

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150738-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150738-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150738-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150738-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150738-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.94-4.70 mm [.155-.185 IN]	∅1.10-1.98 mm [.043-.078 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42164-2	42164-3	42508-2	42508-3
63721-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.40 +/- 0.05 [.055 +/- .002]	5.0
22 AWG OR 0.35mm2	1.35 +/- 0.05 [.053 +/- .002]	5.5
24 AWG OR 0.22mm2	1.27 +/- 0.05 [.050 +/- .002]	6.4

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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.

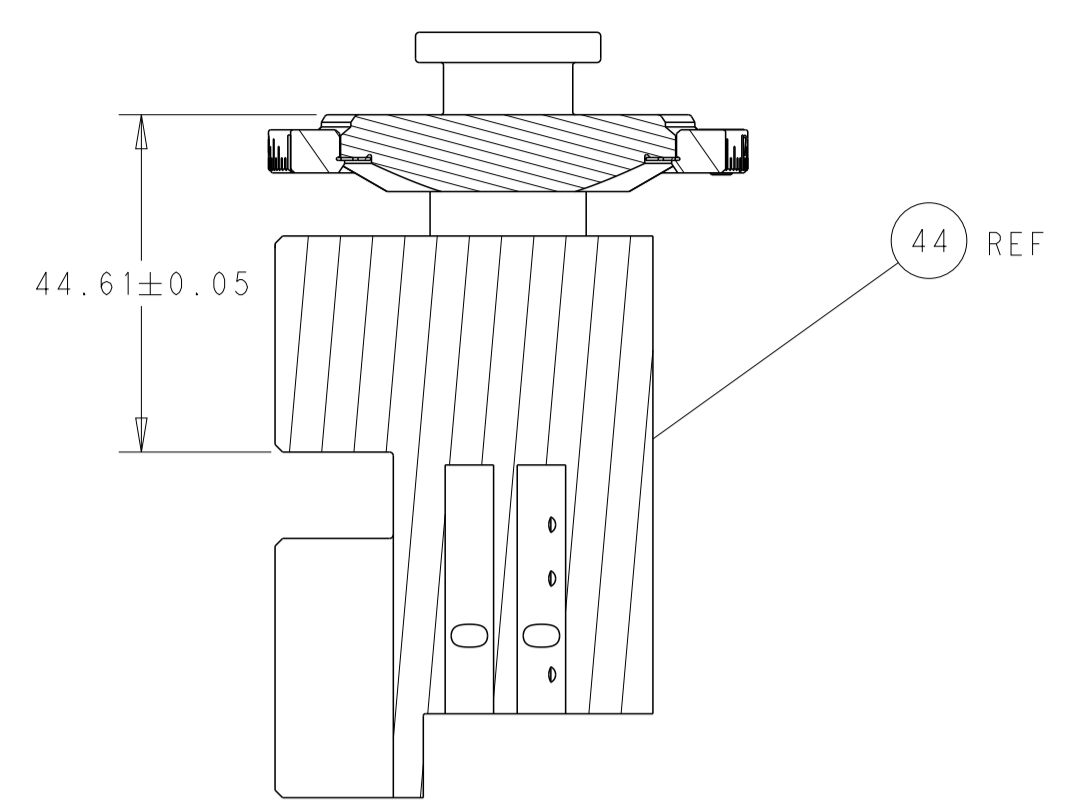
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-19-001374	28JAN2019	FZ	KZ
		C		ECR-20-010470	23JUL2020	JWC	RK
		D		ECR-21-117000	12OCT2021	JWC	RK
		D1		ECR-22-154061	28SEP2022	ROY	GWB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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
-	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	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1	1	2119791-9	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	-	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	1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1901695-2	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	2	2	1	1803426-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	6-240641-0	SPACER	5
-	1	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1803187-6	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	2-1803224-4	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

