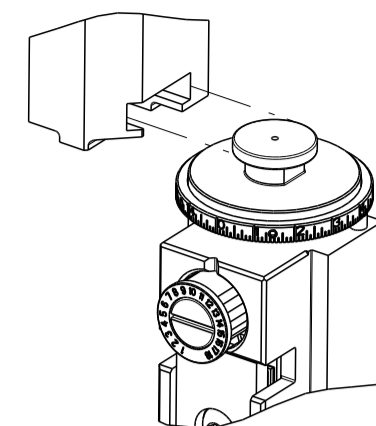


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150311-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150311-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.75-5.35 mm [.187-.211 IN]	Ø 2.92 mm MAX [0.115 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	TE SPEC		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2114314-1	25697.126.009	2113314-4	25697.213.009
2114314-2	25697.126.142	2113314-5	25697.213.141
2114314-3	25697.126.178	2113314-6	25697.213.178

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.49 +/- 0.05 [0.059 +/- .002]	7.8
0.75mm2	1.39 +/- 0.05 [0.055 +/- .002]	8.8
0.50mm2	1.29 +/- 0.05 [0.051 +/- .002]	10.0



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 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.

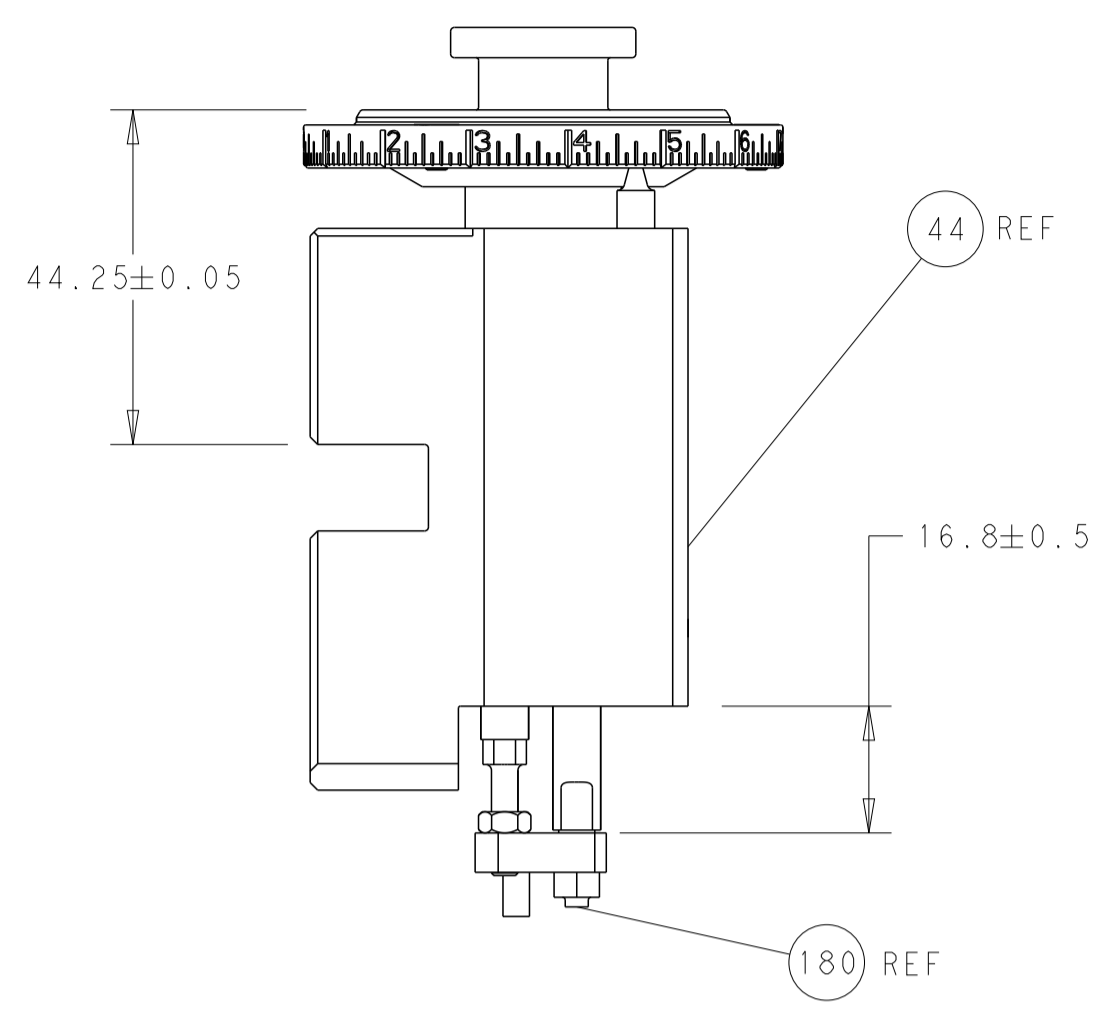
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	1		DEVELOPMENT	22JAN2013	YY	SX
		A		RELEASED	22MAR2013	YY	UG
		B		ECR-19-017433	08NOV2019	TB	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1976055-3	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	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
-	1	1	1976052-1	HOLDDOWN,TERMINAL	65
-	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	2063961-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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
-	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	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	2	1-1803001-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	7-240641-6	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	2	2-456405-5	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

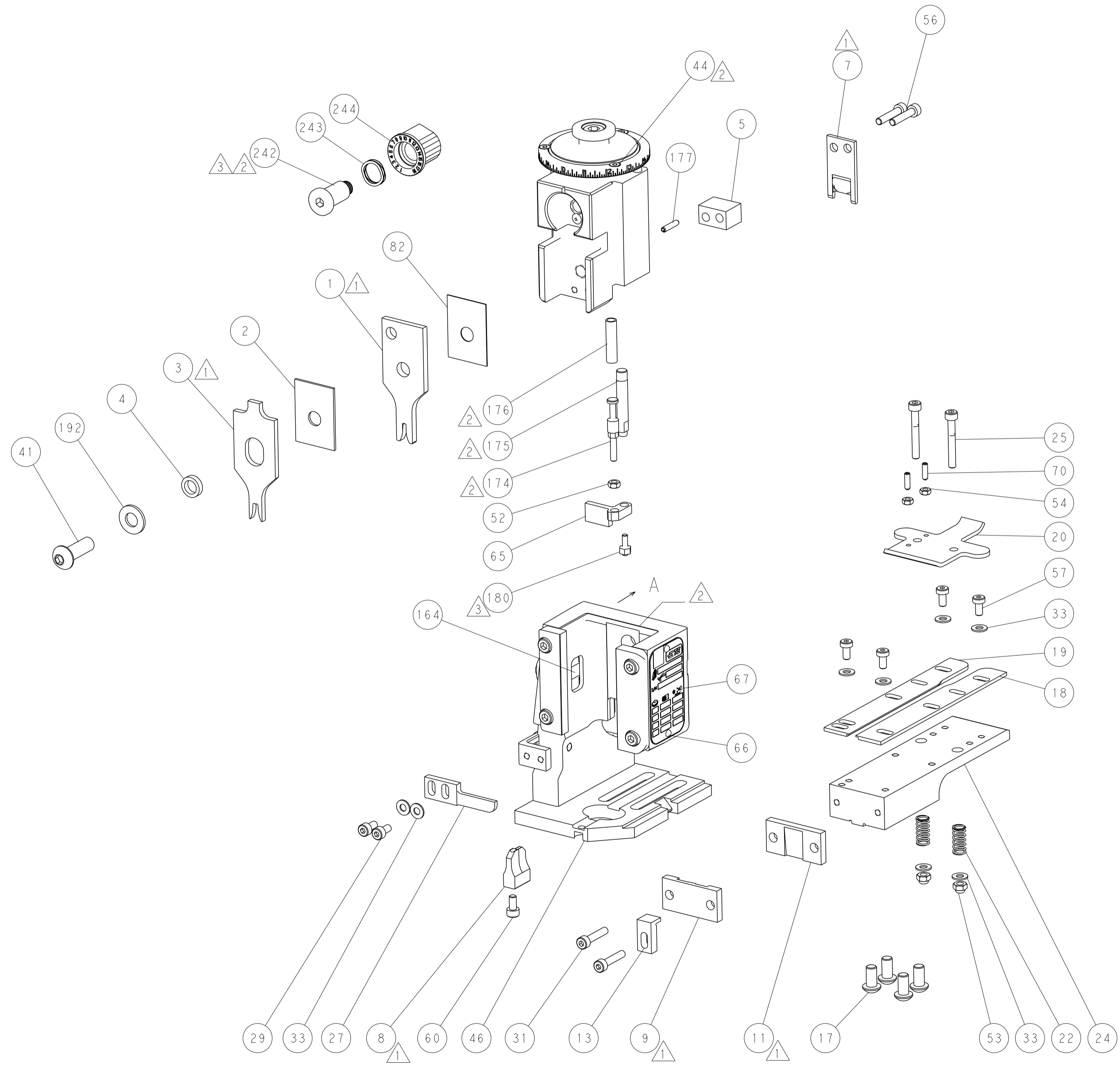
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Y. YIN	22JAN2013	G. BAILEY	22JAN2013
	ANGLES ±	FINISH ±				S. XI	22JAN2013		
MATERIAL						TE Connectivity Harrisburg, PA 17105-3608			
						Ocean End Feed Applicator			
						SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
						A1	00779	2150311	
						CUSTOMER ACCESSIBLE PRODUCTION DRAWING			
						SCALE	SHEET	OF	REV
						1:1	1	4	B

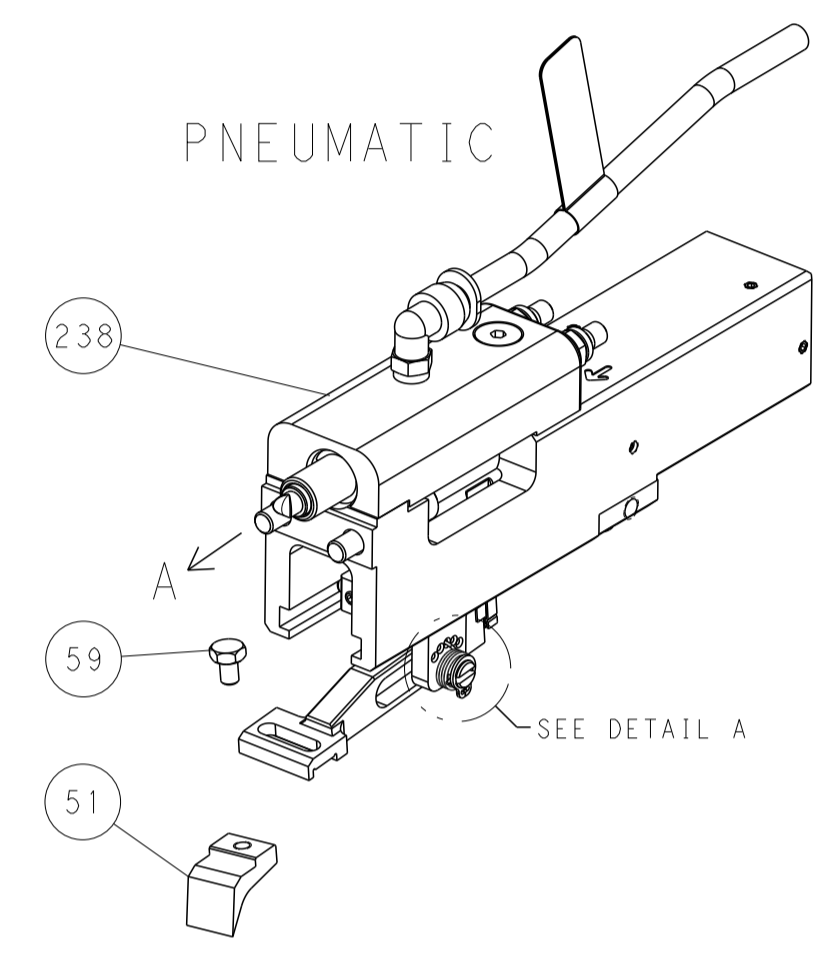
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



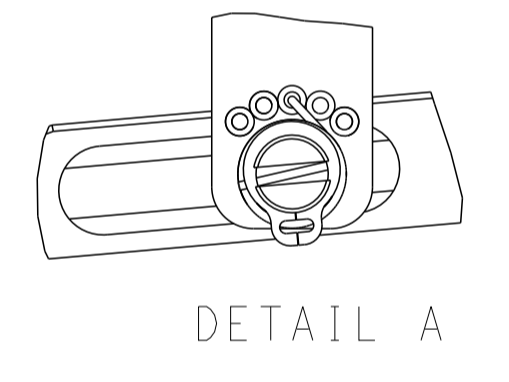
RAM AND HOLDDOWN SET-UP



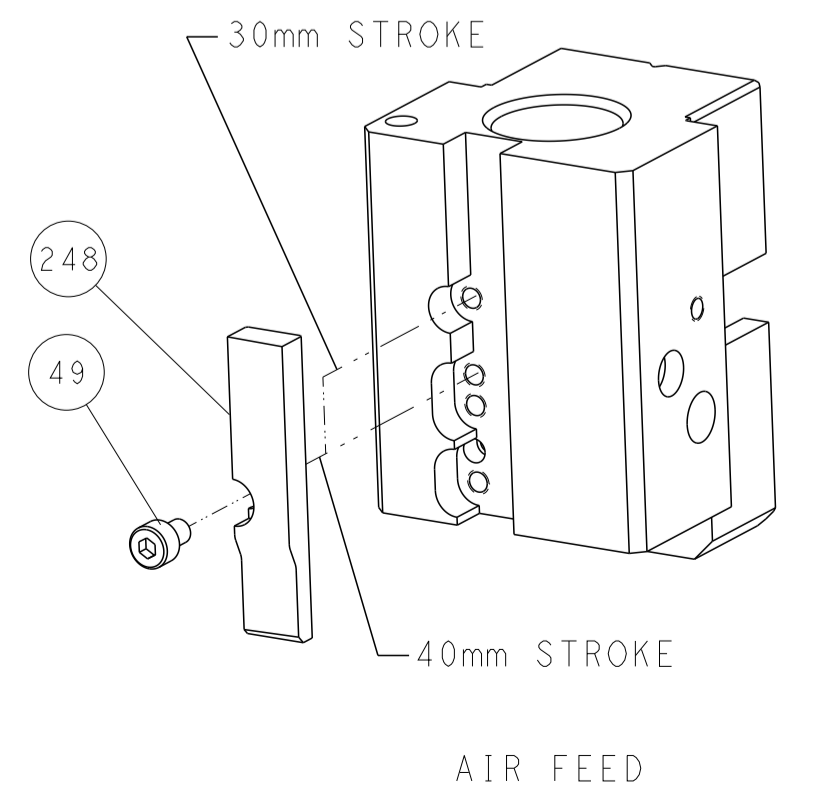
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

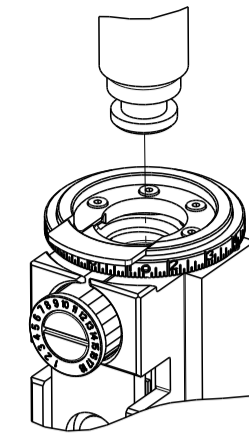


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 22JAN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±			CHK G. BAILEY 22JAN2013	NAME Ocean End Feed Applicator		
MATERIAL	FINISH			APVD S. XI 22JAN2013	PRODUCT SPEC	APPLICATION SPEC	RESTRICTED TO
				WTG	SIZE	CAGE CODE	DRAWING NO
					A1	00779	©=2150311
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1	SHEET 2 OF 4	REV B	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150311-7	A	CRIMP TOOLING KIT	-

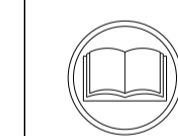
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.56 mm (.140)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.75-5.35 mm (.187-.211 IN)		INSULATION DIAMETER RANGE Ø 2.92 mm MAX (.0115 IN MAX)	
TERMINAL APPLICATION SPECIFICATION		TE SPEC	
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2114314-1	25697.126.009	2113314-4	25697.213.009
2114314-2	25697.126.142	2113314-5	25697.213.141
2114314-3	25697.126.178	2113314-6	25697.213.178

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.49 +/- 0.05 [.059 +/- .002]	7.8
0.75mm2	1.39 +/- 0.05 [.055 +/- .002]	8.8
0.50mm2	1.29 +/- 0.05 [.051 +/- .002]	10.0



- △ 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
 - △ 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.
6. 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.

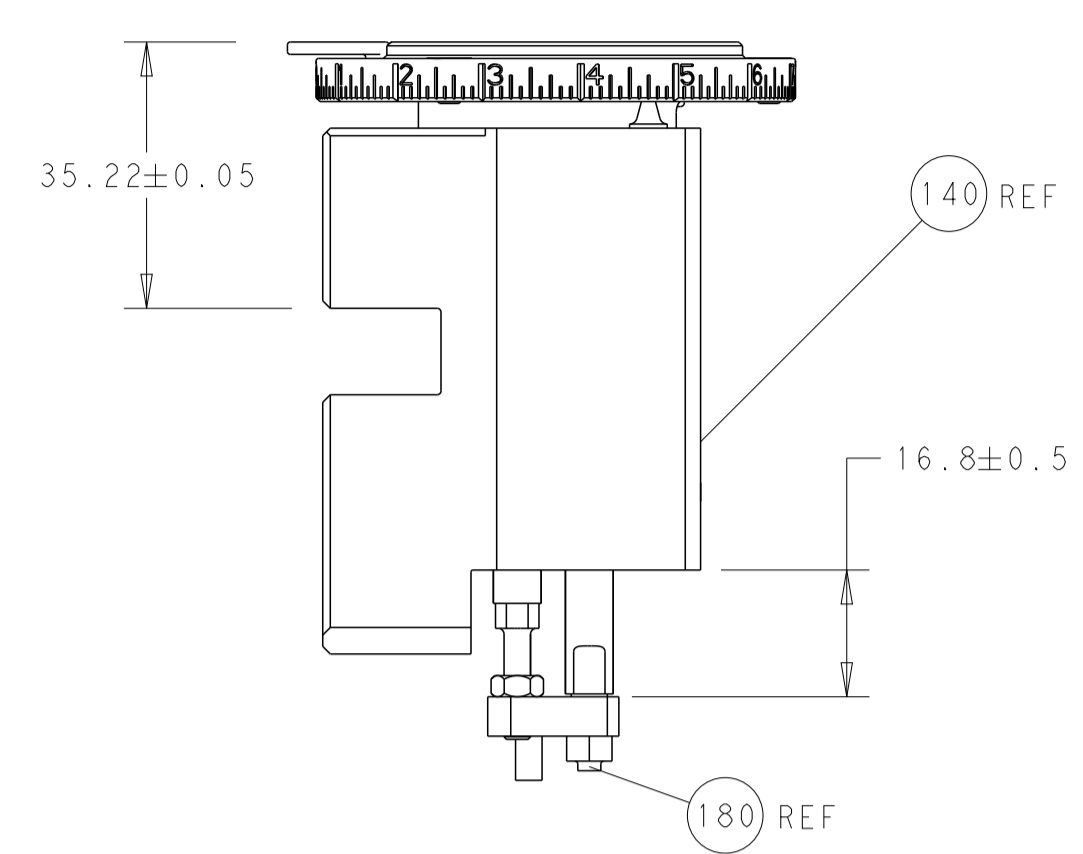
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-9	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	
△	-	1	1976055-3	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	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	
-	1	1976052-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	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	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1901696-3	STRIP GUIDE, REAR	19	
-	1	1901695-3	STRIP GUIDE, FRONT	18	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
△	-	1	240644-1	PLATE, REAR SHEAR	11
△	-	1	690482-3	PLATE, FRONT SHEAR	9
△	1	1	1-1803001-3	ANVIL, COMBINATION, END FEED	8
△	-	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	6	
-	1	7-240641-6	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
△	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
△	1	1	2-456405-5	CRIMPER, WIRE PREMIUM	1
-	-	-	-	0	

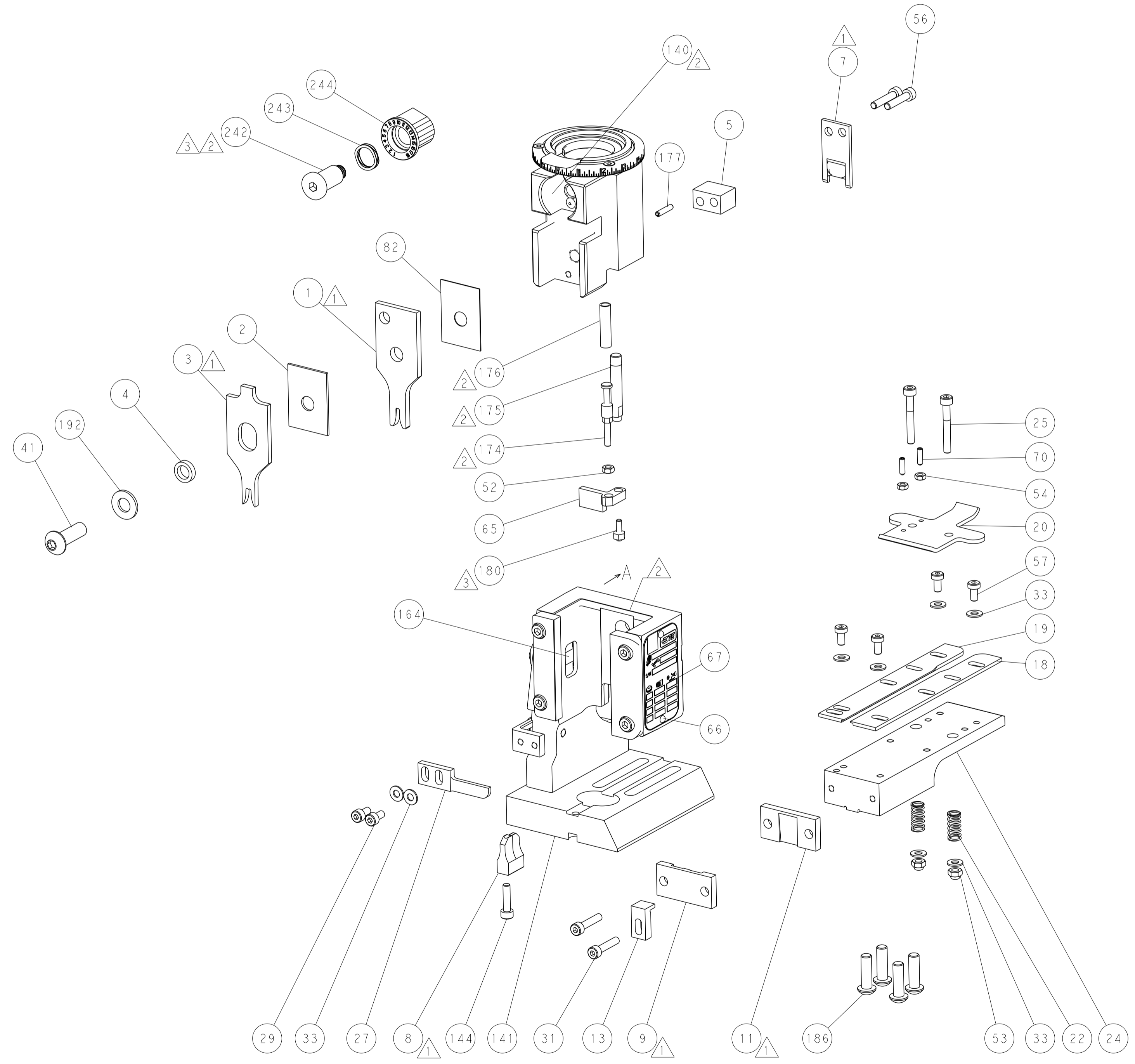
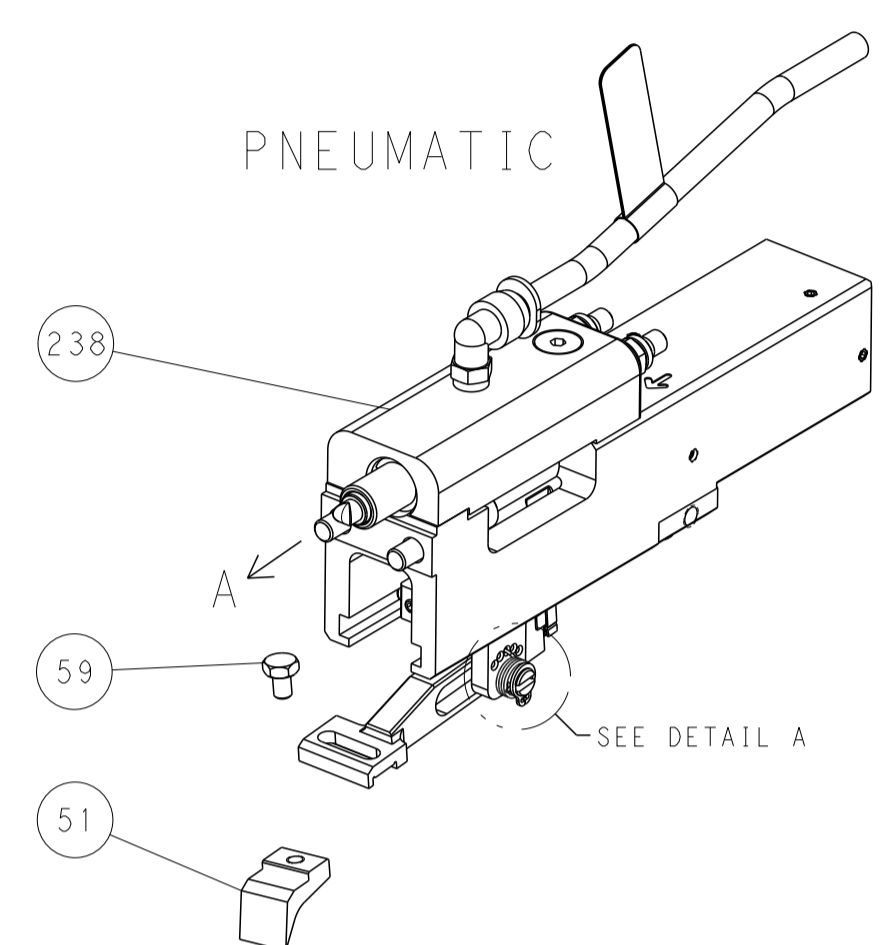
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
ANGLES	FINISH			CHK		DATE	
MATERIAL	FINISH			G. BAILEY		22JAN2013	
APPLICATOR DATA				APVD		DATE	
APPLICATION SPEC				S. XI		22JAN2013	
WEIGHT				NAME		GATEWAY	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE		SHEET 3 OF 4	
SCALE 1:1				REV B		REV B	

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

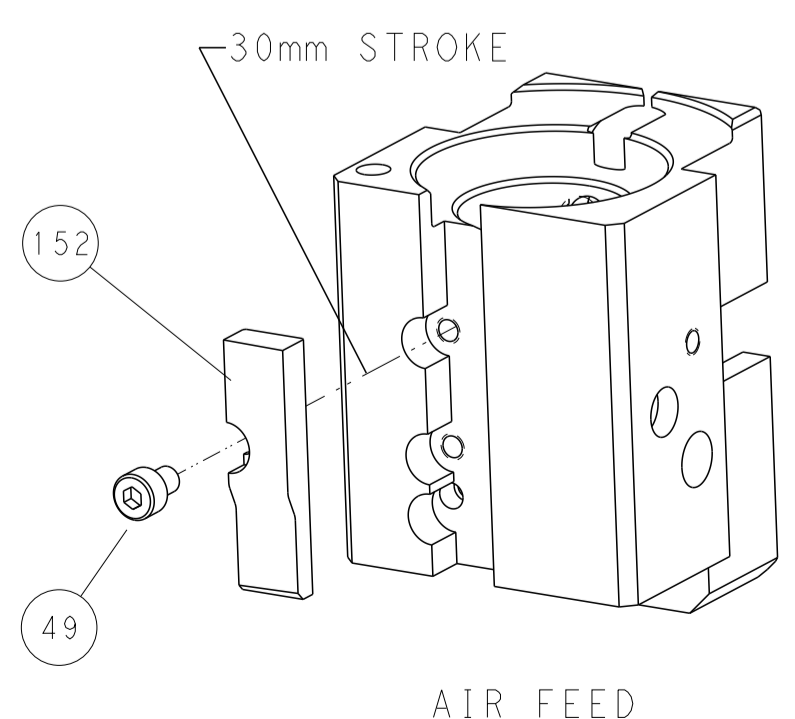


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



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 Y. YIN 22JAN2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 22JAN2013	NAME
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV	RESTRICTED TO
			1:1	4	4	B	Customer Accessible Production Drawing