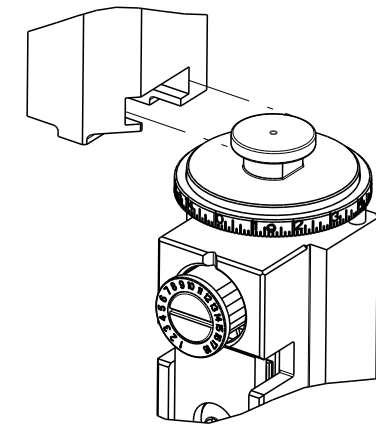


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150771-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150771-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150771-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150771-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150771-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: WELD TAB			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
2.72-3.48 mm [.107-.137 IN]	∅2.29-3.30 mm [.090-.130 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2093		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40990	40990-1	40990-2	40990-4
60581-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.68+/-0.05 [.066+/-0.002]	4.4
18 AWG	1.55+/-0.05 [.061+/-0.002]	5.8
20 AWG	1.45+/-0.05 [.057+/-0.002]	6.9

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

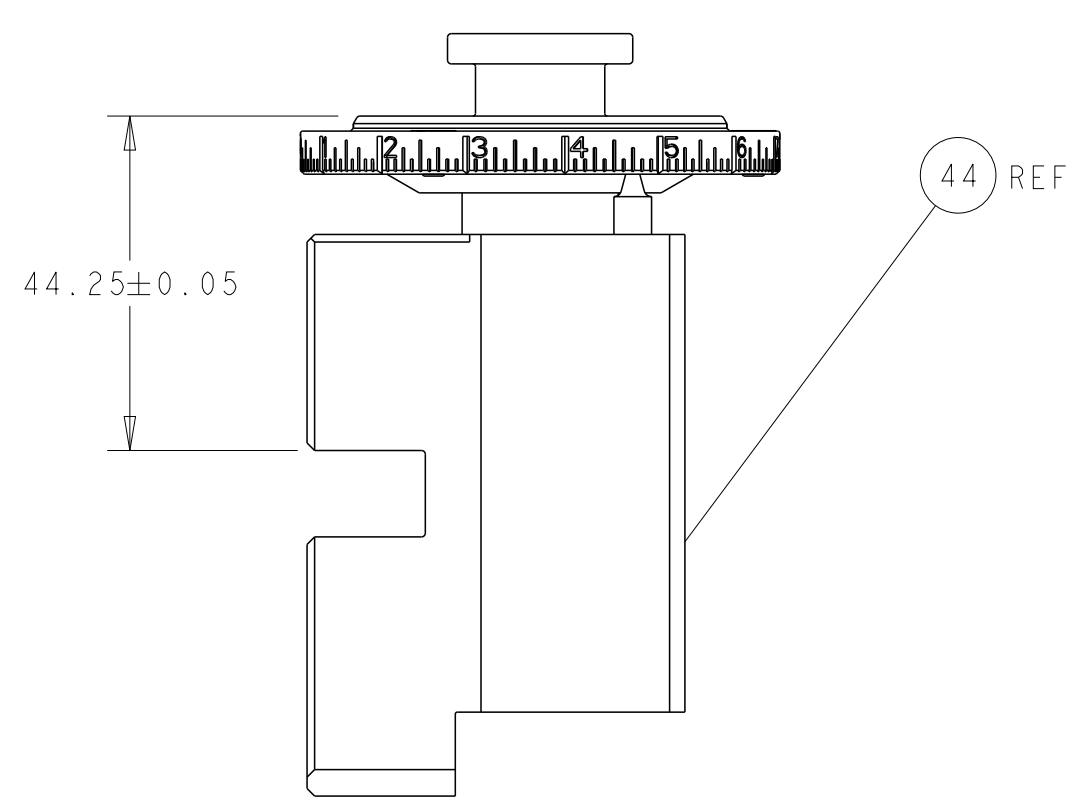
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				ECR-21-001295	01FEB2021	TB	RK

-	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	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	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	
-	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	2063961-8	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	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	-	2063961-8	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	2-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	690455-2	STRIPPER, FRONT CASTING	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	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	1	691901-7	REAR SHEAR PLATE, REVERSIBLE	11	
-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10	
1	-	1	1	1	1-690783-0	PLATE, SPACER	9	
1	1	2	2	1	1	2-1803257-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	460507-1	BLADE, SHEAR	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	9-1803187-5	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
1	2	2	1	1	1633730-3	CRIMPER, WIRE	1	
-	77	72	71	2	-1	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)