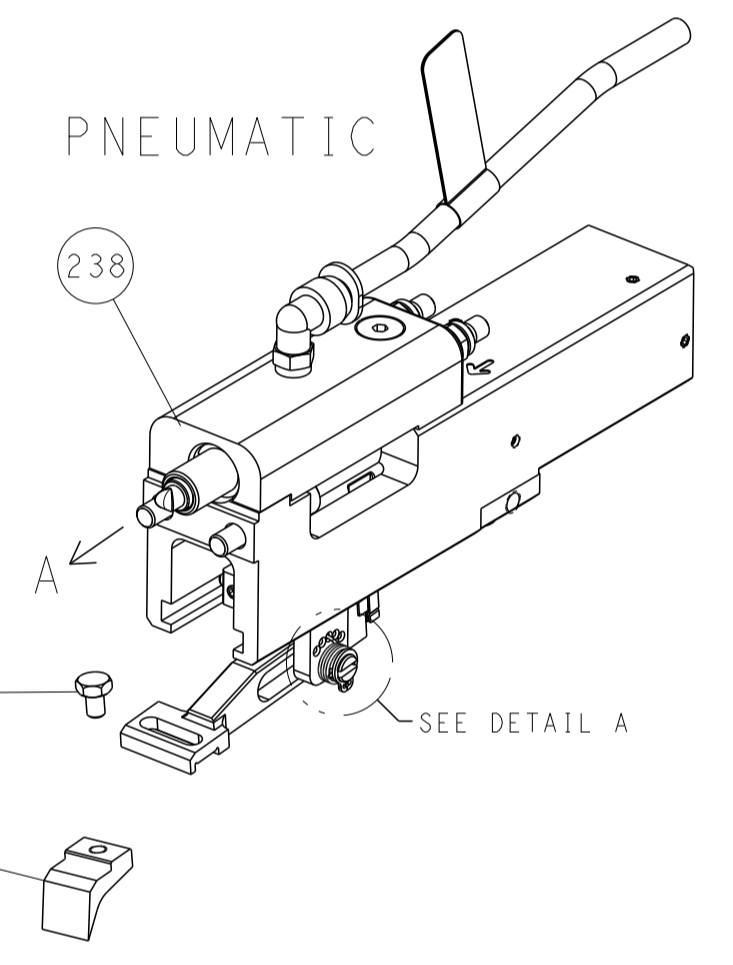
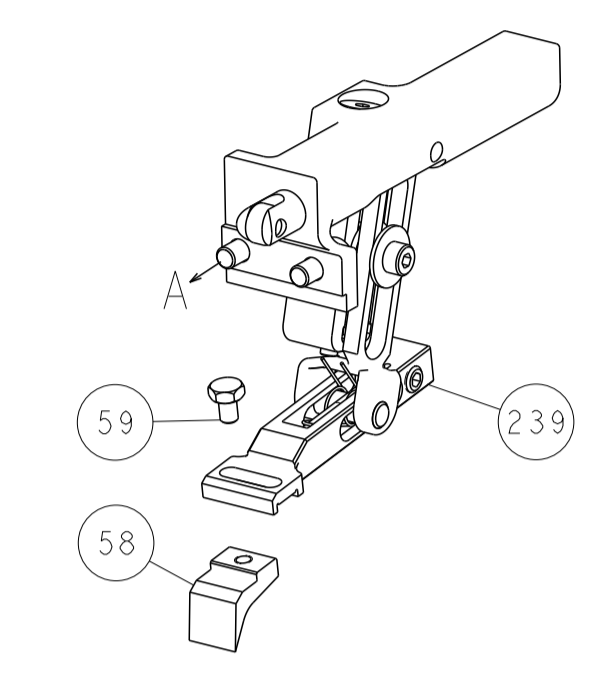
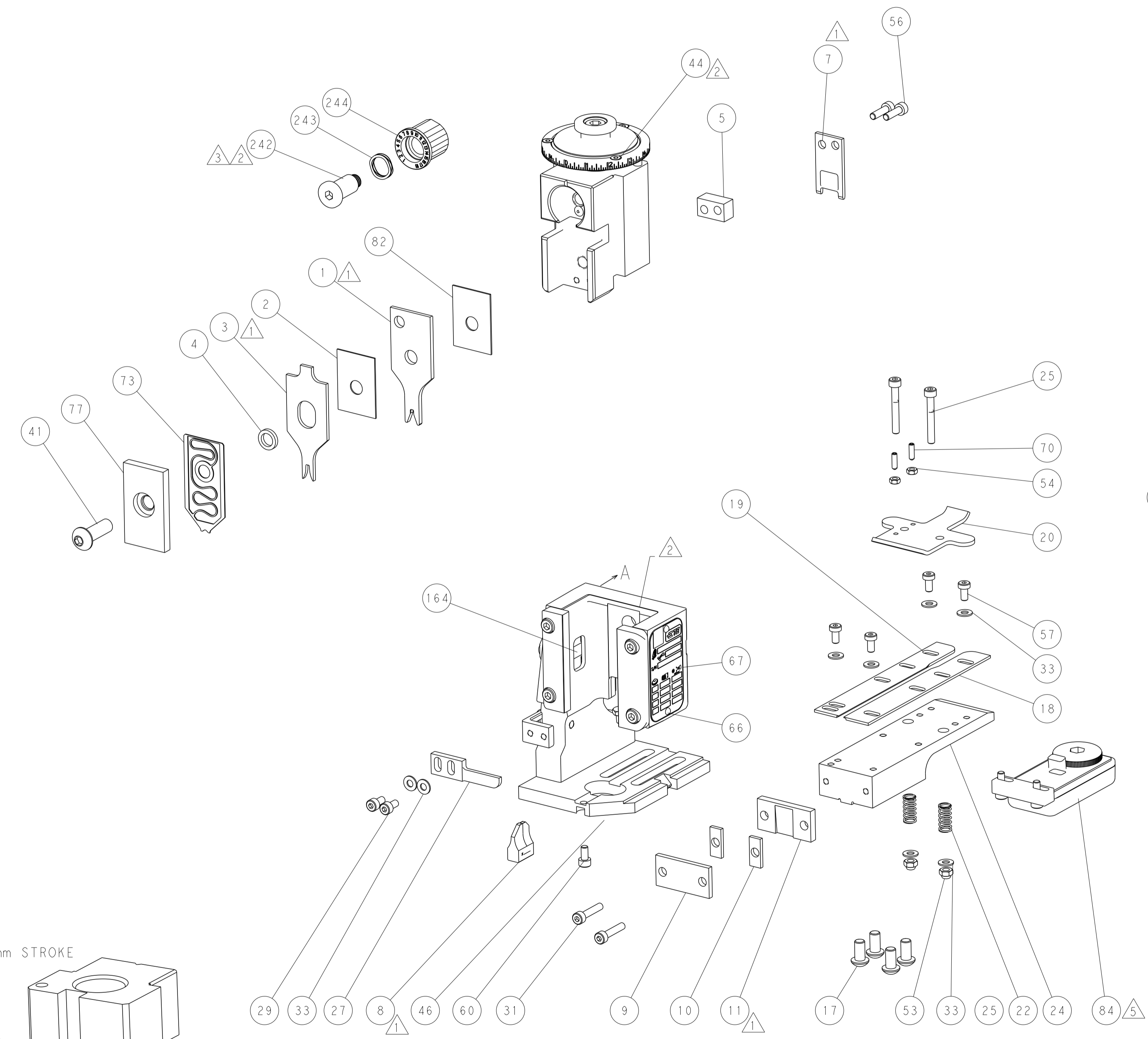
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC	±													
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													

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

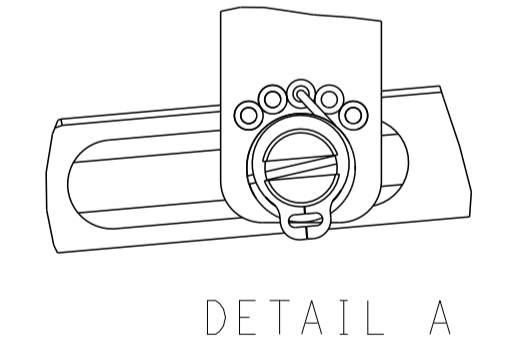


RAM SET-UP

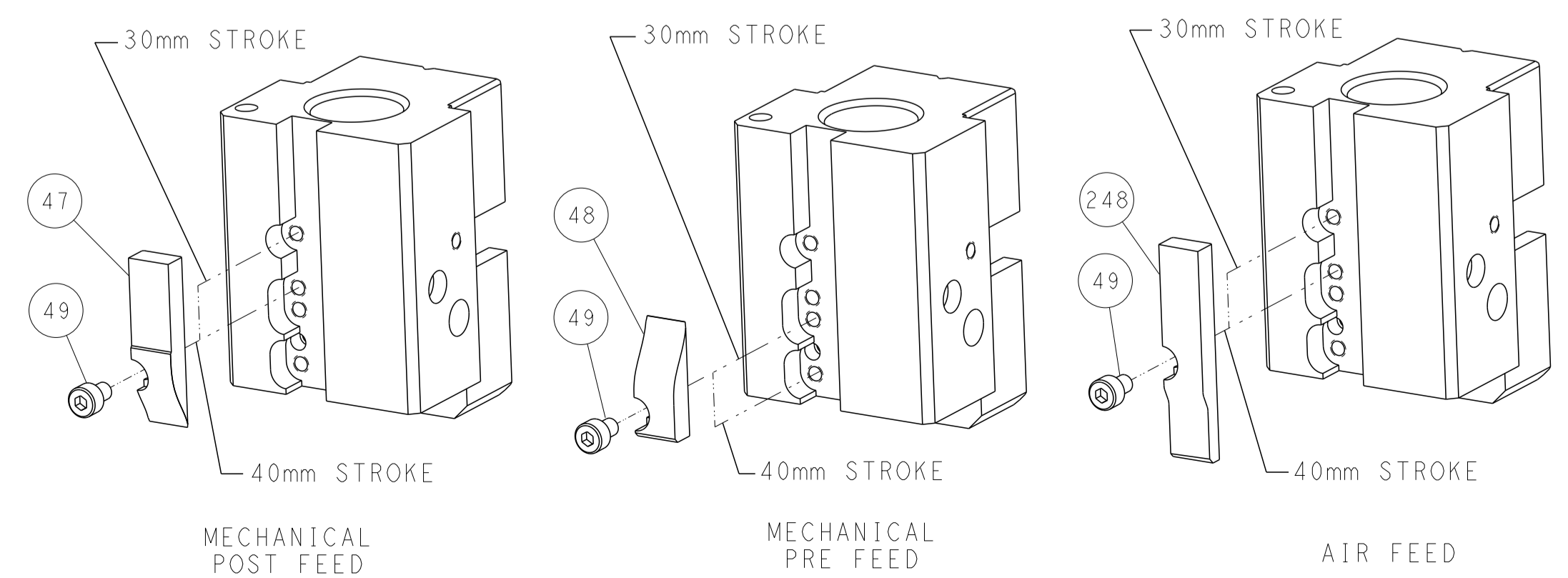
FEED TYPE MECHANICAL



FEED SPRING
SETTING POSITION



CAM POSITIONS

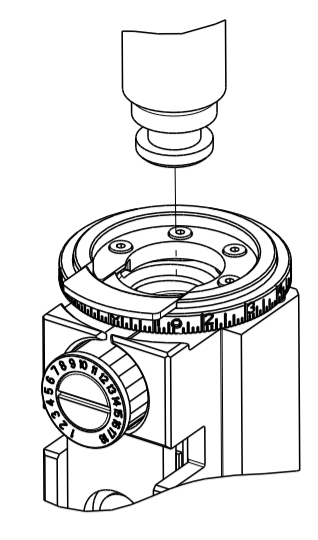


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN J. HOU 26SEP2016 CHK L. ZHANG 26SEP2016 APVD L. ZHANG 26SEP2016 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150738 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV D1	
MATERIAL:		WEIGHT:		TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150738-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150738-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150738-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	2.54 mm (.100)	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.94-4.70 mm (.155-.185 IN)	1.10-1.98 mm (.043-.078 IN)

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42164-2	42164-3	42508-2	42508-3
63721-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.40 +/- 0.05 [0.055 +/- .002]	5.0
22 AWG OR 0.35mm2	1.35 +/- 0.05 [0.053 +/- .002]	5.5
24 AWG OR 0.22mm2	1.27 +/- 0.05 [0.050 +/- .002]	6.4



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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	REV	DATE	BY	CHK	APPV
A	66	-				

