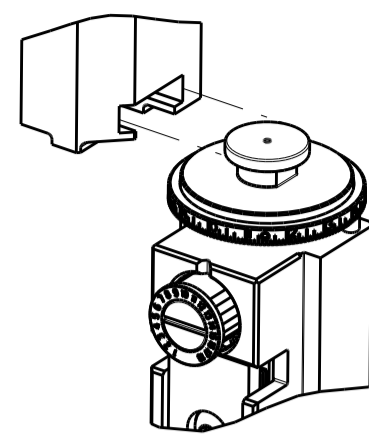


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150889-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150889-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150889-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|-------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 7.62 mm [.300] | F |
| INSUL | 10.67 mm [.420] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| | | | |
|-----------------------------------------------------------|---------------------|--------------------------------|---------------------|
| TERMINAL DATA: ESSEX/LEAR TERMINAL TE CRIMP SPECIFICATION | | | |
| TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 6.85-7.61 mm [.269-.299 IN] | | ∅5.82-7.62 mm [.229-.300 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | ESSEX/LEAR TERMINAL | TE TERMINAL | ESSEX/LEAR TERMINAL |
| 1949939-2 | 110640-AK02 | 1949939-5 | 110645-AKXX |
| 1949939-1 | 110653-AKXX | 1949939-6 | 110634-AKXX |
| 1949939-3 | 110640-AKXX | 1949939-7 | 110628-AKXX |
| 1949939-4 | 110654-AKXX | 1949939-8 | 110620-AKXX |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 8.00mm2 | 4.77 +/- 0.05 [.188 +/- .002] | 4.5 |
| 6.00mm2 | 4.51 +/- 0.05 [.178 +/- .002] | 7.3 |
| 5.00mm2 | 4.44 +/- 0.05 [.175 +/- .002] | 8.1 |

- 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.
 - 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 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.

