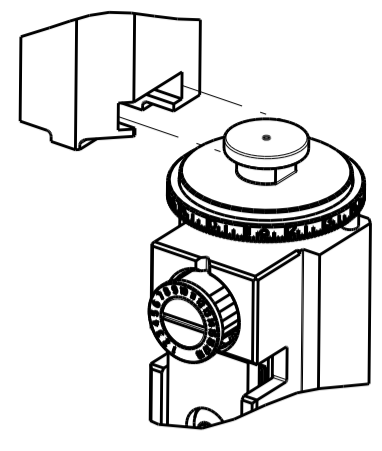


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150008-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150008-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150008-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150008-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150008-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.40-5.70 mm [.213-.224 IN]		Ø2.67-3.68 mm [.105-.145 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350436-2	61794-1	61795-1	61795-8
350436-3	61794-4	61795-3	1-61795-1
350436-4	61794-5	61795-4	63640-1
61793-1	61794-6	61795-5	640051-1
61793-3	61794-8	61795-6	640052-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.18+/-0.05 [.086+/- .002]	6.8
16 AWG	1.98+/-0.05 [.078+/- .002]	8.6
18 AWG	1.85+/-0.05 [.073+/- .002]	10.0

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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.
6. 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.

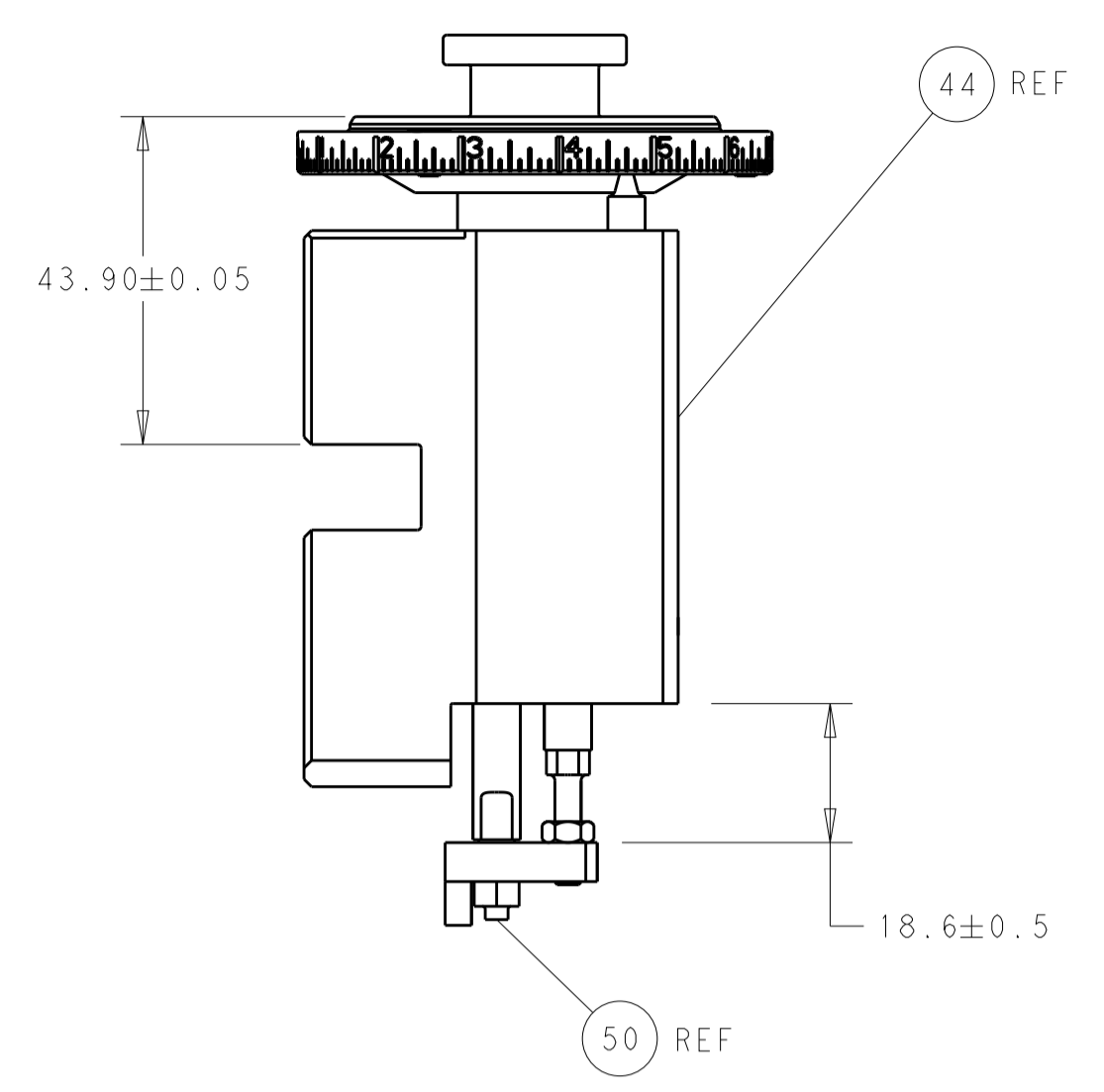
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	D	03AUG2017	FZ	KZ
		E	22JUN2018	FZ	JD
		F	31JUL2018	LG	TE
		F1	16APR2019	FL	GB