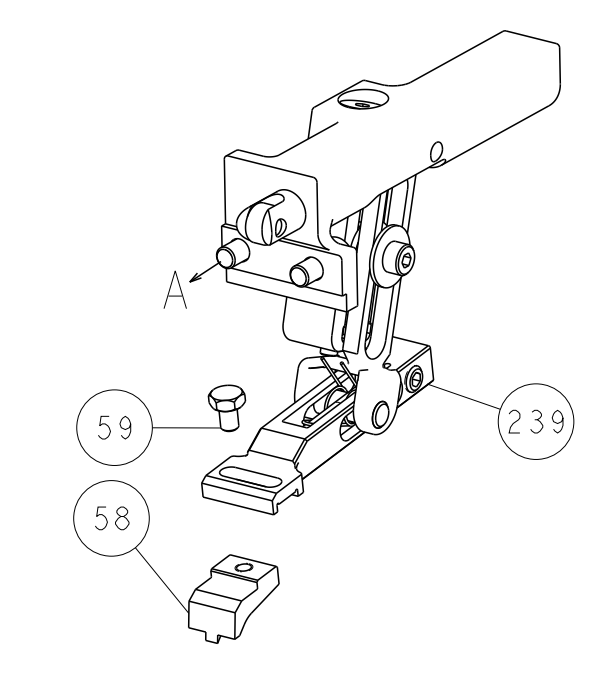
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LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1		-	-

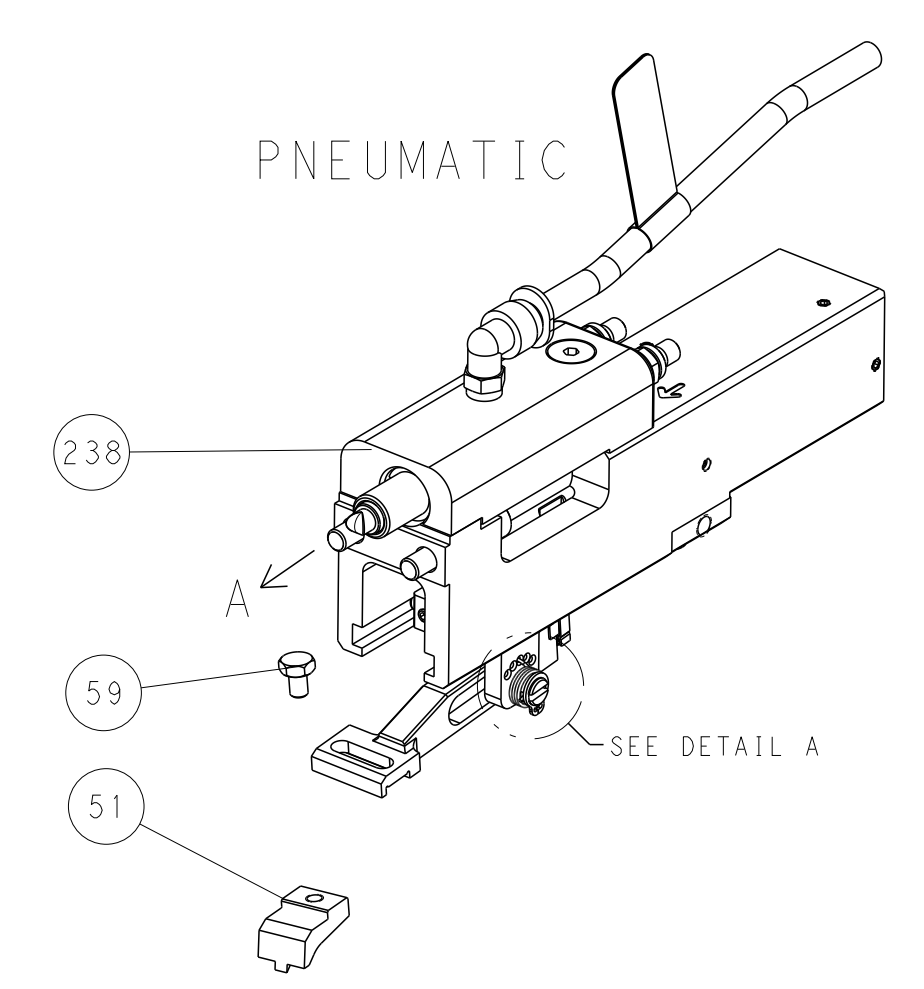


RAM SET-UP

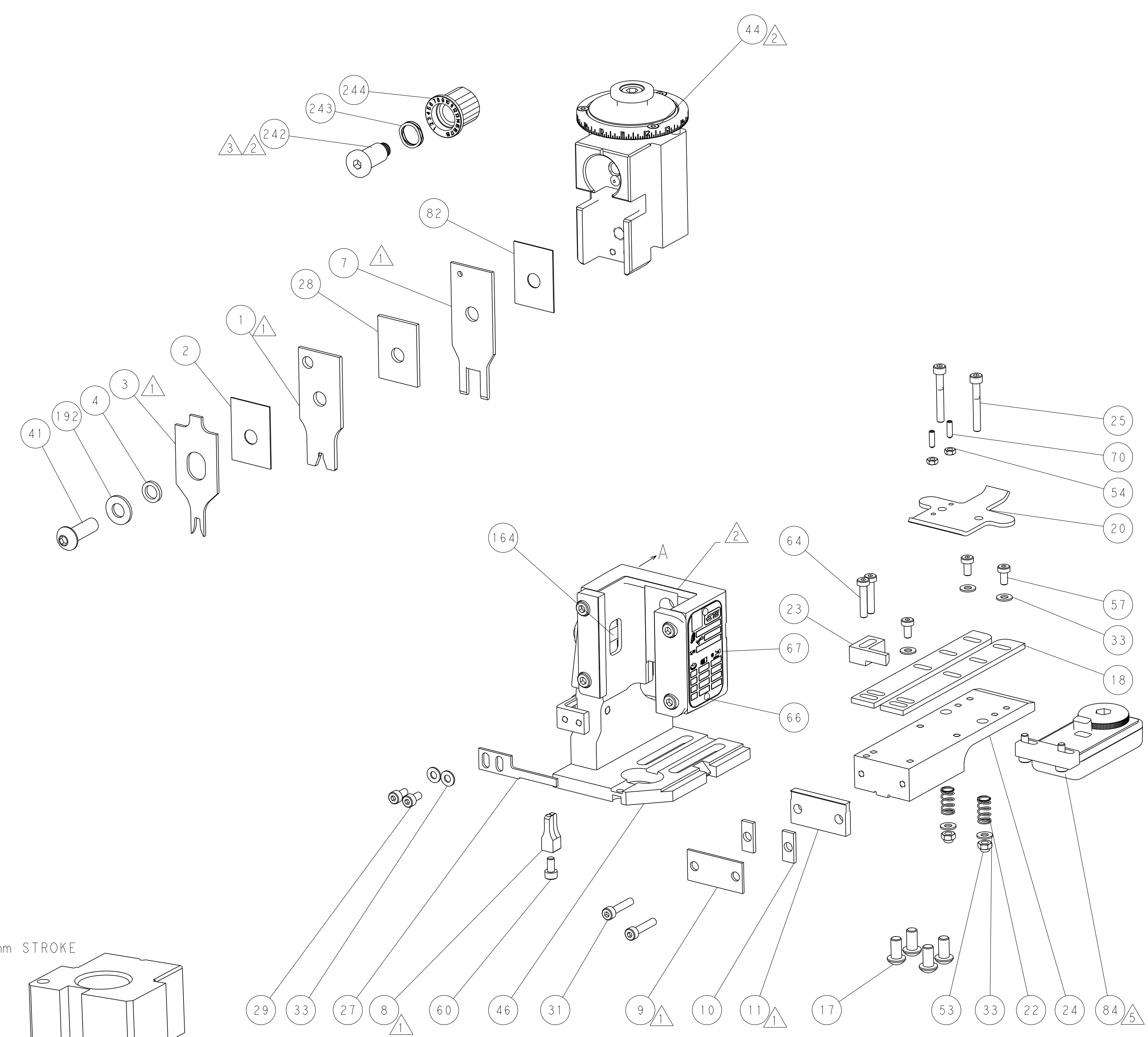
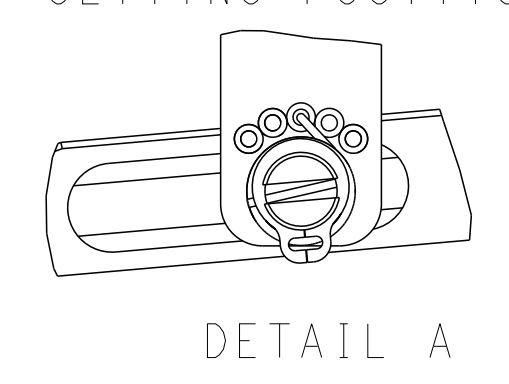
FEED TYPE
MECHANICAL



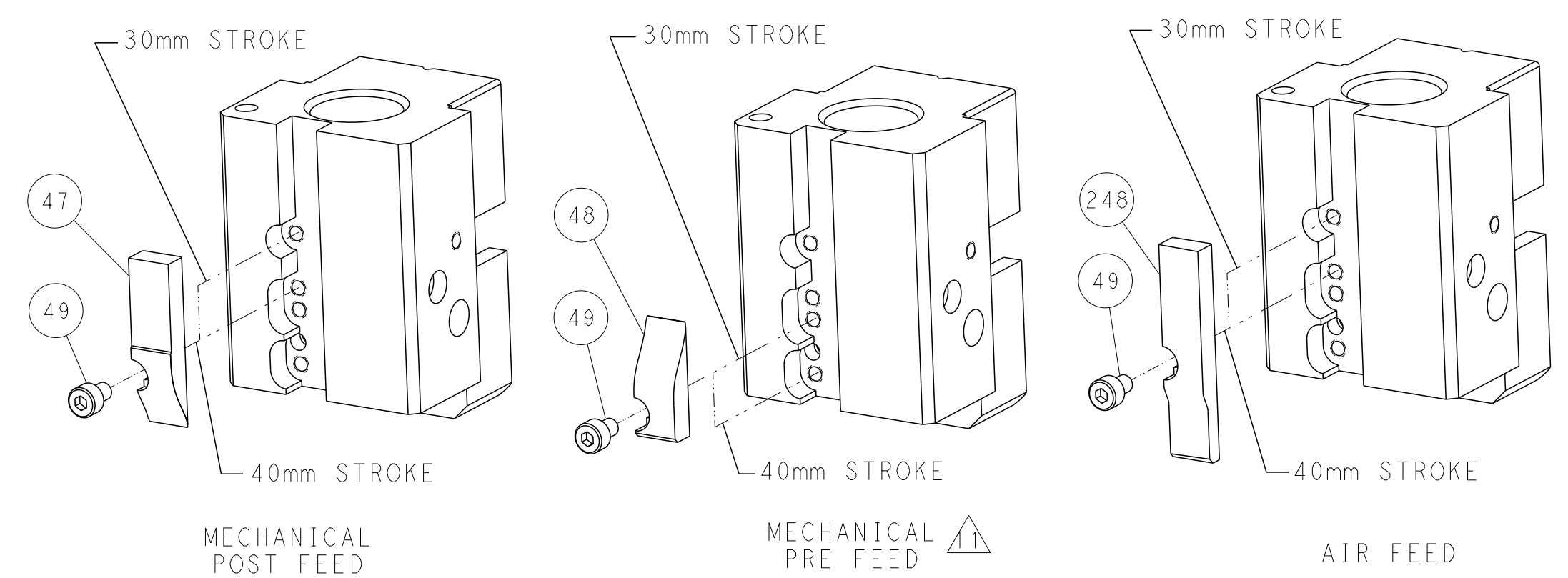
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

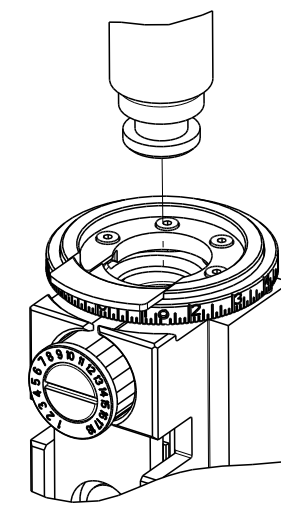


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 26 JAN 2017 CHK J. DEGRANGE 26 JAN 2017 APVD J. DEGRANGE 26 JAN 2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean End Feed Applicator APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 ©=2150771 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV C

