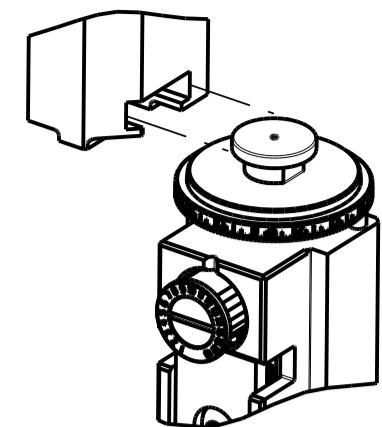


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150408-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.00 mm [.197]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 3.2Ø CLUSTER REC. "L" TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-8.70 mm [.303-.343 IN]		Ø2.20-3.20 mm [.087-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5215		
TERMINALS APPLIED ⁵ / ₆			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.104ø+1.104ø+0.97ø	2.12+/-0.05 [.083+/- .002]	6.2
0.97ø+0.97ø+0.87ø	1.97+/-0.05 [.078+/- .002]	8.2
1.02ø+1.02ø	1.84+/-0.05 [.072+/- .002]	9.7
0.92ø+0.72ø	1.70+/-0.05 [.067+/- .002]	11.0

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

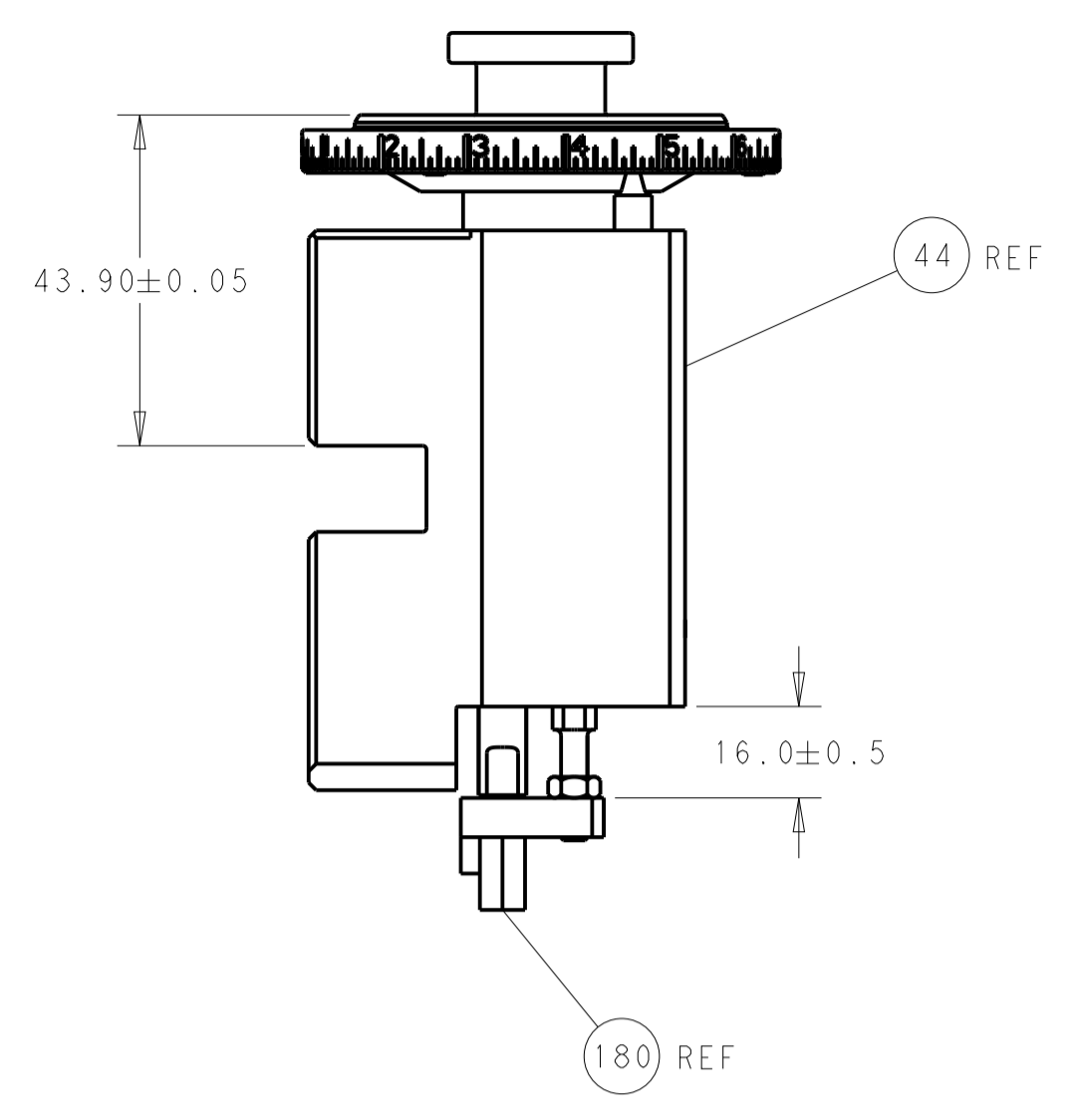
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A	66	REV	DATE	BY	APPV
		B	19SEP2018	FZ	KZ
		C	11JUN2019	LG	TE
		D	01NOV2019	MZ	YY
		E	20MAY2021	FZ	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
3	-	1	1	2-1752354-3	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	
6	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	4-1901681-5	HOLDDOWN, TERMINAL	65	
-	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	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	
-	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	690455-3	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	2-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	2-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	240833-6	PLATE, REAR SHEAR	11
1	-	2	2	7-240645-4	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1-240641-0	SPACER	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	1	409414-3	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

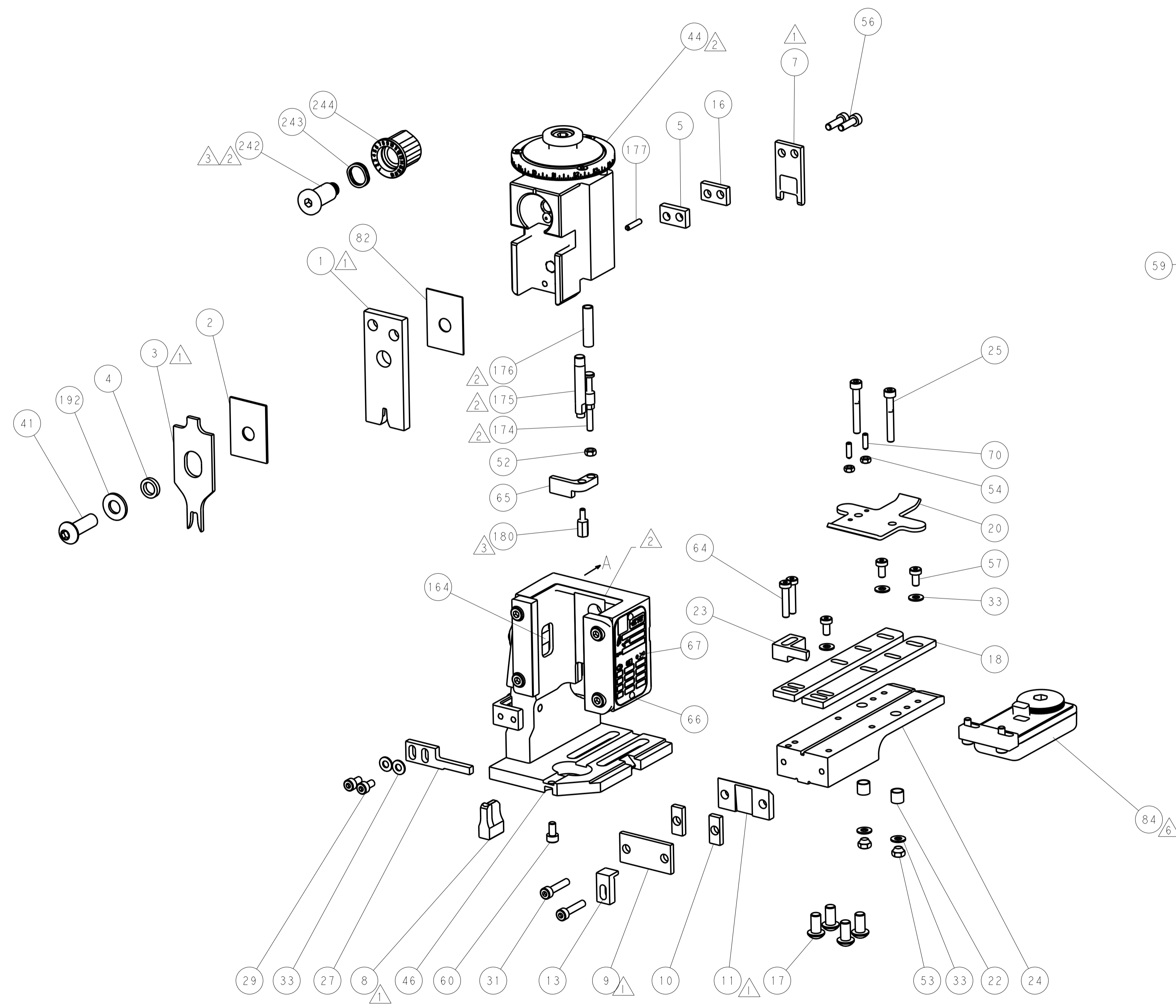
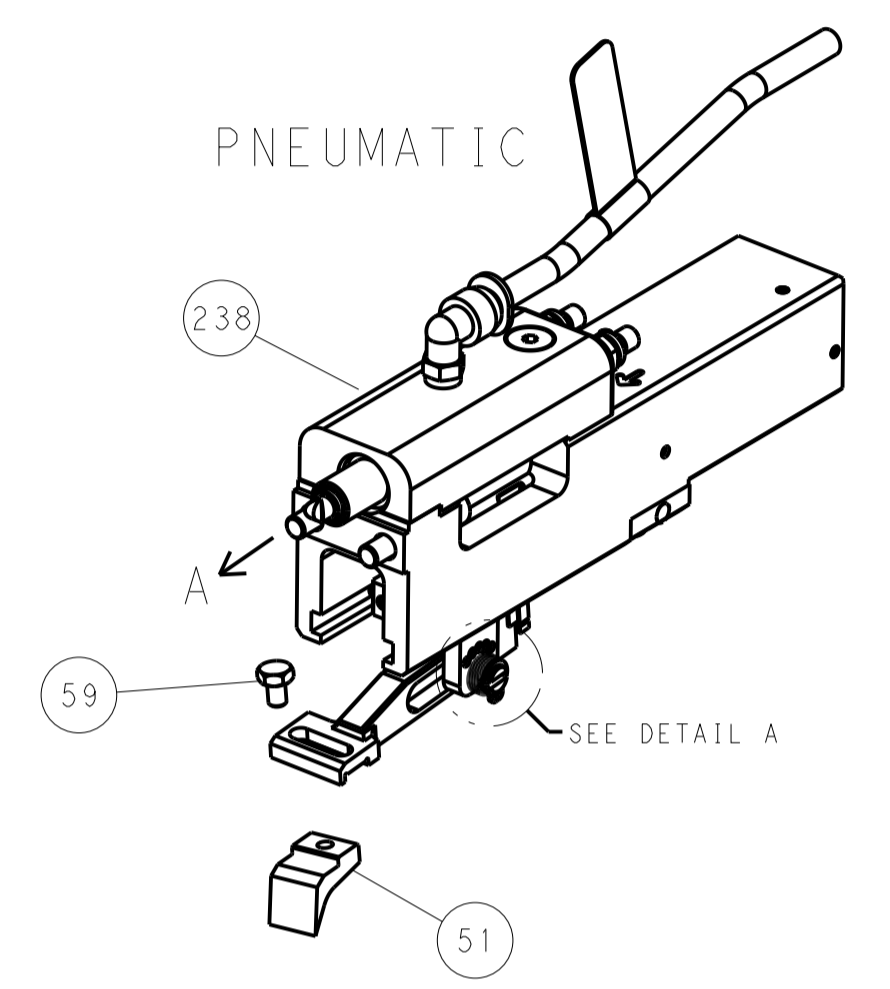
OWN	X. ZHAO	14JAN2014	CHK	L. ZHANG	14JAN2014
APVD	T. ELBIN	14JAN2014	NAME	Ocean End Feed Applicator	
PRODUCT SPEC	-				
APPLICATION SPEC	-				
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
A1	00779	2150408	-		
Customer Accessible Production Drawing			SCALE	1:1	SHEET 1 OF 4

LOC	DIST	REV	DATE	BY	APPV
A	66				

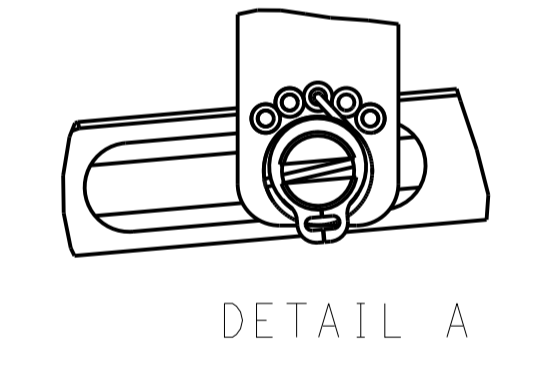


RAM AND HOLDDOWN SET-UP

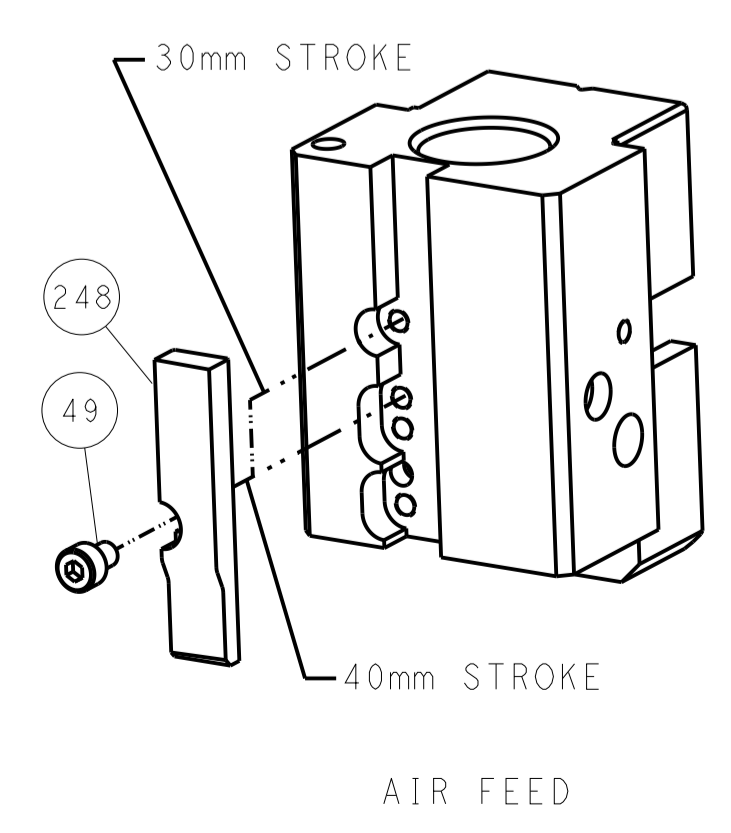
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



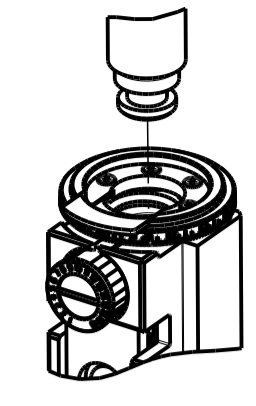
AIR FEED

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN X.ZHAO 14JAN2014 CHK L.ZHANG 14JAN2014 APVD T.FLRIN 14JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean End Feed Applicator	
WEIGHT:		SCALE: 1:1		SHEET 2 OF 4		REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150408-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	5.00 mm [1.971]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 3.2ø CLUSTER REC. "L" TYPE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
7.70-8.70 mm [1.303-.343 IN]	∅2.20-3.20 mm [1.087-.126 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.104ø+1.104ø+0.97ø	2.12+/-0.05 [1.083+/-0.002]	6.2
0.97ø+0.97ø+0.87ø	1.97+/-0.05 [1.078+/-0.002]	8.2
1.02ø+1.02ø	1.84+/-0.05 [1.072+/-0.002]	9.7
0.92ø+0.72ø	1.70+/-0.05 [1.067+/-0.002]	11.0



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 TERMINAL LUBRICANT IS RECOMMENDED.
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	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-7			
-	1	2079764-1			
-	1	2119083-1			
-	1	2844940-4			
-	1	1-18028-0			
-	4	2079383-9			
-	1	2-1752354-3			
-	1	6-993111-6			
-	1	8-22280-7			
-	1	1752353-2			
-	1	1901680-2			
-	REF	994970-2			
-	1	2119641-2			
-	1	2168083-8			
-	1	2119655-6			
-	1	1803518-1			
-	1	2119955-2			
-	1	455888-5			
-	1	1803607-4			
-	2	2-18032-2			
-	1	2119740-1			
-	2	2168078-1			
-	1	4-1901681-5			
-	2	2168400-5			
-	1	5-18022-5			
-	3	2168400-4			
-	2	2-2168083-5			
-	2	5018030-1			
-	2	986965-8			
-	1	1-5018030-0			
-	1	2063961-1			
-	1	18023-9			
-	1	1803602-1			
-	7	1-18028-2			
-	2	2168083-9			
-	2	2168083-2			
-	1	690455-3			
-	2	1-2168083-5			
-	1	2-1752371-0			
-	1	240825-3			
-	2	22281-8			
-	1	1803292-4			
-	2	1901259-7			
-	1	2-240641-4			
-	1	1752360-1			
-	1	240833-6			
-	2	7-240645-4			
-	1	240642-1			
1	1	3-1803001-9			
-	1	9-240651-2			
-	-	-			
-	1	1-240641-0			
-	1	238011-4			
1	1	2-1803016-9			
-	1	1-455888-0			
1	1	409414-3			

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	14JAN2014	X. ZHAO	L. ZHANG
MATERIAL:	FINISH:	DATE	BY	APPV
		14JAN2014	T. ELBIN	

Customer Accessible Production Drawing

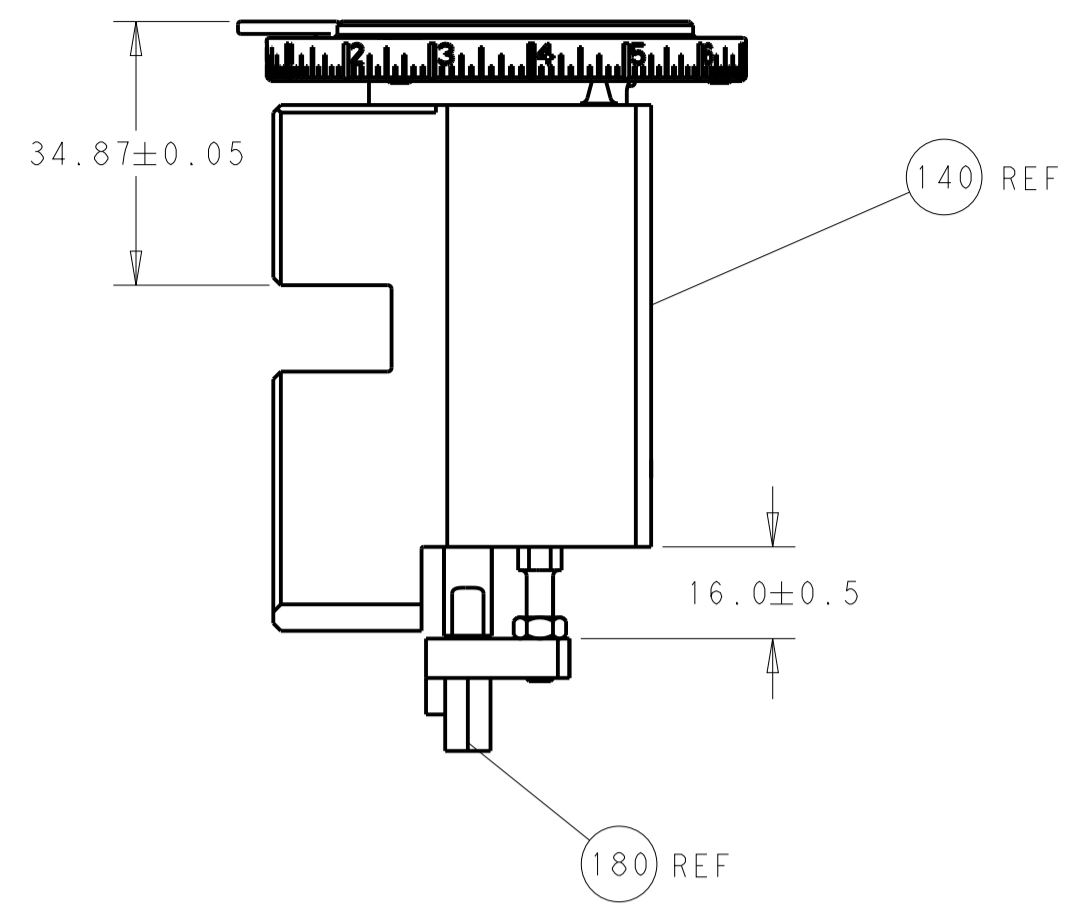
STE TE Connectivity
 Harrisburg, PA 17105-3608

Product Name: Ocean End Feed Applicator

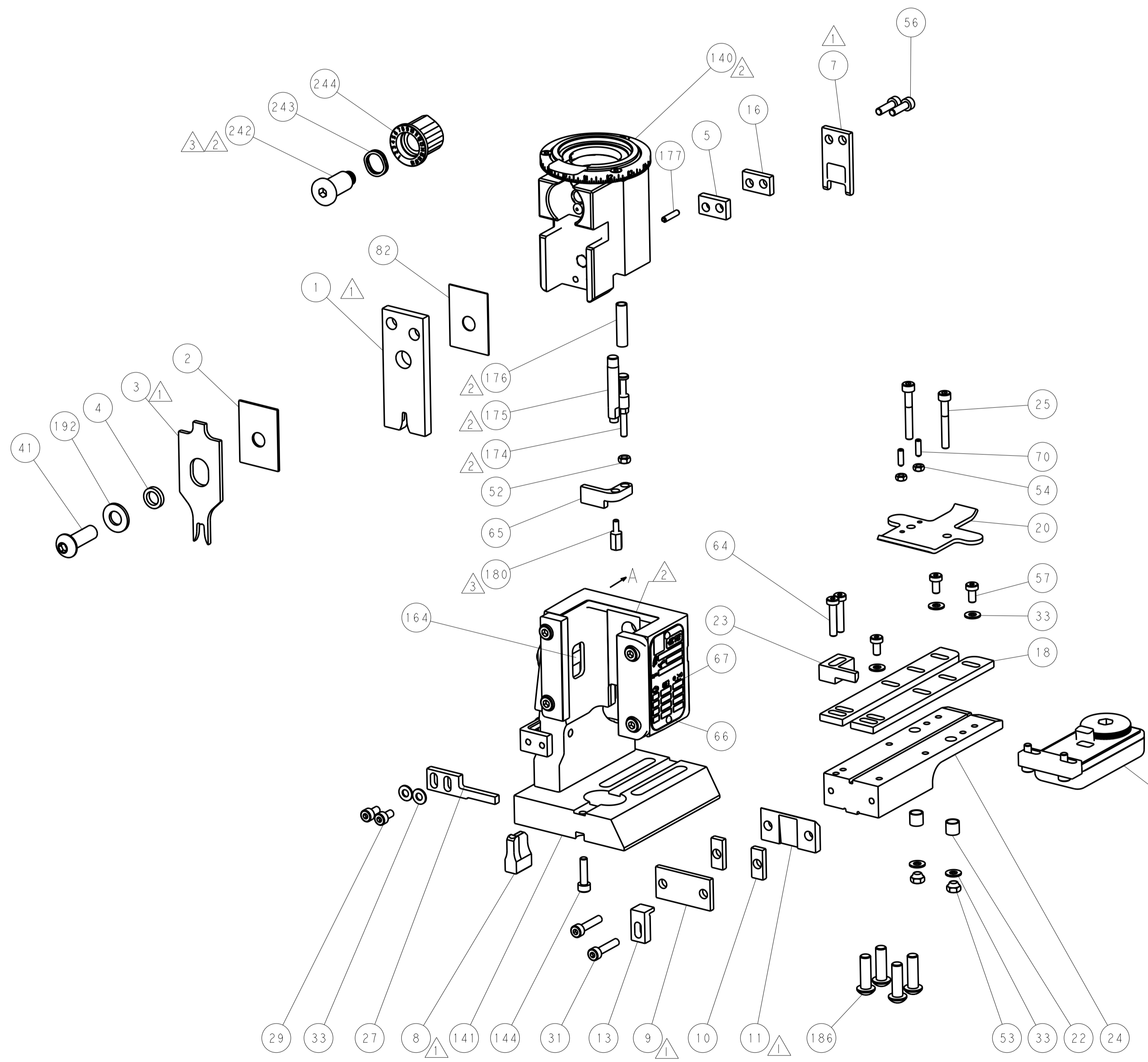
Part No: 00779

Scale: 1:1

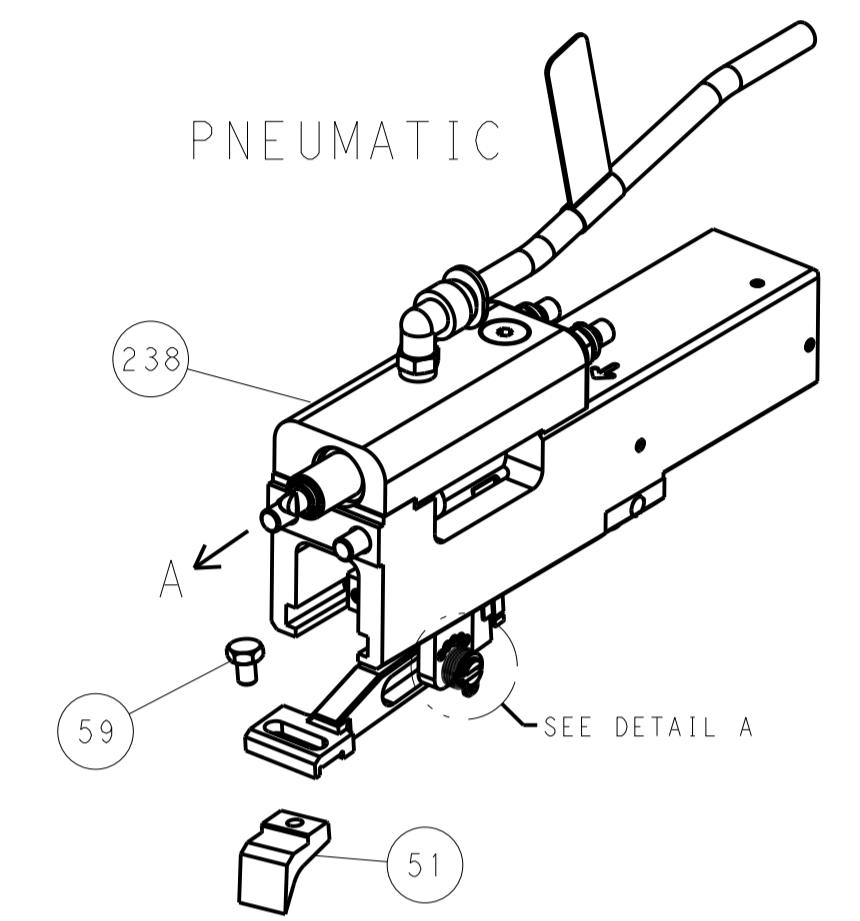
LOC		DIST		REVISIONS				
					DESCRIPTION	DATE	DWN	APVD
A	66				SEE SHEET 1			



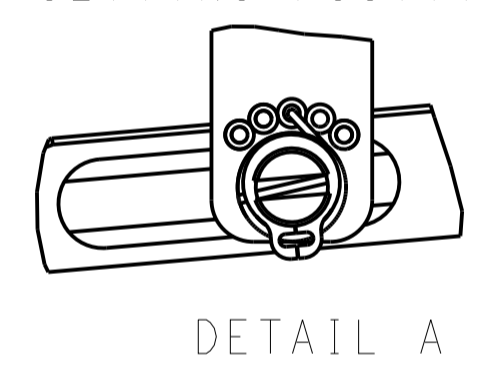
RAM AND HOLDDOWN SET-UP



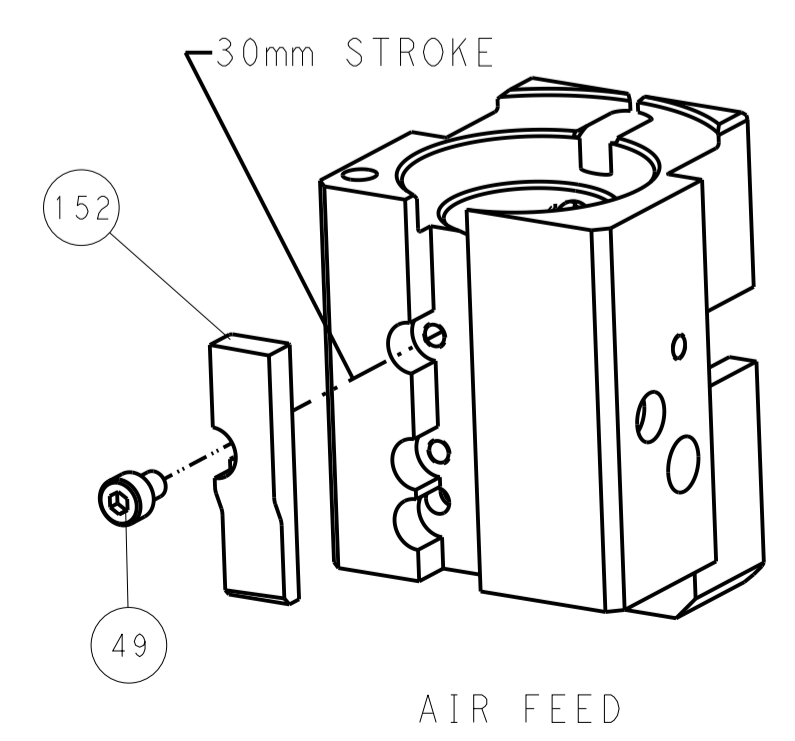
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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 X. ZHAO 14JAN2014		TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±		CHK L. ZHANG 14JAN2014		
		1 PLC ±		APVD T. ELBIN 14JAN2014		
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean End Feed Applicator
				APPLICATION SPEC:		SIZE: CAGE CODE DRAWING NO:
				WEIGHT:		A1 00779 C=2150408
				ANGLES:		RESTRICTED TO:
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV E