

8	7
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RELEASED FOR PUBLICATION 2015	
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PART NUMBER	REVISION
2150532-1	C
2150532-2	C
7-2150532-1	C
7-2150532-2	C
7-2150532-7	A
DESCRIPTION	FEED TYPE
FINE CRIMP HEIGHT ADJUST	MECHANICAL
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.00 mm [.118]	F
APPL INSTRUCTIONS 408-35043		

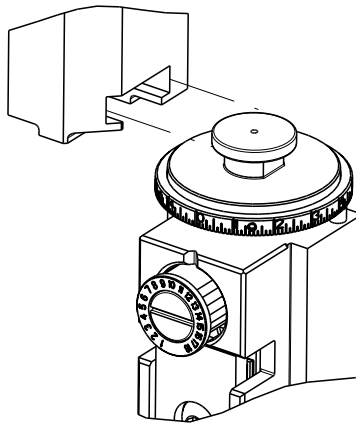
TERMINAL DATA: PRONER TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: PRONER TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.63-6.39 mm [.221-.251 IN]		Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	PRONER TERMINAL	TE TERMINAL	PRONER TERMINAL
1544113-1	P7410074801	1544113-4	P7412274801
1544113-2	P7410074851		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.62+/-0.05 [.064+/- .002]	6.6
0.75mm ² or 18 AWG	1.55+/-0.05 [.061+/- .002]	7.3
0.60mm ²	1.48+/-0.05 [.058+/- .002]	7.9
0.50mm ² or 20 AWG	1.47+/-0.05 [.058+/- .002]	8.0
0.35mm ² or 22 AWG	1.40+/-0.05 [.055+/- .002]	8.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

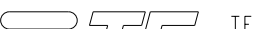
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



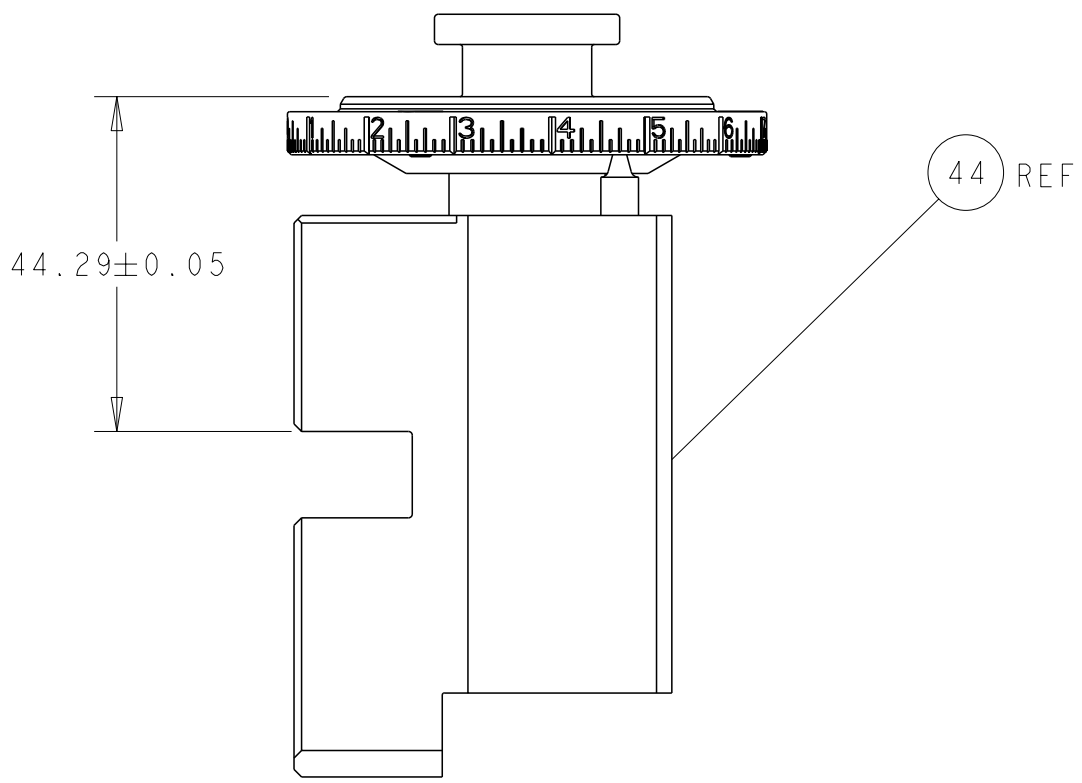
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISONS			
A	66	P	LYR	DESCRIPTION	DATE
		A		RELEASED	22APR2015
		B		ECR-18-014355	10SEP2018
		C		ECR-19-016565	23OCT2019

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	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	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	92
-	1	1	1	1	469633-1	BLOCK, SUPPORT	87
	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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
-	-	1	-	1	2161924-1	FEED FINGER	58
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	55
-	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	-	2161920-1	NARROW PAWL, EF, AIR	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
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1	1	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	240639-3	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	1	464452-4	DRAG, STOCK	20
-	1	1	1	1	1-1901259-2	GUIDE, LOWER STRIP	19
-	1	1	1	1	7-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	1	1	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	2	2	6-240645-0	SPACER, SHEAR PLATE	10
	1	1	1	1	455961-5	PLATE, FRONT SHEAR	9
	1	2	2	1	7-1803001-2	ANVIL, COMBINATION, END FEED	8
	1	1	1	1	1-469634-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-3	SPACER	5
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
	1	2	2	1	8-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	2	2	2	2	1-455888-4	SPACER, CRIMPER	2
	1	2	2	1	1803015-7	CRIMPER, WIRE	1
-	77-72-71	-	2	-	PART NO	DESCRIPTION	ITEM NO

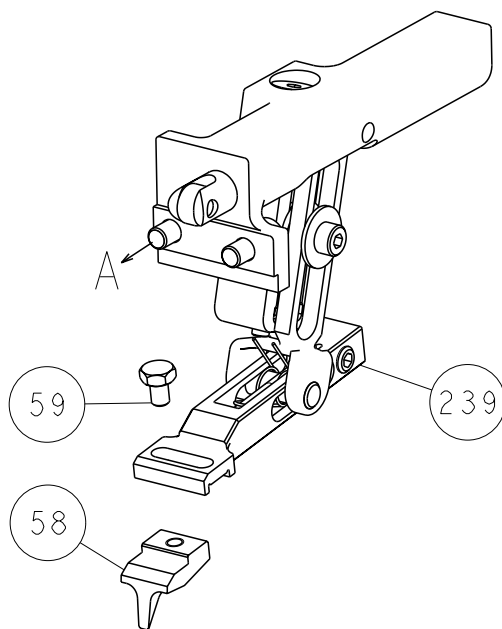
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN	D. WEAVER	27FEB2015	 TE Connectivity Harrisburg, PA 17105-3608						
				CHK	T. ELBIN	27FEB2015							
				APVD	T. ELBIN	27FEB2015							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator							
mm				PRODUCT SPEC									
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC -									
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
-		-		-		A		00779		©=2150532		-	
Customer Accessible Production Drawing						SCALE		1:1		SHEET 1 of 4		REV C	

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

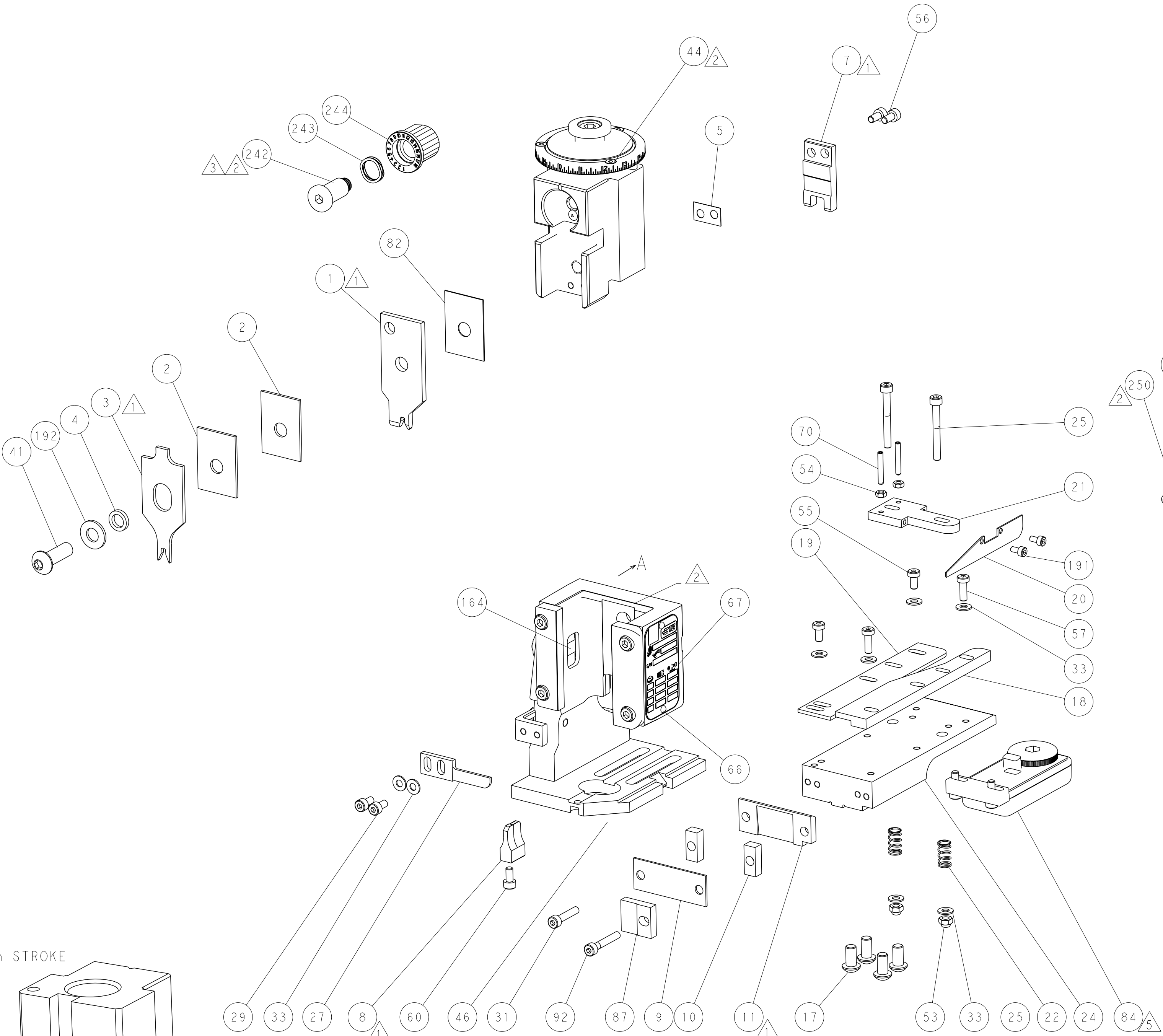
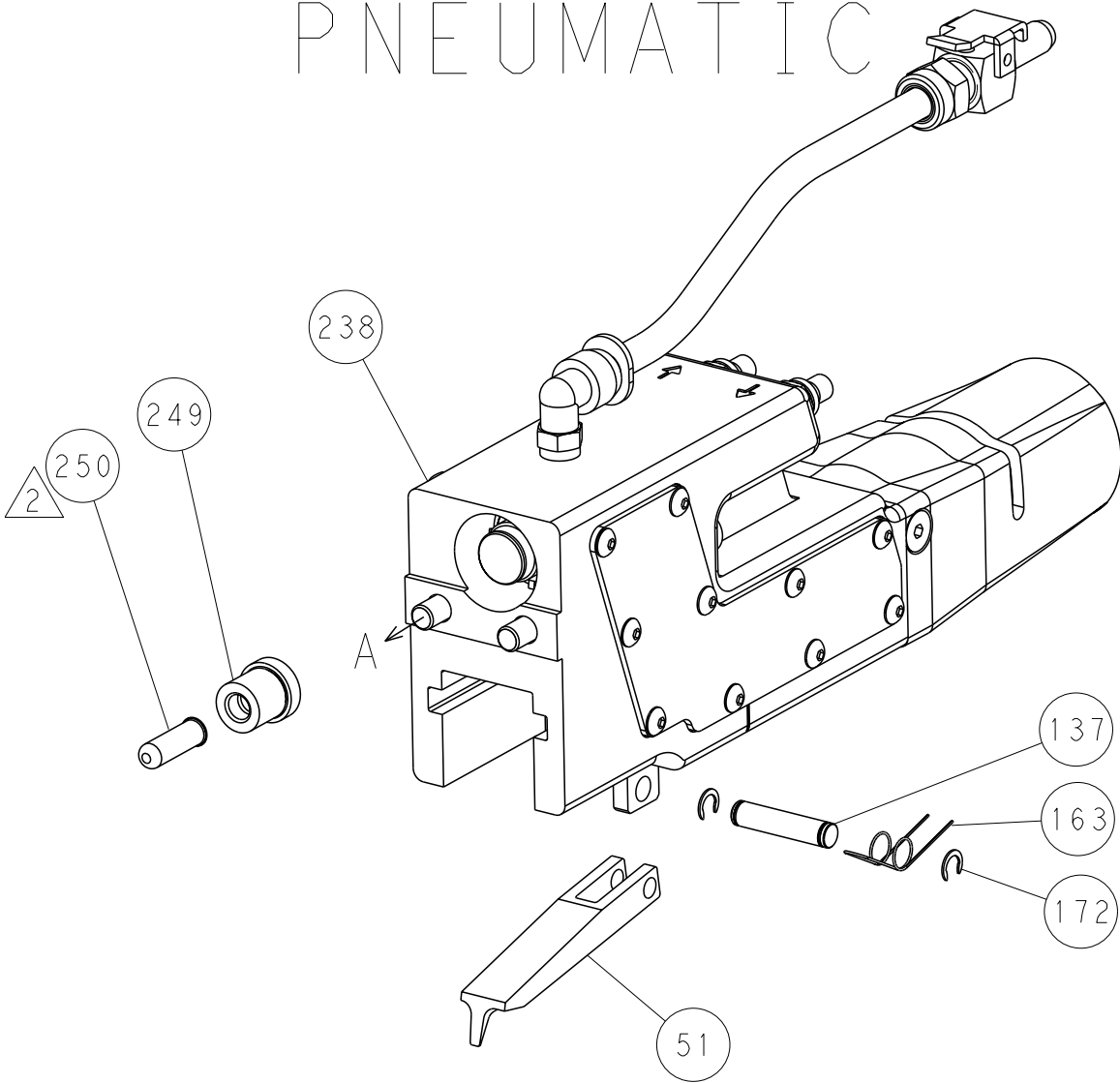


RAM SET-UP

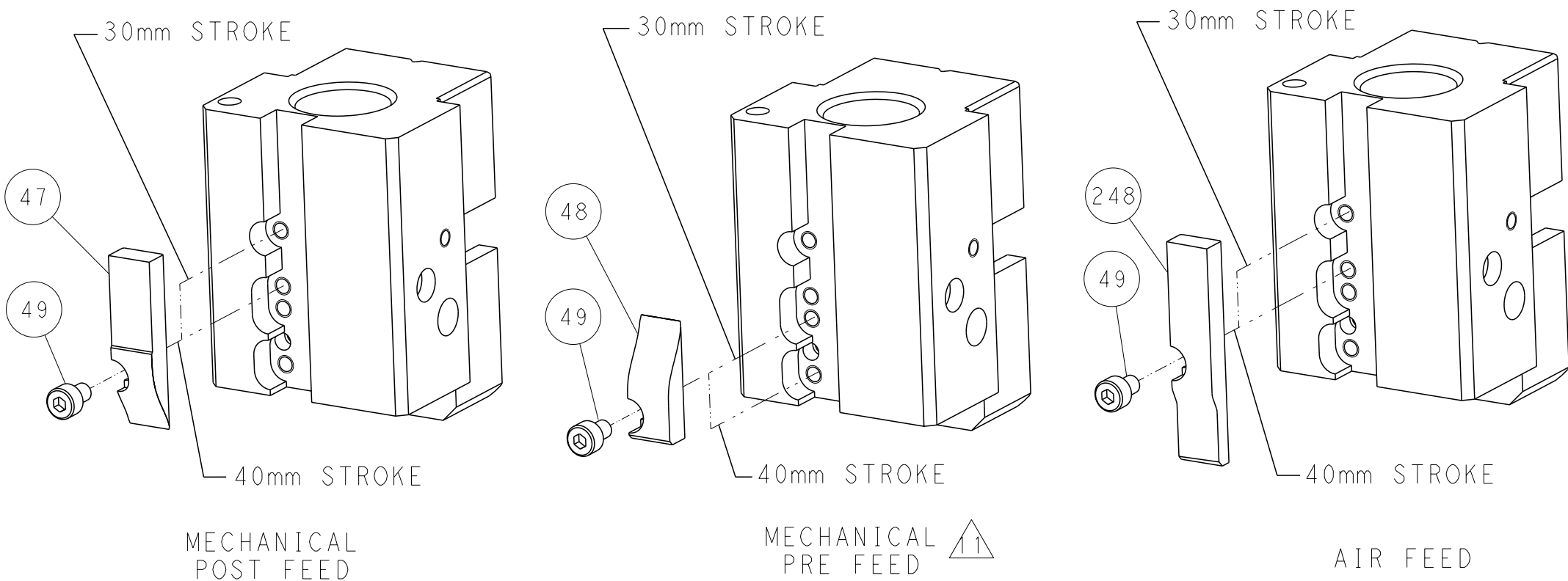
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

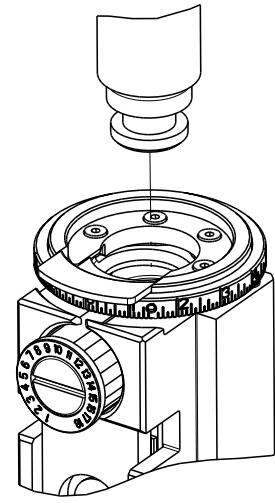


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE USED ONLY FOR THE PURPOSES AND APPLICATIONS SPECIFIED IN THE DRAWING. ANY OTHER USE IS PROHIBITED. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN B. WEAVER 27FEB2015	TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean End Feed Applicator	
DIMENSIONS: mm				CHK T. ELBIN 27FEB2015			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APVD T. ELBIN 27FEB2015			
MATERIAL				PRODUCT SPEC			
				APPLICATION SPEC	SIZE A1	CAGE CODE 00779	DRAWING NO C=2150532
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE 1:1			
				SHEET 2	OF 4	REV C	

8		7	
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2015		2015	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150532-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150532-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150532-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.00 mm [.118]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: PRONER TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: PRONER TERMINAL			
WIRE STRIP LENGTH 5.63-6.39 mm [.221-.251 IN]		INSULATION DIAMETER RANGE Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	PRONER TERMINAL	TE TERMINAL	PRONER TERMINAL
1544113-1	P7410074801	1544113-4	P7412274801
1544113-2	P7410074851		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.62+/-0.05 [.064+/- .002]		6.6
0.75mm2 or 18 AWG		1.55+/-0.05 [.061+/- .002]		7.3
0.60mm2		1.48+/-0.05 [.058+/- .002]		7.9
0.50mm2 or 20 AWG		1.47+/-0.05 [.058+/- .002]		8.0
0.35mm2 or 22 AWG		1.40+/-0.05 [.055+/- .002]		8.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 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.

