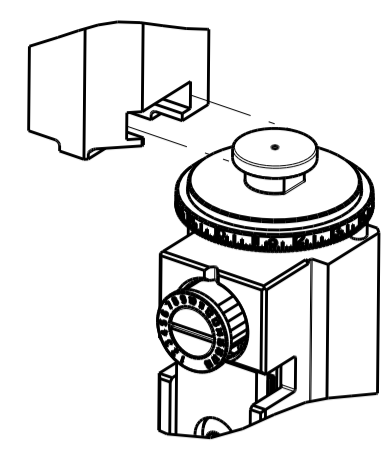


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150520-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150520-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150520-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150520-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150520-7	A	CRIMP TOOLING KIT	-

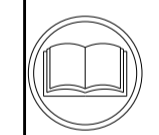
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.19 mm [.165]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: GMG TERMINAL		GMG CRIMP SPECIFICATION	
TERMINAL NAME: FASTON FEMMINA CON DENTINO 6.3X0.8 TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.81-5.57 mm [.189-.219 IN]		∅2.34-3.12 mm [.092-.123 IN]	
TERMINAL APPLICATION SPECIFICATION GMG 30015.52.02.1 Rev 01			
TERMINALS APPLIED			
TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113641-1	30015.52.00.1	2113641-4	30015.52.02.1
2113641-2	30015.52.00.0	2113641-5	30015.30.00.1
2113641-3	30015.52.02.0	2113641-6	30015.30.02.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.80 +/- 0.05 [.071 +/- .002]	3.6
1+1mm2	1.70 +/- 0.05 [.067 +/- .002]	4.2
1.5mm2	1.60 +/- 0.05 [.063 +/- .002]	4.9
1.00mm2	1.50 +/- 0.05 [.059 +/- .002]	6.1



- 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 180. 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.
- 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.

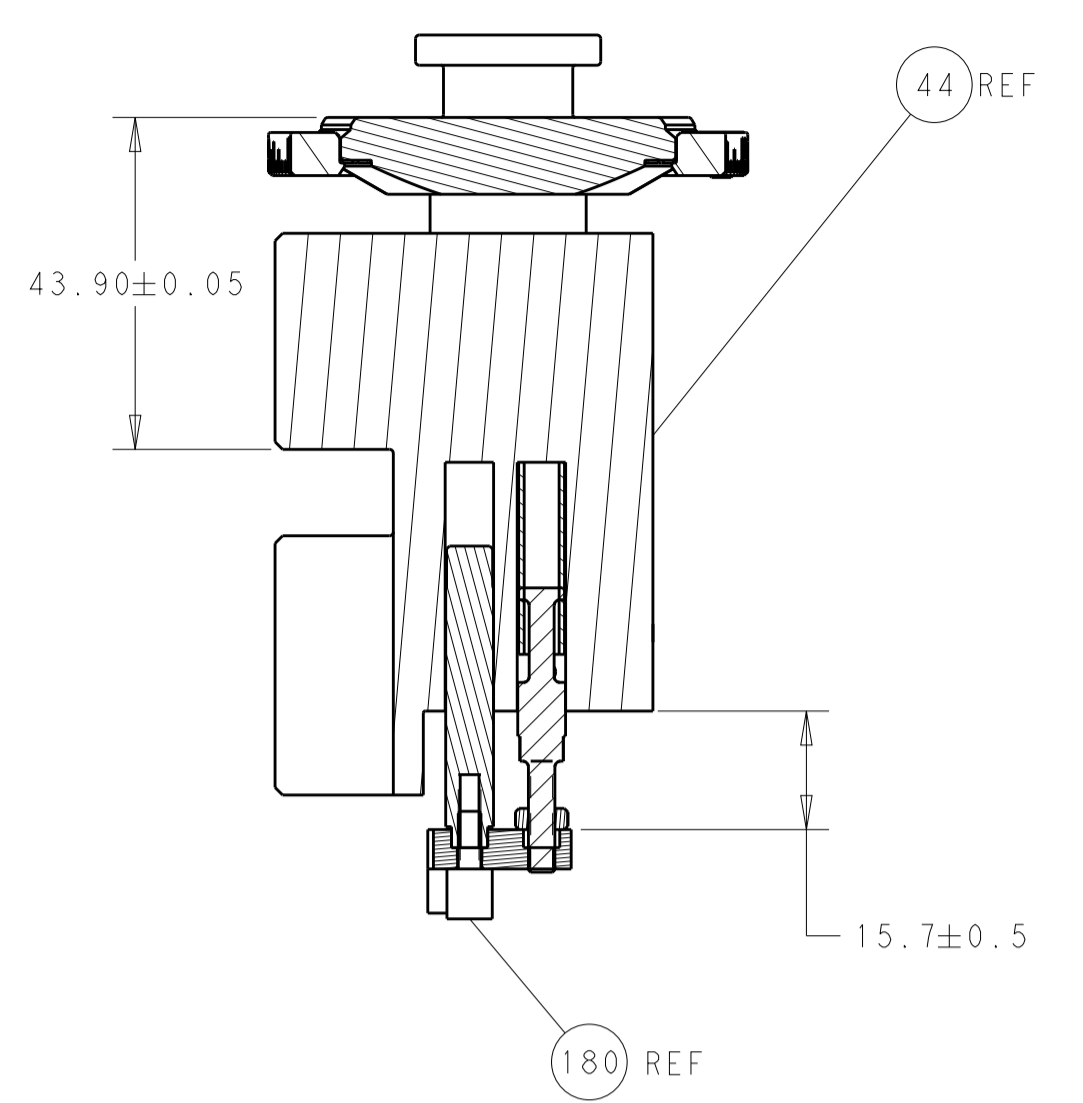
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66	1		DEVELOPMENT	04JAN2015	YY	UG
		A		RELEASED	04FEB2015	YY	UG
		B		ECR-19-007216	07MAY2019	FZ	TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	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	-	2063440-1	AIR FEED MODULE	238	
3	-	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1	1	1-1752354-1	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	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	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	1901681-1	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-1	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	-	2119792-2	PAWL, EF, AIR	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	1752371-3	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	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	-	1	690482-4	PLATE, FRONT SHEAR	9	
1	2	2	1	1	1-1803060-9	ANVIL, COMBINATION, END FEED	8	
1	-	1	-	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-240641-8	SPACER	5	
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	5-2119582-0	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	2	2	1	1	2-456408-1	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

