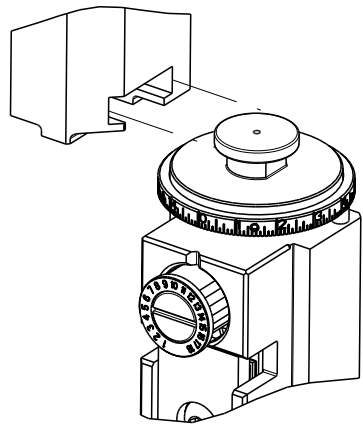


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150430-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150430-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150430-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150430-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150430-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2088		-	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4700 CMA		1.96+/-0.05 [.077+/- .002]		4.6
2500 CMA		1.70+/-0.05 [.067+/- .002]		7.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 5 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
- 6 POSITION ITEM 27 IN FRONT OF ITEM 1.
7. 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)

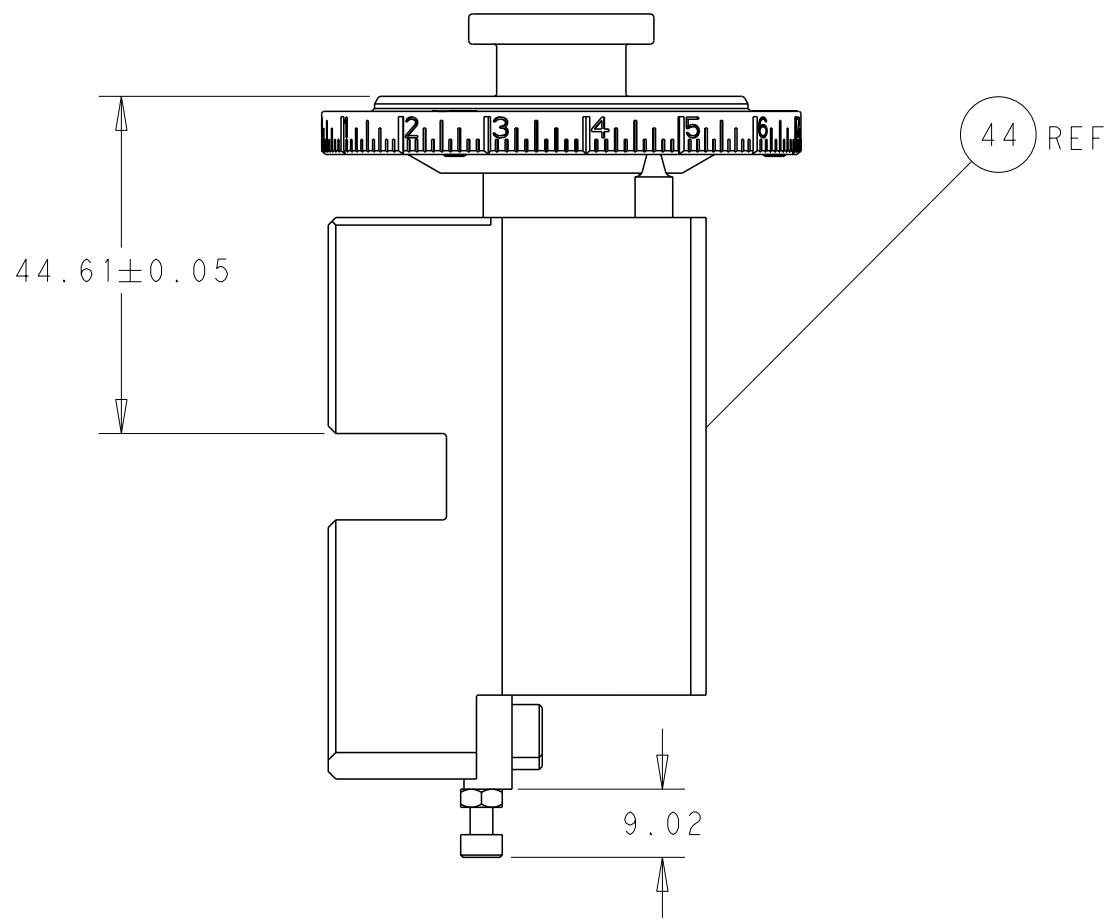
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			B	ECR-19-017880	19NOV2019	FJ
			B1	ECR-20-001142	23JAN2020	JAH
			C	ECO-20-006459	05MAY2020	MEH

-	1	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1	1	1803163-1	FLOATING SHEAR HOLDER	206
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	2	2	2	2	2-22280-0	SPRING, COMPRESSION	180
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178
-	1	1	1	1	356885-1	STOP, SHEAR	177
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	1-2063961-0	FEED FINGER	51
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1	1	464452-2	DRAG, STOCK	20
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
-	-	-	-	-	-	-	11
-	-	-	-	-	-	-	10
-	-	-	-	-	-	-	9
1	2	2	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1	1	1633722-1	SHEAR BLADE	7
-	-	-	-	-	-	-	6
-	1	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	459736-5	CRIMPER, WIRE	1
-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH				WEIGHT SCALE 1:1			
MATERIAL -				WEIGHT -				SCALE 1:1			
Customer Accessible Production Drawing				SHEET 1 of 4				REV C			

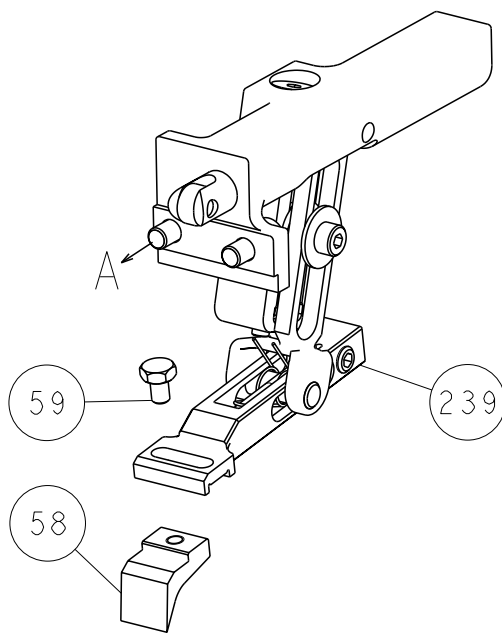
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS					
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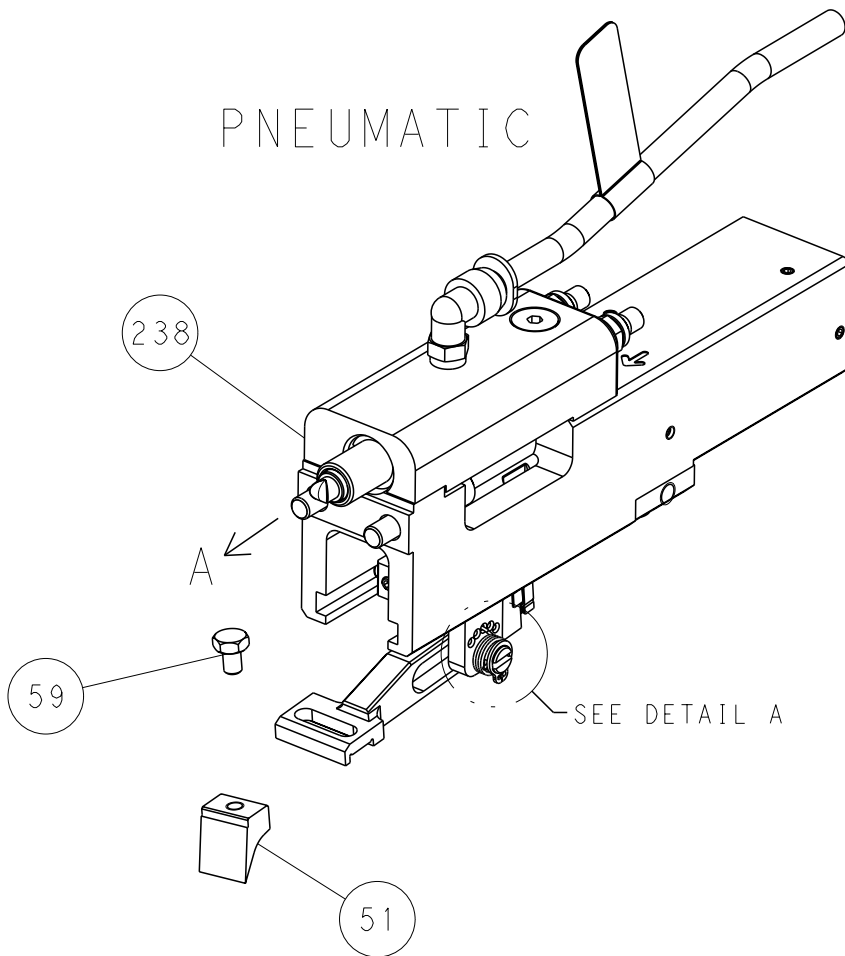


SHEAR TONKER SET UP

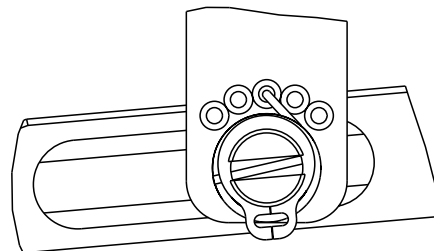
FEED TYPE
MECHANICAL



PNEUMATIC

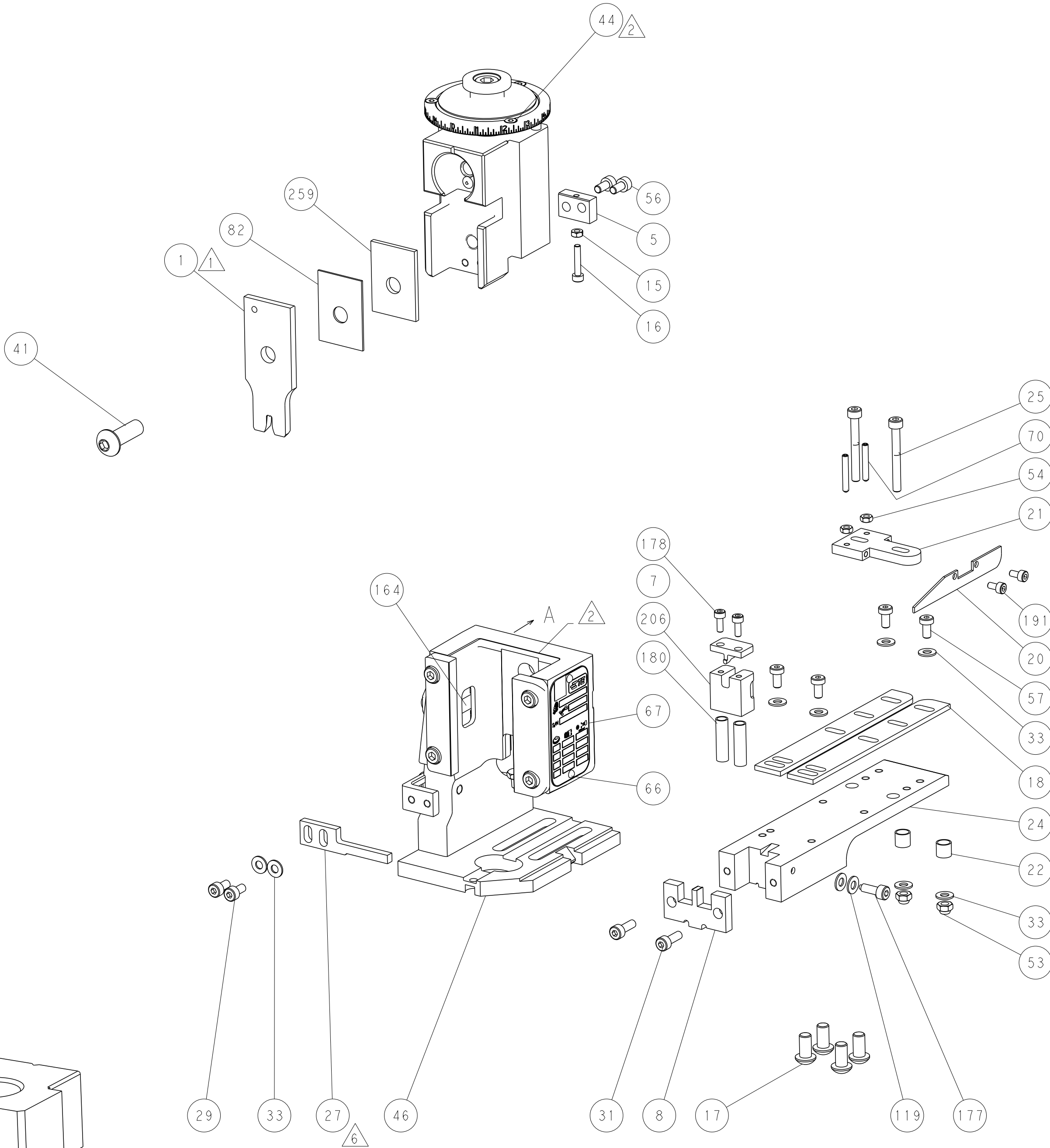
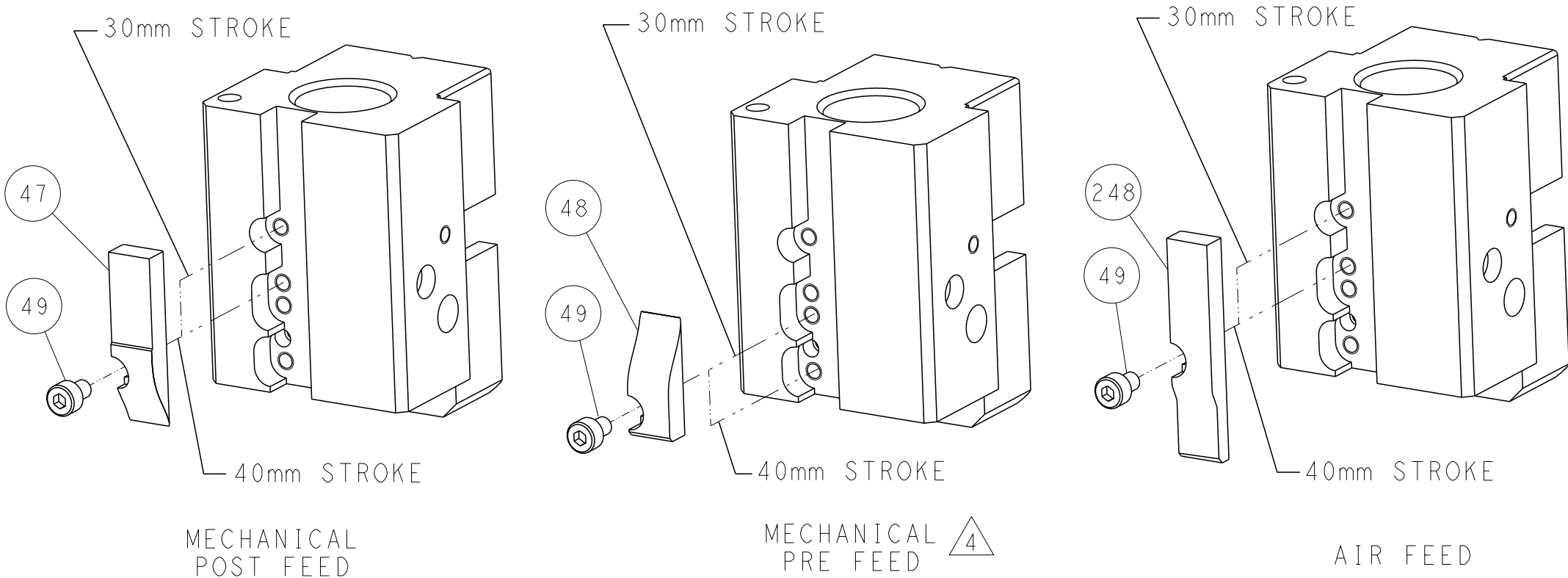


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS

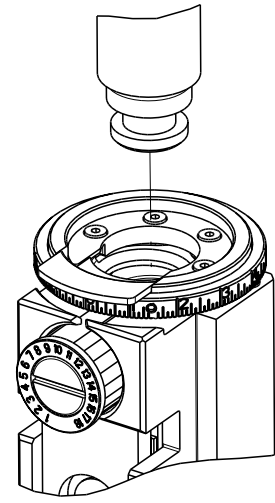


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

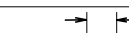
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	L. GROSS	19MAY2014	TE Connectivity Harrisburg, PA 17105-3608		
				CHK	T. ELBIN	19MAY2014			
				APVD	D. STOUGH	19MAY2014	NAME		
							Ocean End Feed Applicator		
							-		
							SIZE		
							A1		
							CAGE CODE		
							00779		
							DRAWING NO		
							C=2150430		
							RESTRICTED TO		
							-		
							Customer Accessible Production Drawing		
							SCALE		
							1:1		
							SHEET		
							2		
							OF		
							4		
							REV		
							C		

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150430-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150430-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150430-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]			INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION 	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]			INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION 	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL 40504	TE TERMINAL -	TE TERMINAL -	TE TERMINAL -

WIRE SIZE	 CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT REFERENCE SETTING
4700 CMA	1.96+/-0.05 [.077+/- .002]		4.6
2500 CMA	1.70+/-0.05 [.067+/- .002]		7.5

WIRE SIZE	 CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT REFERENCE SETTING
5250 AWG	2.02+/-0.05 [.080+/- .002]		3.9
2048 AWG	1.65+/-0.05 [.065+/- .002]		8.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 5 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
- 6 POSITION ITEM 27 IN FRONT OF ITEM 1.
7. 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)

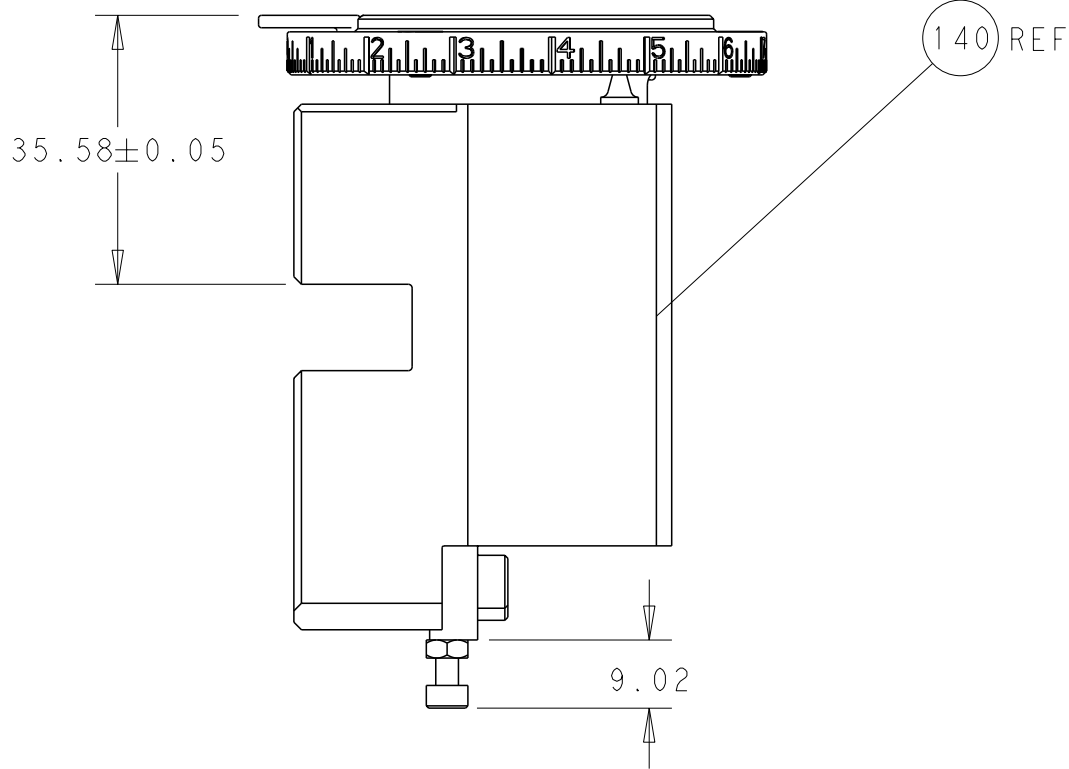
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LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	1803078-2	SPACER, PRECISION	259
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1803163-1	FLOATING SHEAR HOLDER	206
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	2	2-22280-0	SPRING, COMPRESSION	180
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178
-	1	1	356885-1	STOP, SHEAR	177
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	455888-8	SPACER, CRIMPER	82
-	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
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	1-2063961-0	FEED FINGER	51
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1803162-1	PLATE, STRIP GUIDE	24
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	464452-2	DRAG, STOCK	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
-	-	-	-	-	11
-	-	-	-	-	10
-	-	-	-	-	9
1	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1633722-1	SHEAR BLADE	7
-	-	-	-	-	6
-	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	459736-5	CRIMPER, WIRE	1
-77-22-21			PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:				CHK T. ELBIN 19MAY2014			
mm				APVD D. STOUGH 19MAY2014			
				PRODUCT SPEC			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APPLICATION SPEC	NAME Ocean End Feed Applicator		
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				-	SIZE 00779		
FINISH				WEIGHT	CAGE CODE 00779		
-				-	DRAWING NO 2150430		
-				Customer Accessible Production Drawing	RESTRICTED TO		
				SCALE 1:1	SHEET 3		
					OF 4		
					REV C		

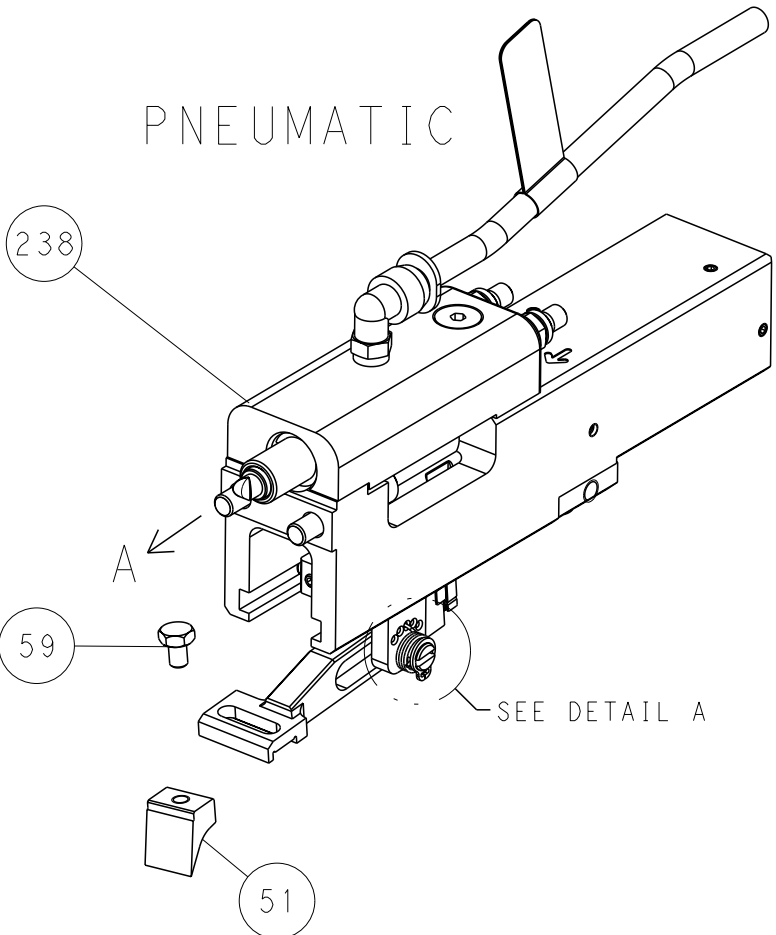
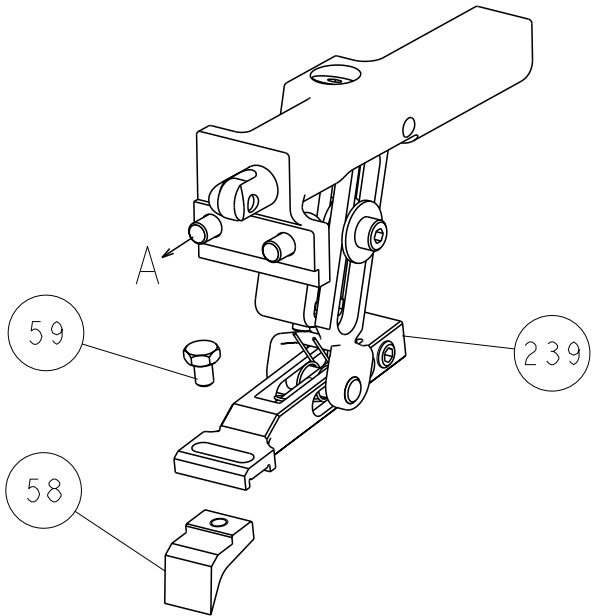
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

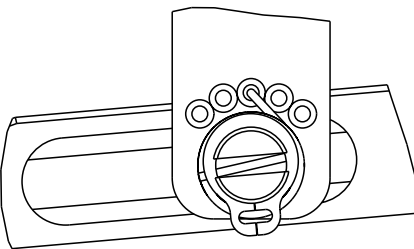


SHEAR TONKER SET UP

FEED TYPE
MECHANICAL

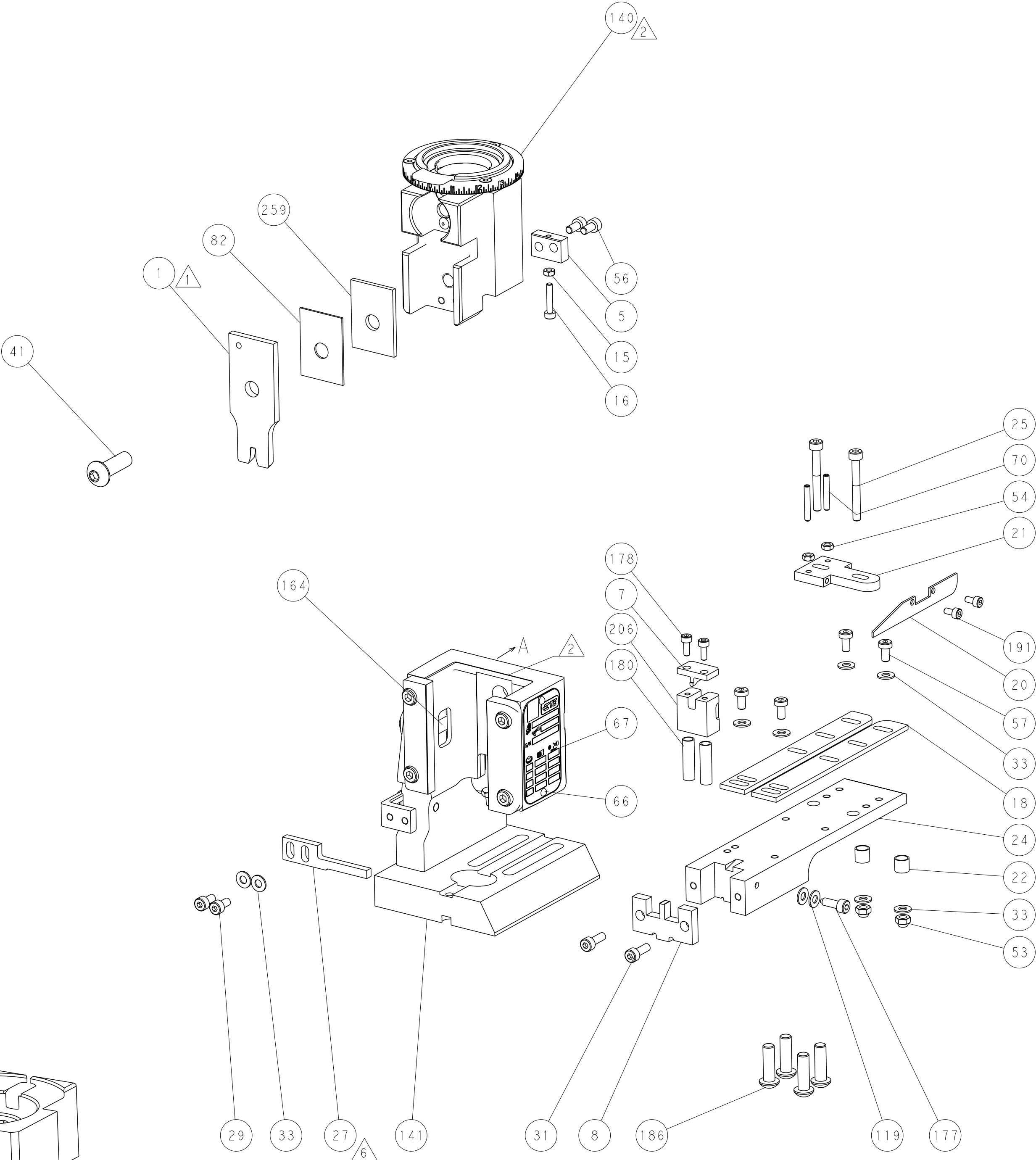
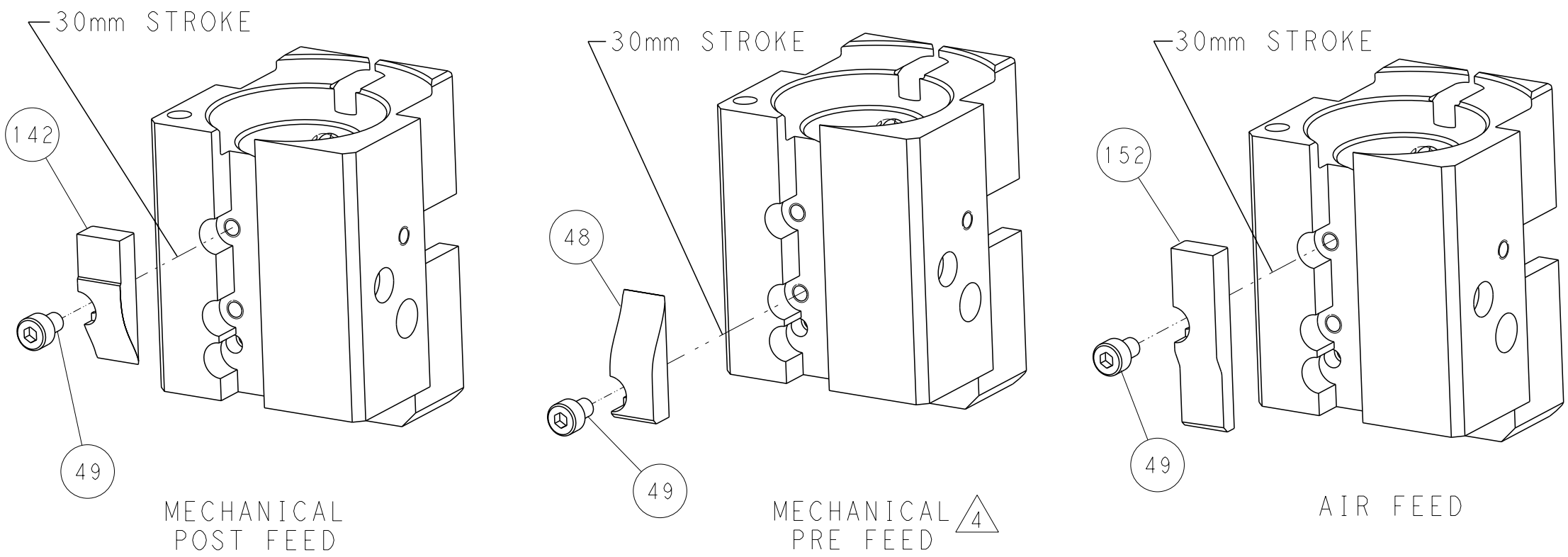


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



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 THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	L. GROSS	19MAY2014	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	T. ELBIN	19MAY2014		
				APVD	D. STOUGH	19MAY2014	NAME	
				PRODUCT SPEC			Ocean End Feed Applicator	
				APPLICATION SPEC			-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A1	00779	©=2150430	-	
				Customer Accessible Production Drawing			SCALE	1:1
							SHEET	4
							OF	4
							REV	C