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	1	1	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
-	-	1	-	1	2063961-1	FEED FINGER	58
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1	1976055-5	STANDOFF, HOLD-DOWN	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	1	1	1	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	1-690495-5	PLATE, FRONT SHEAR	9
-	1	2	2	1	1333221-5	ANVIL, EF .130	8
-	1	1	1	1	2217206-4	BLADE, SLUG	7
-	1	1	1	1	1-240641-8	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	456410-7	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO

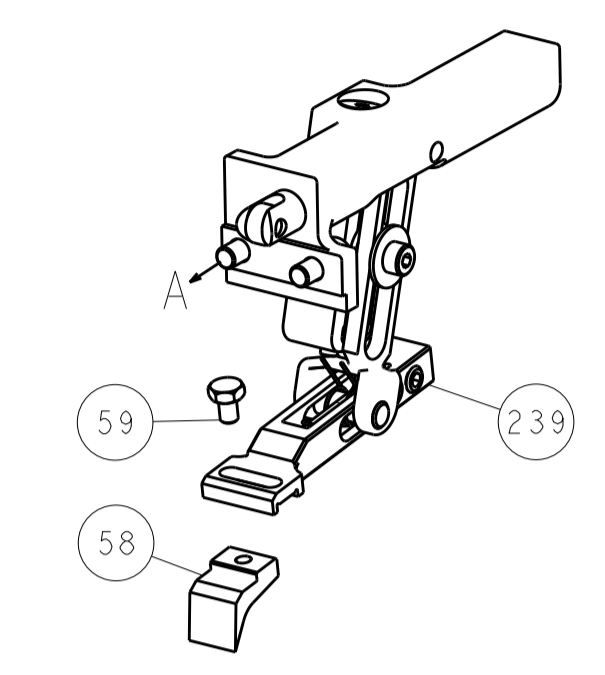
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES ±		FINISH ±		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: F1	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: F1	

LOC	DIST	REV	DATE	BY	APPV
A	66				
		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			

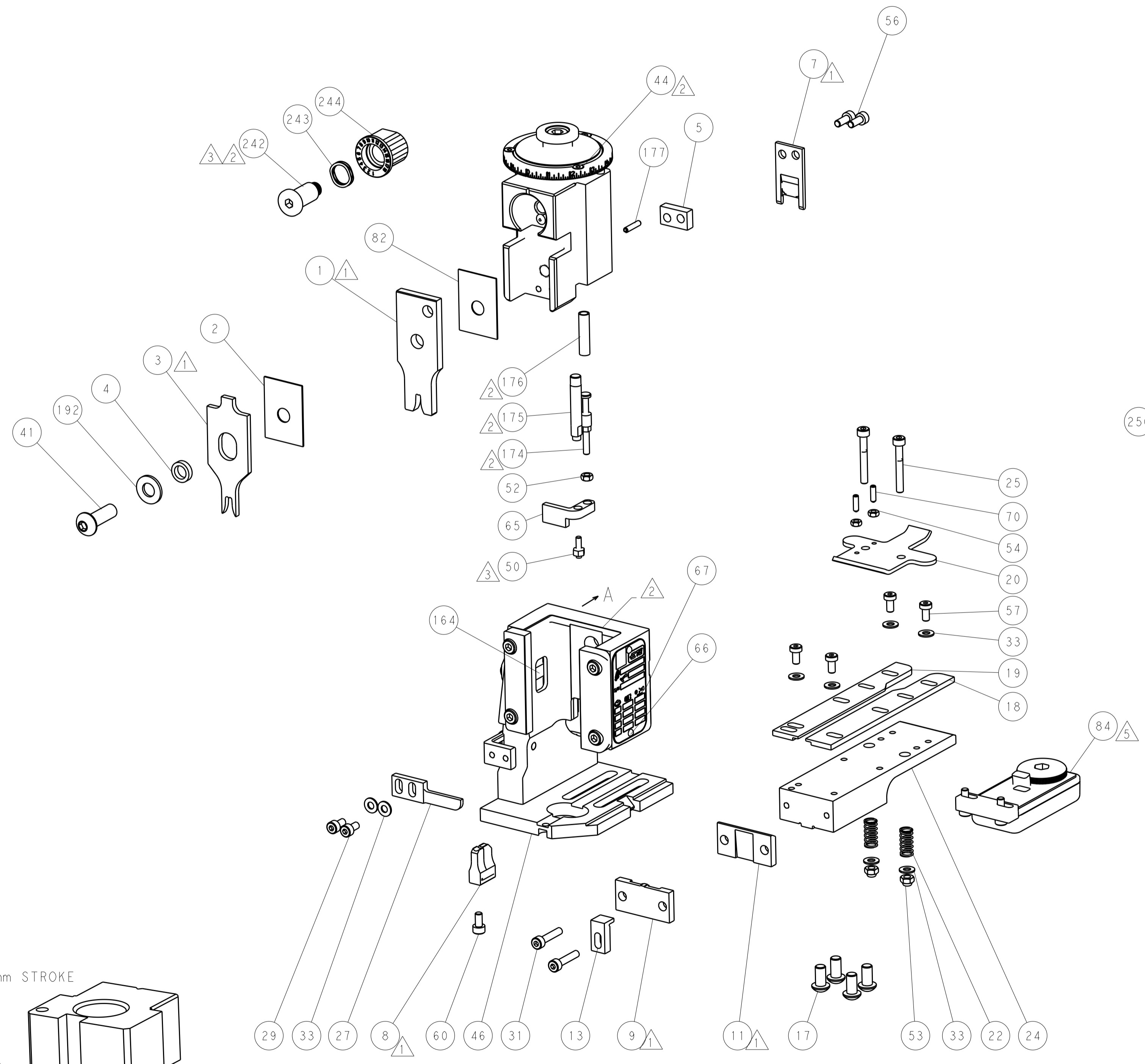
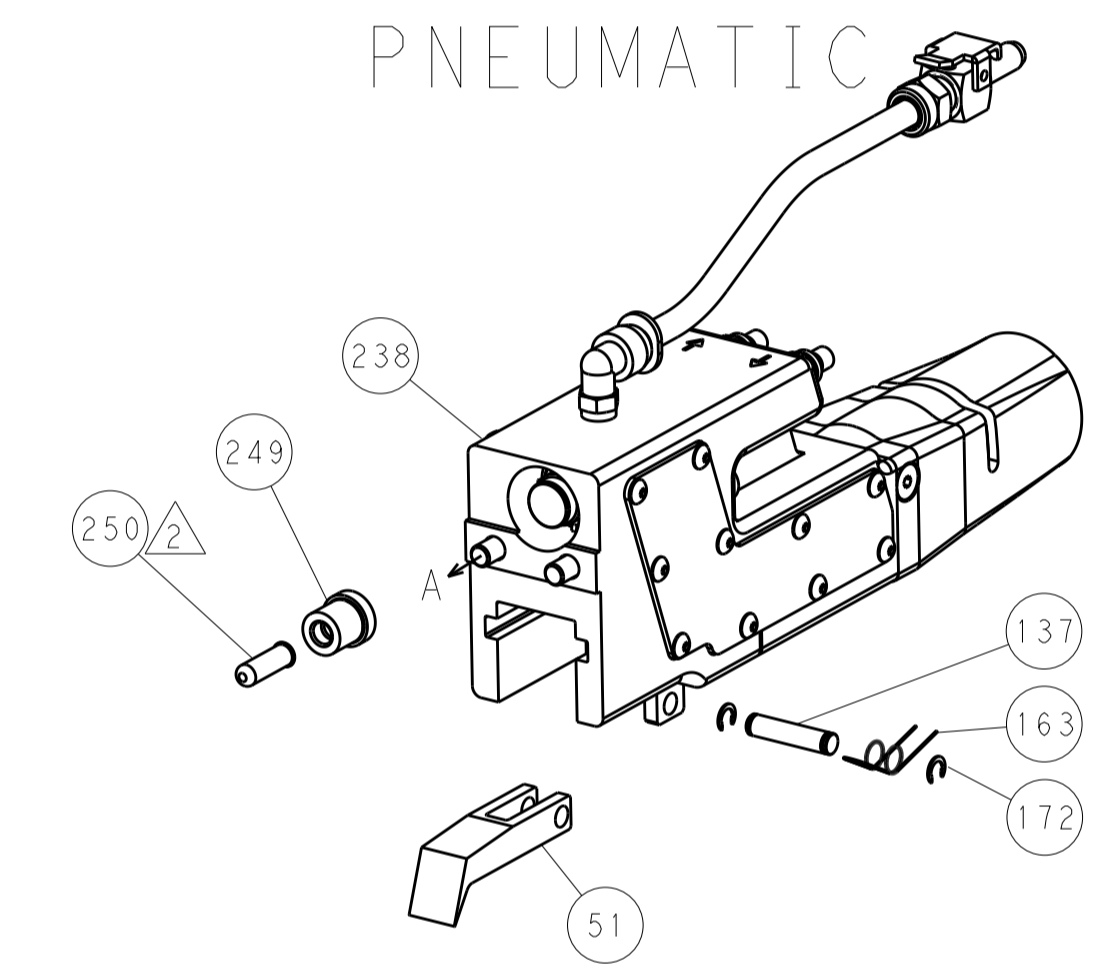


RAM AND HOLDDOWN SET-UP

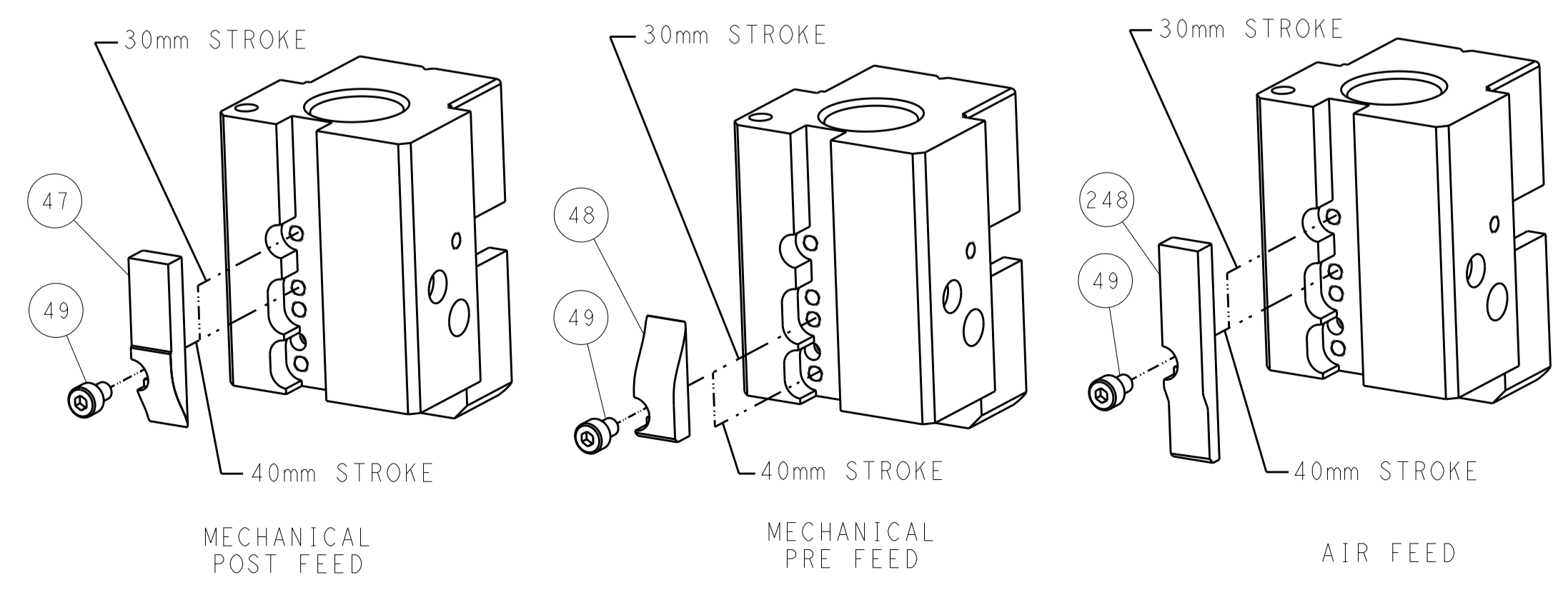
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

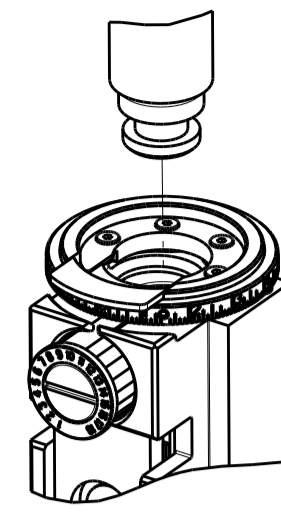


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: L. ZHANG 11JAN2012 CHK: L. ZHANG 11JAN2012 APV: S. XI 11JAN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150008
MATERIAL:		WEIGHT:	RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:1 SHEET: 2 of 4 REV: F1

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150008-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150008-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150008-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 5.40-5.70 mm [.213-.224 IN]		INSULATION DIAMETER RANGE Ø2.67-3.68 mm [.105-.145 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350436-2	61794-1	61795-1	61795-8
350436-3	61794-4	61795-3	1-61795-1
350436-4	61794-5	61795-4	63640-1
61793-1	61794-6	61795-5	640051-1
61793-3	61794-8	61795-6	640052-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.18+/-0.05 [.086+/-0.002]	6.8
16 AWG	1.98+/-0.05 [.078+/-0.002]	8.6
18 AWG	1.85+/-0.05 [.073+/-0.002]	10.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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.
- 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.

