

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150018-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150018-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150018-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150018-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150018-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .156 DIA SHUR PLUG REC			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.14-4.15 mm [.163-.163 IN]		Ø1.40-2.70 mm [.055-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2042		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
881724-1	881724-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.63 +/- 0.05 [.064 +/- .002]	7.8
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	8.9
0.50mm2	1.45 +/- 0.05 [.057 +/- .002]	9.6

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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. 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.

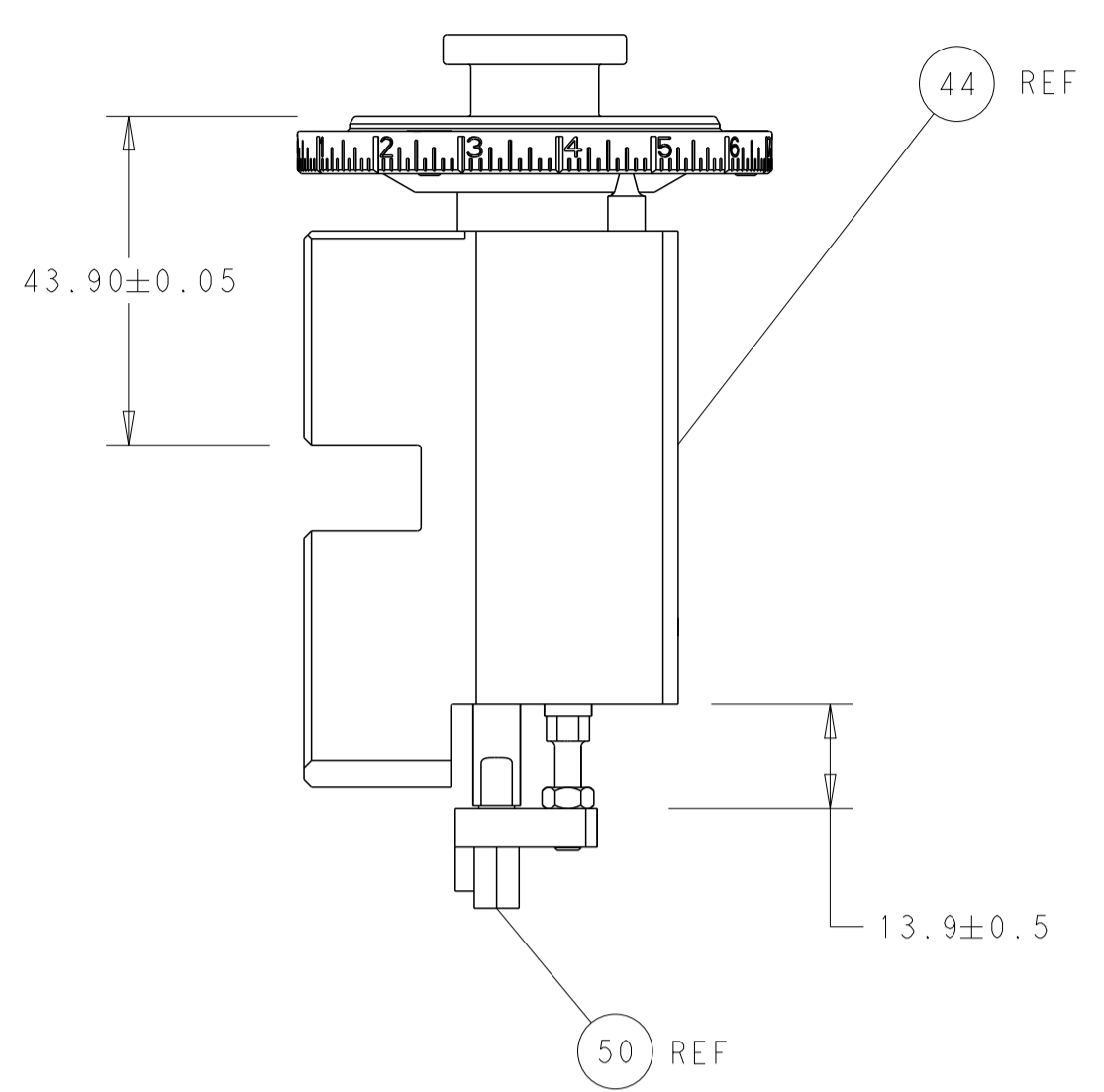
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		ORIGINAL	12APR2013	SA	CL
		A		RELEASED	01NOV2013	EO	CL
		B		ECR-22-131807	08MAR2022	JWC	RK

