

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150685-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150685-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150685-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150685-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150685-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: NICHIFU TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.99-4.75 mm [.157-.187 IN]		∅2.67-3.56 mm [.105-.140 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	NICHIFU TERMINAL	TE TERMINAL	NICHIFU TERMINAL
2303610-1	CSS 43925-F		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.79+/-0.05 [.070+/- .002]	4.8
16 AWG OR 1.50mm2	1.64+/-0.05 [.065+/- .002]	6.3
18 AWG OR 1.00mm2	1.49+/-0.05 [.059+/- .002]	7.9
20 AWG OR 0.50mm2	1.34+/-0.05 [.053+/- .002]	9.5



- 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 ITEMS 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.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

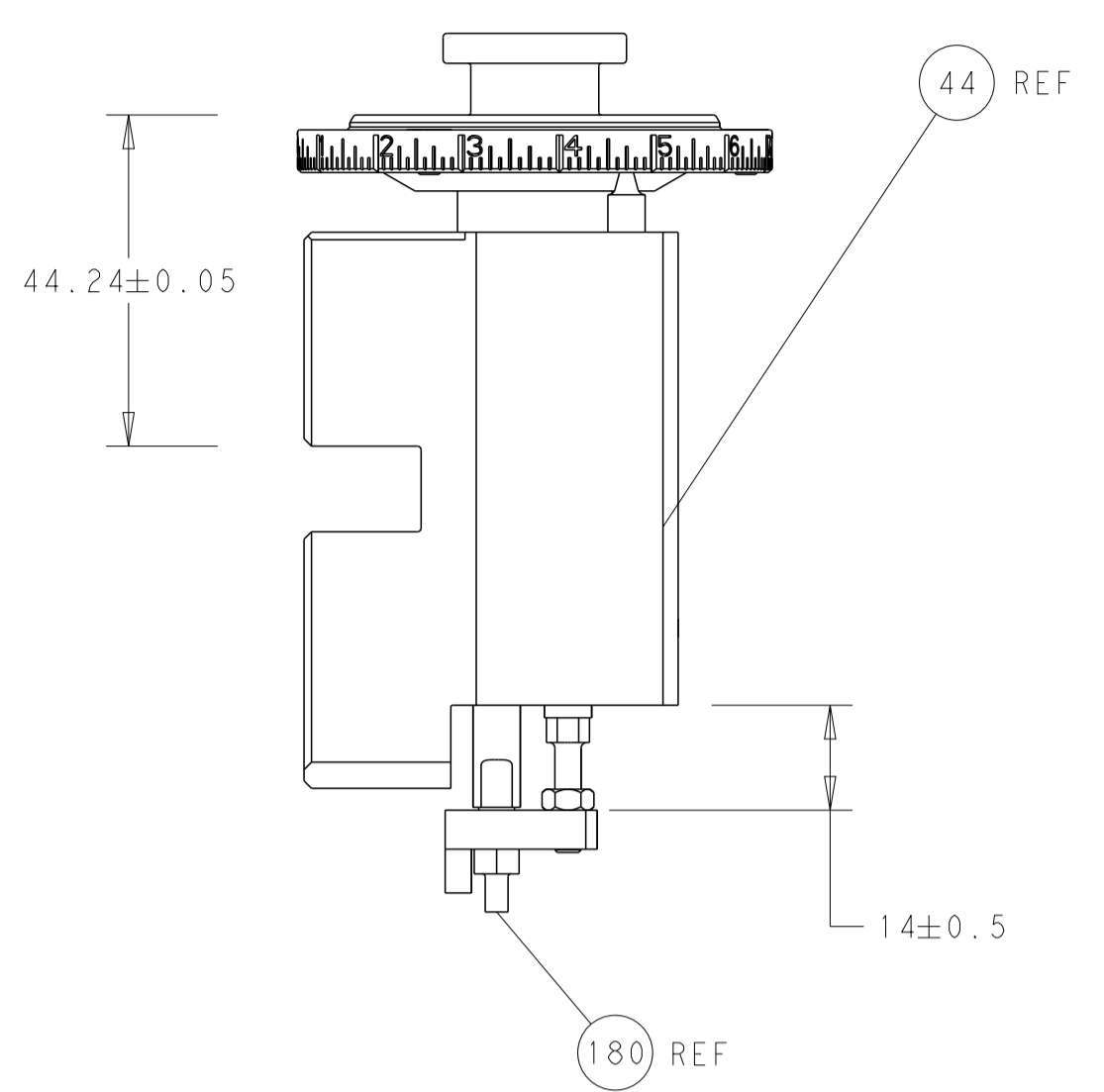
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B1		ECR-17-007579	25MAY2017	LG	TE
		B2		ECR-17-011122	01AUG2017	FZ	KZ
		C		ECR-21-110687	18AUG2021	JAH	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	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	1-1976055-8	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	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-7	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	2119943-1	WASHER, SPACER	69	
-	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	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	
-	-	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	-	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	
-	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	3-240641-6	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	3-1803060-6	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	1	240641-2	SPACER	5
-	1	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	2-1803016-8	CRIMPER, INSULATION F	3
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	1	456408-2	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