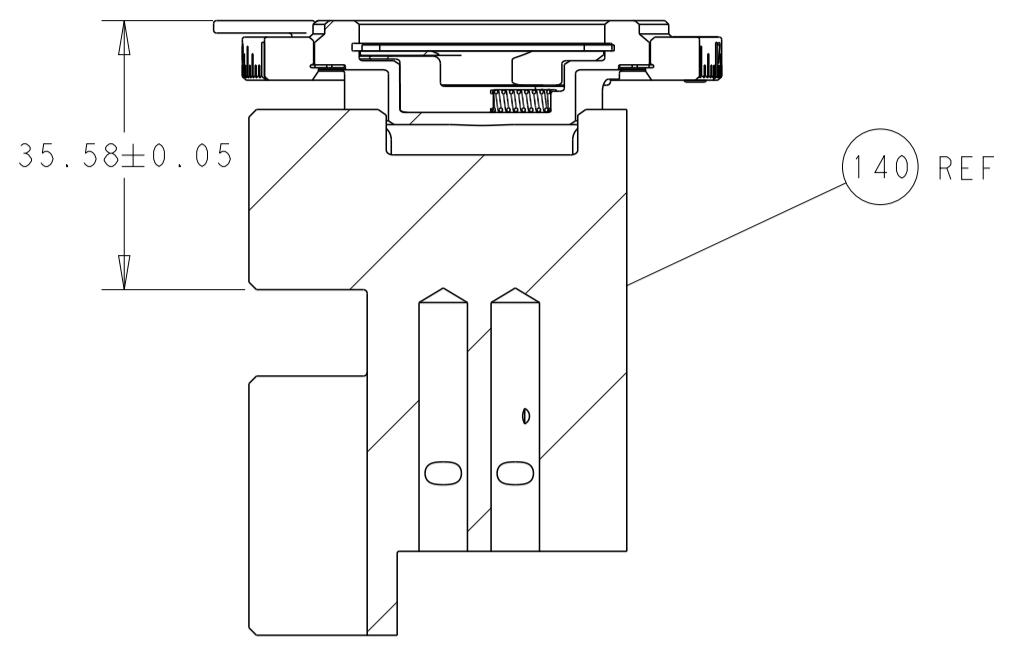
REV	DATE	DESCRIPTION	DATE	BY	CHK	APPV
-	1 1	2119082-4				
-	1 1	2079764-1				
-	1 1	2119083-1				
-	- 1	2119580-1				
-	1 -	2844940-3				
-	4 4	2079383-9				
-	REF REF	994970-2				
-	1 1	2119641-2				
-	1 1	2168083-8				
-	- 1	2119653-2				
-	1 1	2119655-6				
-	1 1	1803518-1				
-	1 1	2119955-2				
-	1 1	455888-7				
-	1 1	1803203-1				
-	1 1	2119791-9				
-	1 1	1803607-4				
-	2 2	2-18032-2				
-	1 1	2119740-1				
-	2 2	2168078-1				
-	2 2	5-18022-5				
-	1 1	2063961-1				
-	4 4	2168400-4				
-	2 2	2-2168083-5				
-	2 2	5018030-1				
-	2 2	986965-8				
-	1 1	2063961-1				
-	1 2	18023-9				
-	- 1	2119652-1				
-	1 1	1803602-1				
-	8 8	1-18028-2				
-	2 2	2168083-9				
-	2 2	2168083-2				
-	1 1	240639-1				
-	2 2	1-2168083-5				
-	1 1	1752371-5				
-	2 2	2-22281-3				
-	1 1	1803292-4				
-	1 1	1901696-2				
-	1 1	1901695-2				
-	1 1	240644-1				
-	2 2	1-240645-6				
-	1 1	240642-1				
-	1 1 1	1803426-2				
-	1 1	9-240651-0				
-	- -	-				
-	1 1	6-240641-0				
-	1 1	5-238011-5				
-	1 1 1	1-1803187-6				
-	1 1	455888-6				
-	1 1 1	2-1803224-4				

