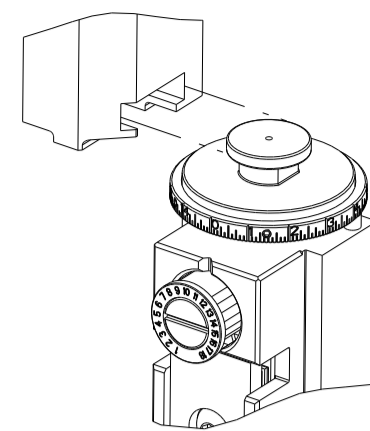


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150920-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150920-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150920-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150920-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150920-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SPRING SPADE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.55-5.31 mm [.179-.209 IN]		∅2.54-3.56 mm [.100-.140 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63268-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.54+/-0.05 [.100+/- .002]	5.4
16 AWG	2.36+/-0.05 [.093+/- .002]	6.4
18 AWG	2.24+/-0.05 [.088+/- .002]	8.4

- 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.
- OVERALL TERMINAL LENGTH AFTER CRIMPING 17.53±0.38 [.690±.015] PER TERMINAL CUSTOMER DRAWING 63268.

***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.

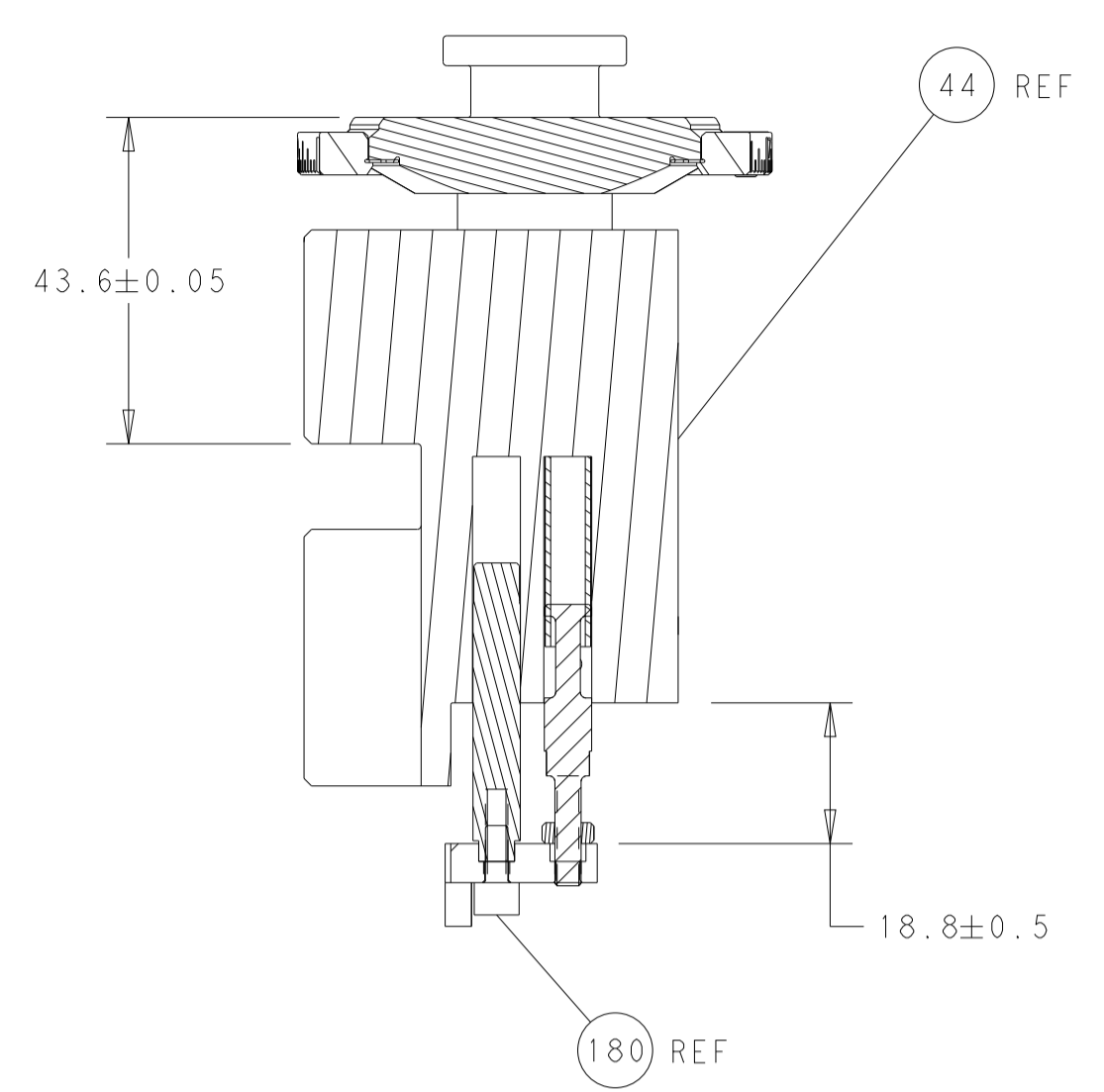
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	28APR2018	MZ	KZ
		A		RELEASED	19JUN2018	TB	GB
		B		ECR-22-149762	18AUG2022	FZ	TE

-	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	1752354-2	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	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	2	2	2	2	2119791-9	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	2063961-1	FEED FINGER	58	
-	3	3	3	3	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	-	2063961-1	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	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	7	7	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	
-	1	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	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	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	2	2	5-240645-5	SPACER, SHEAR PLATE	10	
-	1	1	1	1	1803322-1	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	4-1803257-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-9	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-240641-2	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	456411-3	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	ITEM NO	

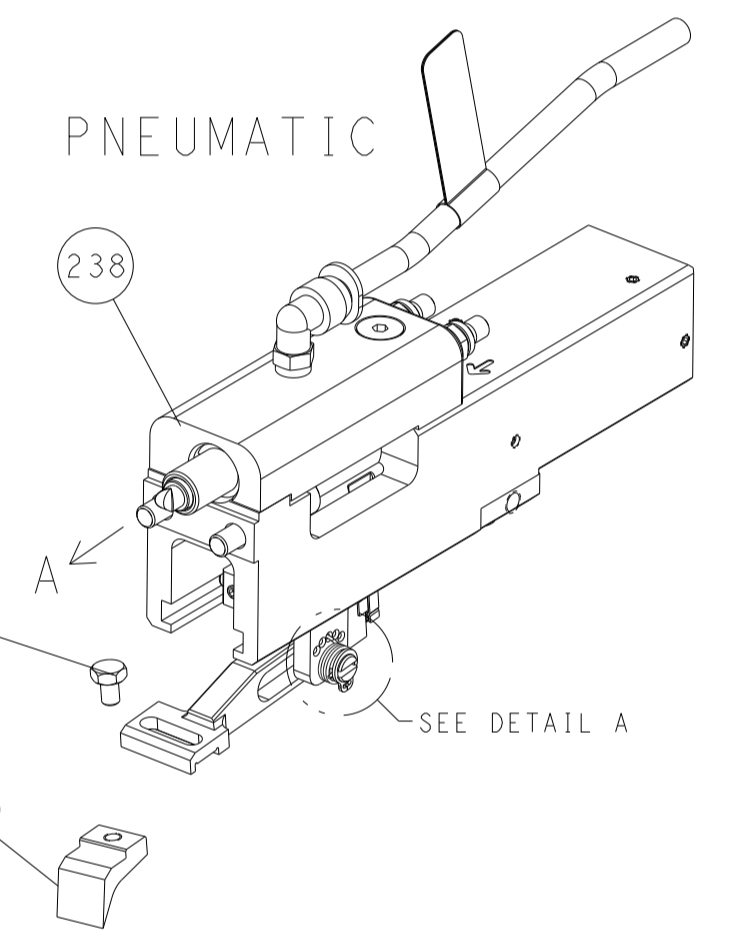
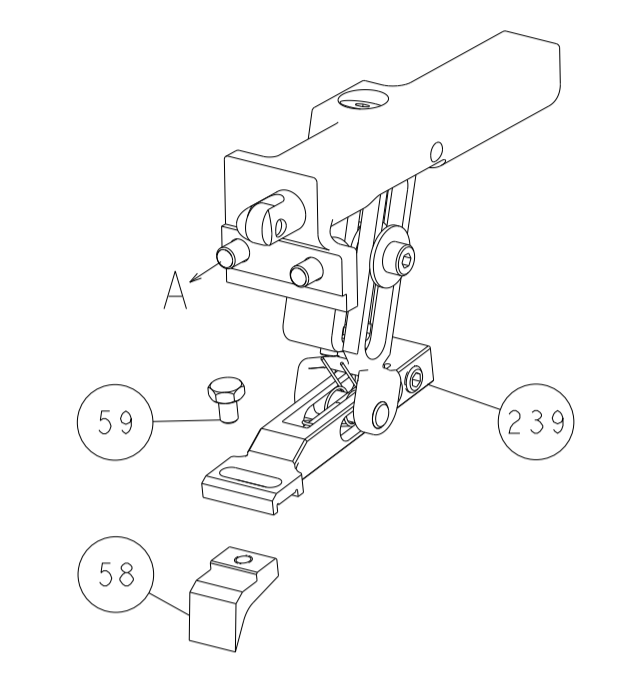
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mm	0 PLC	±													
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													
	FINISH														

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

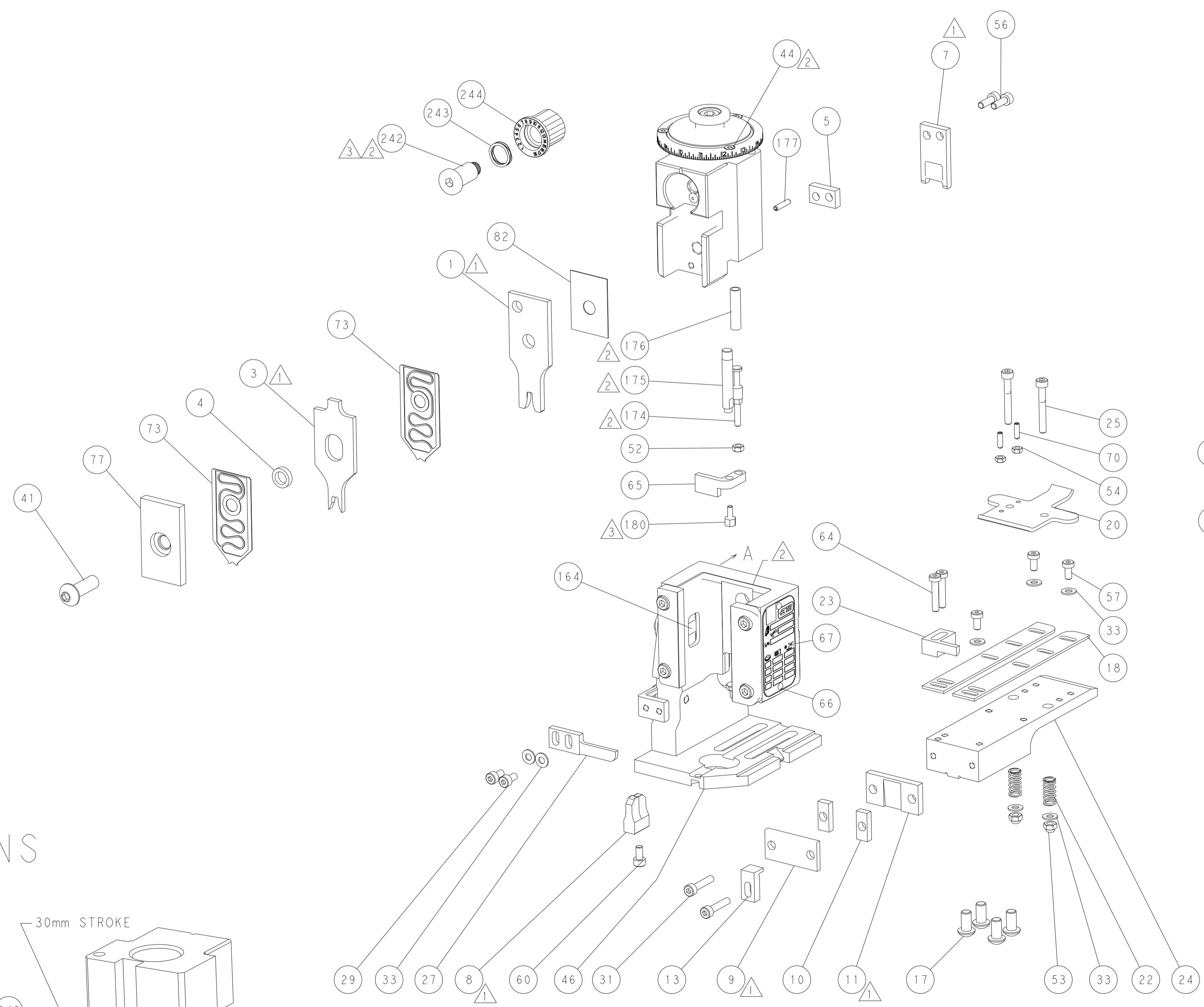
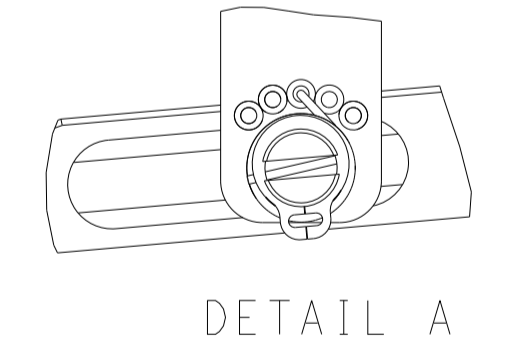


RAM AND HOLDDOWN SET-UP

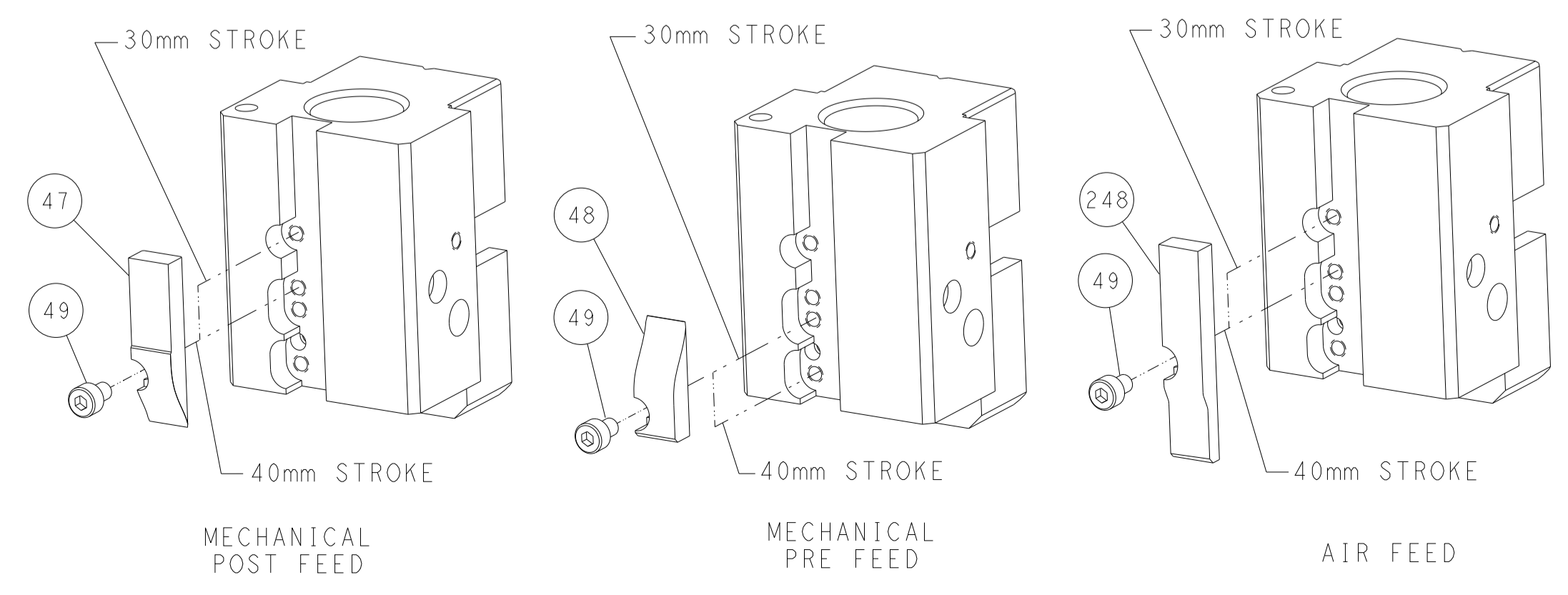
FEED TYPE
MECHANICAL



FEED SPRING
SETTING POSITION



CAM POSITIONS

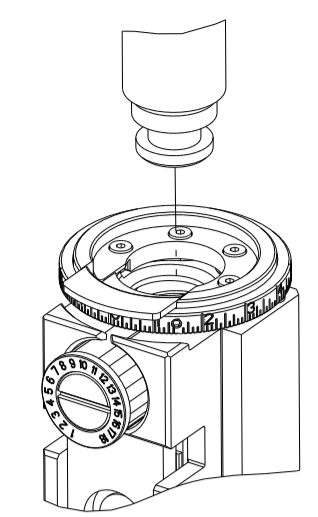


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN M. ZHAO 28APR2018 CHK K. ZHANG 28APR2018 APVD K. ZHANG 28APR2018 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150920 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV B	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				STE TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150920-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150920-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150920-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	4.57 mm [1.80]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, SPRING SPADE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.55-5.31 mm [1.79-.209 IN]	∅2.54-3.56 mm [1.00-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63268-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.54 +/- 0.05 [1.00 +/- .002]	5.4
16 AWG	2.36 +/- 0.05 [1.093 +/- .002]	6.4
18 AWG	2.24 +/- 0.05 [1.088 +/- .002]	8.4



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 OVERALL TERMINAL LENGTH AFTER CRIMPING 17.53±0.38 [1.690±.015] PER TERMINAL CUSTOMER DRAWING 63268.

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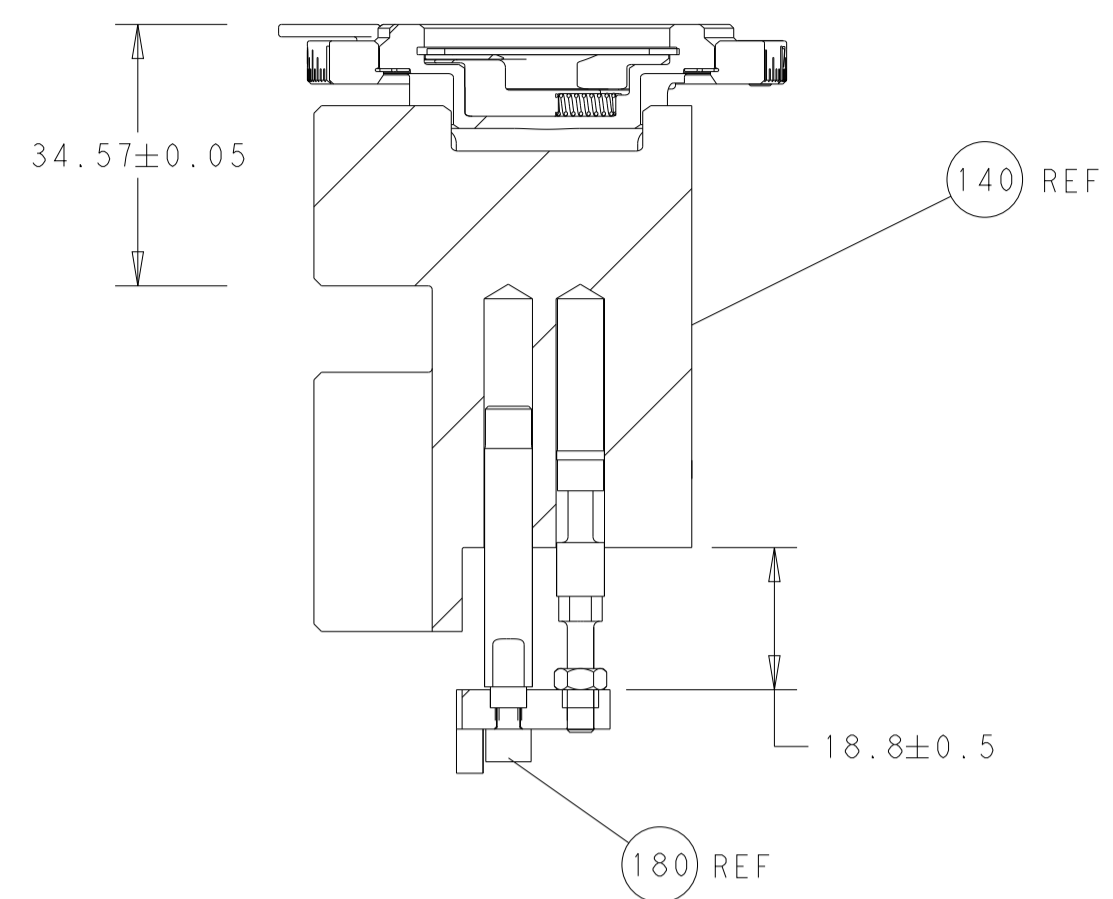
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	ITEM NO
-	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	2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1 -	2844940-3 AIR FEED MODULE	238
-	4 4	2079383-9 SCR, BHSC, RoHS (M6 X 20)	186
-	1 1	1752354-2 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 1	1803518-1 RAM ASSEMBLY, EF PACIFIC	140
-	1 1	455888-4 SPACER, CRIMPER	82
-	1 1	1803203-1 BLOCK, FRONT DEPRESSOR	77
-	2 2	2119791-9 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	1901681-5 HOLDDOWN, TERMINAL	65
-	2 2	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20	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	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 -	2063961-1 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	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	240825-3 PLATE, STRIP HOLD DOWN	23
-	2 2	2-22281-3 SPRING, COMPRESSION	22
-	1 1	1803292-4 DRAG	20
-	2 2	1901259-3 GUIDE, LOWER STRIP	18
-	1 1	1752360-1 SPACER, HOLD-DOWN	13
-	1 1	240644-1 PLATE, REAR SHEAR	11
-	2 2	5-240645-5 SPACER, SHEAR PLATE	10
-	1 1	1803322-1 PLATE, FRONT SHEAR	9
1	1 1 1	4-1803257-8 ANVIL, COMBINATION, END FEED	8
1	1 1	9-240651-9 BLADE, SLUG	7
-	- -	-	6
-	1 1	1-240641-2 SPACER	5
-	1 1	238011-2 BLOCK, CRIMPER SPACER	4
1	1 1 1	4-1633962-1 CRIMPER, INSULATION F PREMIUM	3
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1	1 1 1	456411-3 CRIMPER, WIRE PREMIUM	1
-	77-22-21	PART NO DESCRIPTION	ITEM NO

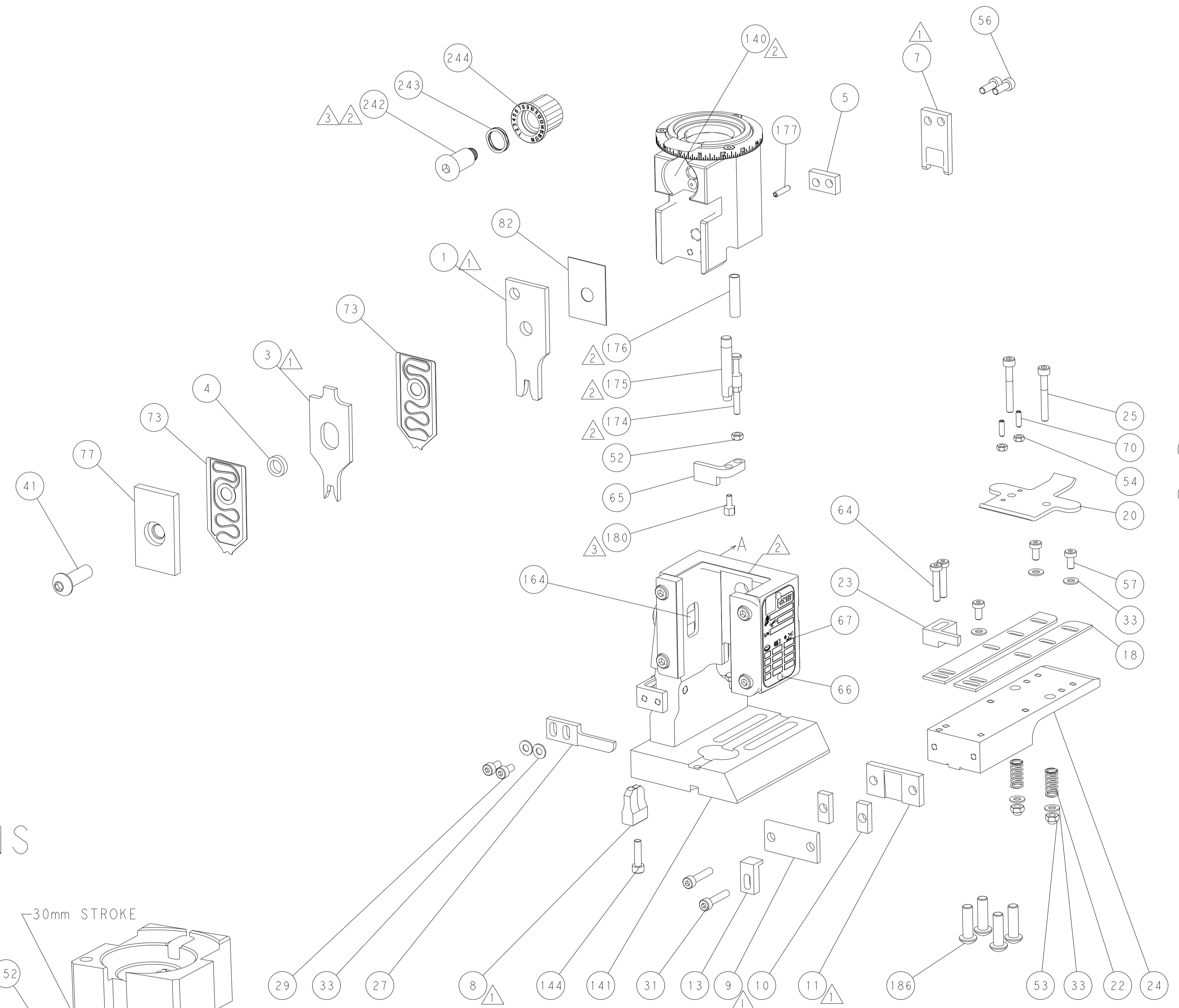
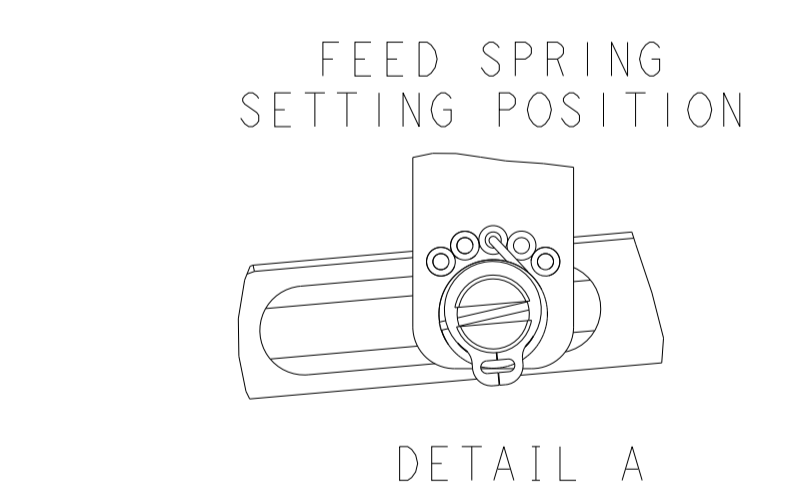
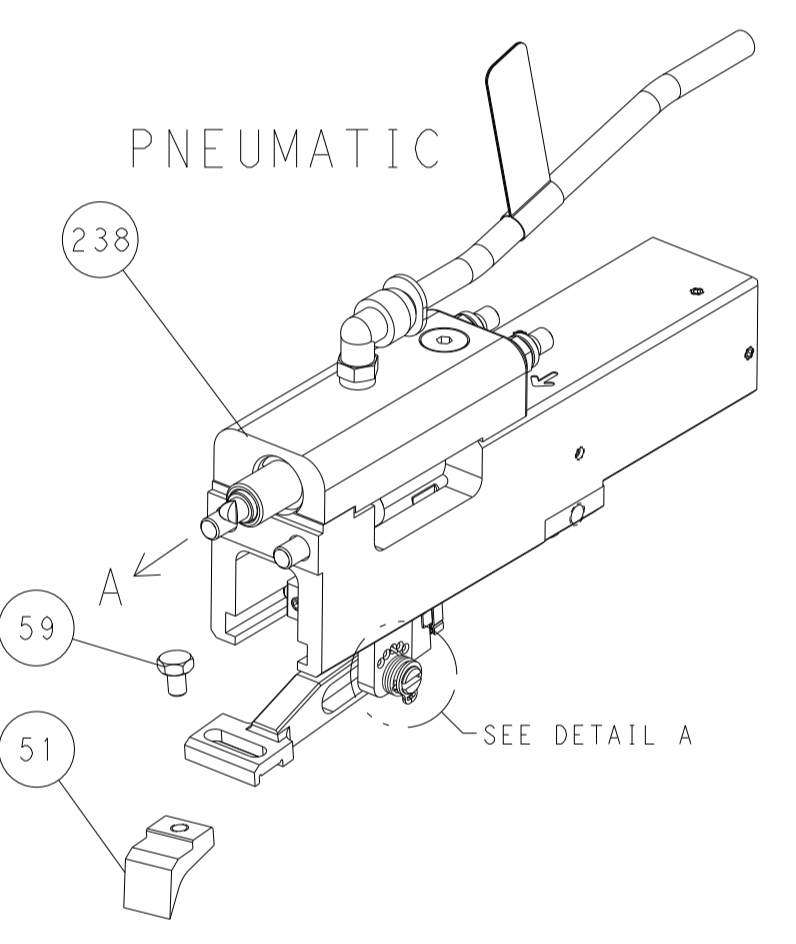
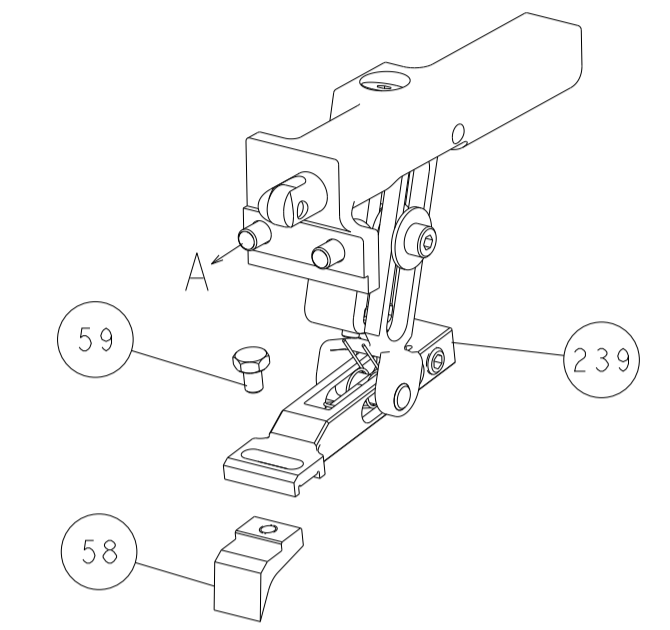
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES ±		FINISH ±		WEIGHT: -		SCALE: 1:1		SHEET: 3 OF 4		REV: B	

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

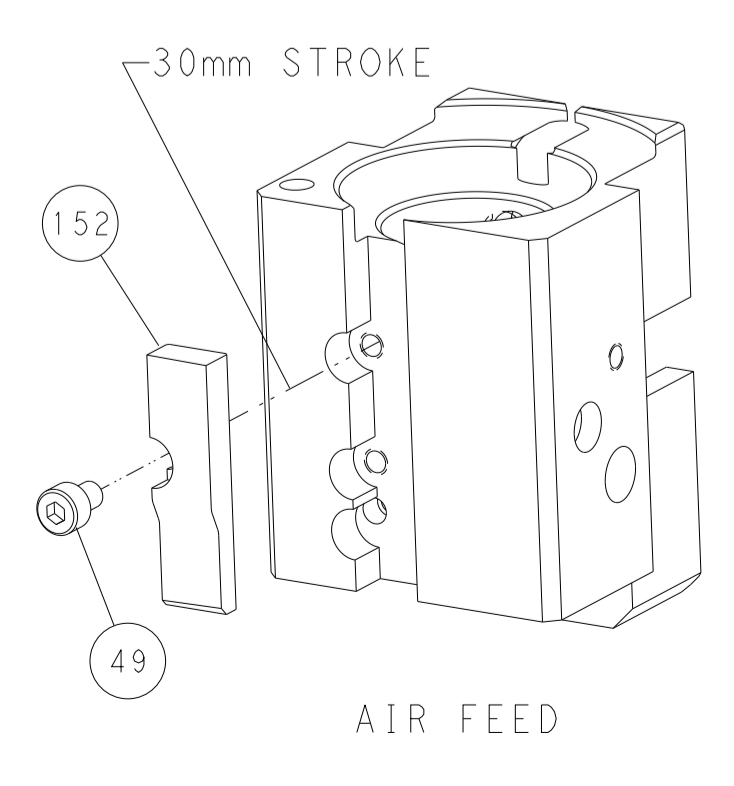
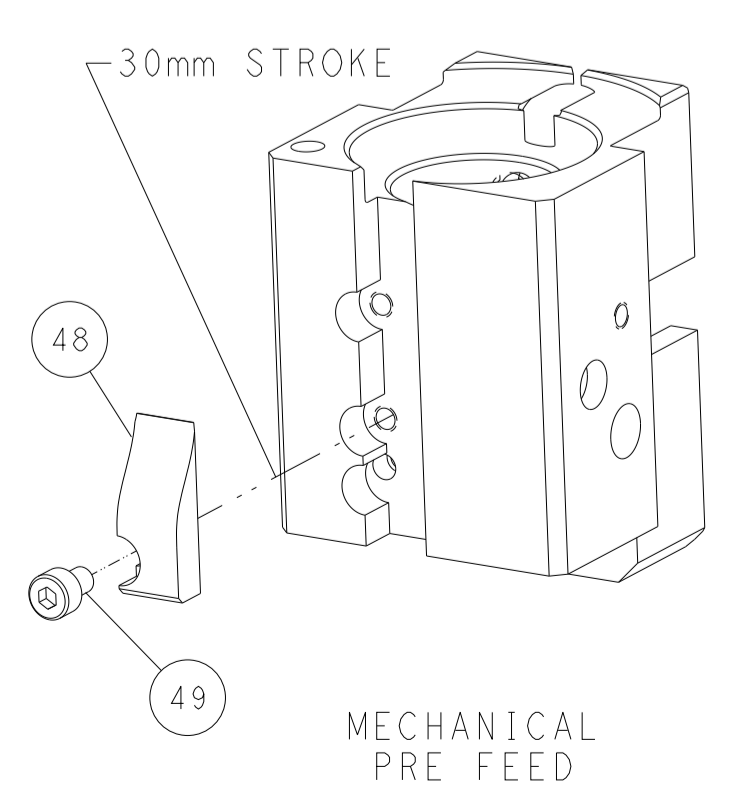
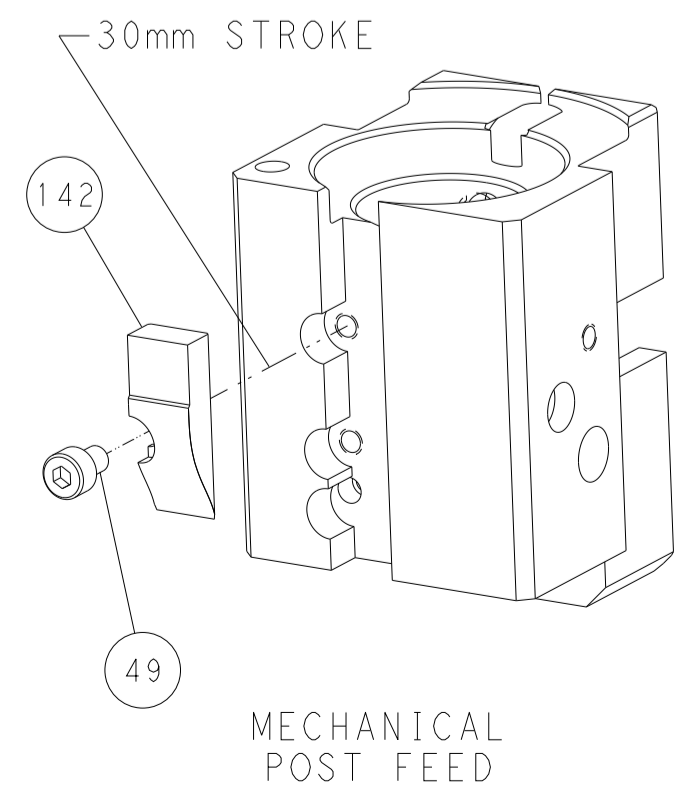


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



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:		DWN M. ZHAO 28APR2018 CHK K. ZHANG 28APR2018 APVD K. ZHANG 28APR2018		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	Customer Accessible Production Drawing
	ANGLES	FINISH	WEIGHT	SCALE	1:1	SIZE	A1
MATERIAL						CAGE CODE	00779
						DRAWING NO	2150920
						SHEET	4
						OF	4
						REV	B