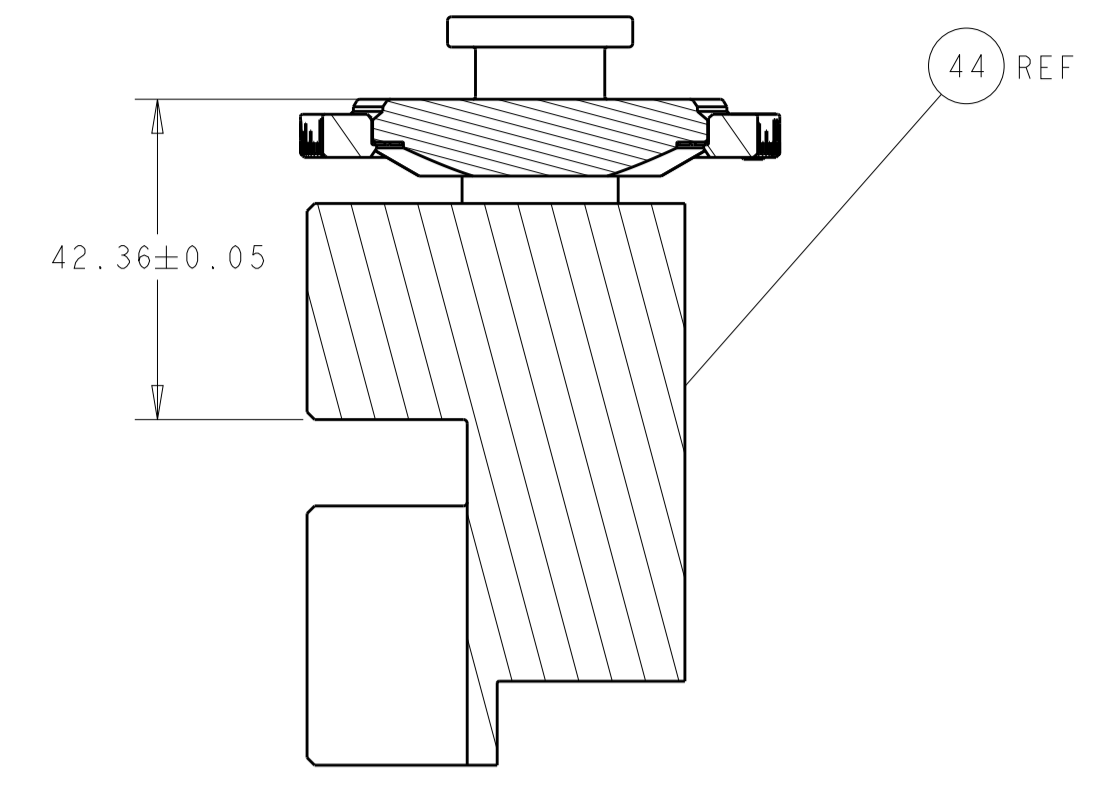
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|-----|------|-----------|-----|---------------|-----------|-----|------|
| | | REV | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | 1 | | PRELIMINARY | 09MAR2018 | CT | GB |
| | | A | | RELEASE | 02MAY2018 | AW | CT |
| | | B | | ECR-19-018195 | 21NOV2019 | FZ | TE |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1803078-2 | SPACER, PRECISION | 259 |
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| | - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 2844940-4 | AIR FEED MODULE | 238 |
| - | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| | - | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1 | 1-455888-8 | SPACER, CRIMPER | 82 |
| - | 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 | 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 |
| - | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 |
| - | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 56 |
| - | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 |
| - | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 |
| - | 1 | 1 | 2063961-1 | FEED FINGER | 51 |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1 | 1-2119655-1 | APPLICATOR BASIC ASSEMBLY, EF | 46 |
| - | 1 | 1 | 1803517-2 | RAM ASSEMBLY, EF ATLANTIC | 44 |
| - | 1 | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 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 | 690455-8 | STRIPPER, FRONT CASTING | 27 |
| - | 2 | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 |
| - | 1 | 1 | 3-1752371-4 | PLATE, STRIP GUIDE | 24 |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1803292-5 | DRAG | 20 |
| - | 1 | 1 | 4-1901696-1 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 4-1901695-1 | STRIP GUIDE, FRONT | 18 |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| - | 1 | 1 | 6-240641-8 | SPACER | 16 |
| | - | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | 10 |
| - | 1 | 1 | 690482-3 | PLATE, FRONT SHEAR | 9 |
| | 1 | 2 | 1803004-2 | ANVIL, COMBINATION, END FEED | 8 |
| | - | 1 | 1-2217206-5 | BLADE, SLUG | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 8-240641-5 | SPACER | 5 |
| - | 1 | 1 | 4-238011-9 | BLOCK, CRIMPER SPACER | 4 |
| | 1 | 2 | 1803614-9 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 2 |
| | 1 | 2 | 6-1633588-7 | CRIMPER, WIRE | 1 |
| - | 77 | 72 | -2 | PART NO | ITEM NO |

