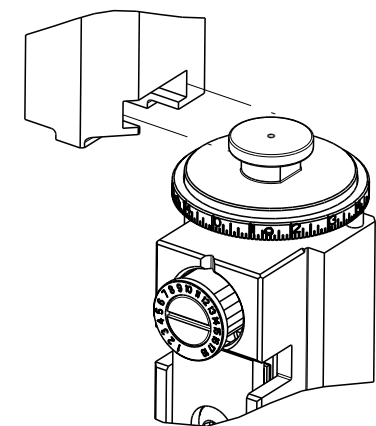


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150065-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150065-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150065-7	A	CRIMP TOOLING KIT	-

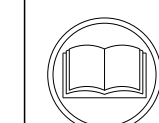
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.09-8.66 mm [.279-.341 IN]	Ø -		
TERMINAL APPLICATION SPECIFICATION (B)114-2008	-		
(A)114-2002	-		
TERMINALS APPLIED 4/6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 42778-1	(A) 62000-1	(A) 62157-1	(A) 280004-1
(B) 42778-2	(A) 62000-2	(A) 62157-2	(A) 280004-2
	(A) 62200-2	(A) 280005-1	(A) 280007-1
		(A) 280005-2	(A) 280007-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3000 CMA 19+18 MAG(2951)	1.65+/-0.05 [.065+/- .002]	5.8
600 CMA 22 MAG(635)	1.34+/-0.05 [.053+/- .002]	8.9



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
- 8 CUT TO LENGTH AT ASSEMBLY.

***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.

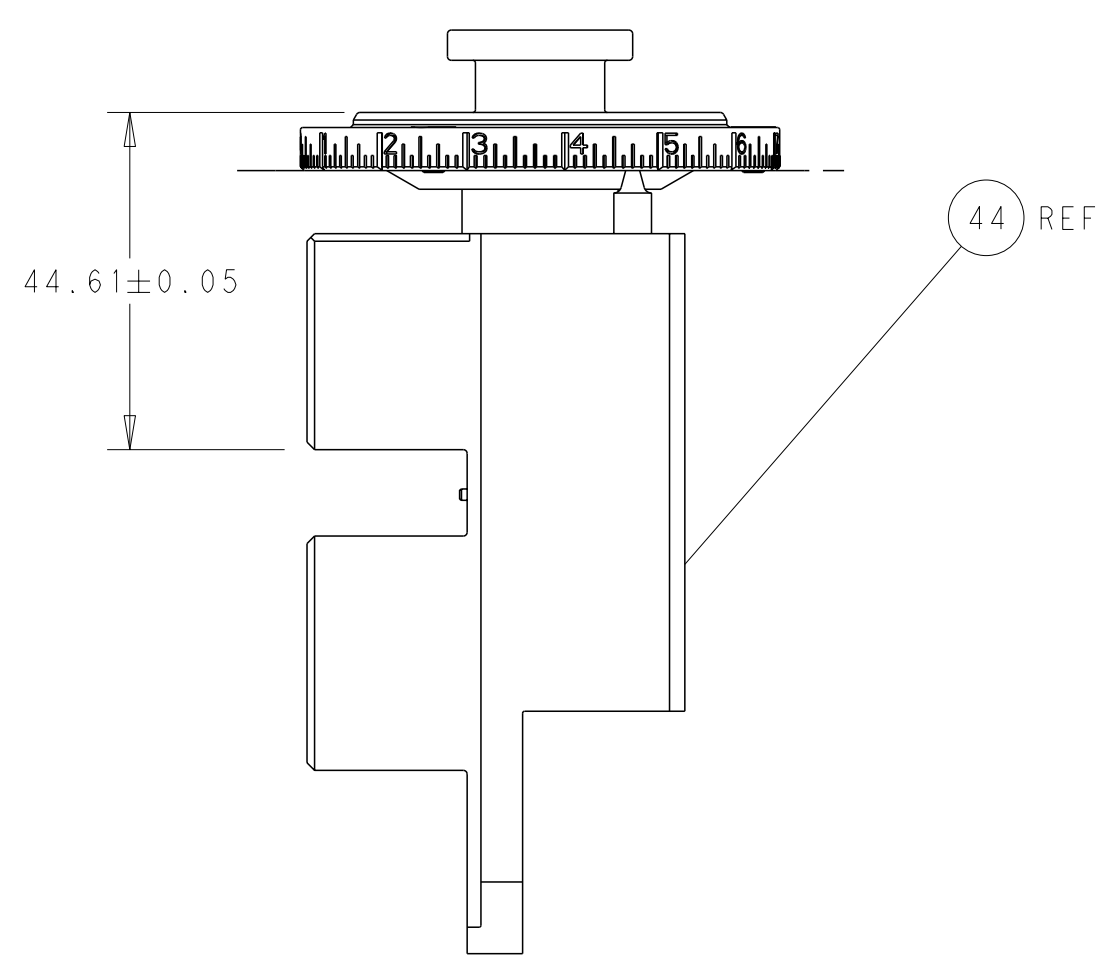
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		B		ECR-19-002381	14 FEB 2019	TB	CT
		C		ECR-9-007406	10 MAY 2019	MZ	YY
		D		ECR-19-009335	18 JUN 2019	LG	TE

