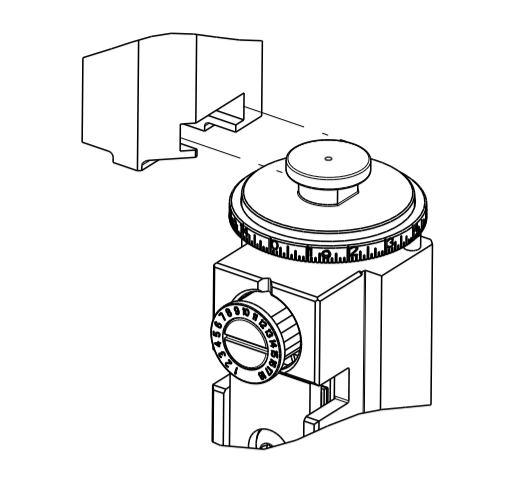


ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150653-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150653-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150653-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150653-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150653-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	5.59 mm [2.20]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.56-6.32 mm [2.19-.249 IN]	Ø3.30-4.32 mm [1.130-.170 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63698-1	61624-1	61624-3	1217996-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.49 +/- 0.05 [1.098 +/- .002]	5.6
2X 16 AWG	2.36 +/- 0.05 [1.093 +/- .002]	7.3
14 AWG	2.24 +/- 0.05 [1.088 +/- .002]	8.8
16 AWG	2.06 +/- 0.05 [1.081 +/- .002]	10.8

- 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.

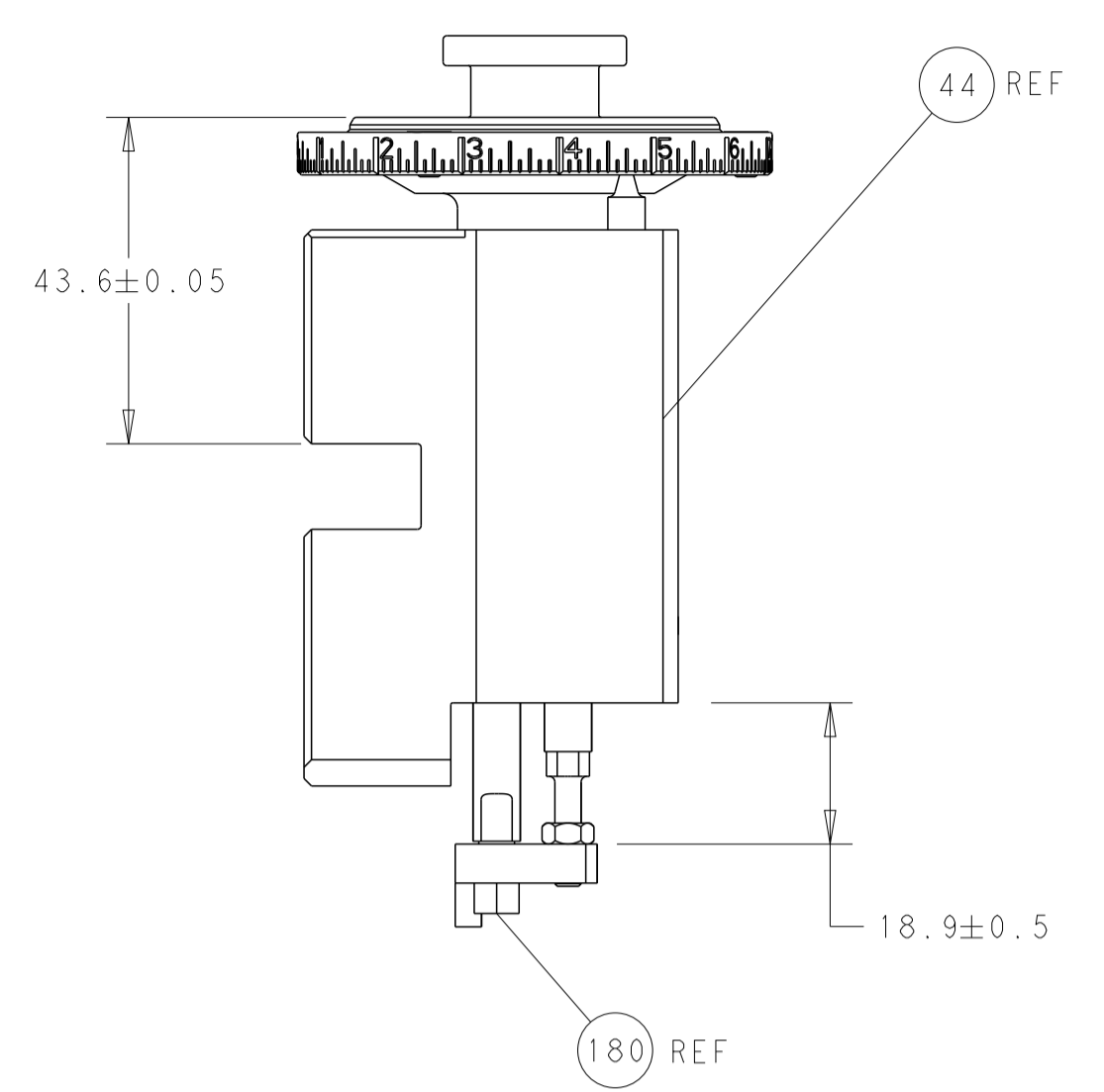
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTM	DESCRIPTION	DATE	DWN	APVD
A	66	1		DEVELOPMENT	14MAR2016	JH	UG
		A		RELEASED	20APR2016	MEH	TE
		B		ECR-18-016008	09OCT2018	JAH	TE
		C		ECR-23-189191	10OCT2023	FZ	TE