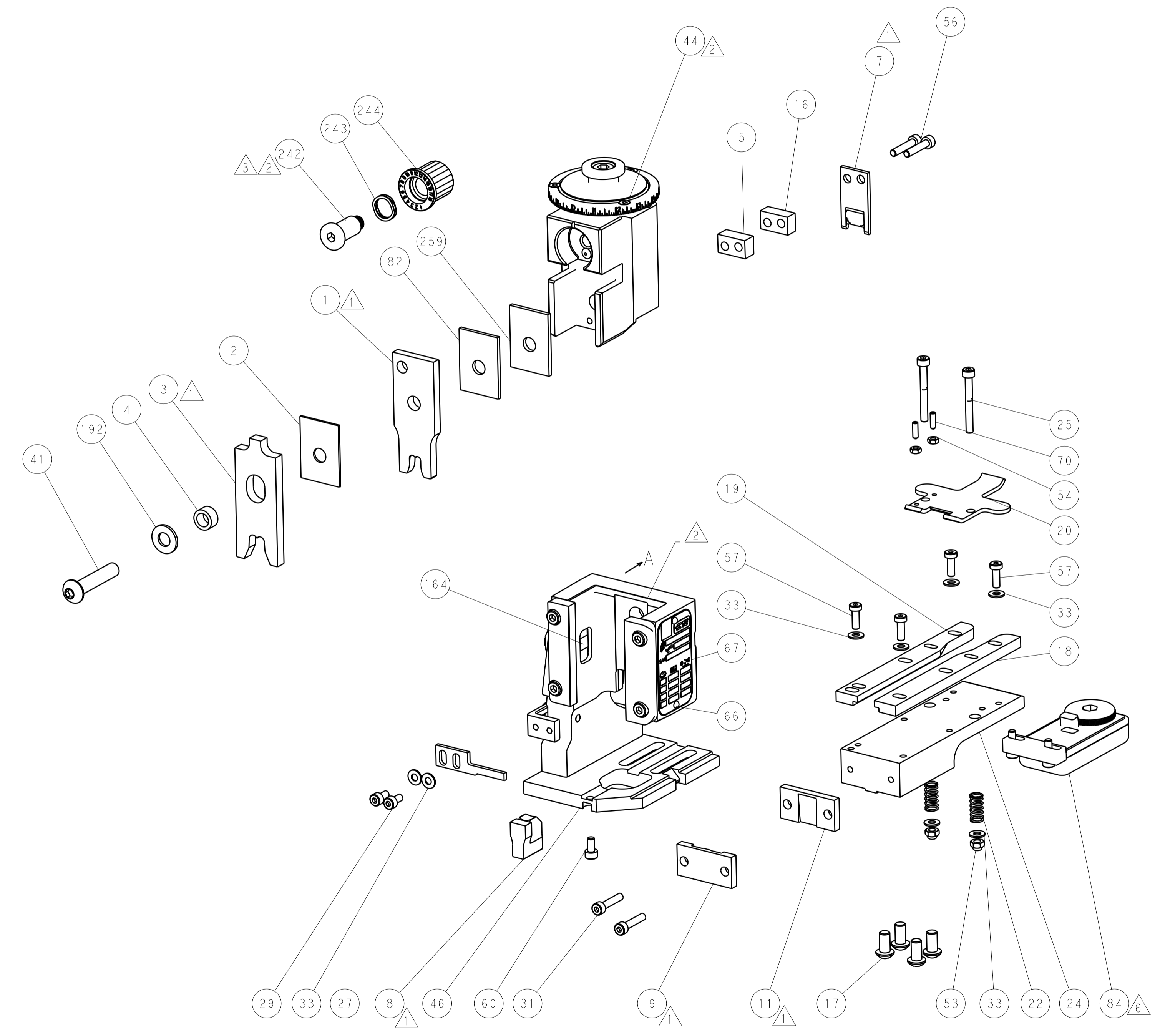
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | |
|----------------|--|-----------------------------------------------------------------------------|--|----------------------------------------|----------------------------------------------|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN: C. TOPPER 09MAR2018 | TE Connectivity Harrisburg, PA 17105-3608 |
| | | 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | | CHK: G. BAILEY 09MAR2018 | |
| MATERIAL: - | | FINISH: - | | APVD: J. DEGRANGE 09MAR2018 | NAME: Ocean End Feed Applicator |
| - | | - | | PRODUCT SPEC: - | SIZE: A1 |
| - | | - | | APPLICATION SPEC: - | CAGE CODE: 00779 |
| - | | - | | WEIGHT: - | DRAWING NO: 2150889 |
| - | | - | | Customer Accessible Production Drawing | RESTRICTED TO: - |
| - | | - | | SCALE: 1:1 | SHEET 1 OF 4 |
| - | | - | | REV: B | |

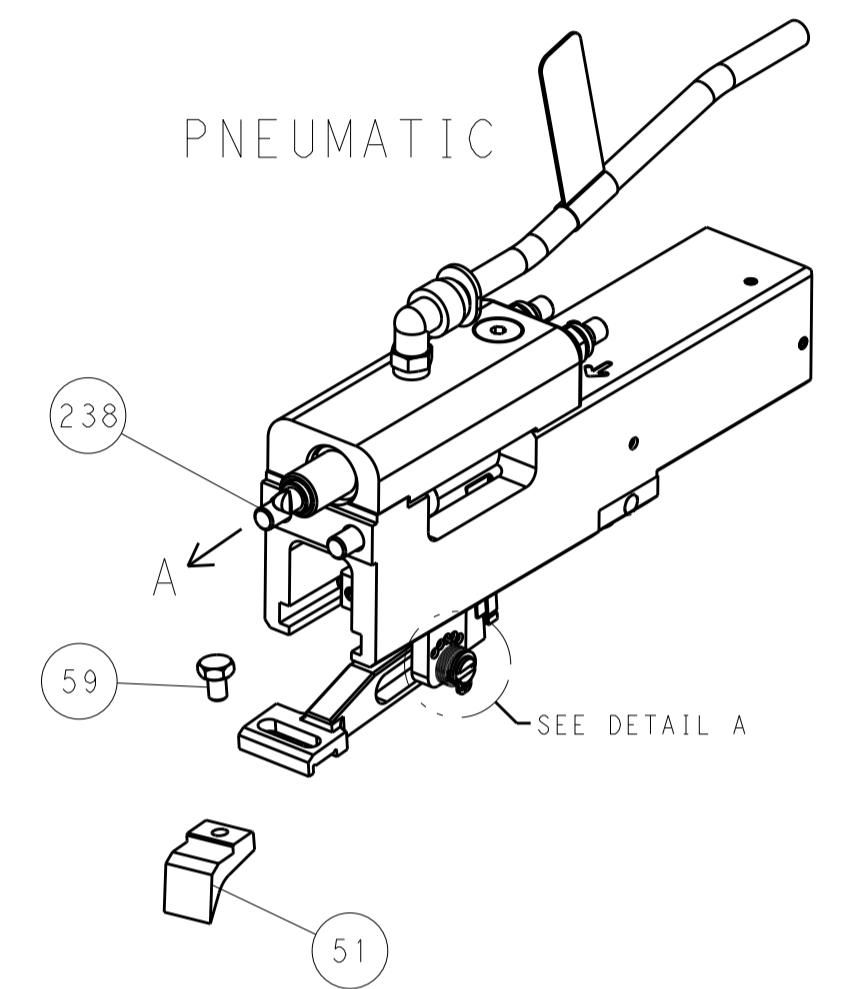
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|-----------|------|-----|-------------|------|------|
| A | 66 | | | | |
| REVISIONS | | | DESCRIPTION | DATE | BY |
| - | | | SEE SHEET 1 | - | - |



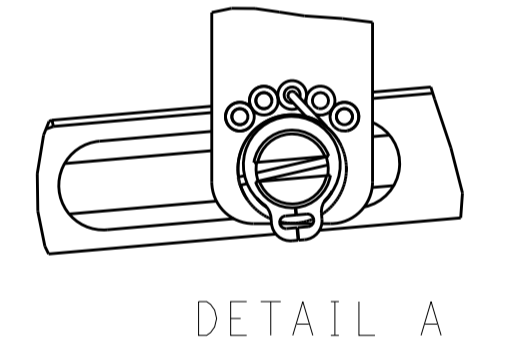
RAM SET-UP



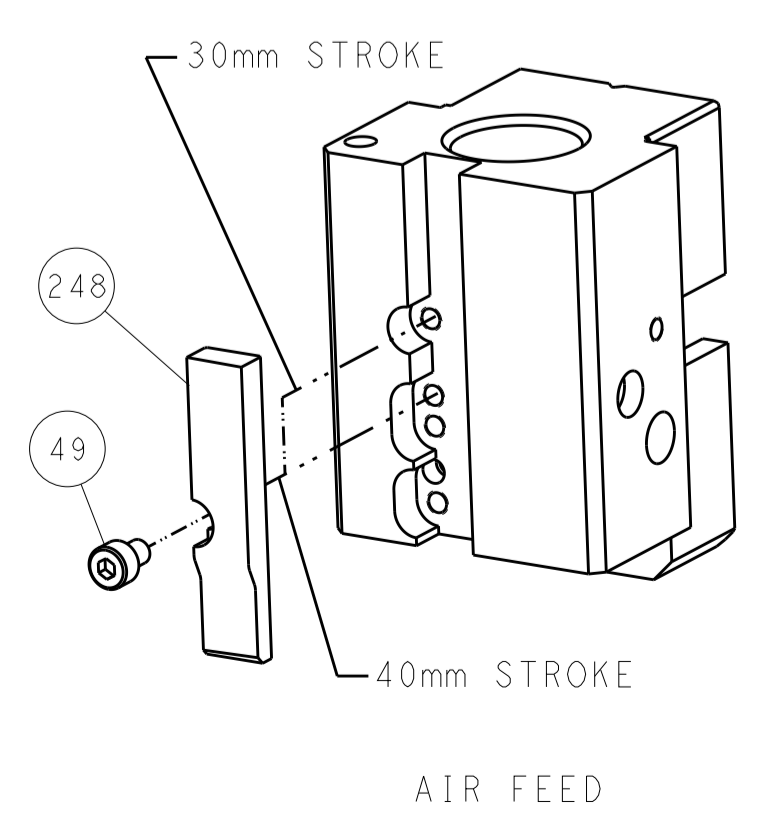
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

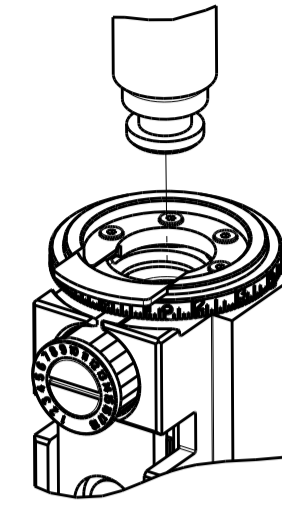


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | |
|-----------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: C. TOPPER 09MAR2018 CHK: G. BAILEY 09MAR2018 APVD: J. DEGRANGE 09MAR2018 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150889 RESTRICTED TO: |
| MATERIAL: | | FINISH: | SCALE: 1:1 SHEET: 2 of 4 REV: B |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2150889-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150889-7 | A | CRIMP TOOLING KIT | - |

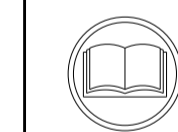
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 7.62 mm [.300] | F |
| INSUL | 10.67 mm [.420] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: ESSEX/LEAR TERMINAL TE CRIMP SPECIFICATION | | | |
|-----------------------------------------------------------|------------------------------|-------------|---------------------|
| TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 6.85-7.61 mm [.269-.299 IN] | ∅5.82-7.62 mm [.229-.300 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | ESSEX/LEAR TERMINAL | TE TERMINAL | ESSEX/LEAR TERMINAL |
| 1949939-2 | 110640-AK02 | 1949939-5 | 110645-AKXX |
| 1949939-1 | 110653-AKXX | 1949939-6 | 110634-AKXX |
| 1949939-3 | 110640-AKXX | 1949939-7 | 110628-AKXX |
| 1949939-4 | 110654-AKXX | 1949939-8 | 110620-AKXX |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 8.00mm2 | 4.77+/-0.05 [.188+/-0.002] | 4.5 |
| 6.00mm2 | 4.51+/-0.05 [.178+/-0.002] | 7.3 |
| 5.00mm2 | 4.44+/-0.05 [.175+/-0.002] | 8.1 |



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 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.

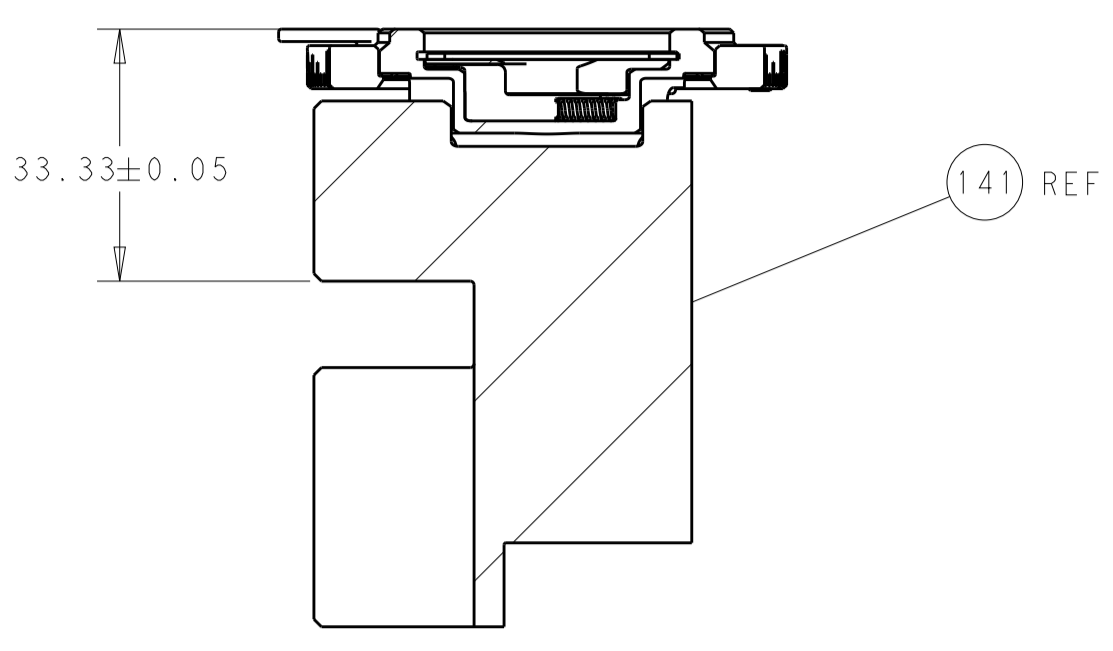
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