-	1	1	23238-1	INSERT, COUPLING	278
-	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	2844280-1	MOUNT, AIR BLAST	273
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2844940-3	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143
-	2	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94
-	2	2	1-18024-2	SCR, BTN SKT HD CAP (M5 X 12.0)	93
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80
-	1	1	1803607-4	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
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-2063961-3	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-3	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	9	9	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29
-	1	1	460276-2	STRIPPER, SPECIAL	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	3-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	1-462932-0	PLATE, STRIP COVER	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	17
-	1	1	459684-1	PLATE GUIDE, RETAINING	11
-	1	1	459580-1	PLATE, RETAINING	10
-	1	1	2-459583-0	BODY, ANVIL	9
-	1	2	459582-4	ANVIL, AMPLIVAR SPLICE	8
-	1	1	459581-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	-	-	-	-	4
-	1	2	459587-1	GUIDE, CRIMPER	3
-	-	-	-	-	2
-	1	2	459585-1	CRIMPER, BLUNT F	1
-	77	72	2	PART NO	ITEM NO

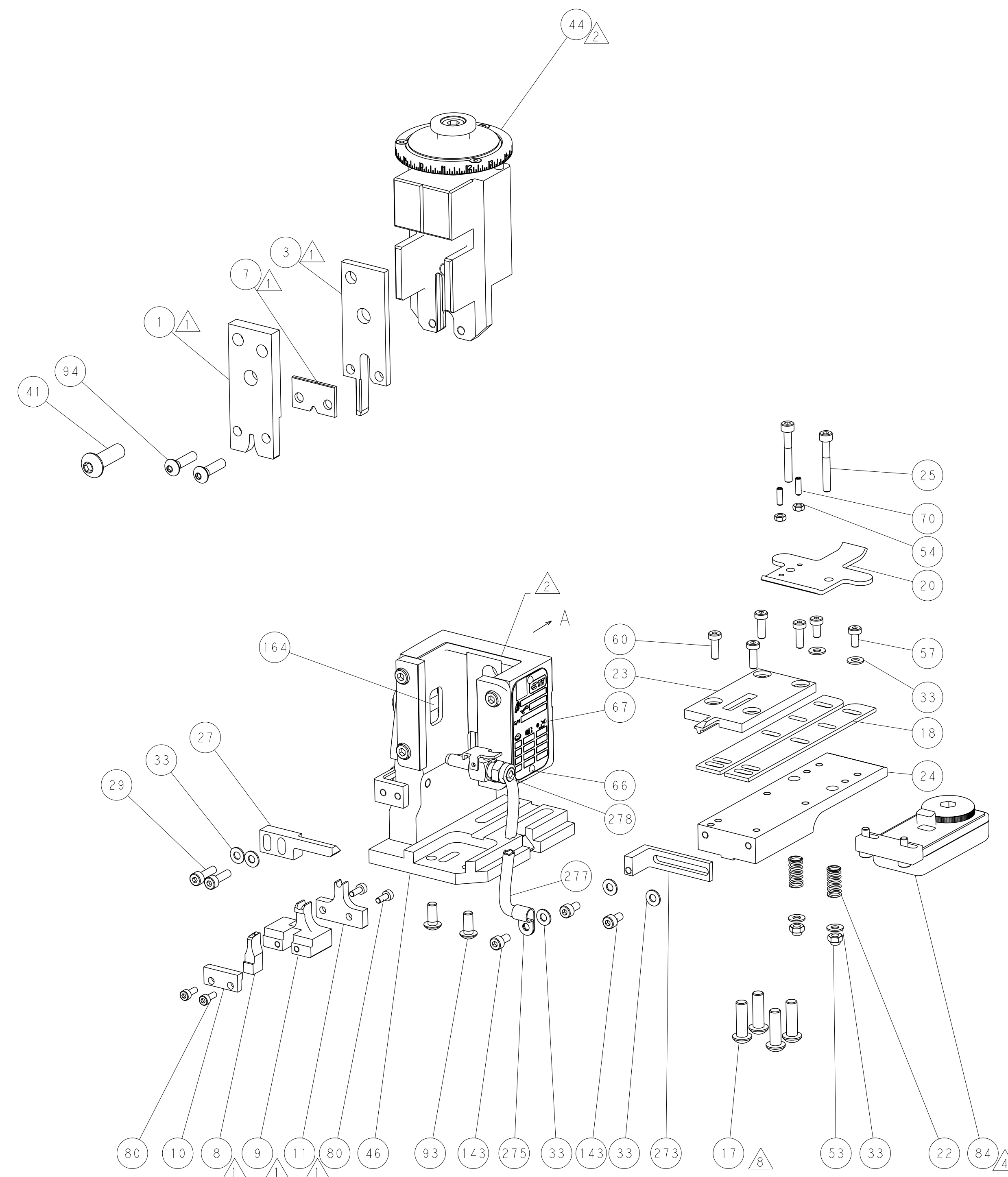
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SIZE	CAGE CODE
	ANGLES FINISH					00779	2150065
MATERIAL				WEIGHT		SCALE	
						1:1	
						SHEET 1 OF 4	
						REV D	

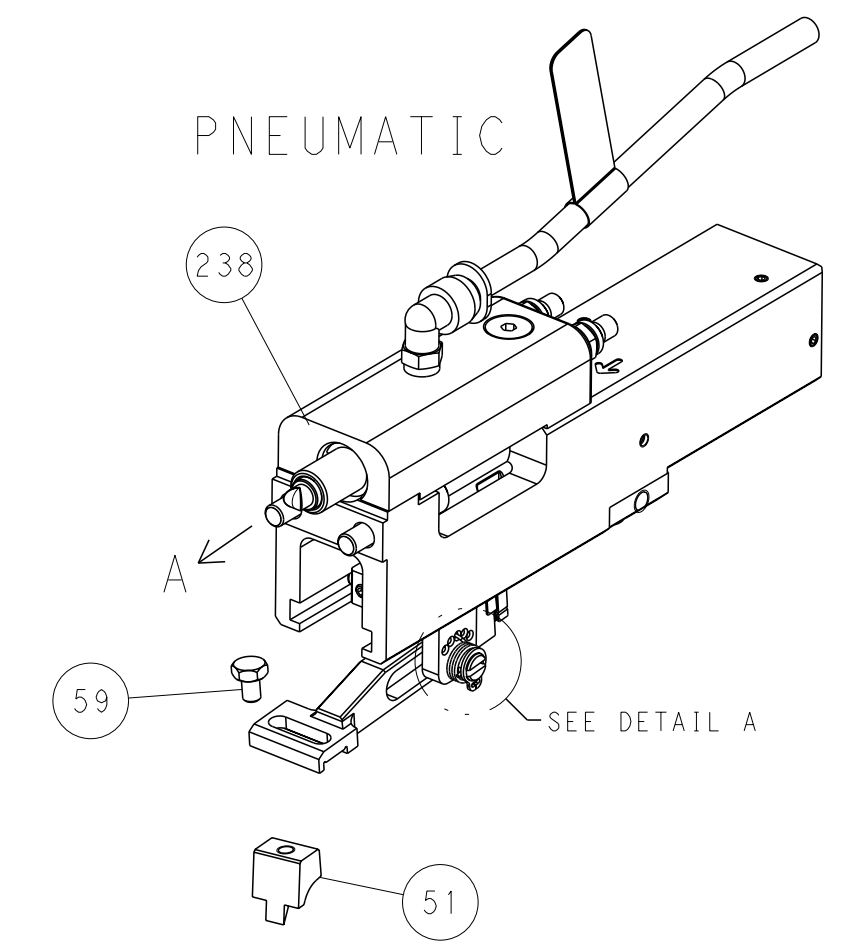
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