-	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	-	2844940-3	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2161924-2	FEED FINGER	58	
-	3	3	3	3	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	-	2161924-2	FEED FINGER	51	
-	1	1	1	1	1-1752354-7	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	
-	7	7	7	7	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	4-22281-1	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	5-240641-4	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	2	2	1	2-1803001-1	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	690474-3	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-2119785-9	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	2	2	1	3-1633305-1	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

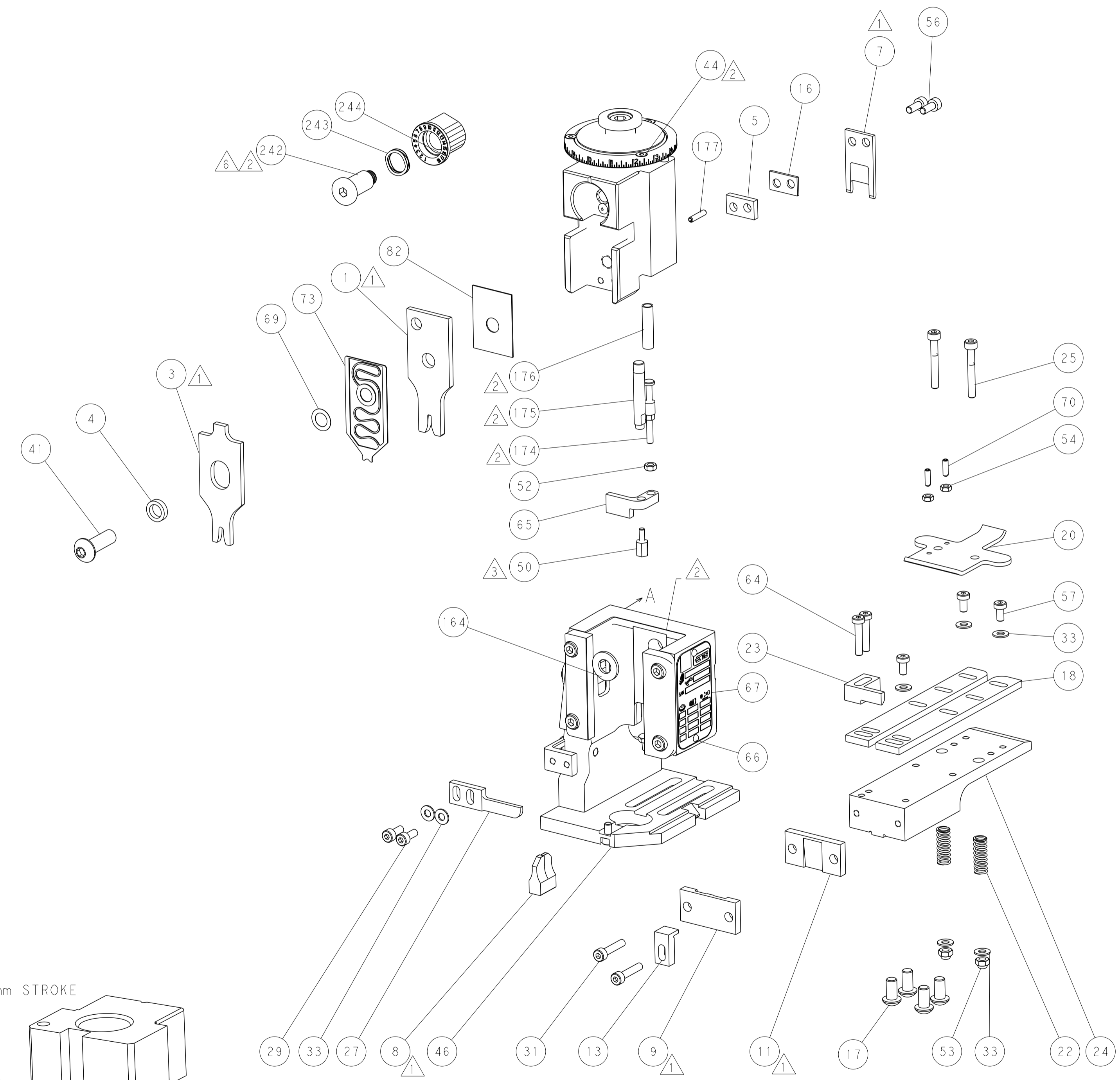
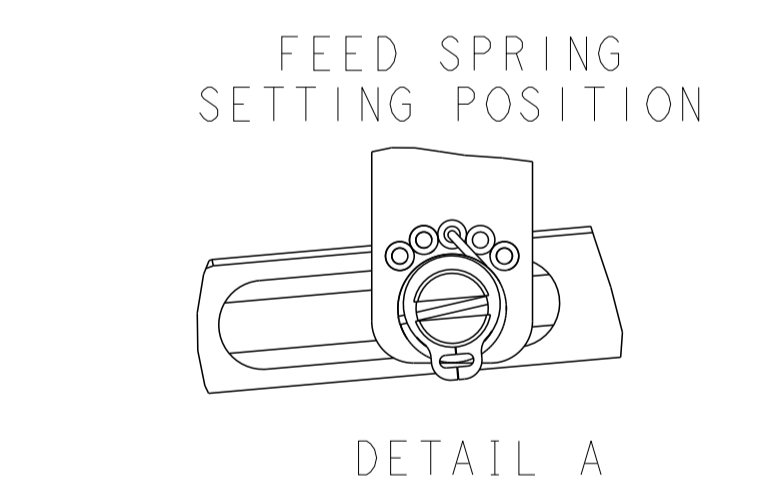
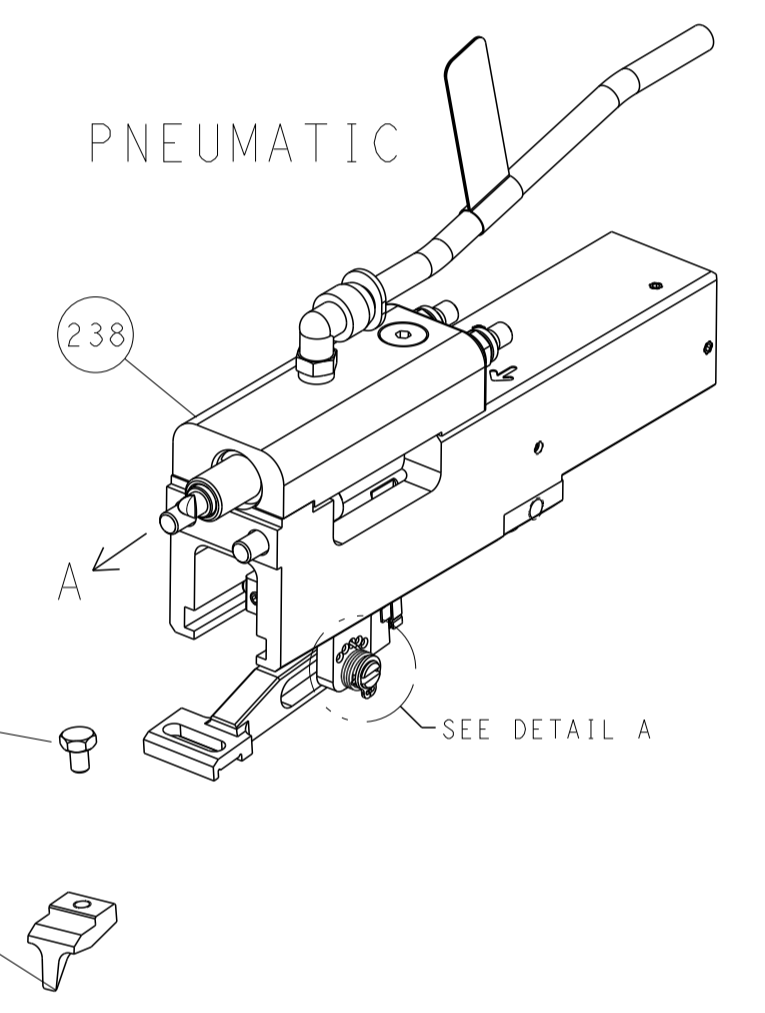
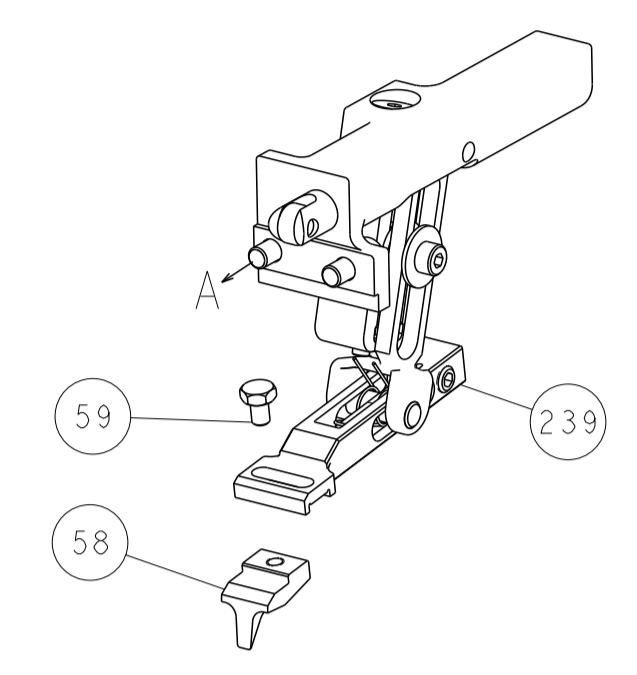
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL:		FINISH:		WEIGHT:		SCALE:	
				A1 00779		C=2150018	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:1		SHEET 1 OF 4	

