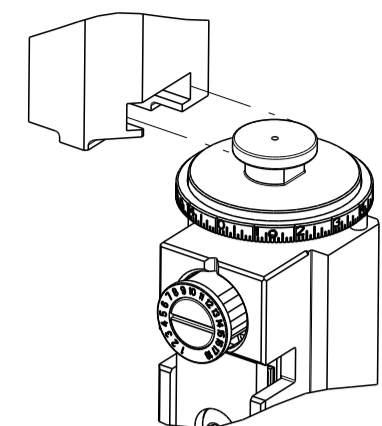


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150403-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150403-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150403-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.05 mm [.120]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: STOCKO/LNX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, TAB 6.3			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm [.228-.260 IN]		∅1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO/LNX TERMINAL	TE TERMINAL	STOCKO/LNX TERMINAL
1572348-1	7831.010.76.3-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.75+/-0.03 [.069+/- .001]	5.4
1.00mm2	1.55+/-0.03 [.061+/- .001]	7.5
0.75mm2	1.45+/-0.03 [.057+/- .001]	8.7
0.50mm2	1.37+/-0.03 [.054+/- .001]	9.4



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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.

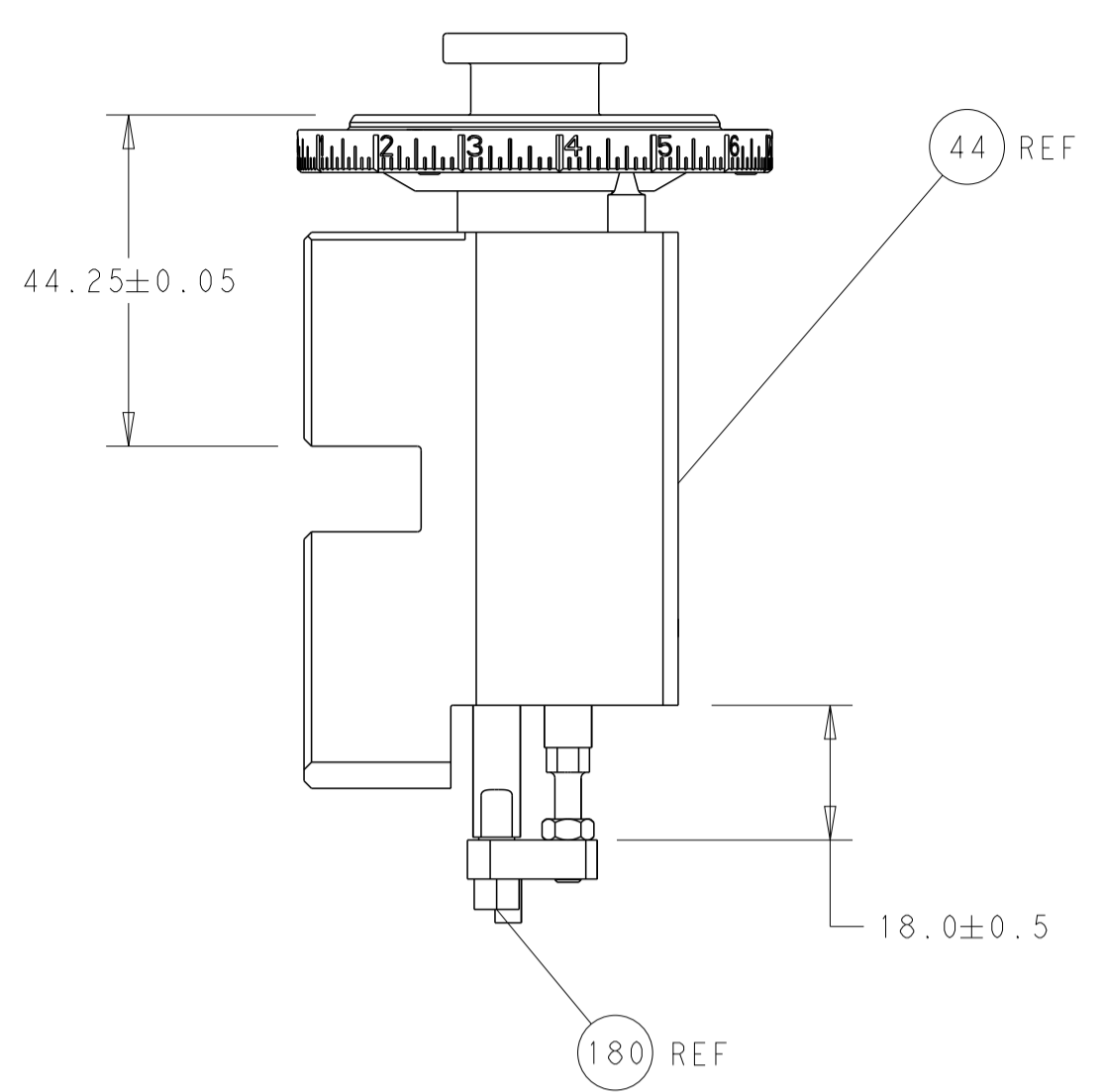
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-21-000502	16JAN2021	TB	RK

-	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	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	1	1	1752354-1	STANDOFF, HOLD-DOWN	180	
-	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1976052-1	HOLDDOWN, TERMINAL	65	
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1	2063961-1	FEED FINGER	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	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	4-240641-7	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	3-690482-2	PLATE, FRONT SHEAR	9	
	1	2	1	3-1333217-2	ANVIL, EF .090	8
	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	1-240641-8	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	2	2	2	455888-3	SPACER, CRIMPER	2
	1	2	1	5-456406-7	CRIMPER, WIRE PREMIUM	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)

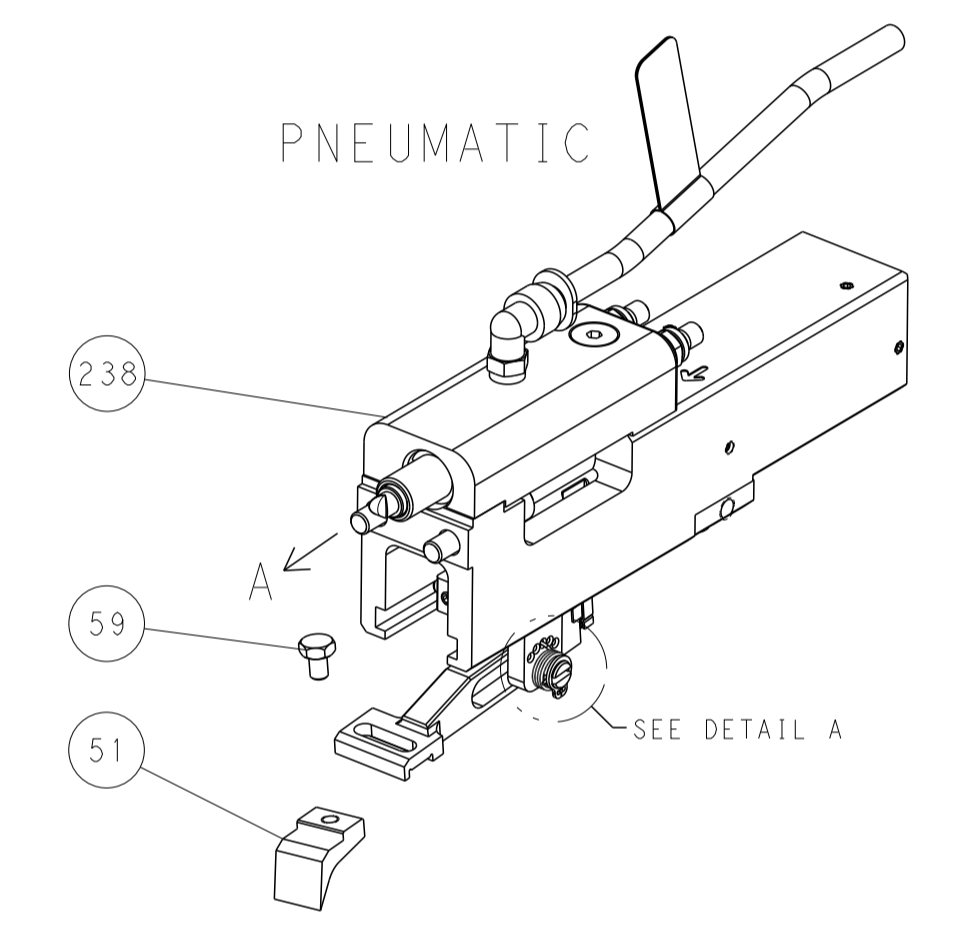
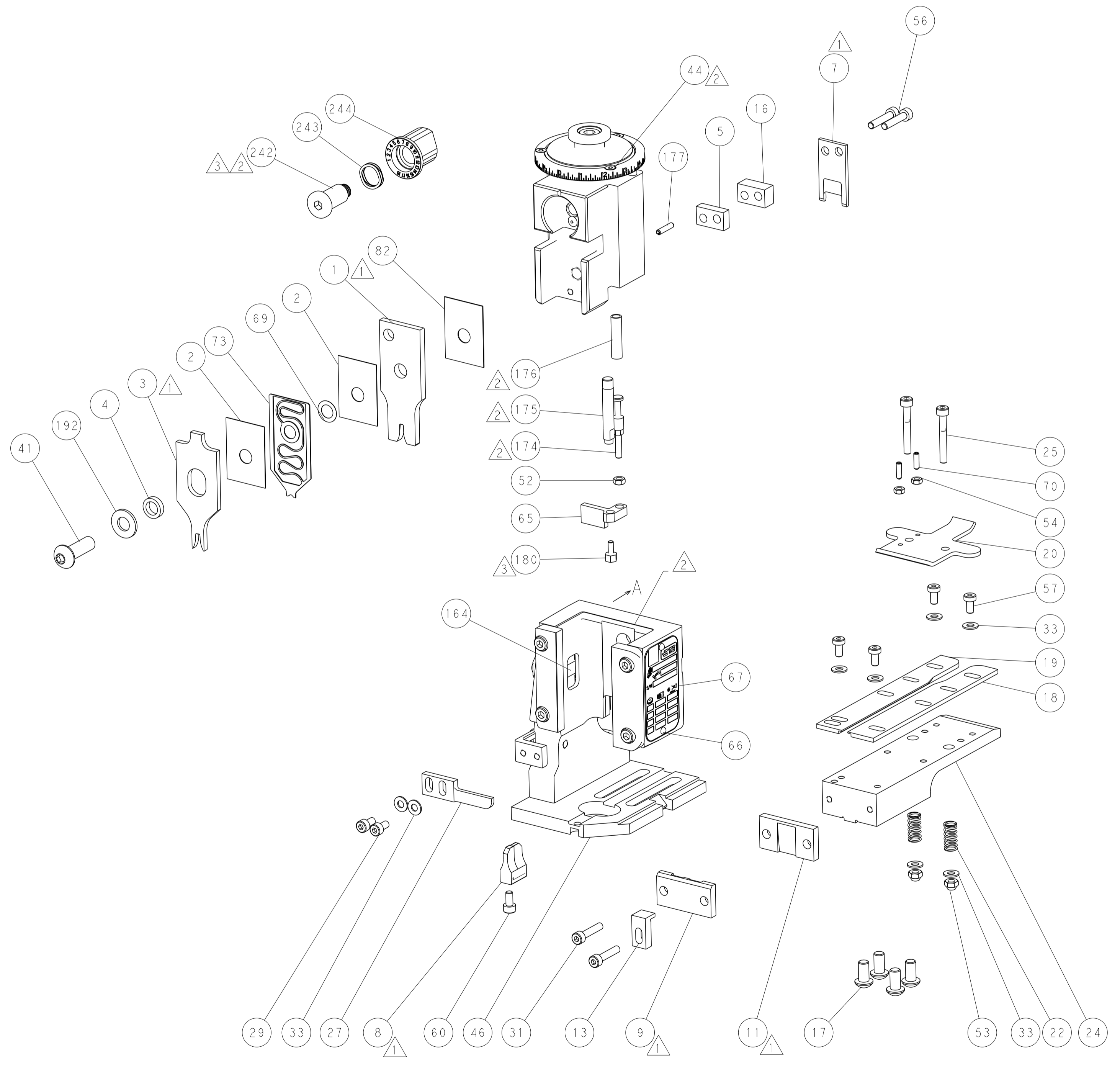
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. COPYRIGHT 2014.</small>		DWN R. HUANG 11DEC2013 CHK L. ZHANG 11DEC2013 APVD J. GUO 11DEC2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 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 C=2150403 Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV B

LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

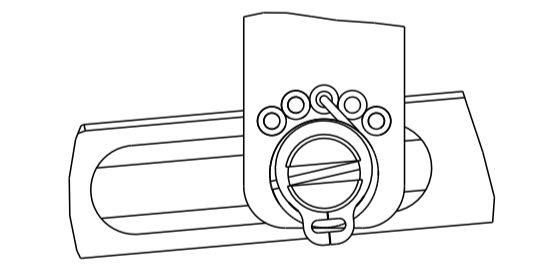


RAM AND HOLDDOWN SET-UP

FEED TYPE

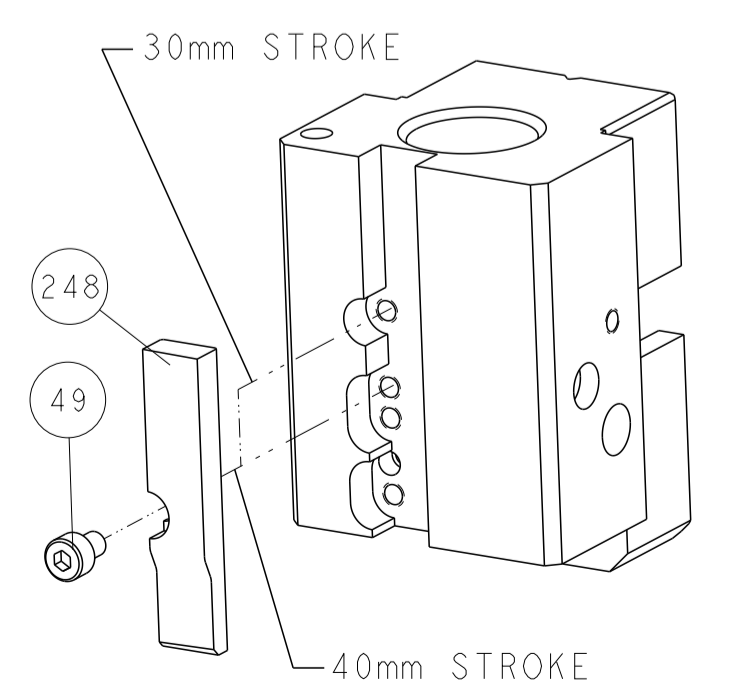


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



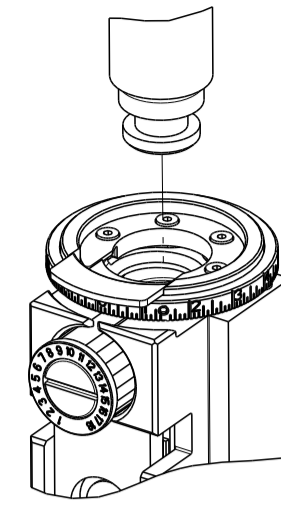
AIR FEED

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	K. HUANG	11DEC2013	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	L. ZHANG	11DEC2013	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	J. GUO	11DEC2013	NAME
MATERIAL	FINISH	WEIGHT	Customer Accessible Production Drawing	SCALE	1:1	SHEET	2 of 4
							REV

8	7	6	5	4	3	2	1
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COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150403-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150403-7	A	CRIMP TOOLING KIT	-				

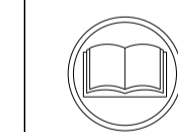
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.05 mm (.120)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO/LNX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, TAB 6.3			
WIRE STRIP LENGTH 5.80-6.60 mm (.228-.260 IN)		INSULATION DIAMETER RANGE Ø1.52-2.54 mm (.060-.100 IN)	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO/LNX TERMINAL	TE TERMINAL	STOCKO/LNX TERMINAL
1572348-1	7831.010.Z6.3-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.75+/-0.03 [.069+/-0.001]	5.4
1.00mm2	1.55+/-0.03 [.061+/-0.001]	7.5
0.75mm2	1.45+/-0.03 [.057+/-0.001]	8.7
0.50mm2	1.37+/-0.03 [.054+/-0.001]	9.4



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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.

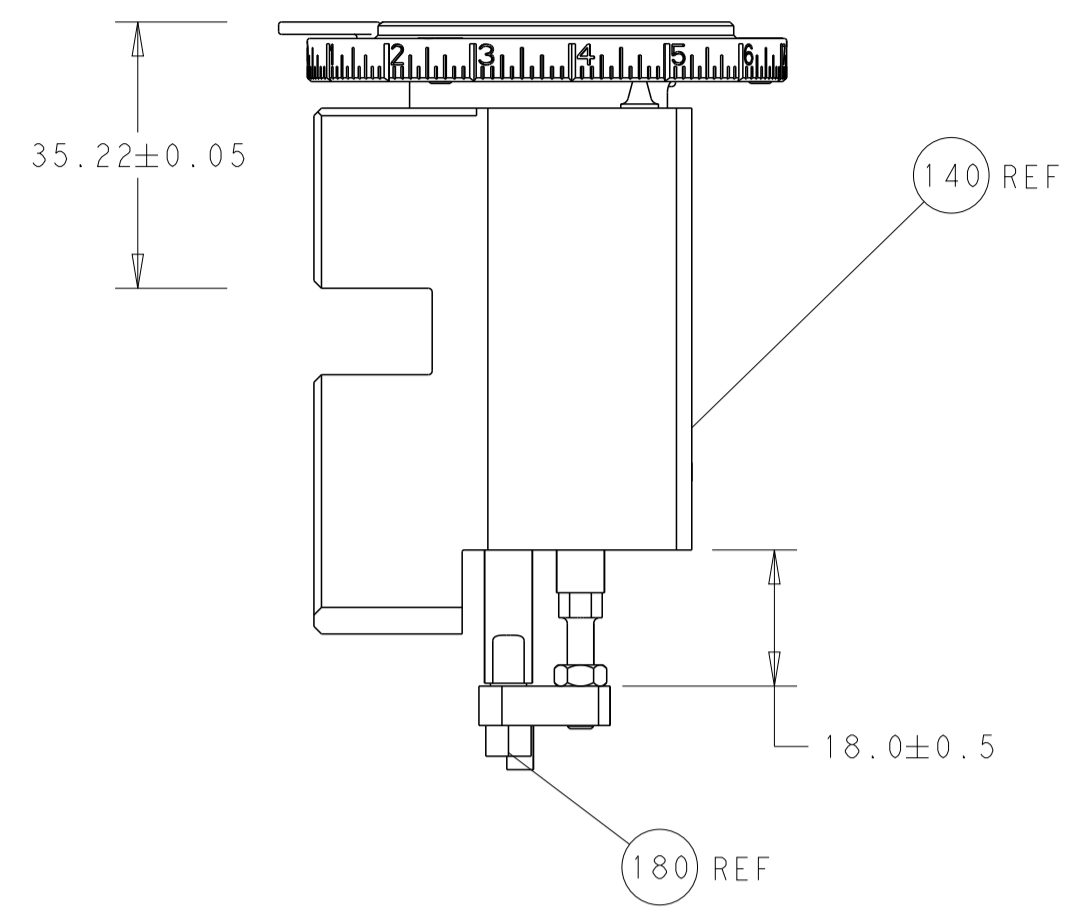
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1752354-1	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	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	455888-4	SPACER, CRIMPER	82
-	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1976052-1	HOLDDOWN, TERMINAL	65
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	2063961-1	FEED FINGER	58
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-1	FEED FINGER	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-8	STRIP GUIDE, REAR	19
-	1	1-1901695-8	STRIP GUIDE, FRONT	18
-	1	4-240641-7	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	10
1	-	3-690482-2	PLATE, FRONT SHEAR	9
1	1	3-1333217-2	ANVIL, EF .090	8
1	-	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6
-	1	1-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	2	455888-3	SPACER, CRIMPER	2
1	1	5-456406-7	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

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

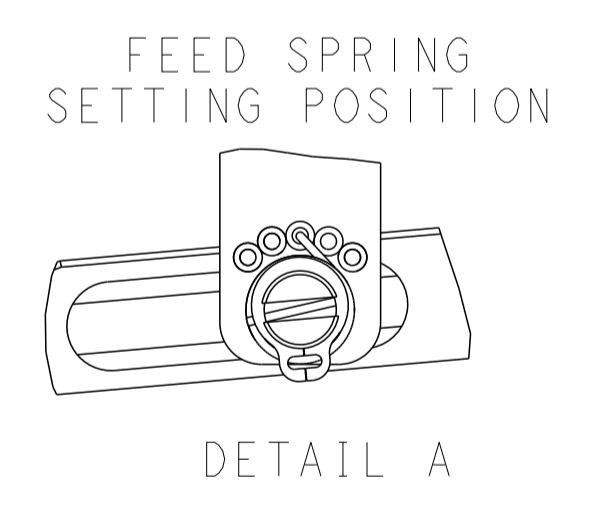
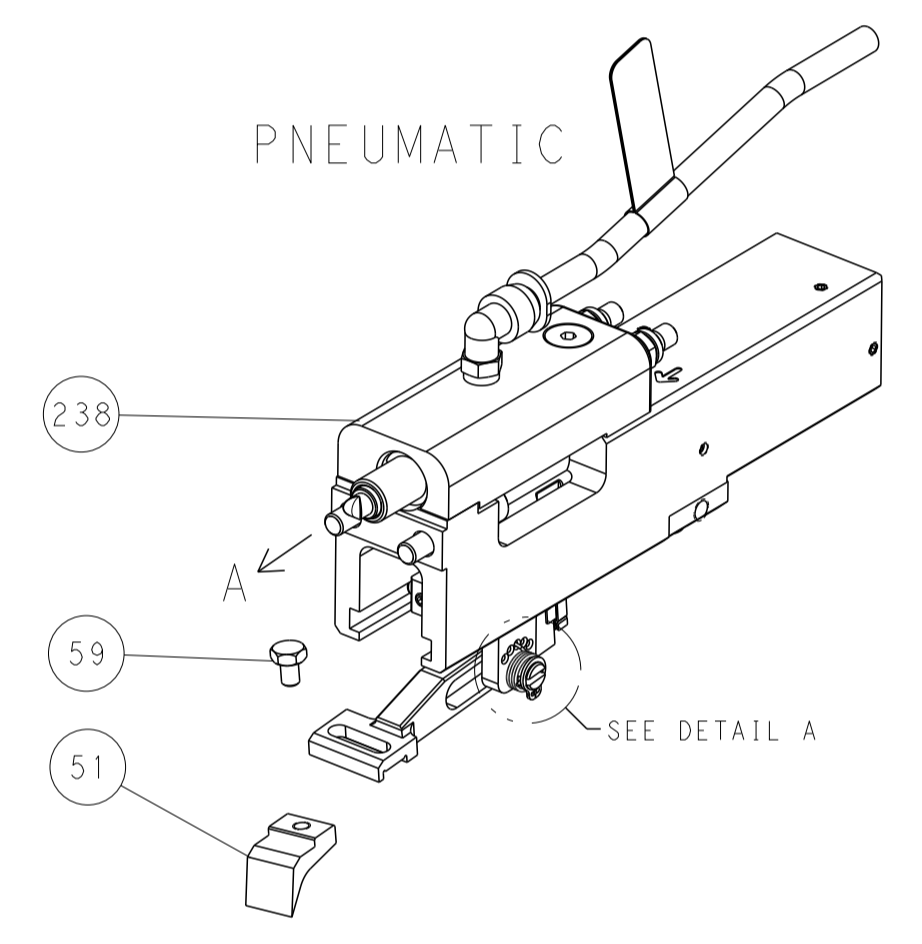
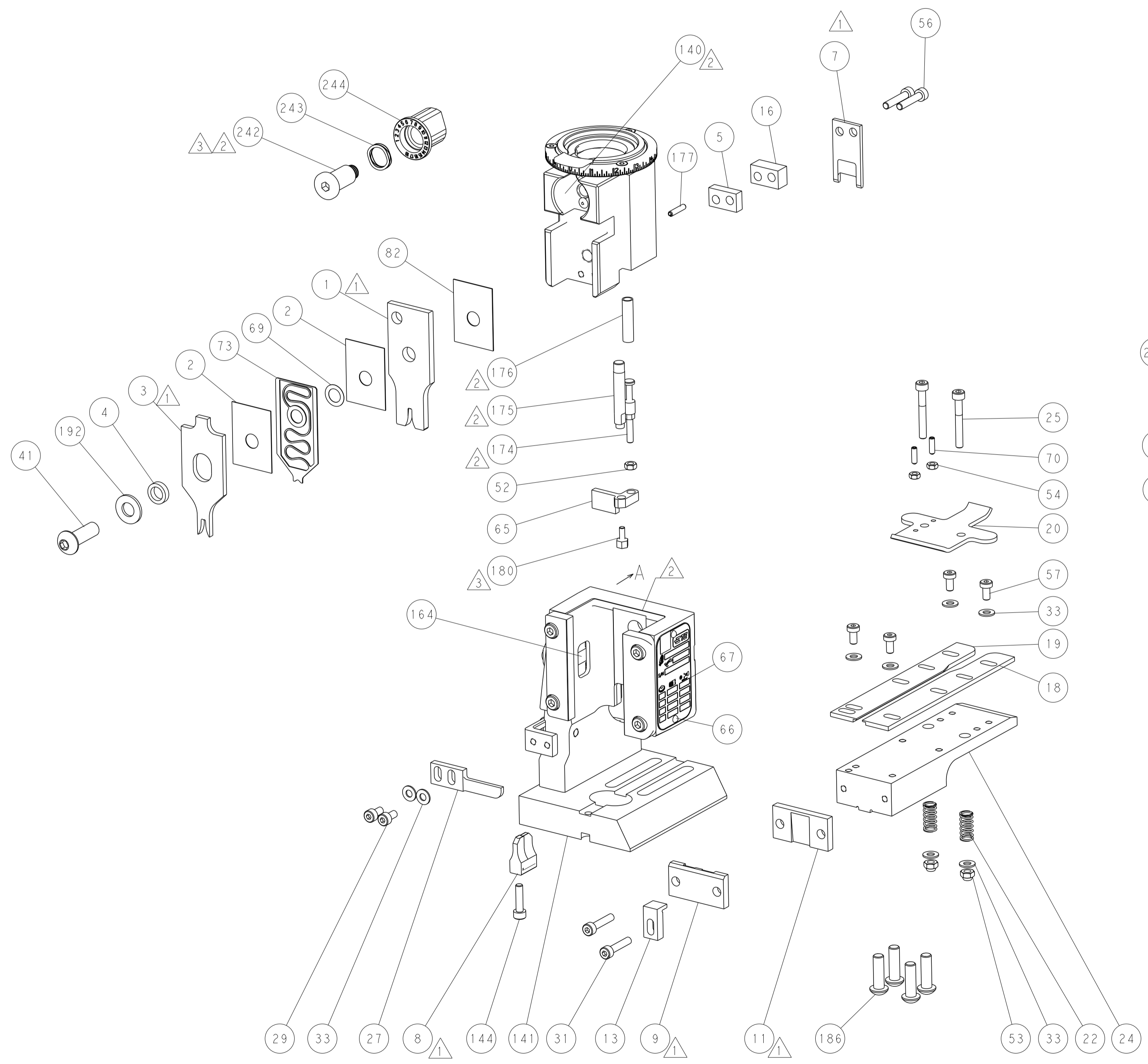
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 11DEC2013		CHK: L. ZHANG 11DEC2013		APVD: J. GUO 11DEC2013		NAME: TE Connectivity Harrisburg, PA 17105-3608			
0 PLC	±	1 PLC	±	PRODUCT SPEC									
2 PLC	±	3 PLC	±	APPLICATION SPEC									
4 PLC	±	ANGLES	±	WEIGHT									
FINISH	±	MATERIAL	±	SCALE									
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO						
				A1	00779	2150403							
				Customer Accessible Production Drawing		SCALE	1:1	SHEET	3	OF	4	REV	B

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

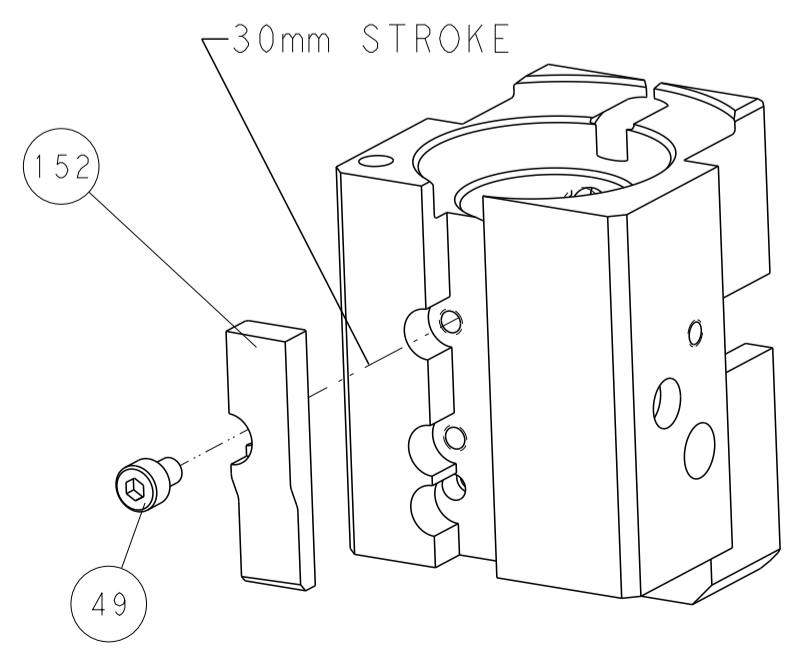


RAM AND HOLDDOWN SET-UP

FEED TYPE



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150403 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 4 OF 4 REV: B	Customer Accessible Production Drawing