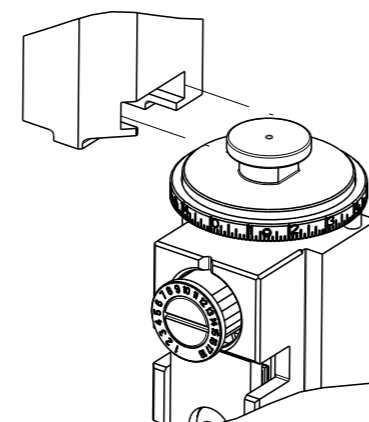


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150821-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150821-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150821-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150821-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150821-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



REVISIONS				
#	DATE	DESCRIPTION	BY	APPV
B	19 JUN 2020	ECR-20-008422	FJ	YY
C	22 OCT 2020	ECR-20-015060	JWC	RK

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AUTOMACH. WIRE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-8.46 mm [.303-.333 IN]		∅2.00-2.50 mm [.079-.098 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925667-1	925667-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ²	1.09 +/- 0.05 [1.043 +/- .002]	7.4
0.50mm ²	1.04 +/- 0.05 [1.041 +/- .002]	8.0
0.35mm ²	0.99 +/- 0.05 [1.039 +/- .002]	8.7



- 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.

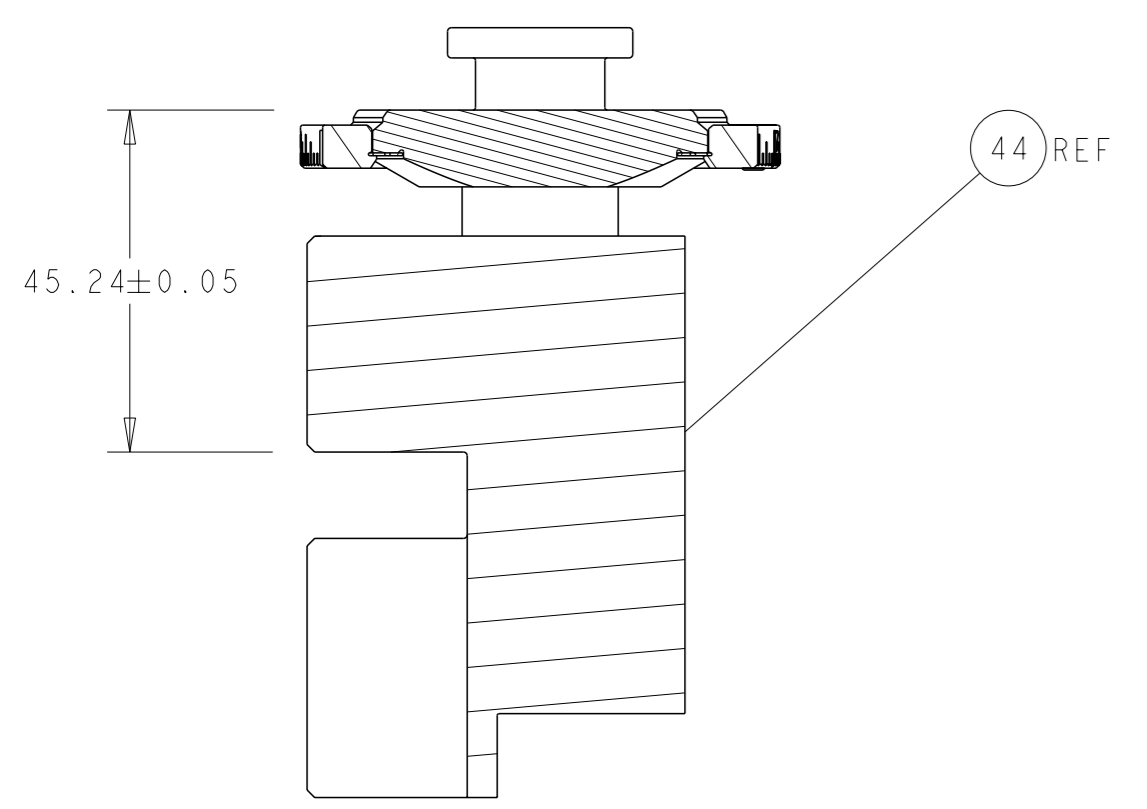
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