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		2017			
COPYRIGHT 2017 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150771-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2150771-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150771-7	A	CRIMP TOOLING KIT	-				

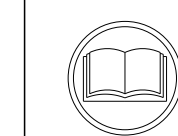
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: WELD TAB			
WIRE STRIP LENGTH 2.72-3.48 mm [.107-.137 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2093	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40990	40990-1	40990-2	40990-4
60581-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.68+/-0.05 [.066+/-0.002]	4.4
18 AWG	1.55+/-0.05 [.061+/-0.002]	5.8
20 AWG	1.45+/-0.05 [.057+/-0.002]	6.9



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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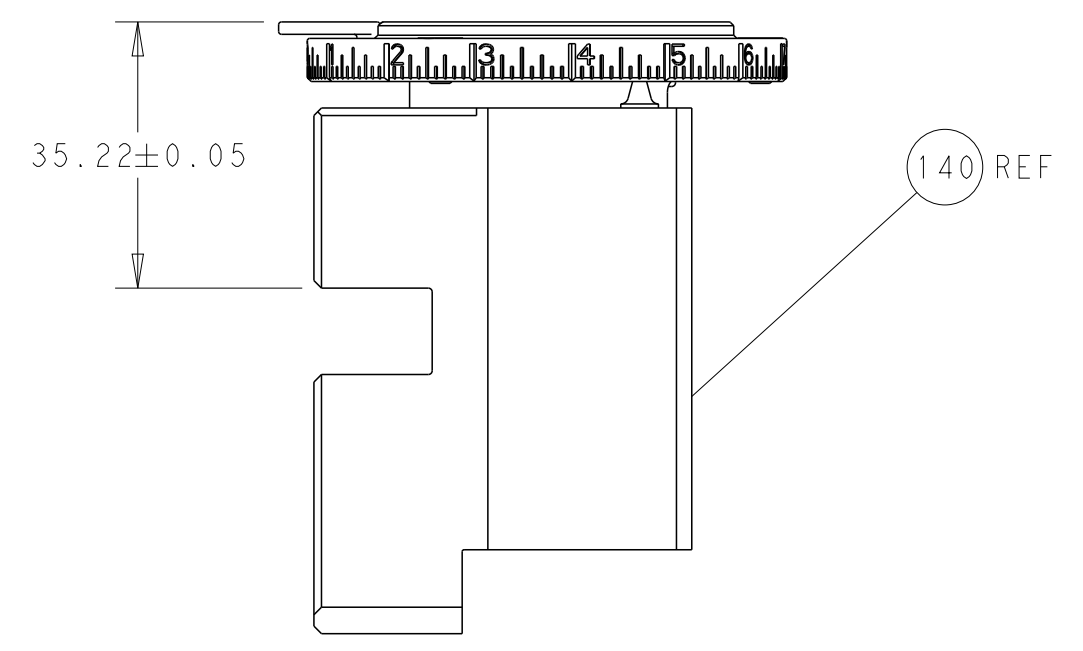
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

3	-	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
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	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
5	-	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
	-	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	2063961-8	FEED FINGER	58
	-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	-	2063961-8	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	2-455888-0	SPACER, CRIMPER	28
	-	1	1	690455-2	STRIPPER, FRONT CASTING	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	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-6	GUIDE, LOWER STRIP	18
1	-	1	1	691901-7	REAR SHEAR PLATE, REVERSIBLE	11
	-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
1	-	1	1	1-690783-0	PLATE, SPACER	9
1	1	1	1	2-1803257-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	460507-1	BLADE, SHEAR	7
	-	-	-	-	-	6
	-	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1	9-1803187-5	CRIMPER, INSULATION F	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1633730-3	CRIMPER, WIRE	1
	-	77	22	21	PART NO	ITEM NO

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

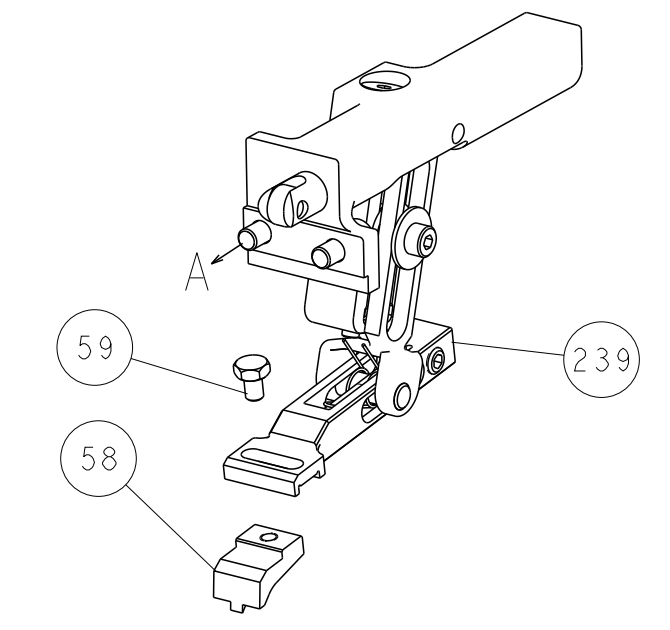
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0 PLC	±	1 PLC	±	CHK: J. DEGRANGE 26 JAN 2017	NAME: Ocean End Feed Applicator		
2 PLC	±	3 PLC	±	APVD: J. DEGRANGE 26 JAN 2017	SIZE: A1		
4 PLC	±	ANGLES	±	PRODUCT SPEC	CAGE CODE: 00779		
MATERIAL	FINISH	APPLICATION SPEC		DRAWING NO: 2150771		RESTRICTED TO: -	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 OF 4	