-	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
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	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
-	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	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
-	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	2063961-1	FEED FINGER	58
-	4	4	4	4	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	-	2063961-1	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
-	8	8	8	8	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
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	1	1	1	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	5-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	6-690482-8	PLATE, FRONT SHEAR	9
1	2	2	1	1	4-1803059-3	ANVIL, COMBINATION, END FEED	8
1	1	1	1	1	2217206-6	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-3	SPACER	5
-	1	1	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	4-1803018-8	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2
1	2	2	1	1	456411-1	CRIMPER, WIRE PREMIUM	1
-	77-72-71-2	-	1	-	PART NO	DESCRIPTION	ITEM NO

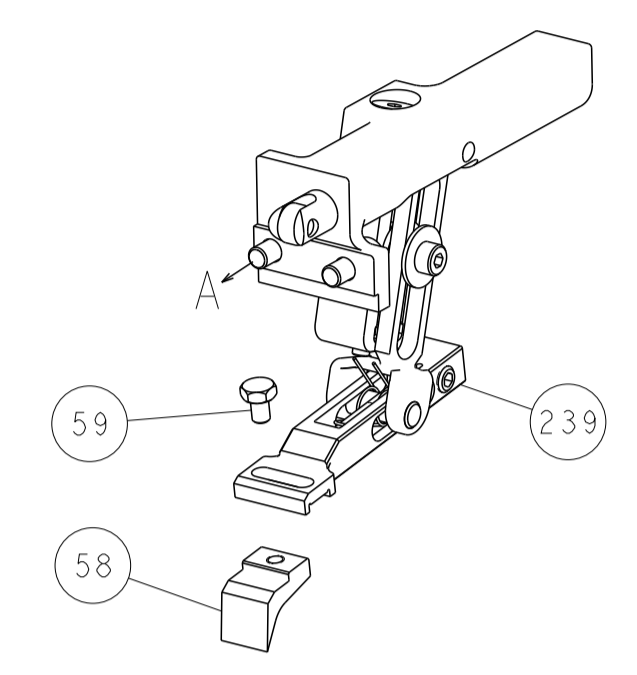
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		2 PLC	±	Customer Accessible Production Drawing			
		3 PLC	±	SCALE 1:1 SHEET 1 OF 4 REV C			
		4 PLC	±				
		ANGLES	±				
		FINISH	±				

