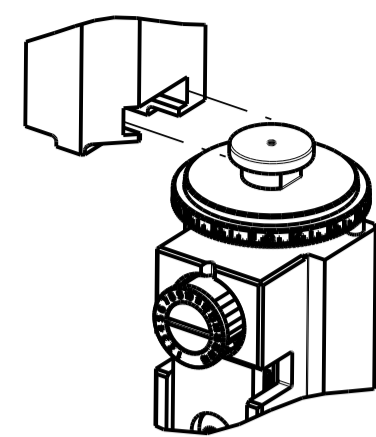


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150770-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150770-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150770-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .180 DIA. SHUR PLUG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.56-4.36 mm [.140-.172 IN]		Ø3.05-4.45 mm [.120-.175 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2017		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60660-1	60660-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.98+/-0.05 [.078+/-0.002]	4.9
16 AWG	1.75+/-0.05 [.069+/-0.002]	7.3
18 AWG	1.60+/-0.05 [.063+/-0.002]	9.0

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

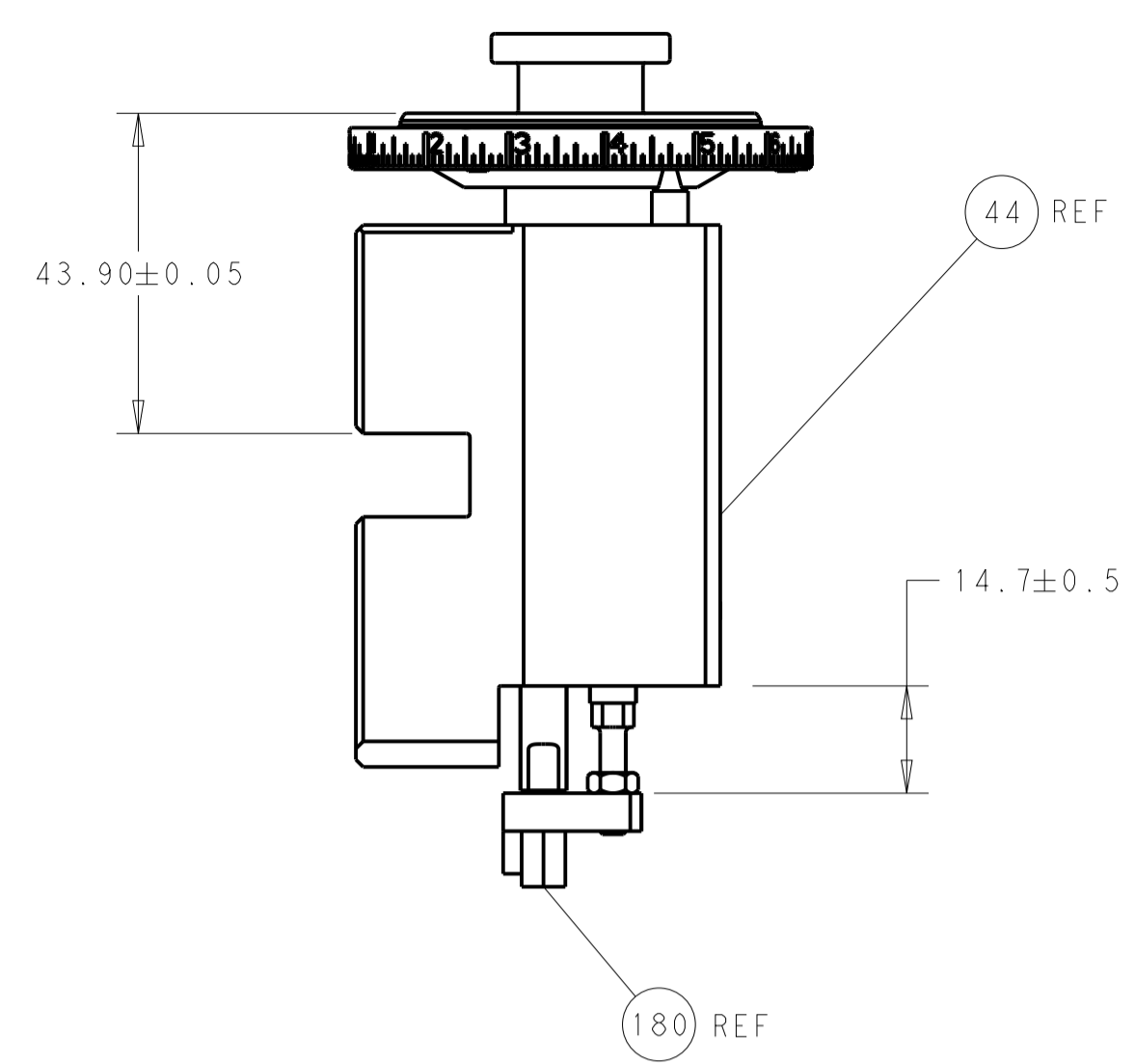
LOC	DIST	REVISIONS					
		REV	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	C		ECR-17-012104	18AUG2017	JH	GB
		D		ECR-18-015909	08OCT2018	TB	TE
		E		ECR-19-002482	15FEB2019	FL	CT
		F		ECR-21-002179	25FEB2021	FZ	TE

-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	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	1-1752354-5	STANDOFF,HOLD-DOWN	180	
-	1	1	6-9931111-6	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-6	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	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	1	1-2063961-0	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	
-	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	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	8-690482-7	PLATE, FRONT SHEAR	9	
	1	2	1	7-1803059-4	ANVIL, COMBINATION, END FEED	8
	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	1-240641-5	SPACER	5
-	1	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4
	1	2	1	4-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-5	SPACER, CRIMPER	2
	1	2	1	2-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

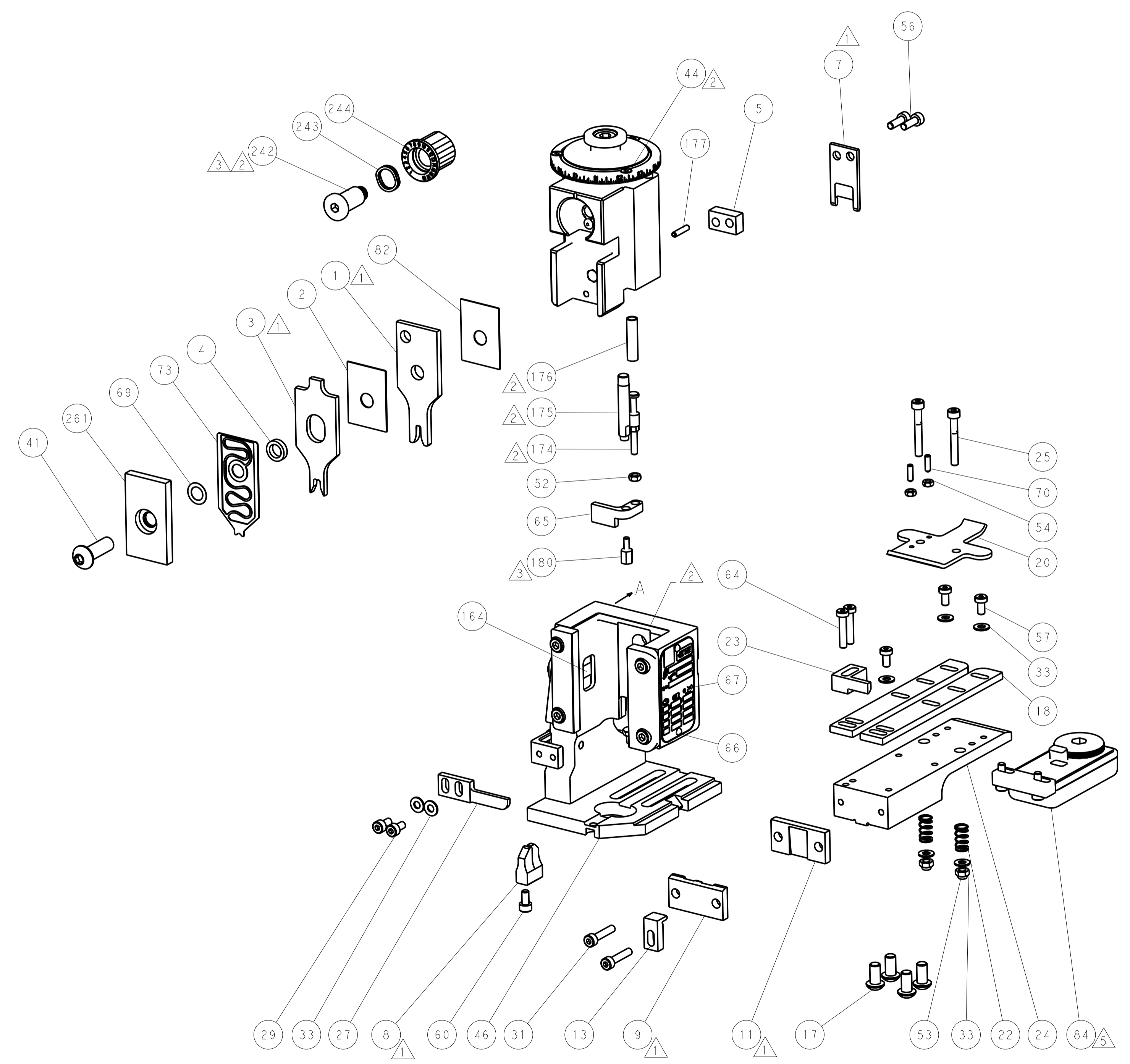
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		WEIGHT	
MATERIAL				Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 OF 4 REV F

