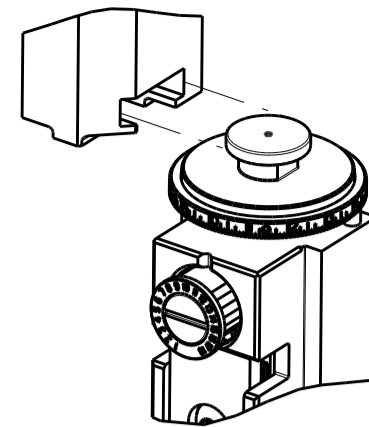


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150198-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150198-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150198-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	6.35 mm [.250]	O

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.78-5.54 mm [.188-.218 IN]	∅3.81-5.33 mm [.150-.210 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41124	41125	42722-1	62691-1
41124-1	41125-1	42724-1	62691-2
41124-2	41126		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	3.07 +/- 0.05 [.121 +/- .002]	6.0
12 AWG	2.77 +/- 0.05 [.109 +/- .002]	10.0

- 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 PITCH NOT COMPATIBLE WITH MACHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED

**\*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.

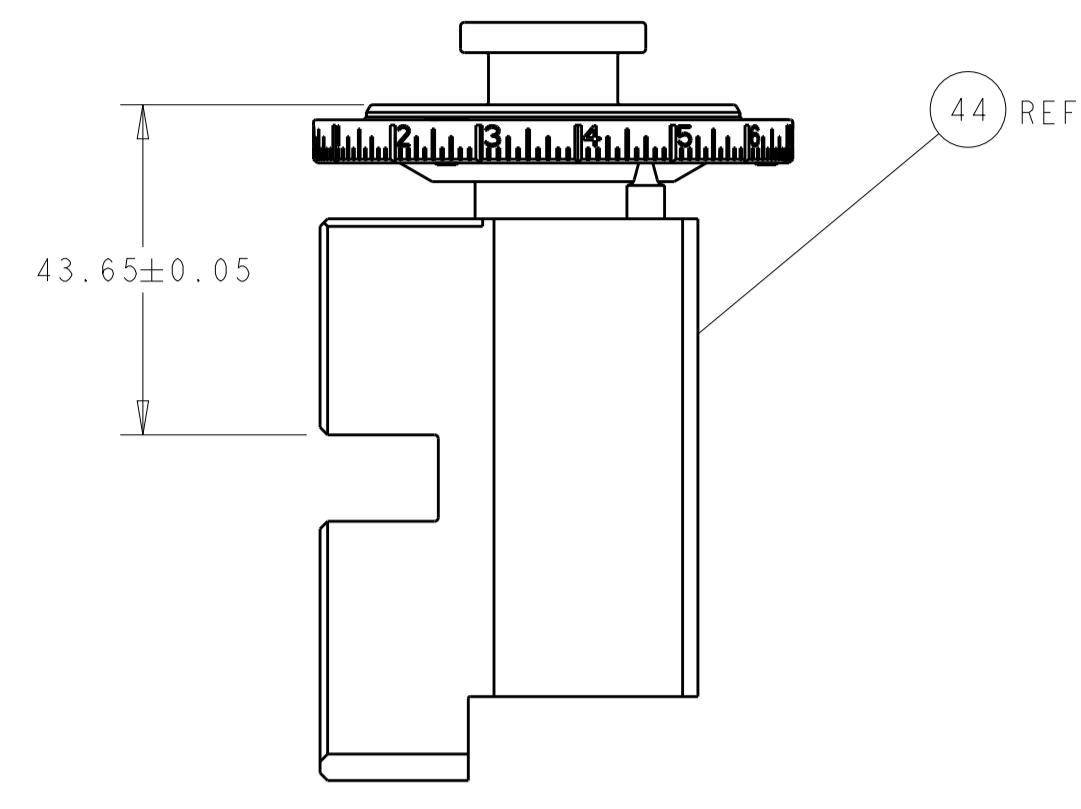
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		C		ECR-18-014305	11SEP2018	MZ	KZ
		D		ECR-20-001030	21JAN2020	FJ	RK
		E		ECR-20-003424	06MAR2020	JWC	TE

