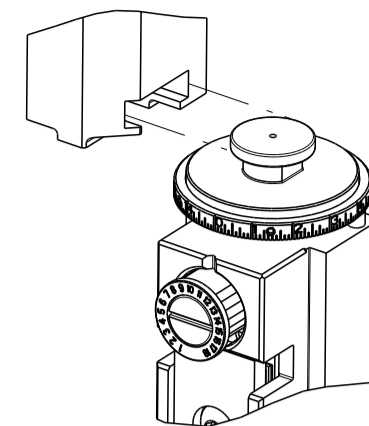


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2150528-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150528-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2150528-7	A	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	4.00 mm [.157]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: QUICK DISCONNECT, FEMALE TERMINAL	
WIRE STRIP LENGTH 5.00-5.60 mm [.197-.220 IN]	INSULATION DIAMETER RANGE Ø2.20-3.40 mm [.087-.134 IN]
TERMINAL APPLICATION SPECIFICATION 63802-5000 Rev C	
TERMINALS APPLIED	
TE TERMINAL 1949471-1	MOLEX TERMINAL 35072-9802

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.84 +/- 0.05 [.072 +/- .002]	4.5
16 AWG	1.68 +/- 0.05 [.066 +/- .002]	6.0
18 AWG	1.52 +/- 0.05 [.060 +/- .002]	7.6



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

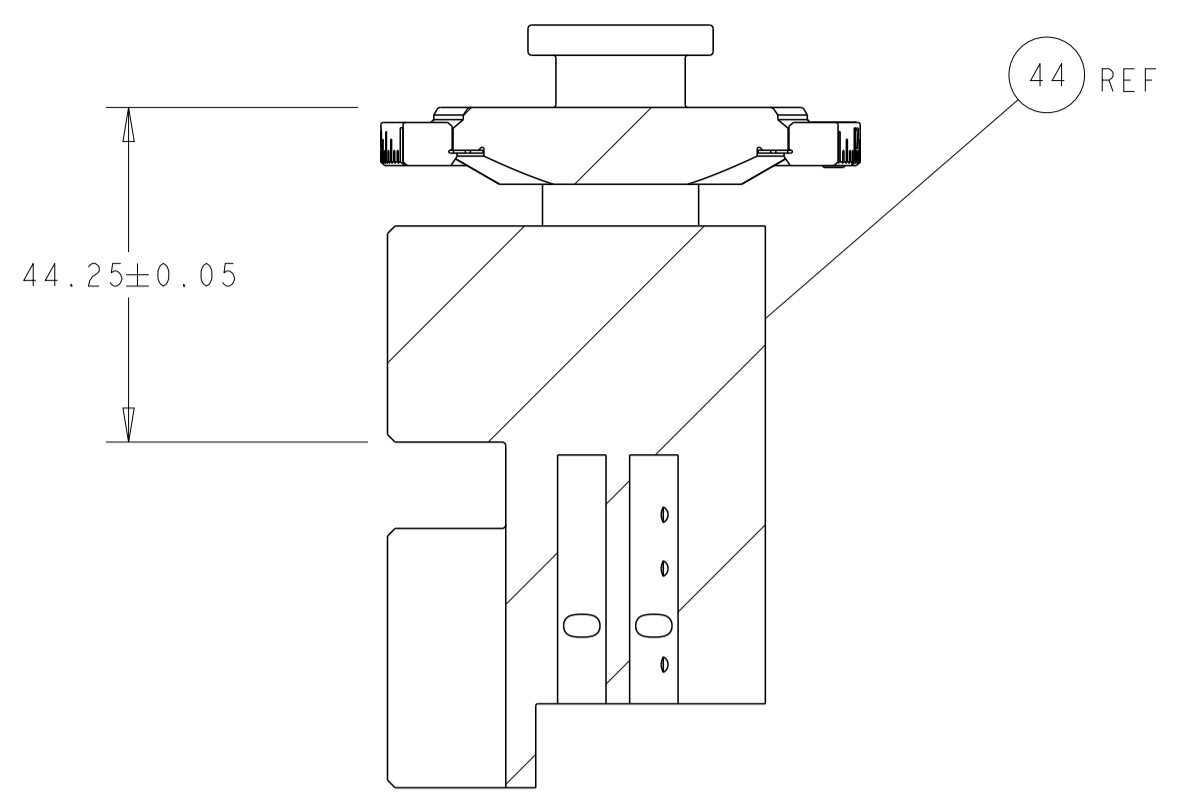
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		A		RELEASED	27FEB2015	GH	TE
		B		ECR-22-151858	07SEP2022	TB	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	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	1	455888-4	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
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	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
-	-	-	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	2063961-9	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2-1752371-8	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	1-1901259-0	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-8	SPACER	16
-	1	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	2	1	1-1803074-1	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	3-240641-0	SPACER	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	2	1	5-1803016-1	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	456408-7	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	ITEM NO
-	-	-	-	DESCRIPTION	

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

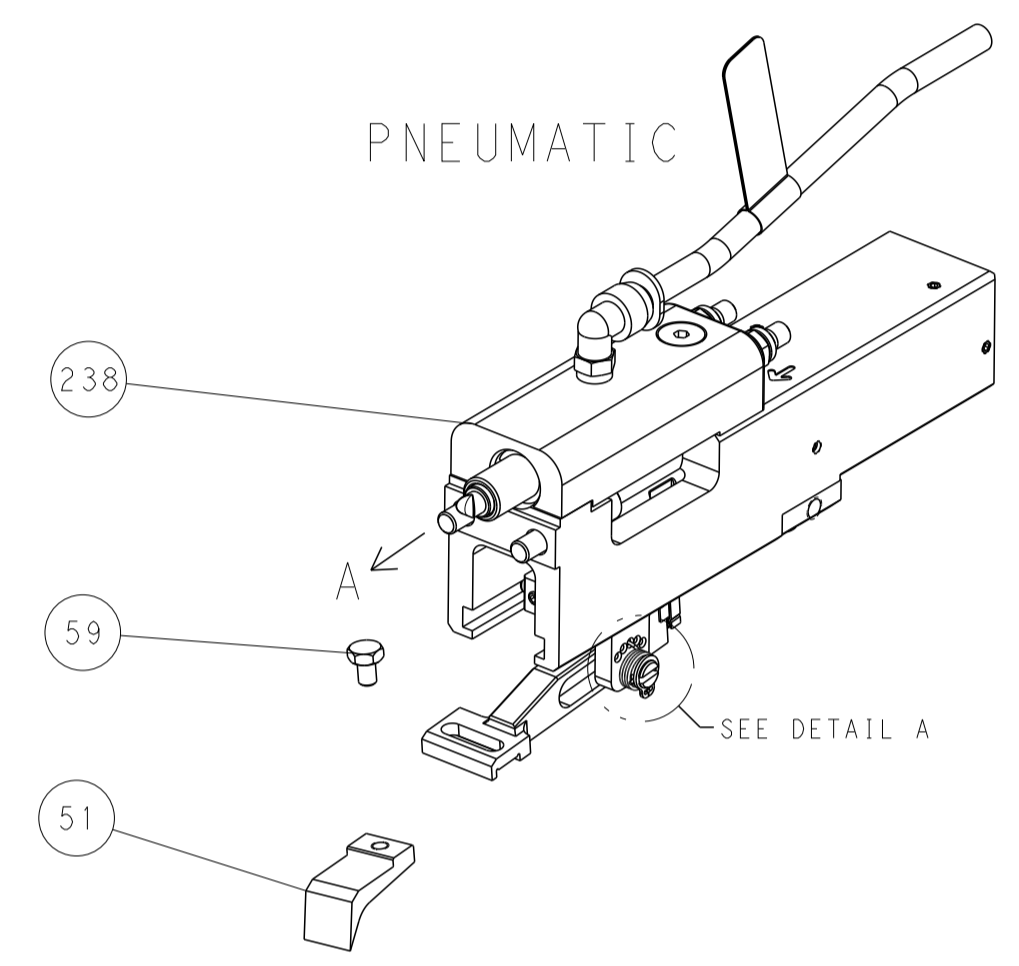
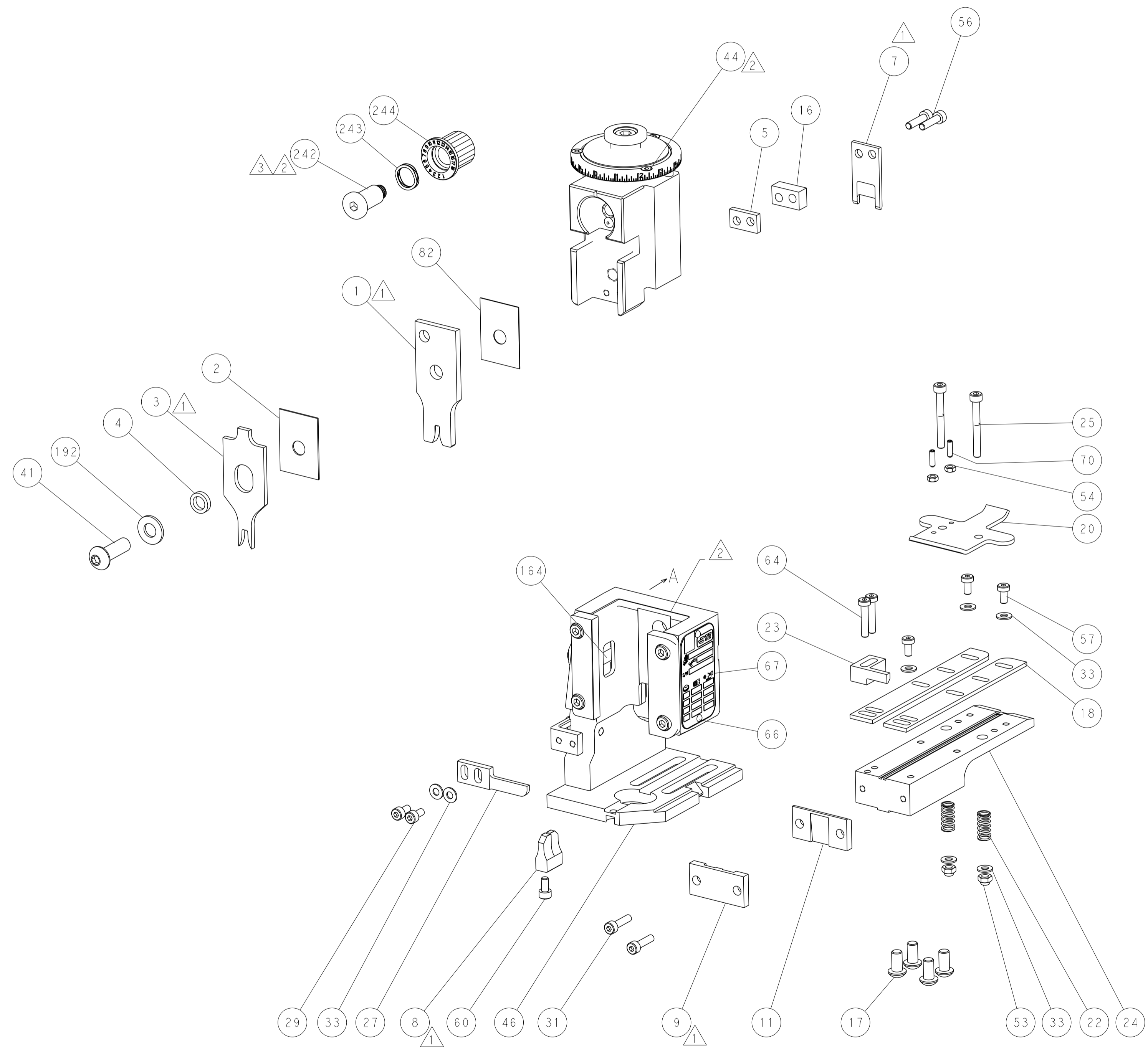
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0 PLC ±		1 PLC ±		CHK: T. ELBIN 28JAN2015		Harrisburg, PA 17105-3608	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 28JAN2015		NAME: Ocean End Feed Applicator	
4 PLC ±		ANGLES FINISH ±		PRODUCT SPEC		SIZE: A1	
MATERIAL: -		FINISH: -		APPLICATION SPEC		CAGE CODE: 00779	
				WEIGHT: -		DRAWING NO: C=2150528	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 1 OF 4 REV B	

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

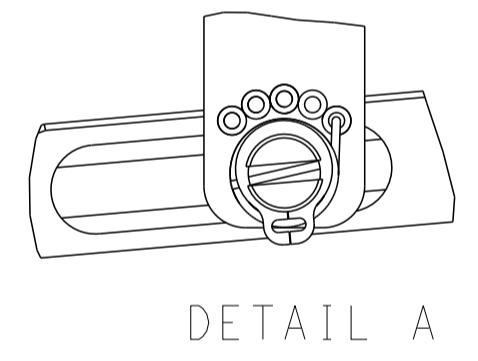


RAM SET-UP

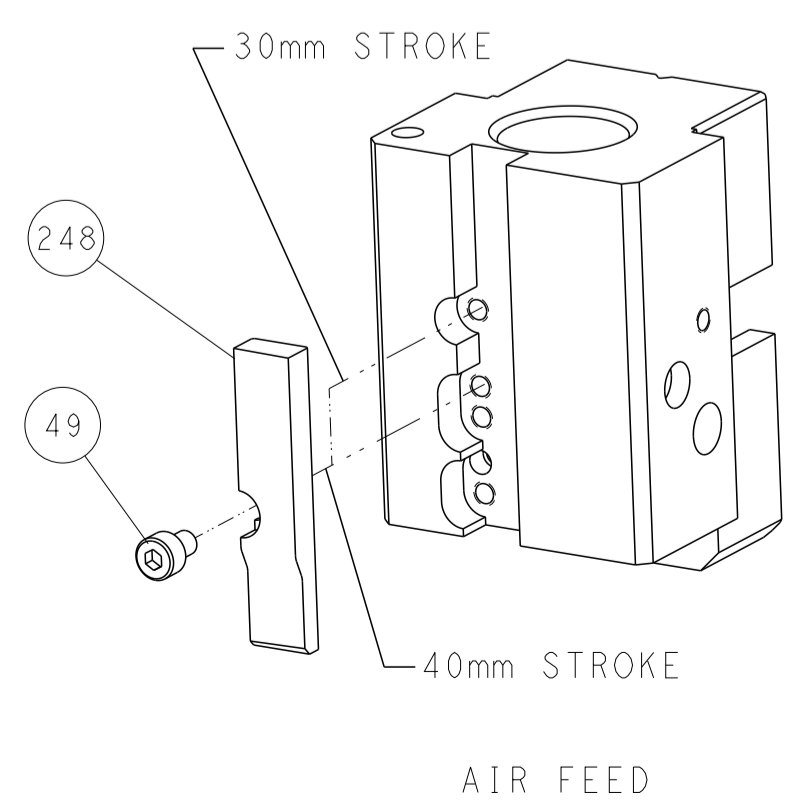
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



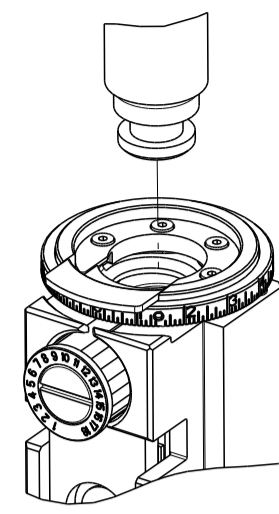
AIR FEED

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150528 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 2 of 4 REV: B	Customer Accessible Production Drawing

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150528-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150528-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	4.00 mm [.157]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: QUICK DISCONNECT, FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-5.60 mm [.197-.220 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 63802-5000 Rev C			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949471-1	35072-9802		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.84 +/- 0.05 [.072 +/- .002]	4.5
16 AWG	1.68 +/- 0.05 [.066 +/- .002]	6.0
18 AWG	1.52 +/- 0.05 [.060 +/- .002]	7.6



- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

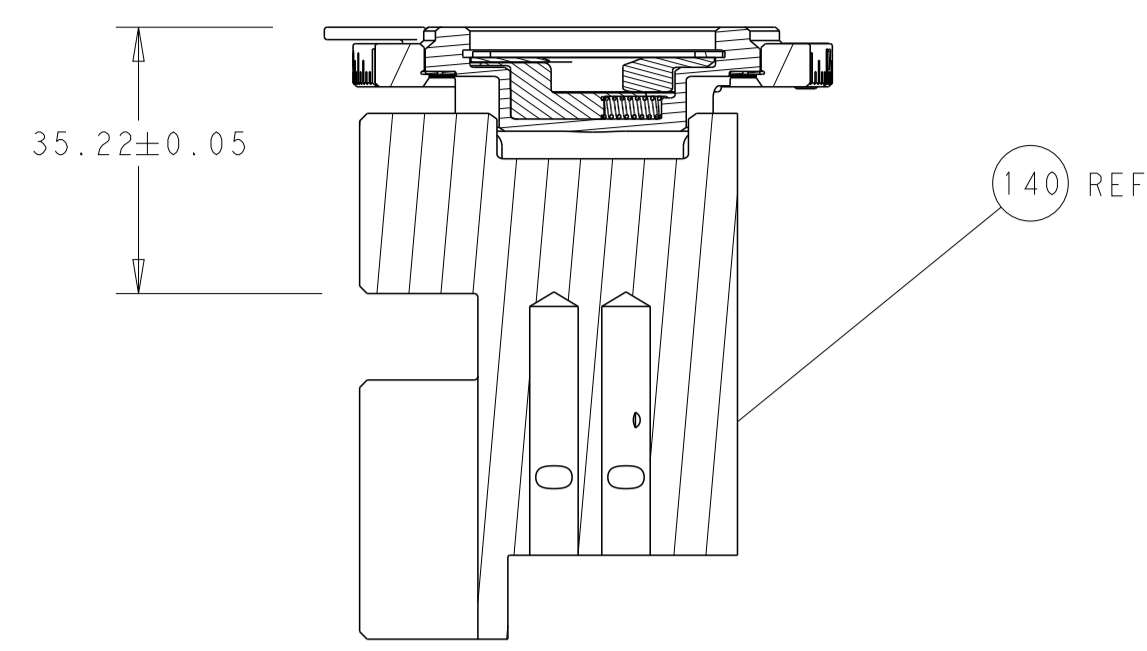
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	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	
-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	455888-4	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	
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	2063961-1	FEED FINGER	58	
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	2063961-9	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	2-1752371-8	PLATE, STRIP GUIDE	24	
-	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1-1901259-0	GUIDE, LOWER STRIP	18	
-	1	6-240641-8	SPACER	16	
-	1	240833-1	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	690482-4	PLATE, FRONT SHEAR	9	
-	1	1-1803074-1	ANVIL, COMBINATION, END FEED	8	
-	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	6	
-	1	3-240641-0	SPACER	5	
-	1	238011-9	BLOCK, CRIMPER SPACER	4	
-	1	5-1803016-1	CRIMPER, INSULATION F	3	
-	1	455888-7	SPACER, CRIMPER	2	
-	1	456408-7	CRIMPER, WIRE PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

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

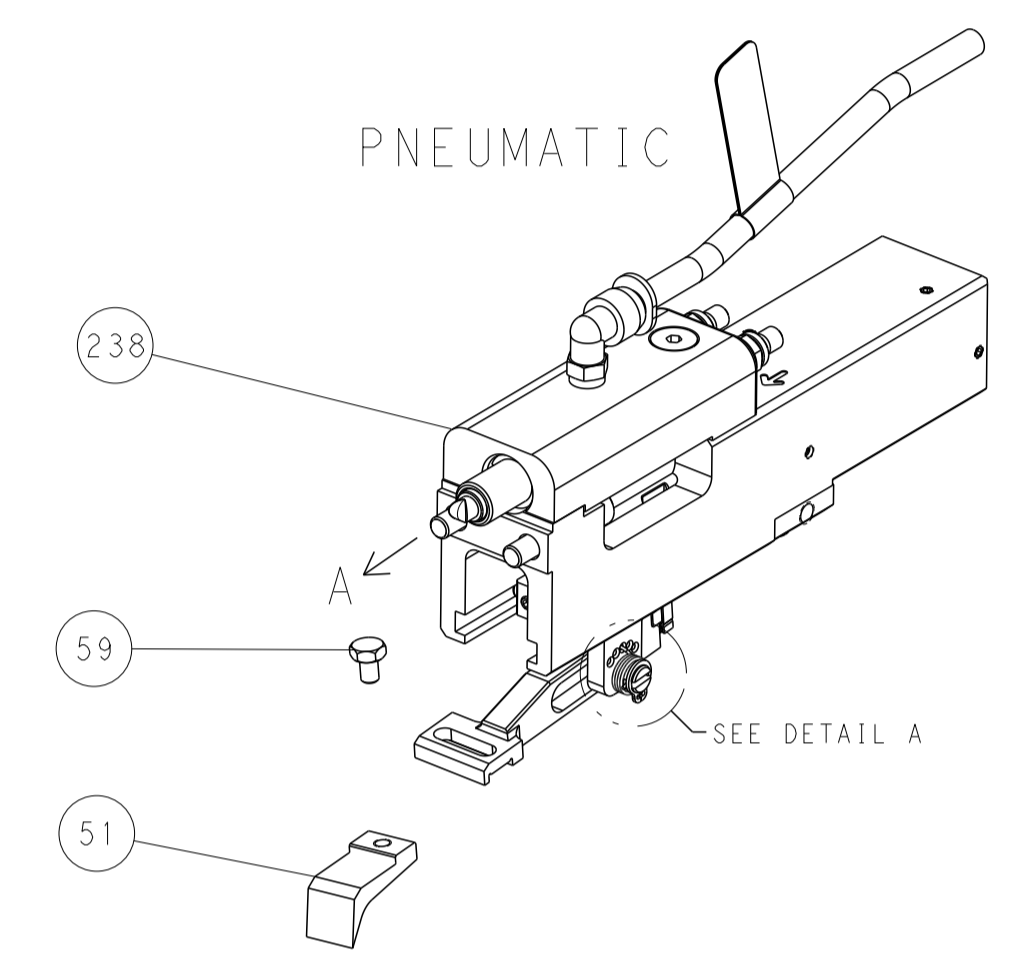
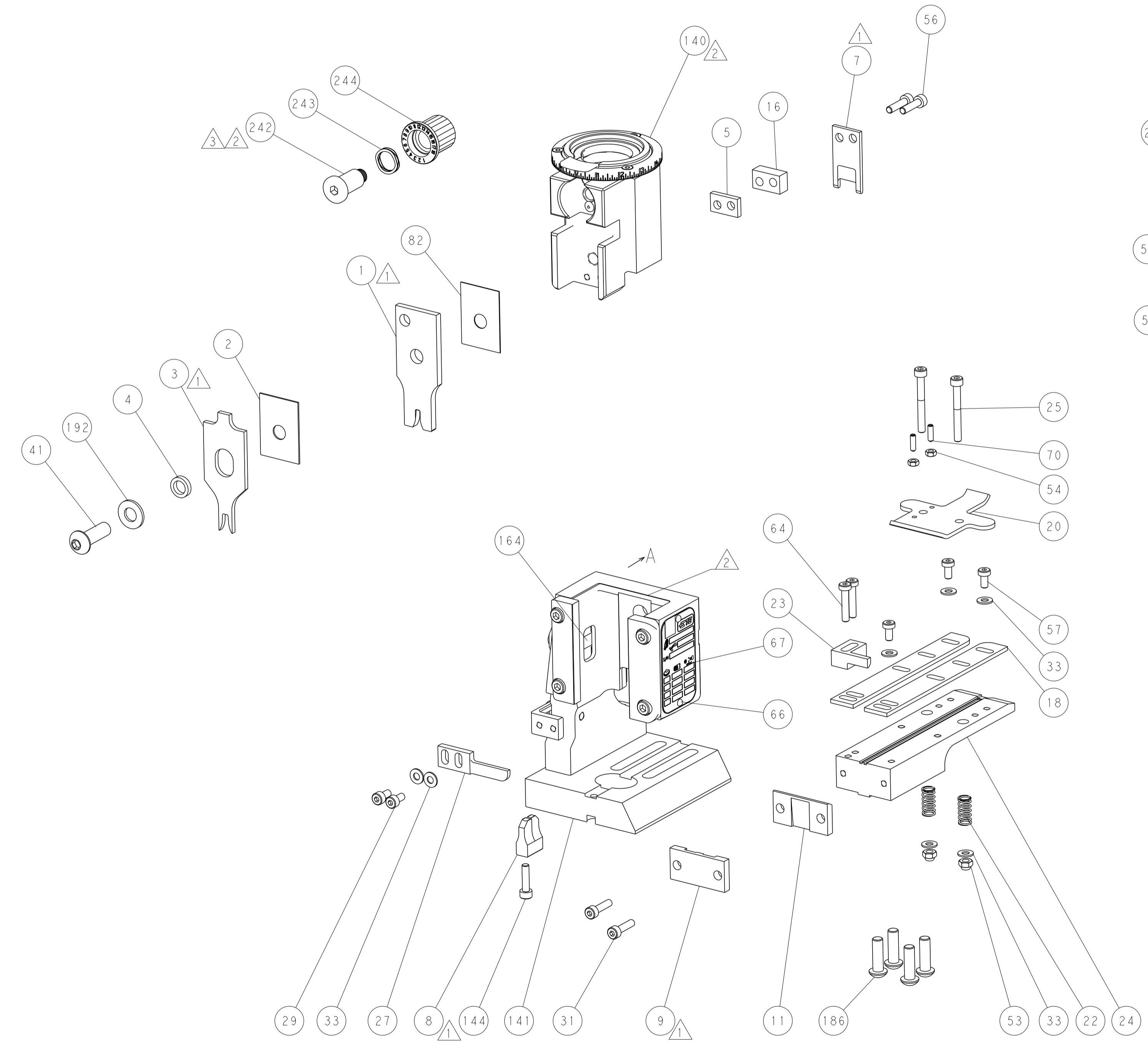
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
								A1	00779	2150528	
MATERIAL								WEIGHT		SCALE	
										1:1	
Customer Accessible Production Drawing								SHEET 3 OF 4		REV B	

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

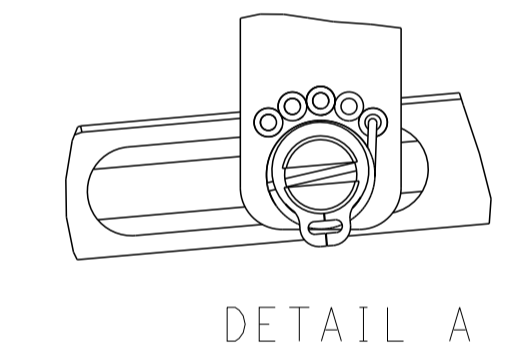


RAM SET-UP

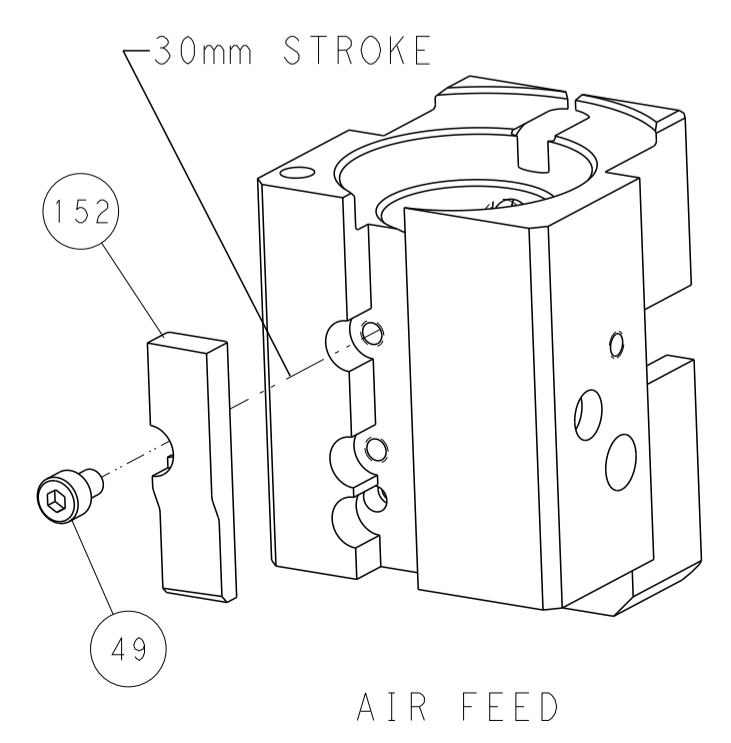
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150528 SHEET: 4 OF 4 REV: B RESTRICTED TO: -