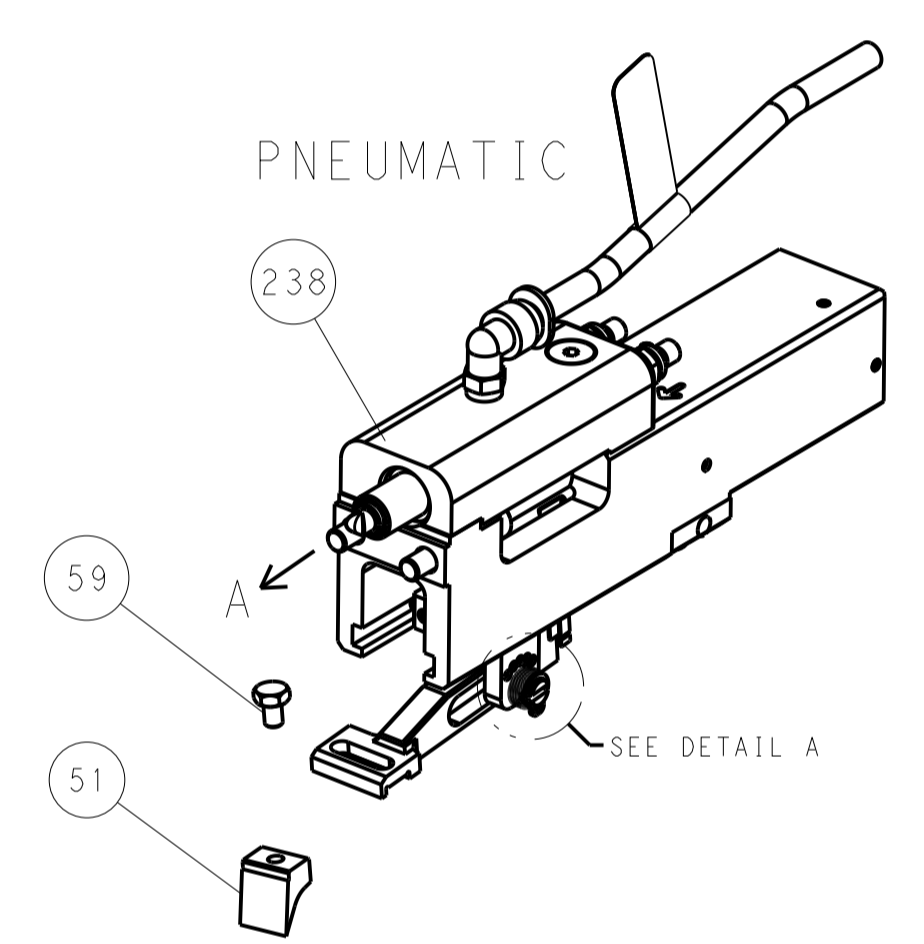
LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			



