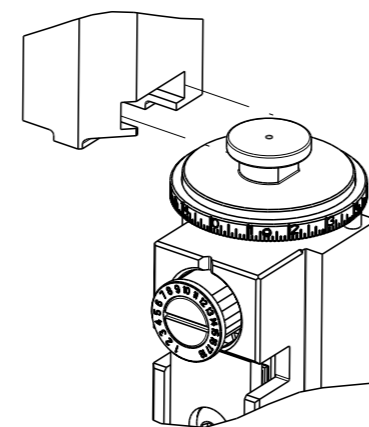


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150527-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150527-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150527-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.81 mm [.150]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CLUSTER BLOCK RECEPTACLE .090 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-5.05 mm [.175-.199 IN]		∅2.00-3.40 mm [.079-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5235		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2825083-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm <sup>2</sup>	1.63 +/- 0.05 [1.064 +/- .002]	5.0
18 AWG OR 0.75mm <sup>2</sup>	1.47 +/- 0.05 [1.058 +/- .002]	6.8
20 AWG OR 0.50mm <sup>2</sup>	1.47 +/- 0.05 [1.058 +/- .002]	6.8

- RECOMMENDED SPARE PARTS
  - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - 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.
  - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - 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.

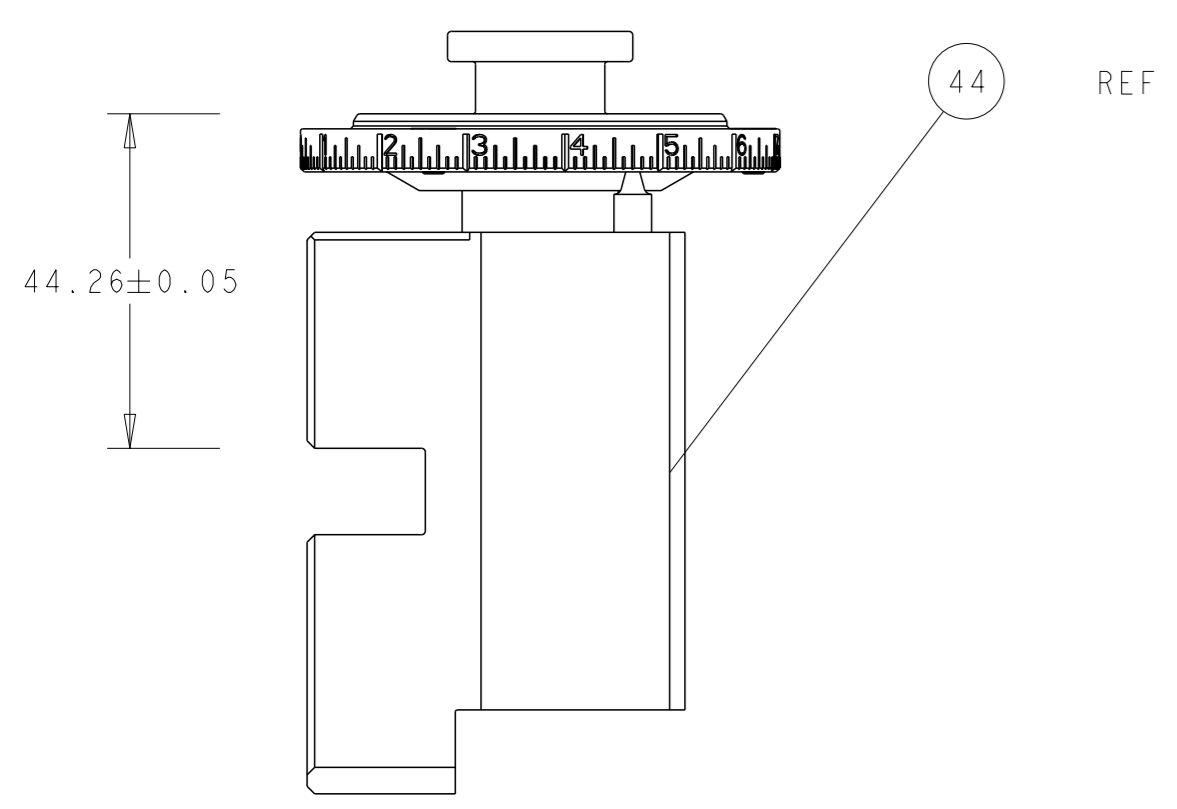
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		A		RELEASED	13JUL2015	JH	GB
		A1		ECR-16-000600	14JAN2016	XZ	CT
		B		ECR-19-011535	23JUL2019	JAH	RR

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	2119791-9	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	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
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	2063961-9	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-3	SPACER	16
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	2	1633387-5	ANVIL, COMBINATION	8
-	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	3-240641-3	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	7-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	2	2-456406-3	CRIMPER, WIRE PREMIUM	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)

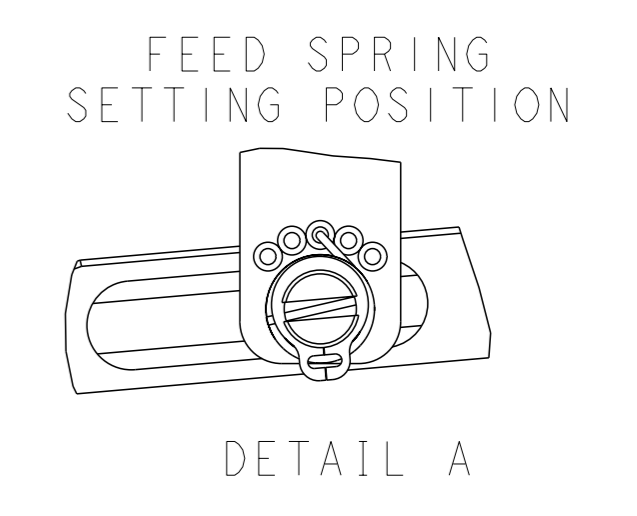
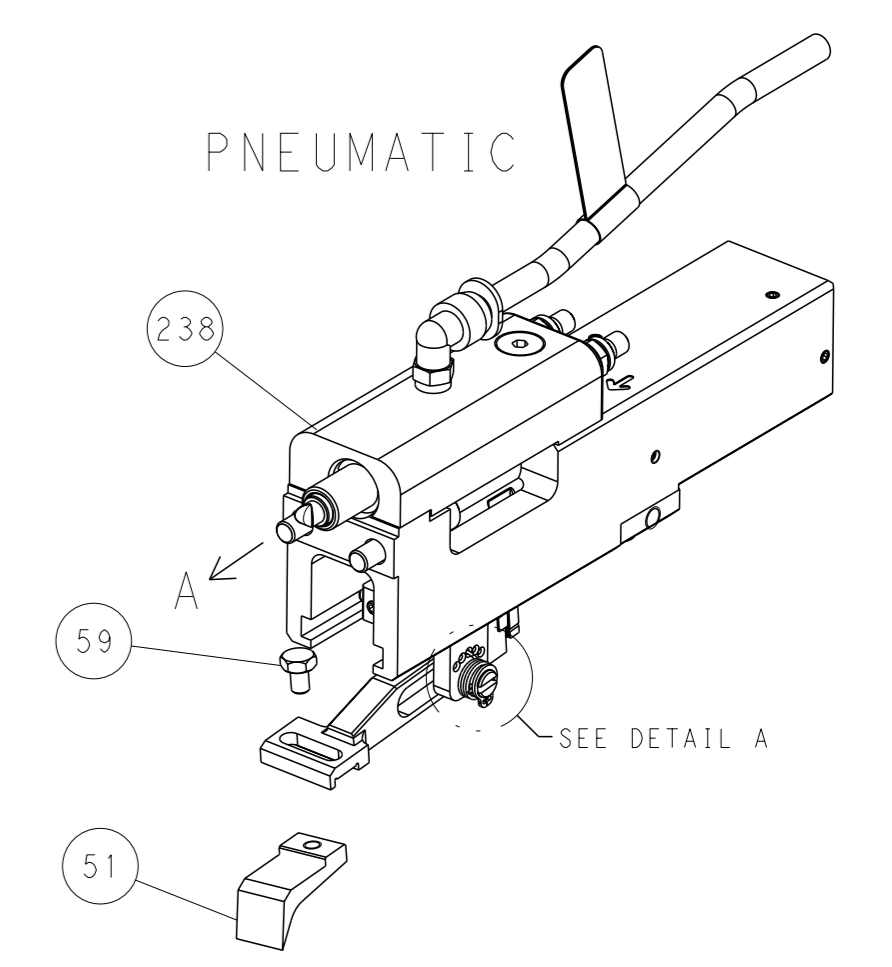
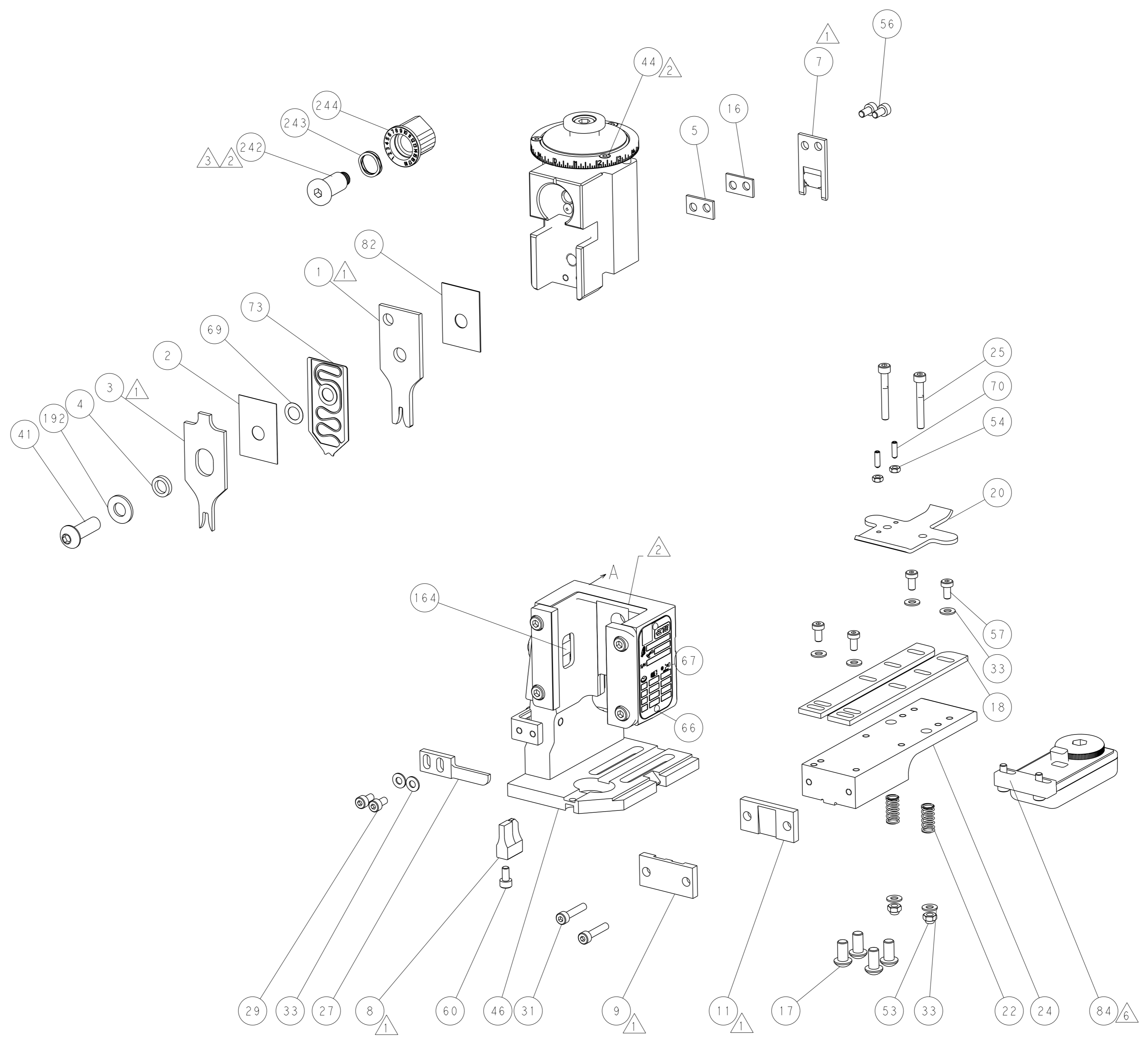
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU TAPR2015		CHK: L. ZHANG TAPR2015		APVD: J. GUO TAPR2015		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2150527	RESTRICTED TO:	Customer Accessible Production Drawing	
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:1	SHEET: 1	OF: 4	REV: B	Customer Accessible Production Drawing				

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

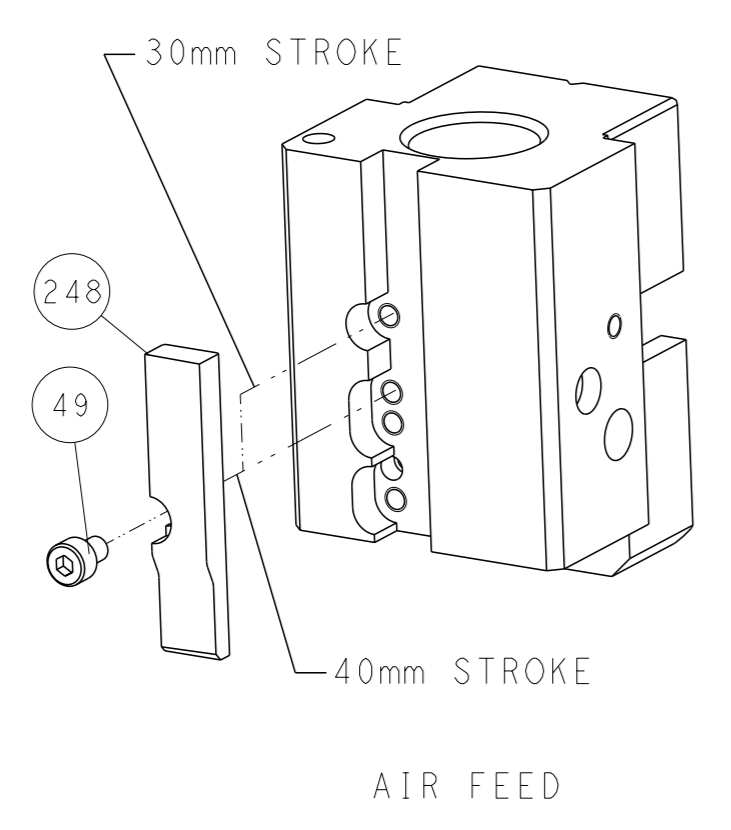


RAM SET-UP

FEED TYPE



CAM POSITIONS

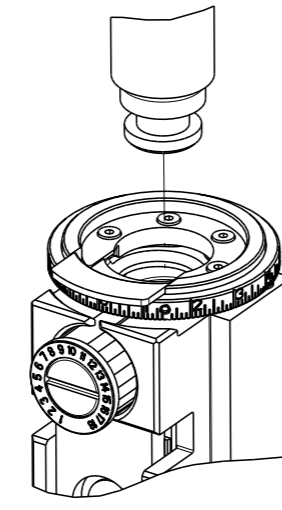


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: H. GUO	DATE: 7 APR 2015 DATE: 7 APR 2015 DATE: 7 APR 2015	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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150527	RESTRICTED TO: SCALE: 1:1 SHEET: 2 of 4 REV: B
MATERIAL:		Customer Accessible Production Drawing		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150527-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150527-7	A	CRIMP TOOLING KIT	-

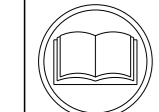
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.81 mm [.150]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CLUSTER BLOCK RECEPTACLE .090 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-5.05 mm [.175-.199 IN]		Ø2.00-3.40 mm [.079-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5235	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2825083-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm <sup>2</sup>	1.63 +/- 0.05 [.064 +/- .002]	5.0
18 AWG OR 0.75mm <sup>2</sup>	1.47 +/- 0.05 [.058 +/- .002]	6.8
20 AWG OR 0.50mm <sup>2</sup>	1.47 +/- 0.05 [.058 +/- .002]	6.8



- RECOMMENDED SPARE PARTS
  - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - 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.
  - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - 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.

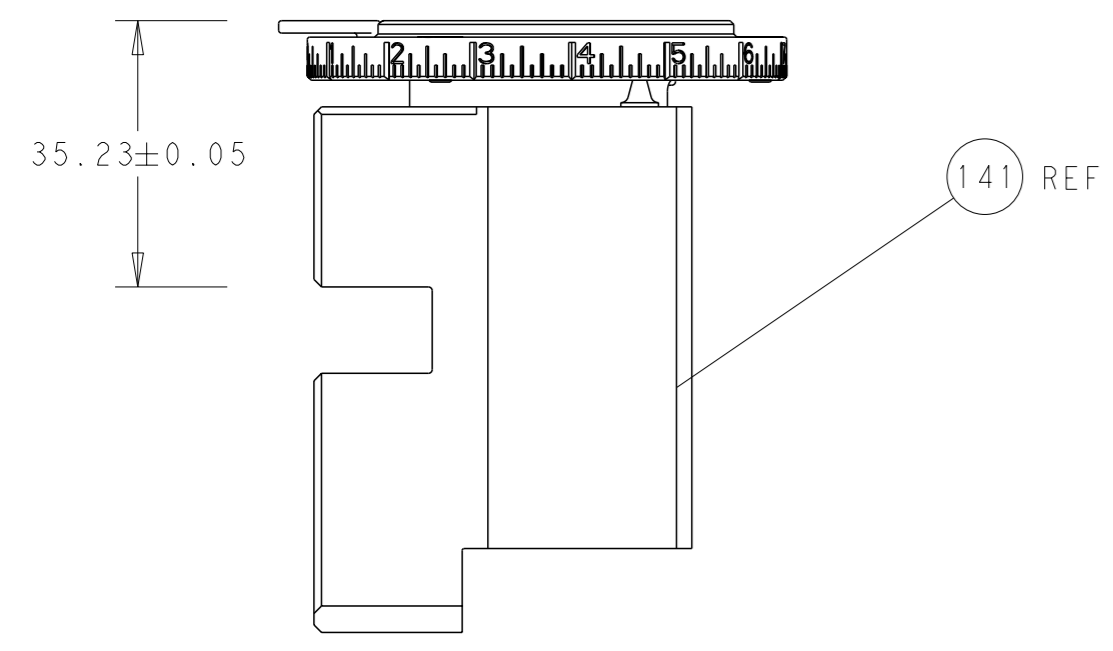
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-3	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82	
-	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119943-1	WASHER, SPACER	69	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	2063961-9	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	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-6	GUIDE, LOWER STRIP	18	
-	1	6-240641-3	SPACER	16	
	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10	
	-	1	690482-5	PLATE, FRONT SHEAR	9
	1	1	1633387-5	ANVIL, COMBINATION	8
	-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6	
-	1	3-240641-3	SPACER	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	1	7-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-2	SPACER, CRIMPER	2	
	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1

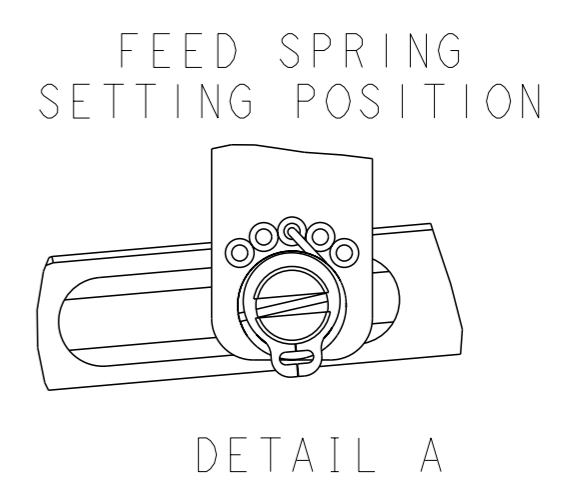
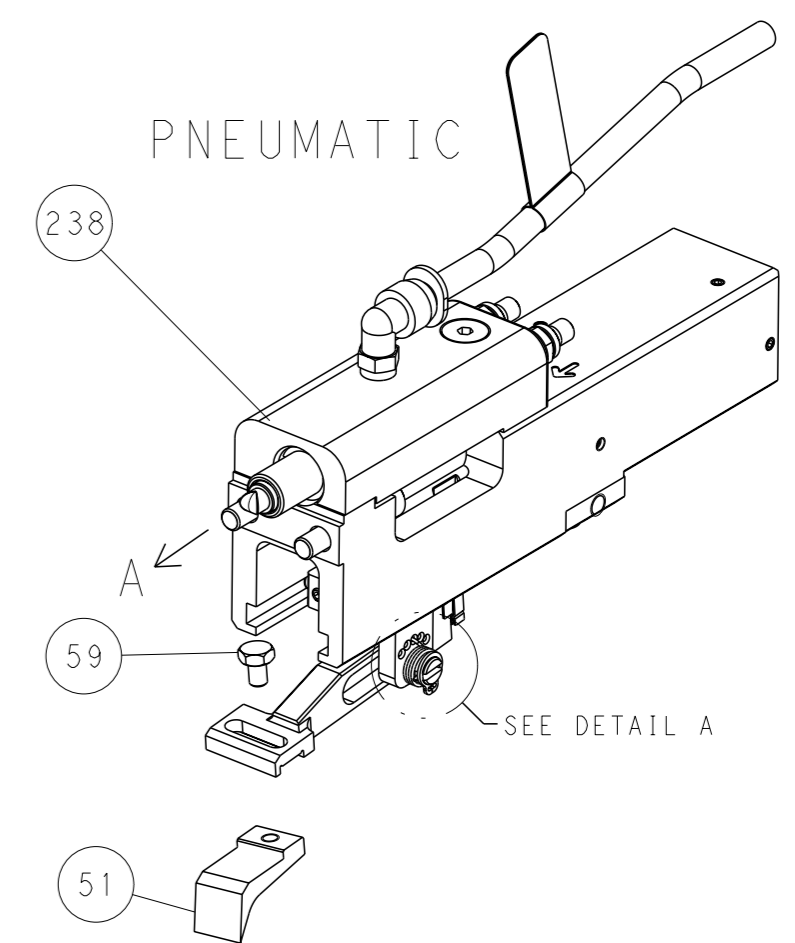
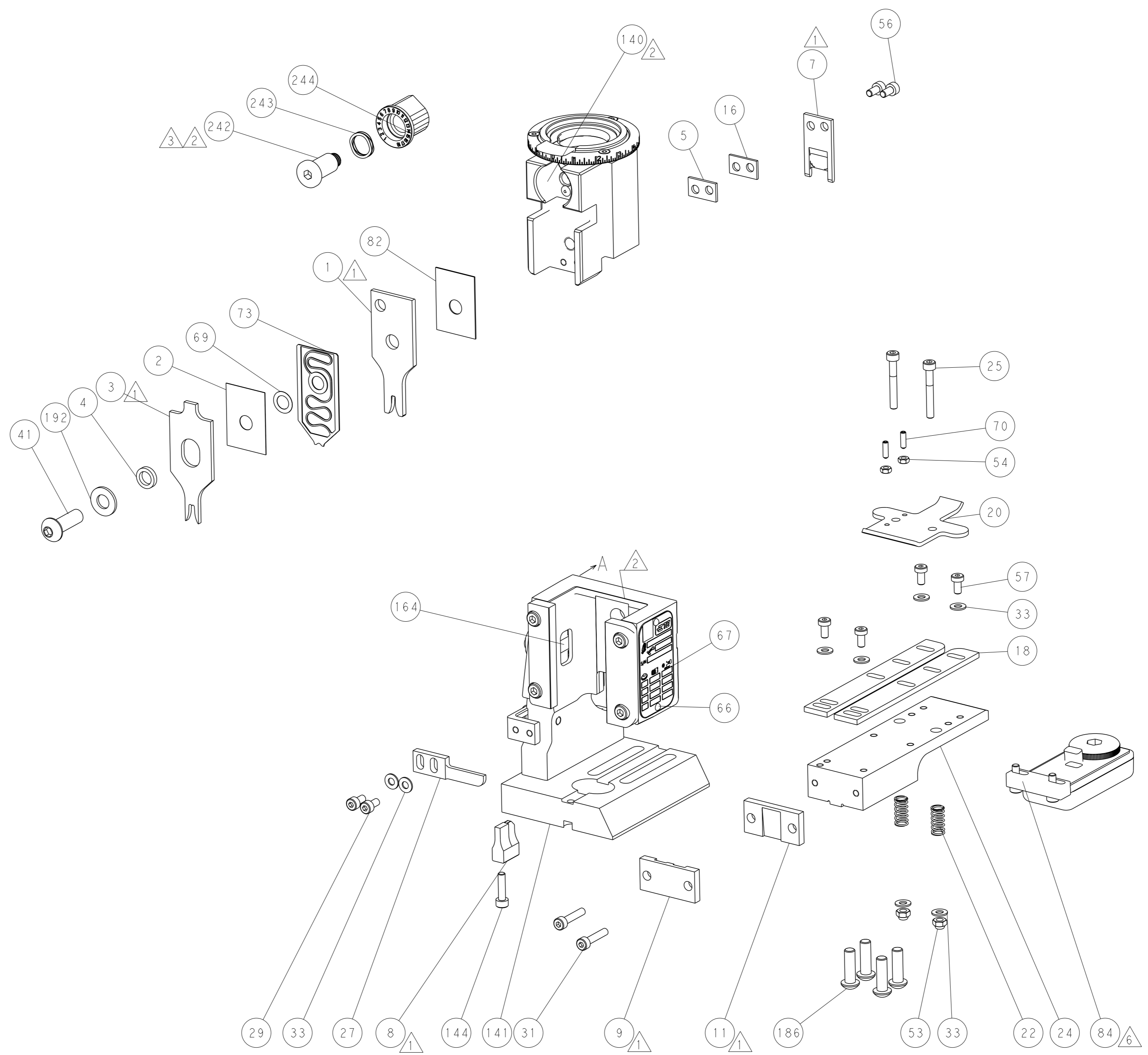
<small>THE DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCT. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY CONTROL ENGINEER. ANY CHANGES TO THE DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: J. GUO PRODUCT SPEC: TAPR2015 APPLICATION SPEC: TAPR2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ±	SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150527	RESTRICTED TO: - SCALE: 1:1 SHEET: 3 of 4 REV: B
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing

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

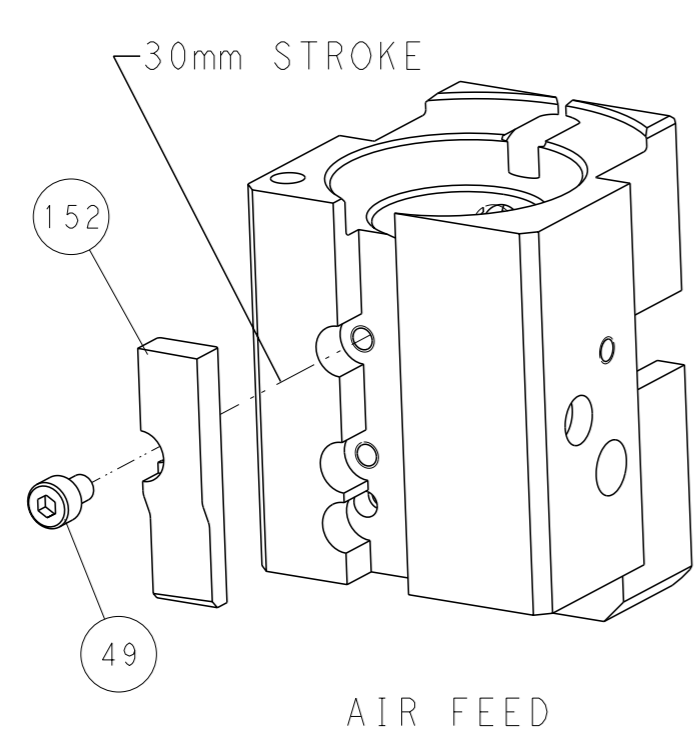


RAM SET-UP

FEED TYPE



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		OWN: J. HOU CHK: L. ZHANG APVD: H. GUO PRODUCT SPEC APPLICATION SPEC WEIGHT: - Customer Accessible Production Drawing	DATE: 7APR2015 7APR2015 7APR2015 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150527 SCALE: 1:1 SHEET: 4 of 4 REV: B	STE TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO
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