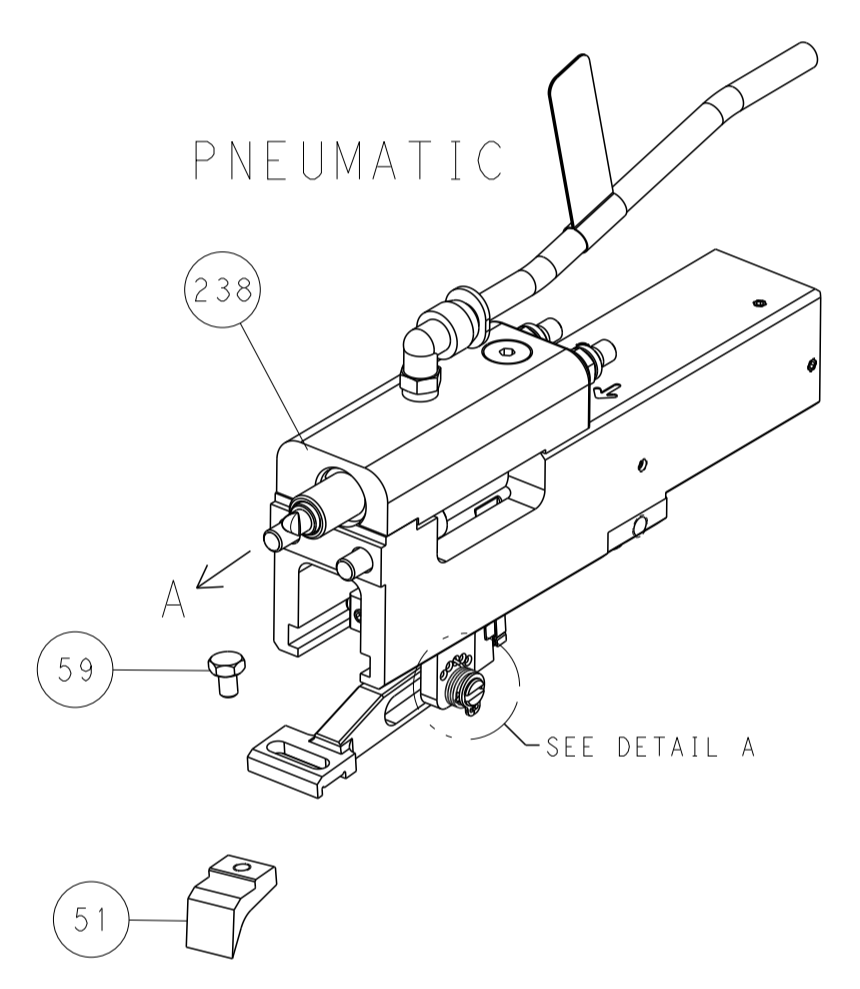
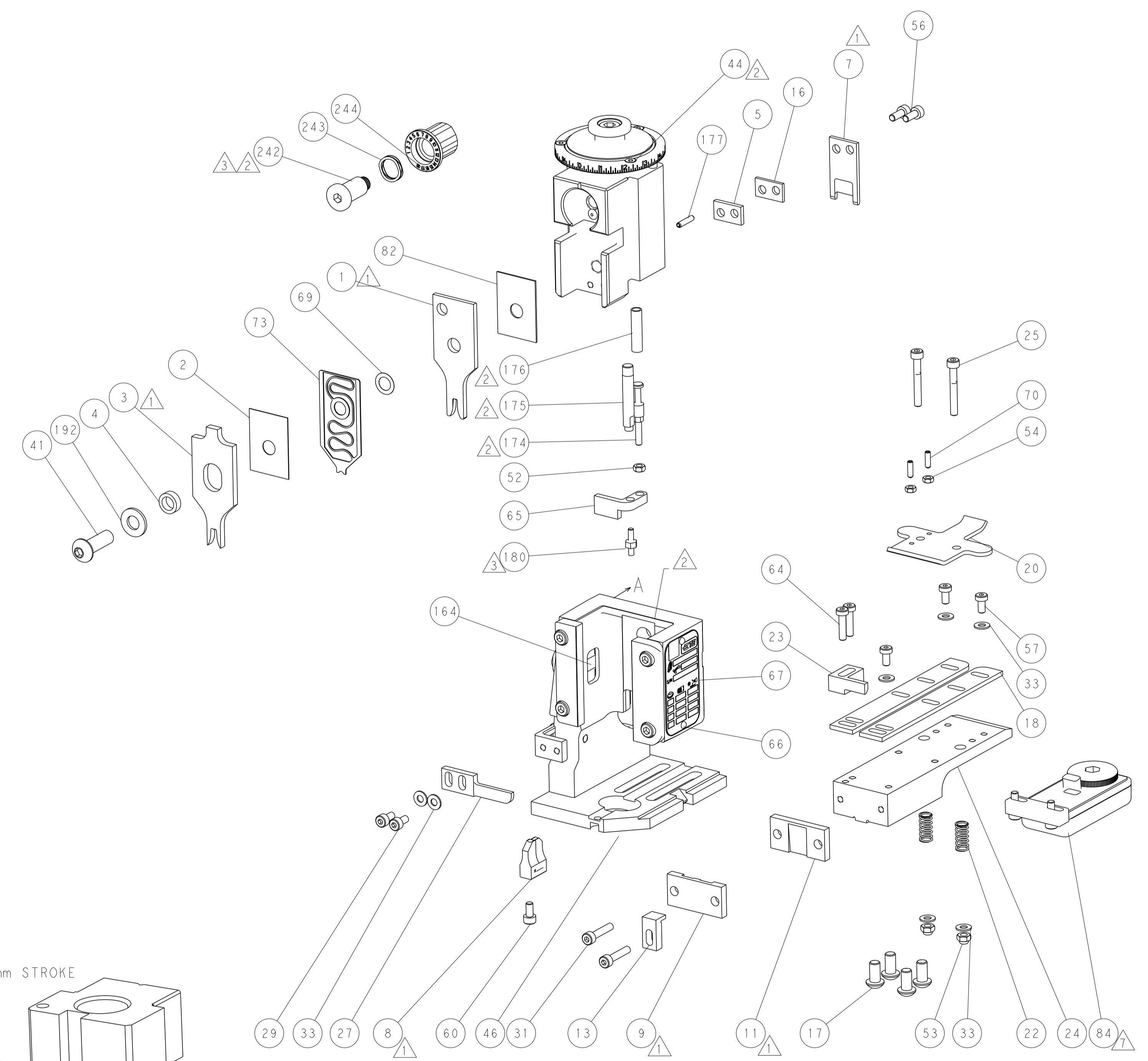
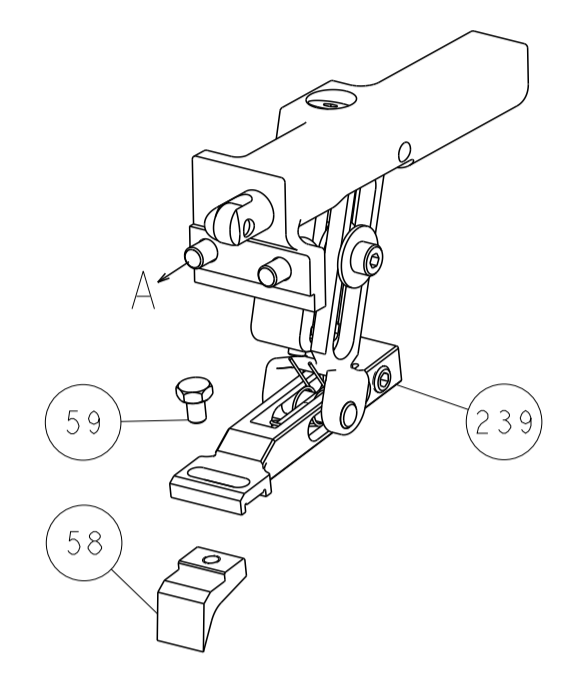
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG 24JUN2016		TE Connectivity Harrisburg, PA 17105-3608	
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MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
						A1 00779 C=2150685	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1		SHEET 1 OF 4 REV C	