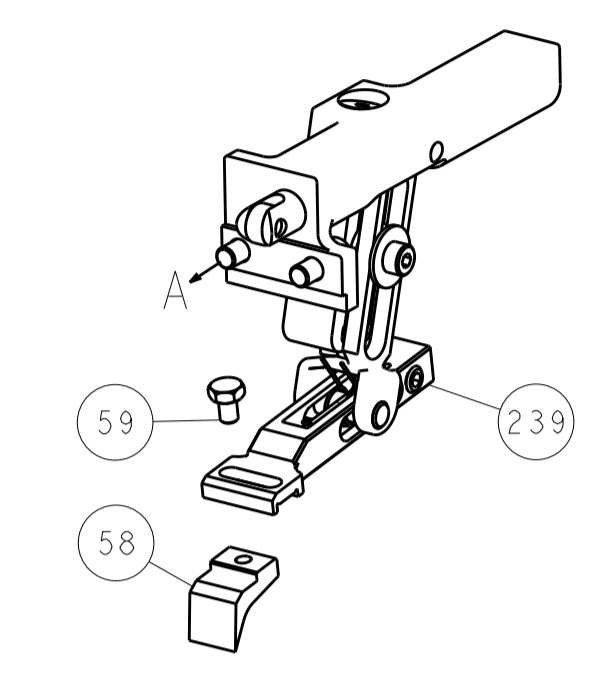
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	04JAN2014	CHK	04JAN2014
	3 PLC ±	4 PLC ±	ANGLES ±	G. BAILEY		APVD	04JAN2014
	FINISH			J. GUO		NAME	
MATERIAL						Ocean End Feed Applicator	
						SIZE	CAGE CODE
						A1	00779
						Customer Accessible Production Drawing	SCALE
						1:1	SHEET 1 OF 4
							REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

