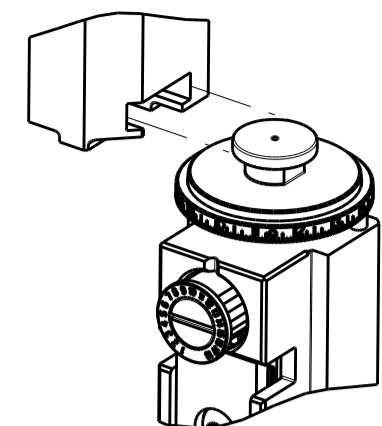


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150919-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150919-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150919-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150919-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150919-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 X 0,8 DIN FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.60-5.60 mm [.181-.220 IN]		Ø1.95-2.60 mm [.077-.102 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
3311200-1	RSB 8178.1108 F 6.3-1	3311200-2	RSB 8178.108 F 6.3-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ² OR 18AWG	1.27 +/- 0.05 [.050 +/- .002]	5.6
0.75mm ² OR 20AWG	1.17 +/- 0.05 [.046 +/- .002]	6.8
0.50mm ² OR 22AWG	1.09 +/- 0.05 [.043 +/- .002]	7.8

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

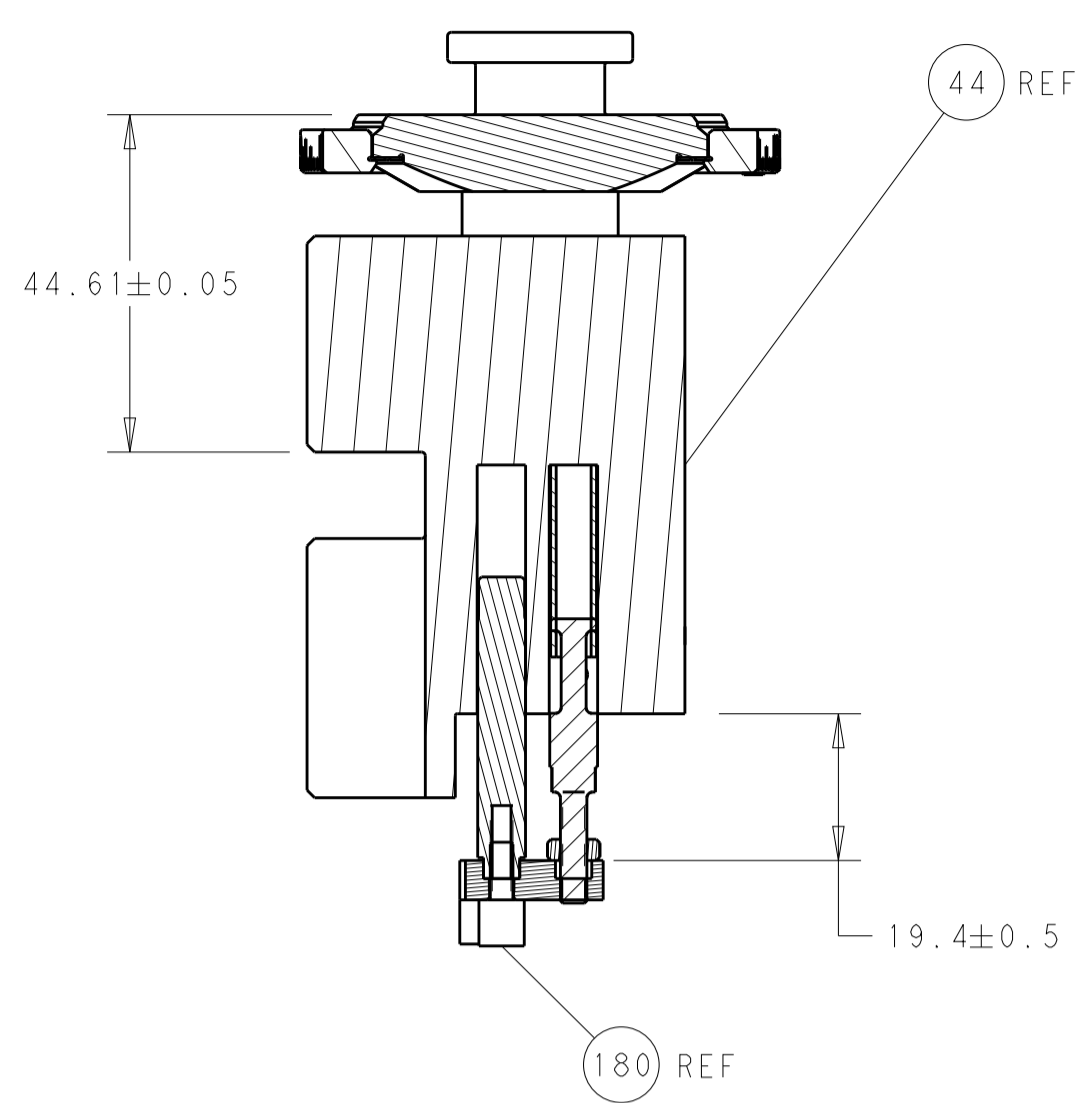
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	19APR2018	TB	CT
		A		RELEASED	31MAY2018	TB	CT
		B		ECR-18-009943	26JUN2018	VLA	TE
		C		ECR-20-003179	04MAR2020	FZ	TE

-	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	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	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1	1	1752354-9	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2063961-3	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2063961-3	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	1803152-4	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-4	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
	1	2	2	1	1803711-4	ANVIL, COMBINATION, END FEED	8	
	-	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-5	SPACER	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	8-1803017-0	CRIMPER, INSULATION F	3
-	-	-	-	-	-	-	2	
	1	2	2	1	1	2-456405-7	CRIMPER, WIRE PREMIUM	1
-	-	-	-	-	-	-	1	
					-77-72-71-2-1	PART NO	DESCRIPTION	ITEM NO

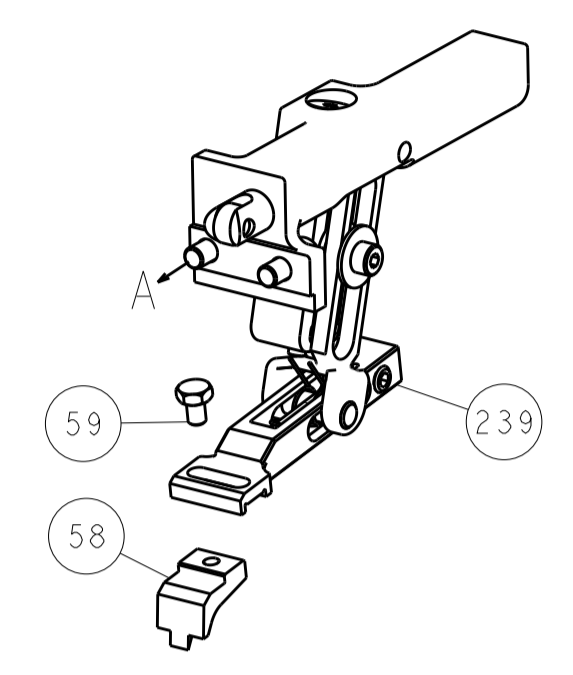
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mm		0 PLC ±		TE Connectivity		Harrisburg, PA 17105-3608		PRODUCT SPEC		Ocean End Feed Applicator	
		1 PLC ±		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
		2 PLC ±		A1		00779		©=2150919		-	
		3 PLC ±		WEIGHT		-		Customer Accessible Production Drawing		SCALE	
		4 PLC ±		SHEET		1		OF		4	
		ANGLES		REV		C					
		FINISH									