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



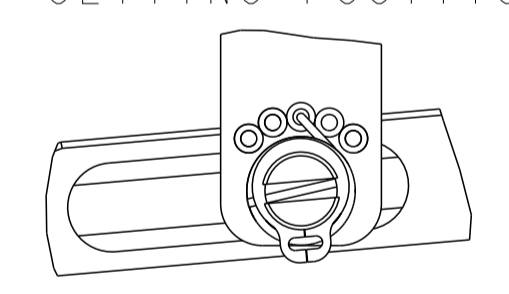
RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



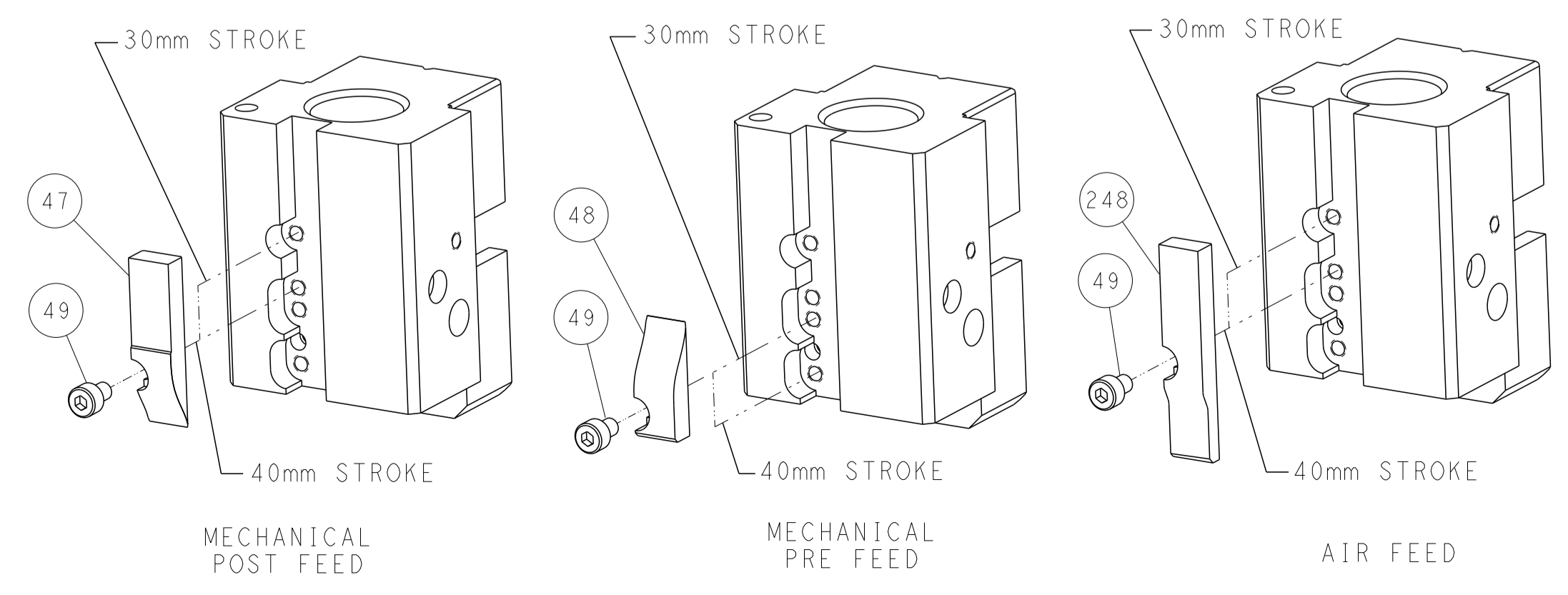
PNEUMATIC

FEED SPRING  
SETTING POSITION



DETAIL A

CAM POSITIONS

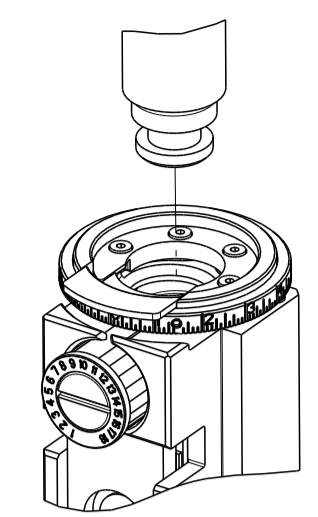


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 24JUN2016 CHK L. ZHANG 24JUN2016 APVD L. ZHANG 24JUN2016		NAME Ocean End Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150685		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:1		SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150685-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150685-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150685-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	4.06 mm [1.60]	F

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: NICHIFU TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.99-4.75 mm [1.57-.187 IN]	Ø2.67-3.56 mm [1.05-.140 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	NICHIFU TERMINAL	TE TERMINAL	NICHIFU TERMINAL
2303610-1	CSS 43925-F		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.79 +/- 0.05 [1.070 +/- .002]	4.8
16 AWG OR 1.50mm2	1.64 +/- 0.05 [1.065 +/- .002]	6.3
18 AWG OR 1.00mm2	1.49 +/- 0.05 [1.059 +/- .002]	7.9
20 AWG OR 0.50mm2	1.34 +/- 0.05 [1.053 +/- .002]	9.5



- 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 ITEMS 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.
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- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

