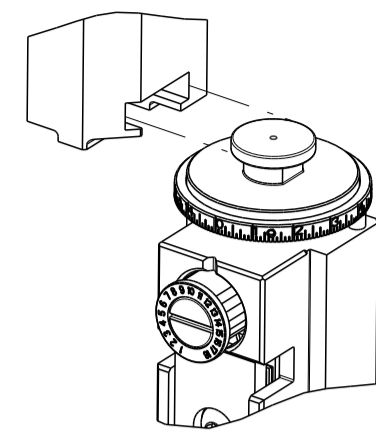


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150325-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150325-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150325-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150325-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150325-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE, POSITIVE LOCK, 110 SERIES		
WIRE STRIP LENGTH 3.62-4.00 mm [.143-.157 IN]		INSULATION DIAMETER RANGE Ø2.03-3.05 mm [.080-.120 IN]
TERMINAL APPLICATION SPECIFICATION 114-2074		
TERMINALS APPLIED		
TE TERMINAL 1742975-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.24+/-0.05 [.049+/-0.002]	4.7
20 AWG	1.09+/-0.05 [.043+/-0.002]	6.3
22 AWG	0.99+/-0.05 [.039+/-0.002]	7.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.

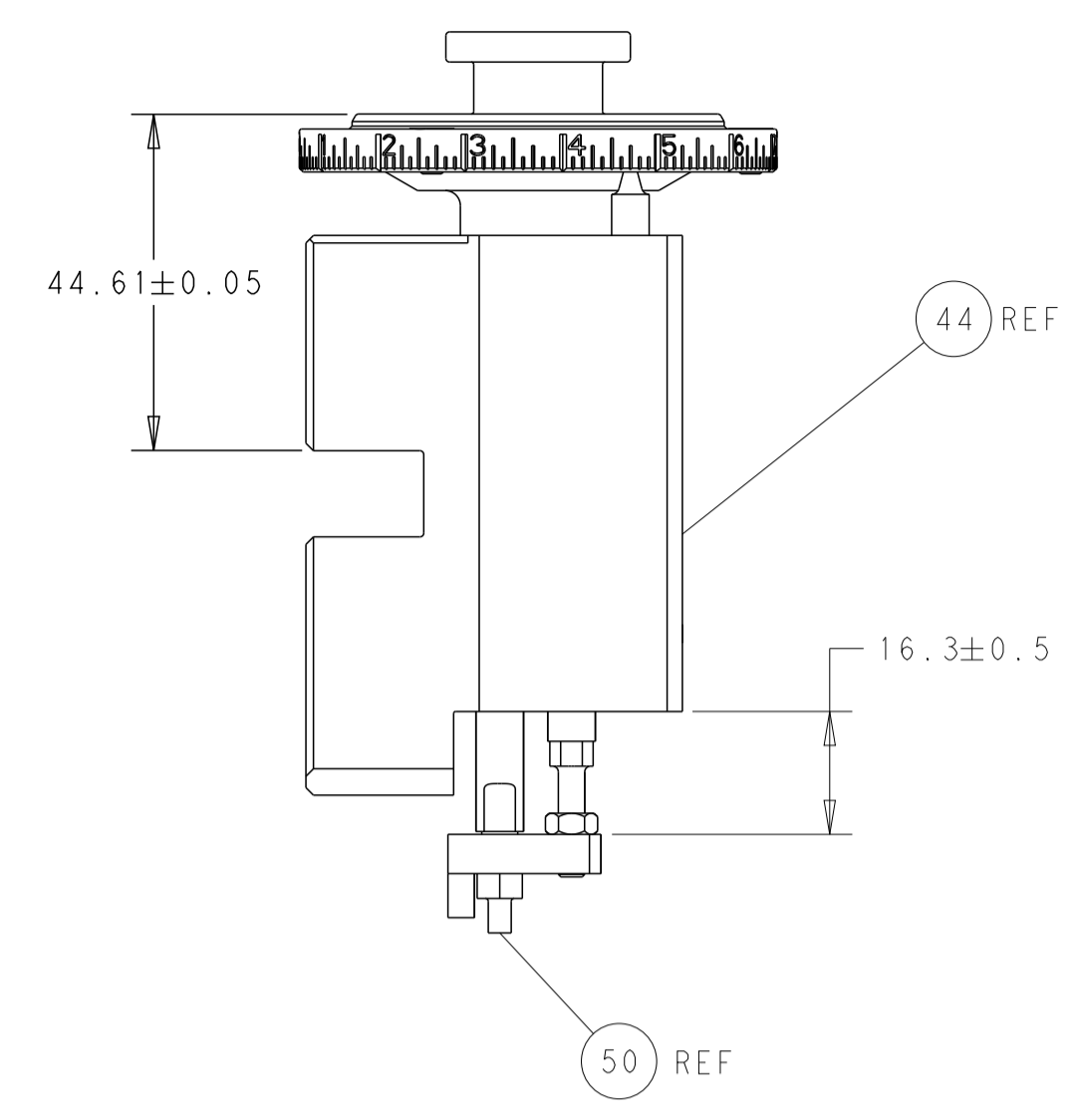
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-14-006200	25APR2014	LG	TE
		C		ECR-17-011879	16AUG2017	TB	GB
		D		ECR-18-018661	29NOV2018	FZ	KZ
		E		ECR-23-193060	20NOV2023	ROY	JAH