| | | | | |
|---|-----|-------------|-------------------------------------|-----|
| - | 1 | 1803078-2 | SPACER, PRECISION | 259 |
| - | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 2844940-4 | AIR FEED MODULE | 238 |
| - | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 |
| - | 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 |
| - | 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 | 1-2119655-2 | APPLICATOR BASIC ASSEMBLY, EF | 141 |
| - | 1 | 1803518-2 | RAM ASSEMBLY, EF PACIFIC | 140 |
| - | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1-455888-8 | SPACER, CRIMPER | 82 |
| - | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 |
| - | 2 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 70 |
| - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 |
| - | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 56 |
| - | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 |
| - | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 |
| - | 1 | 2063961-1 | FEED FINGER | 51 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 8 | 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 | 690455-8 | STRIPPER, FRONT CASTING | 27 |
| - | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 |
| - | 1 | 3-1752371-4 | PLATE, STRIP GUIDE | 24 |
| - | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1803292-5 | DRAG | 20 |
| - | 1 | 4-1901696-1 | STRIP GUIDE, REAR | 19 |
| - | 1 | 4-1901695-1 | STRIP GUIDE, FRONT | 18 |
| - | 1 | 6-240641-8 | SPACER | 16 |
| - | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | 10 |
| - | 1 | 690482-3 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1803004-2 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1-2217206-5 | BLADE, SLUG | 7 |
| - | - | - | - | 6 |
| - | 1 | 8-240641-5 | SPACER | 5 |
| - | 1 | 4-238011-9 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1803614-9 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1-455888-0 | SPACER, CRIMPER | 2 |
| 1 | 1 | 6-1633588-7 | CRIMPER, WIRE | 1 |

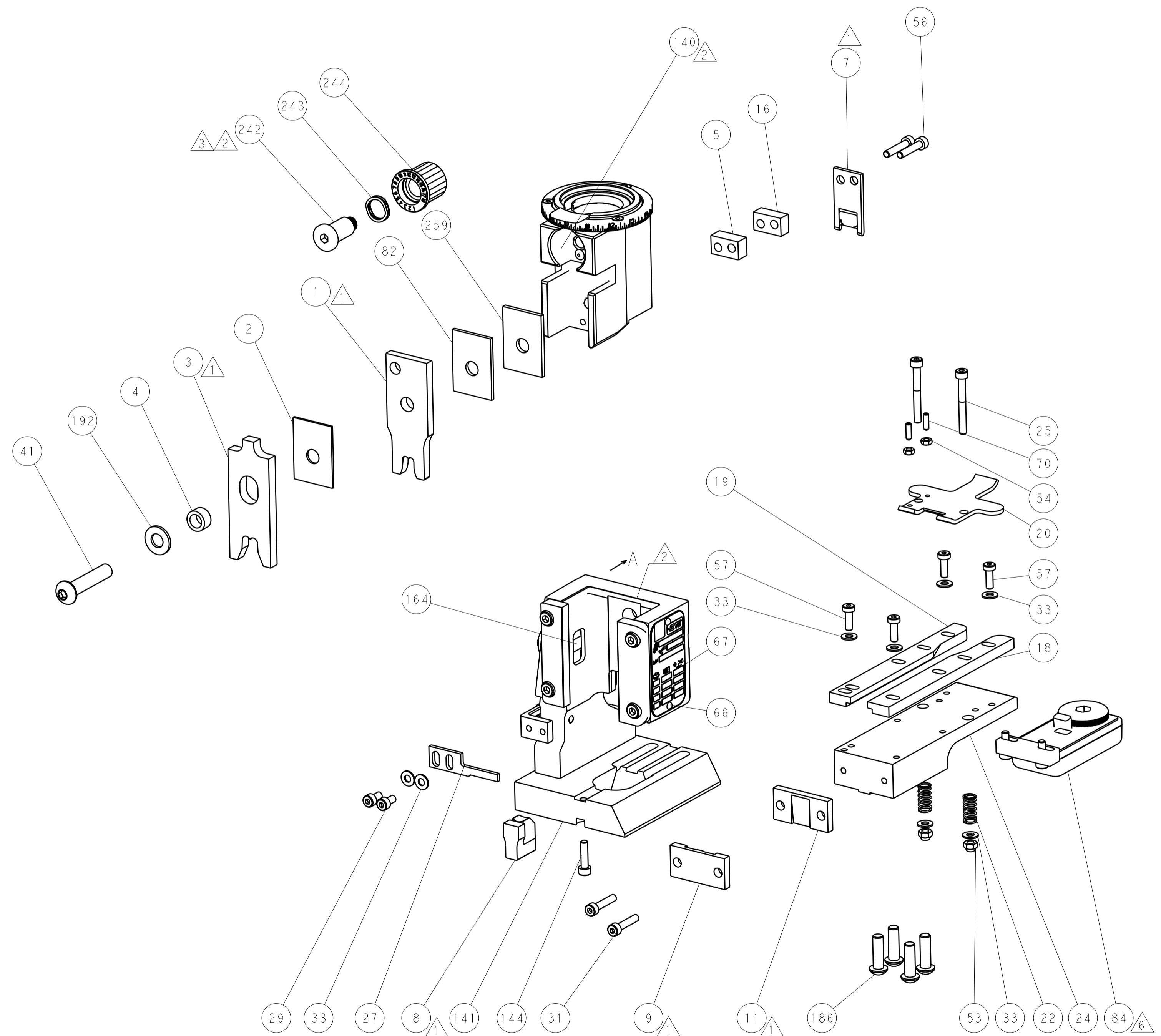
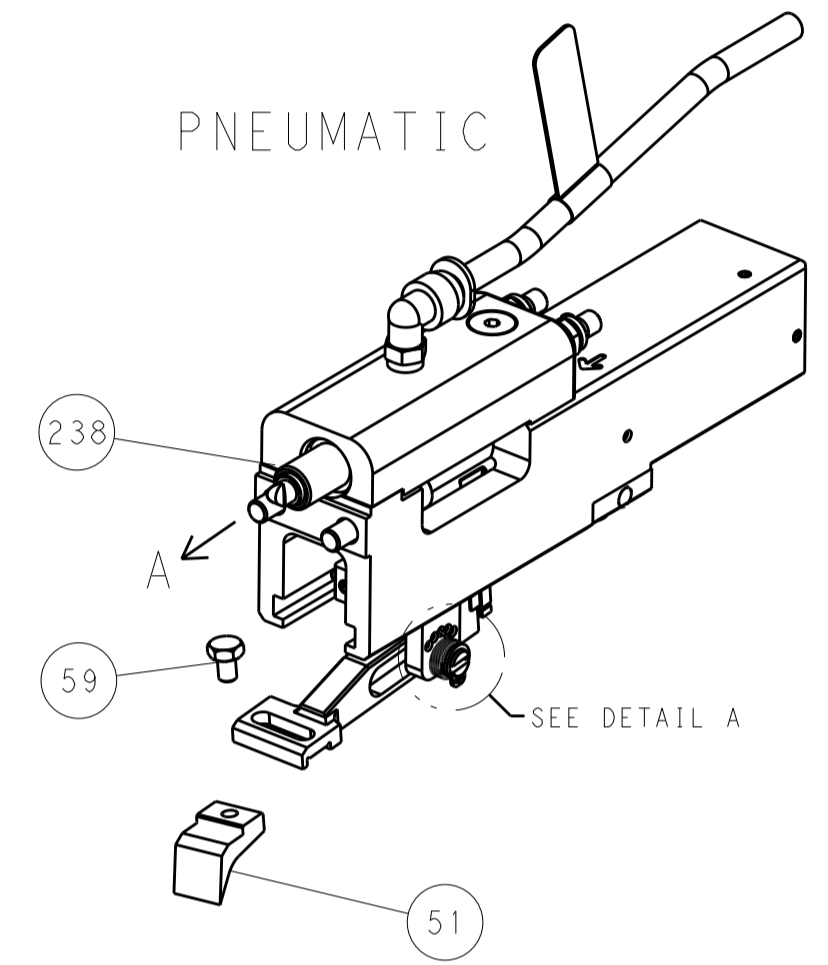
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN | | CHK | | APVD | | NAME | |
|-------------|---------|----------------------------------------|---------|---------|---------|---------|----------|--------|-----------|-----------|----------------------------------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | ANGLES ± | FINISH | 09MAR2018 | TOPPER | TE Connectivity |
| | | | | | | | | | 09MAR2018 | G. BAILEY | Harrisburg, PA 17105-3608 |
| | | | | | | | | | 09MAR2018 | DEGRANGE | |
| | | | | | | | | | | | Ocean End Feed Applicator |
| | | | | | | | | | | | Customer Accessible Production Drawing |
| | | | | | | | | | | | SCALE 1:1 SHEET 3 OF 4 REV B |

