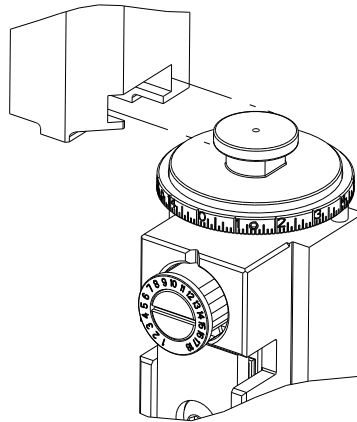


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150365-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150365-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150365-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150365-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150365-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.35MM E-SPRING CONTACT RECEPTACLE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.50-5.10 mm [.177-.201 IN]			Ø2.00-3.00 mm [.079-.118 IN]
TERMINAL APPLICATION SPECIFICATION	114-22017	-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
336075-1	336075-3	336075-5	336075-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.75+/-0.05 [.069+/- .002]	5.5
1.00mm2	1.57+/-0.05 [.062+/- .002]	7.4
0.5+0.5	1.57+/-0.05 [.062+/- .002]	7.4
0.75mm2	1.48+/-0.05 [.058+/- .002]	8.5
0.50mm2	1.39+/-0.05 [.055+/- .002]	9.6

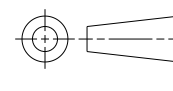


- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 INSULATION DIAMETER FOR DOUBLE WIRE CRIMP 2X0.5mm IS 2 X 2.10mm DIAMETER MAX.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

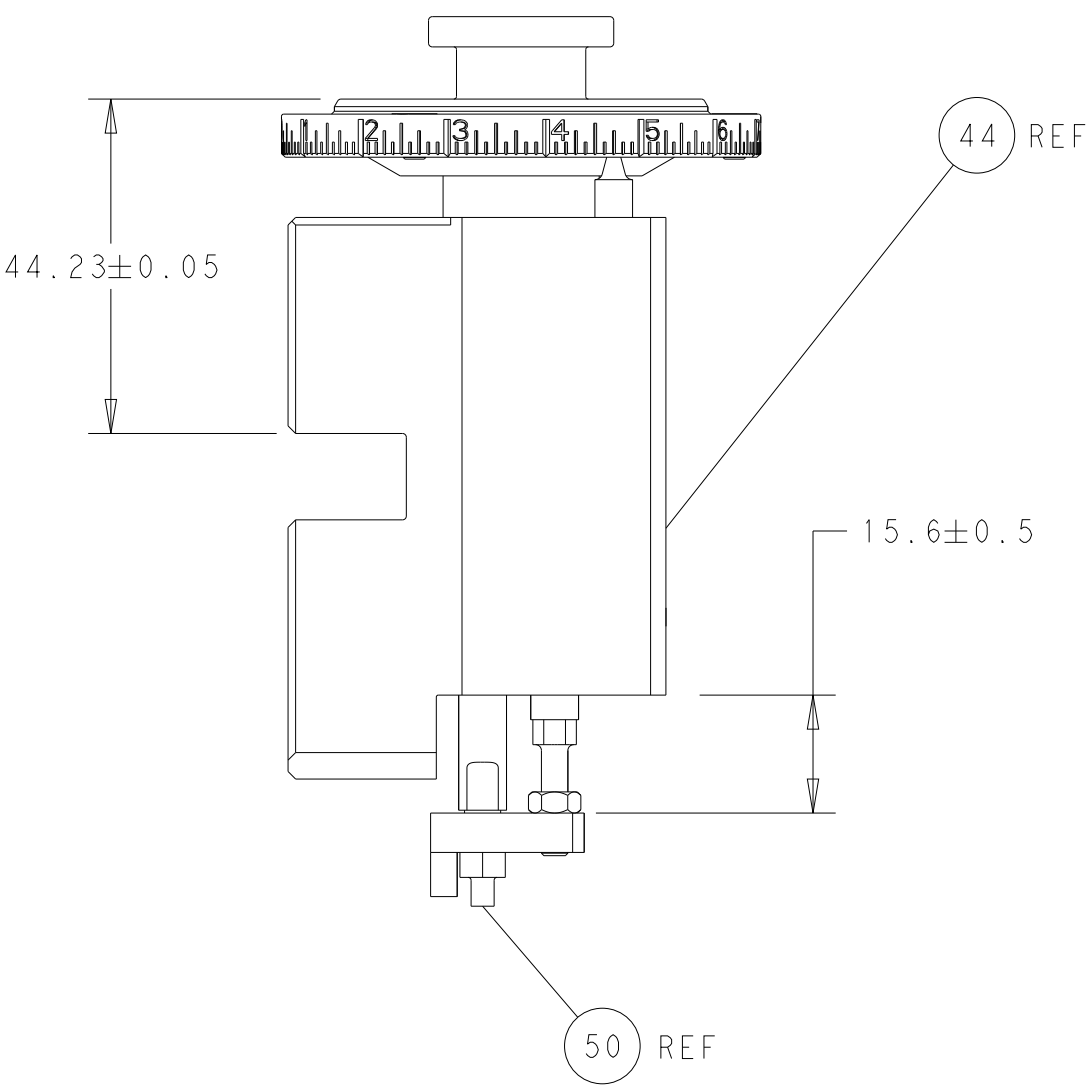
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		A		RELEASED	10OCT2013	YY	UG
		B		ECR-19-004644	22MAR2019	TB	CT
		C		ECR-21-006610	30 JUN2021	FZ	TE

	-	1	-	1		2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	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	
	-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65	
	-	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	2063961-1	FEED FINGER	58	
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
	-	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
	-	1	-	1	-	2063961-1	FEED FINGER	51	
3	-	1	1	1	1	1-1976055-3	STANDOFF, HOLD-DOWN	50	
	-	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	240639-1	STRIPPER (MACHINING)	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	2-22281-3	SPRING, COMPRESSION	22	
	-	1	1	1	1	1803292-4	DRAG	20	
	-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18	
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
	-	-	-	-	-	-	-	10	
1	-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	2-1803001-9	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	2217206-5	BLADE, SLUG	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1-240641-0	SPACER	5	
	-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456406-5	CRIMPER, WIRE PREMIUM	1	
	-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

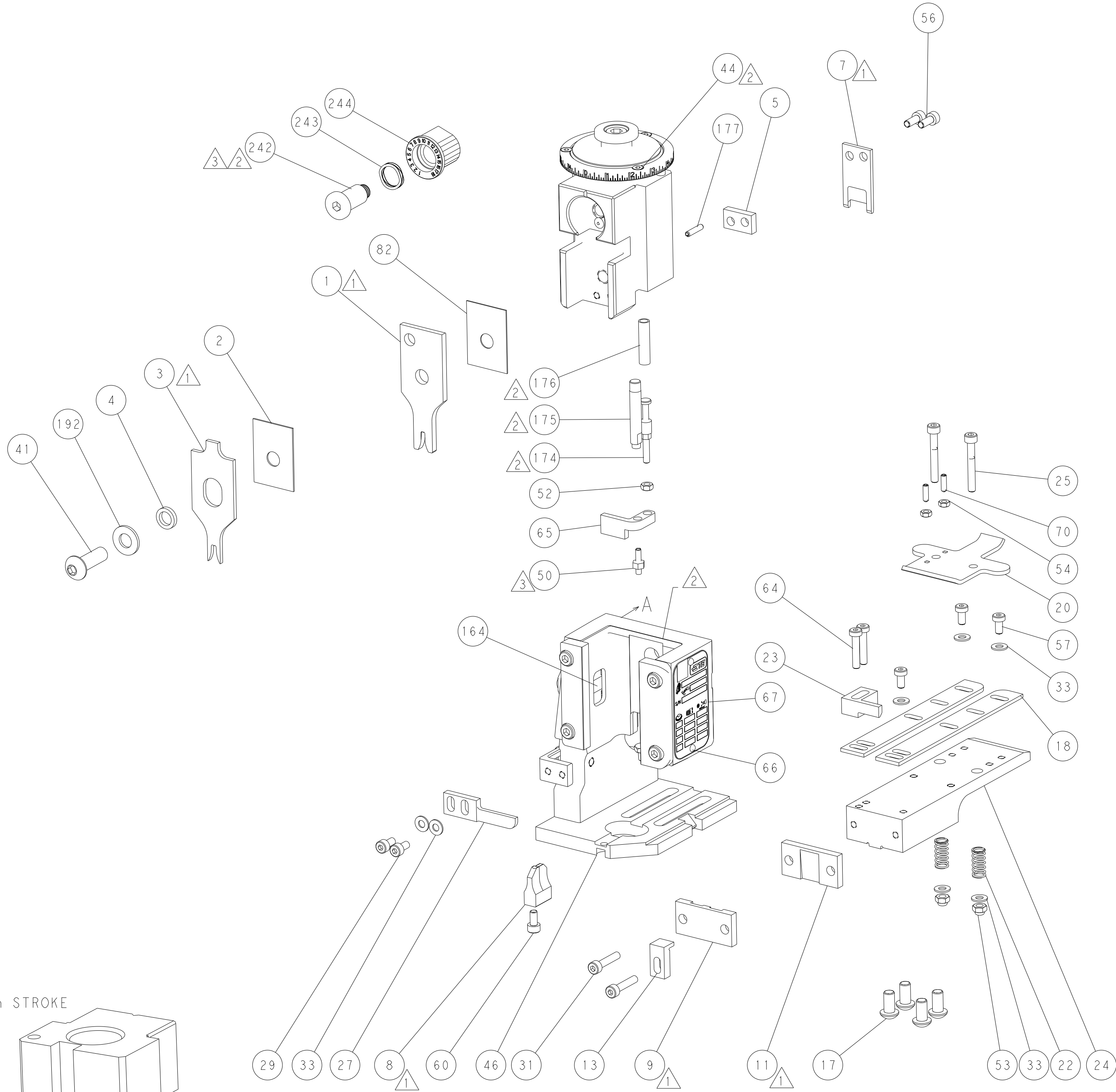
THIS DRAWING IS A CONTROLLED DOCUMENT FOR FPCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE SAME CONTROL AND REVISIONING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	13SEP2013	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	Y. YIN					13SEP2013
				APVD	G. BAILEY					13SEP2013
				U. GUO	13SEP2013					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		Ocean End Feed Applicator		
mm		0 PLC ±.01		APPLICATION SPEC						
		1 PLC ±.01		-						
		2 PLC ±.01								
		3 PLC ±.01								
		4 PLC ±.01								
		ANGLES		±.1°						
		FINISH								
MATERIAL				WEIGHT		SIZE		CAGE CODE		
				-		A1		00779		
						C=		2150365		
Customer Accessible Production Drawing						SCALE		1:1		
						SHEET		1 OF 4		
						REV		C		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

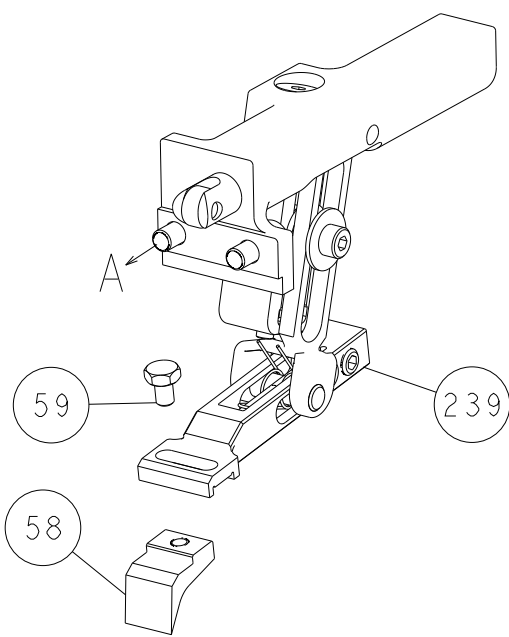
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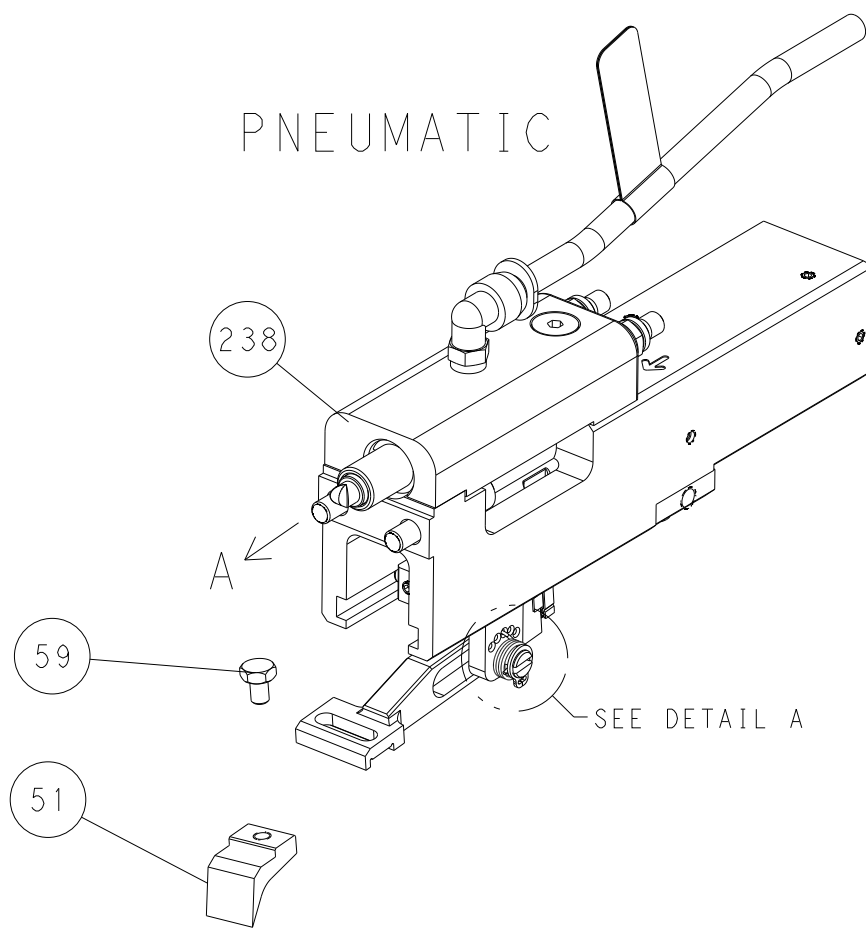
RAM AND HOLDDOWN SET-UP



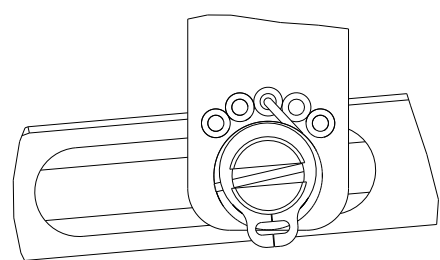
FEED TYPE
MECHANICAL



PNEUMATIC

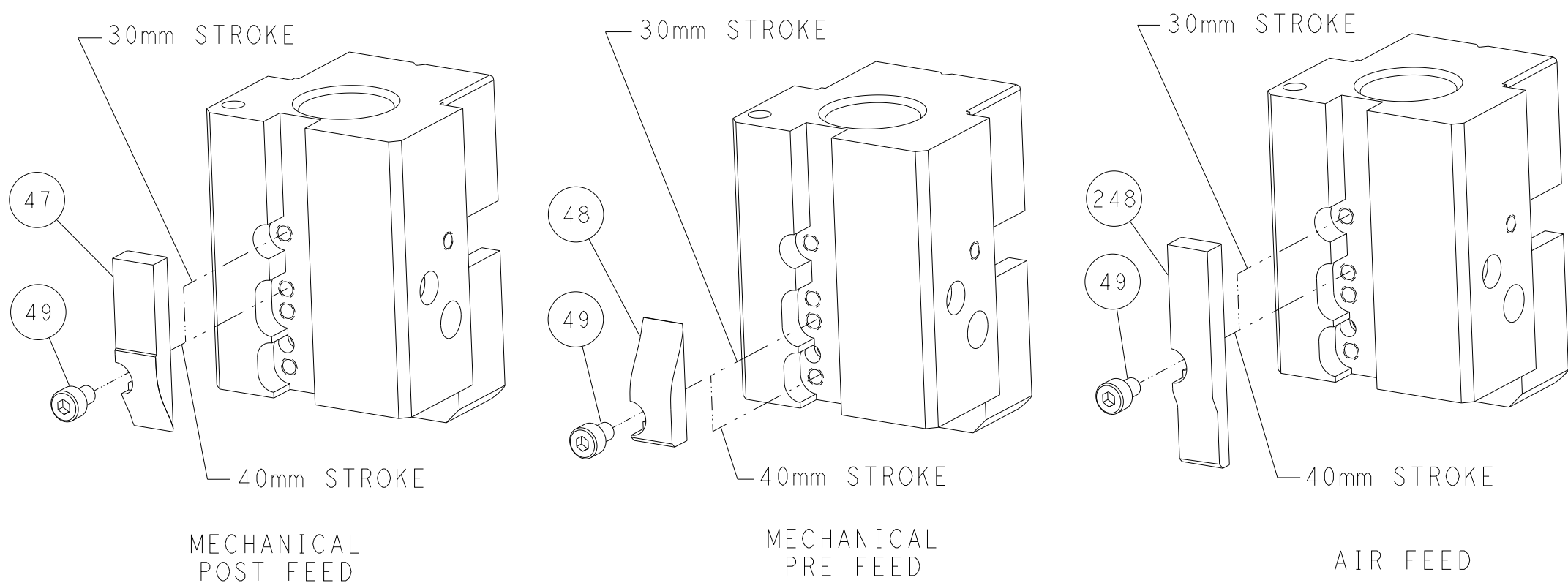


FEED SPRING
SETTING POSITION



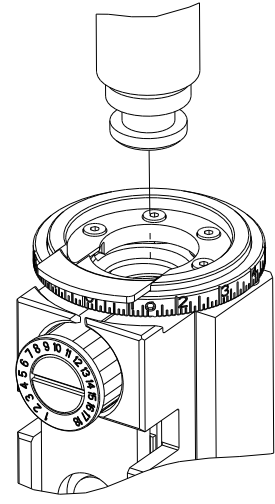
DETAIL A

CAM POSITIONS



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 VERSION.				DWN Y. YIN 13SEP2013	TE Connectivity Harrisburg, PA 17105-3608		
				CHK G. BAILEY 13SEP2013			
				APVD J. GUO 13SEP2013	NAME Ocean End Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE 1:1			
				SHEET 2			
				REV C			



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.35MM E-SPRING CONTACT RECEPTACLE			
WIRE STRIP LENGTH 4.50-5.10 mm [.177-.201 IN]		INSULATION DIAMETER RANGE Ø2.00-3.00 mm [.079-.118 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
336075-1	336075-3	336075-5	336075-6

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.50mm2		1.75+/-0.05 [0.069+/- .002]		5.5
1.00mm2		1.57+/-0.05 [0.062+/- .002]		7.4
0.5+0.5		1.57+/-0.05 [0.062+/- .002]		7.4
0.75mm2		1.48+/-0.05 [0.058+/- .002]		8.5
0.50mm2		1.39+/-0.05 [0.055+/- .002]		9.6



- 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 50.
 - 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 INSULATION DIAMETER FOR DOUBLE WIRE CRIMP 2X0.5mm IS 2 X 2.10mm DIAMETER MAX.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

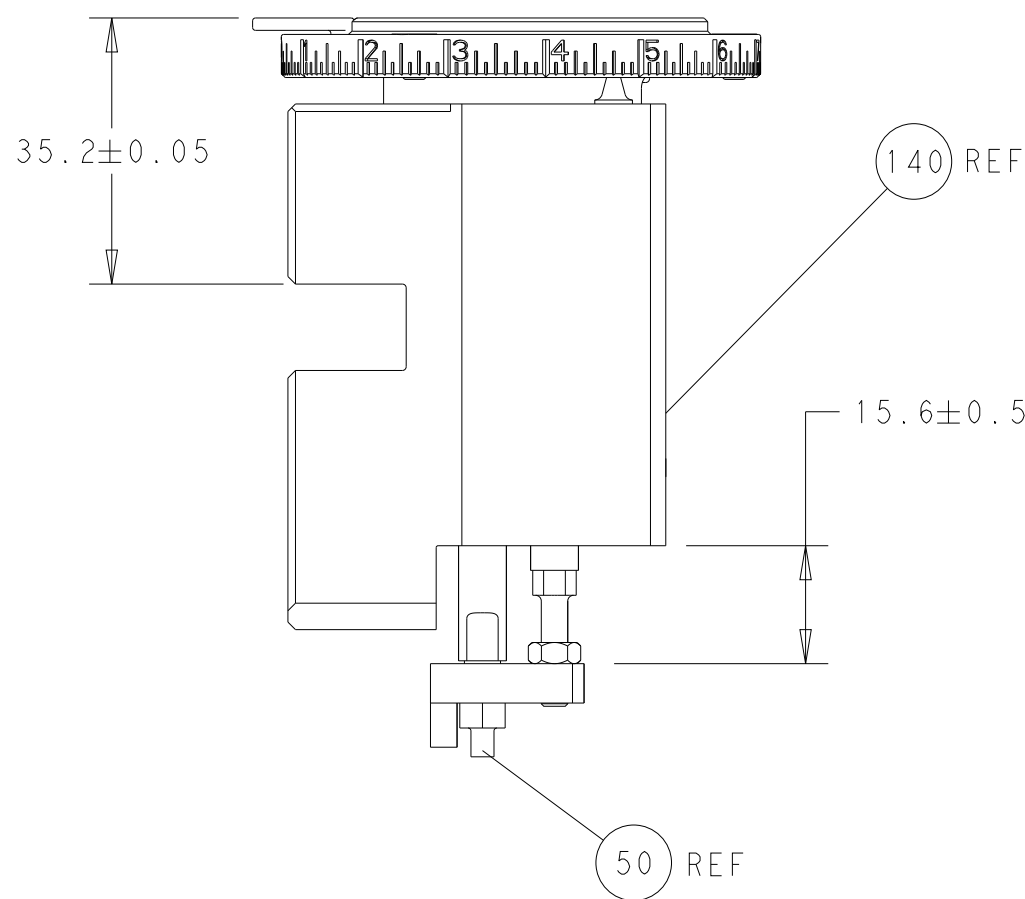
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*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE
SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE
SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO
THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR
PROPER SETUP AND ADJUSTMENTS.
```

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

[illegible]

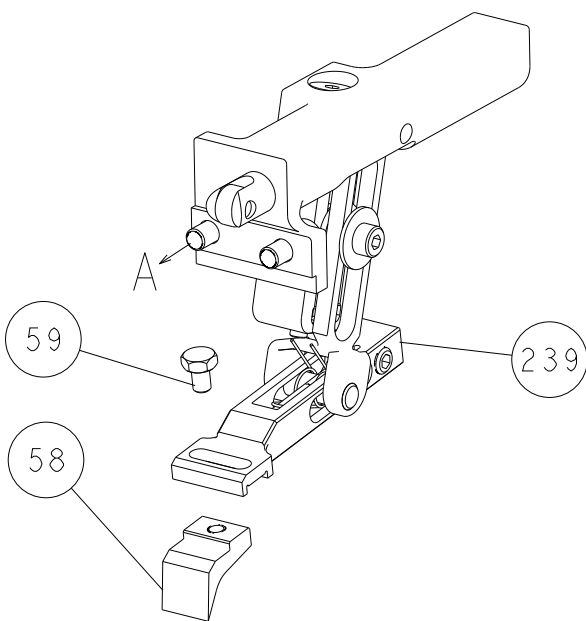
(THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE USE OF ALL INFORMATION ASSOCIATION SHOULD BE CONTACTED FOR THE LATEST VERSION) DWN 13SEP2013 E.LIN 13SEP2013 CHG G.BAILEY 13SEP2013 APD U.GUO 13SEP2013						 TE Connectivity Harrisburg PA 17105-3608					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME							
mm				PRODUCT SPEC		Ocean End Feed Applicator					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APPLICATION SPEC		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
MATERIAL	-	-		WEIGHT		A	00779	C=	2150365	-	
Customer Accessible Production Drawing								SCALE	1:1	SHEET	3 OF 4 REV C

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

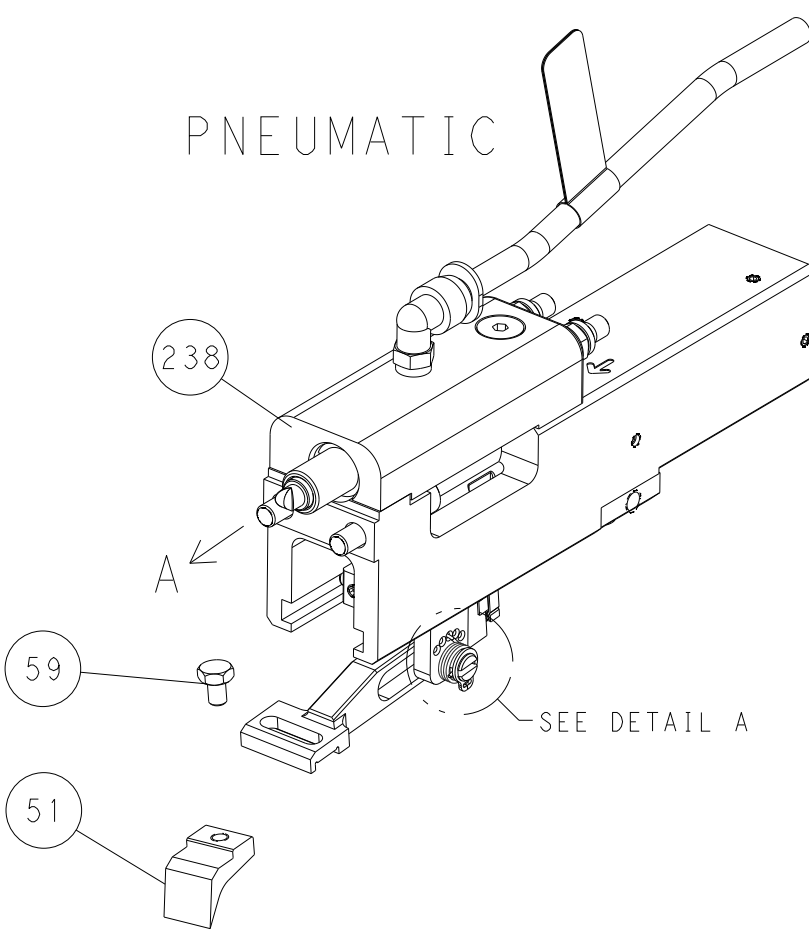


RAM AND HOLDDOWN SET-UP

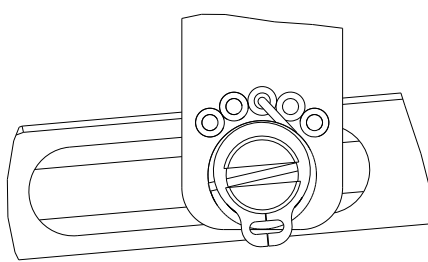
FEED TYPE
MECHANICAL



PNEUMATIC

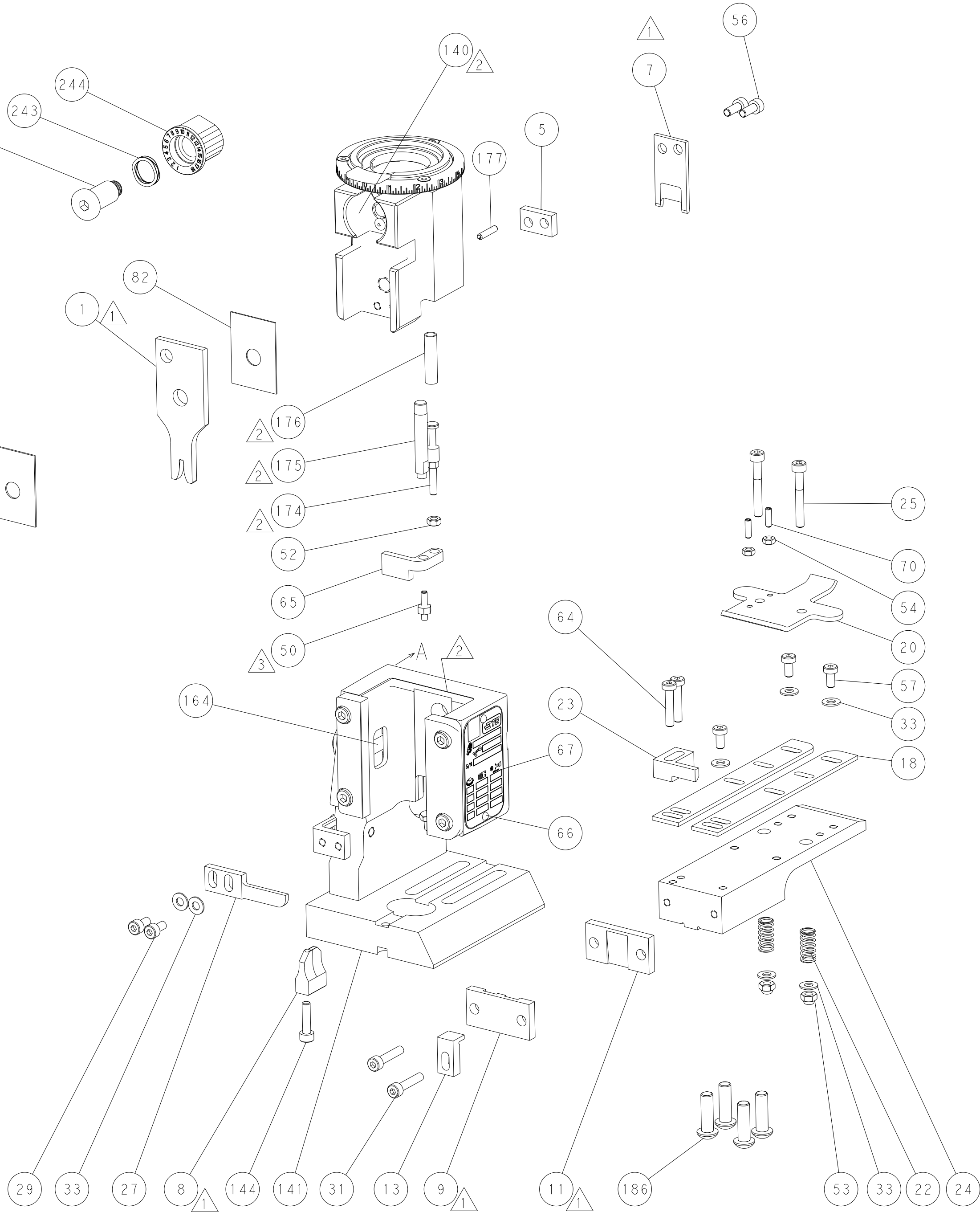
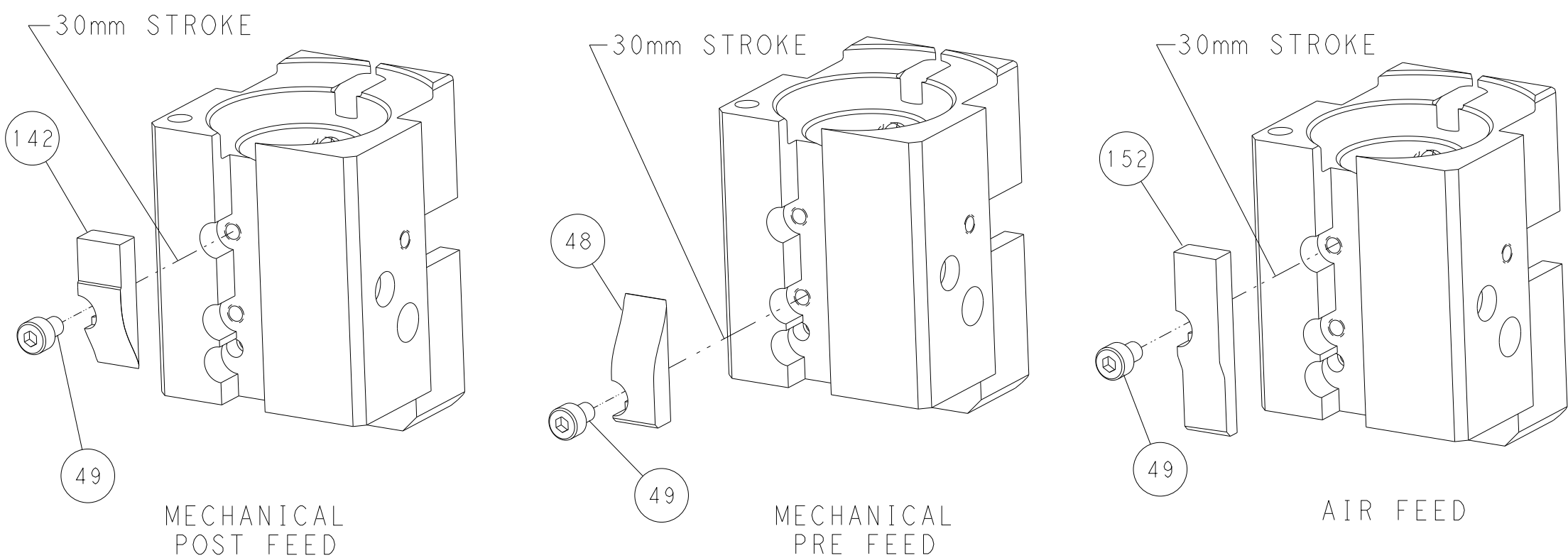


FEED SPRING
SETTING POSITION



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CONTROLLED DOCUMENT AND INSPECTION ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST VERSION.										DWN Y. YIN 13SEP2013		 TE Connectivity Harrisburg, PA 17105-3608							
										CHK G. BAILEY 13SEP2013									
										APVD V. GUO 13SEP2013		NAME							
DIMENSIONS: mm  0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH										PRODUCT SPEC		Ocean End Feed Applicator -							
										APPLICATION SPEC									
										WEIGHT		SIZE		CASE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL										-		A1		00779		C=2150365		-	
										Customer Accessible Production Drawing									
										SCALE		1:1		SHEET		4 of 4		REV C	