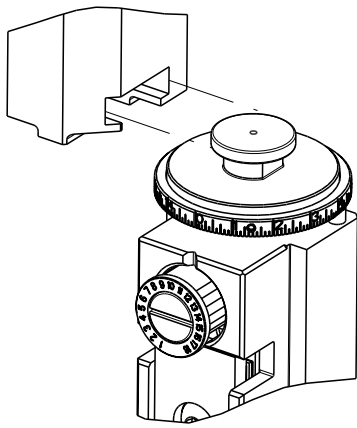
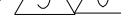


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150955-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150955-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150955-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	8.64 mm [.340]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.86-7.62 mm [.270-.300 IN]		INSULATION DIAMETER RANGE Ø5.21-6.78 mm [.205-.267 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 			
TE TERMINAL 1949826-1	LEAR TERMINAL 6K-5125	TE TERMINAL 1949826-2	LEAR TERMINAL 100953-D02

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
10 AWG		3.45+/-0.05 [.136+/- .002]		7.1
12 AWG		3.15+/-0.05 [.124+/- .002]		10.4



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL LUBRICANT IS RECOMMENDED.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CUT TO LENGTH AT ASSEMBLY.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

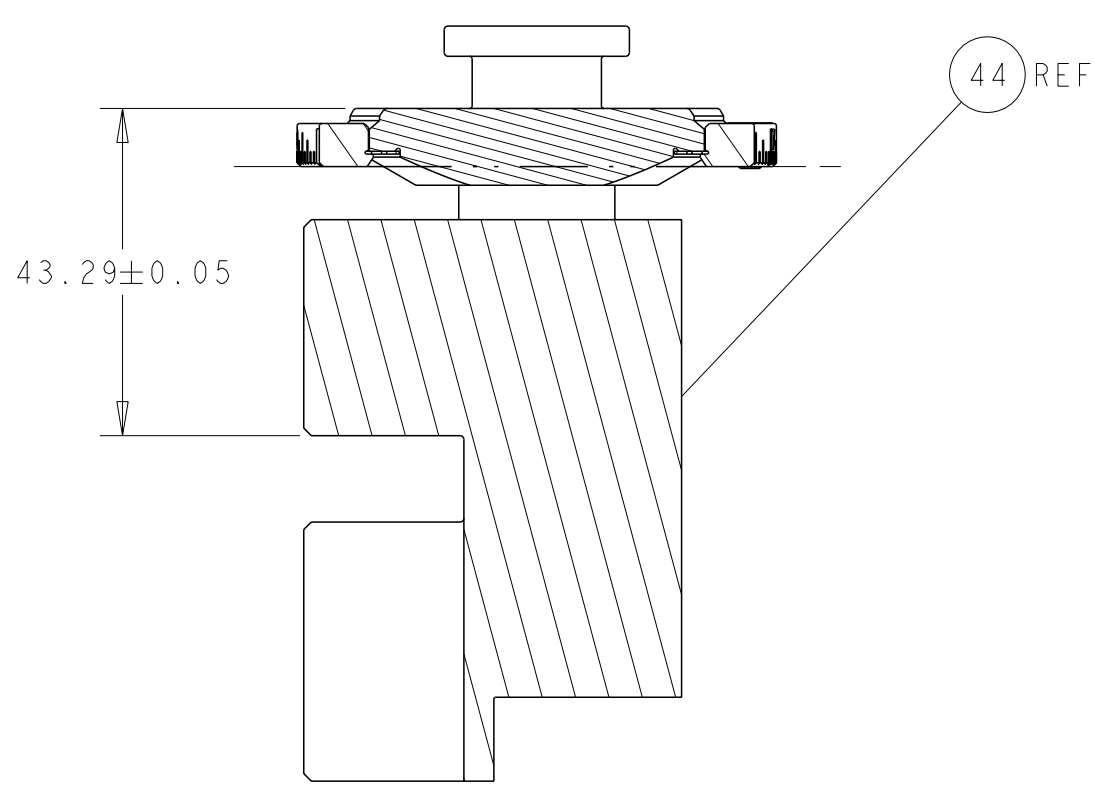
2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
			A	RELEASED			17JAN2019	TB	TE
			B	ECR-20-004638			30MAR2020	FJ	TE

3	-	1	1	1803078-5	SPACER, PRECISION	259	
	-	1	1	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
5	-	1	1	2844940-4	AIR FEED MODULE	238	
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
7	-	1	1	1-455888-1	SPACER, CRIMPER	82	
	-	1	1	2119791-5	DEPRESSOR, WIRE	73	
	-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
	-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
1	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56	
1	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	-	1	1	1-2063961-0	FEED FINGER	51	
	-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50	
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
1	-	1	1	1-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46	
	-	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
	-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
	-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
1	-	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	30	
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
	-	1	1	1-690455-3	STRIPPER, FRONT CASTING	27	
	-	2	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25	
	-	1	1	1752371-5	PLATE, STRIP GUIDE	24	
1	-	2	2	22281-8	SPRING, COMPRESSION	22	
	-	1	1	1633168-1	ARM, STOCK DRAG	21	
	-	1	1	1-464452-7	DRAG, STOCK	20	
	-	1	1	1-1901696-9	STRIP GUIDE, REAR	19	
	-	1	1	1-1901695-9	STRIP GUIDE, FRONT	18	
1	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	3-240641-2	SPACER	16	
	-	1	1	240644-9	PLATE, REAR SHEAR	11	
	-	-	-	-	-	10	
	-	1	1	6-690482-3	PLATE, FRONT SHEAR	9	
1	1	2	1	1803004-5	ANVIL, COMBINATION, END FEED	8	
	-	1	1	1-2217206-1	BLADE, SLUG	7	
	-	-	-	-	-	6	
	-	1	1	240641-3	SPACER	5	
	-	1	1	4-238011-9	BLOCK, CRIMPER SPACER	4	
1	1	2	1	4-1803260-6	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	455888-2	SPACER, CRIMPER	2	
	1	2	1	456413-6	CRIMPER, WIRE PREMIUM	1	
	-	77	-72	-2	PART NO	DESCRIPTION	ITEM NO