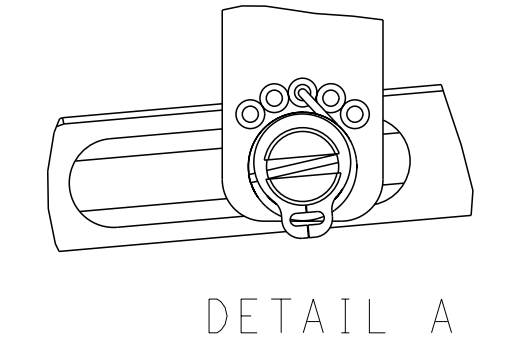
RAM SET-UP



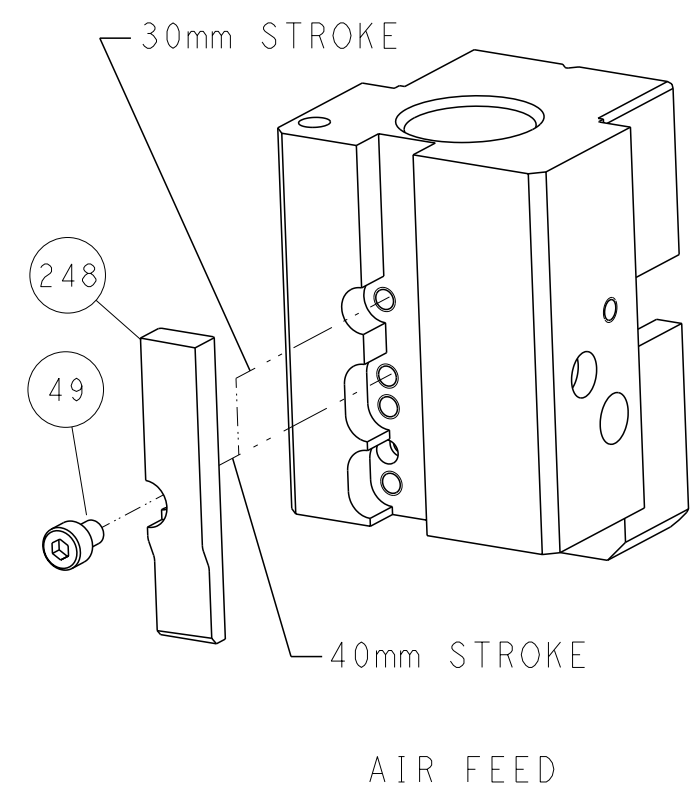
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