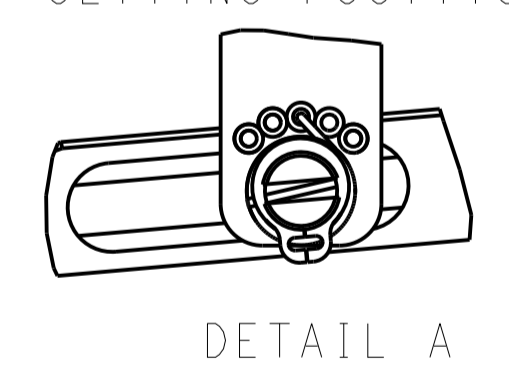
RAM AND HOLDDOWN SET-UP



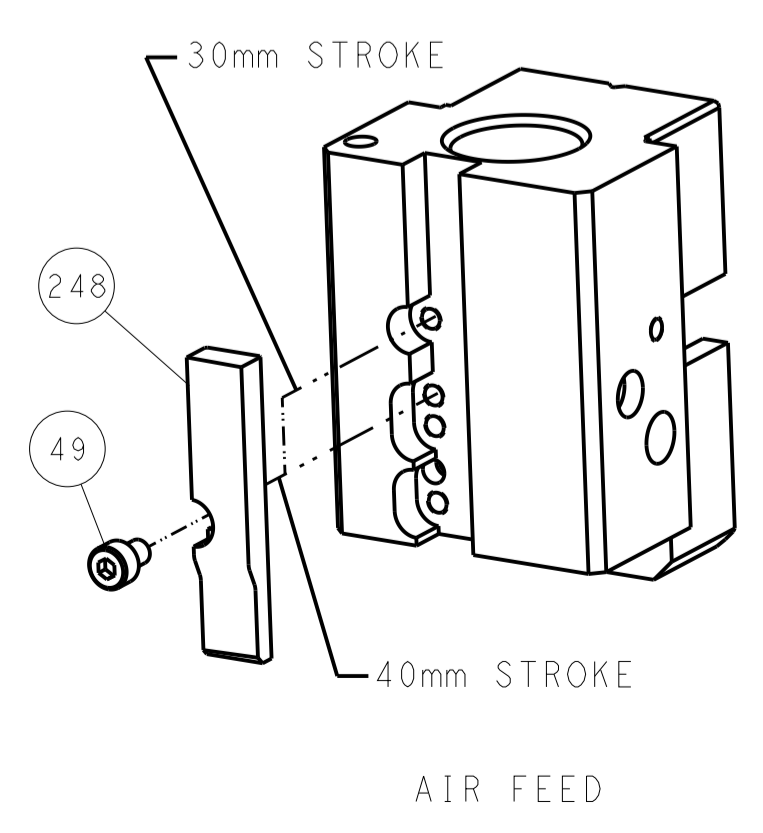
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

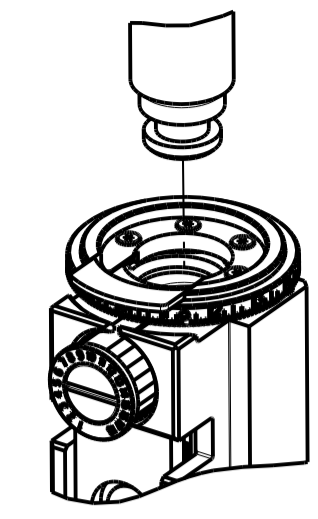


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 23JAN2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD T. ELBIN 23JAN2017		NAME	
				PRODUCT SPEC		Ocean End Feed Applier	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2150770	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:1		SHEET 2 OF 4 REV F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150770-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150770-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .180 DIA. SHUR PLUG			
WIRE STRIP LENGTH 3.56-4.36 mm [.140-.172 IN]		INSULATION DIAMETER RANGE Ø3.05-4.45 mm [1.20-.175 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2017			
TERMINALS APPLIED			
TE TERMINAL 60660-1	TE TERMINAL 60660-2	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.98+/-0.05 [.078+/-0.002]	4.9
16 AWG	1.75+/-0.05 [.069+/-0.002]	7.3
18 AWG	1.60+/-0.05 [.063+/-0.002]	9.0



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

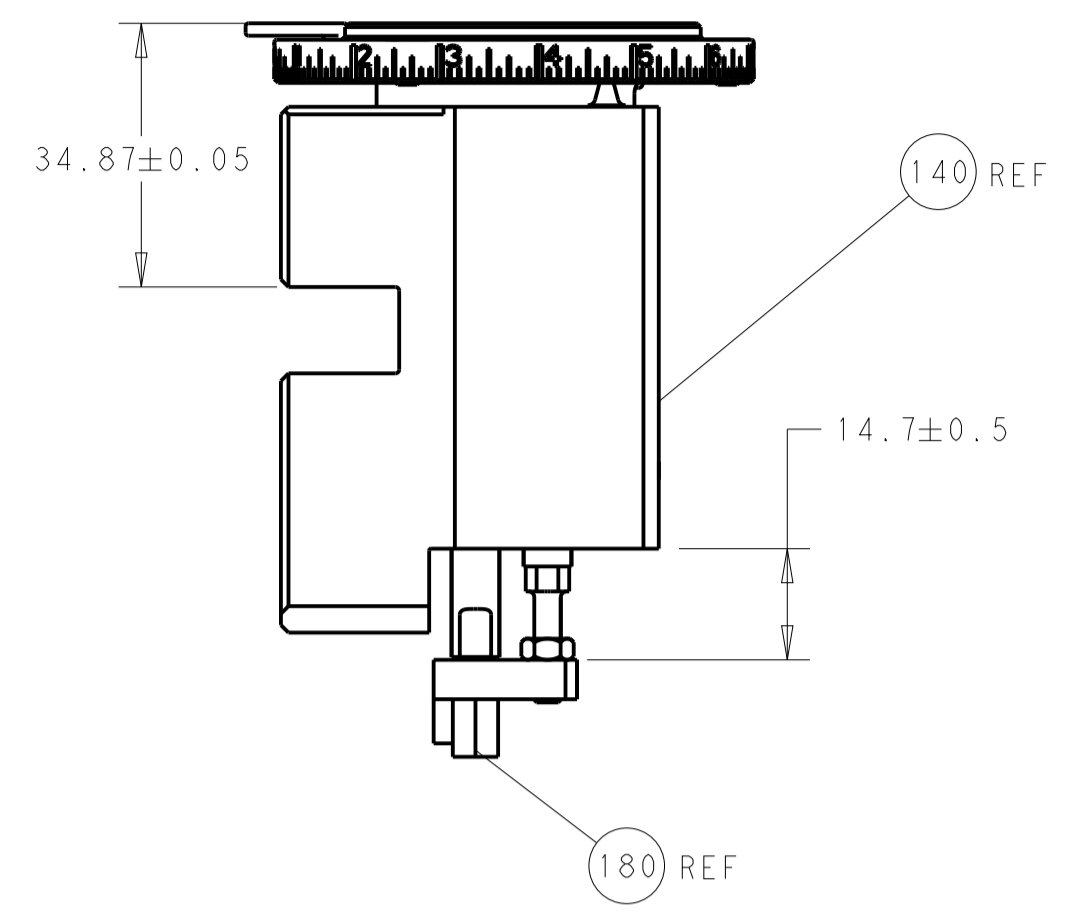
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
		REV	DATE	BY	APPD
A	66	-	SEE SHEET 1	-	-

-	1	1803203-1	BLOCK, FRONT DEPRESSOR	261
-	1	2119082-3	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
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	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	455888-4	SPACER, CRIMPER	82
-	1	2119791-6	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
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1-2063961-0	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
-	7	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
-	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	8-690482-7	PLATE, FRONT SHEAR	9
-	1	7-1803059-4	ANVIL, COMBINATION, END FEED	8
-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	1-240641-5	SPACER	5
-	1	6-238011-9	BLOCK, CRIMPER SPACER	4
-	1	4-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
-	1	2-456408-8	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

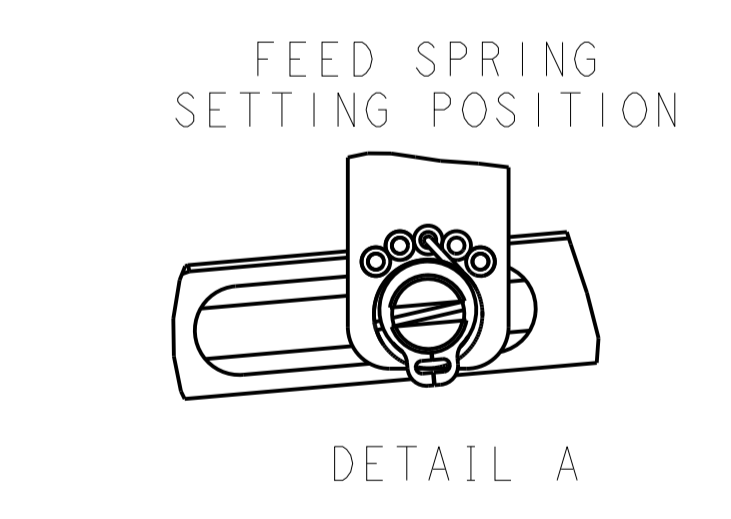
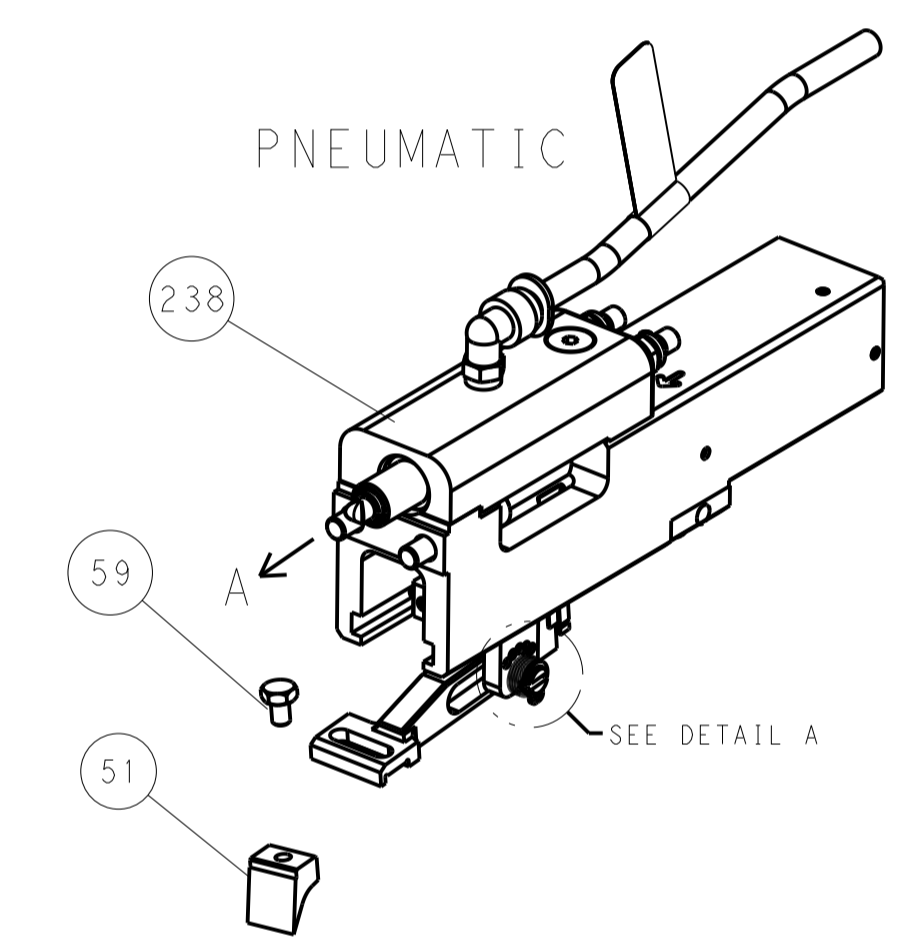
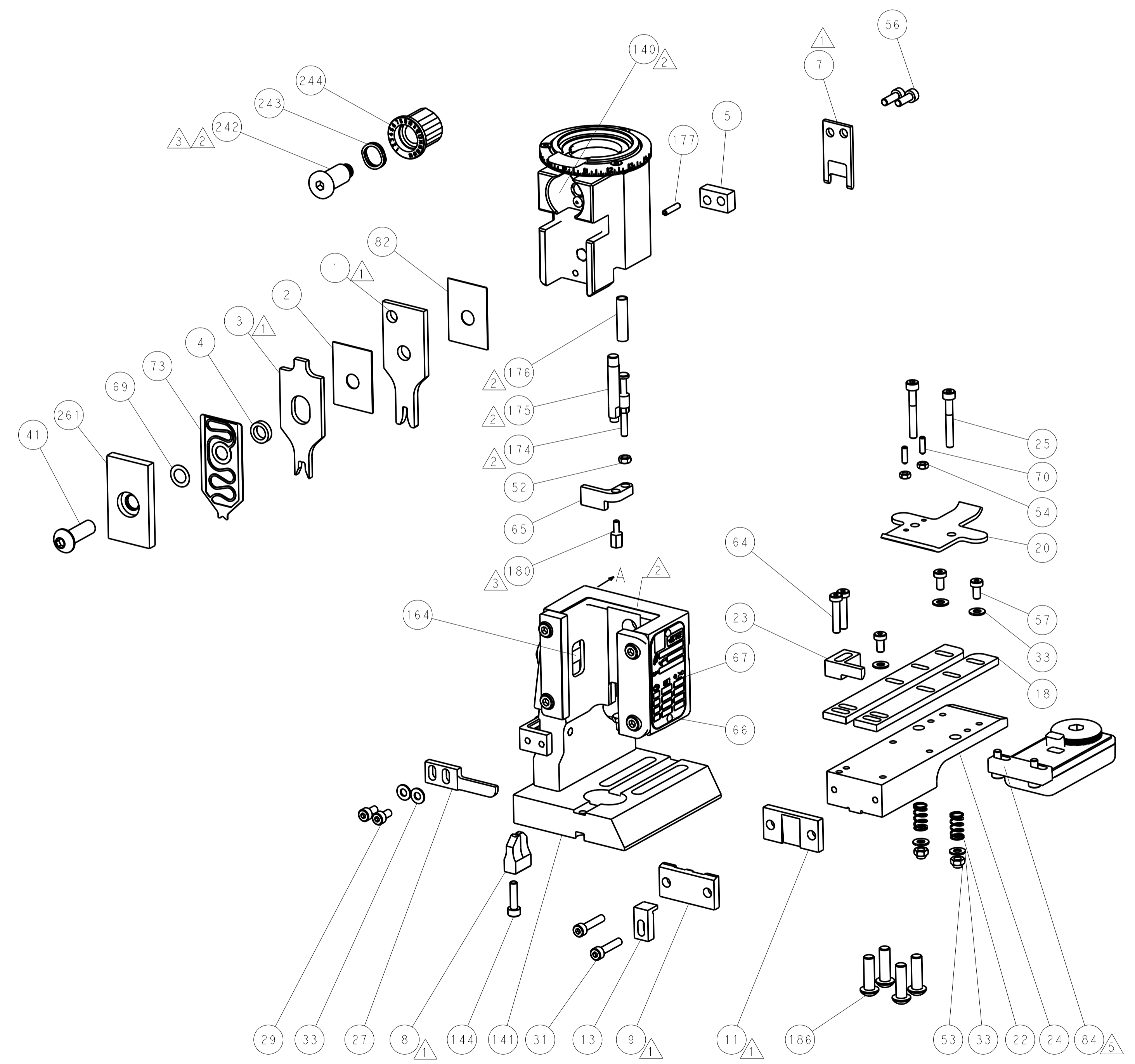
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 23JAN2017		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: T. ELBIN 23JAN2017		NAME: Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		APPD: T. ELBIN 23JAN2017		PRODUCT SPEC: -	
4 PLC ±		5 PLC ±		APPLICATION SPEC: -		SIZE: A1	
ANGLES: -		FINISH: -		WEIGHT: -		CAGE CODE: 00779	
MATERIAL: -		SCALE: 1:1		DRAWING NO: C=2150770		SHEET 3 OF 4	
Customer Accessible Production Drawing		SCALE: 1:1		DRAWING NO: C=2150770		REV: F	

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

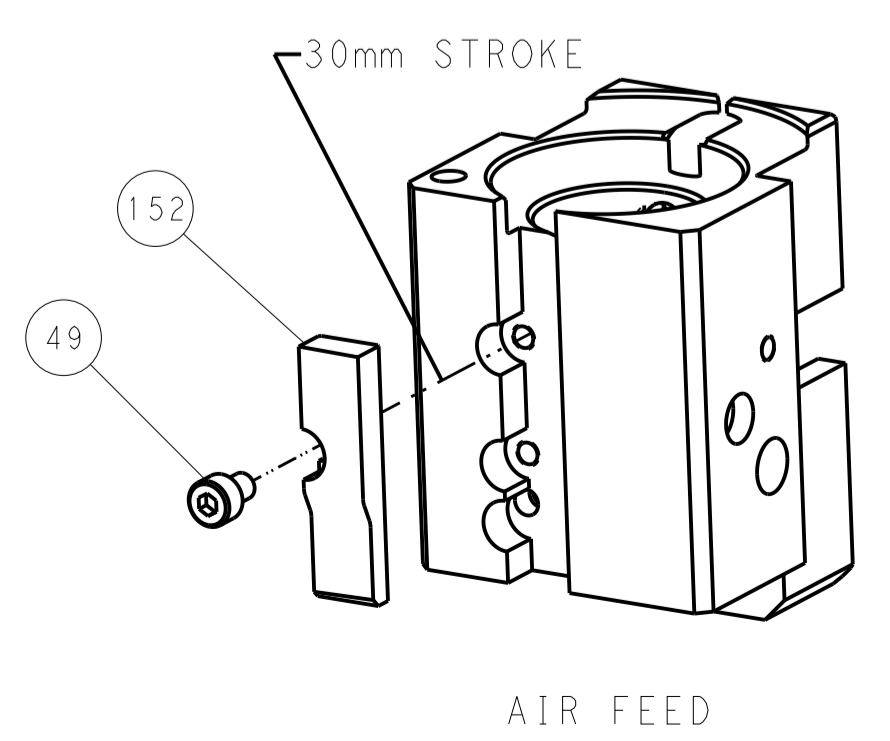


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



AIR FEED

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2017. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND ORGANIZATION FOR WHICH IT WAS PREPARED. IT IS TO BE DESTROYED OR RECYCLED UPON THE COMPLETION OF THE PROJECT.</small>		DWN: B. WEAVER 23JAN2017 CHK: T. ELBIN 23JAN2017 APVD: T. ELBIN 23JAN2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	NAME: Ocean End Feed Applier SIZE: A CAGE CODE: 00779 DRAWING NO: 2150770 SHEET: 4 OF 4 REV: F
MATERIAL: FINISH:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: