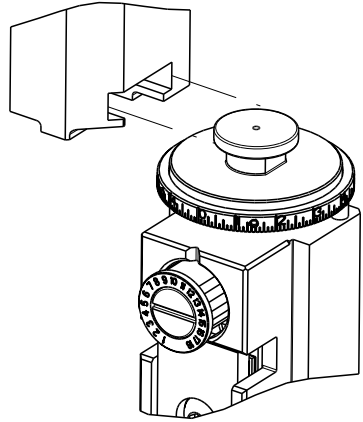


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150198-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150198-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150198-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	6.35 mm [.250]	Ø
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 4.78-5.54 mm [.188-.218 IN]		INSULATION DIAMETER RANGE Ø3.81-5.33 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.

*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		RELEASE	24MAY2012	L. Z	S. X
		B		ECR-14-003773	14MAR2014	KH	UG
		C		ECR-18-014305	11SEP2018	MZ	KZ

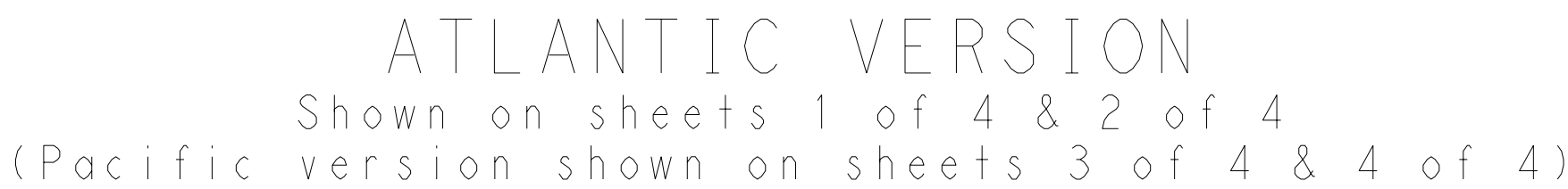
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2063440-2	AIR FEED 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	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	690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	1-1633384-9	ANVIL, COMBINATION	8
1	-	1	1	2-690474-8	BLADE, SLUG	7
	-	1	1	5-240641-3	SPACER	5
	-	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	1803018-9	CRIMPER, INSULATION O	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	1	456430-1	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED FOR THE ENTIRE LIFE OF THE PRODUCT. ANY CHANGES TO THE DESIGN OR CONSTRUCTION OF THE PRODUCT MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY ENGINEER. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY ENGINEER. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY ENGINEER.				DWN L. ZHANG 29FEB2012	 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK L. ZHANG 29FEB2012			
mm				APVD S. XI 29FEB2012			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME			
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				PRODUCT SPEC	Ocean End Feed Applicator		
FINISH				APPLICATION SPEC			
MATERIAL				WEIGHT	SIZE	CAGE CODE	DRAWING NO
-				-	A1	00779	©=2150198
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	1:1	SHEET	1 OF 4
				REV	C		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



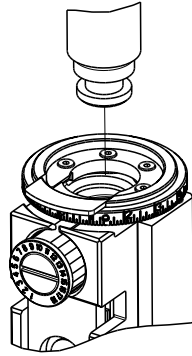
This diagram shows an exploded view of a mechanical assembly. The main component is a rectangular block (238) with a cylindrical feature on top and a slot on the side. A triangular part (2) is shown near a circular opening (A) on the front face. A small cylindrical part (250) and a larger cylindrical part (249) are shown below the front face. A bracket (51) is shown below the main block. A long, thin component (137) with multiple holes is shown to the right, with a small cylindrical part (163) and a small rectangular part (172) attached to it. A small rectangular part (10) is shown at the bottom of the main block.



SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150198-2	C	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 4.78-5.54 mm [.188-.218 IN]			INSULATION DIAMETER RANGE Ø3.81-5.33 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	



- 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 MACHANICAL FEED.
- 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				
		P	LYR	DESCRIPTION	DATE	OWN
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	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	690482-3	PLATE, FRONT SHEAR	9
1	1	1-1633384-9	ANVIL, COMBINATION	8
-	1	2-690474-8	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

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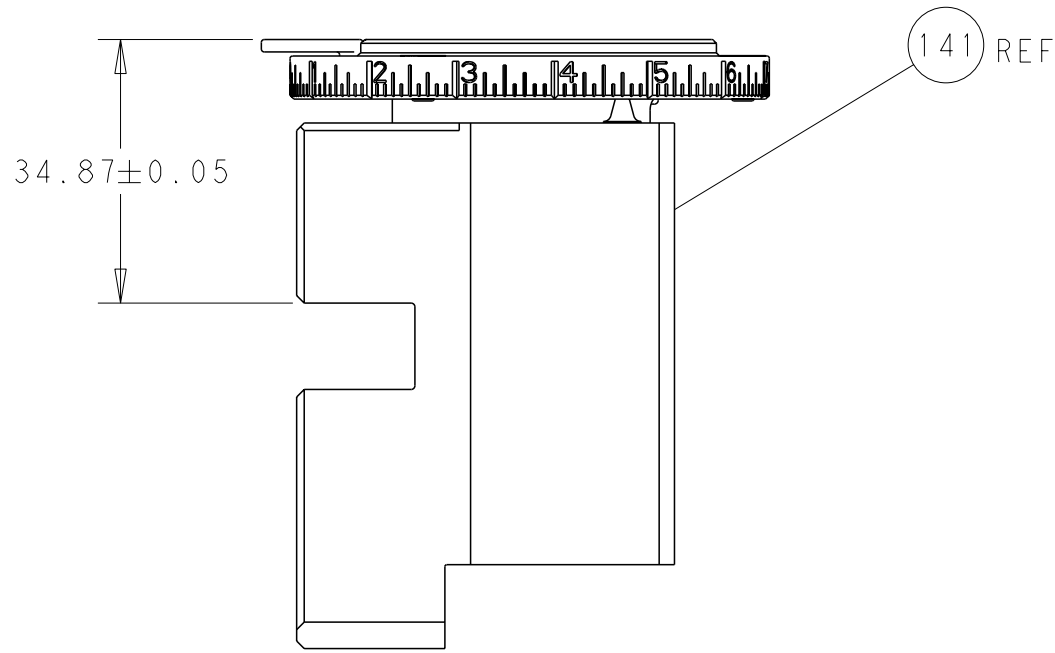
-77-22		PART NO	DESCRIPTION		ITEM NO
		OWN L. ZHANG CHK L. ZHANG APVD S. YI	29FEB2012 29FEB2012 29FEB2012		
		NAME		Ocean End Feed Applicator	
		SIZE		CAGE CODE	
		DRAWING NO		RESTRICTED TO	
		WEIGHT		SCALE	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 3 OF 4	

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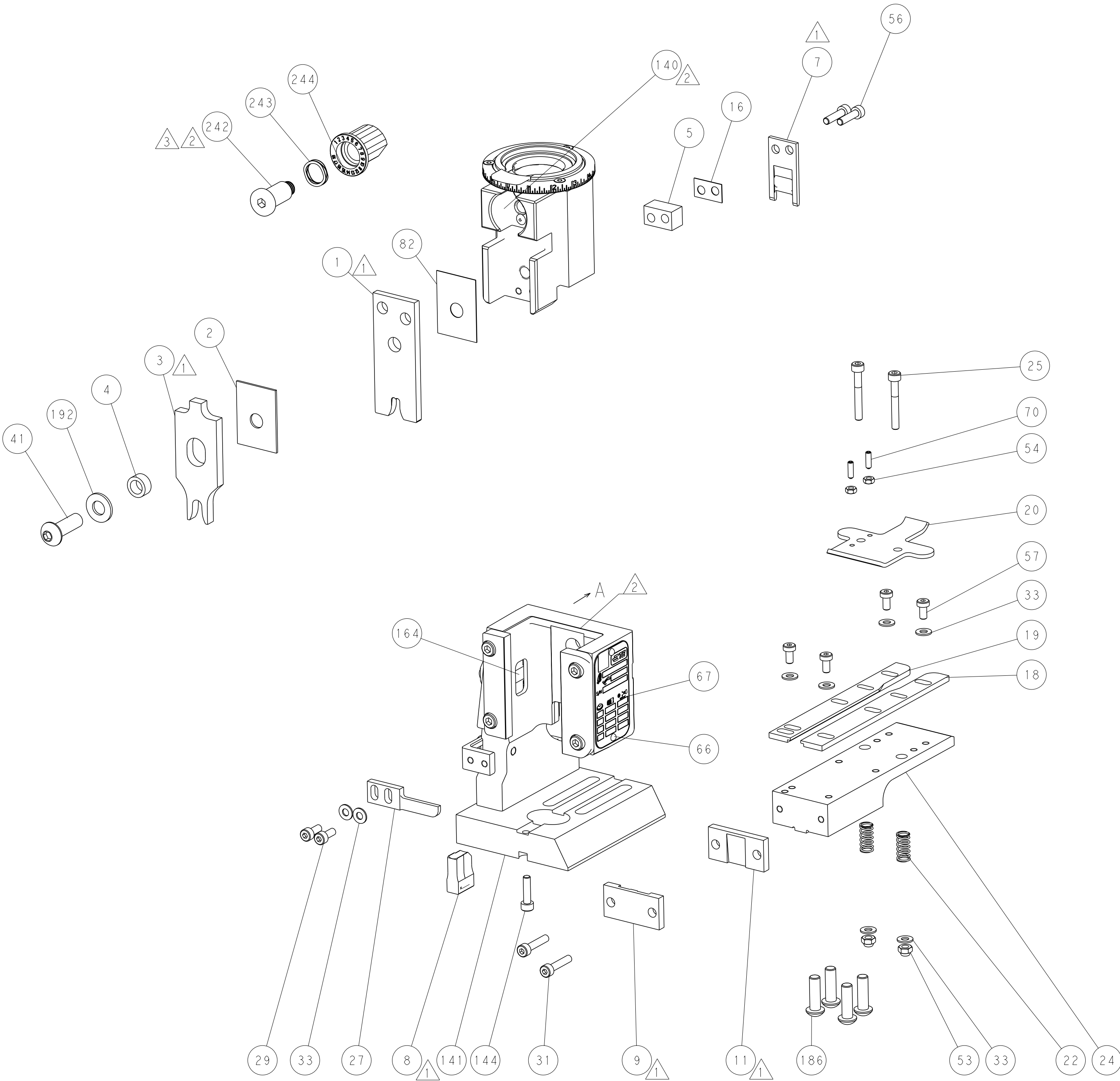
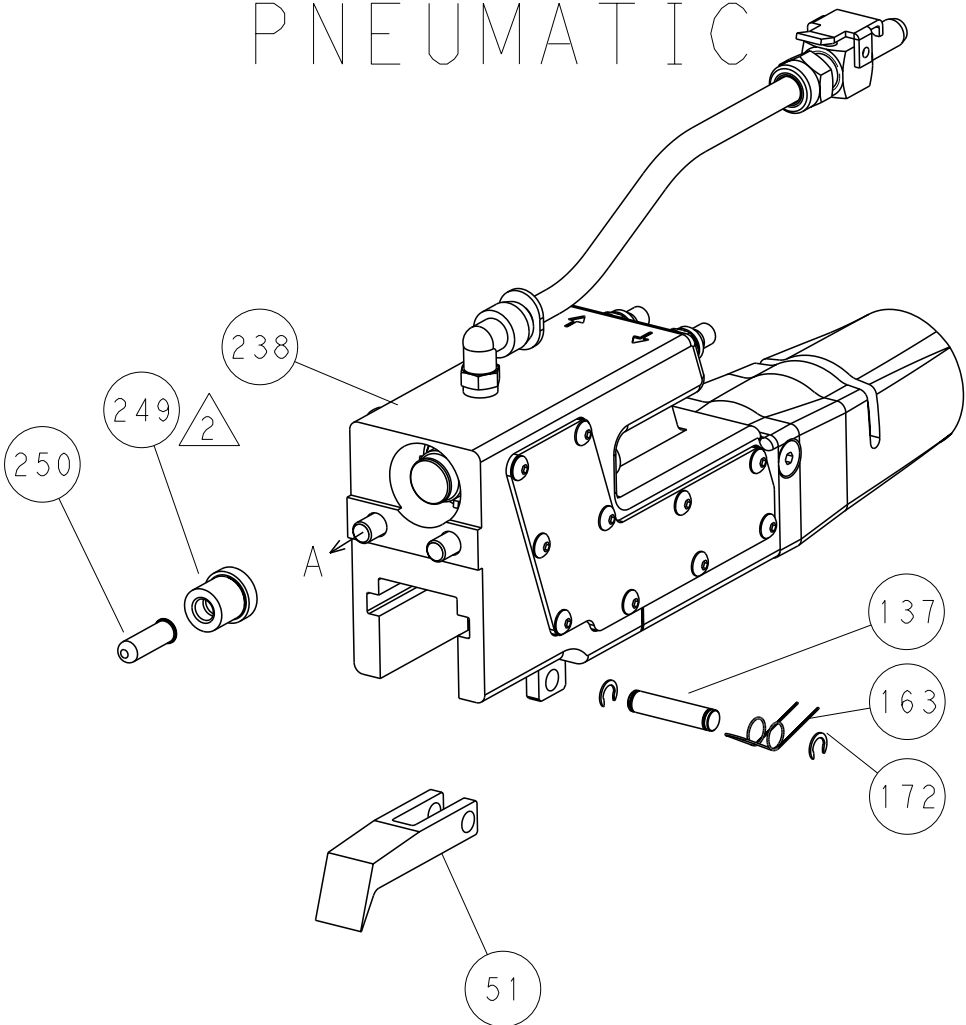
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		WEIGHT	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		-		-		-	
MATERIAL		FINISH		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE		SHEET 3 OF 4	

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

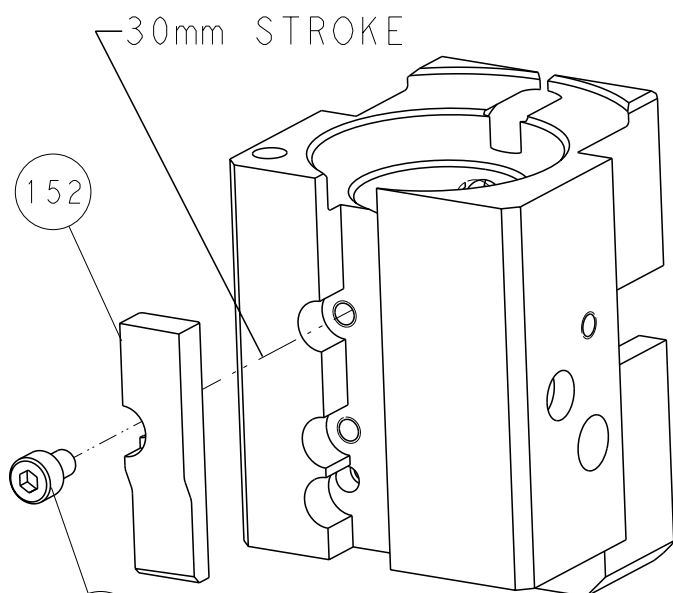


RAM SET-UP

FEED TYPE
PNEUMATIC



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN L. ZHANG 29FEB2012	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 29FEB2012		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD S. YI 29FEB2012	NAME Ocean End Feed Applicator	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	SIZE A1	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:1	
			SHEET 4	
			OF 4	
			REV C	