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

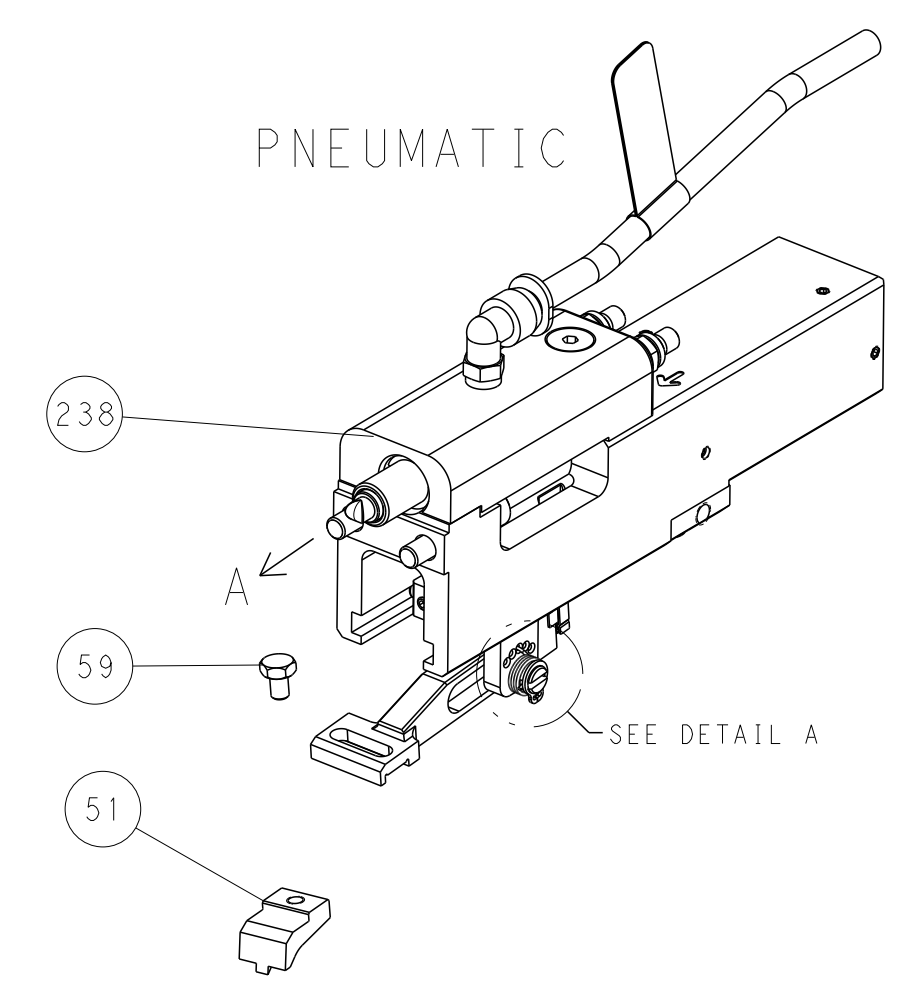


RAM SET-UP

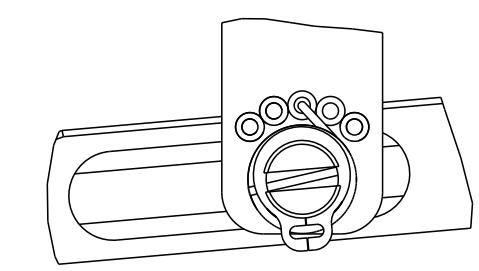
FEED TYPE
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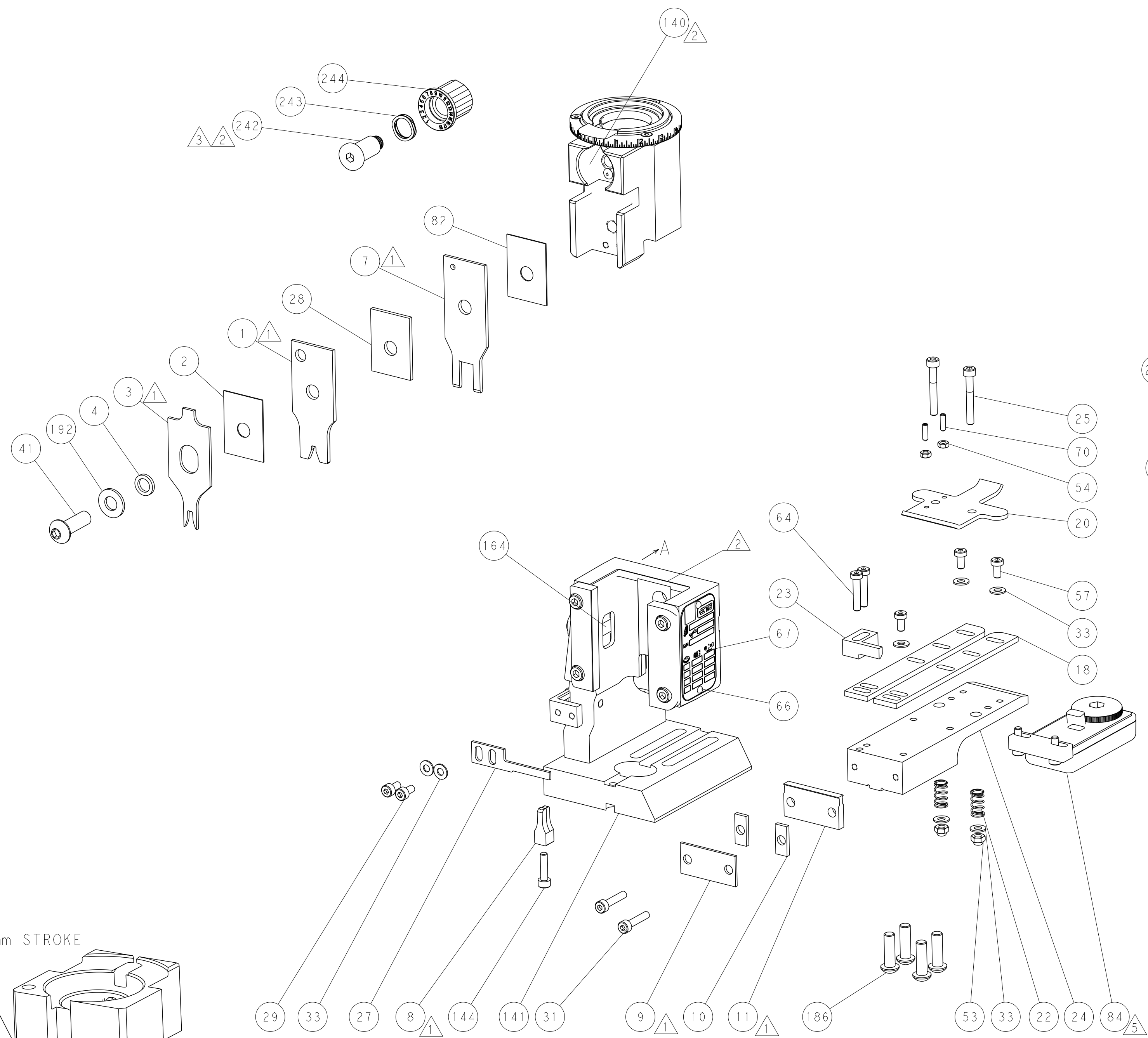
PNEUMATIC



