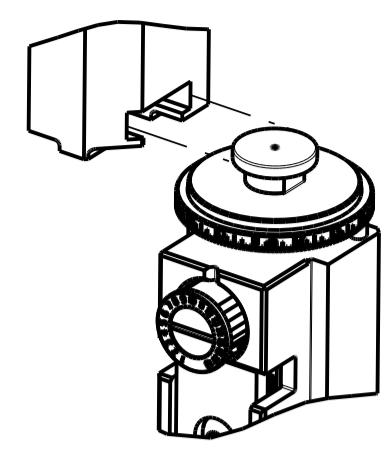


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150404-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150404-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150404-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING, AMPLIVAR			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.46-5.84mm [.215-.230 IN]	∅ 2.54-3.56mm [.100-.140 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60320-1	60320-2	60318-1	1217730-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 OR 14.5 MAG	1.93+/-0.05 [.076+/- .002]	7.6
15 MAG	1.85+/-0.05 [.073+/- .002]	8.4
16 MAG	1.75+/-0.05 [.069+/- .002]	9.4
17 OR 18 MAG	1.65+/-0.05 [.065+/- .002]	10.5

- 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 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.

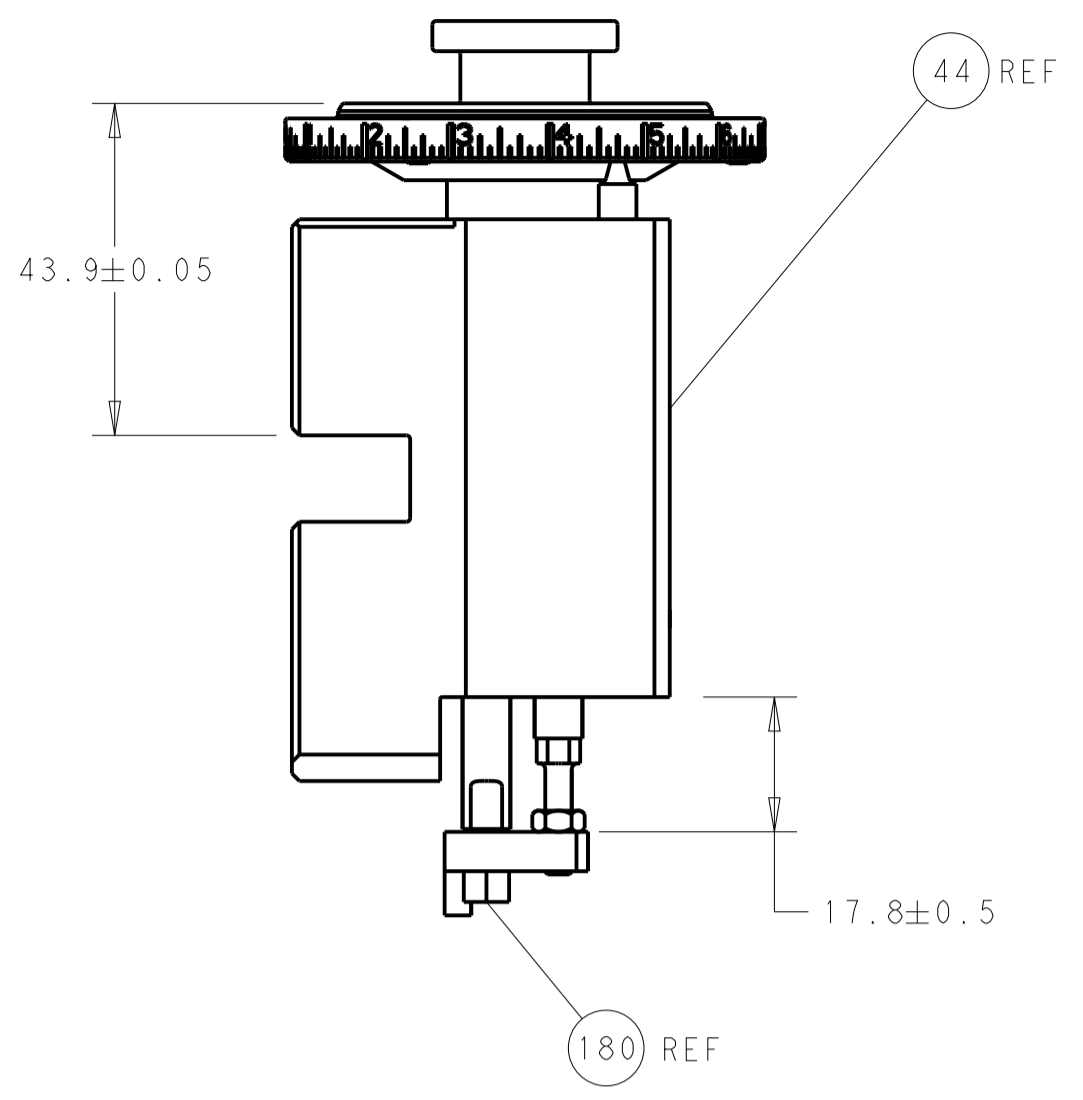
LOC	DIST	REVISIONS					
A	66	F	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	19MAR2014	LG	TE
		B		ECR-21-002618	02MAR2021	FZ	TE

-	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	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1752354-1	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	455888-5	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	1901681-1	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	2168083-3	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	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	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-5	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	8-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10	
1	-	1	1	690482-5	PLATE, FRONT SHEAR	9
1	1	2	1	1803064-5	ANVIL, COMBINATION	8
1	-	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-0	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	2	1	456408-9	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

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

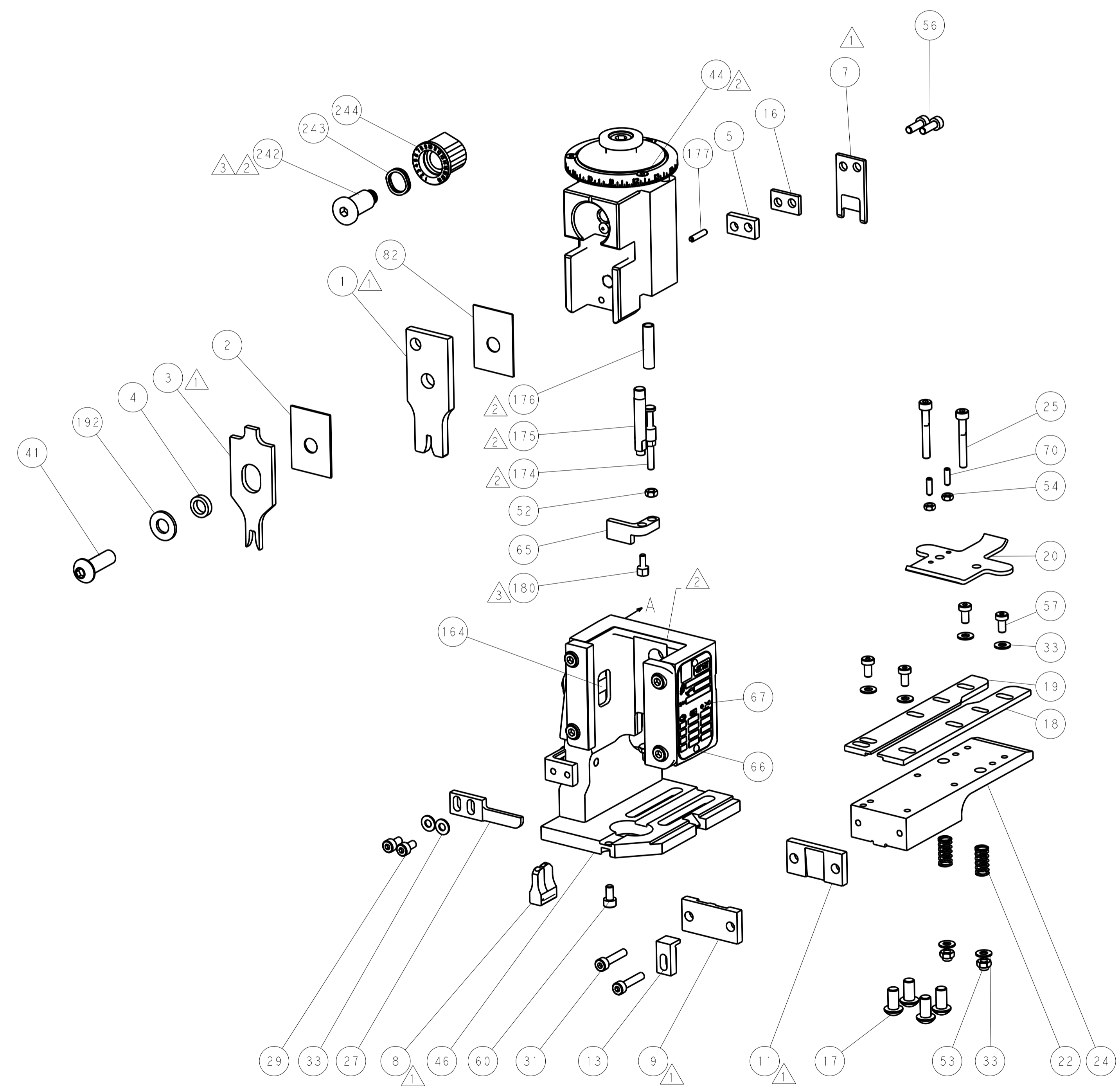
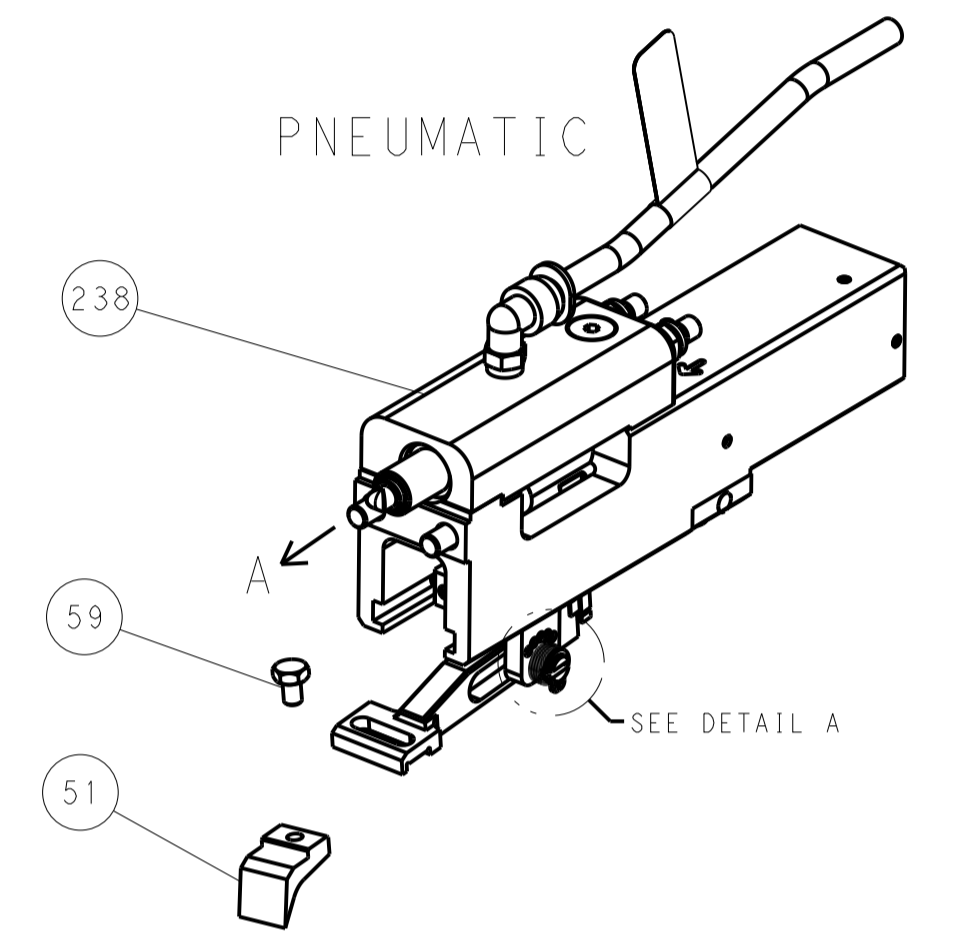
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0 PLC ±		1 PLC ±		CHK: L. ZHANG 30JAN2014	Harrisburg, PA 17105-3608
2 PLC ±		3 PLC ±		APVD: T. ELBIN 30JAN2014	NAME: Ocean End Feed Applicator
4 PLC ±		ANGLES ±		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO
MATERIAL: -		FINISH: -		WEIGHT: -	A1 00779 C=2150404
Customer Accessible Production Drawing				SCALE: 1:1	SHEET 1 OF 4 REV B

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

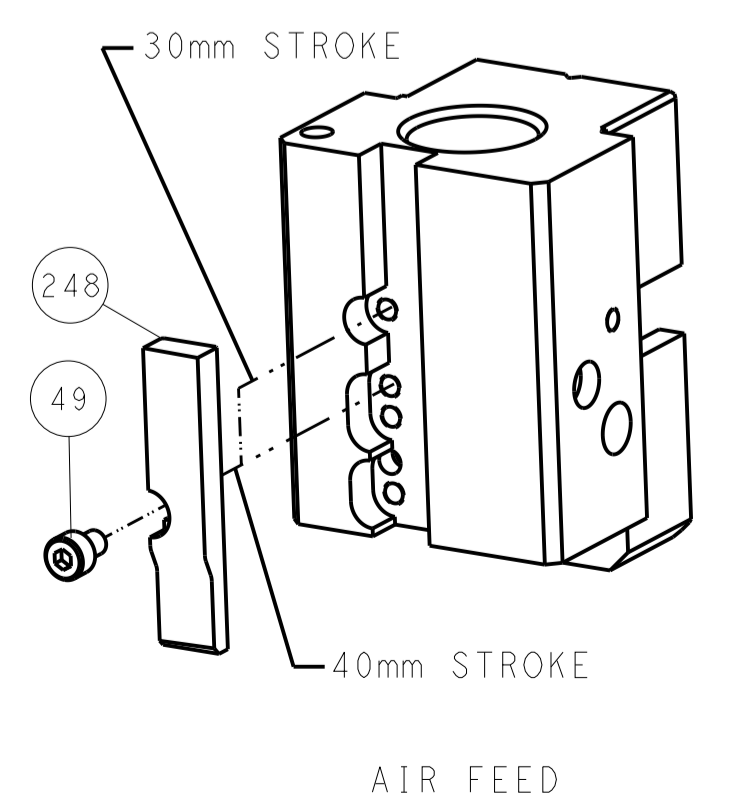


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION

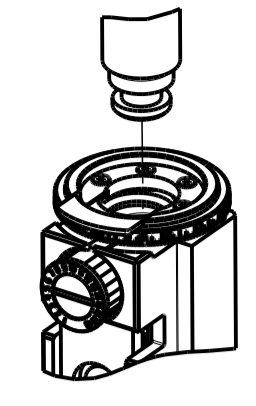


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> <small>THIS IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORIGINAL DESIGNING ORGANIZATION. CHANGES BY OTHERS SHOULD BE CONTACTED FOR THE LATEST VERSION.</small>		DWN: X.ZHAO 30JAN2014 CHK: L.ZHANG 30JAN2014 APVD: T.FLRIN 30JAN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A11 CAGE CODE: 00779 DRAWING NO: C=2150404 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 2 of 4 REV: B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150404-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150404-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING, AMPLIVAR

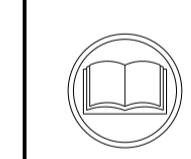
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.46-5.84mm [.215-.230 IN]	2.54-3.56mm [.100-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60320-1	60320-2	60318-1	1217730-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 OR 14.5 MAG	1.93+/-0.05 [.076+/- .002]	7.6
15 MAG	1.85+/-0.05 [.073+/- .002]	8.4
16 MAG	1.75+/-0.05 [.069+/- .002]	9.4
17 OR 18 MAG	1.65+/-0.05 [.065+/- .002]	10.5



- 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 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.

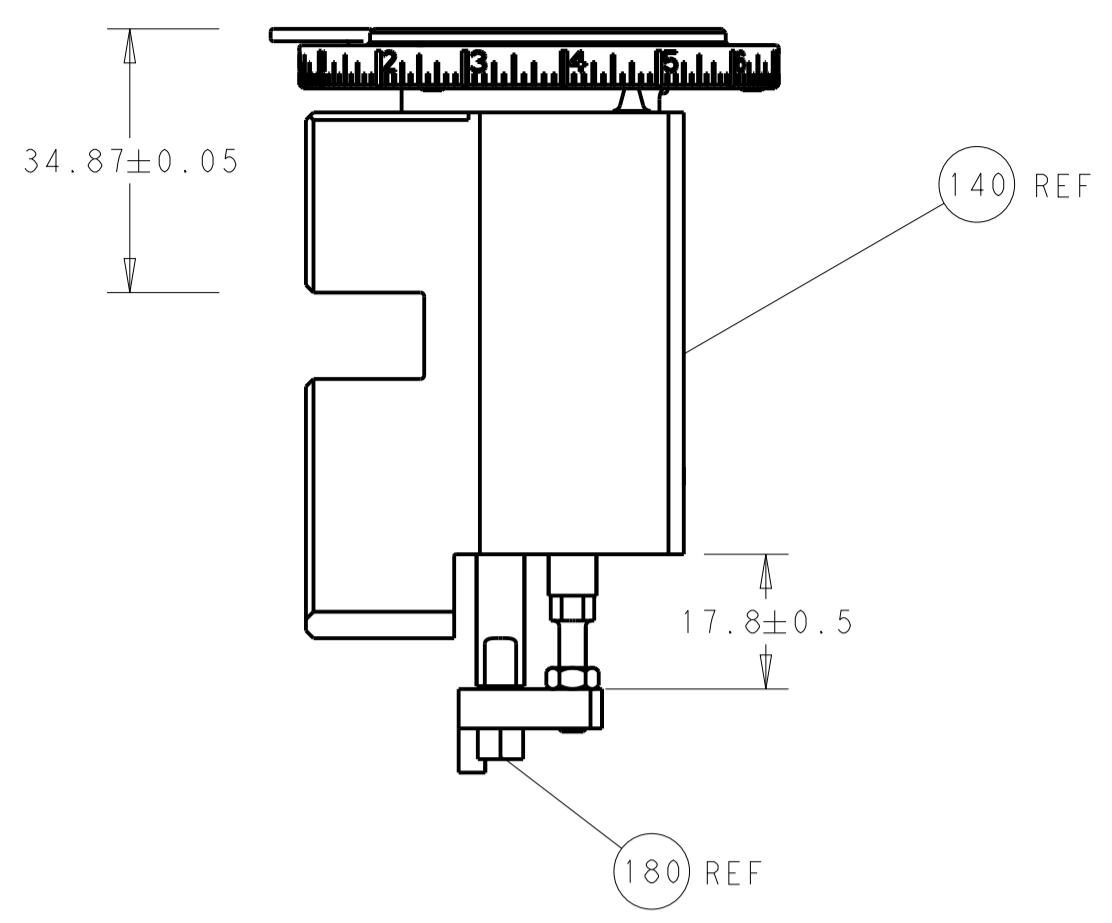
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

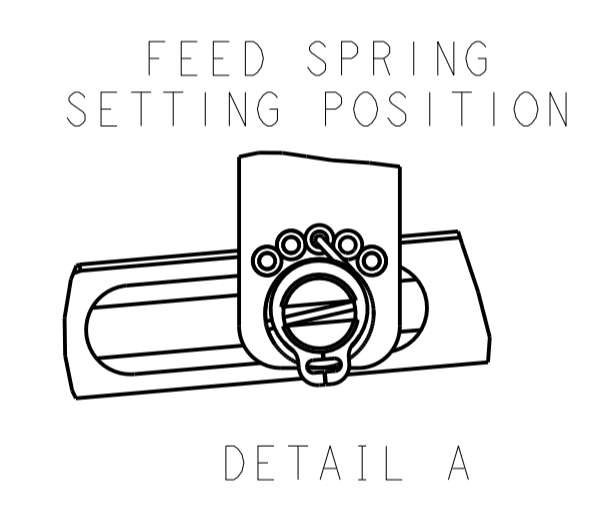
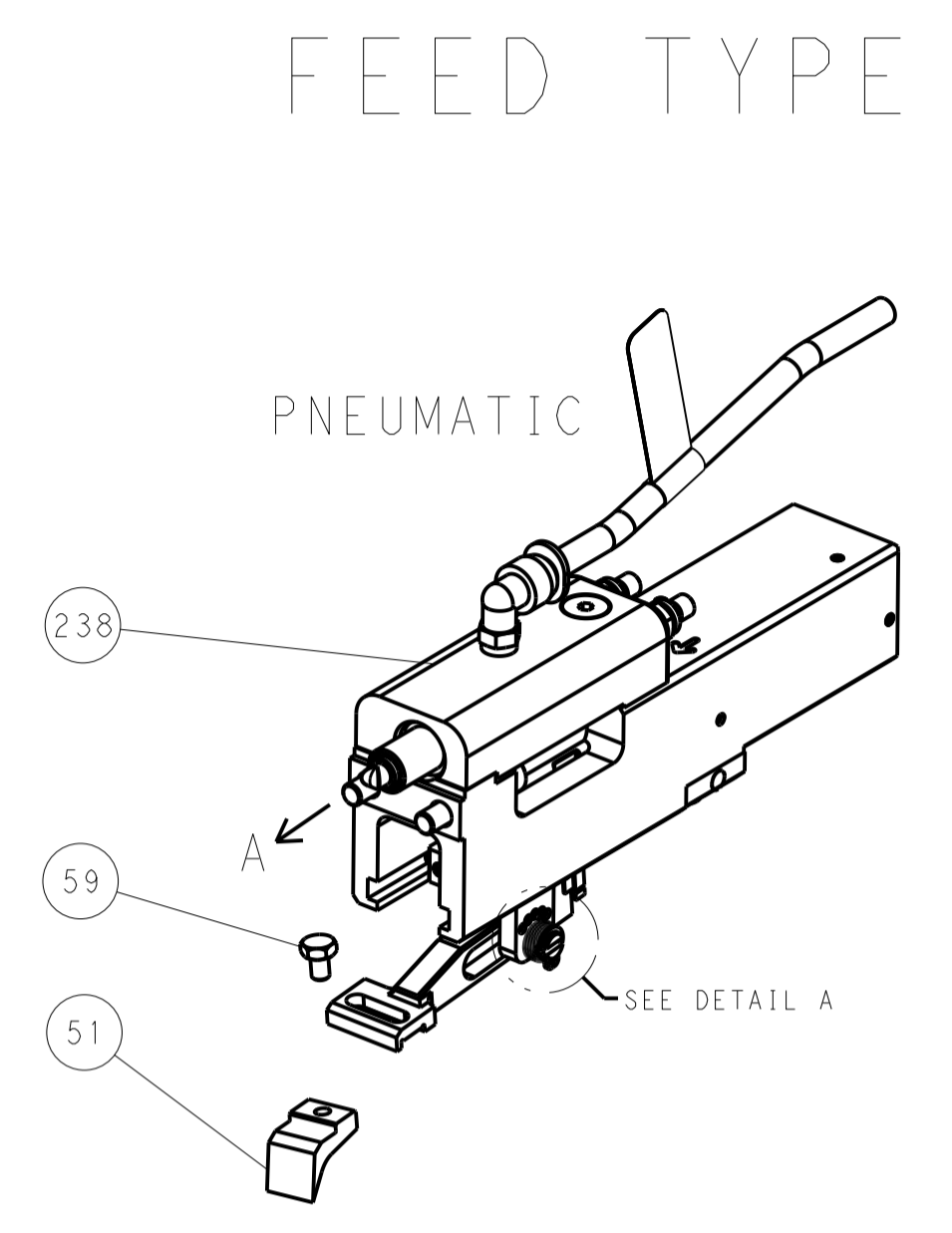
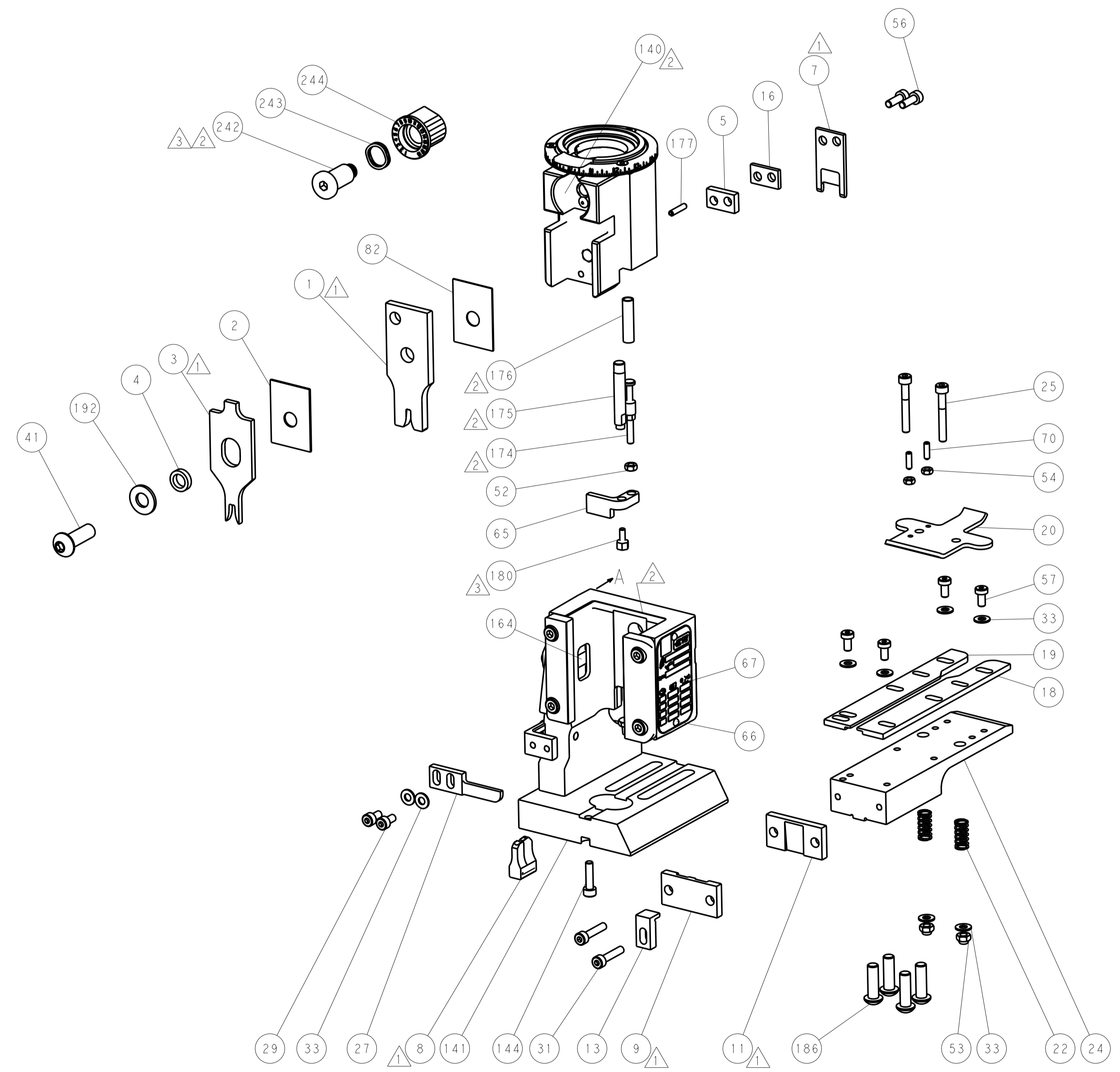
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-3	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1752354-1	STANDOFF, HOLD-DOWN	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	455888-5	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	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	1	8-240641-4	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1803064-5	ANVIL, COMBINATION	8
-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-0	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
-	1	456408-9	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN X ZHAO 30JAN2014 CHK L ZHANG 30JAN2014 APVD T ELRIN 30JAN2014		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1 SHEET 3 OF 4 REV B	

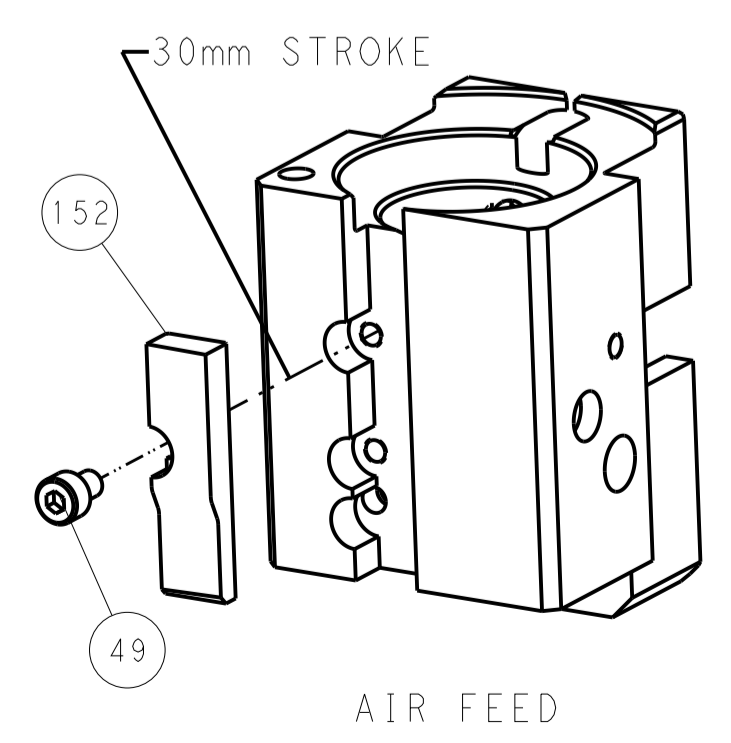
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



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 X. ZHAO 30JAN2014		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	ANGLES:		APVD T. ELBIN 30JAN2014		NAME Ocean End Feed Applicator	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 4	OF 4	REV B	RESTRICTED TO	