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

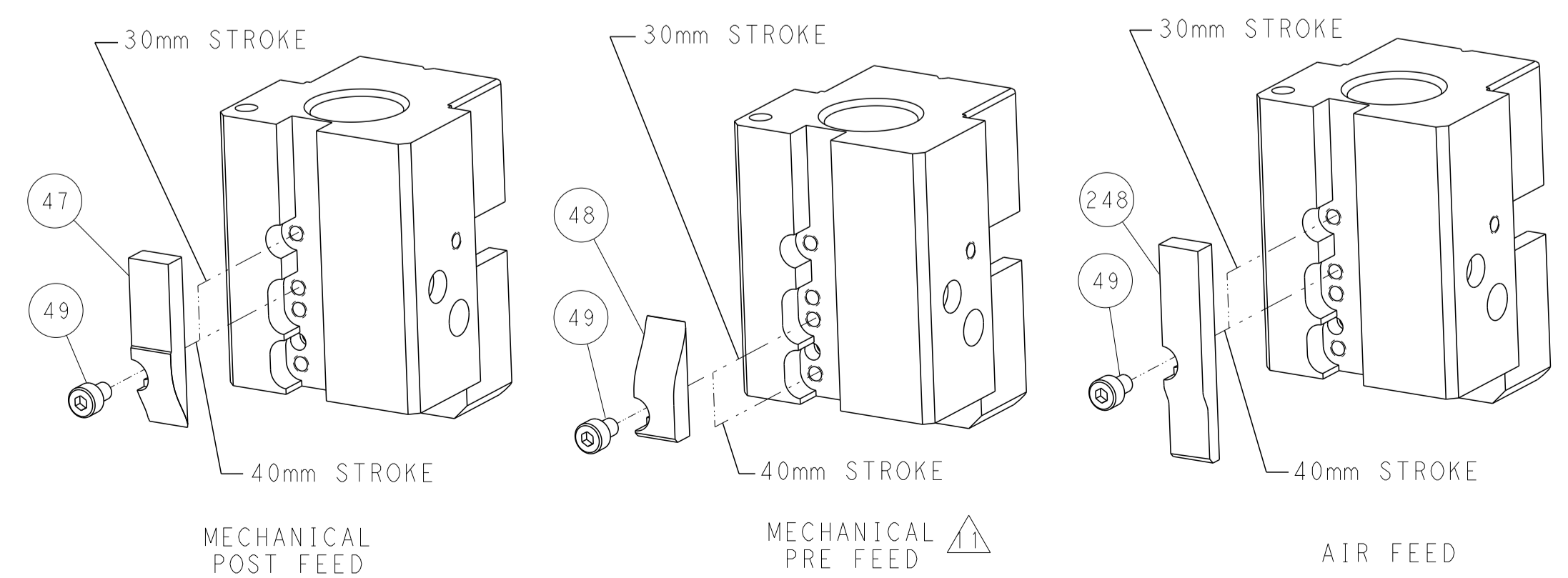


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

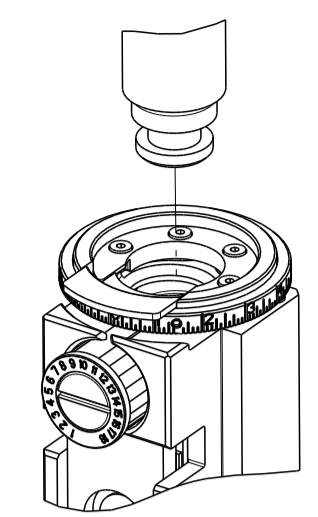


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN S. ALVES 12APR2013 CHK P. BARLETTA 12APR2013 APVD C. LIMA 12APR2013 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150018 CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:1 SHEET 2 OF 4 REV B	
MATERIAL:		WEIGHT:		DATE: 12APR2013 DRAWING NO: 00779 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150018-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150018-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150018-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.05 mm (.120)	OV