-	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	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	1	2063440-2	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-3	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2119792-2	PAWL, EF, AIR	51	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1-1901696-0	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	5-240641-8	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	1	1	690482-7	PLATE, FRONT SHEAR	9	
-	1	2	1-1633384-9	ANVIL, COMBINATION	8	
-	1	1	1-2217206-8	BLADE, SLUG	7	
-	1	1	5-240641-3	SPACER	5	
-	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	1803018-9	CRIMPER, INSULATION O	3	
-	1	1	1-455888-0	SPACER, CRIMPER	2	
-	1	2	456430-1	CRIMPER, WIRE	1	
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

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

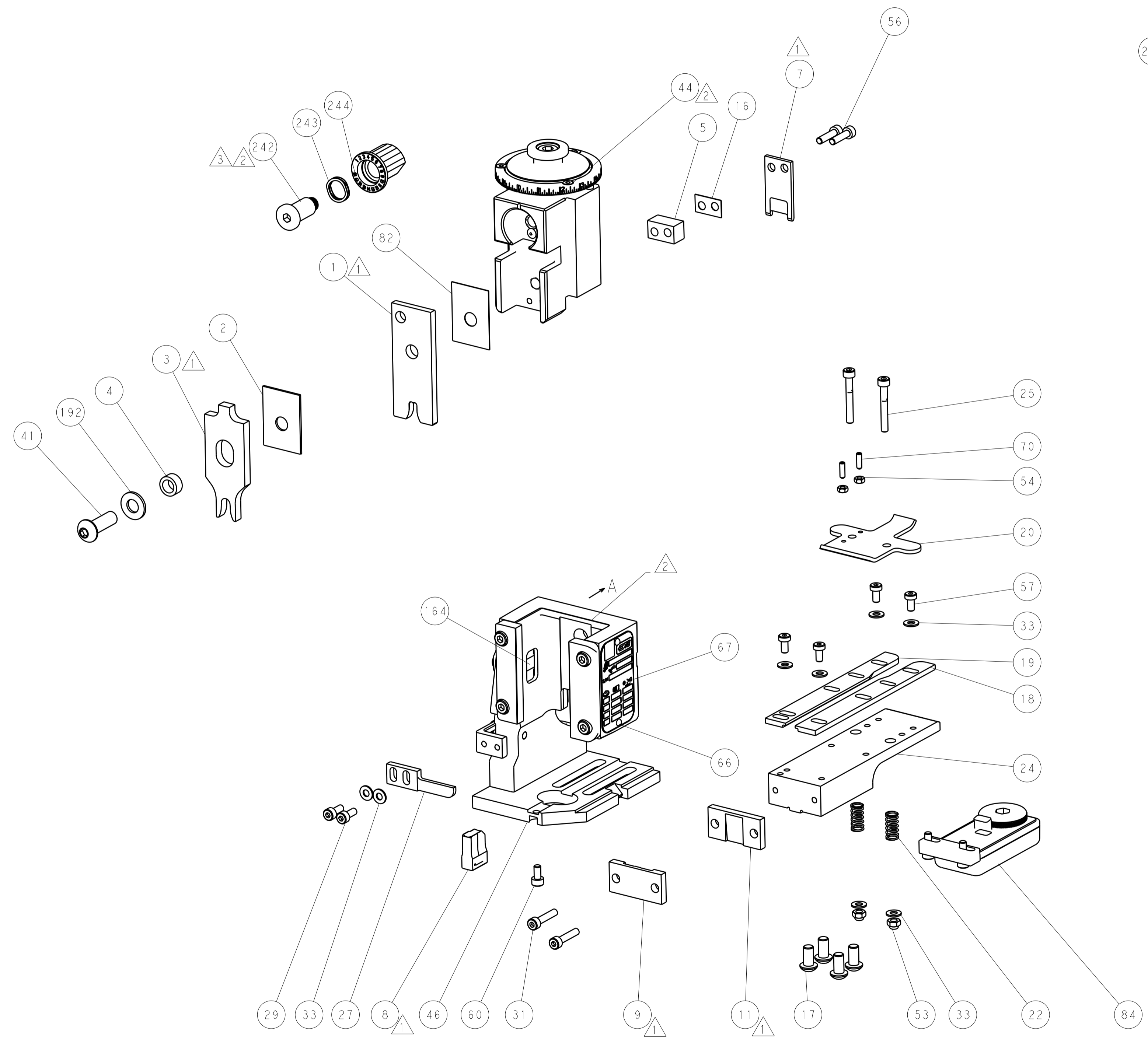
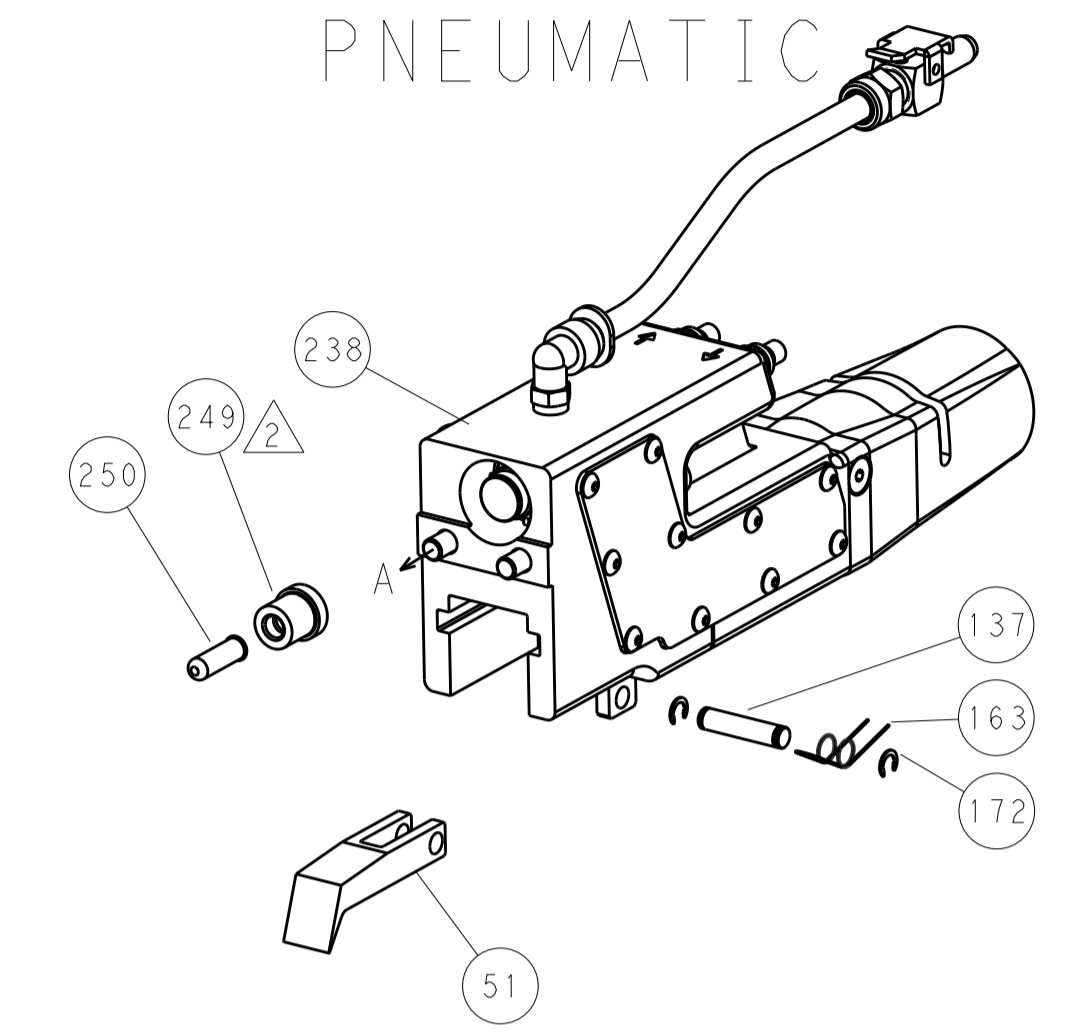
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES ±
MATERIAL				FINISH			
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE		SHEET 1 OF 4	