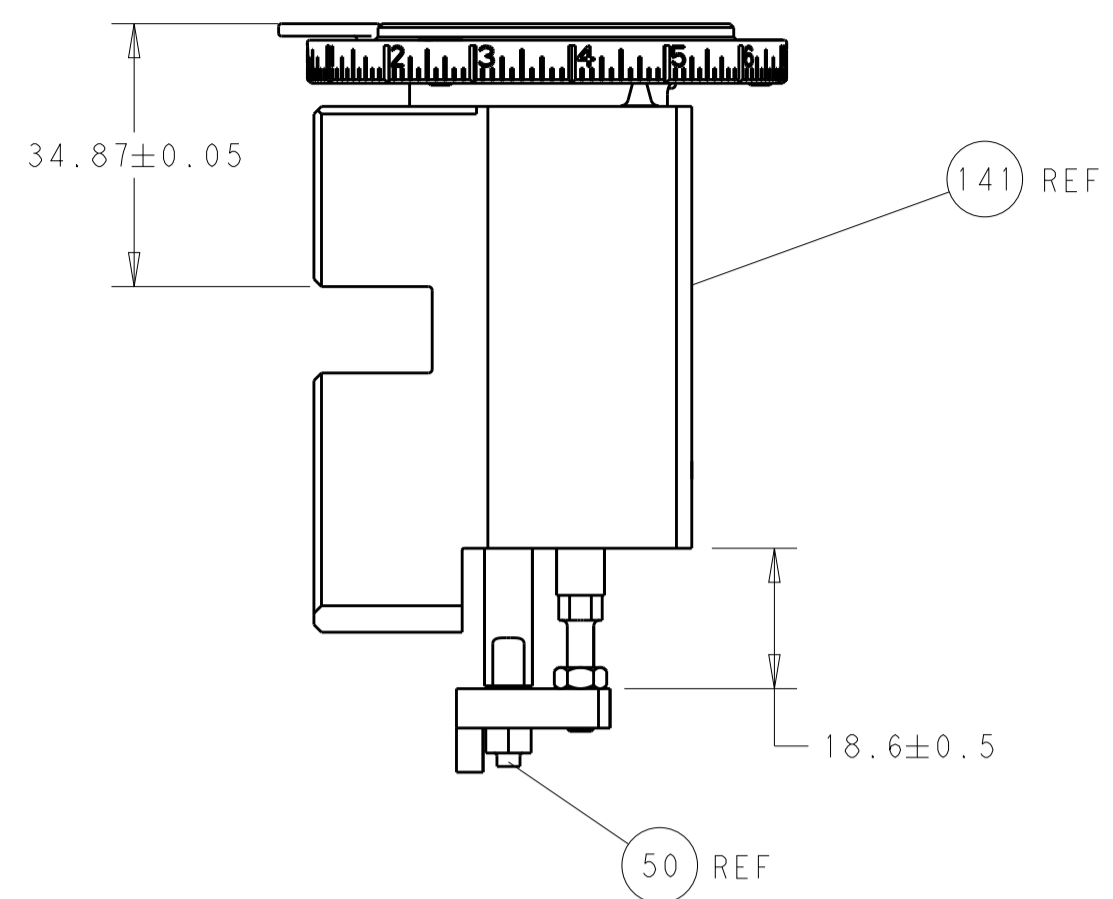
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REVISIONS							
REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO	
-	-	-	-	-	SEE SHEET 1	-	
-	1	1			2119640-1	PUSH ROD, AIR FEED	250
-	1	1			1803259-1	BUSHING, FLANGED	249
-	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
-	-	1			2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-			2063440-1	AIR FEED MODULE	238
-	1	1			1-18028-0	WASHER, FLAT, REG M8	192
-	4	4			2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1			6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1			8-22280-7	SPRING, COMPRESSION	176
-	1	1			1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1			1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	2			21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF			994970-2	COUNTER, MAGNETIC	164
-	1	1			240638-1	SPRING, FEED FINGER	163
-	1	-			2119641-2	FEED CAM, AIR FEED	152
-	1	1			2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1			2119653-2	FEED CAM, POST FEED	142
-	1	1			2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1			1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	1			3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1			2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1			455888-5	SPACER, CRIMPER	82
-	1	1			1803607-2	DOCUMENTATION PACKAGE	71
-	2	2			2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1			2119740-1	TAG, IDENTIFICATION	67
-	2	2			2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1			1901681-5	HOLDDOWN, TERMINAL	65
-	1	1			5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1			2063961-1	FEED FINGER	58
-	4	4			2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2			1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2			5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2			986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1			1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-			2119792-2	PAWL, EF, AIR	51
-	1	1			1976055-5	STANDOFF, HOLD-DOWN	50
-	1	2			18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1			2119652-1	FEED CAM, PRE FEED	48
-	1	1			1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8			1-18028-2	WASHER, FLAT, REG M4	33
-	2	2			2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2			2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1			240639-1	STRIPPER (MACHINING)	27
-	2	2			1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1			1752371-1	PLATE, STRIP GUIDE	24
-	2	2			2-22281-3	SPRING, COMPRESSION	22
-	1	1			1803292-4	DRAG	20
-	1	1			1-1901696-5	STRIP GUIDE, REAR	19
-	1	1			1-1901695-5	STRIP GUIDE, FRONT	18
-	1	1			1752360-1	SPACER,HOLD-DOWN	13
-	1	1			240833-1	PLATE, REAR SHEAR	11
-	-	-			-	-	10
-	1	1			1-690495-5	PLATE, FRONT SHEAR	9
1	1	1			1333221-5	ANVIL, EF .130	8
-	1	1			2217206-4	BLADE, SLUG	7
-	1	1			1-240641-8	SPACER	5
-	1	1			238011-2	BLOCK, CRIMPER SPACER	4
1	1	1			2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1			455888-6	SPACER, CRIMPER	2
1	1	1			456410-7	CRIMPER, WIRE PREMIUM	1

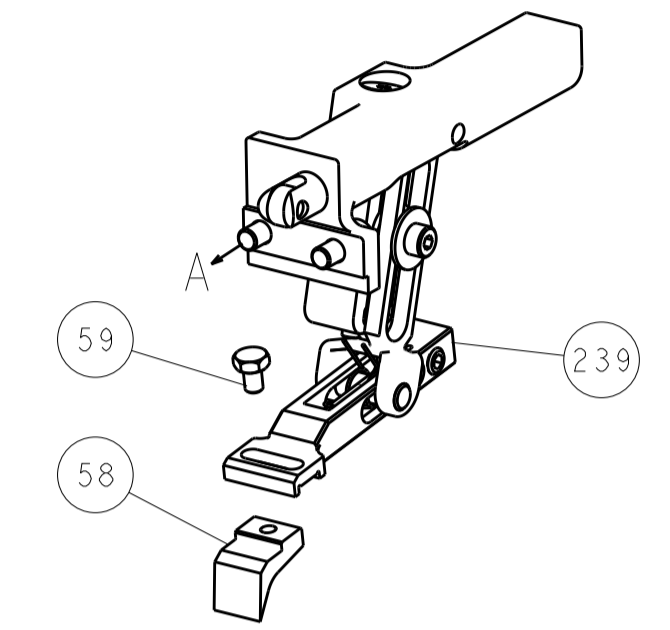
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		11JAN2012		TE Connectivity	
mm		0 PLC ±		CHK		11JAN2012		Harrisburg, PA 17105-3608	
mm		1 PLC ±		CHK		11JAN2012		NAME	
mm		2 PLC ±		CHK		11JAN2012		Ocean End Feed	
mm		3 PLC ±		CHK		11JAN2012		Applicator	
mm		4 PLC ±		CHK		11JAN2012		SIZE	
mm		5 PLC ±		CHK		11JAN2012		CAGE CODE	
mm		6 PLC ±		CHK		11JAN2012		DRAWING NO	
mm		7 PLC ±		CHK		11JAN2012		RESTRICTED TO	
mm		8 PLC ±		CHK		11JAN2012		SCALE	
mm		9 PLC ±		CHK		11JAN2012		SHEET	
mm		10 PLC ±		CHK		11JAN2012		OF	
mm		11 PLC ±		CHK		11JAN2012		REV	
mm		12 PLC ±		CHK		11JAN2012		F1	
mm		13 PLC ±		CHK		11JAN2012		Customer Accessible Production Drawing	
mm		14 PLC ±		CHK		11JAN2012		SCALE 1:1	
mm		15 PLC ±		CHK		11JAN2012		SHEET 3 OF 4	
mm		16 PLC ±		CHK		11JAN2012		REV	
mm		17 PLC ±		CHK		11JAN2012		F1	
mm		18 PLC ±		CHK		11JAN2012		Customer Accessible Production Drawing	
mm		19 PLC ±		CHK		11JAN2012		SCALE 1:1	
mm		20 PLC ±		CHK		11JAN2012		SHEET 3 OF 4	
mm		21 PLC ±		CHK		11JAN2012		REV	
mm		22 PLC ±		CHK		11JAN2012		F1	

