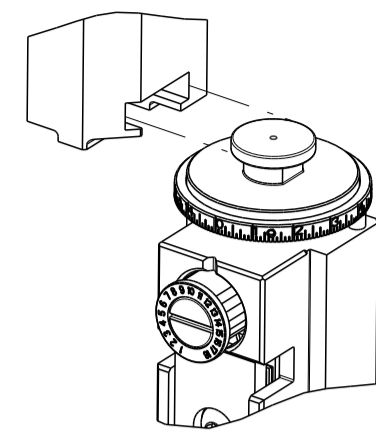


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150080-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150080-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150080-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150080-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150080-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG, .180 DIA.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.98-4.78 mm [.157-.188 IN]		Ø2.29-3.18 mm [.090-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2017		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60793-1	60793-3	62739-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/-0.002]	3.5
16 AWG	1.65+/-0.05 [.065+/-0.002]	5.9
18 AWG	1.50+/-0.05 [.059+/-0.002]	7.5

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. 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.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

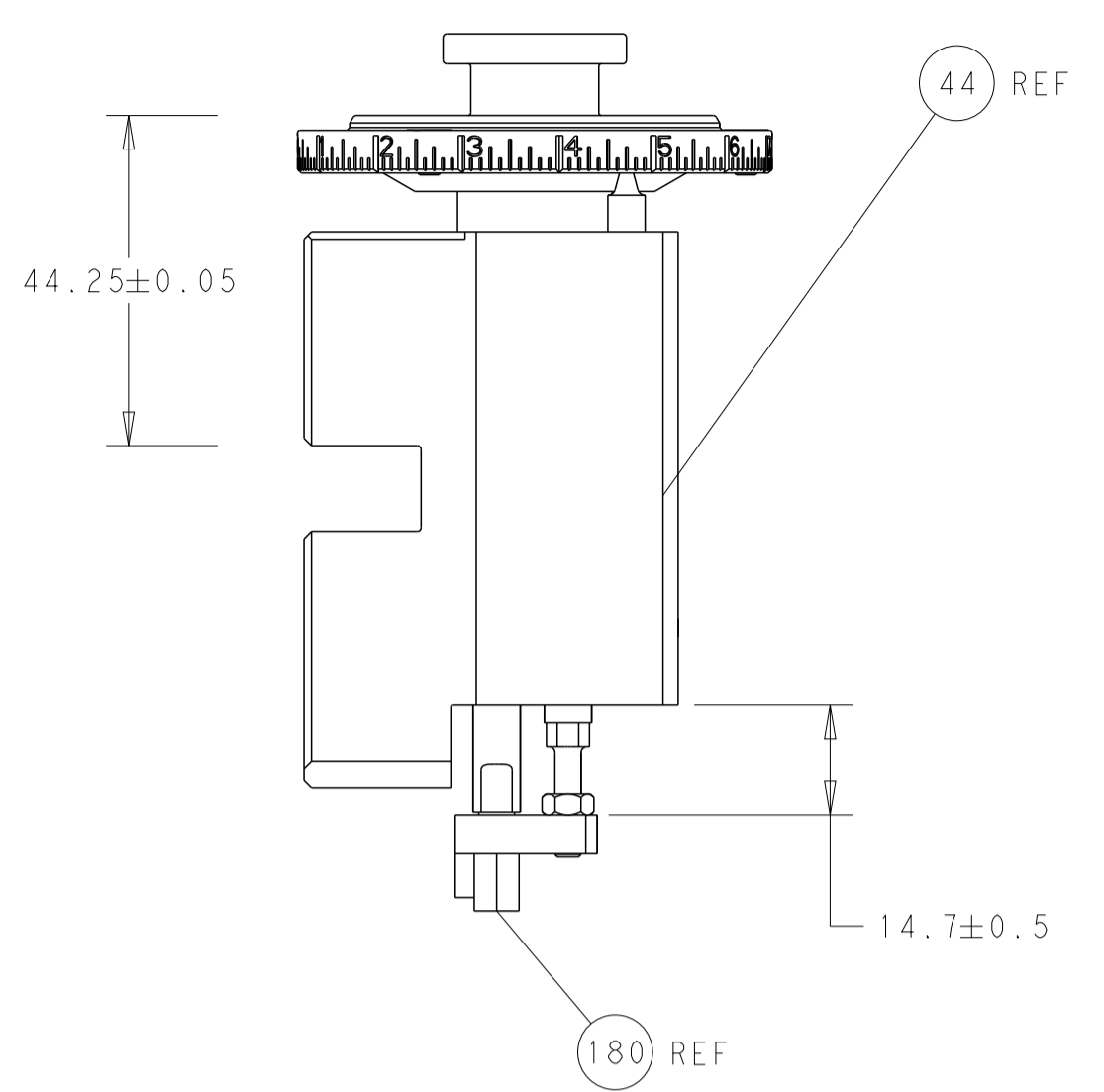
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-18-006373	25APR2018	AW	TE
		C		ECR-18-014718	17SEP2018	JAH	TE
		D		ECR-21-006519	25JUN2021	FZ	TE
		E		ECR-21-007066	28JUL2021	TB	GB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
3	-	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180	
-	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	
6	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-4	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	2063961-4	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	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	
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	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	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	2-690496-7	PLATE, FRONT SHEAR	9	
1	2	2	1	1	7-1803059-0	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-2	SPACER	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	6-1803016-3	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	2	2	1	1	6-456408-9	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

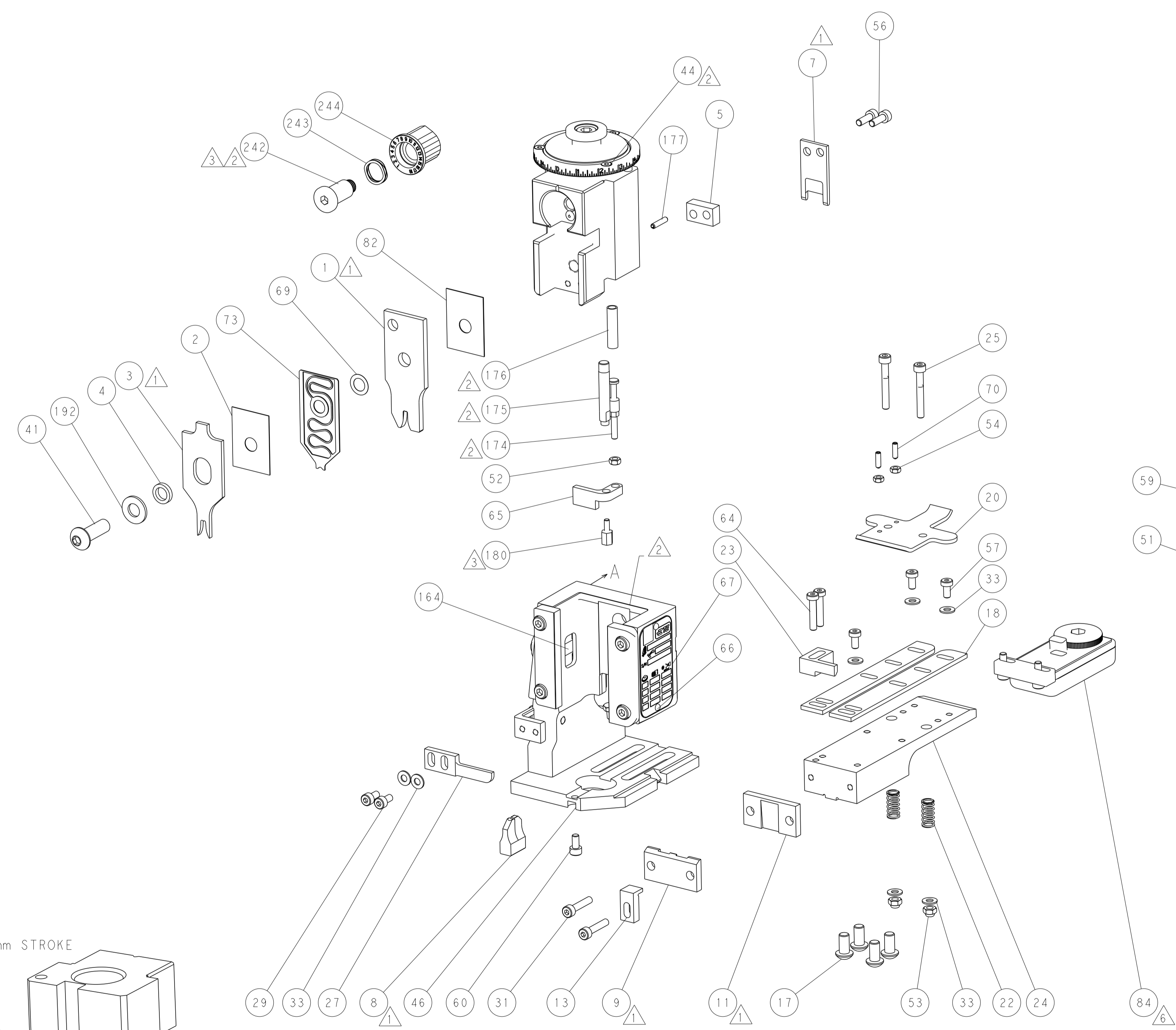
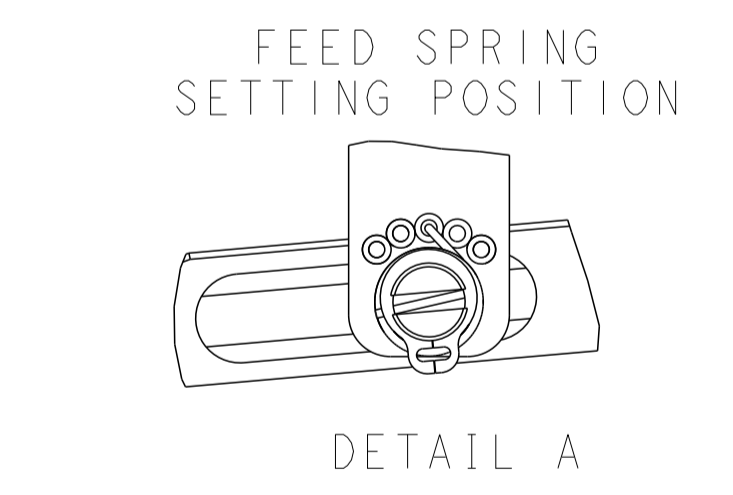
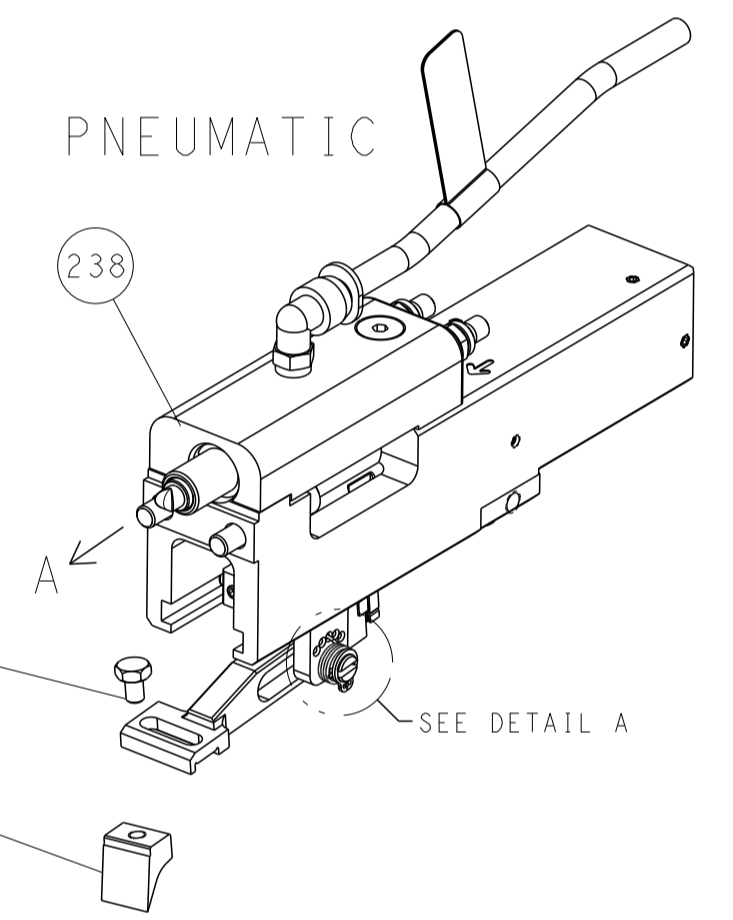
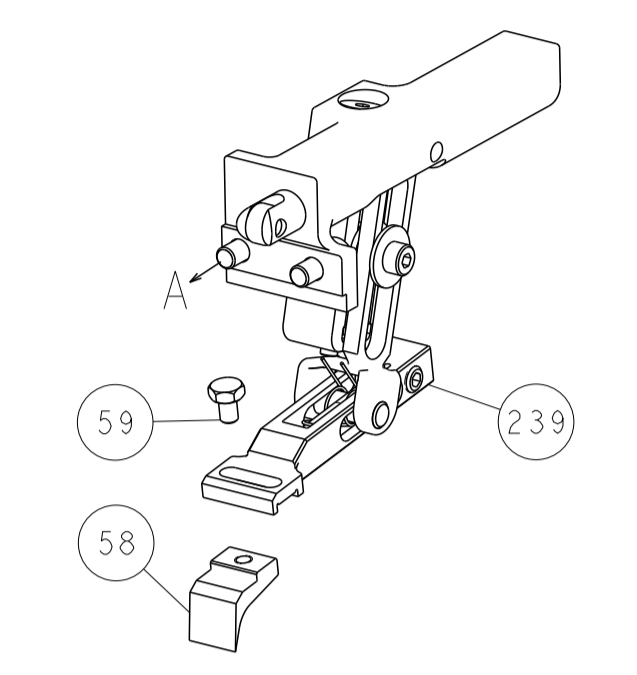
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	H. HUANG	L. ZHANG	L. ZHANG	TE Connectivity
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						1:1		1 OF 4		E	

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

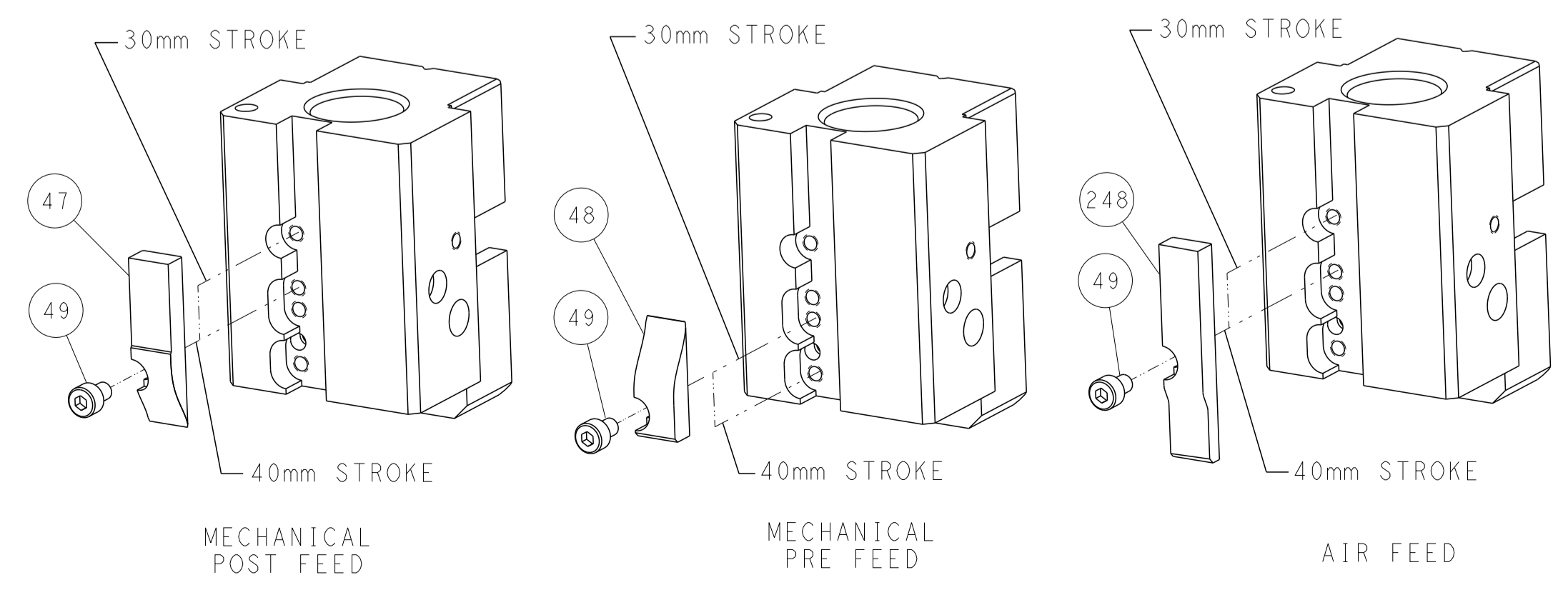


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

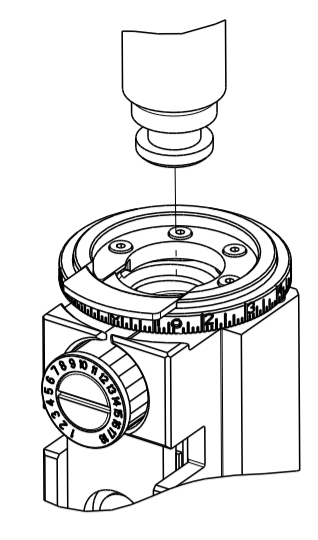


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 28NOV2016 CHK L. ZHANG 28NOV2016 APVD L. ZHANG 28NOV2016		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		NAME: Ocean End Feed Applicator		SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150080	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150080-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150080-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150080-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: SHUR PLUG, .180 DIA.

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.98-4.78 mm [.157-.188 IN]	Ø2.29-3.18 mm [.090-.125 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60793-1	60793-3	62739-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/- .002]	3.5
16 AWG	1.65+/-0.05 [.065+/- .002]	5.9
18 AWG	1.50+/-0.05 [.059+/- .002]	7.5

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. 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.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

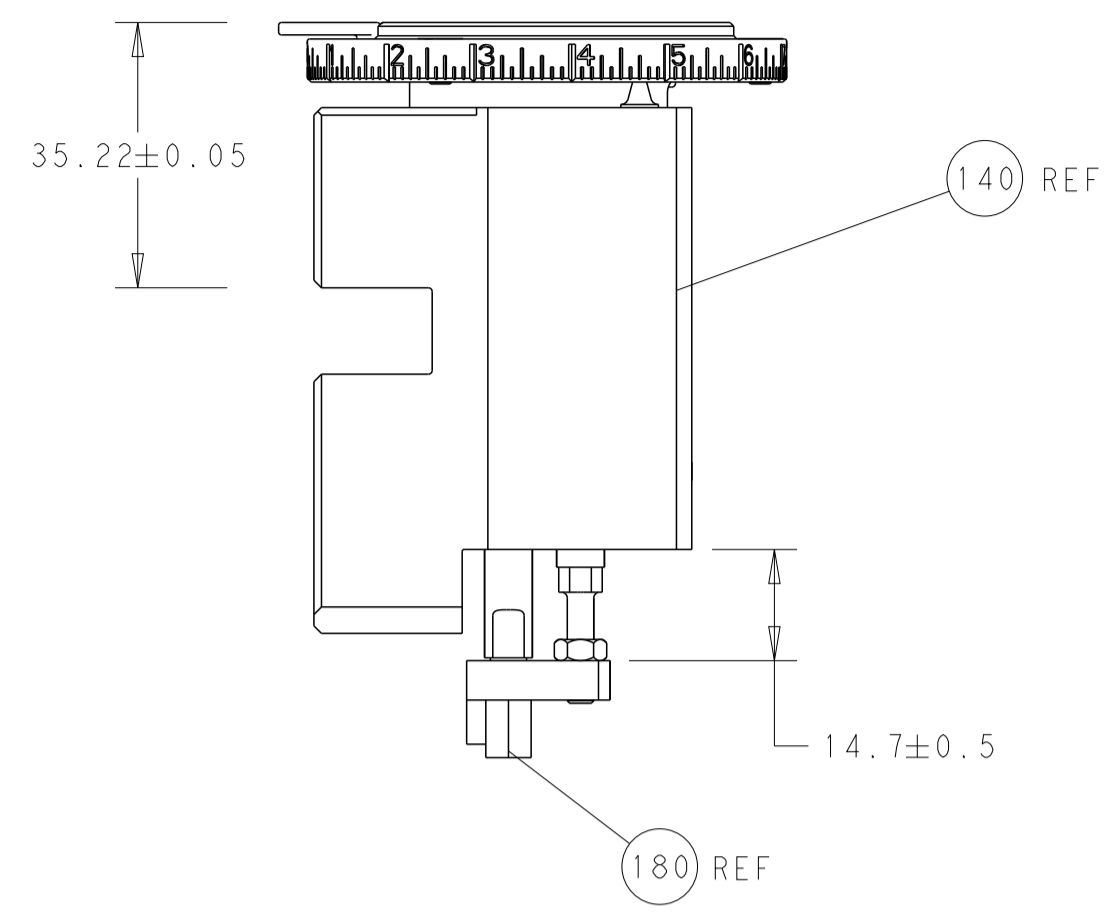
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 1	-
-	1	1		2119082-7 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
3	-	1		1-1752354-5 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
-	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
6	-	1		2119955-2 ASSY, LUBRICATOR, END FEED	84
-	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		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		2063961-4 FEED FINGER	58
-	3	3		2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2		2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-		1-2063961-0 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
-	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		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
-	1	1		240825-1 PLATE, STRIP HOLD DOWN	23
-	2	2		2-22281-3 SPRING, COMPRESSION	22
-	1	1		1803292-4 DRAG	20
-	2	2		1901259-5 GUIDE, LOWER STRIP	18
-	1	1		1752360-1 SPACER, HOLD-DOWN	13
1	-	1		240644-5 PLATE, REAR SHEAR	11
-	-	-		-	10
-	1	1		2-690496-7 PLATE, FRONT SHEAR	9
1	1	1		7-1803059-0 ANVIL, COMBINATION, END FEED	8
1	-	1		2217206-7 BLADE, SLUG	7
-	-	-		-	6
-	1	1		2-240641-2 SPACER	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
1	1	1		6-1803016-3 CRIMPER, INSULATION F	3
-	1	1		455888-3 SPACER, CRIMPER	2
1	1	1		6-456408-9 CRIMPER, WIRE PREMIUM	1
-	77-22-21			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)

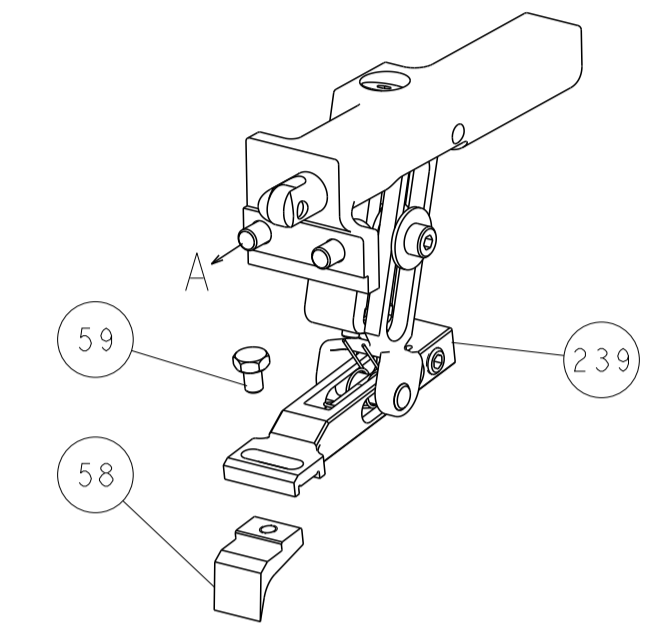
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN H. HUANG 28NOV2016 CHK L. ZHANG 28NOV2016 APVD L. ZHANG 28NOV2016 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1 SHEET 3 OF 4 REV E	
MATERIAL:		FINISH:		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150080 Customer Accessible Production Drawing	

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

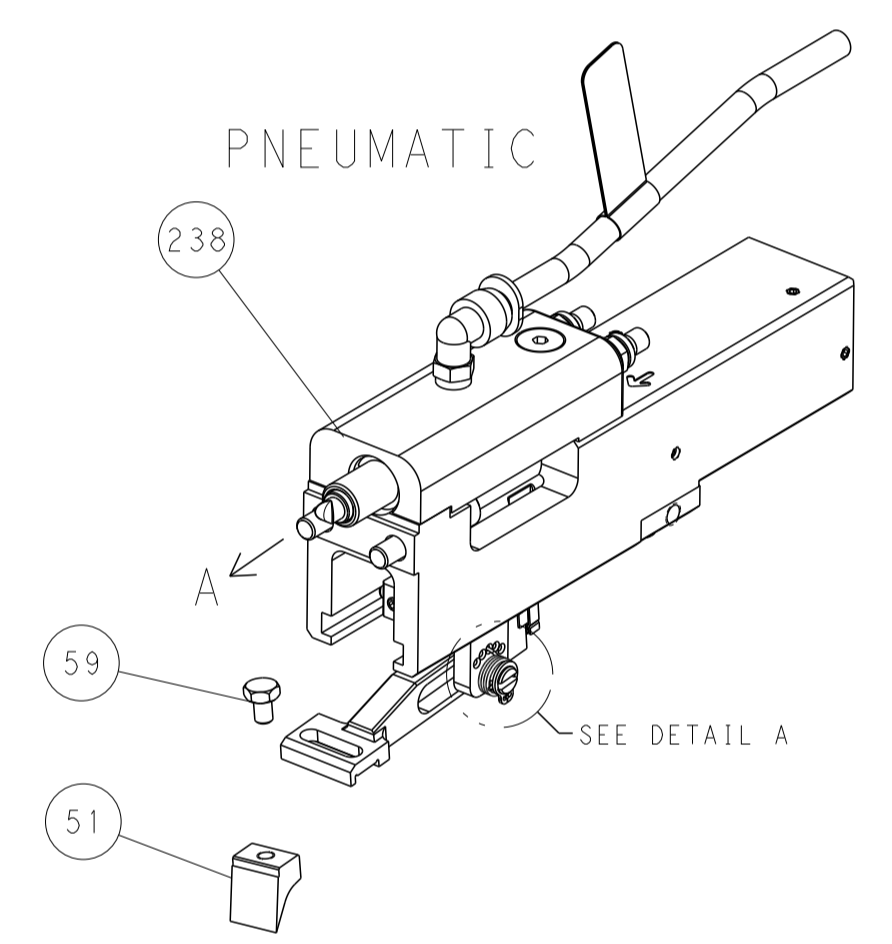


RAM AND HOLDDOWN SET-UP

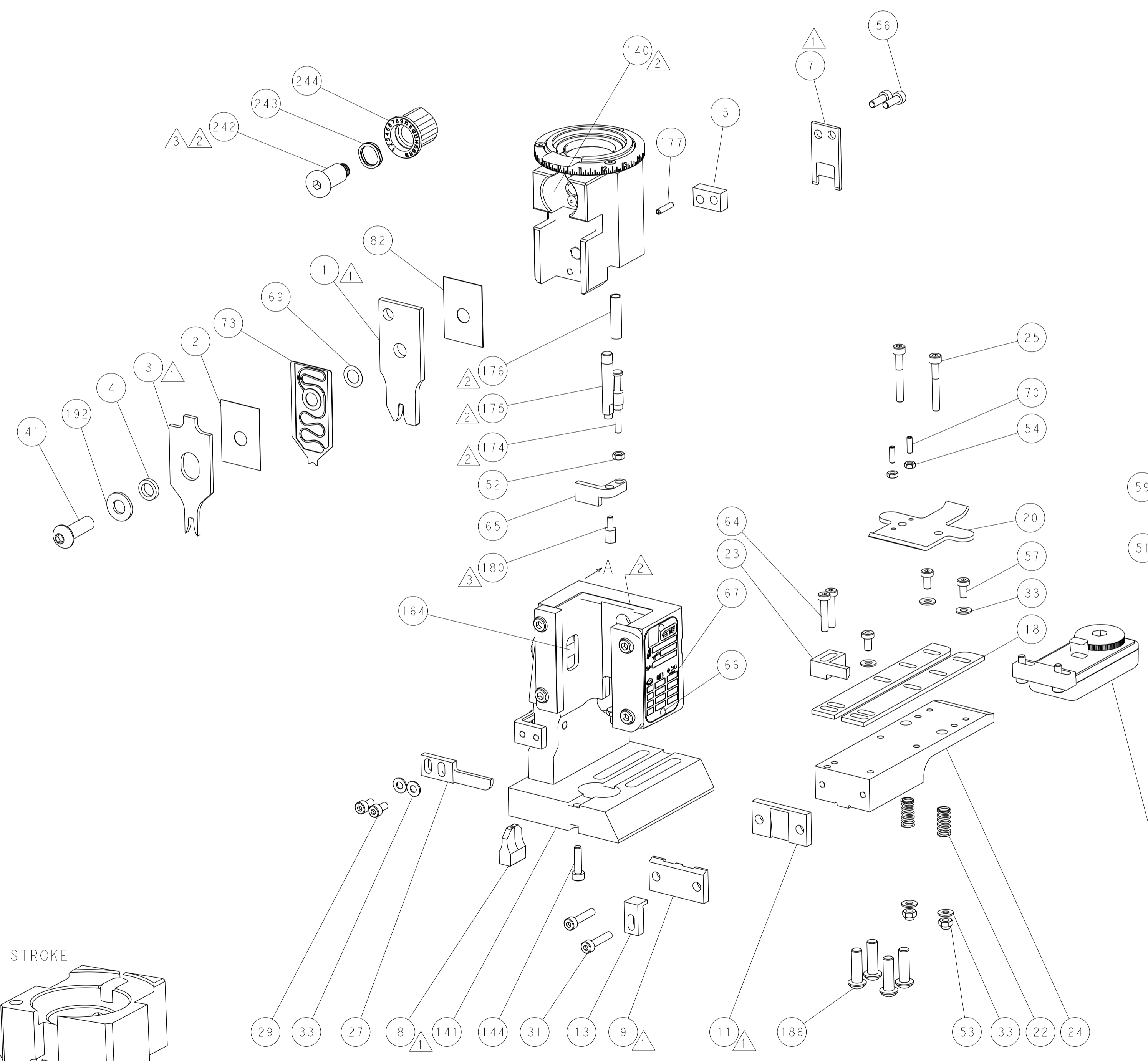
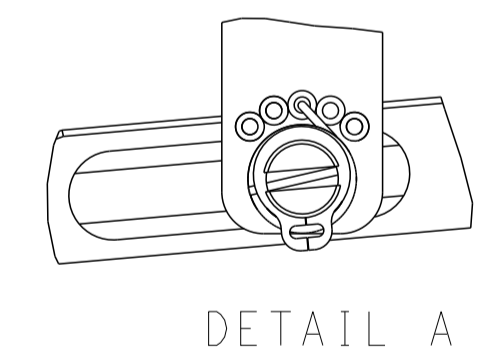
FEED TYPE
MECHANICAL