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

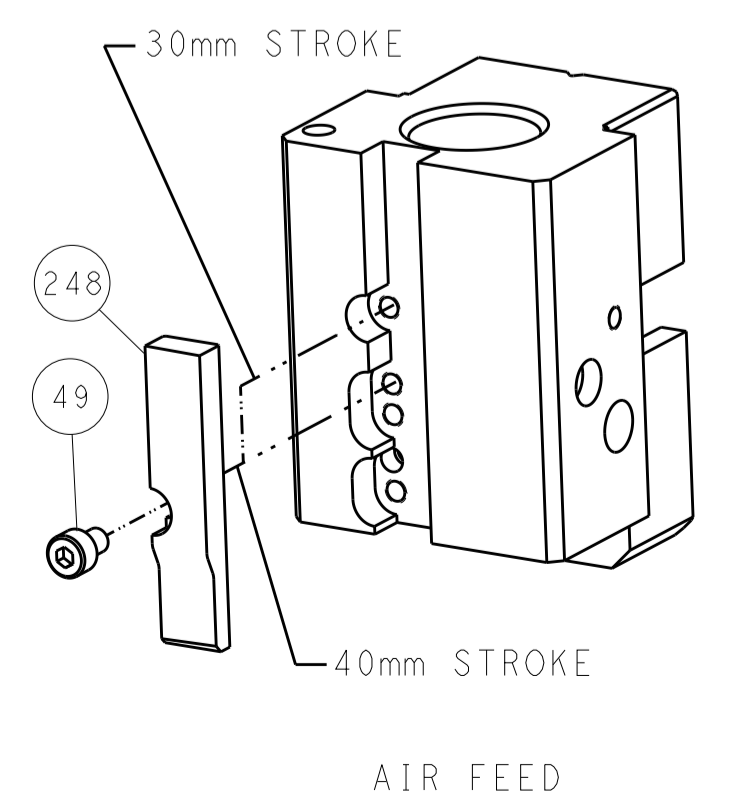


RAM SET-UP

# FEED TYPE PNEUMATIC



# CAM POSITION



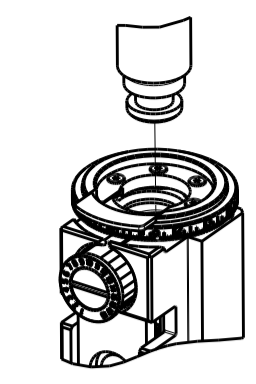
AIR FEED

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN L. ZHANG 29FEB2012 CHK L. ZHANG 29FEB2012 APVD S. XI 29FEB2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150198
MATERIAL:		WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:1 SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150198-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150198-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	5.33 mm (.210)	F
INSUL	6.35 mm (.250)	O

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, RING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.78-5.54 mm (.188-.218 IN)	3.81-5.33 mm (.150-.210 IN)

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41124	41125	42722-1	62691-1
41124-1	41125-1	42724-1	62691-2
41124-2	41126		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	3.07+/-0.05 (.121+/-0.002)	6.0
12 AWG	2.77+/-0.05 (.109+/-0.002)	10.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED

**\*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.

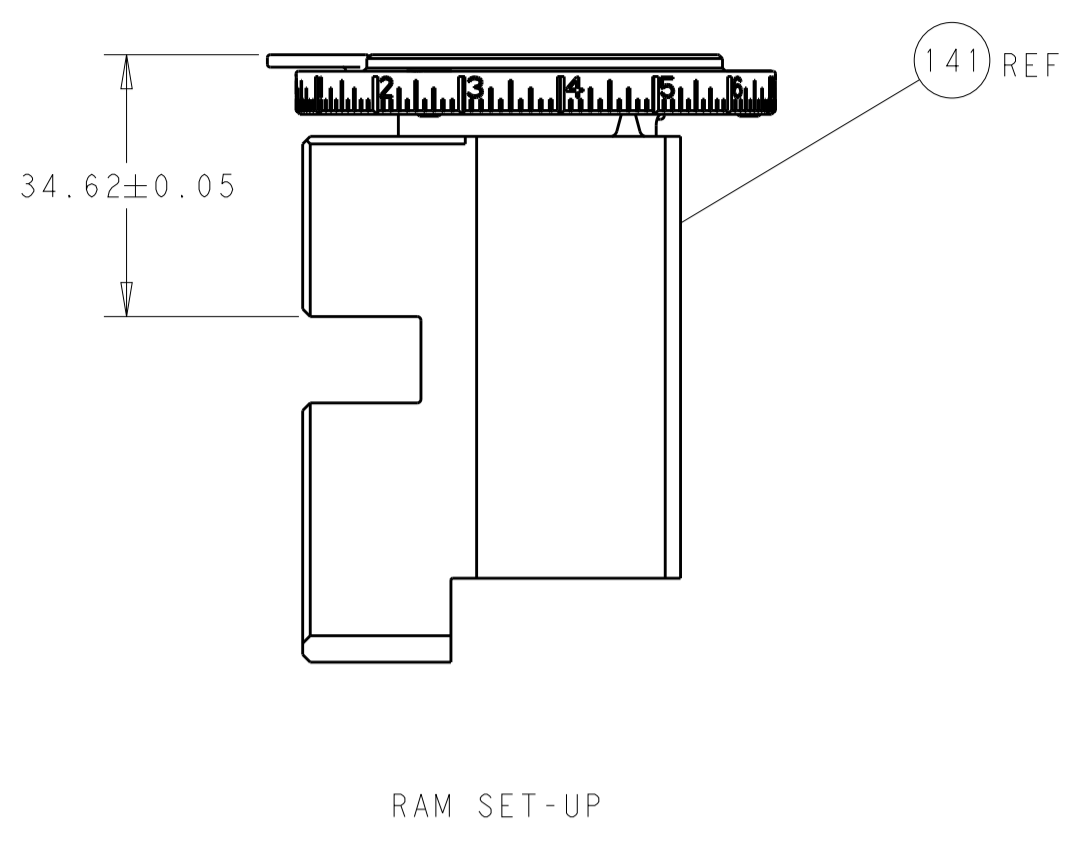
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

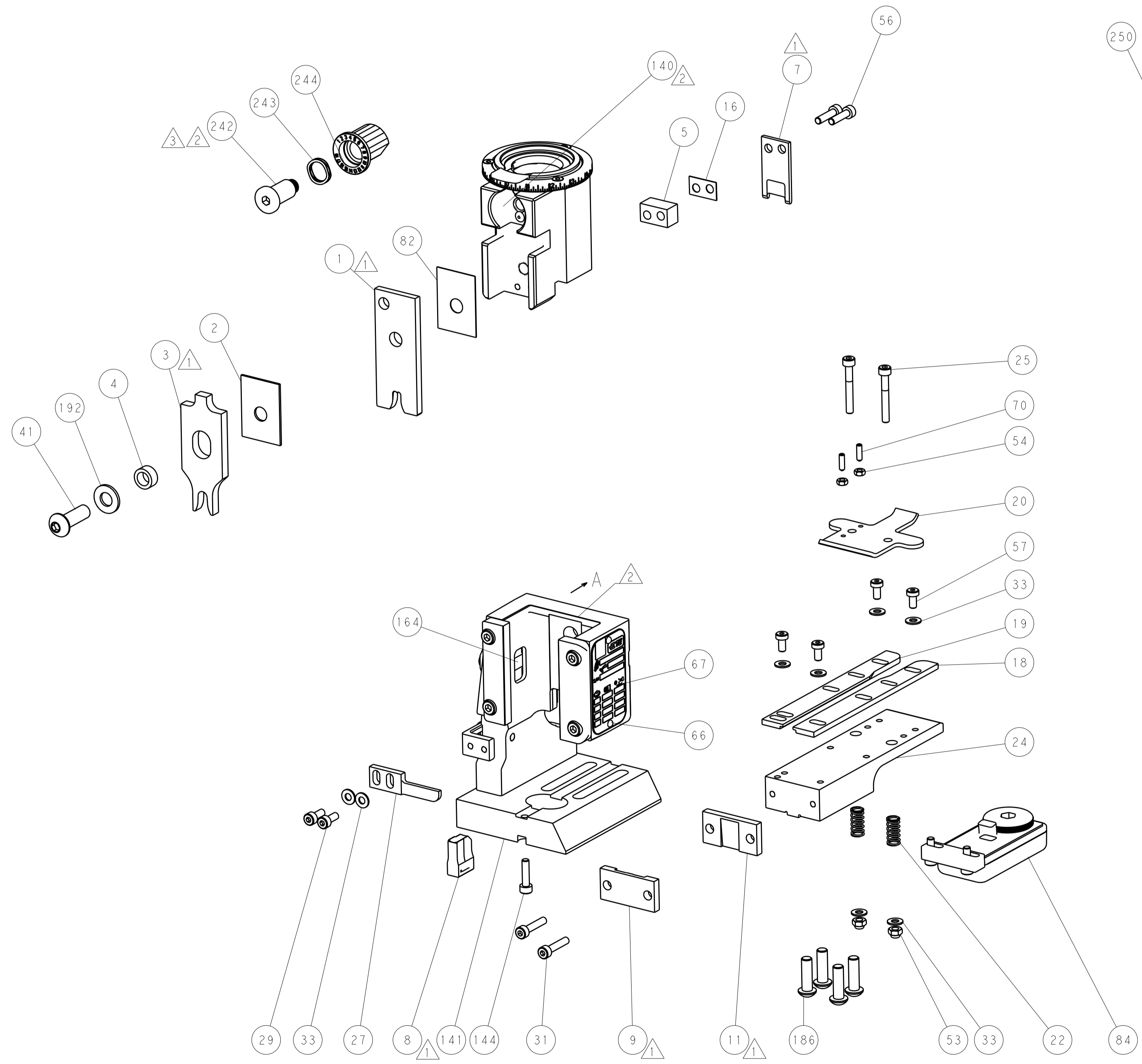
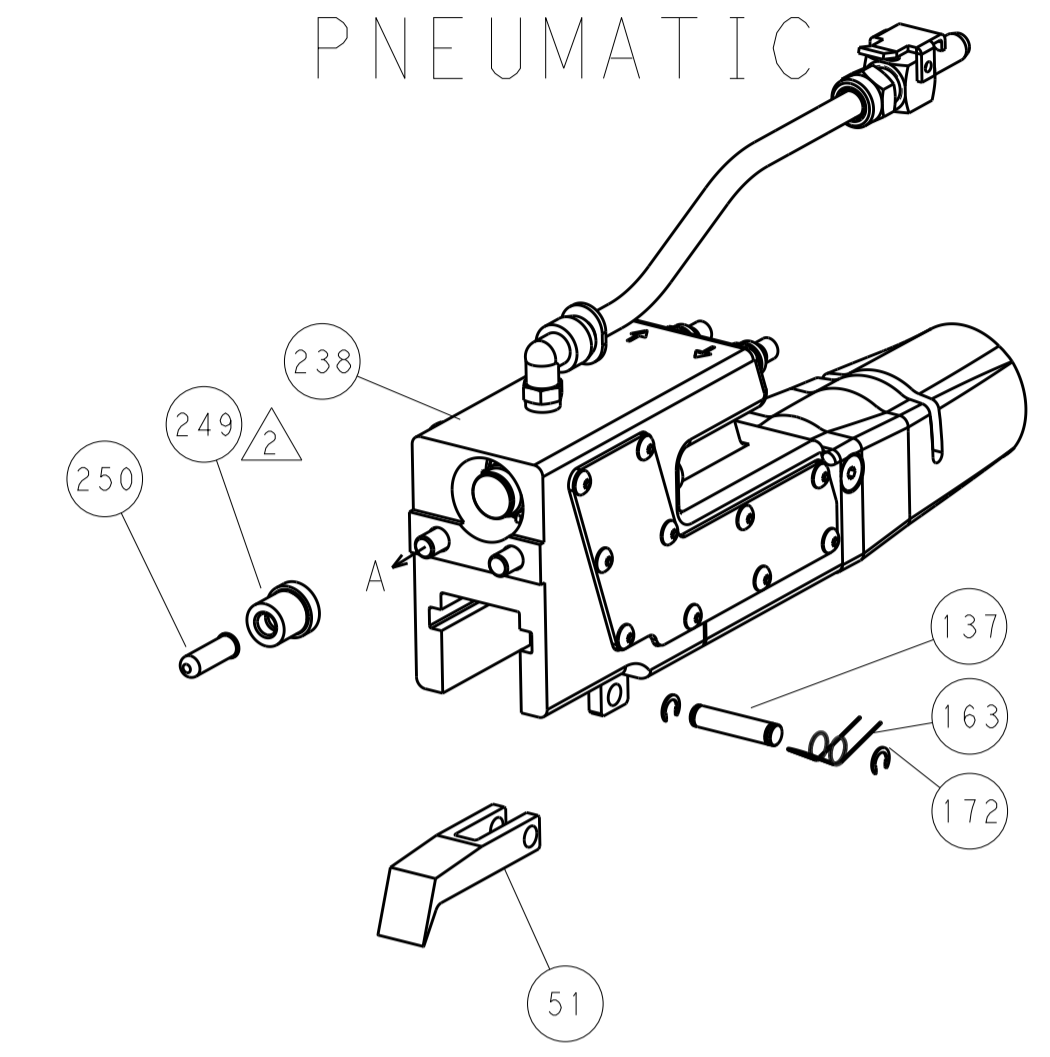
-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-2	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-3	SPACER, CRIMPER	82
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2119792-2	PAWL, EF, AIR	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	5-240641-8	SPACER	16
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-7	PLATE, FRONT SHEAR	9
1	1	1-1633384-9	ANVIL, COMBINATION	8
-	1	1-2217206-8	BLADE, SLUG	7
-	1	5-240641-3	SPACER	5
-	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1803018-9	CRIMPER, INSULATION O	3
-	1	1-455888-0	SPACER, CRIMPER	2
1	1	456430-1	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	OF
										3	4

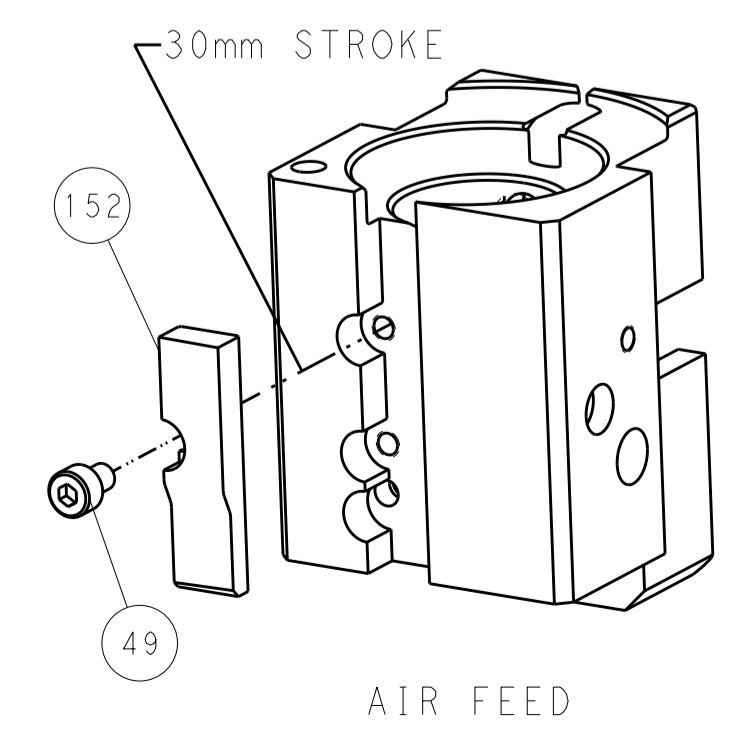
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-	-	SEE SHEET 1	-	-	-



FEED TYPE  
PNEUMATIC



CAM POSITION



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:		DWG L. ZHANG 29FEB2012		CHK L. ZHANG 29FEB2012		APVD S. XI 29FEB2012		NAME		STE TE Connectivity Harrisburg, PA 17105-3608			
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
										A1	00779	©=2150198			
CUSTOMER ACCESSIBLE PRODUCTION DRAWING										SCALE	1:1	SHEET	4 OF 4	REV	E