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

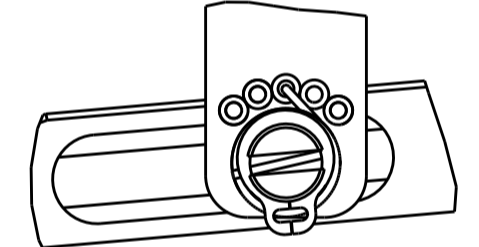


RAM SET-UP

FEED TYPE

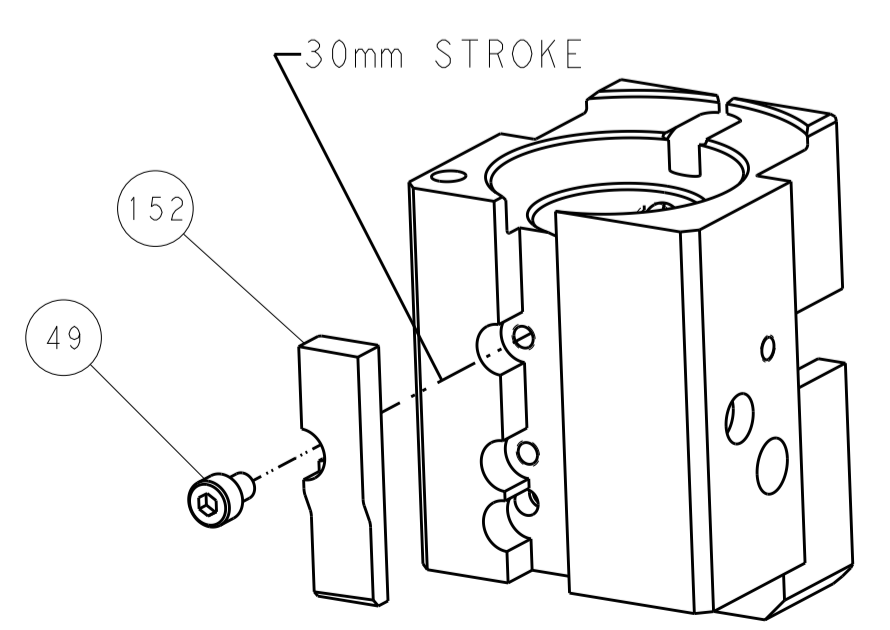


FEED SPRING SETTING POSITION



DETAIL A

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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: C. TOPPER 09MAR2018 CHK: G. BAILEY 09MAR2018 APVD: J. DEGRANGE 09MAR2018 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT: | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150889 RESTRICTED TO: |
| MATERIAL: FINISH: | | SCALE: 1:1 SHEET: 4 of 4 REV: B | Customer Accessible Production Drawing |