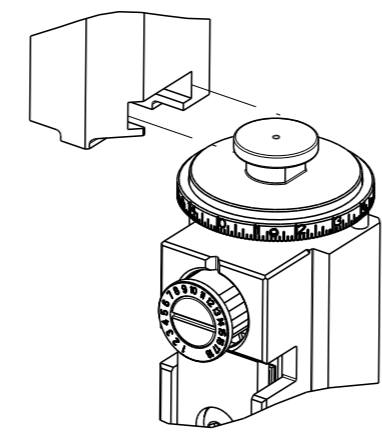


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150900-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150900-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150900-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150900-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150900-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.80 mm [.071]	F
INSUL	2.60 mm [.102]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE (PRONER) CRIMP SPECIFICATION			
TERMINAL NAME: CLIP DRAPEAU 2.8x0.5 & 2.8x0.8			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.70-5.30 mm [.185-.209 IN]	Ø1.60-2.50 mm [.063-.098 IN]		
TERMINAL APPLICATION SPECIFICATION	SPS 73002-5 Rev A	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544358-1	1544358-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20 +/- 0.03 [.047 +/- .001]	3.0
0.50mm2	1.08 +/- 0.03 [.043 +/- .001]	4.2
0.38mm2	1.03 +/- 0.03 [.041 +/- .001]	4.7
0.22mm2	0.96 +/- 0.03 [.038 +/- .001]	5.4

- 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 CUT TO LENGTH.
 - 6 POSITION ITEM 27 BETWEEN ITEM 1 AND ITEM 3.
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.

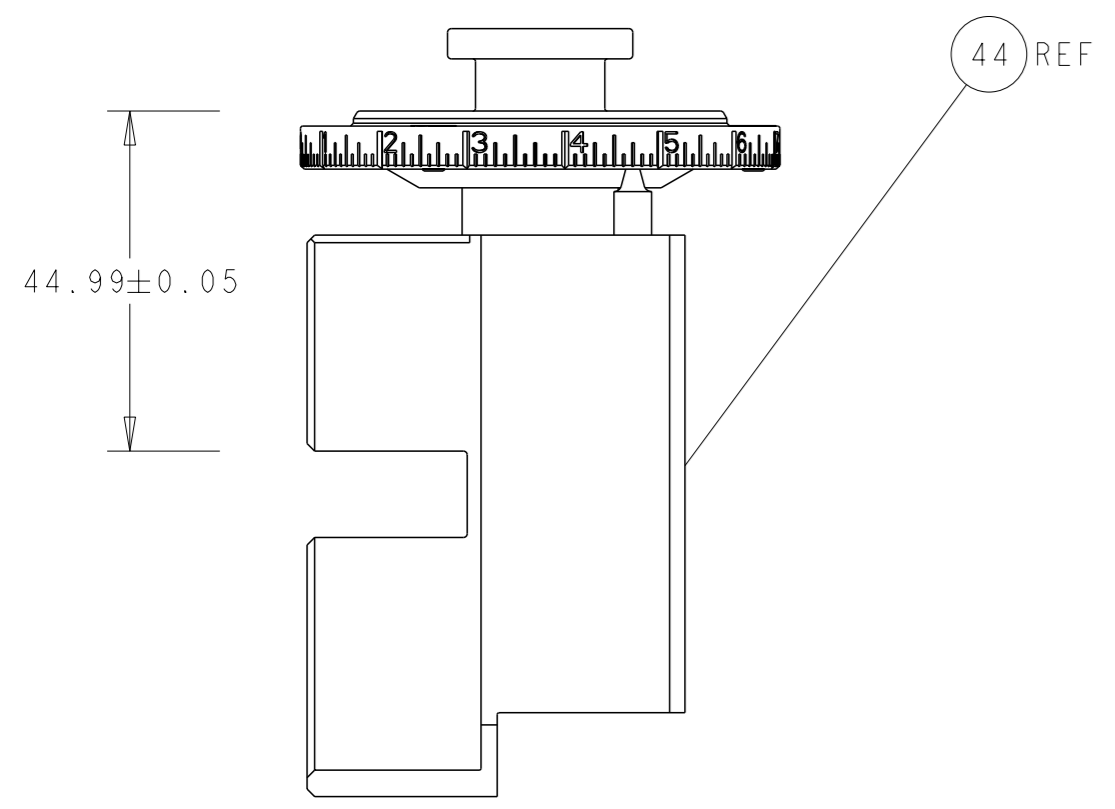
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASE	12APR2018	AW	CT
		B		ECR-19-016775	29OCT2019	FJ	TE
		C		ECR-20-003520	09MAR2020	JWC	GB
		D		ECR-20-014917	20OCT2020	JAH	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	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	18023-1	SCR, SKT HD CAP M3 X 5.0	111	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	80	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-6	FEED FINGER	58	
-	4	4	4	4	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	-	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	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	1	240639-2	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	3-1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1-1633168-4	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-5	DRAG, STOCK	20	
-	1	1	1	1	9-1901695-0	STRIP GUIDE, FRONT	19	
-	1	1	1	1	2-1901259-1	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	690815-5	STOP, TERMINAL	12	
-	-	-	-	-	-	-	11	
-	2	2	2	2	1-240645-1	SPACER, SHEAR PLATE	10	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	9	
-	1	2	2	1	1	7-690618-6	ANVIL, SPLICE TYPE	8
-	1	1	1	1	461297-5	BLADE, SHEAR	7	
-	1	1	1	1	690816-5	ANVIL, INSULATION	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1803108-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	2	2	1	1	8-1803188-4	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	ITEM NO	