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

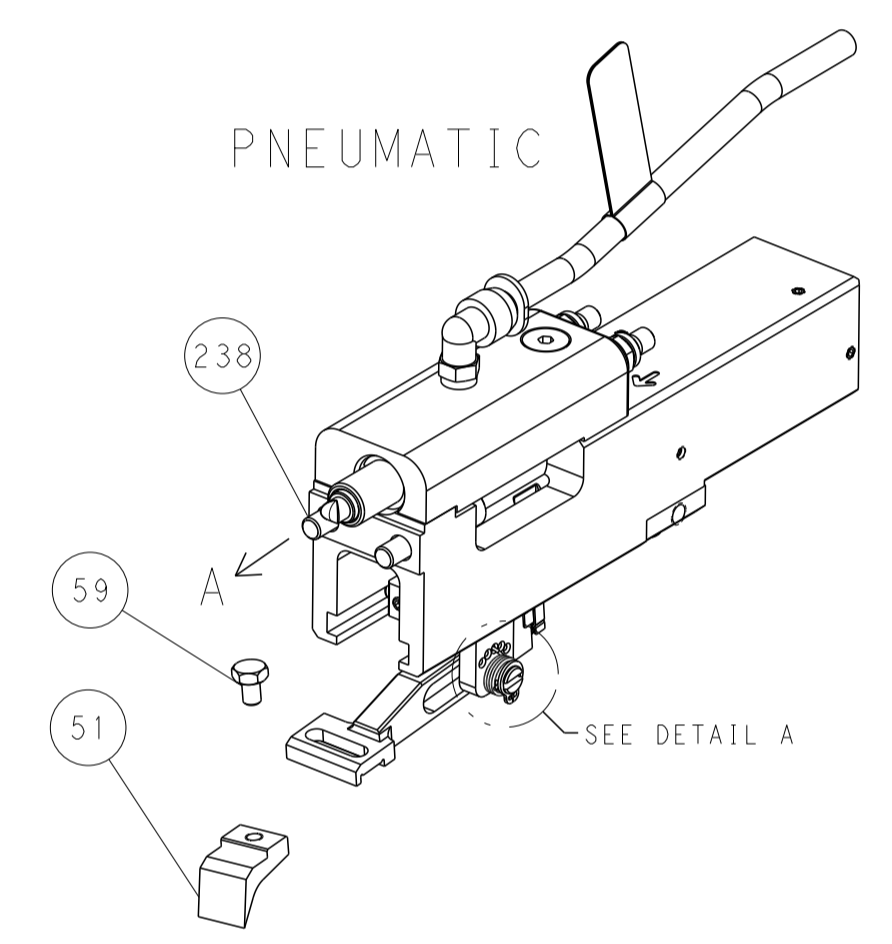


RAM AND HOLDDOWN SET-UP

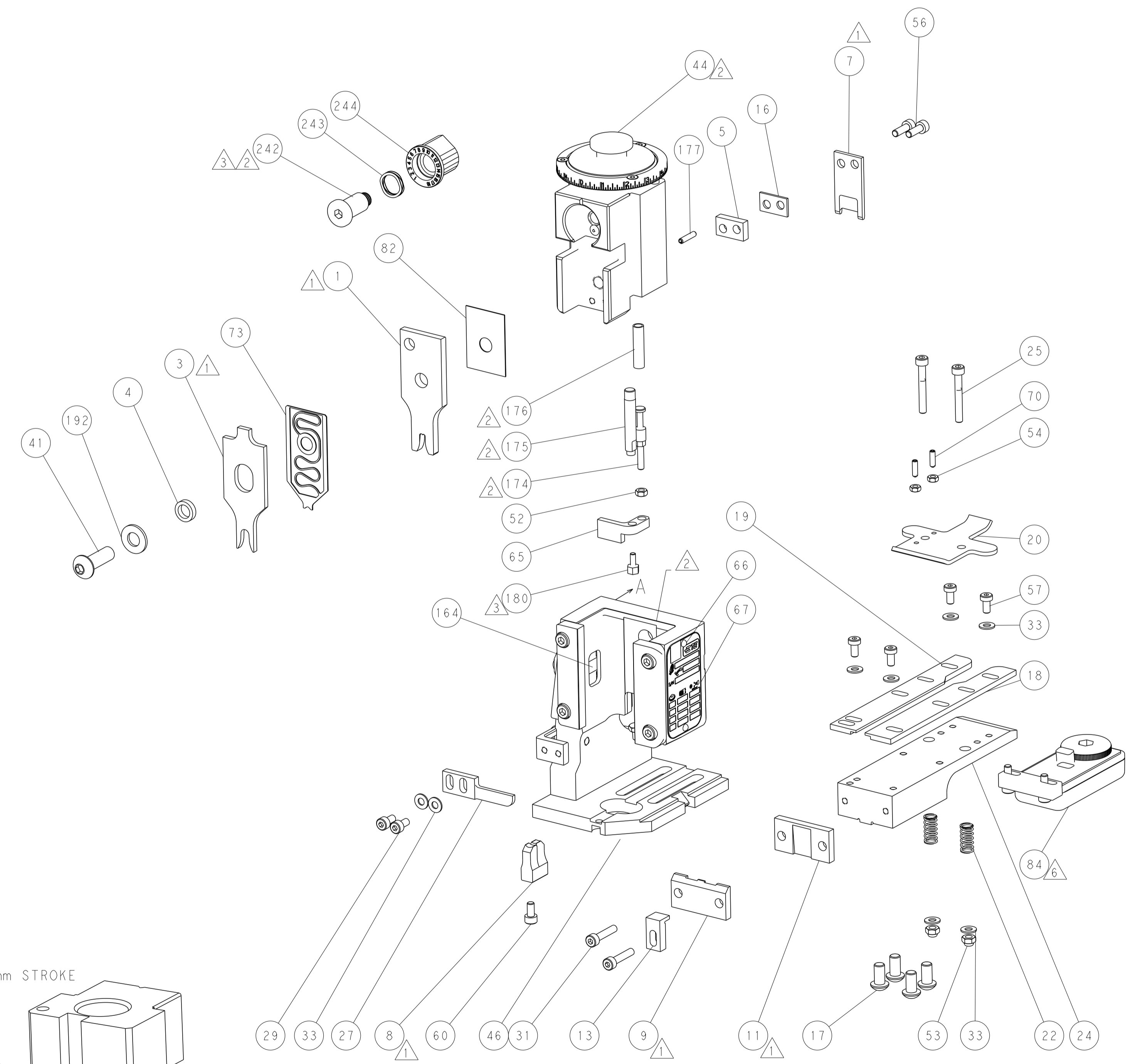
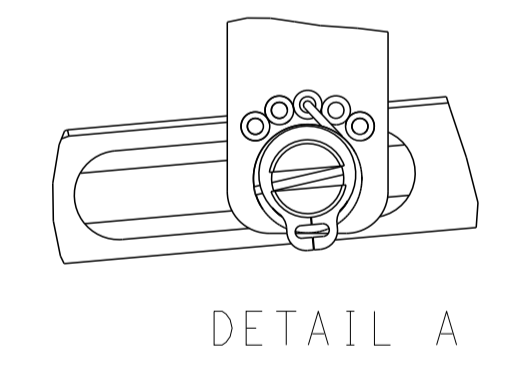
FEED TYPE  
MECHANICAL



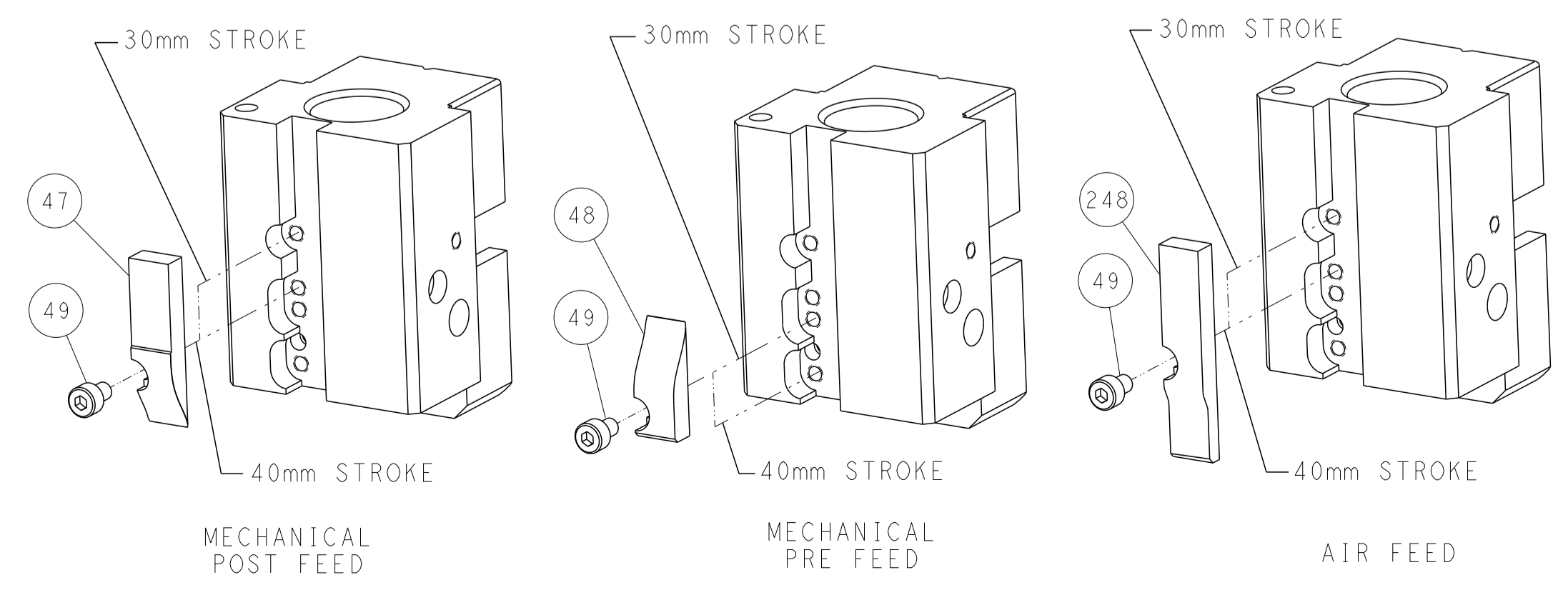
PNEUMATIC



FEED SPRING  
SETTING POSITION



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 J. HOU 14MAR2016 CHK L. ZHANG 14MAR2016 APVD H. GUO 14MAR2016 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2150653 RESTRICTED TO	
MATERIAL:				Customer Accessible Production Drawing			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150653-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150653-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150653-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	5.59 mm [1.220]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 5.56-6.32 mm [1.219-.249 IN]		INSULATION DIAMETER RANGE Ø3.30-4.32 mm [1.130-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63698-1	61624-1	61624-3	1217996-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.49+/-0.05 [1.098+/-0.002]	5.6
2X 16 AWG	2.36+/-0.05 [1.093+/-0.002]	7.3
14 AWG	2.24+/-0.05 [1.088+/-0.002]	8.8
16 AWG	2.06+/-0.05 [1.081+/-0.002]	10.8

- 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.

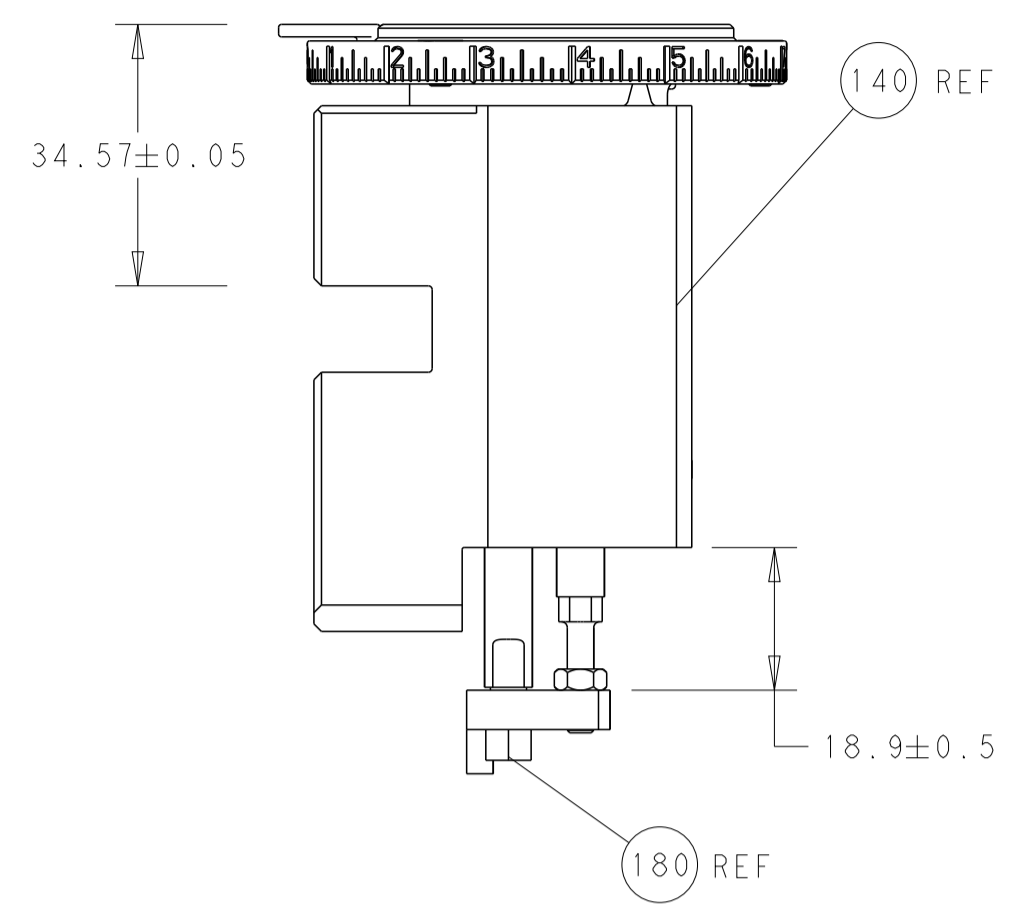
**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-
-	1	1		2119082-9	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	-		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	1752354-1	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
-	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	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		2119740-1	TAG, IDENTIFICATION		67
-	2	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1		1901681-1	HOLDDOWN, TERMINAL		65
-	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		2168083-3	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	-		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	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
-	1	1		1-1901696-5	STRIP GUIDE, REAR		19
-	1	1		1-1901695-5	STRIP GUIDE, FRONT		18
-	1	1		5-240641-4	SPACER		16
-	1	1		1752360-1	SPACER, HOLD-DOWN		13
1	-	1	1	240644-9	PLATE, REAR SHEAR		11
-	-	-	-	-	-		10
1	-	1	1	6-690482-8	PLATE, FRONT SHEAR		9
1	1	1	1	4-1803059-3	ANVIL, COMBINATION, END FEED		8
1	-	1	1	2217206-6	BLADE, SLUG		7
-	-	-	-	-	-		6
-	1	1		240641-3	SPACER		5
-	1	1		6-238011-9	BLOCK, CRIMPER SPACER		4
1	1	1	1	4-1803018-8	CRIMPER, INSULATION 0		3
-	-	-	-	-	-		2
1	1	1	1	456411-1	CRIMPER, WIRE PREMIUM		1
-	77	22	21	PART NO	DESCRIPTION	ITEM NO	

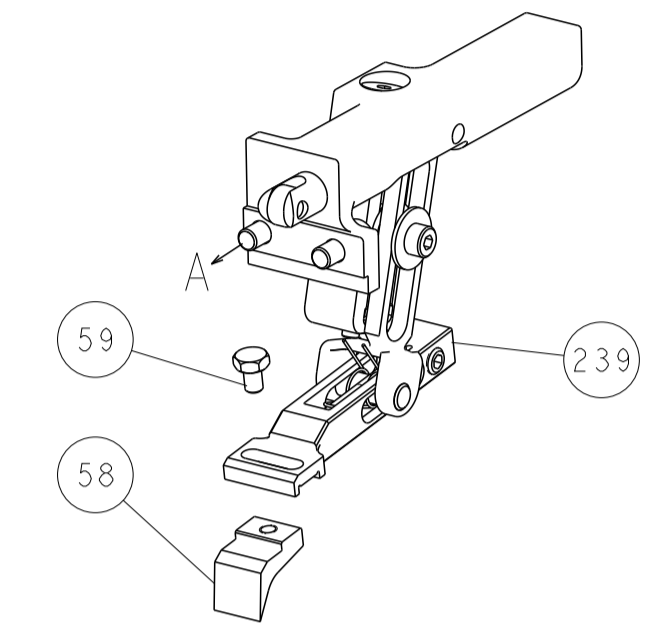
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MATERIAL: -								WEIGHT: -		SCALE: 1:1	
Customer Accessible Production Drawing								SHEET 3 OF 4		REV C	

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

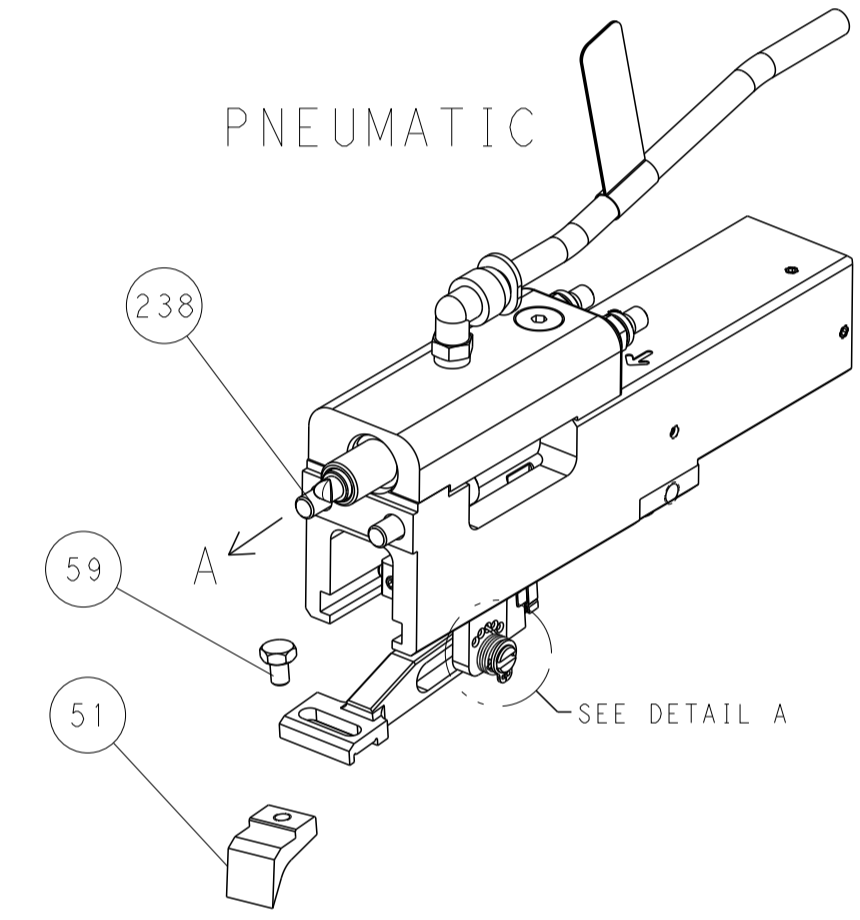


RAM AND HOLDDOWN SET-UP

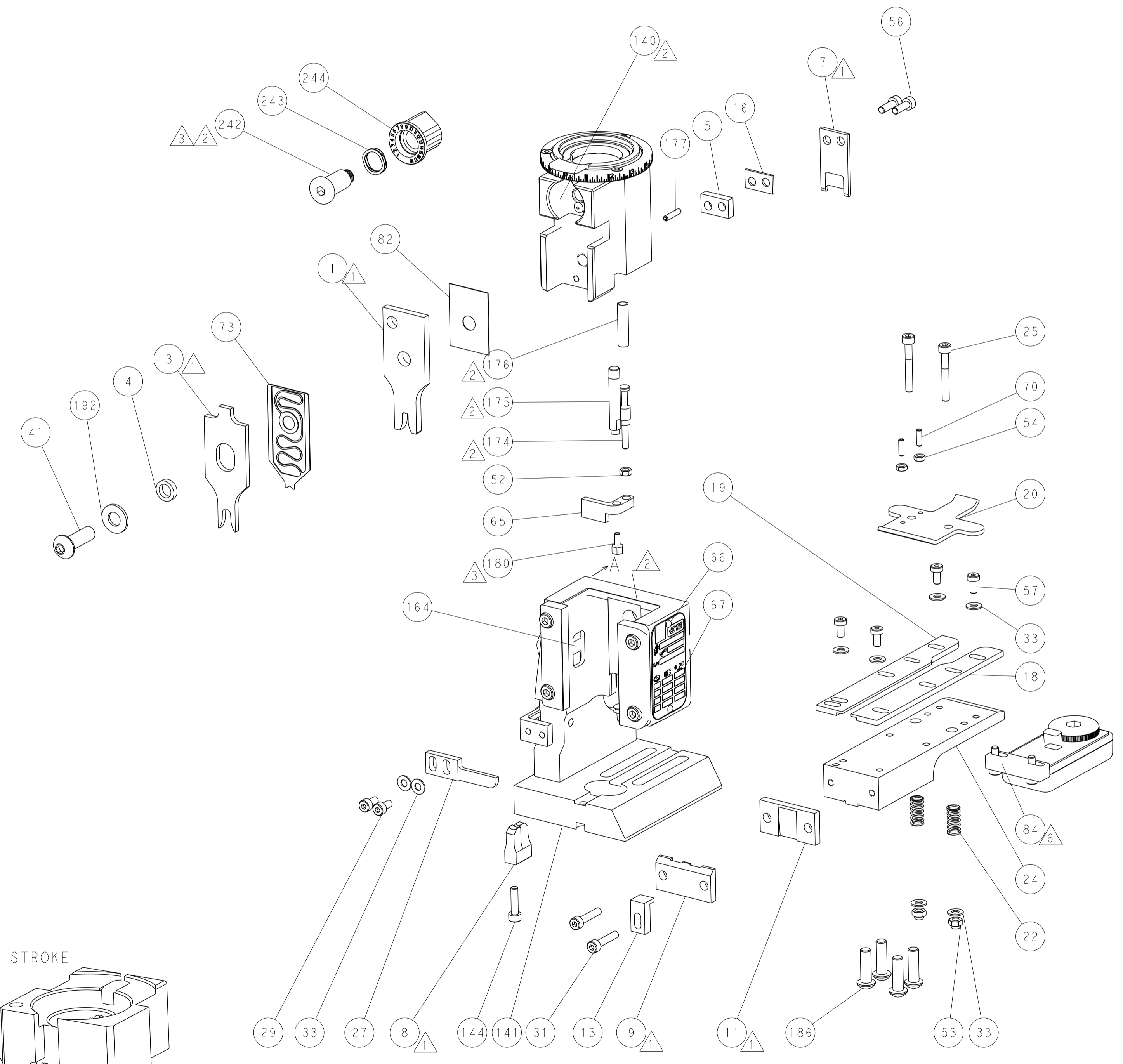
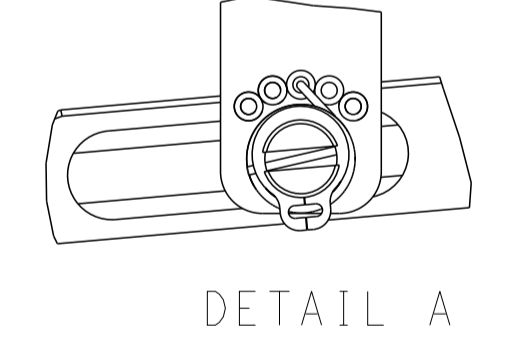
FEED TYPE  
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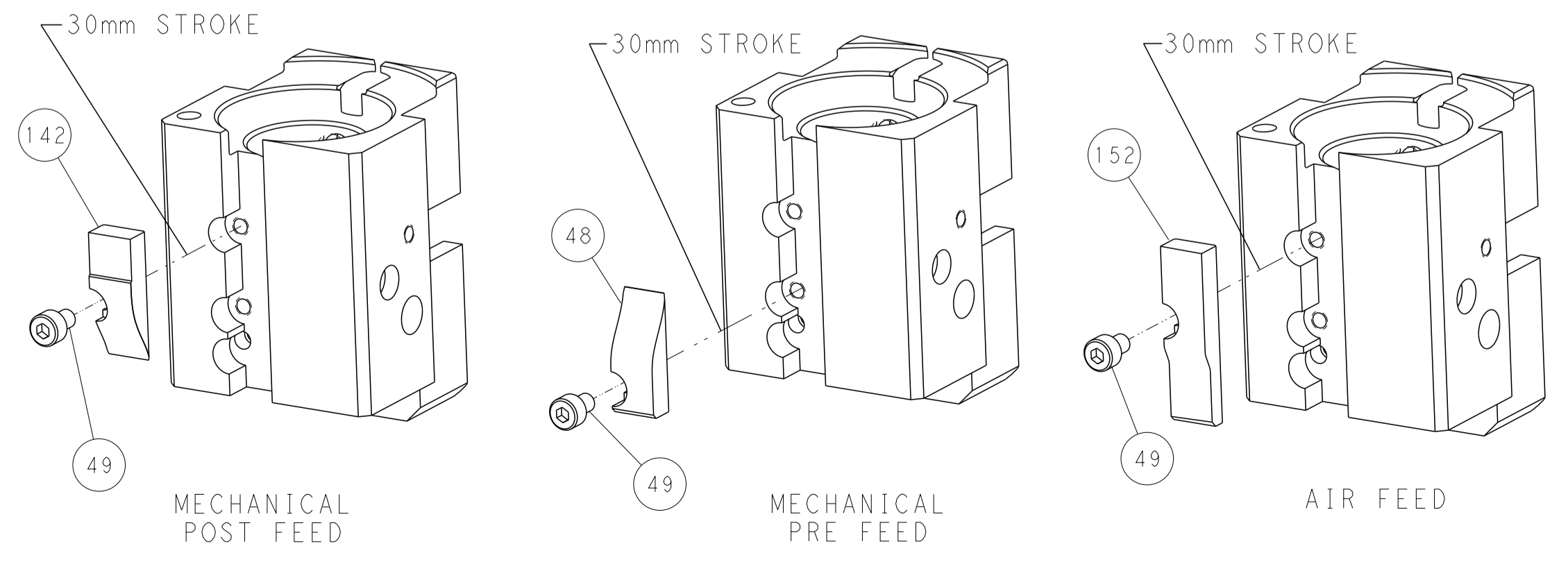
PNEUMATIC



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 J. HOU 14MAR2016		CHK L. ZHANG 14MAR2016		APVD H. GUO 14MAR2016		NAME		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	9 PLC ±	10 PLC ±	SIZE	CAGE CODE
												A1	00779
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV	Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4		