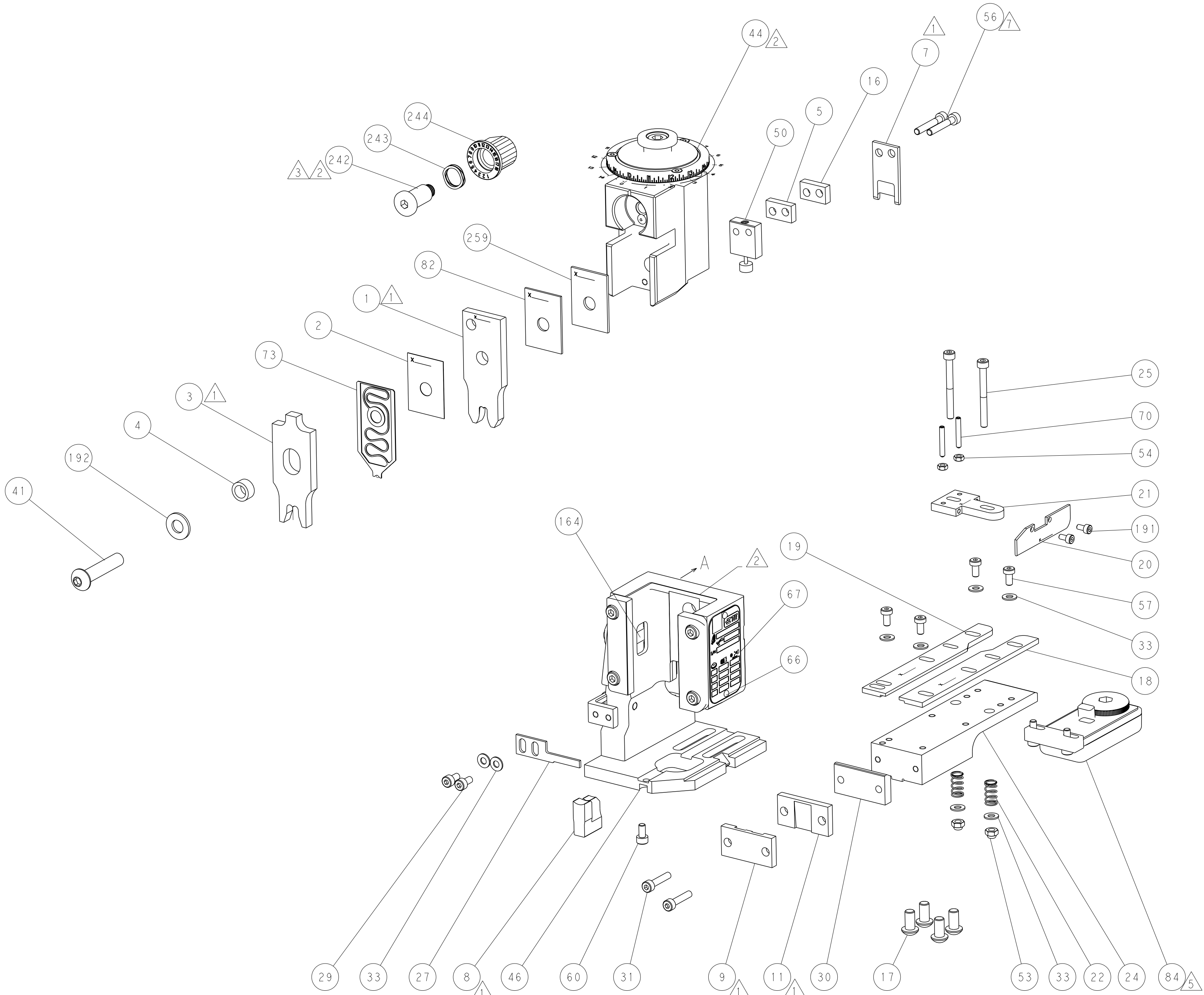
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE.				DWN T. BROOKS 24OCT2018	TE Connectivity Harrisburg, PA 17105-3608		
CHK R. KNEPPER 24OCT2018				NAME T. ELBIN 24OCT2018	Ocean End Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC	SIZE CAGE CODE DRAWING NO		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APPLICATION SPEC	RESTRICTED TO		
MATERIAL -				WEIGHT -	A1 00779 ©=2150955		
FINISH -				Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 of 4 REV B		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

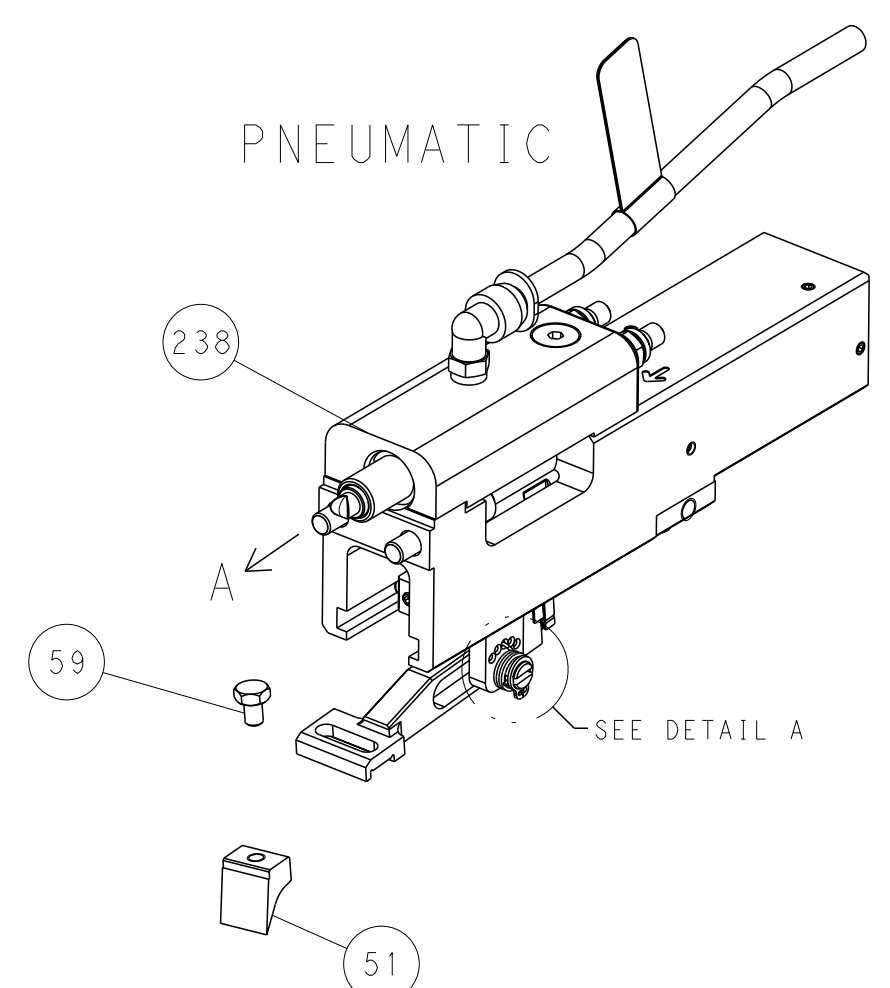
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-



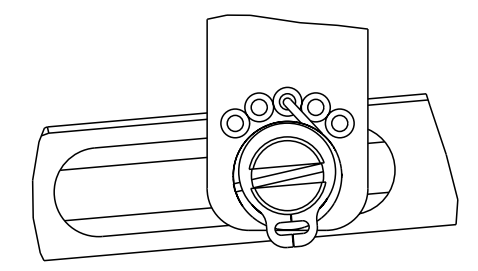
RAM SET-UP



FEED TYPE

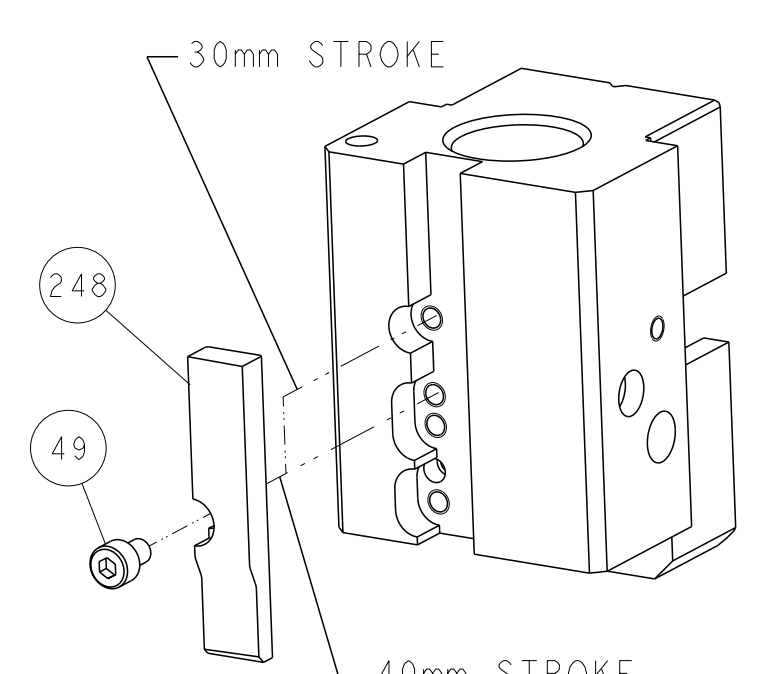


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION

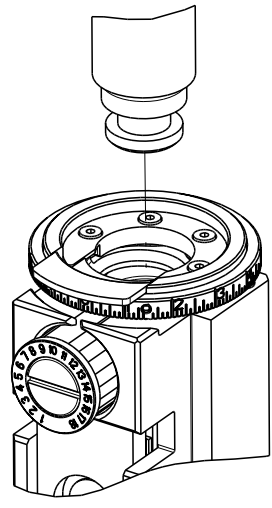


AIR FEED

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1411 BROWN 1411 IS CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION 1411 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION CHANGES BE CONTACTED FOR THE LATEST REVISION		DWN T. BROOKS 24OCT2018	TE Connectivity Harrisburg, PA 17105-3608	
CHK R. KNEPPER 24OCT2018		NAME	Ocean End Feed Applicator	
APVD T. ELBIN 24OCT2018		PRODUCT SPEC	-	
APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO
-		A1	00779	©=2150955
MATERIAL		WEIGHT	Customer Accessible Production Drawing	
-		SCALE	1:1	SHEET 2 OF 4
FINISH		REV	B	
-				

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150955-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150955-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	8.64 mm [.340]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.86-7.62 mm [.270-.300 IN]		INSULATION DIAMETER RANGE Ø5.21-6.78 mm [.205-.267 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
NONE		NONE	
TERMINALS APPLIED		TERMINALS APPLIED	
TE TERMINAL		TE TERMINAL	
LEAR TERMINAL		LEAR TERMINAL	
1949826-1		100953-D02	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
10 AWG			3.45+/-0.05 [1.36+/- .002]		7.1
12 AWG			3.15+/-0.05 [1.24+/- .002]		10.4



1. RECOMMENDED SPARE PARTS
 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
 5. TERMINAL LUBRICANT IS RECOMMENDED.
 6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 7. CUT TO LENGTH AT ASSEMBLY.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING,
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

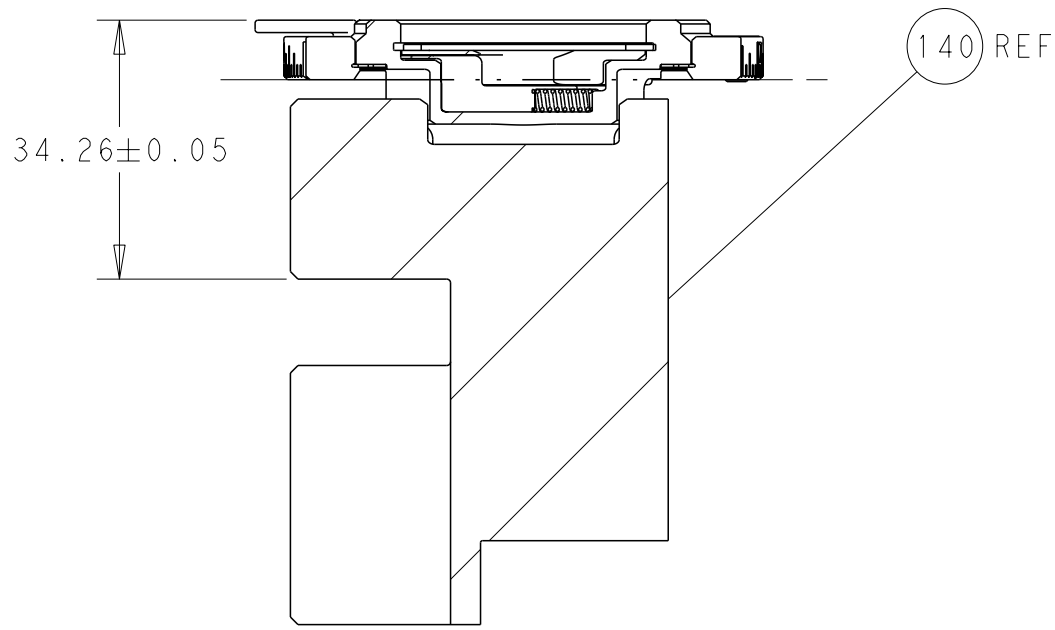
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

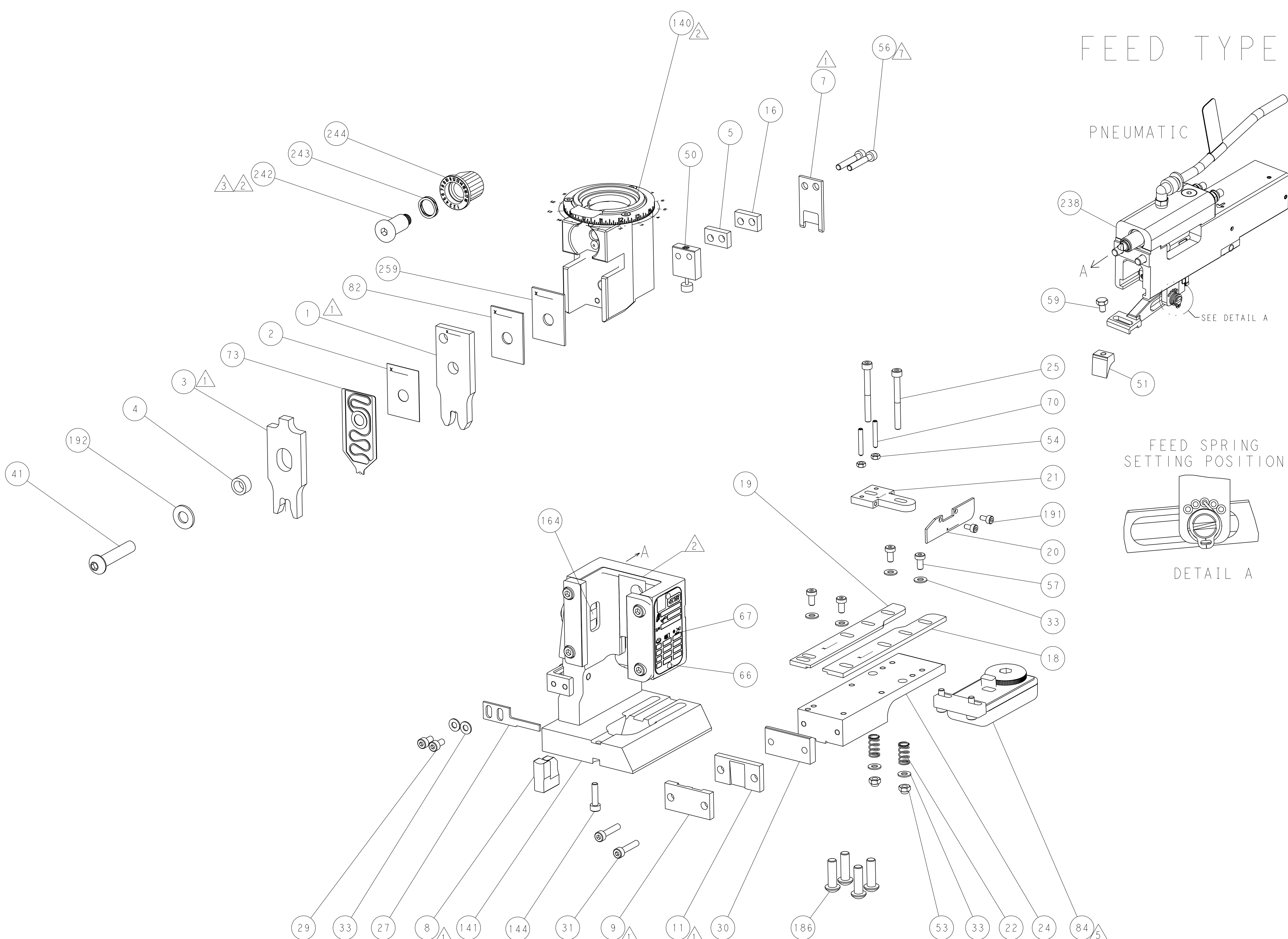
	-	1	1803078-5	SPACER, PRECISION	259
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	155
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	1	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
△	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1-455888-1	SPACER, CRIMPER	82
	-	1	2119791-5	DEPRESSOR, WIRE	73
	-	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
△	-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1-2063961-0	FEED FINGER	51
	-	1	1803382-1	HOLD DOWN, SPRING LOADED	50
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
	-	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	30
	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1-690455-3	STRIPPER, FRONT CASTING	27
	-	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
	-	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	22281-8	SPRING, COMPRESSION	22
	-	1	1633168-1	ARM, STOCK DRAG	21
	-	1	1-464452-7	DRAG, STOCK	20
	-	1	1-1901696-9	STRIP GUIDE, REAR	19
	-	1	1-1901695-9	STRIP GUIDE, FRONT	18
	-	1	3-240641-2	SPACER	16
△	-	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	10
△	-	1	6-690482-3	PLATE, FRONT SHEAR	9
△	1	1	1803004-5	ANVIL, COMBINATION, END FEED	8
△	-	1	1-2217206-1	BLADE, SLUG	7
	-	-	-	-	6
	-	1	240641-3	SPACER	5
	-	1	4-238011-9	BLOCK, CRIMPER SPACER	4
△	1	1	4-1803260-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-2	SPACER, CRIMPER	2
△	1	1	456413-6	CRIMPER, WIRE PREMIUM	1
-77-22			PART NO	DESCRIPTION	ITEM NO

[illegible]

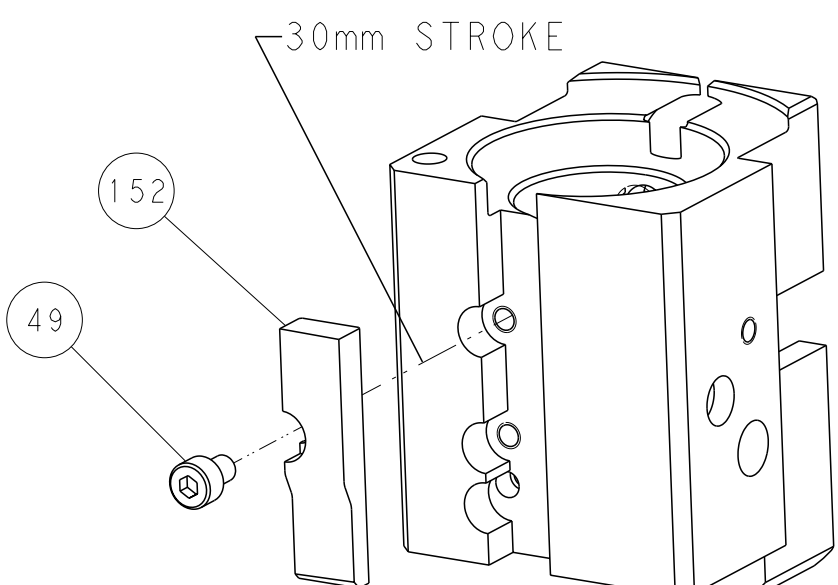
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



RAM SET-UP



CAM POSITION



AIR FEED

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

1:1 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN T. BROOKS	24OCT2018	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK R. KNEPPER	24OCT2018		
		APVD T. ELBIN	24OCT2018	NAME Ocean End Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -		A 00779 ©=2150955 Customer Accessible Production Drawing	
		SCALE 1:1		SHEET 4 OF 4	
				REV B	