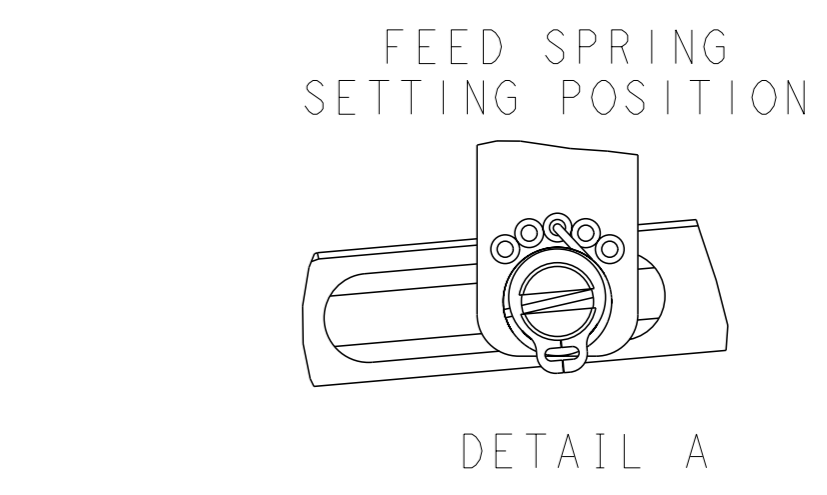
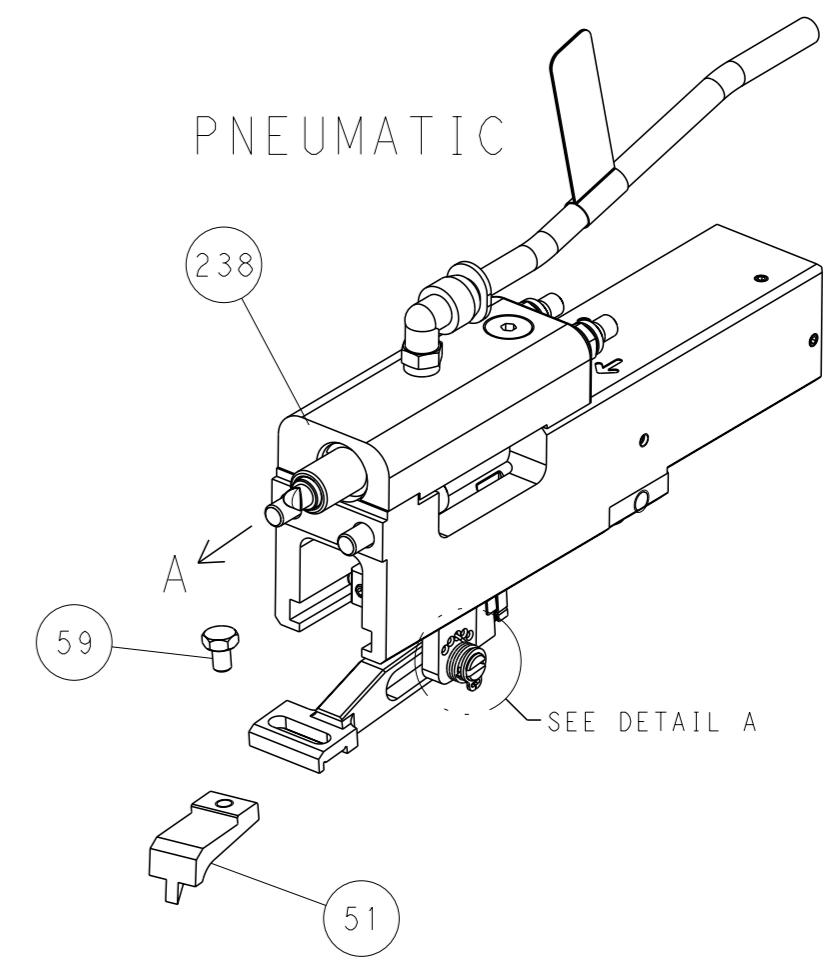
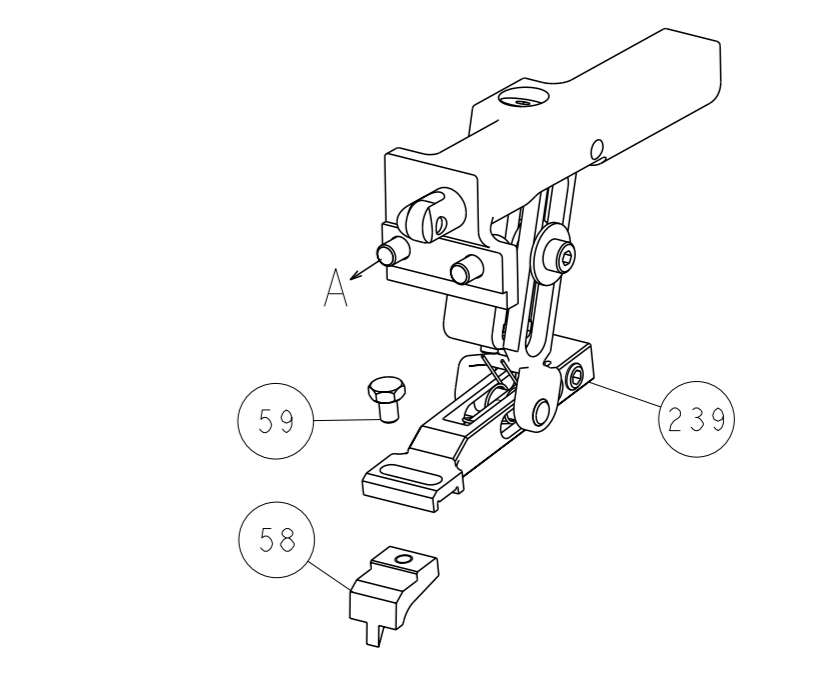
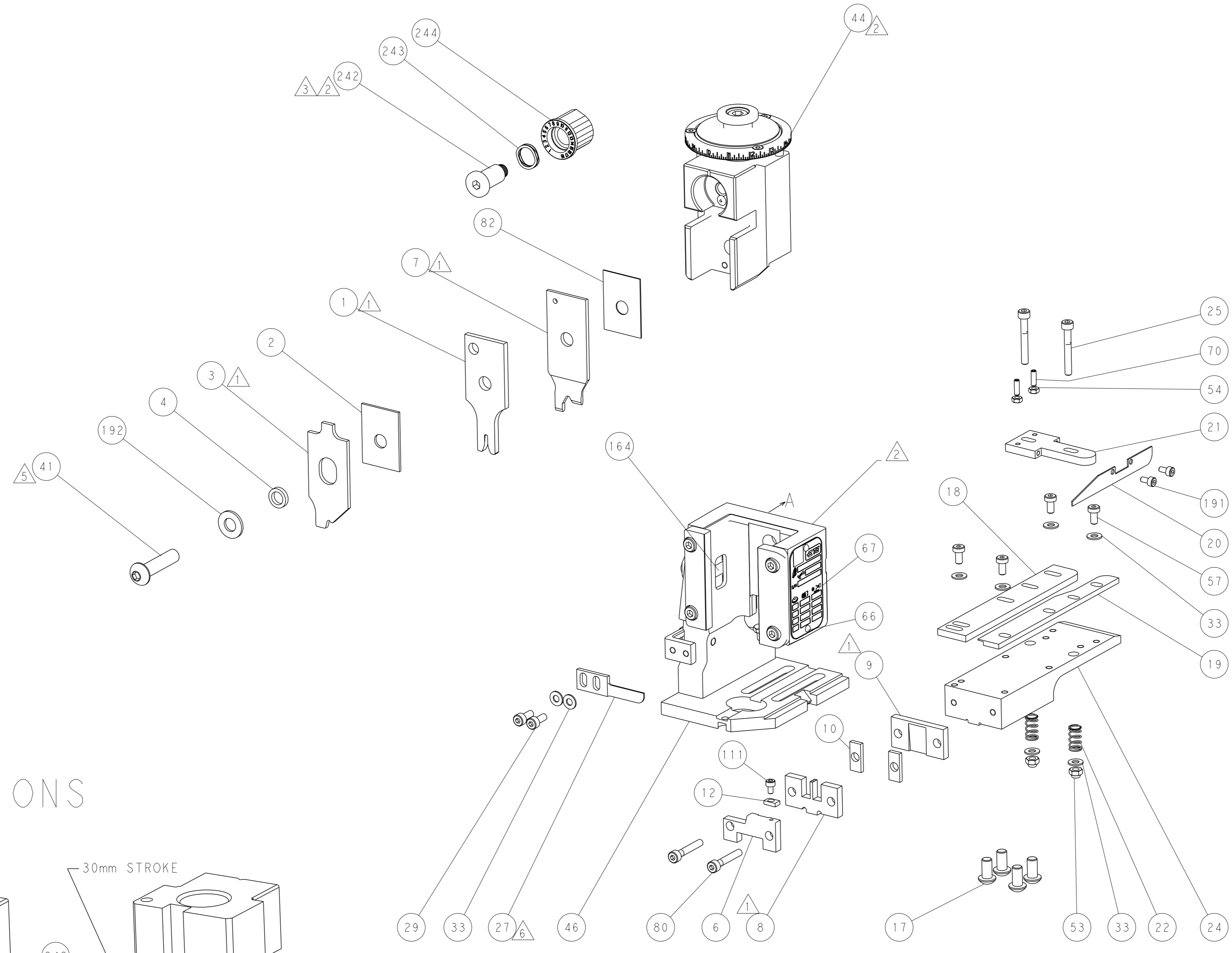
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: B. WEAVER 01MAR2018 CHK: T. ELBIN 01MAR2018 APVD: T. ELBIN 01MAR2018 PRODUCT SPEC APPLICATION SPEC WEIGHT: - Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150900 SCALE: 1:1 SHEET: 1 of 4 REV: D	
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LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		1	SEE SHEET 1		