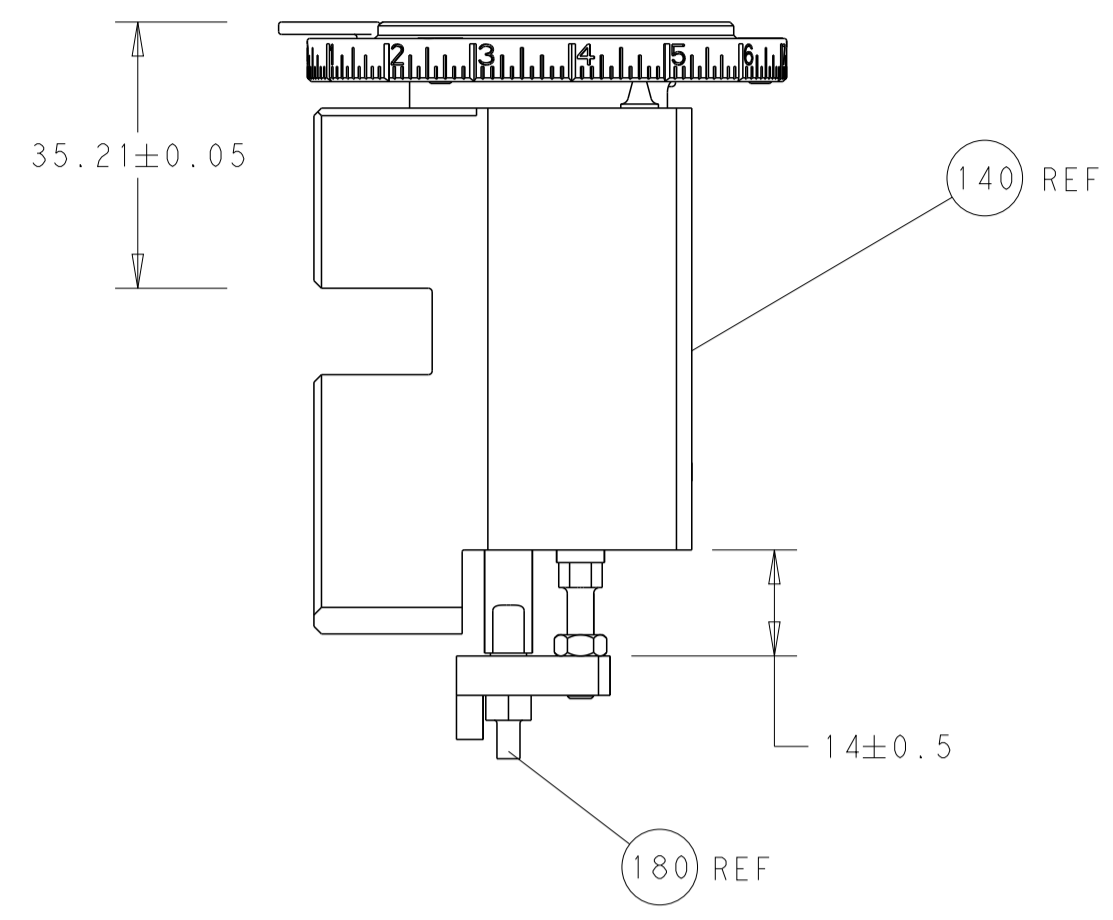
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

				REVISIONS		
P	LTN	DESCRIPTION	DATE	OWN	APPV	
-	-	SEE SHEET 1	-	-	-	-
-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	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	1-1976055-8	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
7	-	1	2119955-2	ASSY, LUBRICATOR, END FEED		84
-	1	1	455888-7	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	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	1901681-5	HOLDDOWN, TERMINAL		65
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16		64
-	1	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	-	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
-	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	1752371-5	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	3-240641-6	SPACER		16
-	1	1	1752360-1	SPACER, HOLD-DOWN		13
1	-	1	240644-1	PLATE, REAR SHEAR		11
-	-	-	-	-		10
1	-	1	690482-4	PLATE, FRONT SHEAR		9
1	1	1	3-1803060-6	ANVIL, COMBINATION, END FEED		8
1	-	1	1-2217206-1	BLADE, SLUG		7
-	-	-	-	-		6
-	1	1	240641-2	SPACER		5
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER		4
1	1	1	2-1803016-8	CRIMPER, INSULATION F		3
-	1	1	455888-3	SPACER, CRIMPER		2
1	1	1	456408-2	CRIMPER, WIRE PREMIUM		1
-	77	22	21	PART NO		ITEM NO
-	-	-	-	DESCRIPTION		

