

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150645-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150645-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150645-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.34-6.10 mm [.210-.240 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42716-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.31+/-0.05 [.091+/-0.002]	6.3
16 AWG	2.13+/-0.05 [.084+/-0.002]	8.8
18 AWG	2.03+/-0.05 [.080+/-0.002]	9.9

- 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 ITEM 180.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

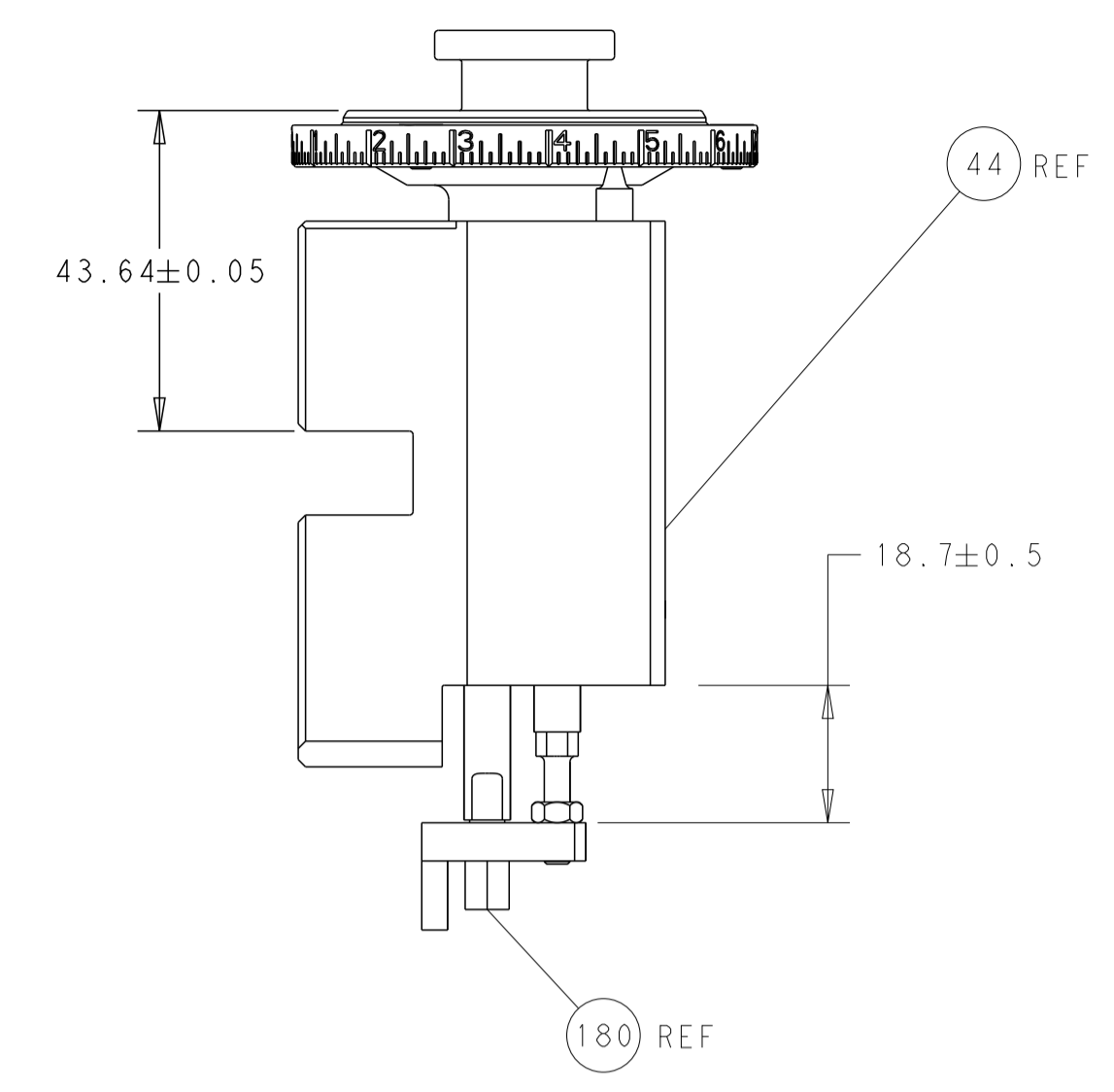
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	06MAY2016	MR	CT
		B		ECR-19-002019	07FEB2019	TB	TE
		C		ECR-19-004188	15MAR2019	FZ	YY
		D		ECR-24-210251	29MAY2024	TB	RK

-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-4	SPACER, CRIMPER -	82
-	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
-	1	1	2-1901681-9	HOLDDOWN, TERMINAL	65
-	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	2063961-1	FEED FINGER	58
-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	2063961-1	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	2119653-1	FEED CAM, POST FEED	47
-	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	240639-4	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
-	1	1	1-1901696-9	STRIP GUIDE, REAR	19
-	1	1	1-1901695-9	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	240644-9	PLATE, REAR SHEAR	11
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	240642-4	PLATE, FRONT SHEAR	9
-	1	1	1-1333224-5	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8
-	1	1	3-691157-1	BLADE, SHEAR -	7
-	-	-	-	-	6
-	1	1	240641-7	SPACER	5
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	456411-3	CRIMPER, WIRE PREMIUM	1
-	77	-2	-1	PART NO	ITEM NO

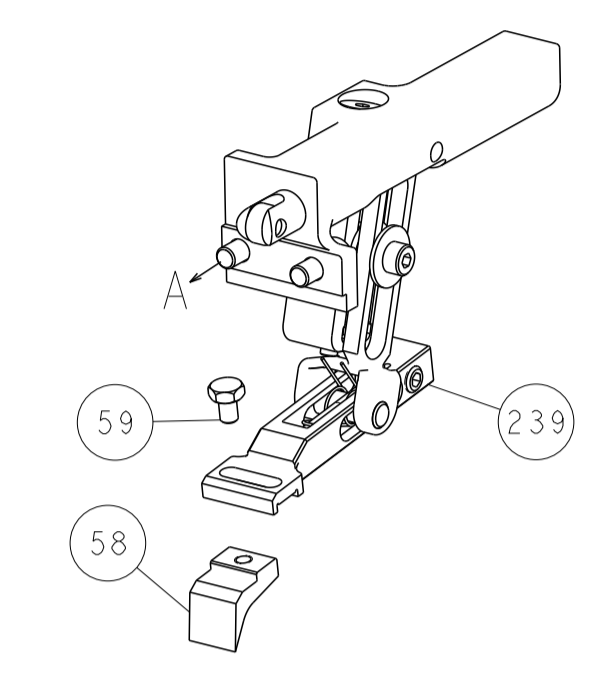
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWG: J.HOU 25JAN2016 CHK: L.ZHANG 25JAN2016 APVD: J.GUO 25JAN2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean End Feed Applicator SIZE: A 00779 C=2150645 SCALE: 1:1 SHEET 1 OF 4 REV D
MATERIAL: - FINISH: -		WEIGHT: - RESTRICTED TO: -	Customer Accessible Production Drawing

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

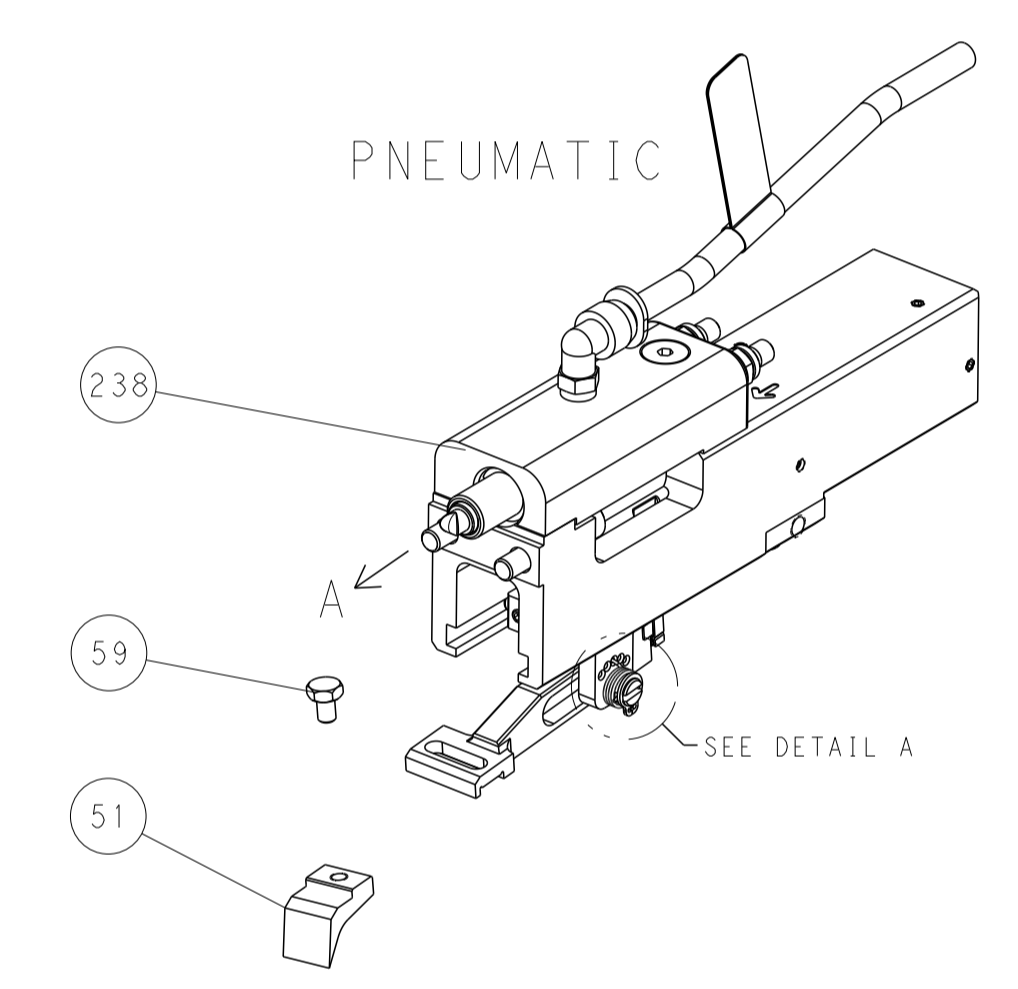


RAM AND HOLDDOWN SET-UP

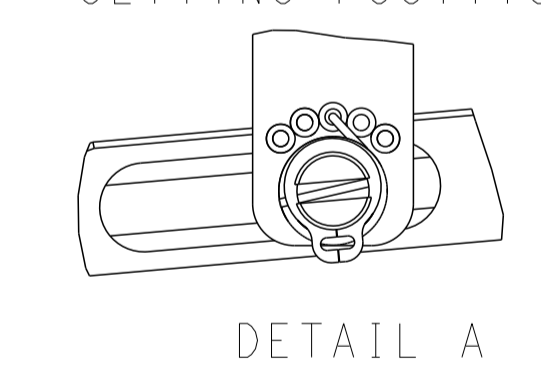
FEED TYPE
MECHANICAL



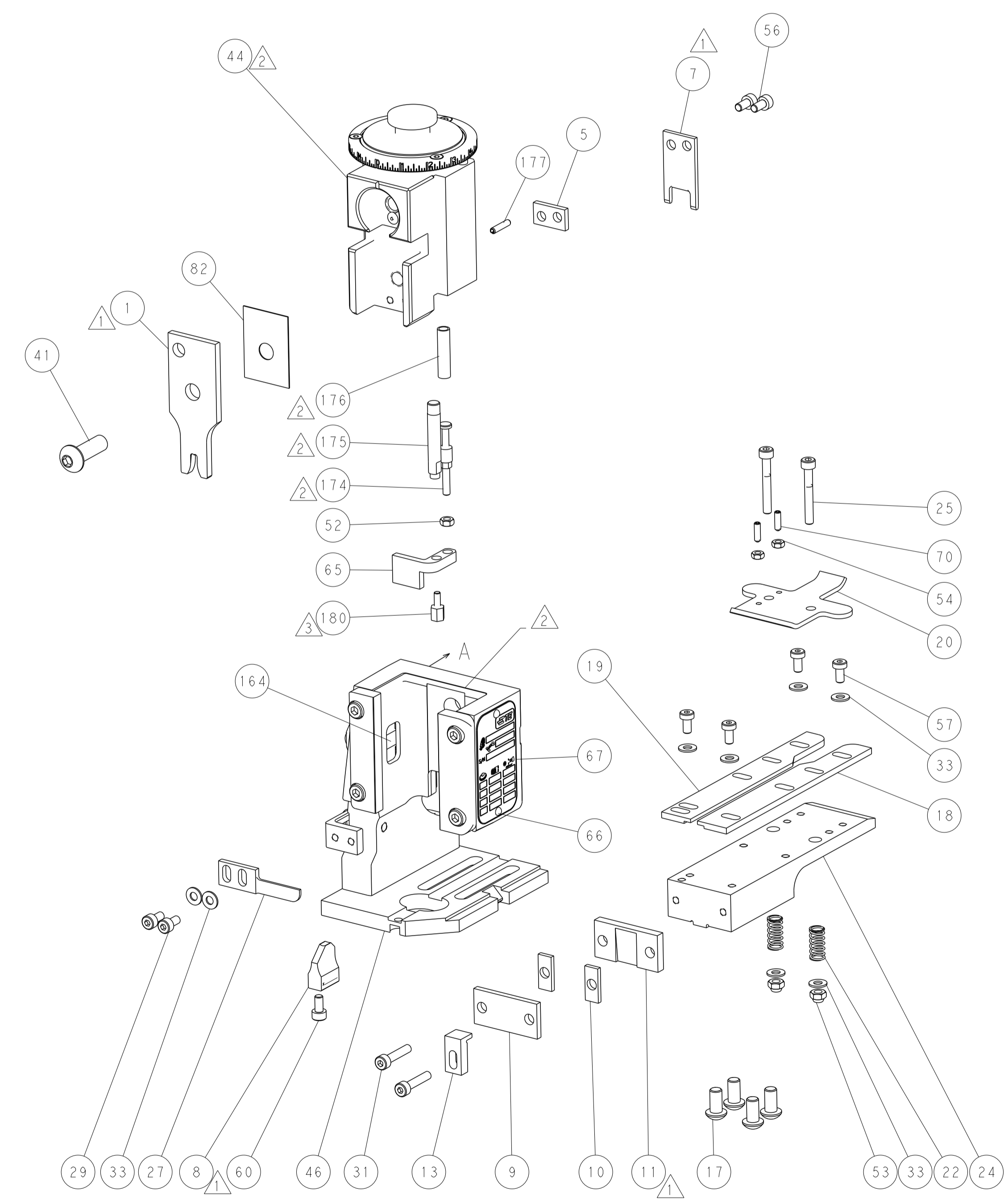
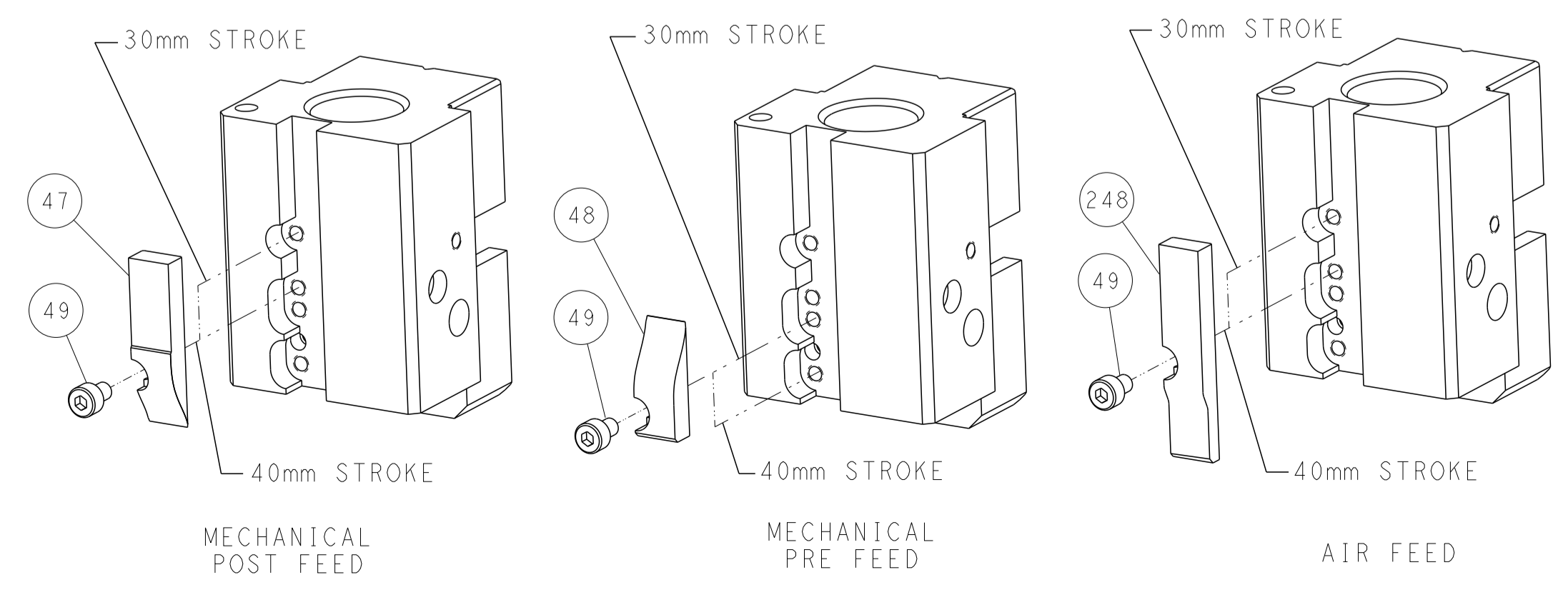
PNEUMATIC



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 J. HOU 25JAN2016 CHK L. ZHANG 25JAN2016 APVD H. GUO 25JAN2016		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		NAME: Ocean End Feed Applicator		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150645	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1		SHEET: 2 OF 4		REV: D	