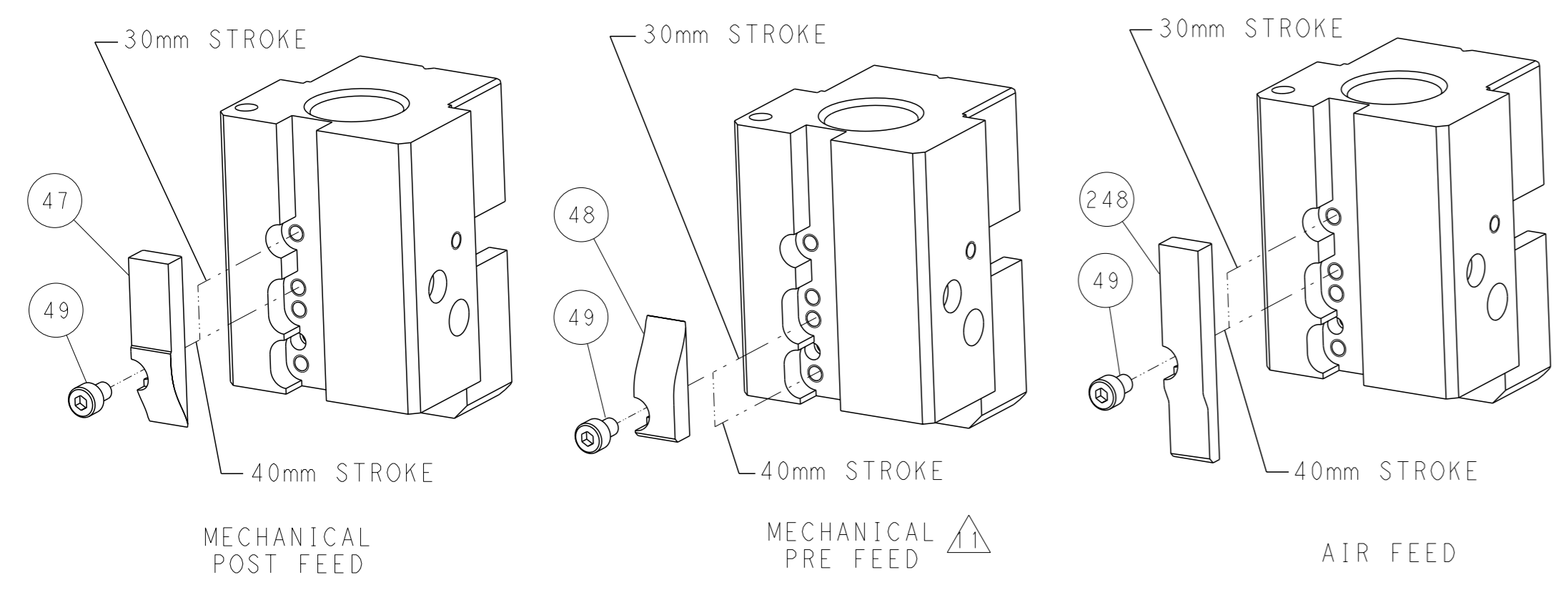


FEED TYPE MECHANICAL

RAM SET-UP



CAM POSITIONS

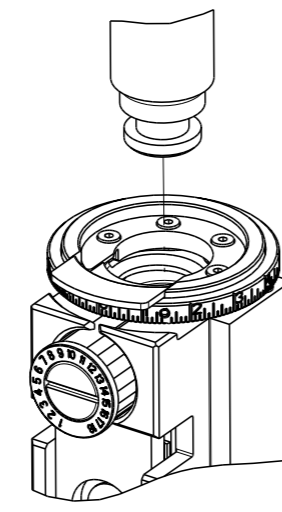


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2018 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: B. WEAVER 01MAR2018 CHK: T. ELBIN 01MAR2018 APVD: T. ELBIN 01MAR2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150900	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D
MATERIAL: - FINISH: -		WEIGHT: - APPLICATION SPEC: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150900-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150900-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150900-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.80 mm [.071]	F
INSUL	2.60 mm [.102]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE (PRONER) CRIMP SPECIFICATION			
TERMINAL NAME: CLIP DRAPEAU 2.8x0.5 & 2.8x0.8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [1.85-.209 IN]		Ø1.60-2.50 mm [1.063-.098 IN]	
TERMINAL APPLICATION SPECIFICATION	SPS 73002-5 Rev A	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544358-1	1544358-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20 +/- 0.03 [1.047 +/- .001]	3.0
0.50mm2	1.08 +/- 0.03 [1.043 +/- .001]	4.2
0.38mm2	1.03 +/- 0.03 [1.041 +/- .001]	4.7
0.22mm2	0.96 +/- 0.03 [1.038 +/- .001]	5.4

- 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.
 - CUT TO LENGTH.
 - POSITION ITEM 27 BETWEEN ITEM 1 AND ITEM 3.