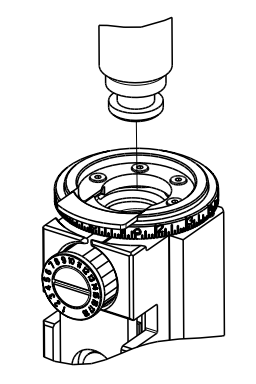
AIR FEED

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 15FEB2016 CHK: T. ELBIN 15FEB2016 APVD: T. ELBIN 15FEB2016	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150065	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D
MATERIAL: - FINISH: -		WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150065-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150065-7	A	CRIMP TOOLING KIT	-

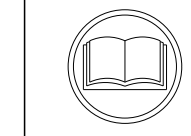
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.09-8.66 mm [.279-.341 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION (A)114-2002	(B)114-2008	-	-
TERMINALS APPLIED Δ 4 ∇ 6			
TE TERMINAL (B) 42778-1	TE TERMINAL (A) 62000-1	TE TERMINAL (A) 62157-1	TE TERMINAL (A) 280004-1
(B) 42778-2	(A) 62000-2	(A) 62157-2	(A) 280004-2
	(A) 62200-2	(A) 280005-1	(A) 280007-1
		(A) 280005-2	(A) 280007-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3000 CMA 19+18 $\frac{1}{2}$ MAG(2951)	1.65+/-0.05 [.065+/- .002]	5.8
600 CMA 22 $\frac{1}{2}$ MAG(635)	1.34+/-0.05 [.053+/- .002]	8.9



- Δ RECOMMENDED SPARE PARTS
- Δ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- Δ 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.
- Δ TERMINAL LUBRICANT IS RECOMMENDED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- Δ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- Δ REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
- Δ CUT TO LENGTH AT ASSEMBLY.

***WARNING**
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LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	23238-1	INSERT, COUPLING	278	
-	1	2030758-3	TUBING, POLYURETHANE	277	
-	1	986220-3	CLAMP, CABLE, BLACK	275	
-	1	2844280-1	MOUNT, AIR BLAST	273	
-	1	2844940-3	AIR FEED MODULE	238	
-	4	2-18024-1	SCR, BTN SKT HD CAP (M6 X 25.0)	186	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143	
-	1	2-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-3	RAM ASSEMBLY, EF PACIFIC	140	
-	4	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94	
Δ	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80	
-	1	1803607-4	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	60	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-2063961-3	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	
-	9	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29	
-	1	460276-2	STRIPPER, SPECIAL	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	3-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1-462932-0	PLATE, STRIP COVER	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-1	DRAG	20	
-	2	1901259-4	GUIDE, LOWER STRIP	18	
Δ	-	1	459684-1	PLATE GUIDE, RETAINING	11
-	1	459580-1	PLATE, RETAINING	10	
Δ	-	1	2-459583-0	BODY, ANVIL	9
Δ	1	1	459582-4	ANVIL, AMPLIVAR SPLICE	8
Δ	-	1	459581-1	BLADE, SLUG	7
-	-	-	-	6	
-	-	-	-	5	
-	-	-	-	4	
Δ	1	1	459587-1	GUIDE, CRIMPER	3
-	-	-	-	2	
Δ	1	1	459585-1	CRIMPER, BLUNT F	1
-	-	-	-	0	