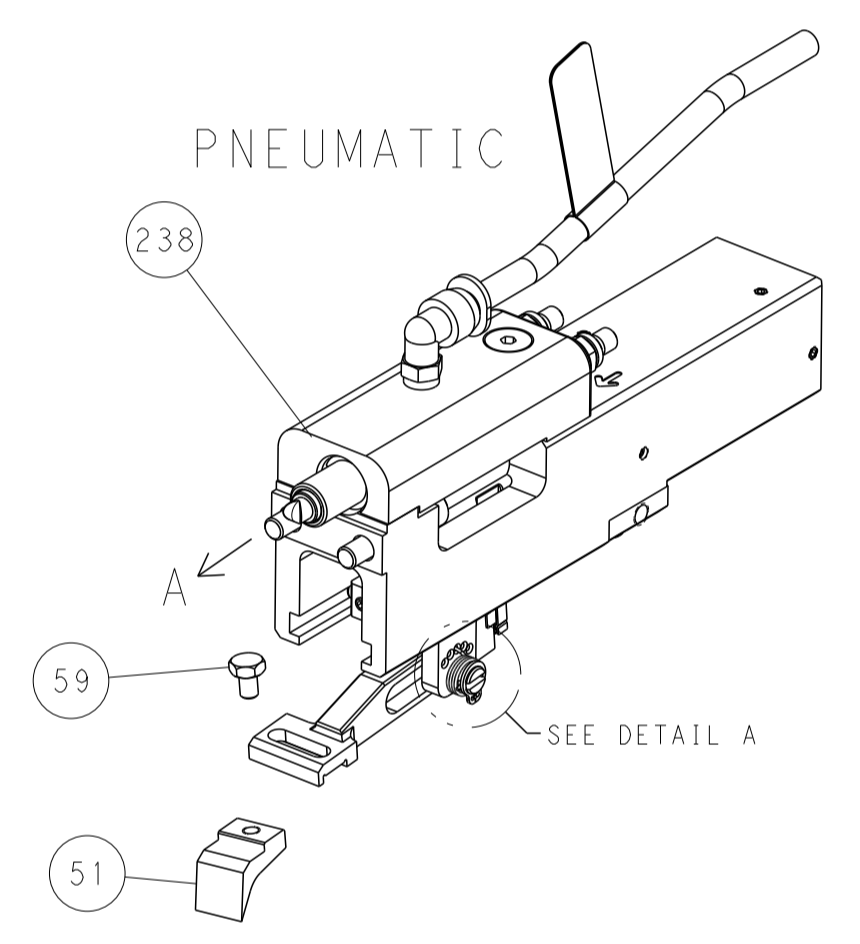
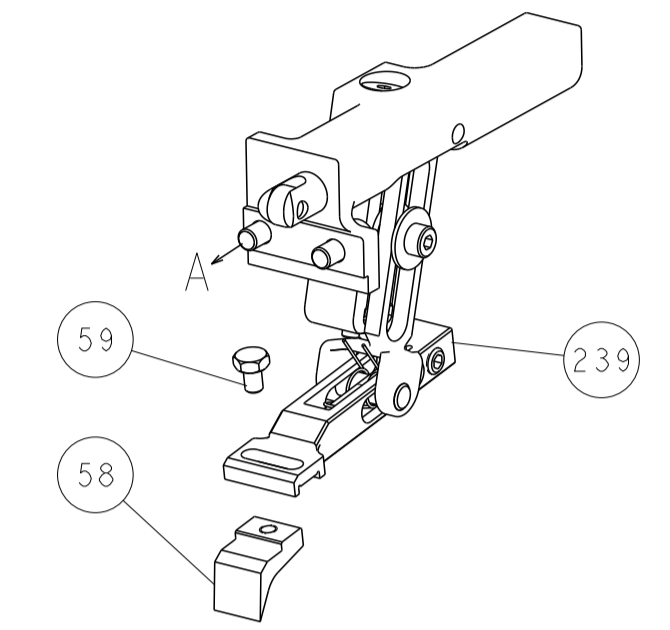
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: H. HUANG 24JUN2016 CHK: L. ZHANG 24JUN2016 APVD: L. ZHANG 24JUN2016	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150685 SCALE: 1:1 SHEET: 3 OF 4 REV: C
MATERIAL: .		FINISH: .		WEIGHT: .	

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

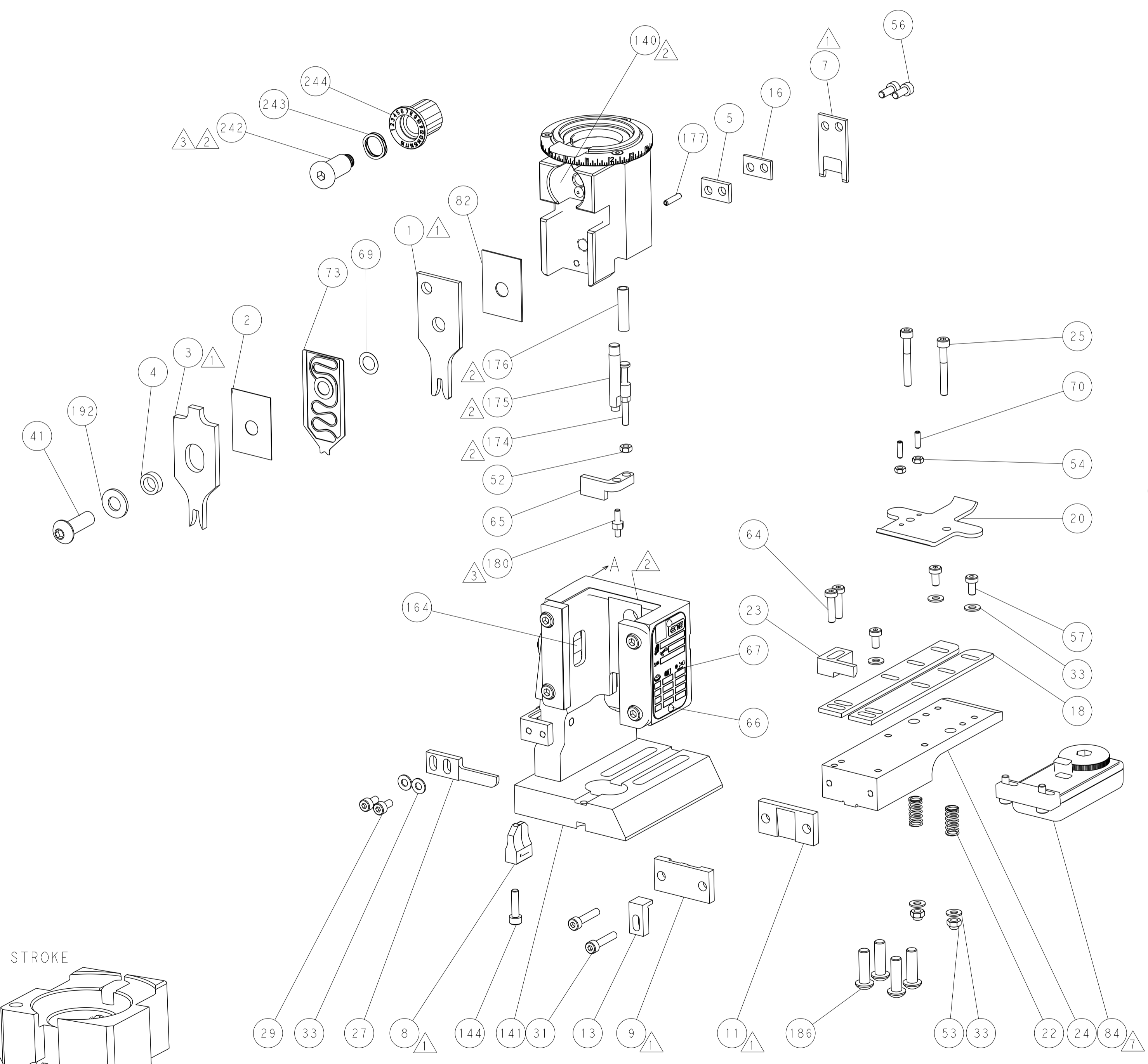
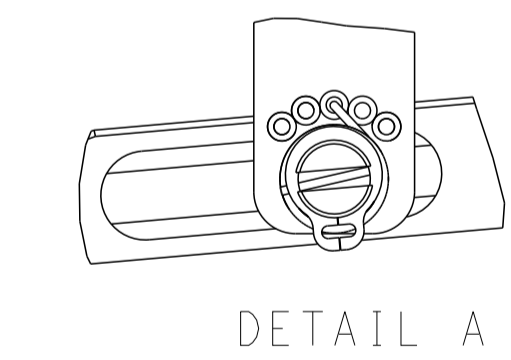


RAM AND HOLDDOWN SET-UP

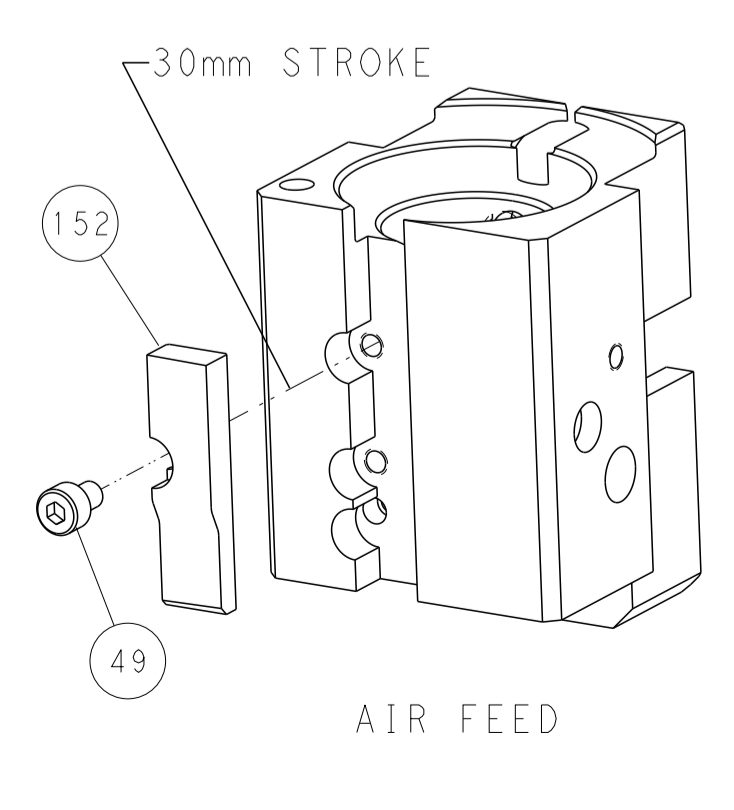
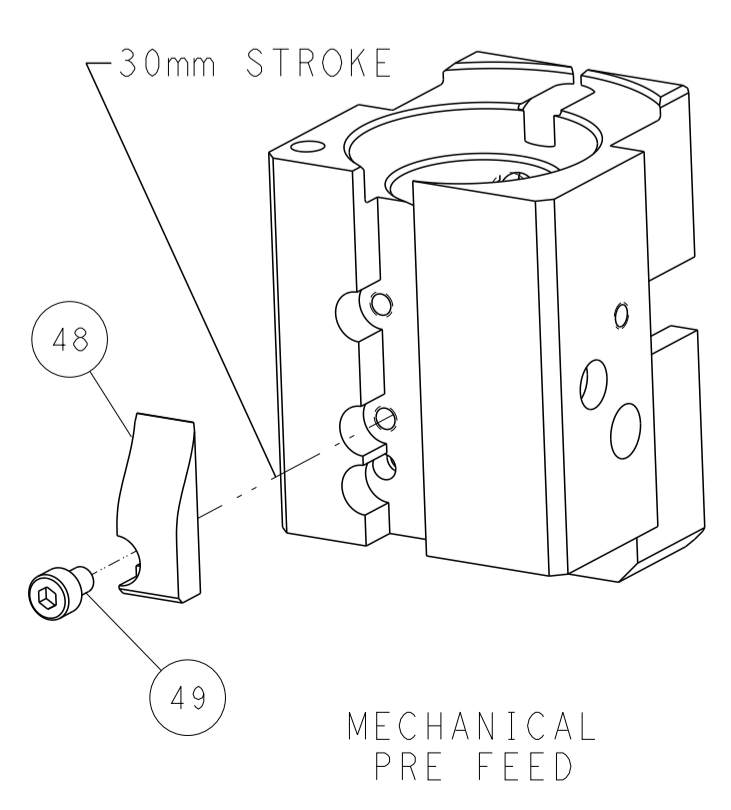
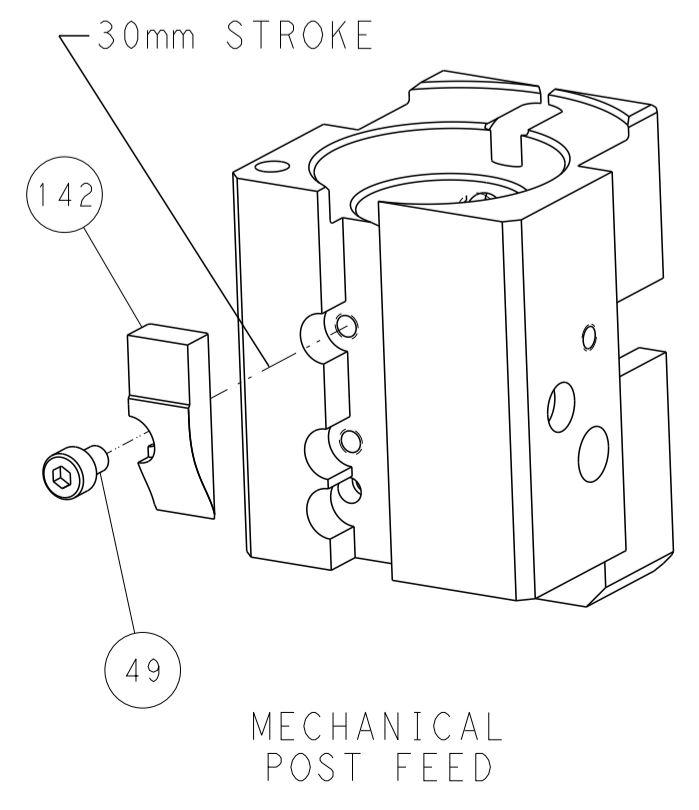
FEED TYPE  
MECHANICAL



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 K. HUANG 24JUN2016		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL							
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1	SHEET 4 OF 4	REV C	