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	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-8	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	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
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REFREF		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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	111
-	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	80
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-6	FEED FINGER	58
-	4	4	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	-	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	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	240639-2	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	3-1752371-5	PLATE, STRIP GUIDE	24
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1-1633168-4	ARM, STOCK DRAG	21
-	1	1	464452-5	DRAG, STOCK	20
-	1	1	9-1901695-0	STRIP GUIDE, FRONT	19
-	1	1	2-1901259-1	GUIDE, LOWER STRIP	18
-	1	1	690815-5	STOP, TERMINAL	12
-	-	-	-	-	11
-	2	2	1-240645-1	SPACER, SHEAR PLATE	10
-	1	1	240644-1	PLATE, REAR SHEAR	9
-	1	1	7-690618-6	ANVIL, SPLICE TYPE	8
-	1	1	461297-5	BLADE, SHEAR	7
-	1	1	690816-5	ANVIL, INSULATION	6
-	-	-	-	-	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1-1803108-1	CRIMPER, INSULATION O	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	1	8-1803188-4	CRIMPER, WIRE	1
-	77	22	21	PART NO	ITEM NO

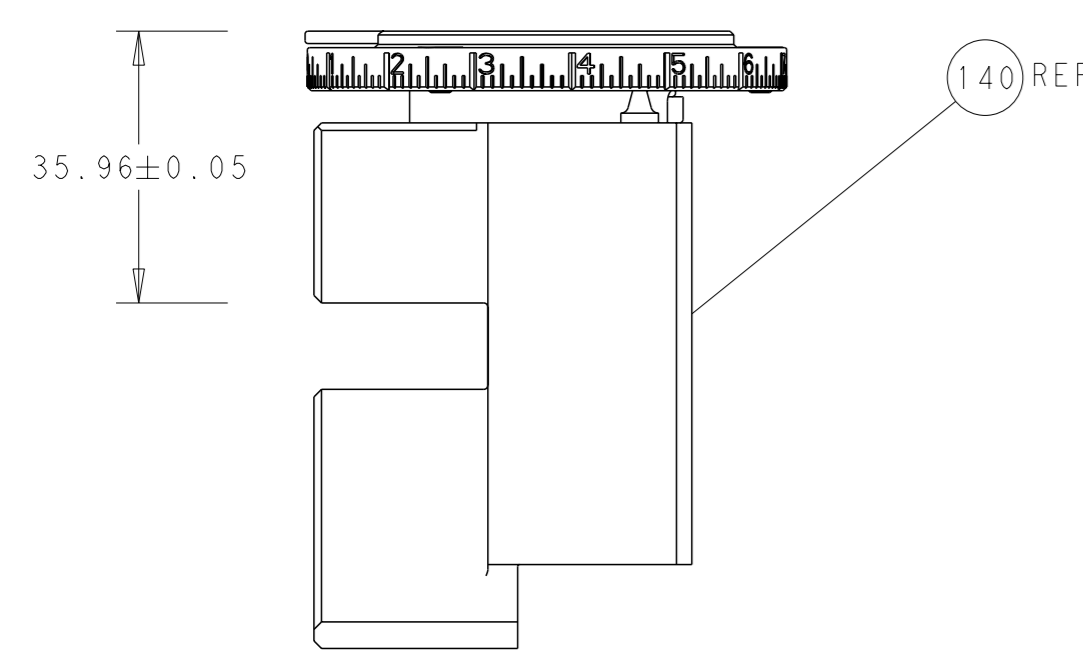
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH		APVD			
MATERIAL				WEIGHT		SCALE	SHEET
						1:1	3 of 4



Ocean End Feed
Applicator

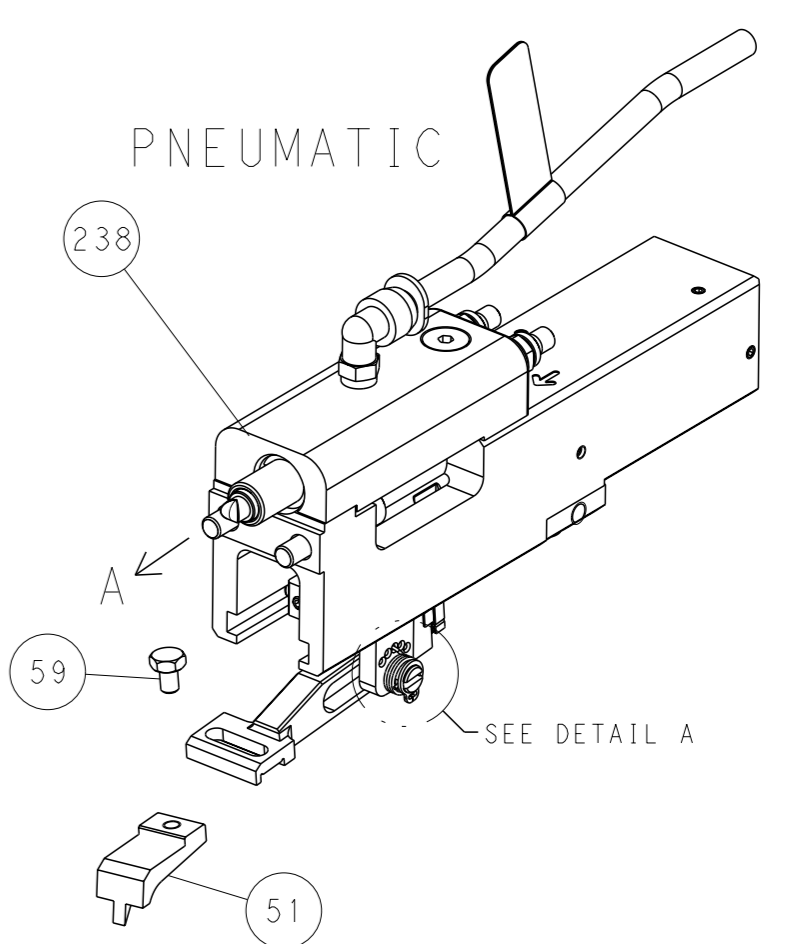
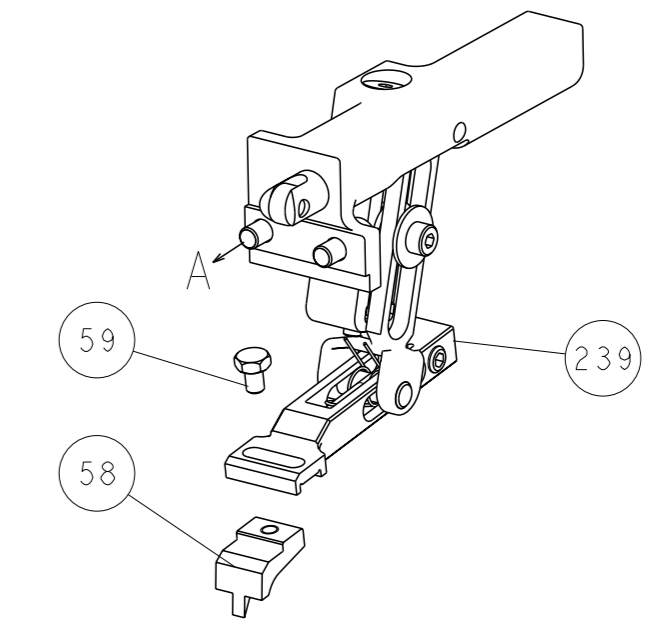
00779 ©=2150900

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

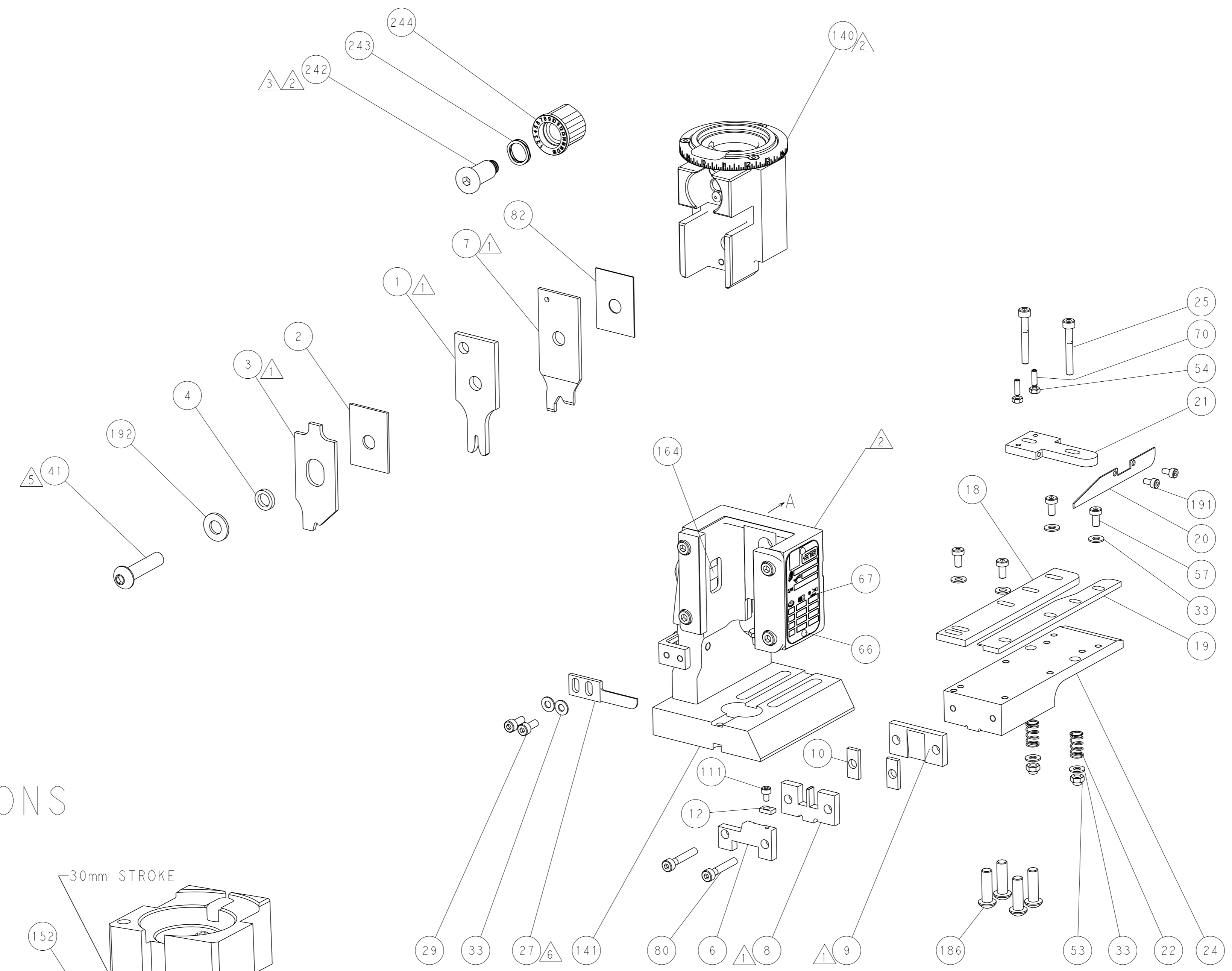
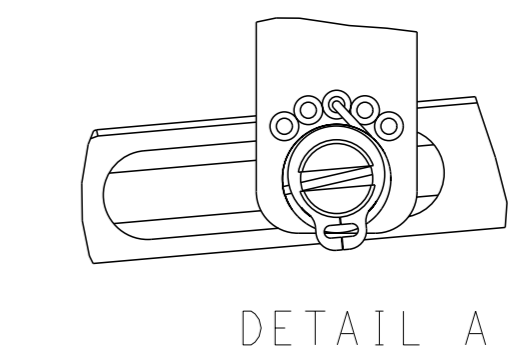


RAM SET-UP

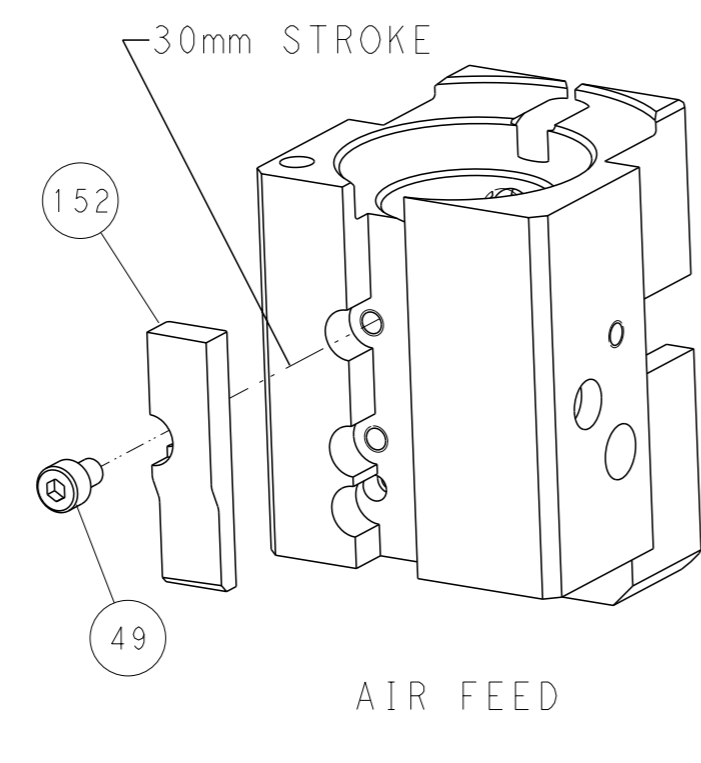
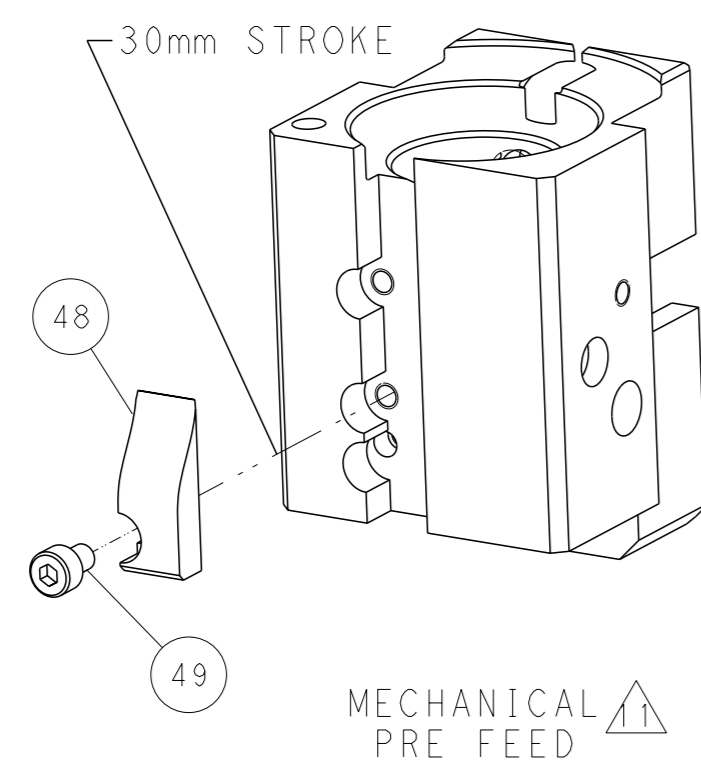
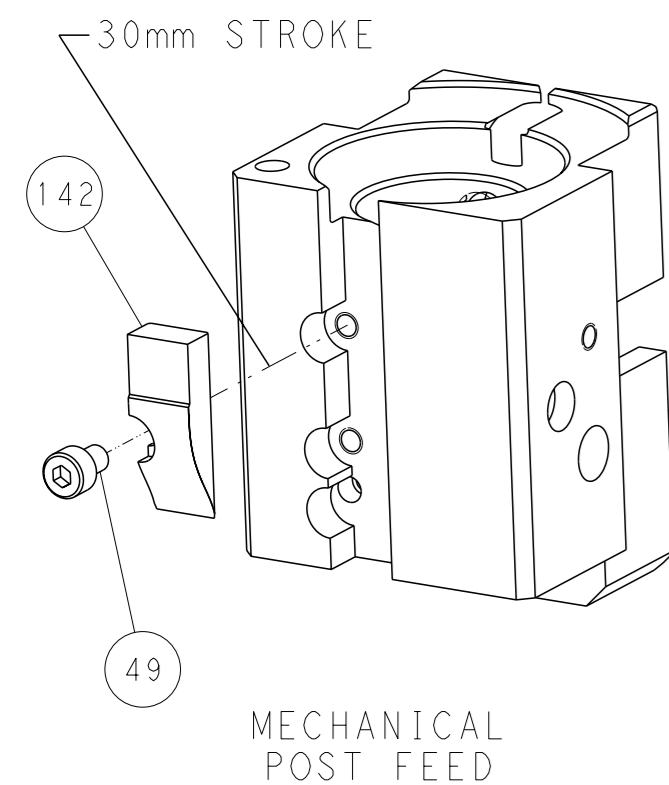
FEED TYPE
 MECHANICAL



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		OWN: B. WEAVER 01MAR2018 CHK: T. ELBIN 01MAR2018 APVD: T. ELBIN 01MAR2018 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150900 SCALE: 1:1 SHEET: 4 of 4 REV: D	
MATERIAL:				RESTRICTED TO:		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	