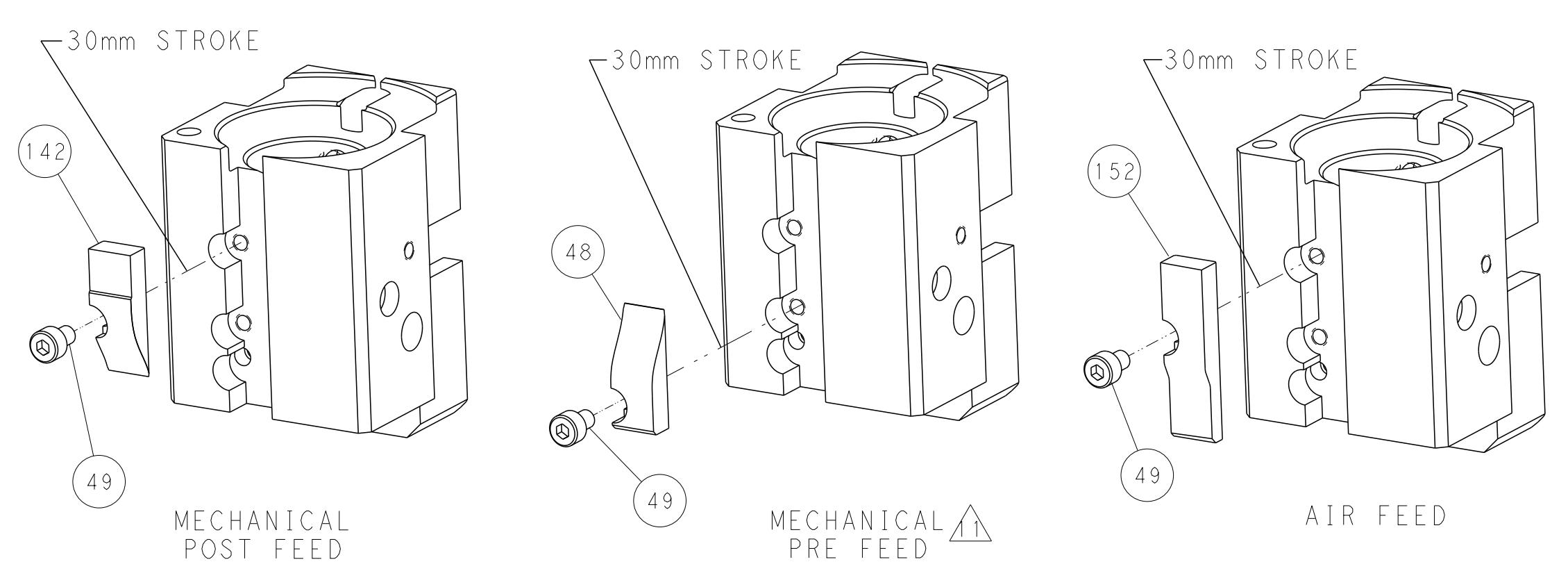
FEED SPRING
SETTING POSITION



DETAIL A



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 B. WEAVER 26 JAN 2017		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	RESTRICTED TO
	ANGLES ±	FINISH		APVD J. DEGRANGE 26 JAN 2017	PRODUCT SPEC	Customer Accessible Production Drawing	
MATERIAL		WEIGHT		APVD J. DEGRANGE 26 JAN 2017	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	REV C
						A1 00779 C=2150771	
				SCALE 1:1		SHEET 4 OF 4	

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