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77-22-21			

DATE: 26SEP2016	CHK: J. HOU	DATE: 26SEP2016	APPV: L. ZHANG
DATE: 26SEP2016	CHK: L. ZHANG	DATE: 26SEP2016	APPV: L. ZHANG

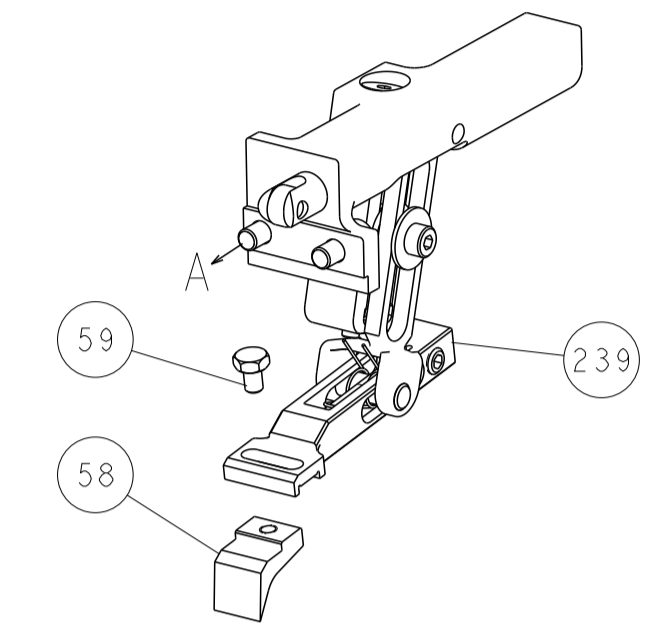
TE Connectivity	Harrisburg, PA 17105-3608
Ocean End Feed Applicator	
SIZE: A1	CAGE CODE: 00779
DRAWING NO: C=2150738	SCALE: 1:1
SHEET: 3	OF: 4
REV: 1	

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

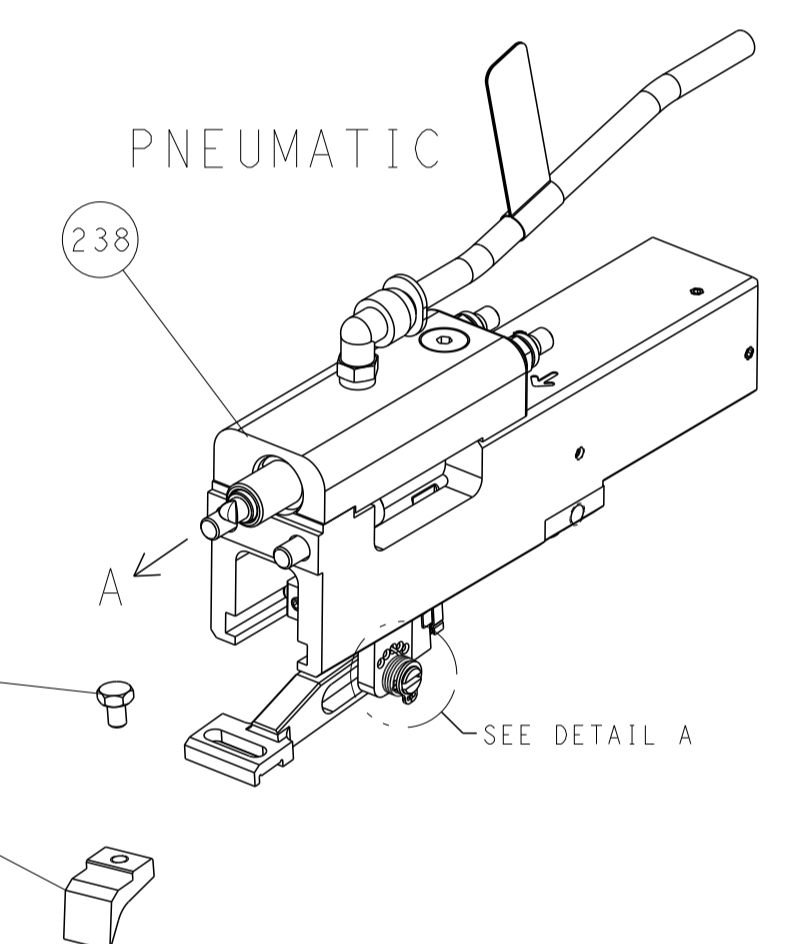


RAM SET-UP

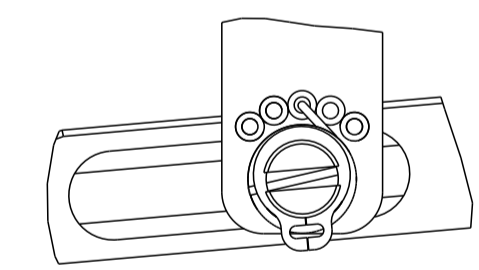
FEED TYPE
MECHANICAL



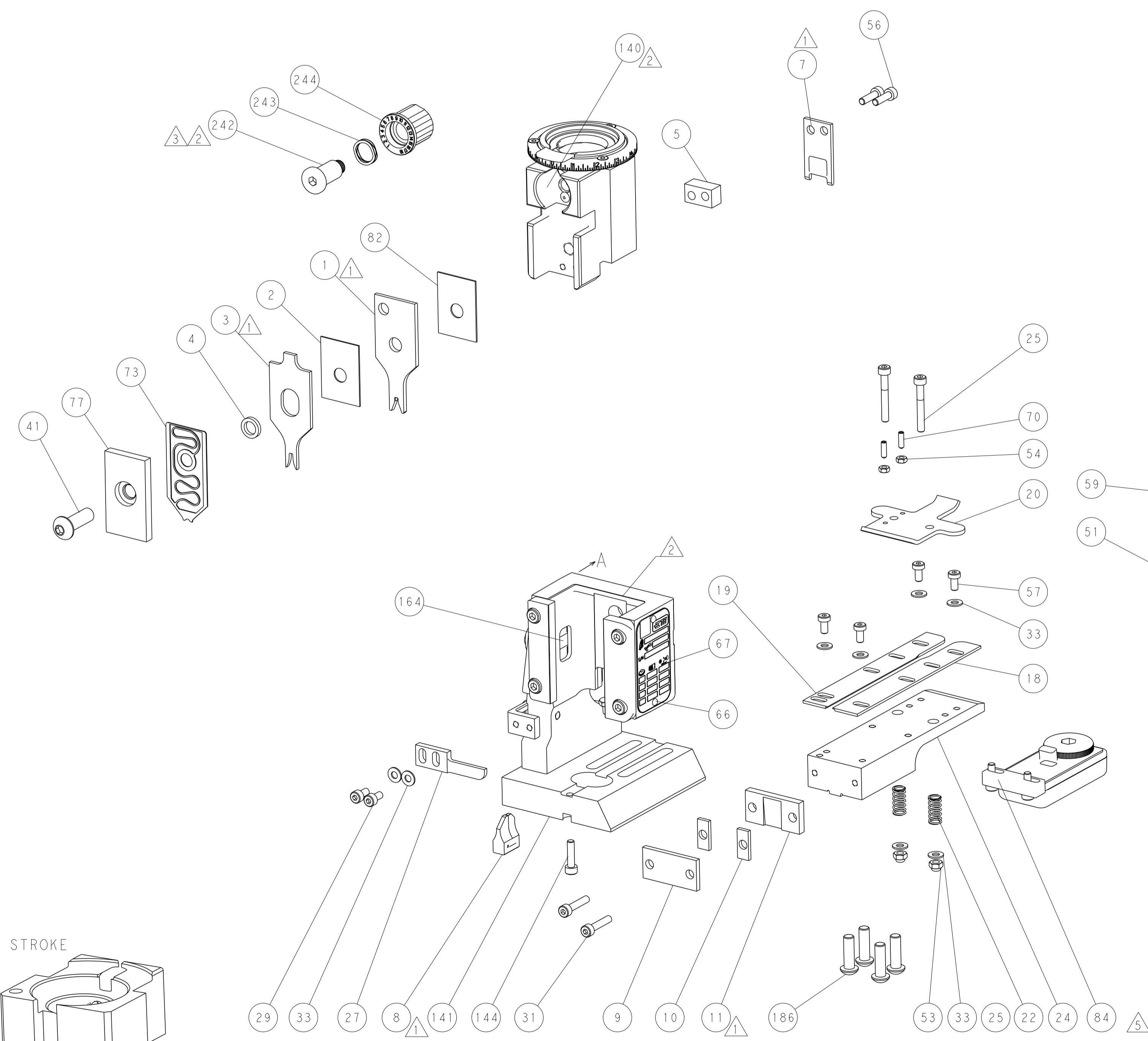
PNEUMATIC



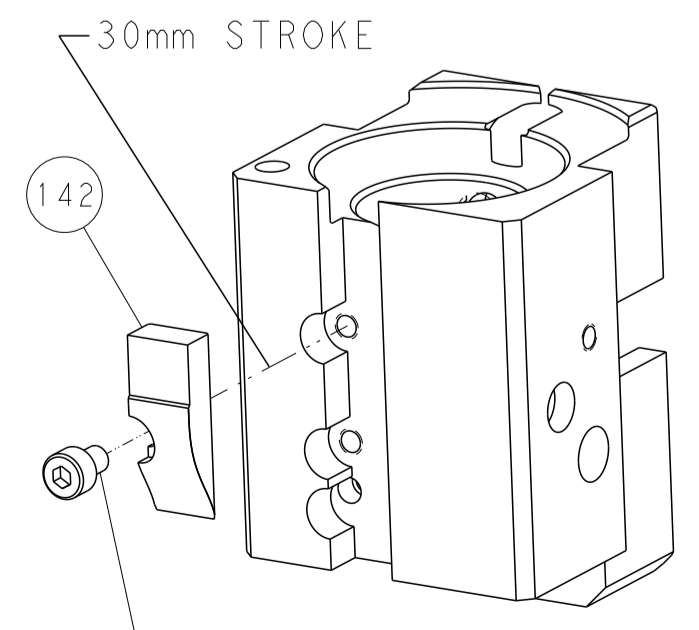
FEED SPRING
SETTING POSITION



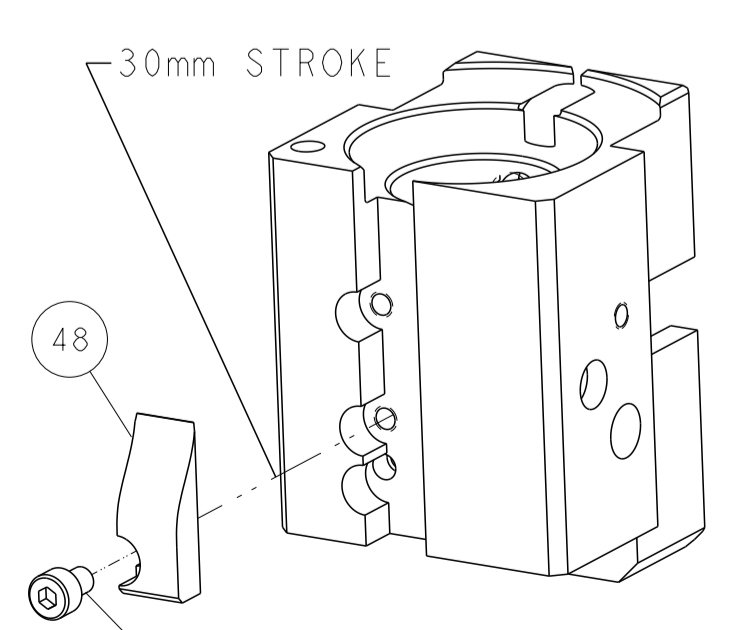
DETAIL A



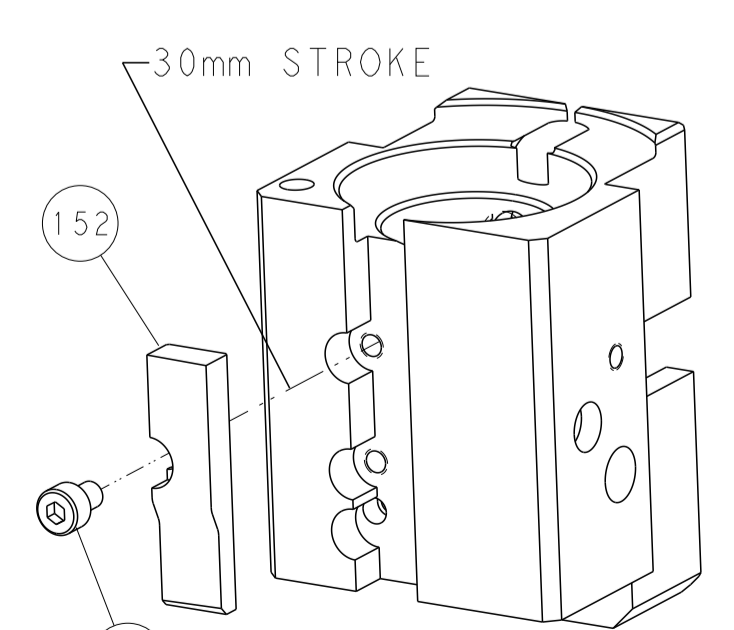
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 26SEP2016		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	©=2150738	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV D1			