-	1	1	1	1	455888-6	SPACER, CRIMPER	259	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	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	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	1	-	2063961-9	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	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	2-464452-1	DRAG, STOCK	20	
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	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	240645-3	SPACER, SHEAR PLATE	10	
-	1	1	1	1	690619-4	PLATE, RETAINING	9	
-	1	2	2	1	1	7-690618-3	ANVIL, SPLICE TYPE	8
-	1	1	1	1	459722-3	BLADE, SHEAR	7	
-	1	1	1	1	1803131-5	ANVIL, SPLICE TYPE	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	9-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	1	6-459736-1	CRIMPER, WIRE	1
-77-72-71-2	-1				PART NO	DESCRIPTION	ITEM NO	

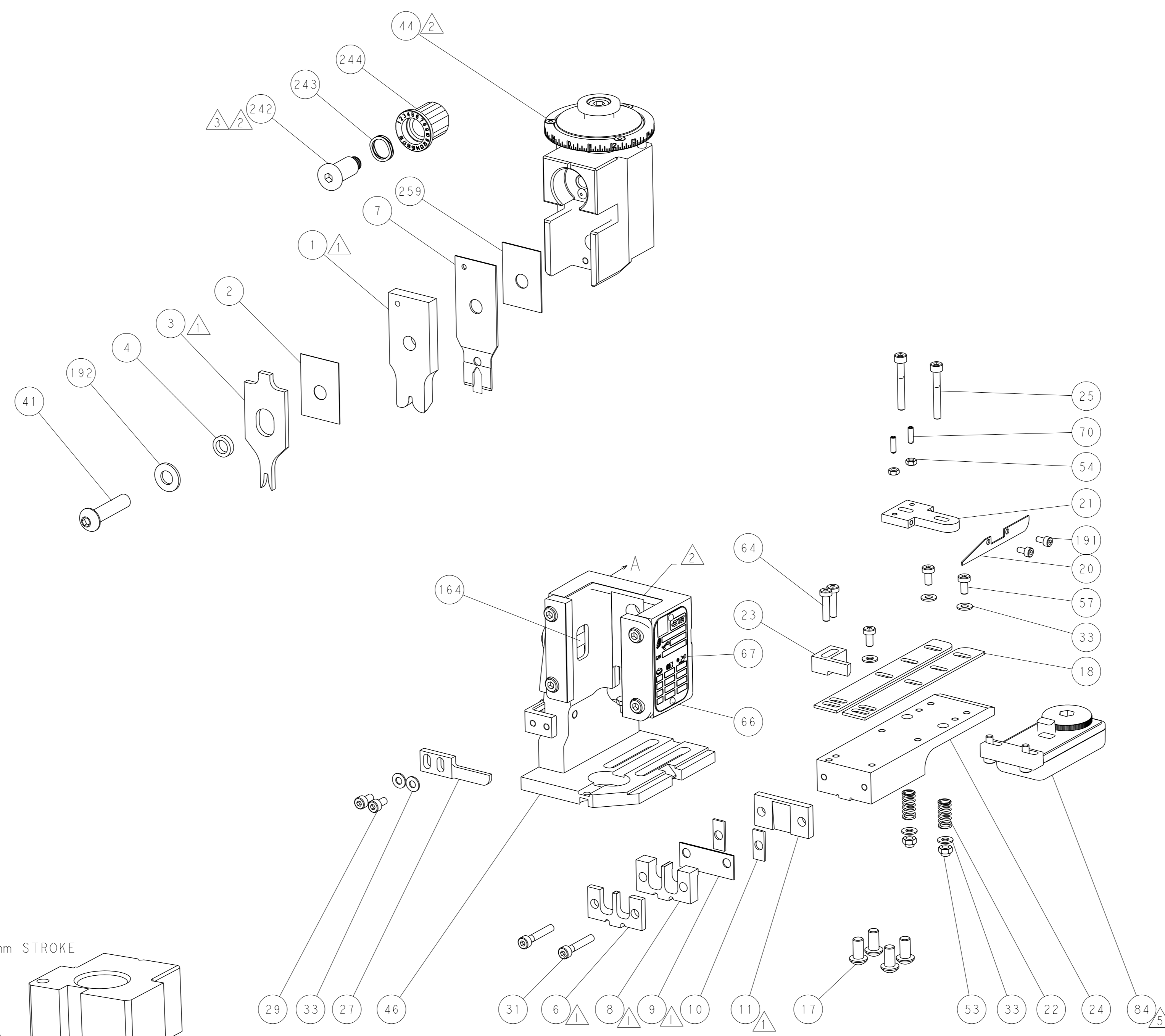
THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN R. HUANG CHK L. ZHANG APV L. ZHANG	10 JUL 2017 10 JUL 2017 10 JUL 2017		
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	NAME Ocean End Feed Applicator		RESTRICTED TO	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
MATERIAL		APPLICATION SPEC		A100779C=2150821	
		WEIGHT		Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV C	

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

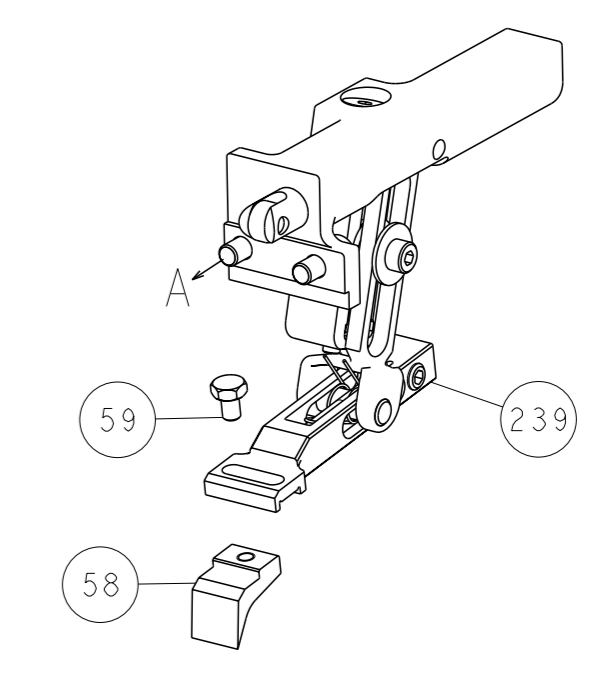
REVISIONS				
P	LY#	DESCRIPTION	DATE	OWN / APVD
-	-	SEE SHEET 1	-	-



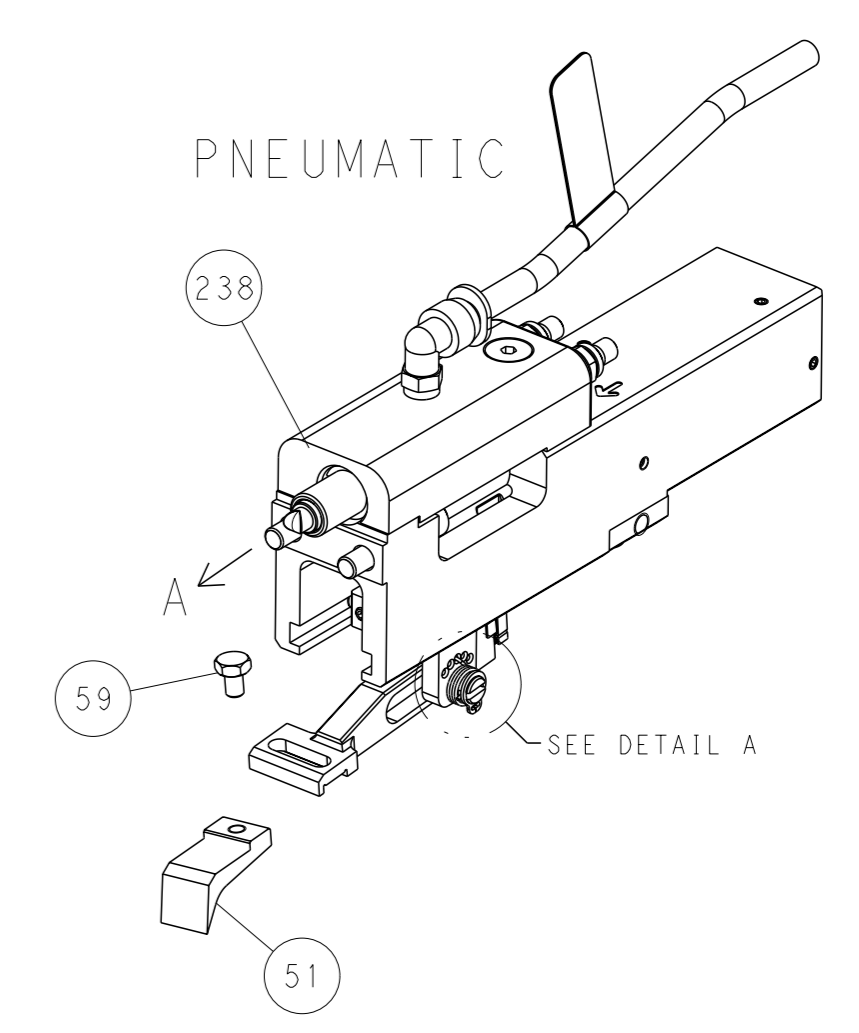
RAM SET-UP



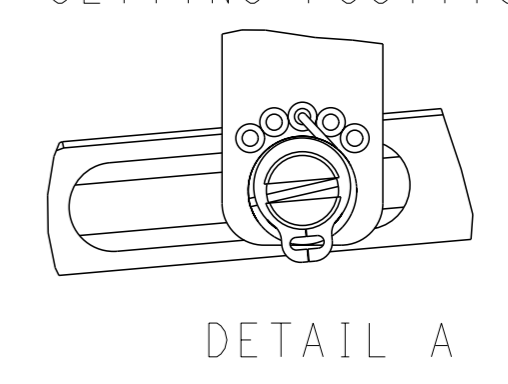
FEED TYPE
MECHANICAL



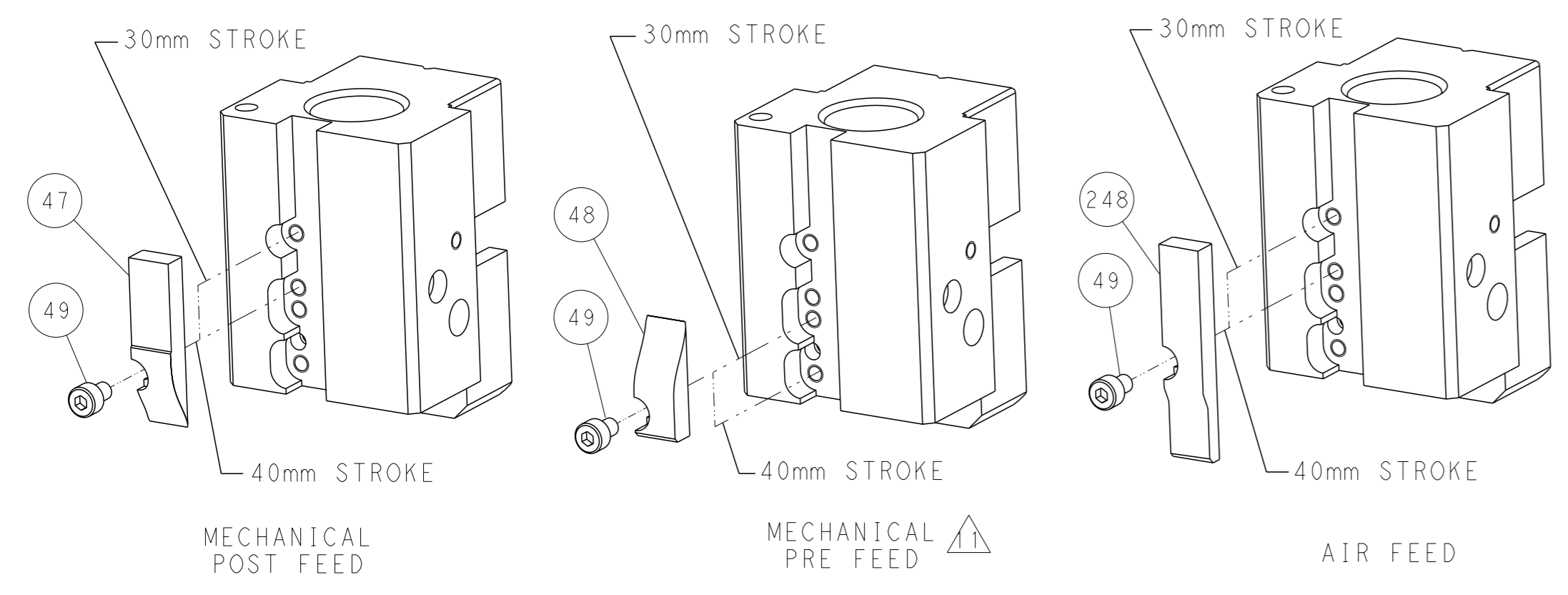
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

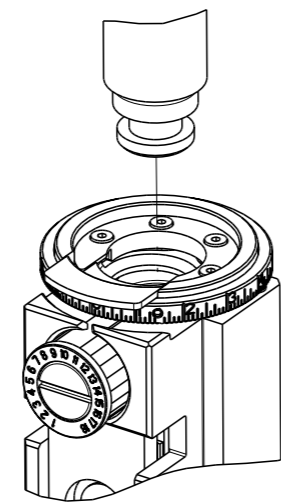


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: K. HUANG 10JUL2017	TE Connectivity
DIMENSIONS: mm		CHK: L. ZHANG 10JUL2017	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: L. ZHANG 10JUL2017	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME: Ocean End Feed Applicator	
MATERIAL: -		SIZE: A100779	RESTRICTED TO: -
FINISH: -		WEIGHT: -	SCALE: 1:1
Customer Accessible Production Drawing		SCALE: 1:1	SHEET 2 of 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150821-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150821-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150821-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AUTOMACH. WIRE TERMINAL			
WIRE STRIP LENGTH 7.70-8.46 mm [.303-.333 IN]		INSULATION DIAMETER RANGE Ø2.00-2.50 mm [.079-.098 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925667-1	925667-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.09+/-0.05 [.043+/-0.002]	7.4
0.50mm2	1.04+/-0.05 [.041+/-0.002]	8.0
0.35mm2	0.99+/-0.05 [.039+/-0.002]	8.7



- 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.

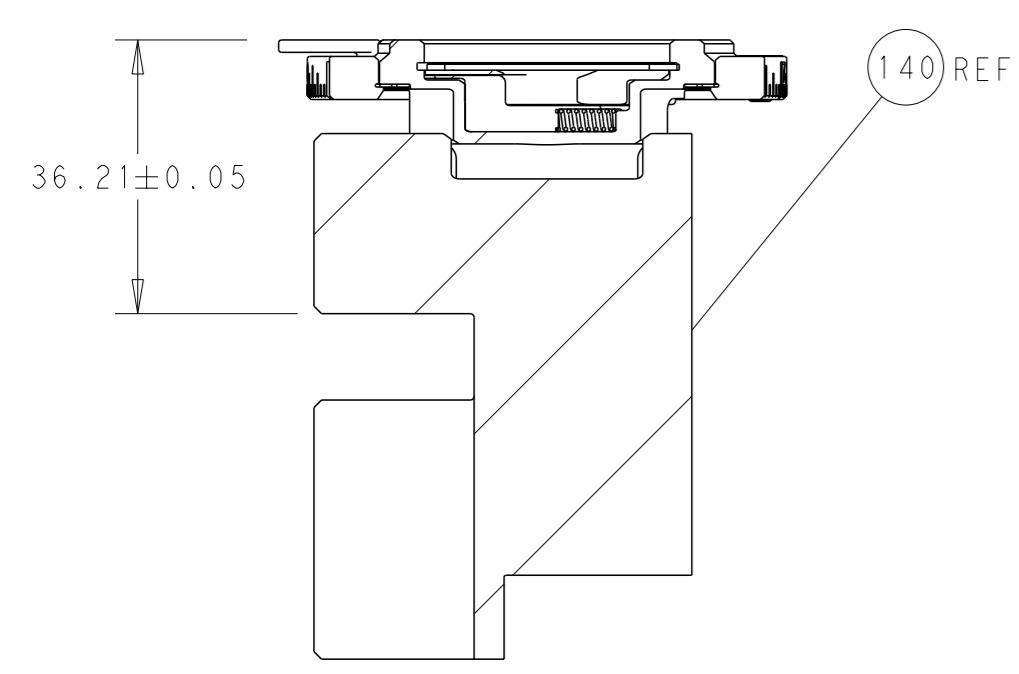
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

REVISIONS				
#	LY#	DESCRIPTION	DATE	APPV
-	-	SEE SHEET 1	-	-

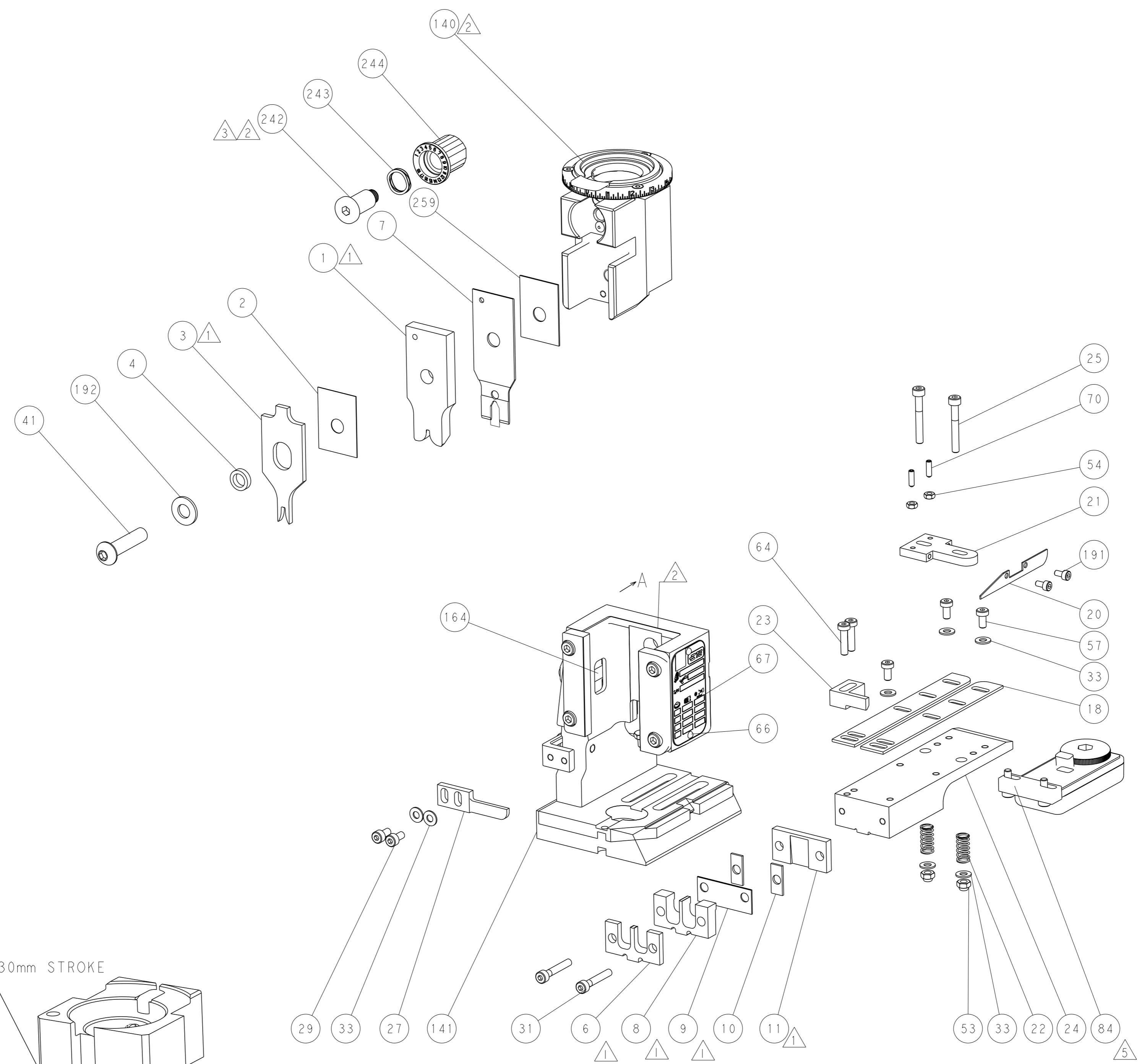
-	1	1	455888-6	SPACER, CRIMPER	259	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140	
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-9	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	2-464452-1	DRAG, STOCK	20	
-	2	2	1901259-3	GUIDE, LOWER STRIP	18	
1	-	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	240645-3	SPACER, SHEAR PLATE	10	
1	-	1	690619-4	PLATE, RETAINING	9	
1	1	1	7-690618-3	ANVIL, SPLICE TYPE	8	
1	-	1	459722-3	BLADE, SHEAR	7	
1	1	1	1803131-5	ANVIL, SPLICE TYPE	6	
-	-	-	-	-	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	9-2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	6-459736-1	CRIMPER, WIRE	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN R. HUANG CHK L. ZHANG APV L. ZHANG	10JUL2017 10JUL2017 10JUL2017	TE Connectivity NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO A100779C=2150821 SCALE 1:1 SHEET 3 of 4 REV C	
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	MATERIAL		WEIGHT	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	-		-	

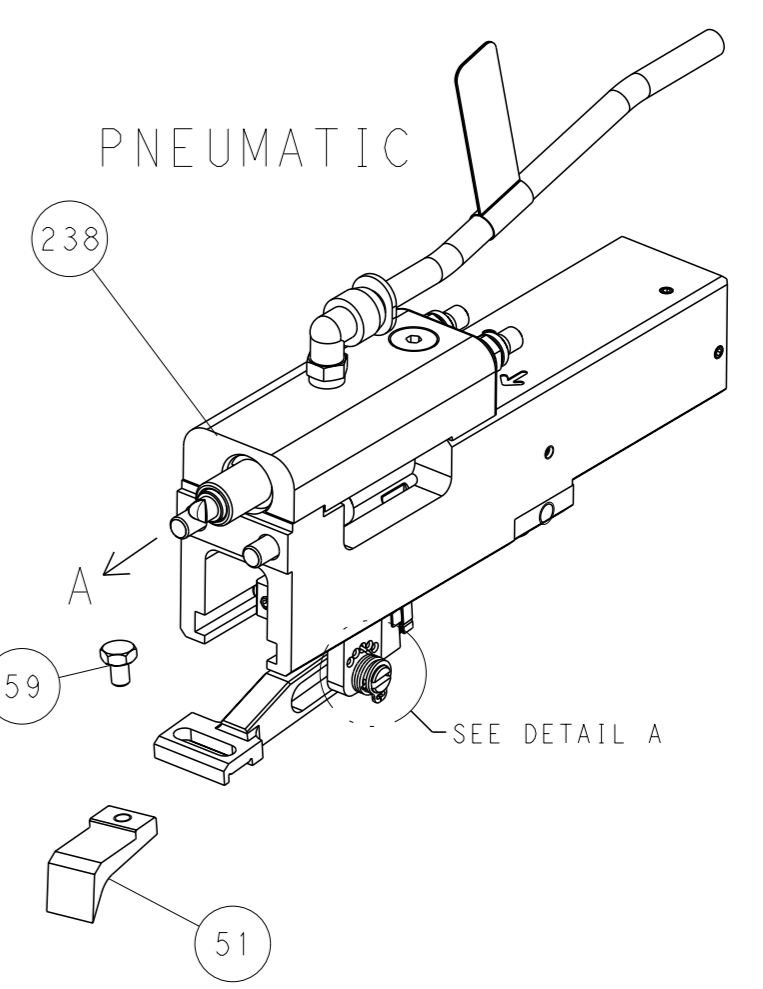
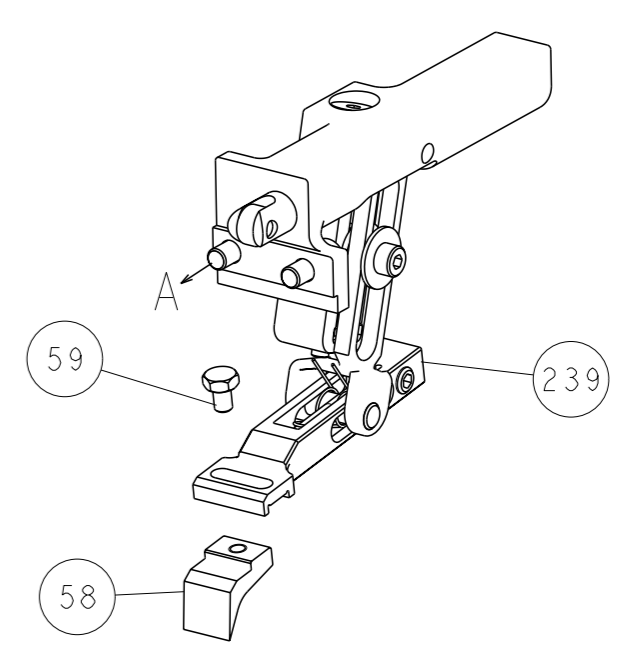
REVISIONS				
P	LY#	DESCRIPTION	DATE	OWN
-	-	SEE SHEET 1	-	-



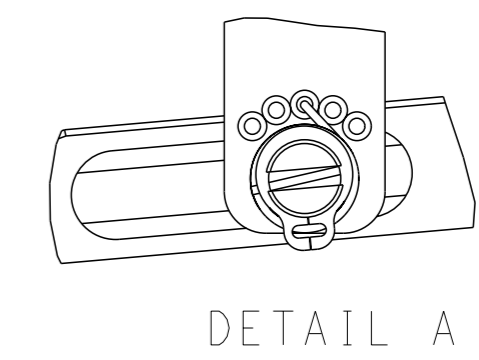
RAM SET-UP



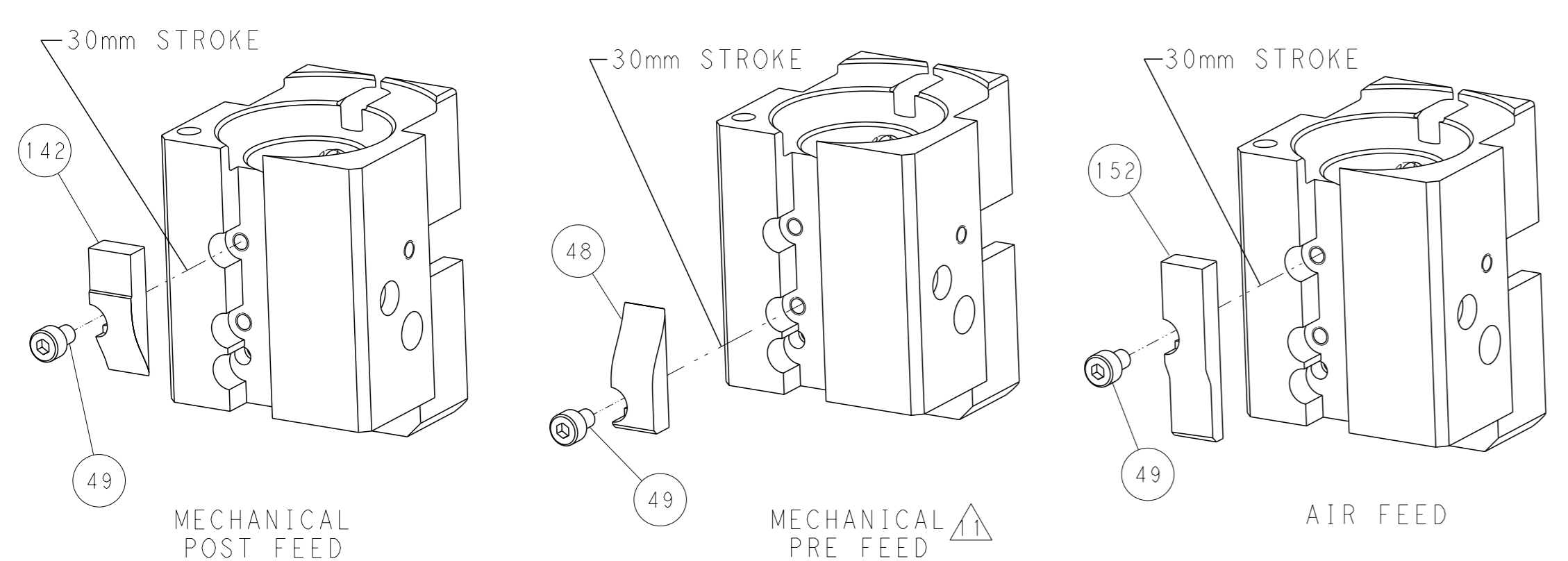
FEED TYPE
MECHANICAL



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)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: K. HUANG 10JUL2017	TE Connectivity
DIMENSIONS: mm		CHK: L. ZHANG 10JUL2017	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: L. ZHANG 10JUL2017	NAME: Ocean End Feed Applicator
0 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *		PRODUCT SPEC	APPLICATION SPEC
MATERIAL		WEIGHT	SIZE: A 00779 C=2150821
Customer Accessible Production Drawing		SCALE: 1:1	SHEET 4 OF 4 REV C