-	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	455888-6	SPACER, CRIMPER -	82					
-	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	2119740-1	TAG, IDENTIFICATION	67					
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66					
-	1	1	1	1	1901681-5	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					
-	2	2	2	2	2063961-6	FEED FINGER	58					
-	3	3	3	3	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52					
-	1	1	1	1	1-1976055-6	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	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	1752371-5	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	240644-1	PLATE, REAR SHEAR	11					
-	1	1	1	1	1338016-3	TAB, LATCHING	10					
-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9					
-	1	2	2	1	1803059-2	ANVIL, COMBINATION, END FEED	8					
-	1	1	1	1	2217206-6	BLADE, SLUG	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	2-240641-0	SPACER	5					
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4					
-	1	2	2	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3					
-	1	1	1	1	455888-7	SPACER, CRIMPER -	2					
-	1	2	2	1	2-456403-1	CRIMPER, WIRE PREMIUM	1					
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

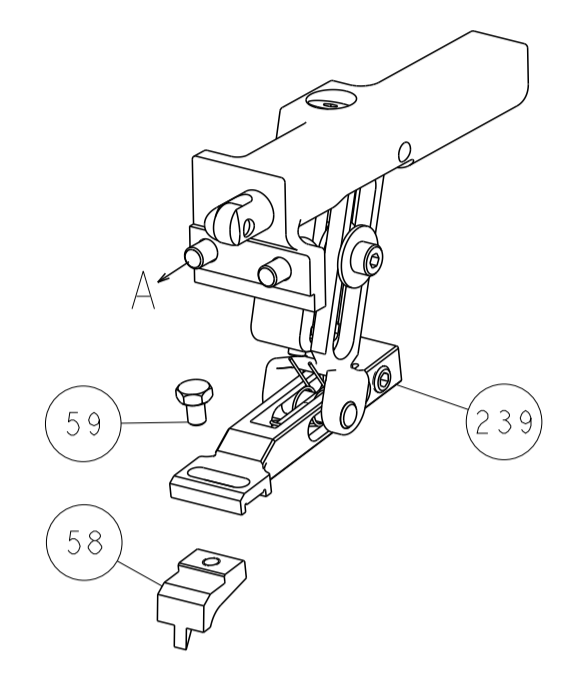
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MATERIAL: -		WEIGHT: -		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150325		RESTRICTED TO: -	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 1 OF 4	

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

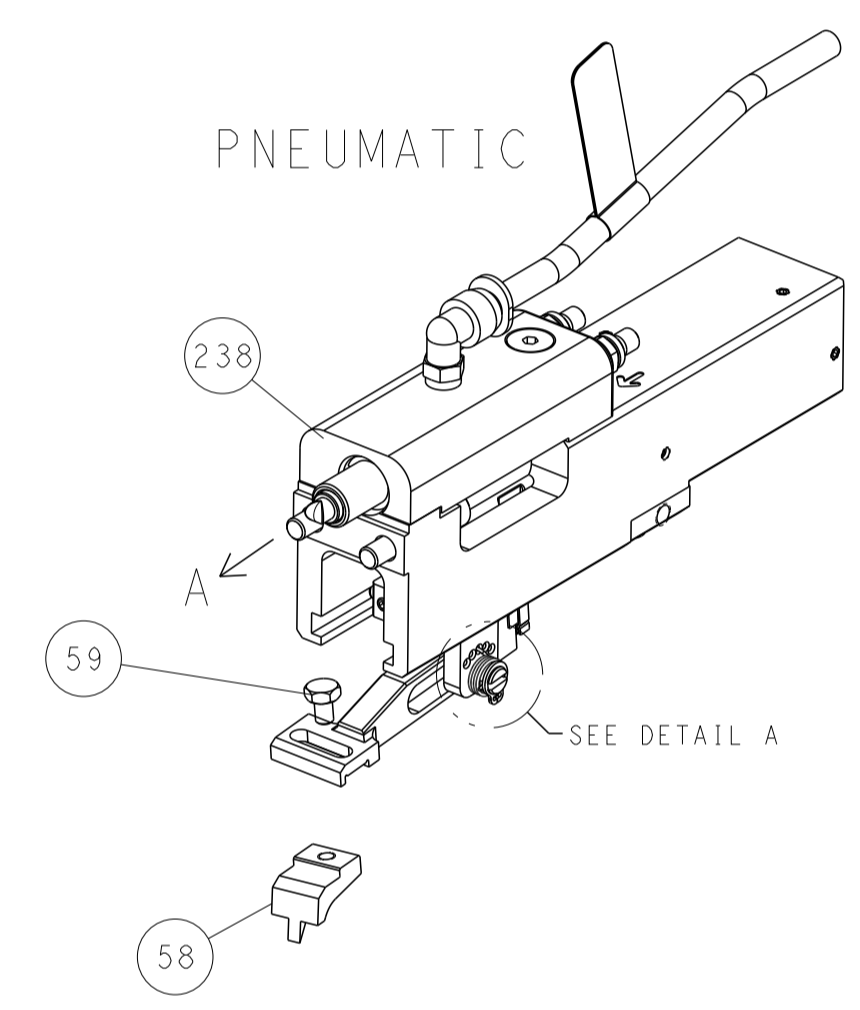


HOLDDOWN SET-UP

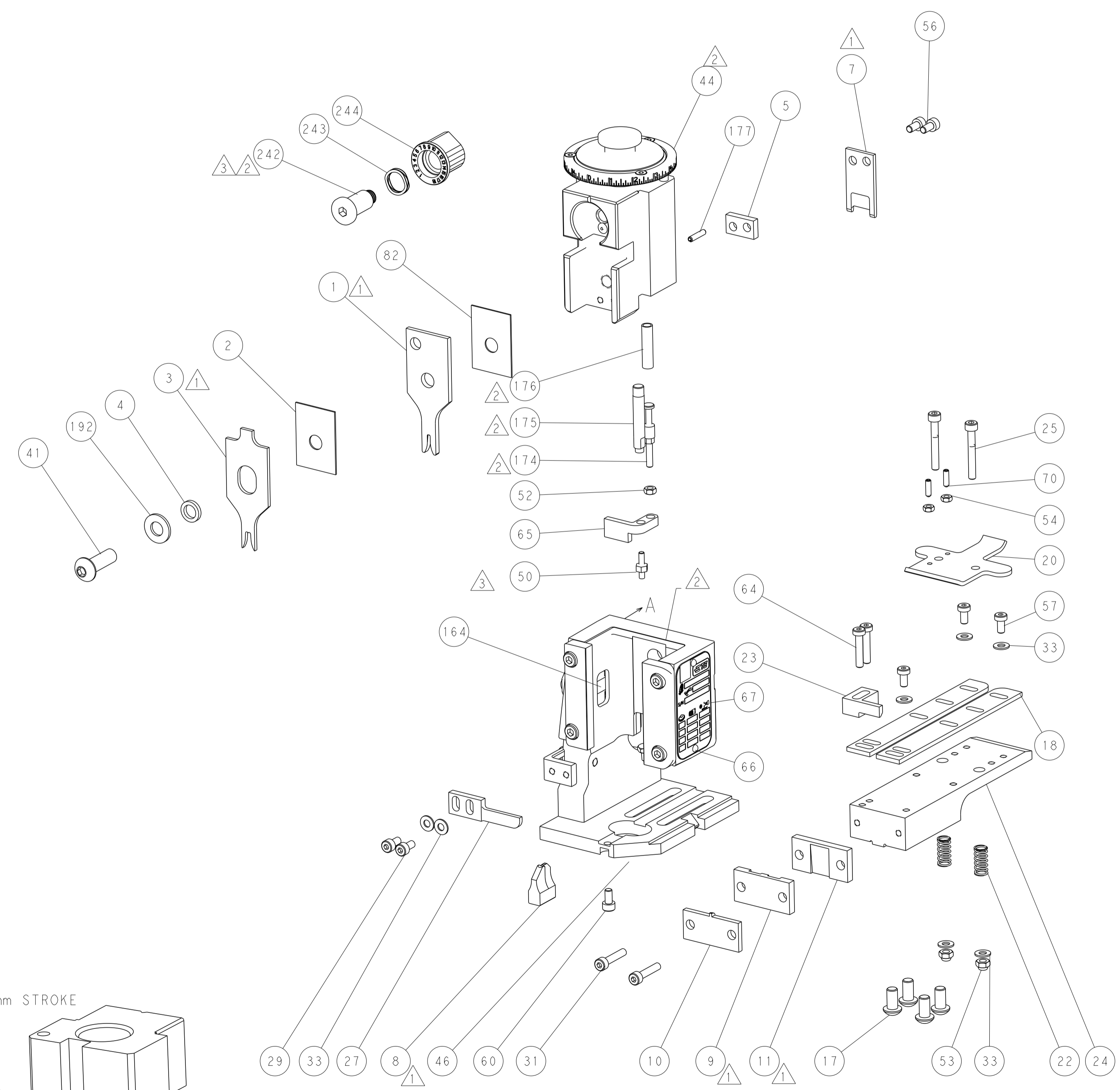
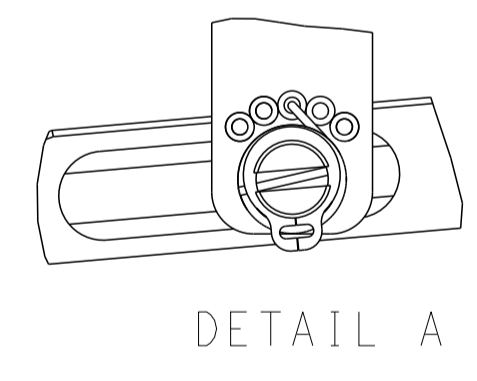
FEED TYPE
MECHANICAL



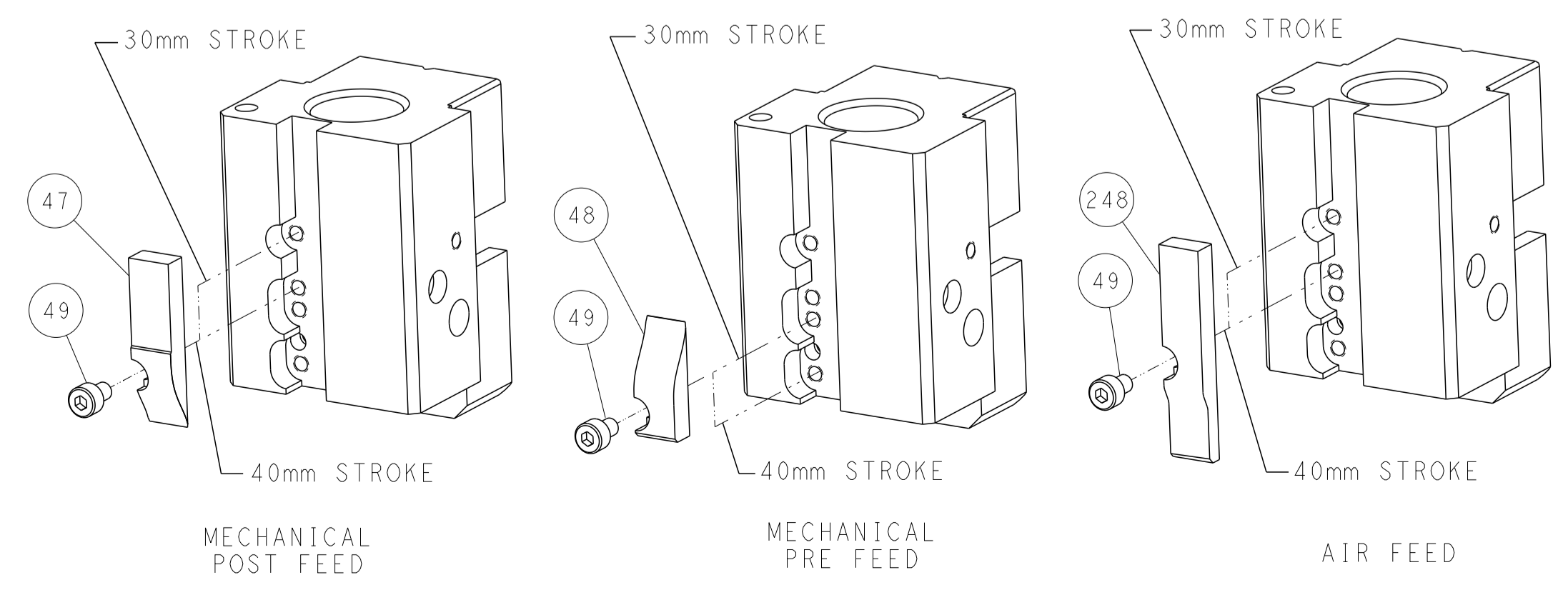
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: K. STAKEM 2MARCH2013 CHK: G. BAILEY 12MARCH2013 APVD: T. ELRLIN 12MARCH2013 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150325 SCALE: 1:1 SHEET: 2 OF 4 REV: E		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL: - WEIGHT: -				RESTRICTED TO: - Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	