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

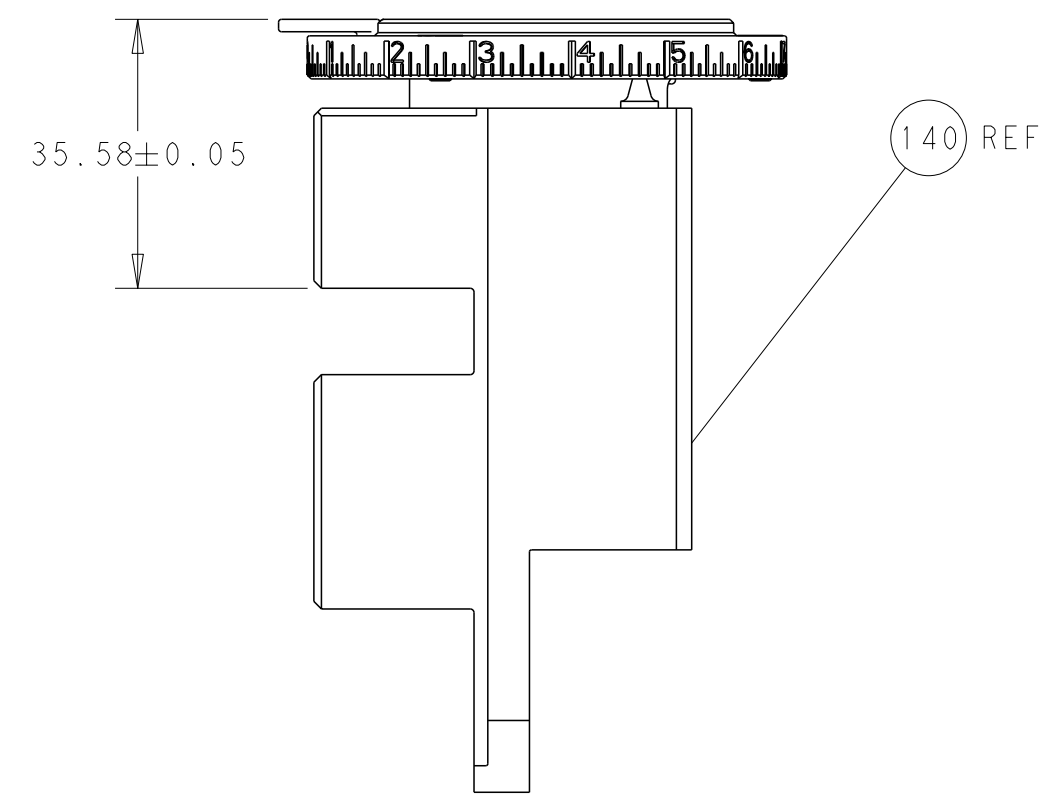
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					

OWN	CHK	APVD	NAME
B. WEAVER	T. ELBIN	T. ELBIN	
15FEB2016	15FEB2016	15FEB2016	

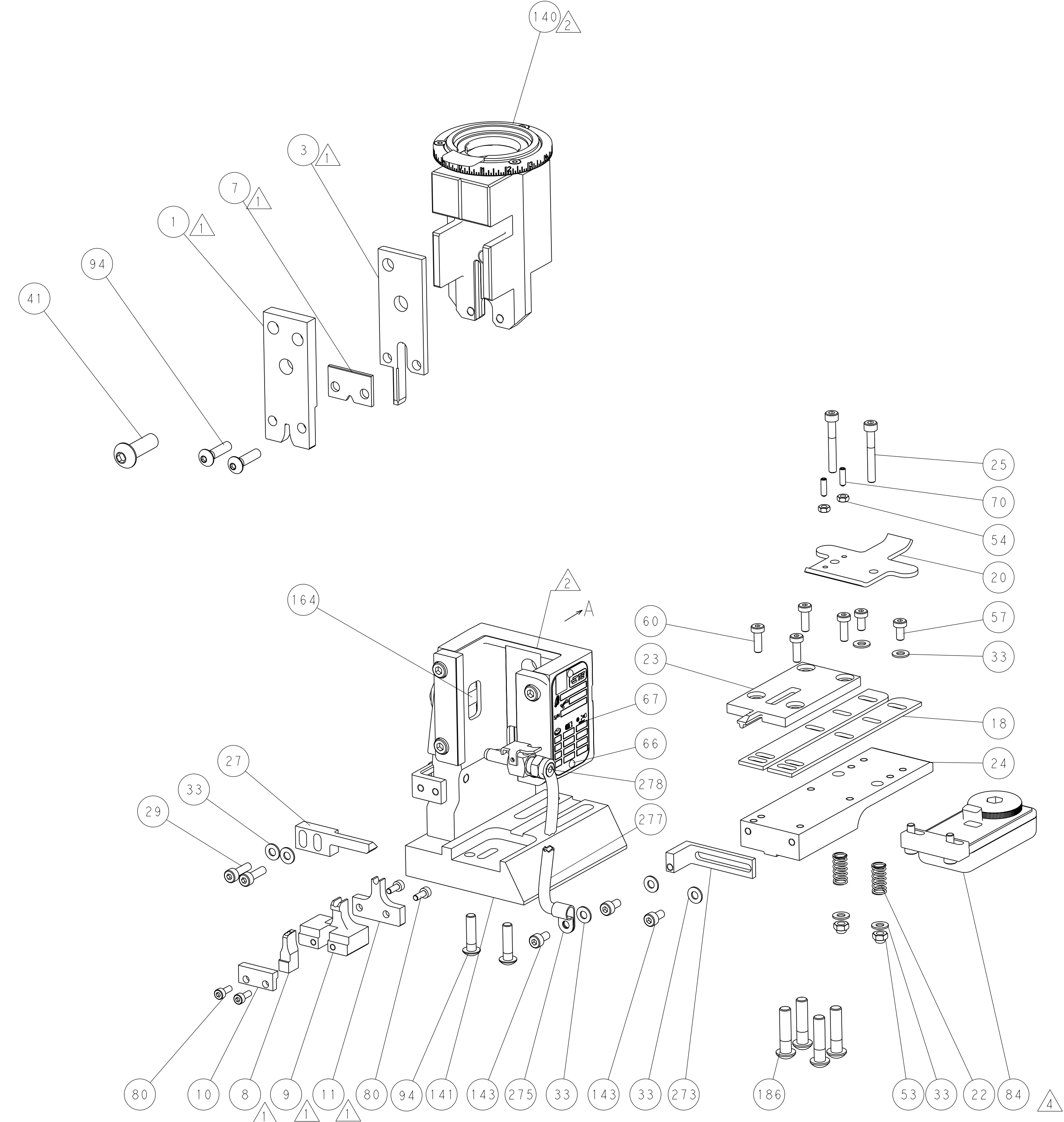
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150065	-

Customer Accessible Production Drawing SCALE 1:1 SHEET 3 OF 4 REV D

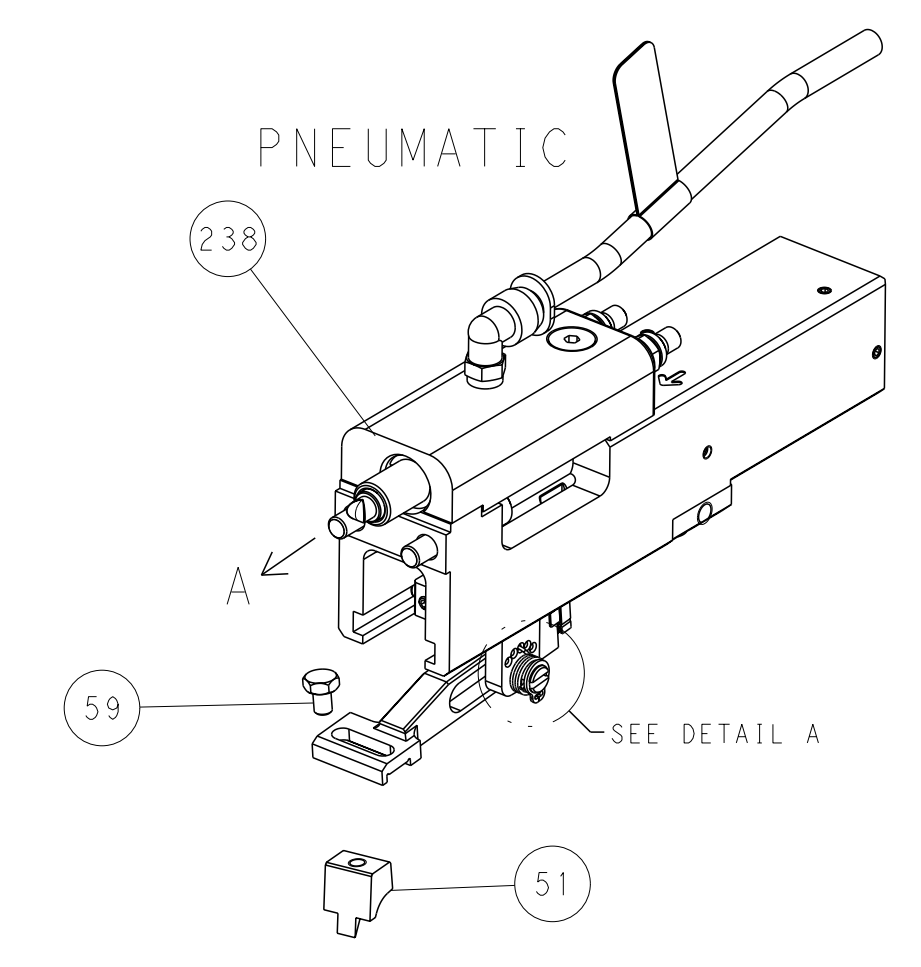
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



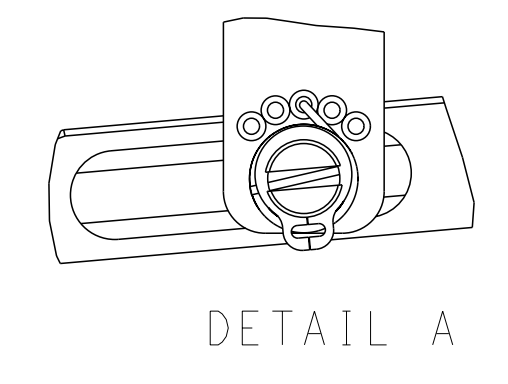
RAM SET-UP



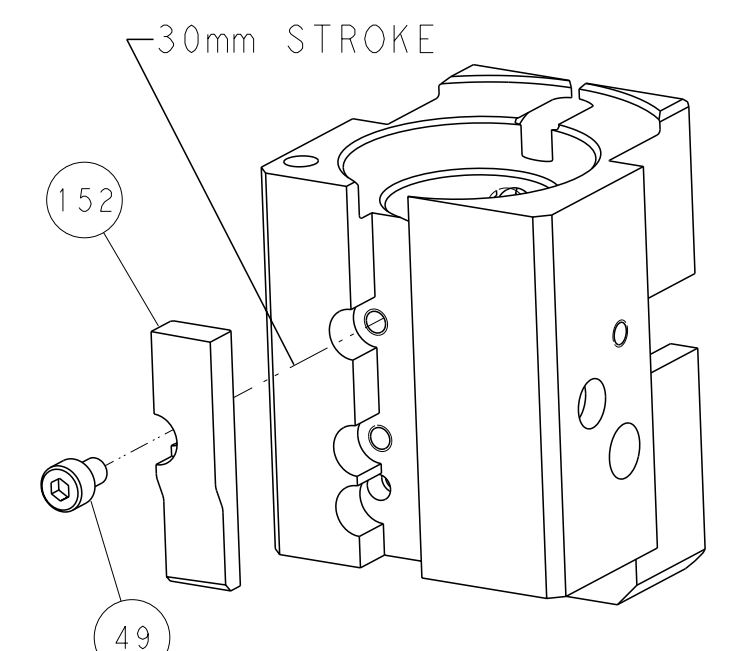
FEED TYPE



FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS ARE THE PROPERTY OF TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 15FEB2016 CHK: T. ELBIN 15FEB2016 APVD: T. ELBIN 15FEB2016	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150065 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET: 4 of 4 REV: D	CUSTOMER ACCESSIBLE PRODUCTION DRAWING