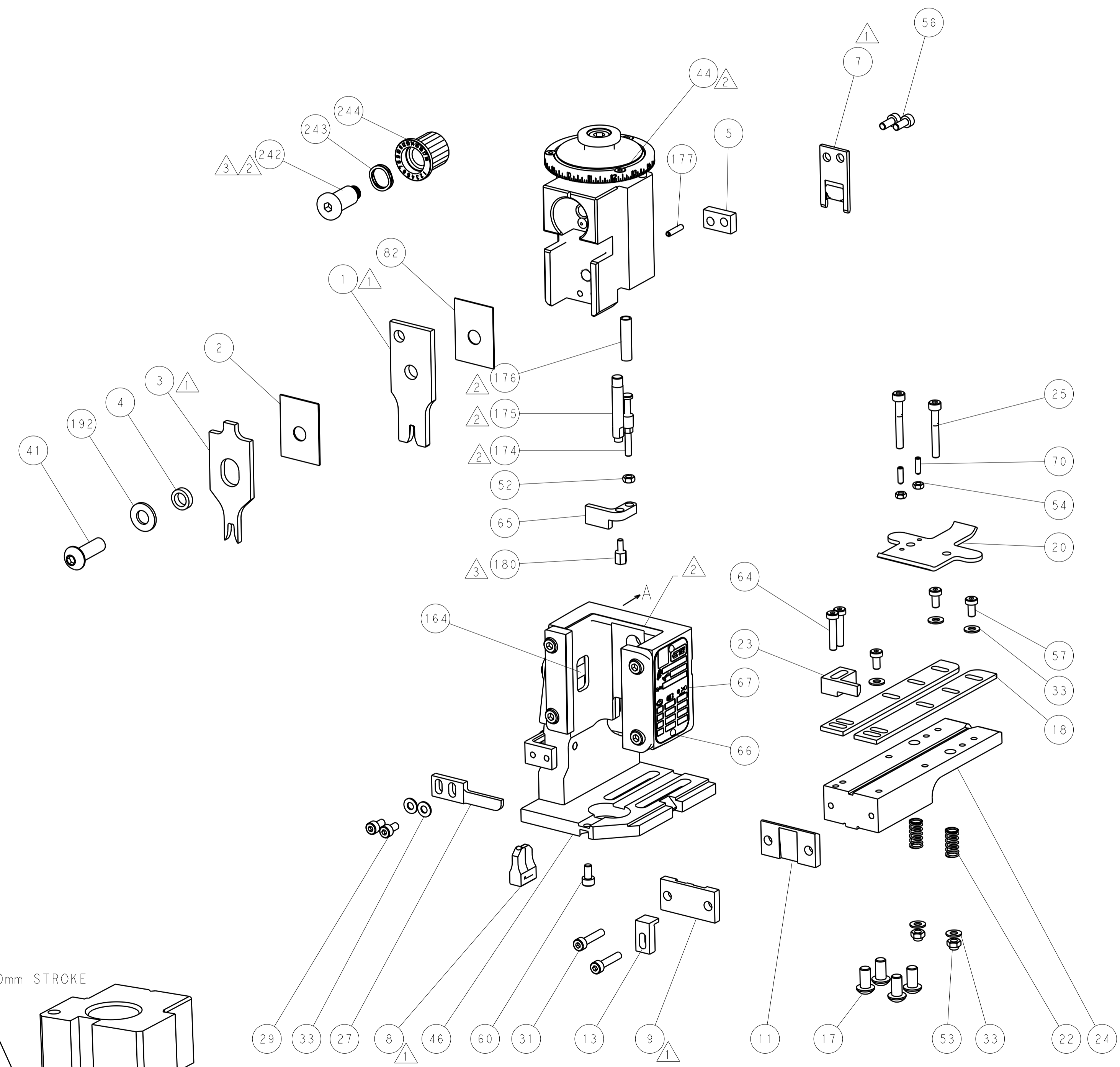
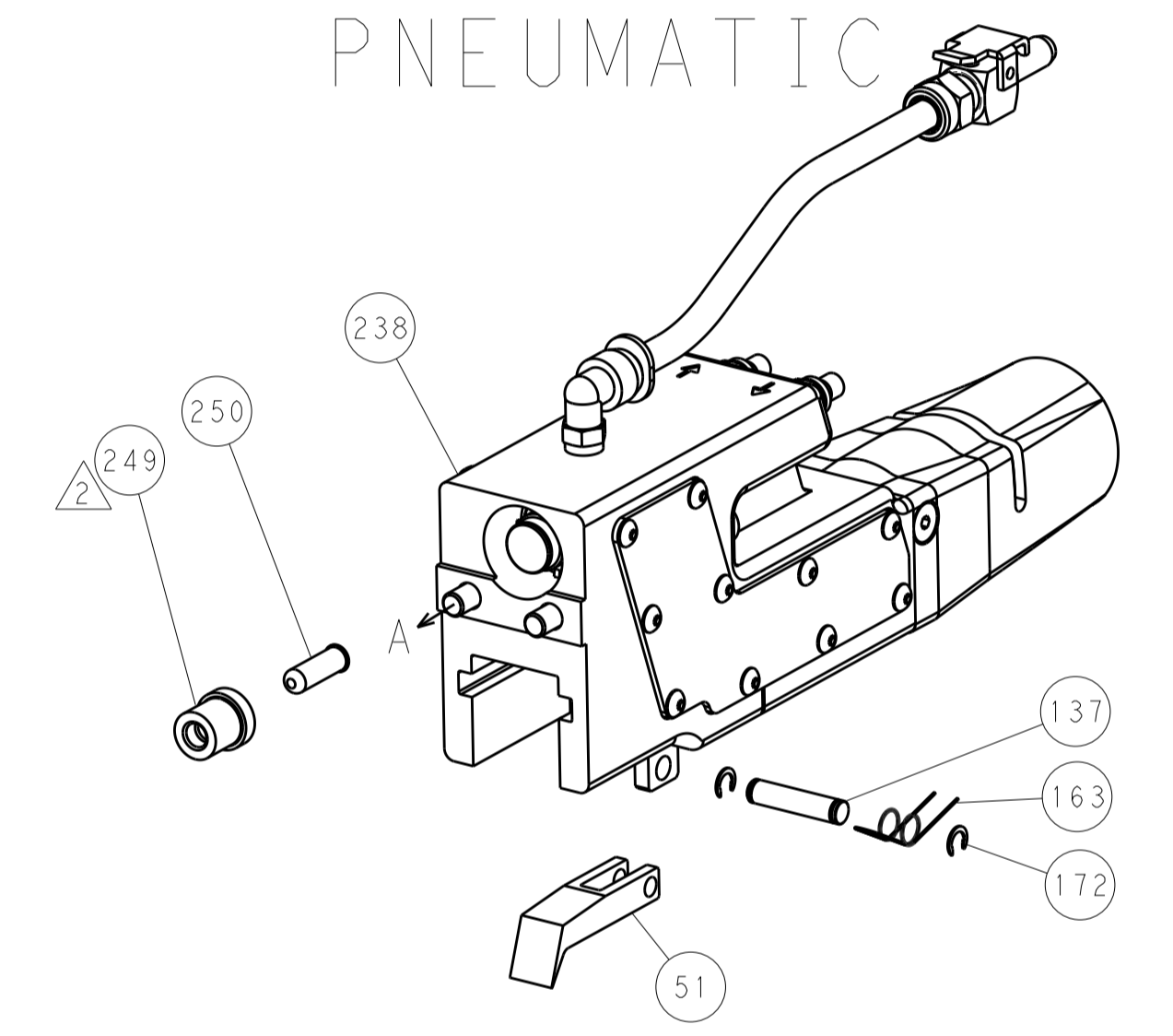


RAM AND HOLDDOWN SET-UP

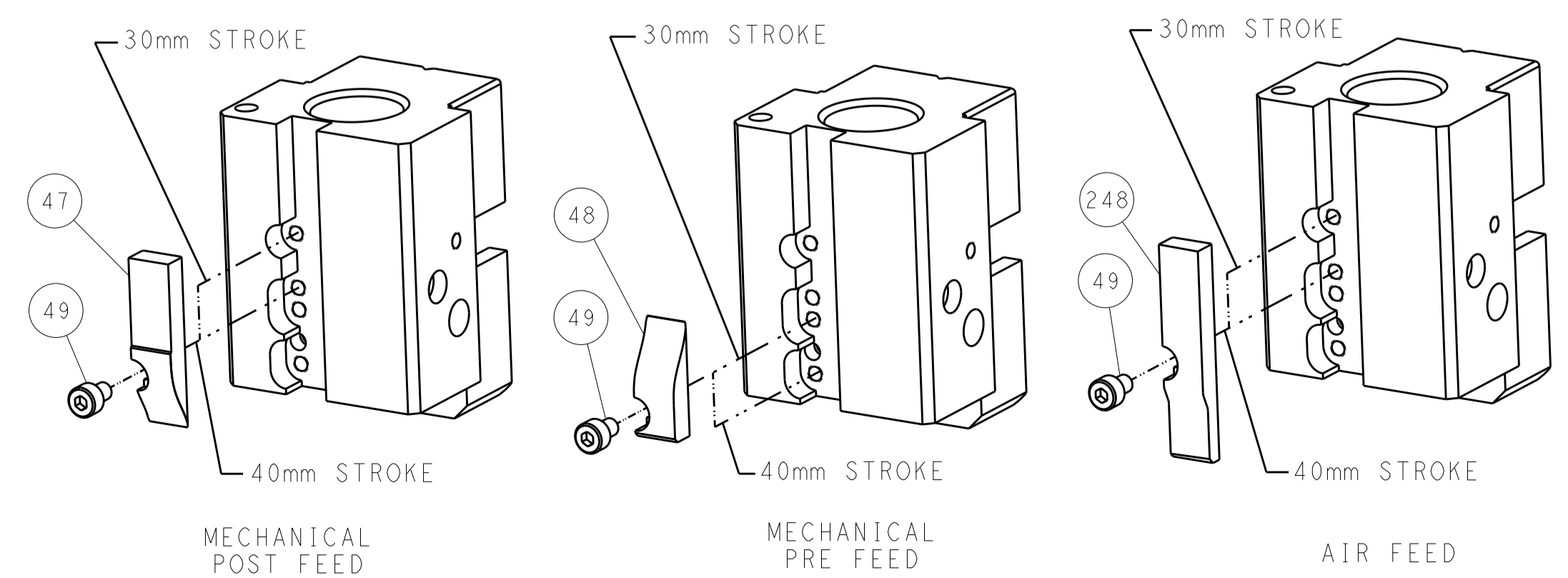
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

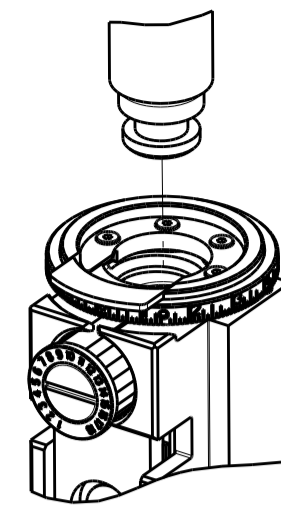


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 04JAN2014		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 04JAN2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: H. GUO 04JAN2014		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150520	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150520-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150520-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150520-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	4.19 mm [1.65]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: GMG TERMINAL		GMG CRIMP SPECIFICATION	
TERMINAL NAME: FASTON FEMMINA CON DENTINO 6.3X0.8 TERMINAL			
WIRE STRIP LENGTH 4.81-5.57 mm [1.89-.219 IN]		INSULATION DIAMETER RANGE 2.34-3.12 mm [1.092-.123 IN]	
TERMINAL APPLICATION SPECIFICATION GMG 30015.52.02.1 Rev 01			
TERMINALS APPLIED			
TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113641-1	30015.52.00.1	2113641-4	30015.52.02.1
2113641-2	30015.52.00.0	2113641-5	30015.30.00.1
2113641-3	30015.52.02.0	2113641-6	30015.30.02.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.80 +/- 0.05 [1.071 +/- .002]	3.6
1+1mm2	1.70 +/- 0.05 [1.067 +/- .002]	4.2
1.5mm2	1.60 +/- 0.05 [1.063 +/- .002]	4.9
1.00mm2	1.50 +/- 0.05 [1.059 +/- .002]	6.1



- 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 180. 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.
- 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.

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	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	1	-	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	2063440-1	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	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
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REFREF	-	-	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	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	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	-	455888-5	SPACER, CRIMPER	82
-	1	1	-	1803607-2	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
-	1	1	-	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	-	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	-	1	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	-	2063961-1	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	-	-	2119792-2	PAWL, EF, AIR	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	-	1752371-3	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	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	-	690482-4	PLATE, FRONT SHEAR	9
1	1	1	-	1-1803060-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	-	1-240641-8	SPACER	5
-	1	1	-	2-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	-	5-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	-	455888-7	SPACER, CRIMPER	2
1	1	1	-	2-456408-1	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	04JAN2014	CHK	04JAN2014
	3 PLC ±	4 PLC ±	ANGLES ±	G. BAILEY		APVD	04JAN2014
	FINISH			H. GUO			
MATERIAL				NAME		TE Connectivity	
				Ocean End Feed		Harrisburg, PA 17105-3608	
				PRODUCT SPEC		Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2150520	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV B	