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

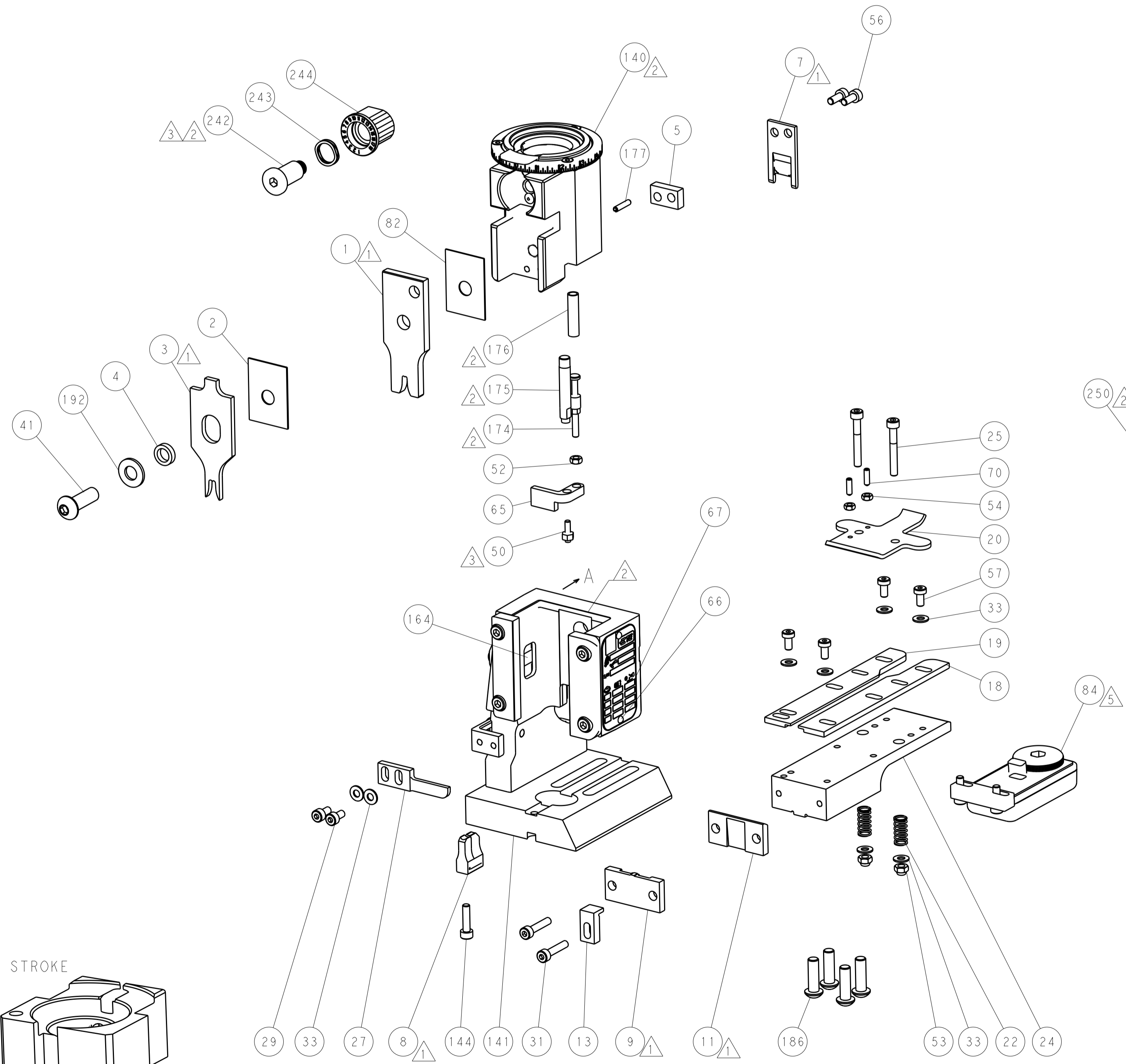
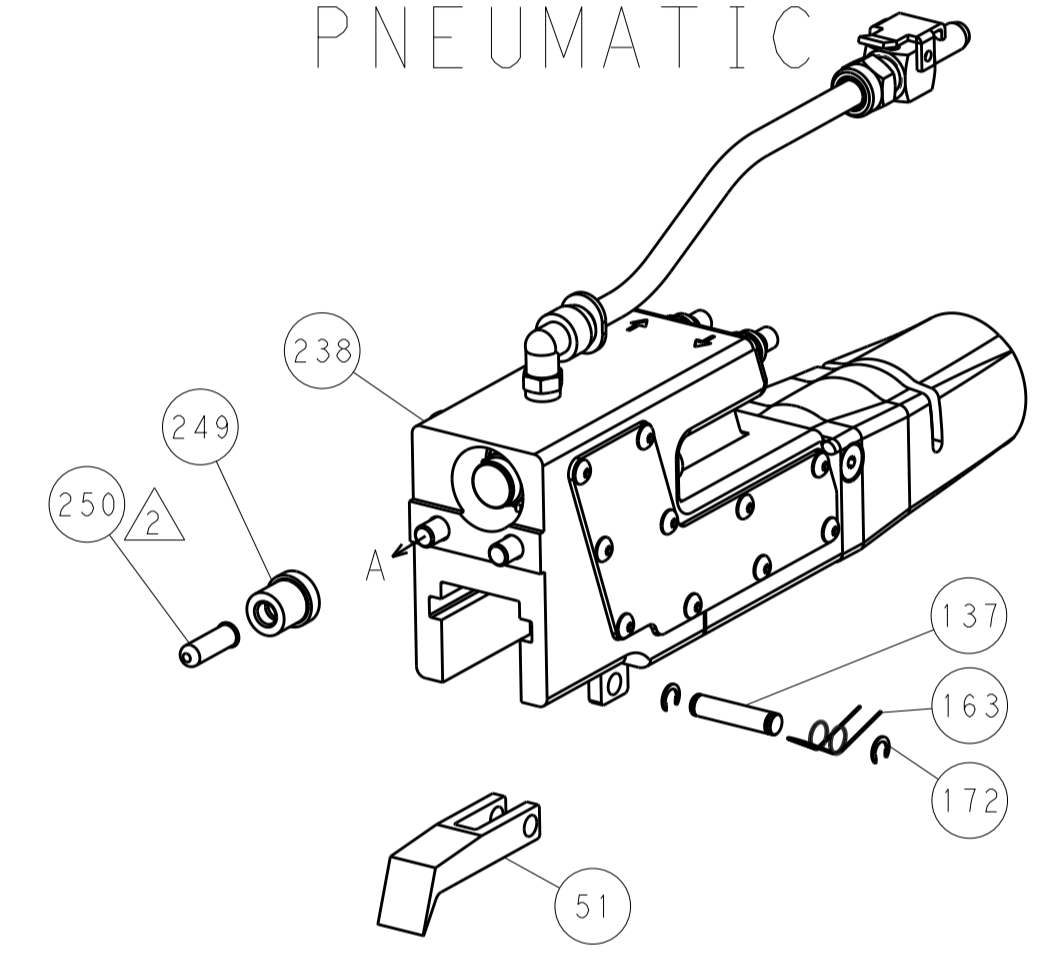


RAM AND HOLDDOWN SET-UP

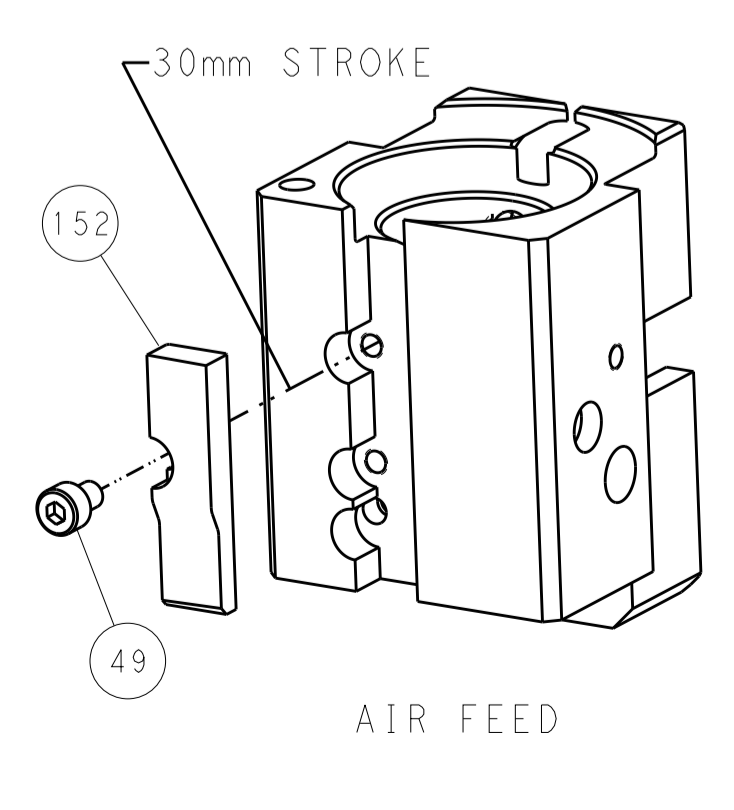
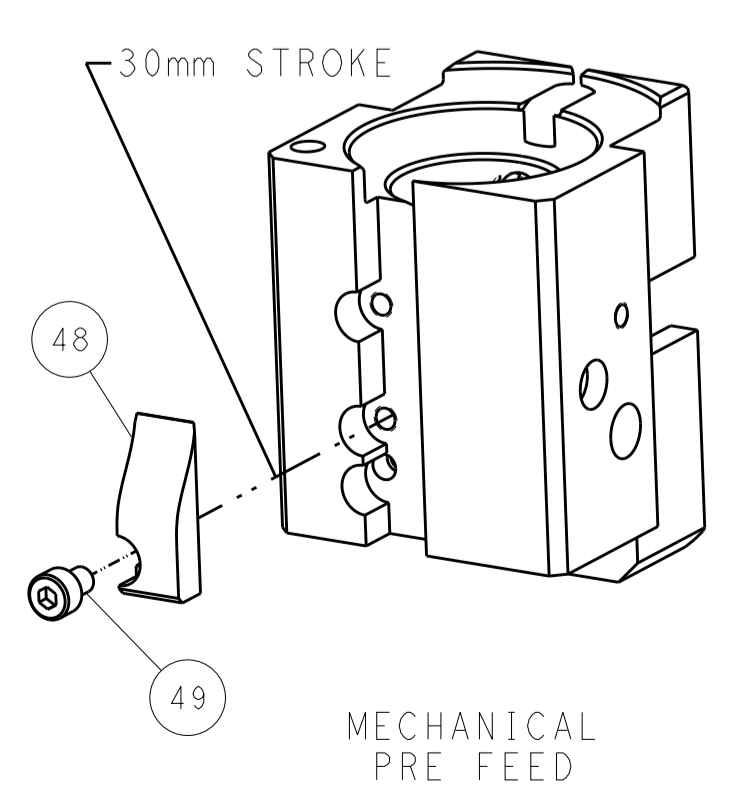
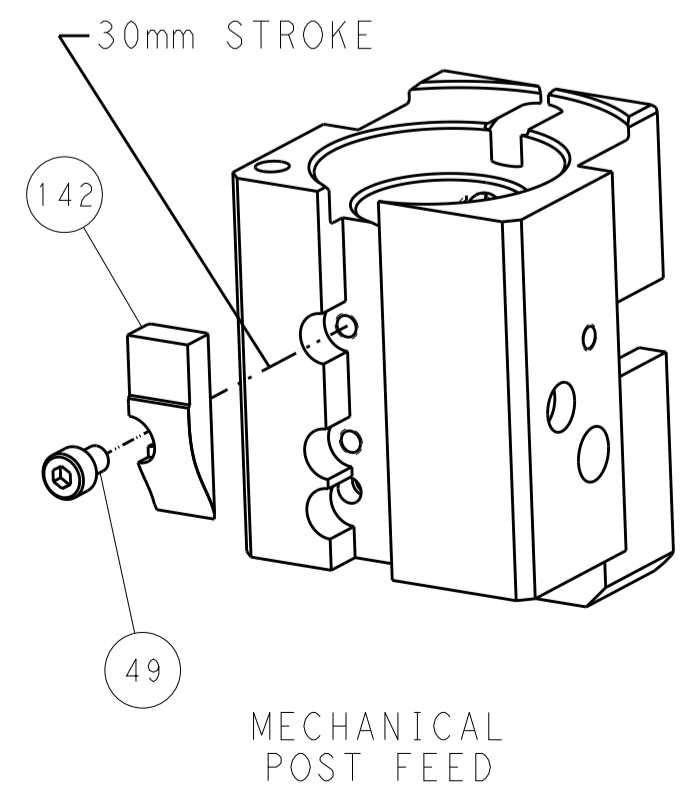
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 11JAN2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK L. ZHANG 11JAN2012		NAME	
				S. XI 11JAN2012		Ocean End Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO	
				PRODUCT SPEC		A1 00779 C=2150008	
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT		Customer Accessible Production Drawing	
				SCALE 1:1		SHEET 4 OF 4 REV 1	