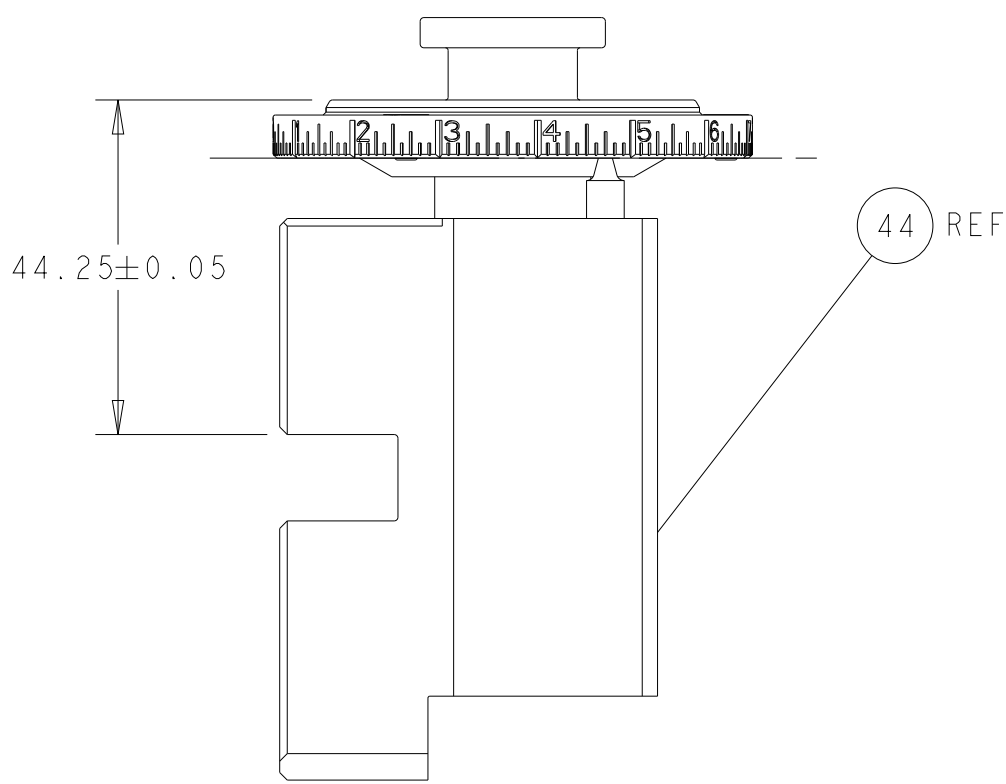
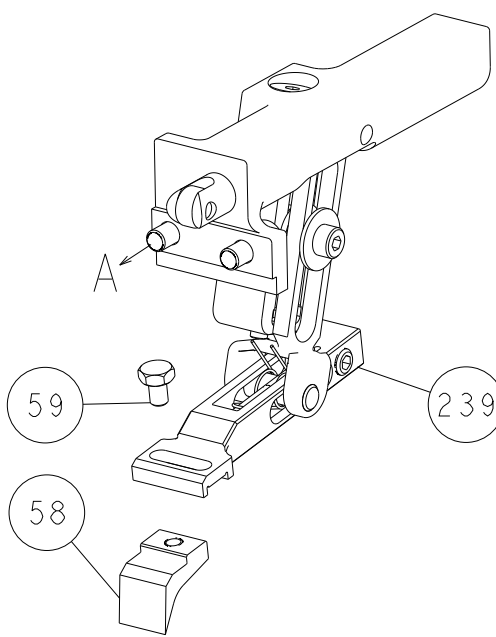


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

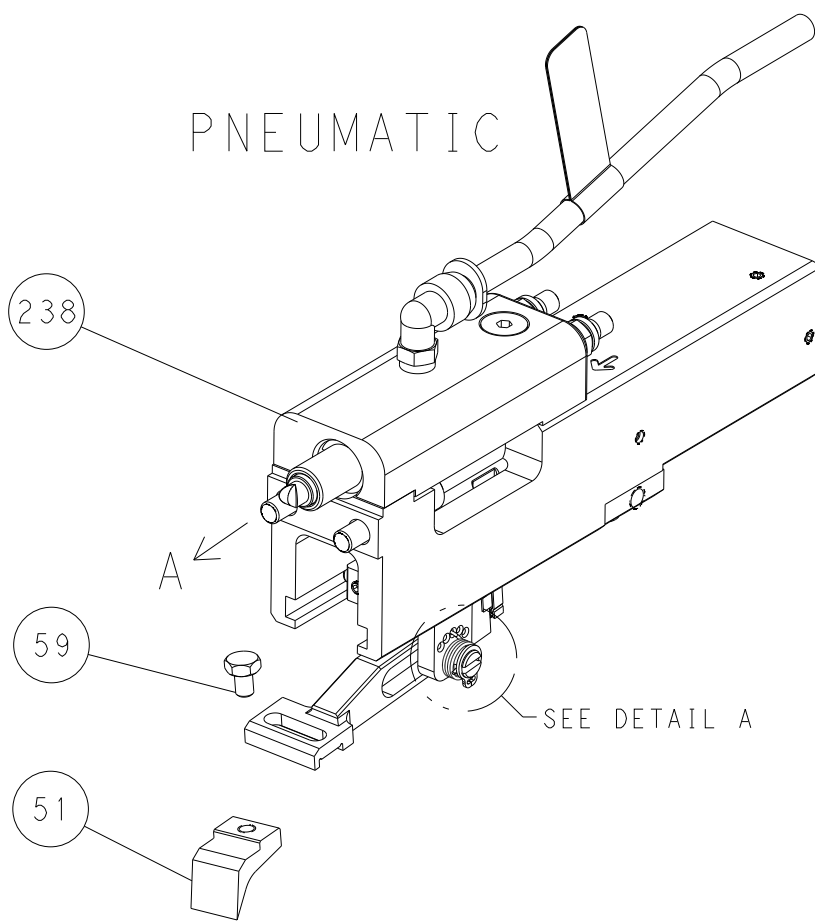


RAM SET-UP

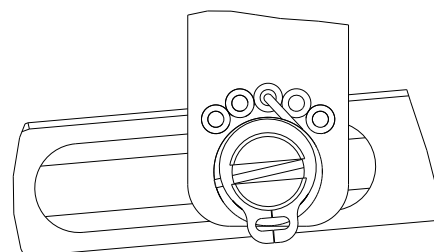
FEED TYPE MECHANICAL



PNEUMATIC

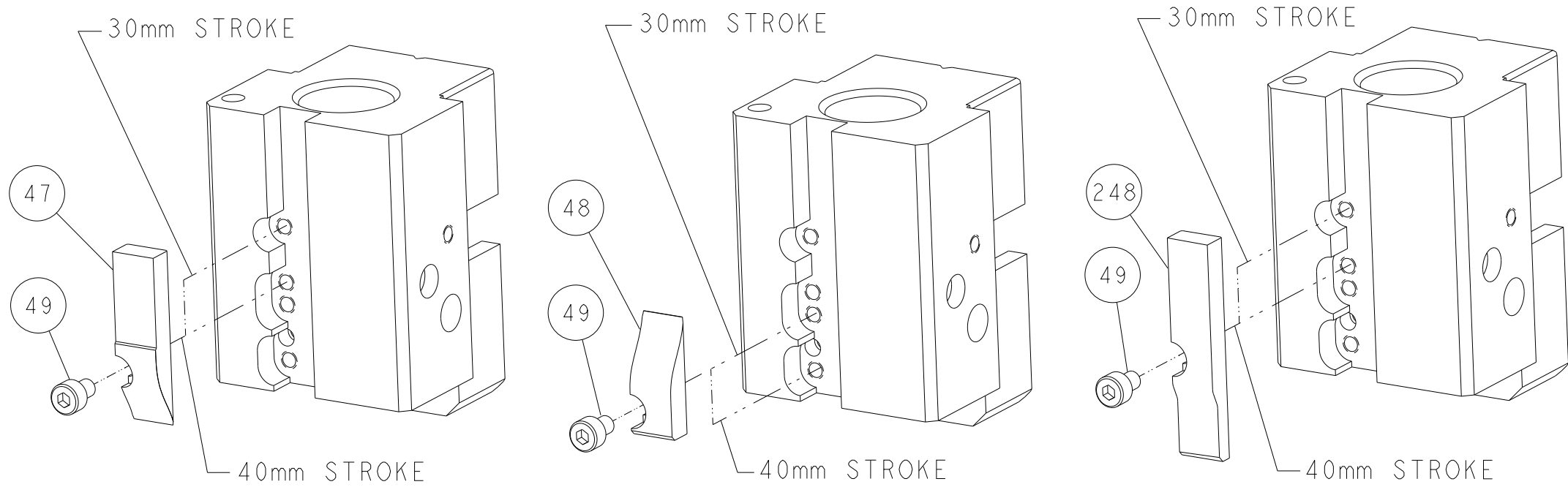


FEED SPRING
SETTING POSITION



DETAIL A

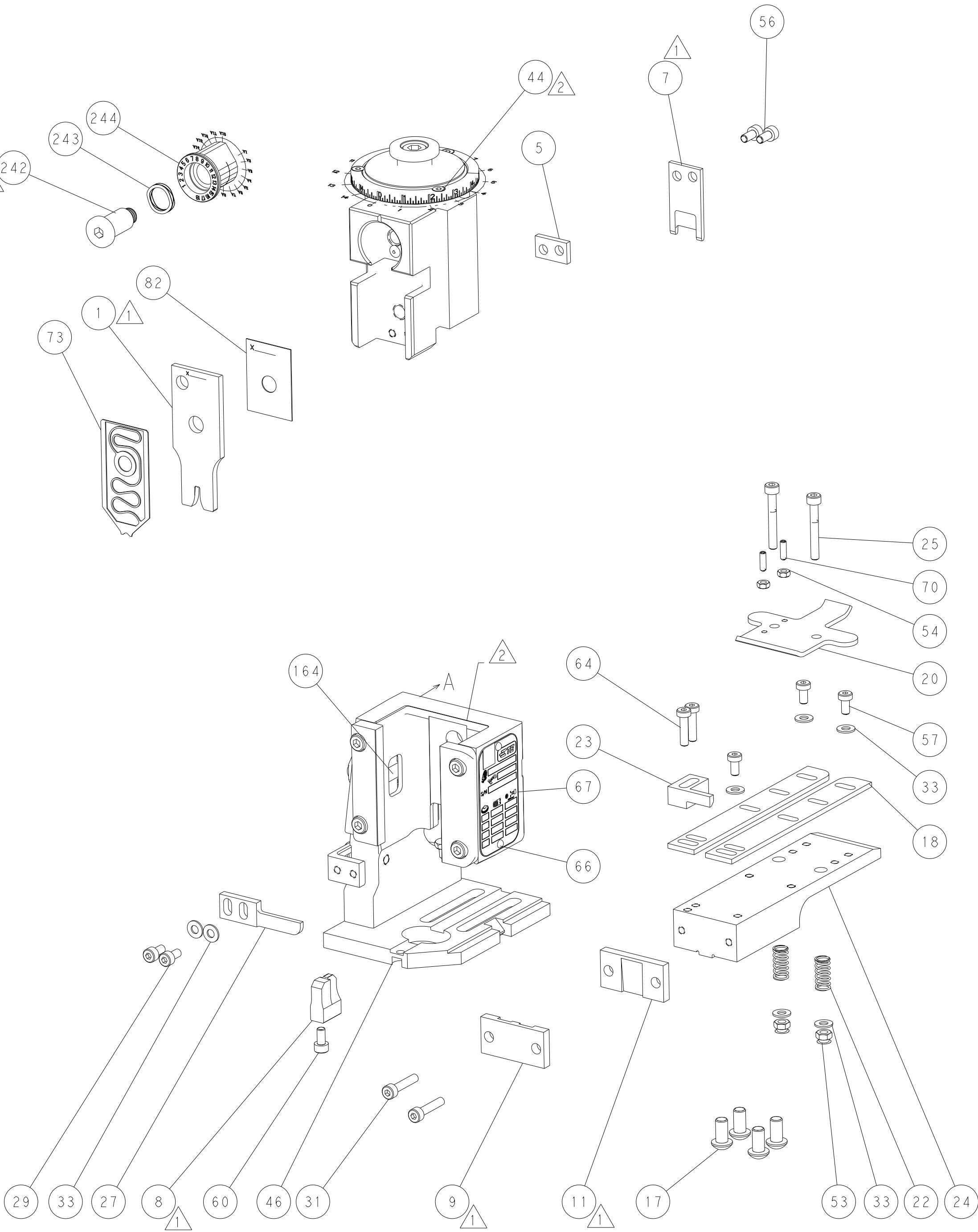
CAM POSITIONS



MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED



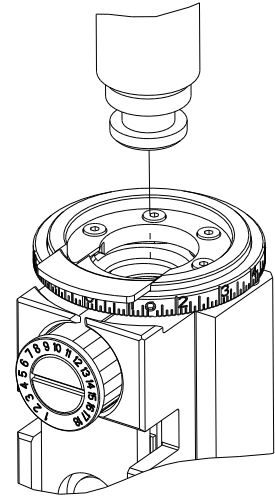
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY CONTROL AND END-USERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 22JAN2013	 TE Connectivity Harrisburg, PA 17105-3608						
				CHK S. XI 22JAN2013					APVD S. XI 22JAN2013		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH							
				PRODUCT SPEC APPLICATION SPEC WEIGHT							
MATERIAL				SIZE CAGE CODE DRAWING NO							
				RESTRICTED TO							
				A 00779 C=2150312							
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV D							

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150312-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150312-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150312-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	6.35 mm [.250]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .187 SERIES			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]			INSULATION DIAMETER RANGE Ø4.57-5.84 mm [.180-.230 IN]
TERMINAL APPLICATION SPECIFICATION	 114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63596-1	63596-2	60742-1	60742-2
63832-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2x AWG 16		1.96+/-0.05 [.077+/- .002]		3.4
14 AWG		1.80+/-0.05 [.071+/- .002]		5.3
16 AWG		1.58+/-0.05 [.062+/- .002]		7.6
18 AWG		1.42+/-0.05 [.056+/- .002]		9.2



- 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.

*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)

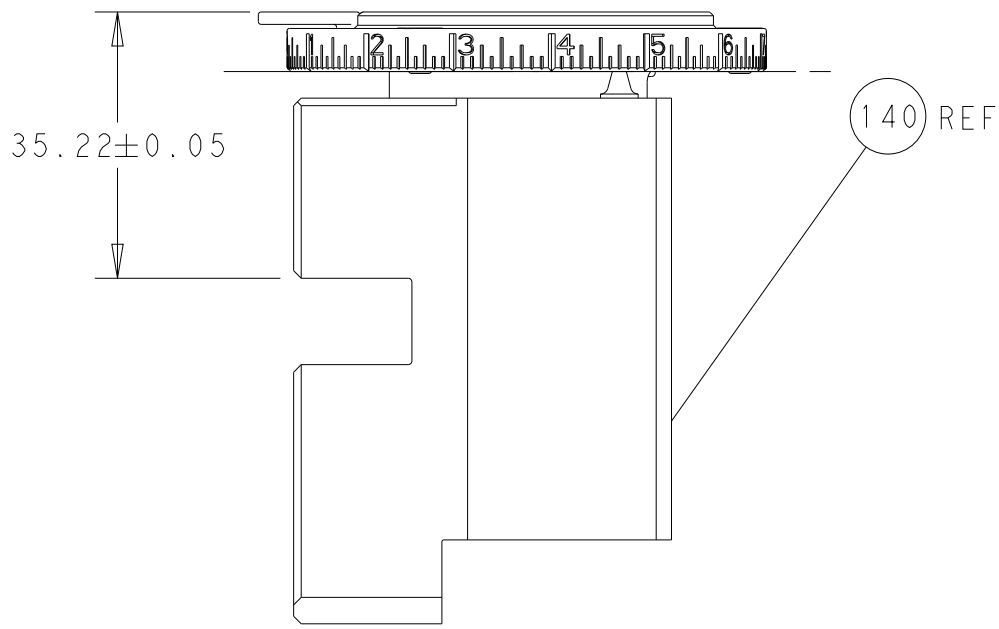
2				I			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	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	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
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	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	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-1	FEED FINGER	58
	-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	-	2063961-1	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	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
	-	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	1901259-5	GUIDE, LOWER STRIP	18
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	5-690482-7	PLATE, FRONT SHEAR	9
1	1	1	1	1803074-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-5	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	5-240641-2	SPACER	5
	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1803019-2	CRIMPER, INSULATION O	3
	-	-	-	-	-	2
1	1	1	1	456408-3	CRIMPER, WIRE PREMIUM	1
	- 77-22-21			PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN R. HUANG CHK S. XI APVD S. XI	22JAN2013 22JAN2013 22JAN2013	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -		A 00779 ©=2150312 Customer Accessible Production Drawing	
		SCALE 1:1		SHEET 3 OF 4 REV D	

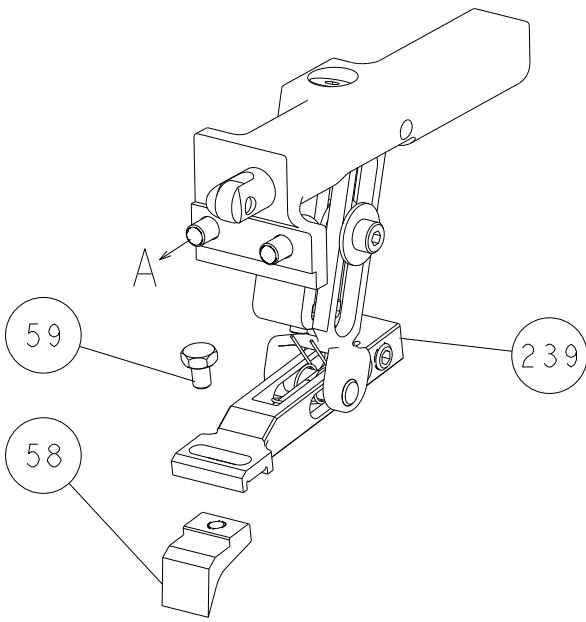
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

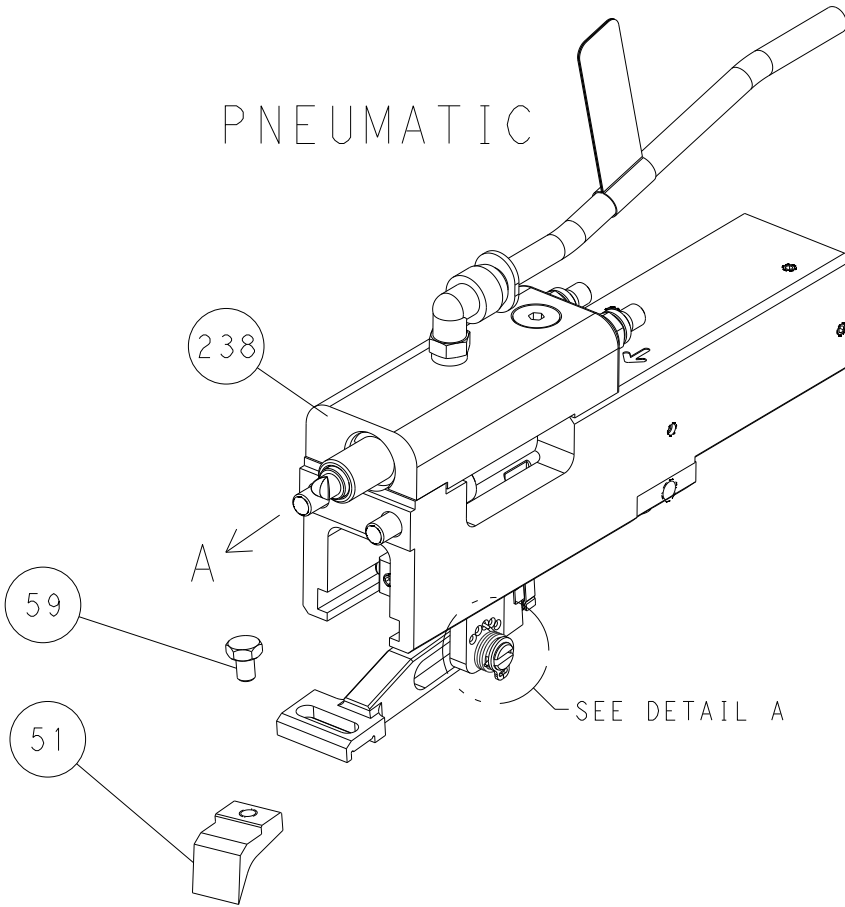


RAM SET-UP

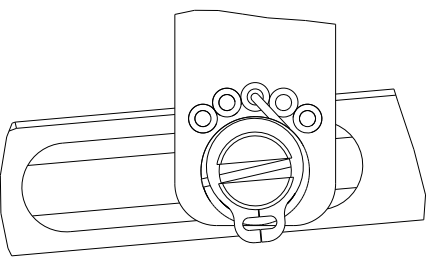
FEED TYPE
MECHANICAL



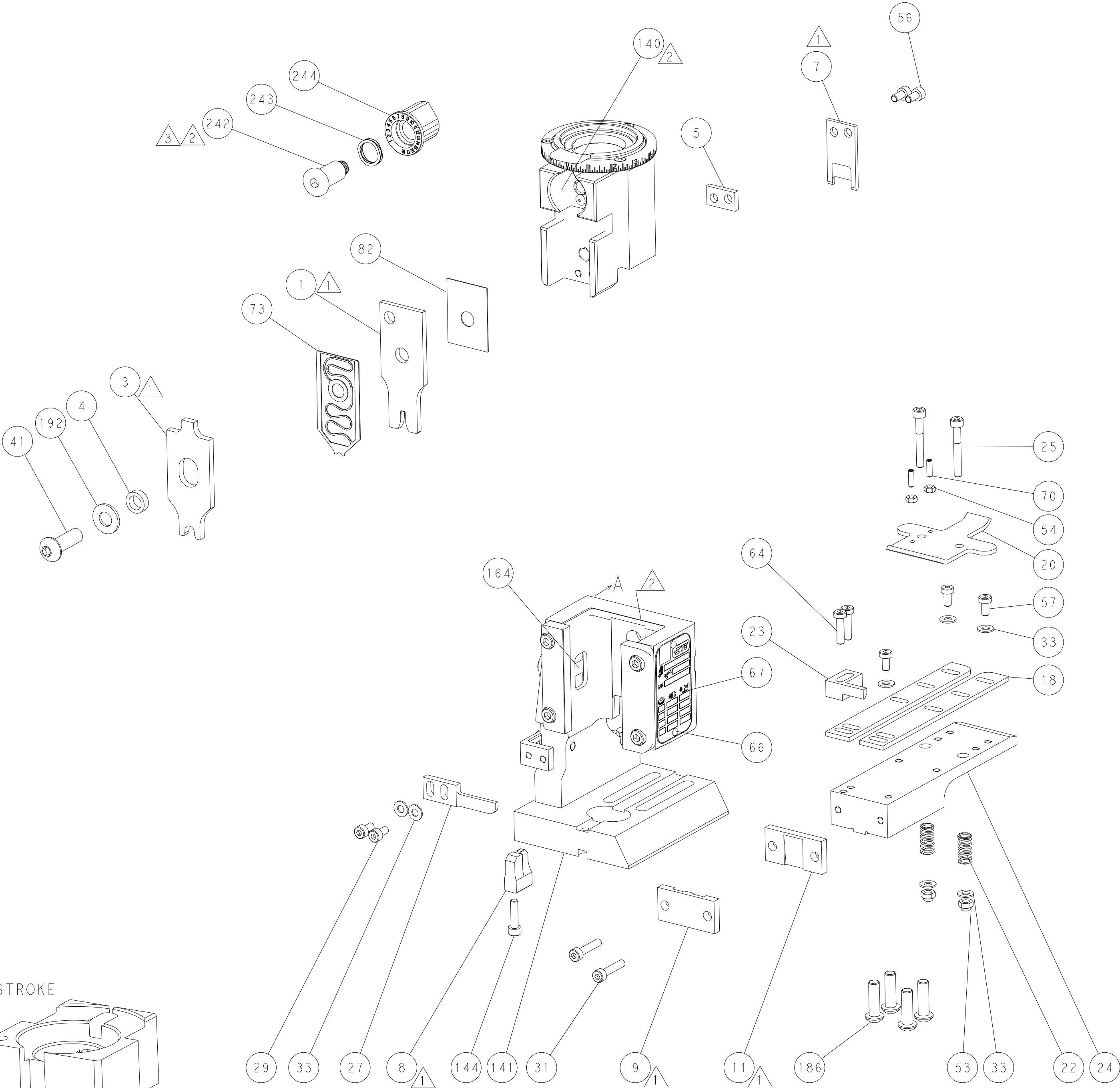
PNEUMATIC



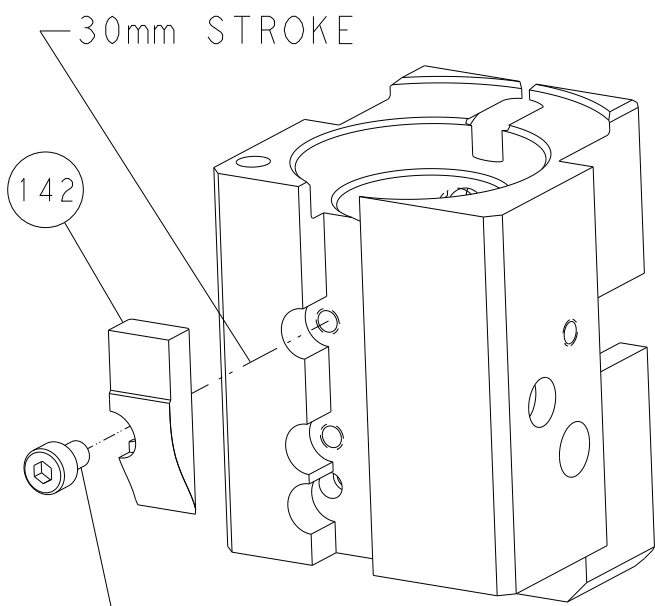
FEED SPRING
SETTING POSITION



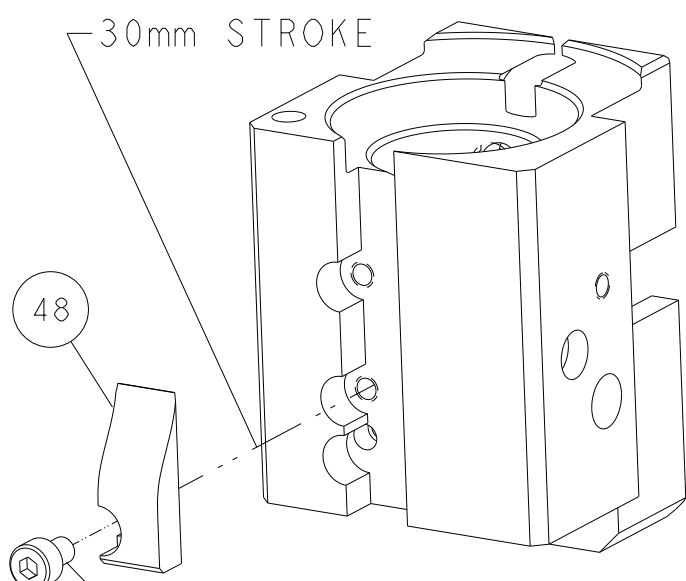
DETAIL A



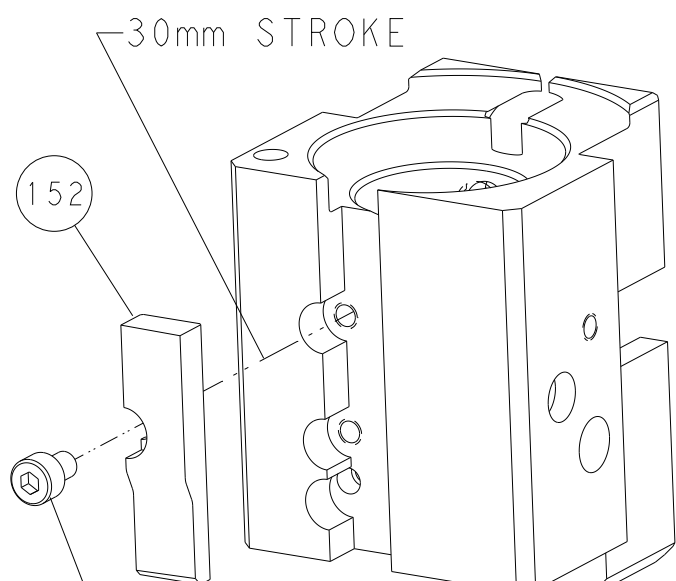
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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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				CHK S. XI	22JAN2013						
				APVD S. XI	22JAN2013	NAME					
				PRODUCT SPEC		Ocean End Feed Applicator					
				APPLICATION SPEC							
				WEIGHT		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
						A1		00779	C=2150312	-	
				Customer Accessible Production Drawing		SCALE		1:1	SHEET	4 of 4	REV D