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .156 DIA SHUR PLUG REC

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.14-4.15 mm (.163-.163 IN)	Ø1.40-2.70 mm (.055-.106 IN)

TERMINAL APPLICATION SPECIFICATION 114-2042

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
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WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup>	1.63 +/- 0.05 [.064 +/- .002]	7.8
0.75mm <sup>2</sup>	1.52 +/- 0.05 [.060 +/- .002]	8.9
0.50mm <sup>2</sup>	1.45 +/- 0.05 [.057 +/- .002]	9.6

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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 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.

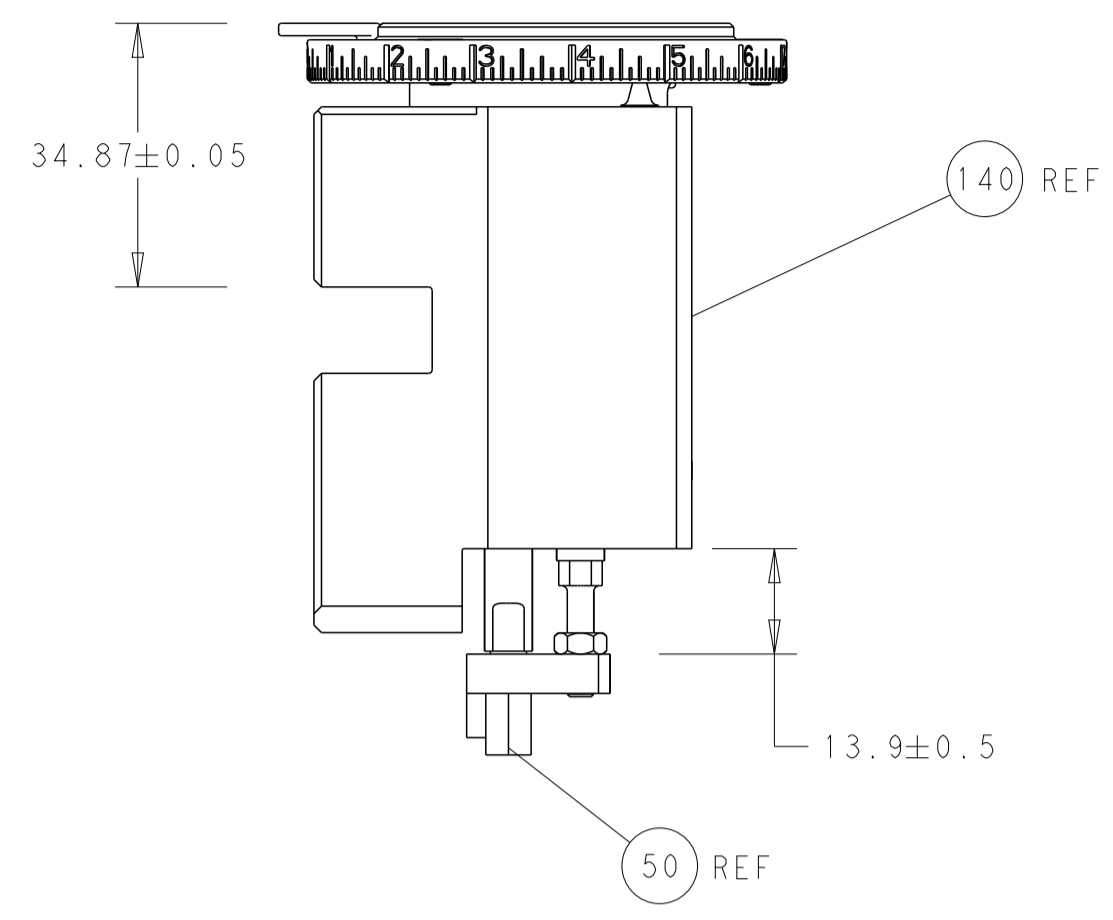
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2161924-2	FEED FINGER	58	
-	3	3	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	-	2161924-2	FEED FINGER	51	
3	-	1	1-1752354-7	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	
-	7	7	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	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	4-22281-1	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	1	1	5-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	690482-3	PLATE, FRONT SHEAR	9	
1	1	1	2-1803001-1	ANVIL, COMBINATION, END FEED	8	
1	-	1	690474-3	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-1	SPACER	5	
1	-	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	1	1-2119785-9	CRIMPER, INSULATION OVERLAP PREMIUM	3	
1	1	1	3-1633305-1	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