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

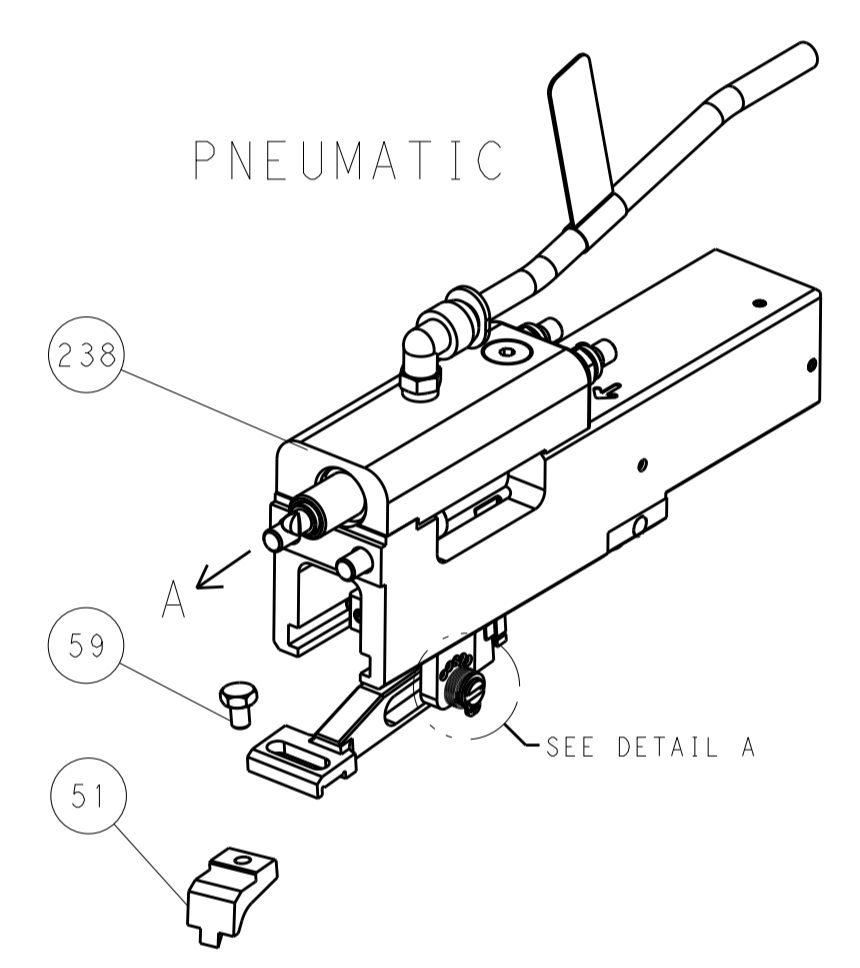


RAM AND HOLDDOWN SET-UP

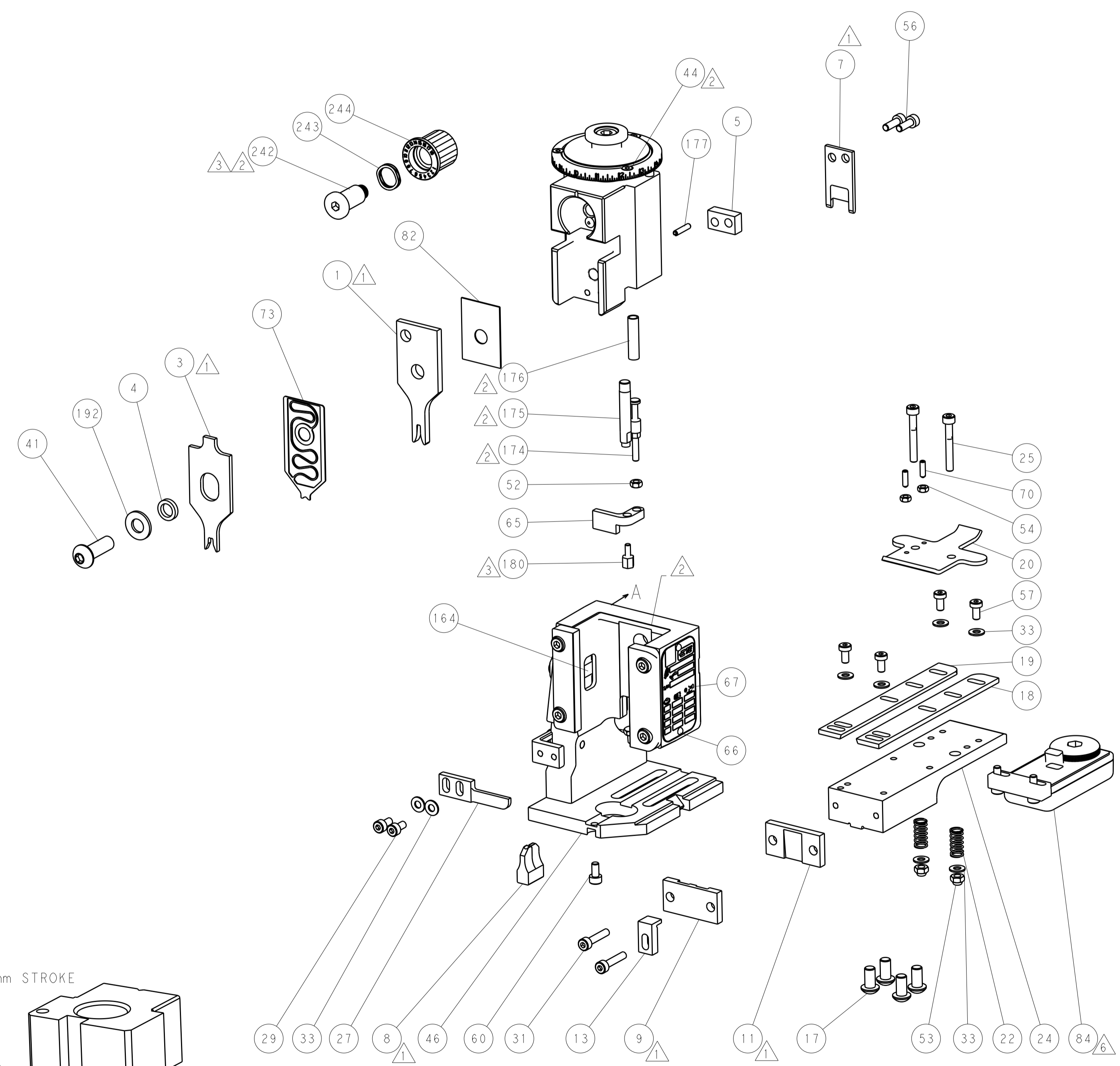
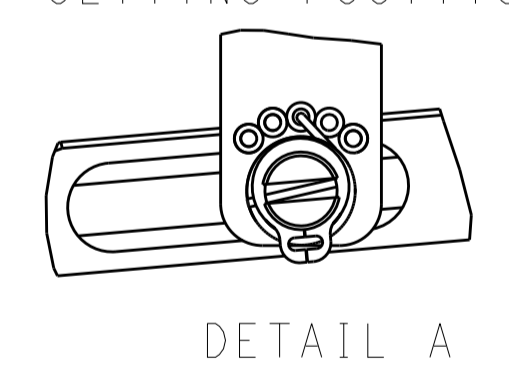
FEED TYPE
MECHANICAL



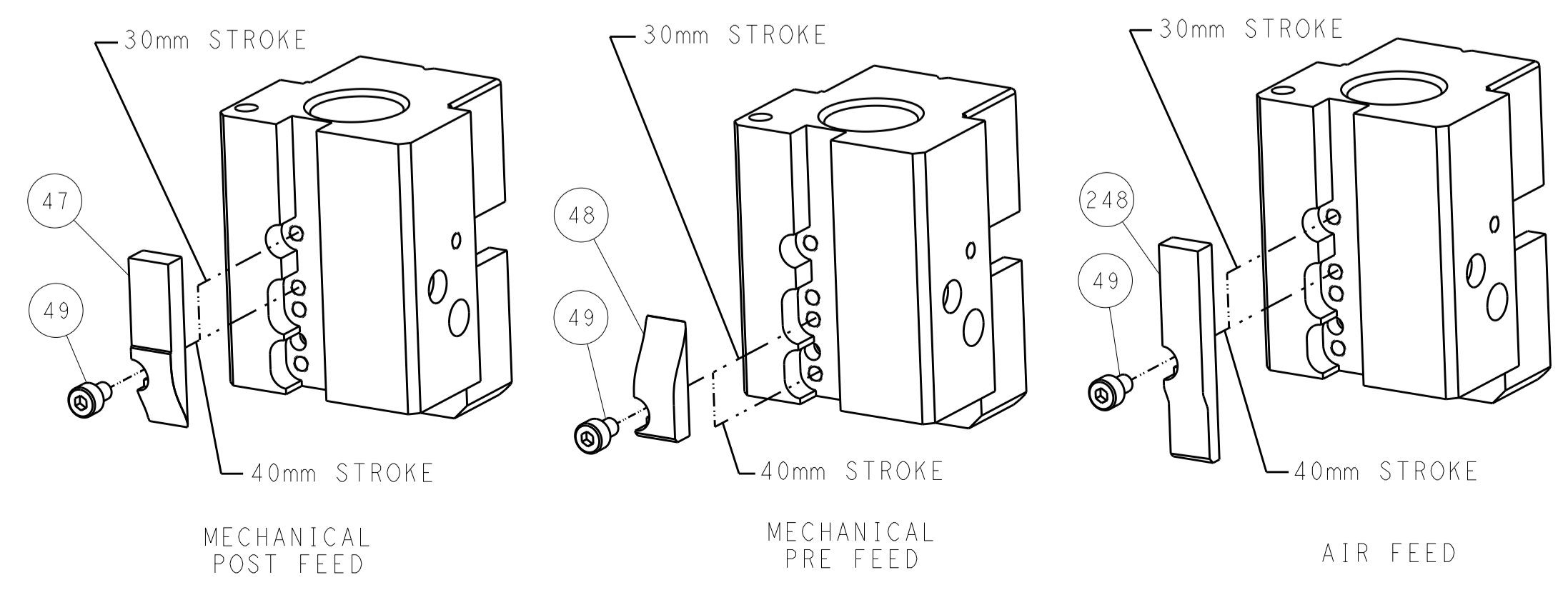
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

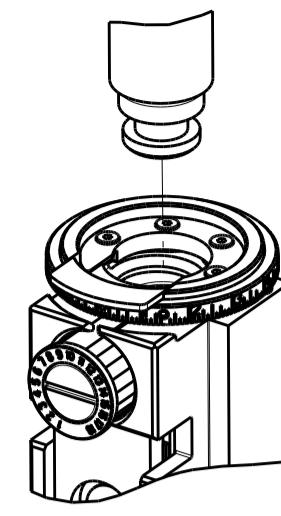


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKENS 19APR2018 CHK M. HERR 19APR2018 APVD C. TOPPER 19APR2018 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150919 SCALE 1:1 SHEET 2 OF 4 REV C	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150919-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150919-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150919-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.30 mm (.130)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 X 0.8 DIN FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.60-5.60 mm (.181-.220 IN)		1.95-2.60 mm (.077-.102 IN)	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
3311200-1	RSB 8178.1108 F 6.3-1	3311200-2	RSB 8178.108 F 6.3-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ² OR 18AWG	1.27 +/- 0.05 [.050 +/- .002]	5.6
0.75mm ² OR 20AWG	1.17 +/- 0.05 [.046 +/- .002]	6.8
0.50mm ² OR 22AWG	1.09 +/- 0.05 [.043 +/- .002]	7.8

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

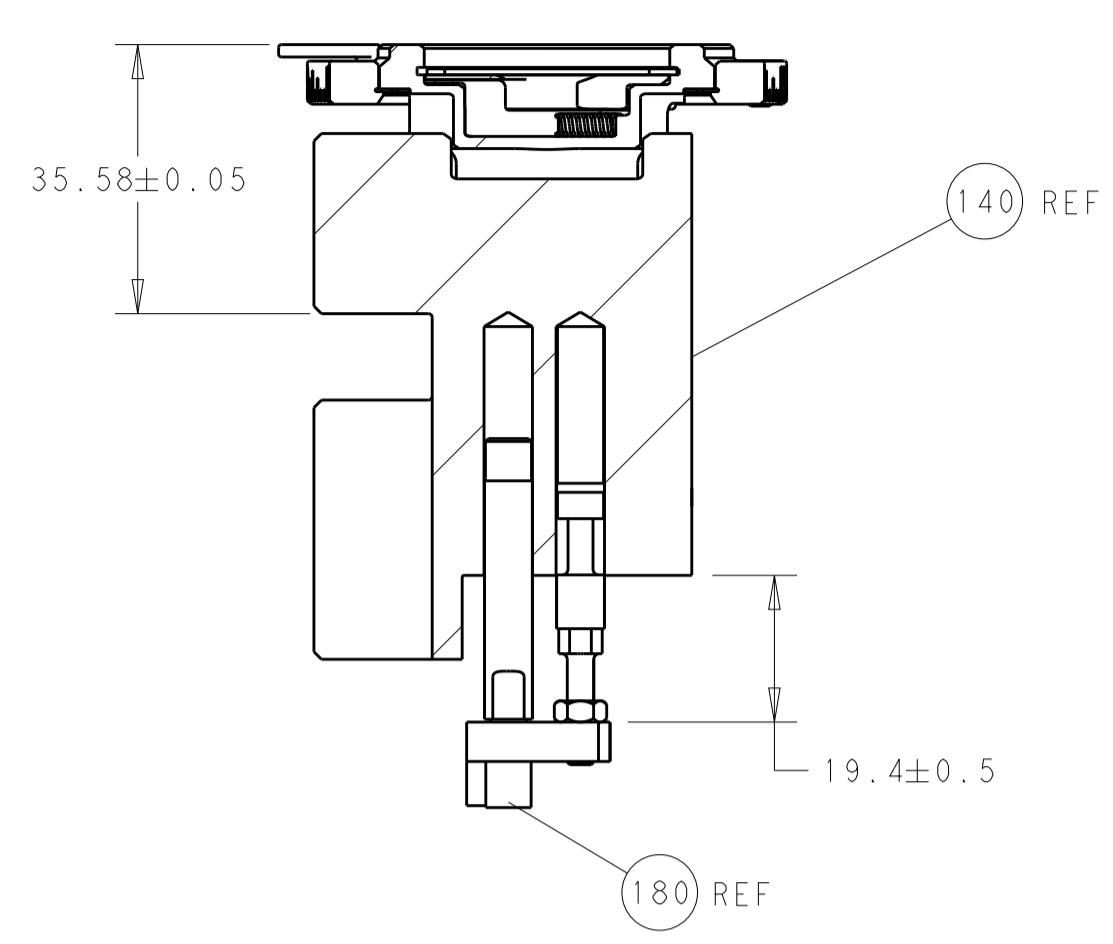
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
	-	1	1752354-9	STANDOFF, HOLD-DOWN	180	
-	1	1	6-993111-6	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	-	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	2119791-5	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-3	FEED FINGER	58	
-	4	4	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	-	2063961-3	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	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	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	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1803152-4	STRIP GUIDE, REAR	19	
-	1	1	1803151-4	STRIP GUIDE, FRONT	18	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	-	1	690482-5	PLATE, FRONT SHEAR	9	
	1	1	1803711-4	ANVIL, COMBINATION, END FEED	8	
	-	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	2-240641-5	SPACER	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	1	1-1803017-0	CRIMPER, INSULATION F	3	
-	-	-	-	-	2	
	1	1	1-456405-7	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

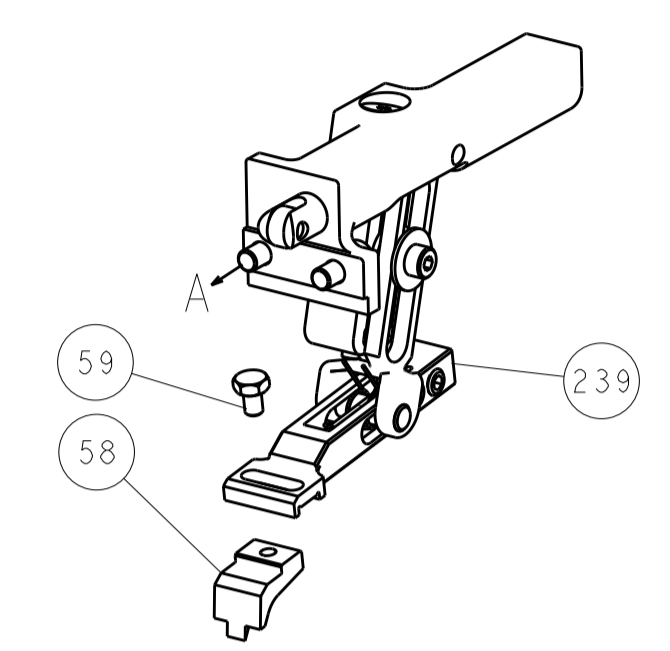
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	T. BROOKENS	19APR2018	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK	M. HERR	19APR2018	
MATERIAL:		FINISH:		APVD	C. TOPPER	19APR2018	NAME
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				WEIGHT	A1	00779	3 of 4
				Customer Accessible Production Drawing		SCALE	1:1
						SHEET	3 of 4
						REV	C

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

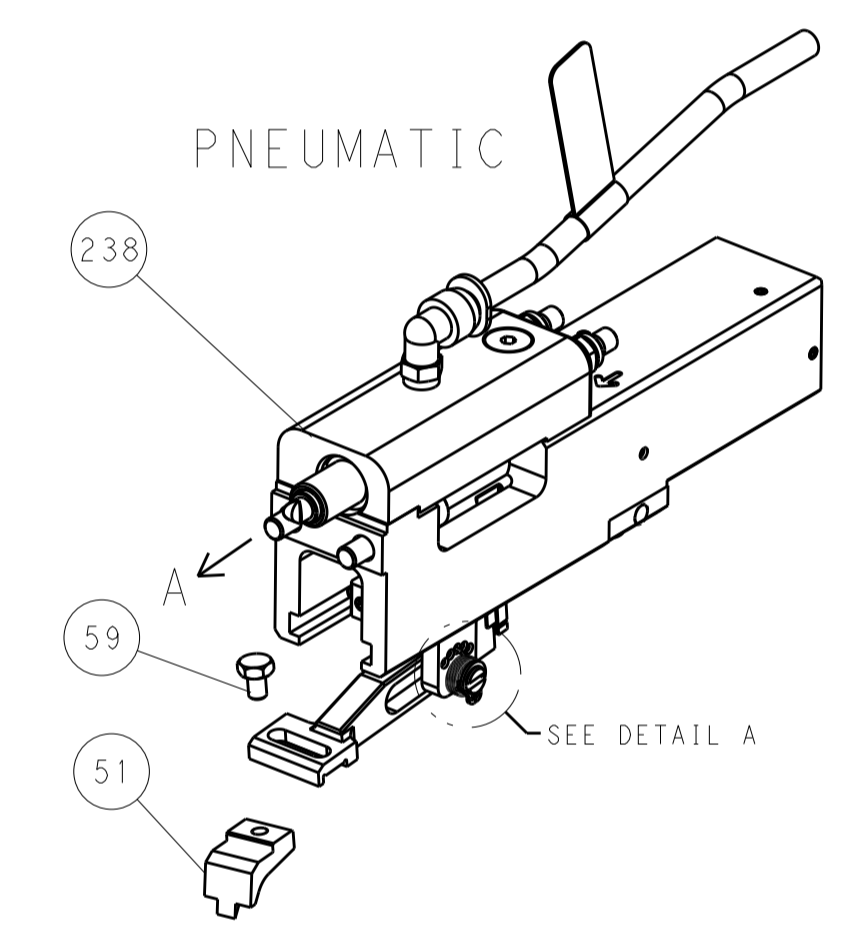


RAM AND HOLDDOWN SET-UP

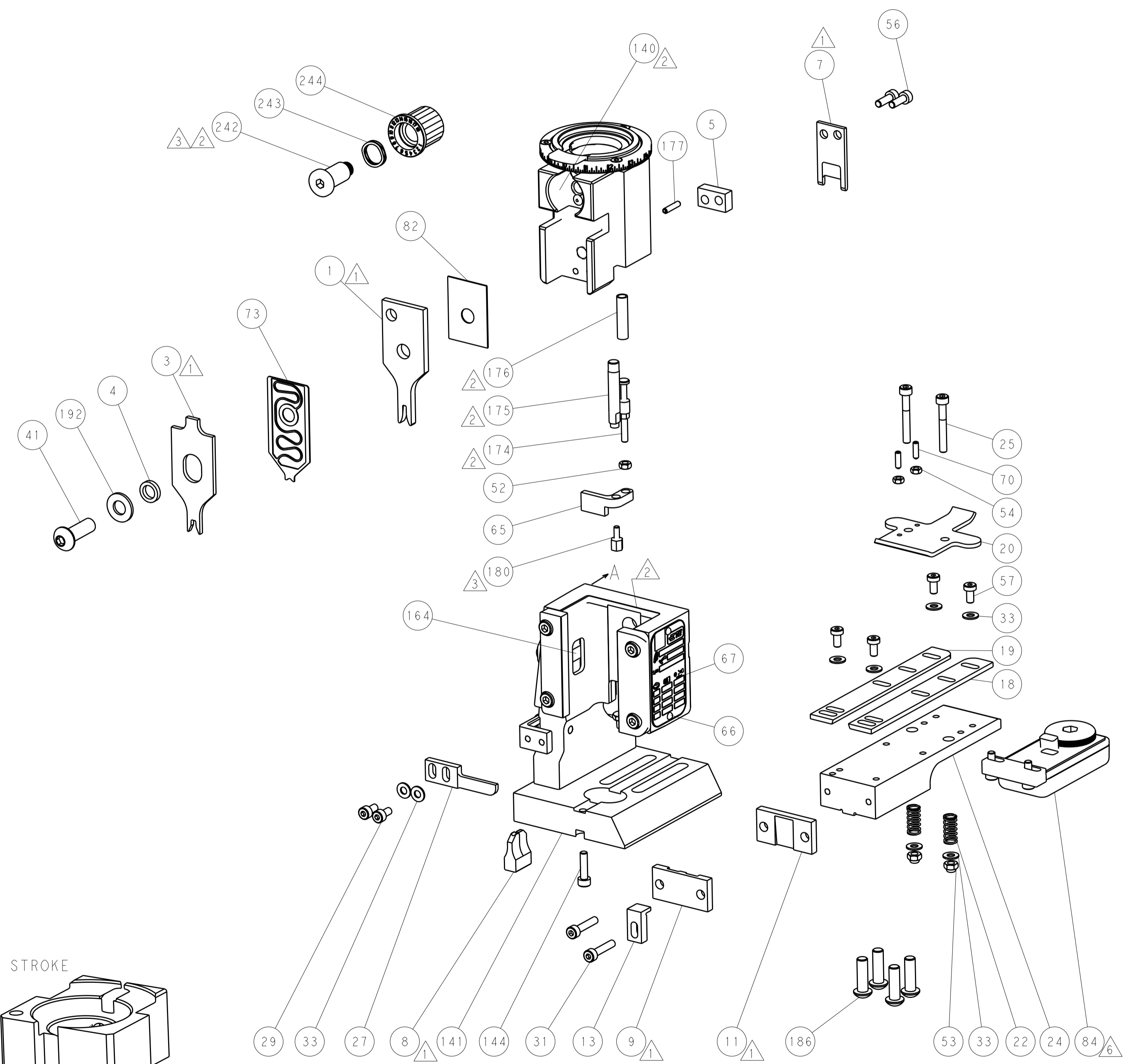
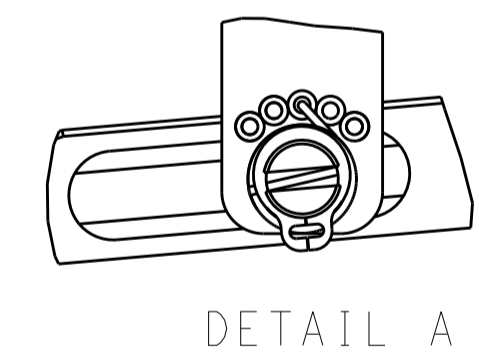
FEED TYPE
MECHANICAL



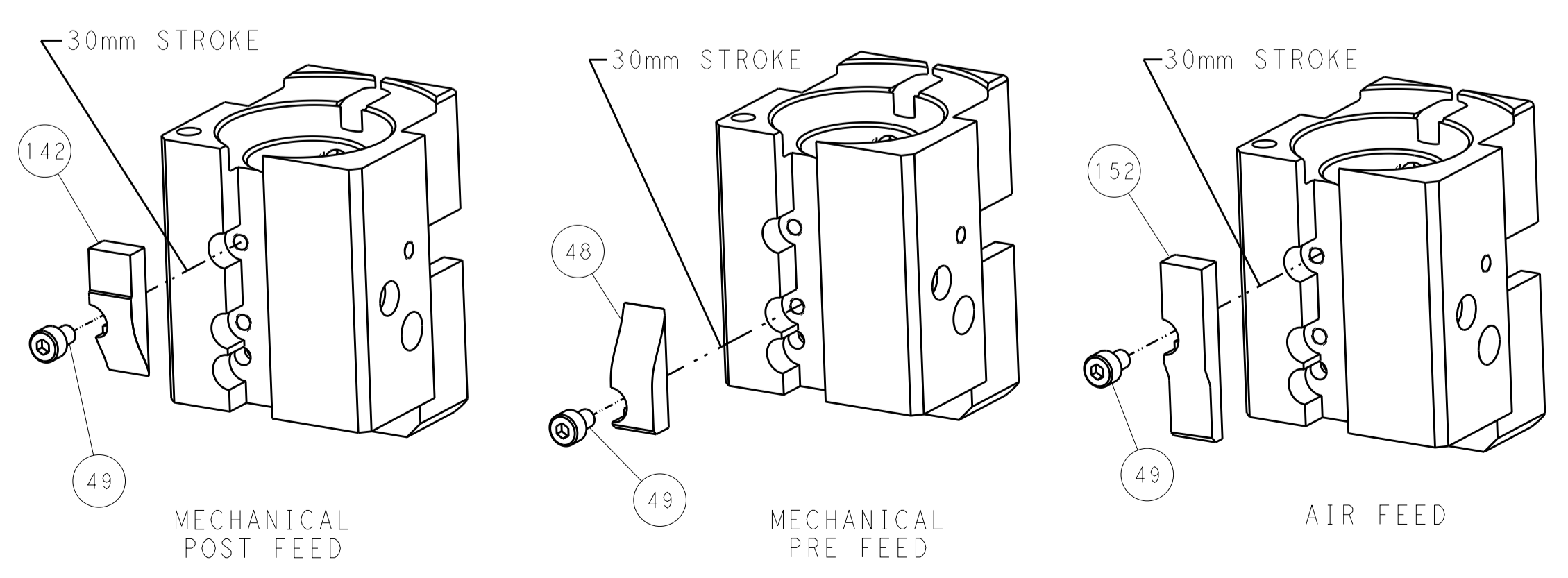
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: T. BROOKS 19APR2018		CHK: M. HERR 19APR2018		APVD: C. TOPPER 19APR2018		NAME: Ocean End Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
	1 PLC	±		SCALE	1:1						
	2 PLC	±		SHEET	4	OF	4				
	3 PLC	±		REV							
	4 PLC	±									
	ANGLES	±									
MATERIAL:	FINISH:	WEIGHT:	Customer Accessible Production Drawing								
				A11 00779 ©=2150919							