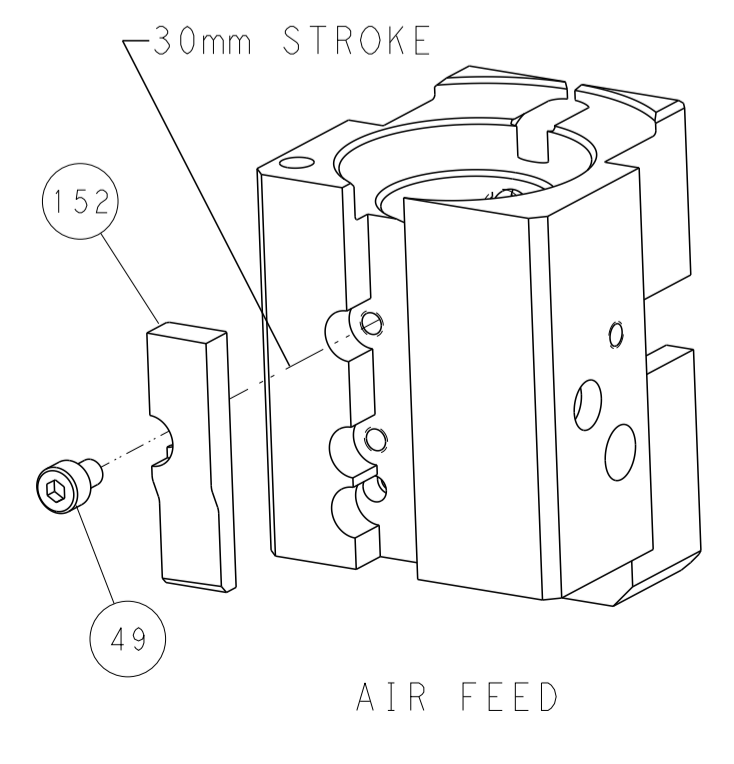
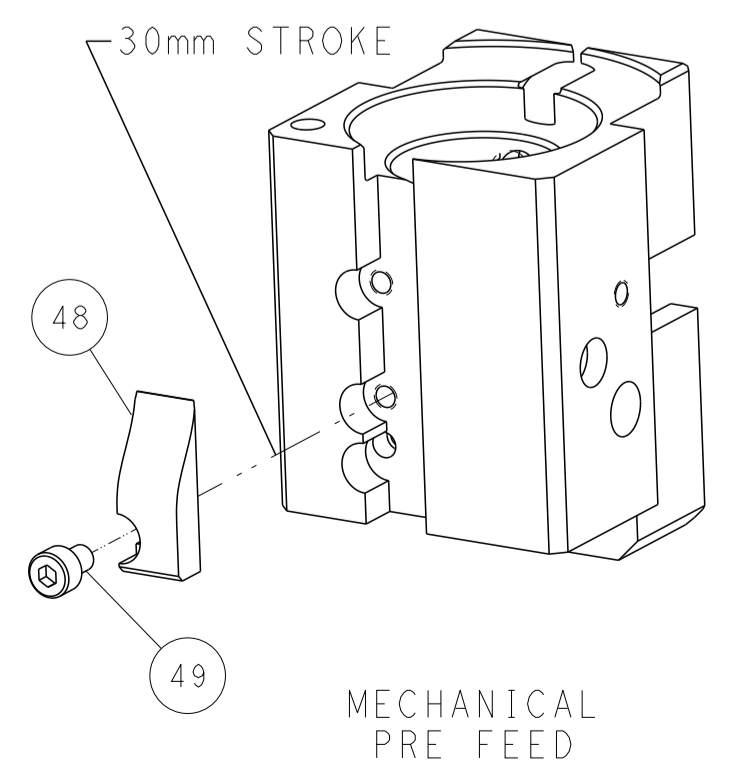
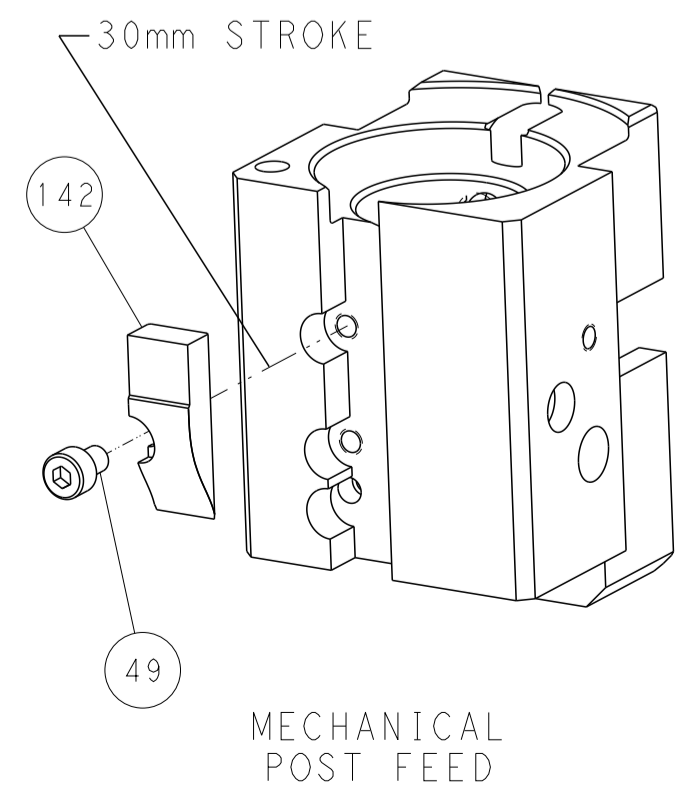
PNEUMATIC



FEED SPRING
SETTING POSITION



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 K. HUANG 28NOV2016		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	2150080	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV E			