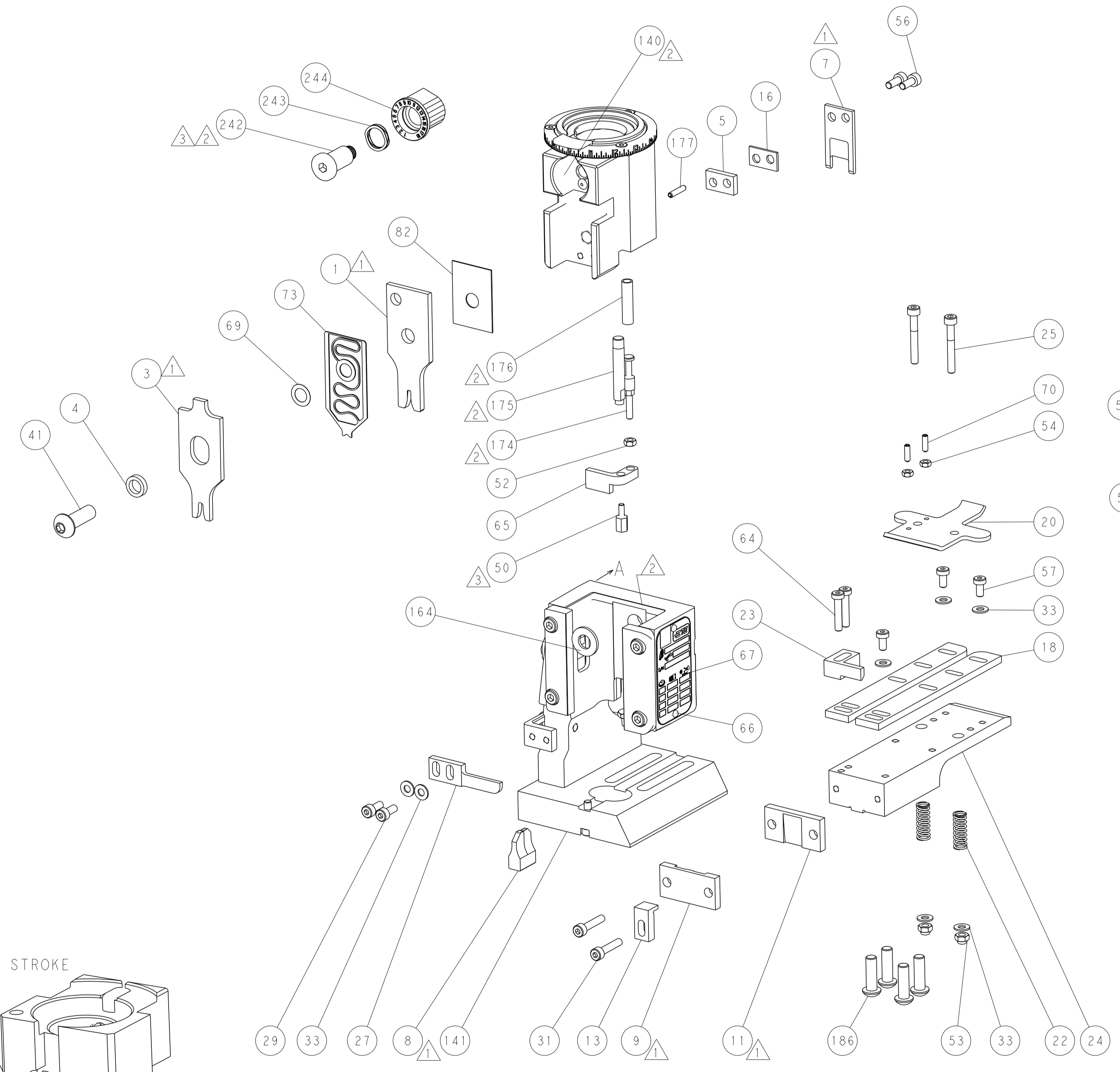
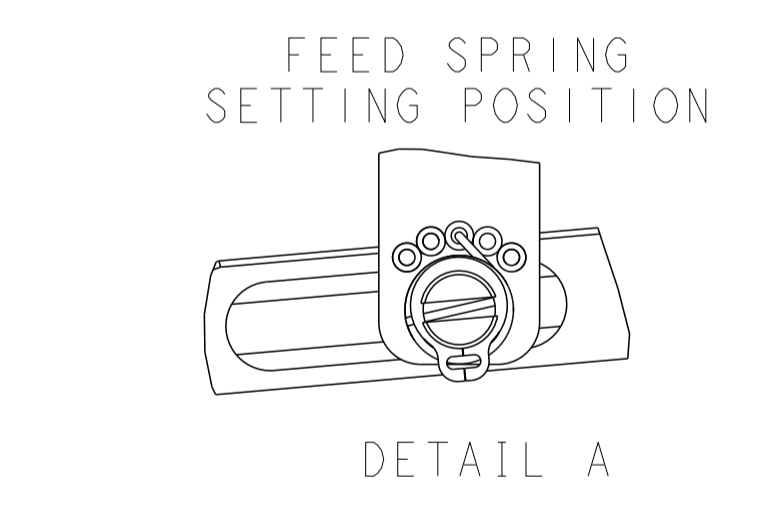
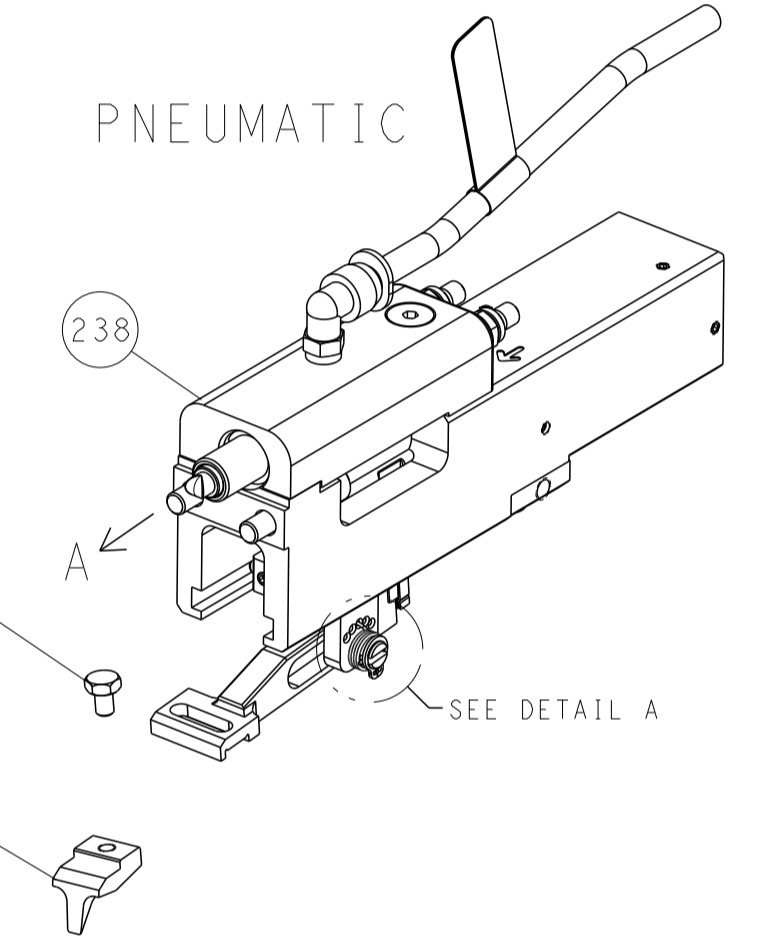
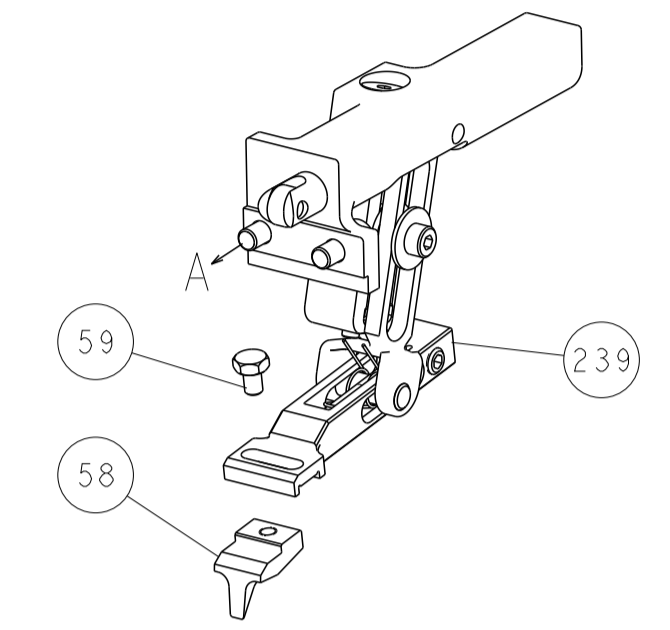
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN	
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	3 PLC ±	4 PLC ±	ANGLES ±	P. BARLETTA	12APR2013
	FINISH			C. LIMA	12APR2013
MATERIAL		WEIGHT		TE Connectivity Harrisburg, PA 17105-3608	
				Ocean End Feed Applicator	
				SIZE	CAGE CODE
				A1	00779
				SCALE	1:1
				SHEET	3 OF 4
				REV	B

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

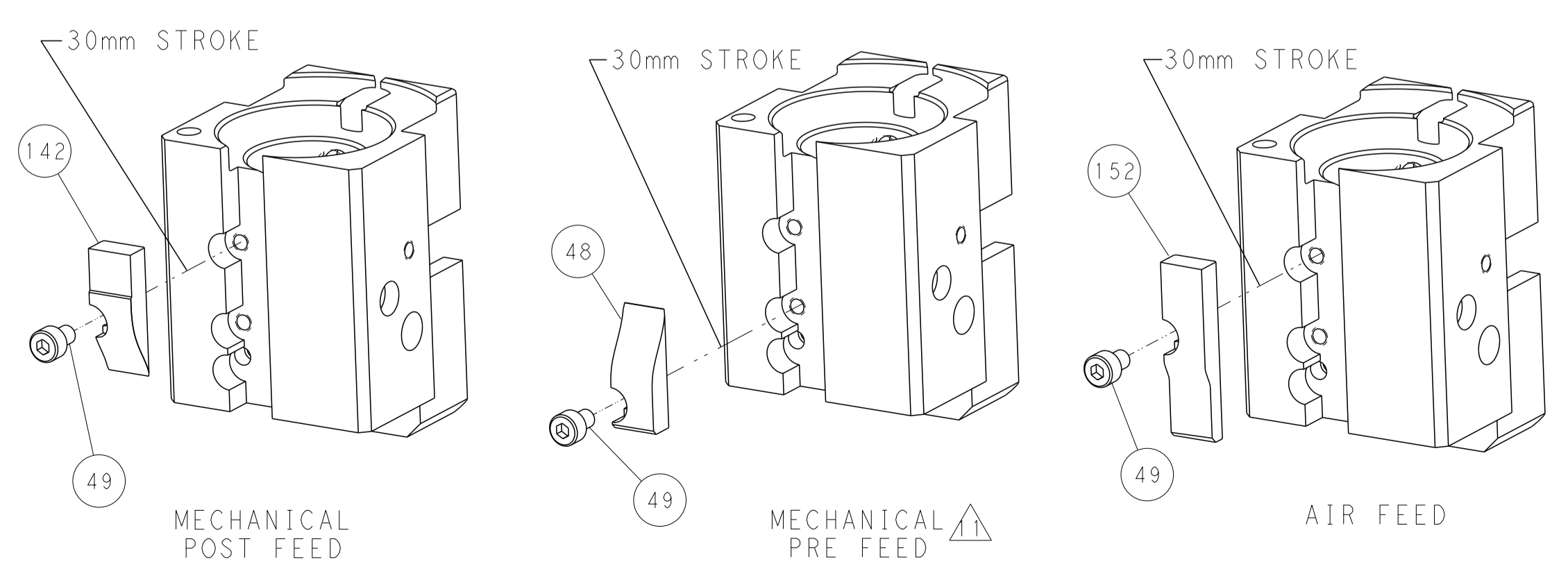


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



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 S. ALVES 12APR2013		CHK P. BARLETTA 12APR2013		APVD C. LIMA 12APR2013		NAME		STE TE Connectivity Harrisburg, PA 17105-3608			
mm	0 PLC	±		0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±		
	ANGLES	±			±		±		±		±		±		
MATERIAL	FINISH			WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	CUSTOMER ACCESSIBLE PRODUCTION DRAWING					
						A1	00779	©=2150018	SCALE	1:1	SHEET	4	OF 4	REV	B