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

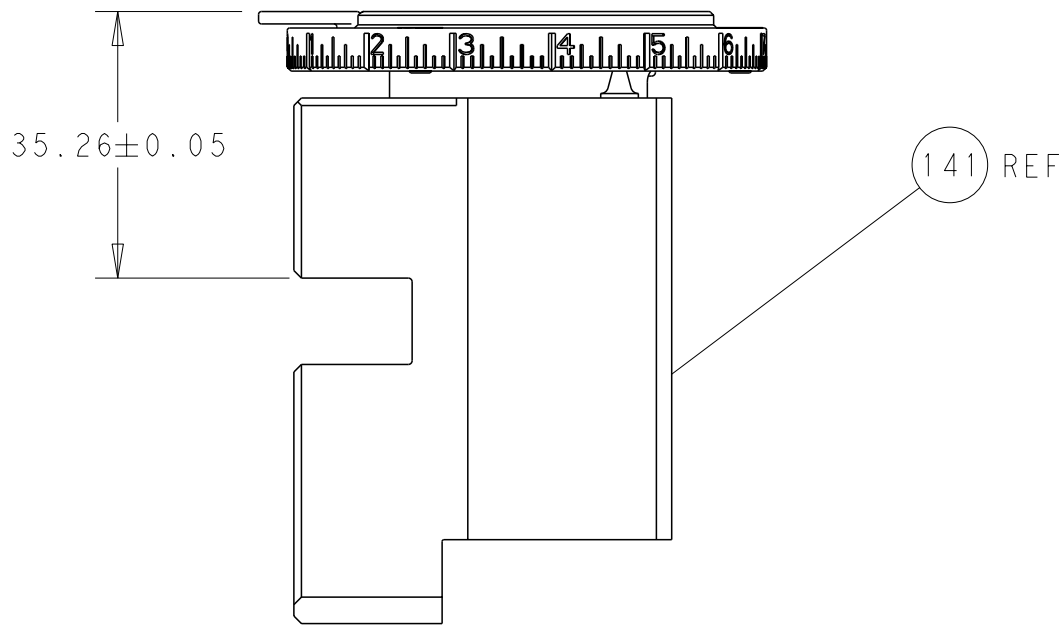
2		1					
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
			-	SEE SHEET 1	-	-	-

3	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-7	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	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	240638-1	SPRING, FEED FINGER	163	
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
5	-	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	92
	-	1	1	469633-1	BLOCK, SUPPORT	87
	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-2	DOCUMENTATION PACKAGE	71
	-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2161924-1	FEED FINGER	58
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	55	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2161920-1	NARROW PAWL, EF, AIR	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	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	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	240639-3	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	2161922-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	464452-4	DRAG, STOCK	20	
-	1	1	1-1901259-2	GUIDE, LOWER STRIP	19	
-	1	1	7-1901695-5	STRIP GUIDE, FRONT	18	
1	-	1	1	461160-3	PLATE, REAR SHEAR	11
1	-	2	2	6-240645-0	SPACER, SHEAR PLATE	10
	-	1	1	455961-5	PLATE, FRONT SHEAR	9
1	1	1	1	7-1803001-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-469634-8	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	4-240641-3	SPACER	-	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	-	4
1	1	1	1	8-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	2	2		1-455888-4	SPACER, CRIMPER	2
1	1	1	1	1803015-7	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO	

THIS DRAWING IS CONTROLLED AND FOR IDENTIFICATION PURPOSES ONLY. ANY REVISIONS TO THIS DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY CONTROL ENGINEER. ANY REVISIONS TO THIS DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY CONTROL ENGINEER.				OWN B. WEAVER 27FEB2015	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK T. ELBIN 27FEB2015				
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD T. ELBIN 27FEB2015	NAME Ocean End Feed Applicator			
MATERIAL -				PRODUCT SPEC -	SIZE A1			
FINISH -				APPLICATION SPEC -	CAGE CODE 00779			
WEIGHT -				RESTRICTED TO -	DRAWING NO C=2150532			
Customer Accessible Production Drawing				SCALE 1:1	SHEET 3	OF 4	REV C	

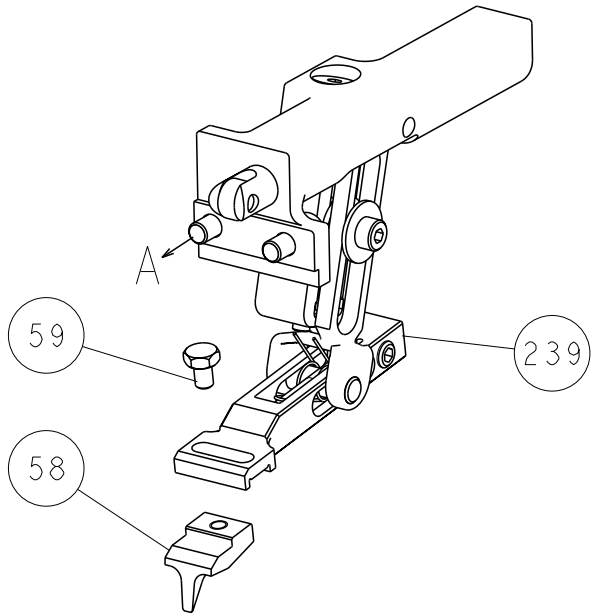
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

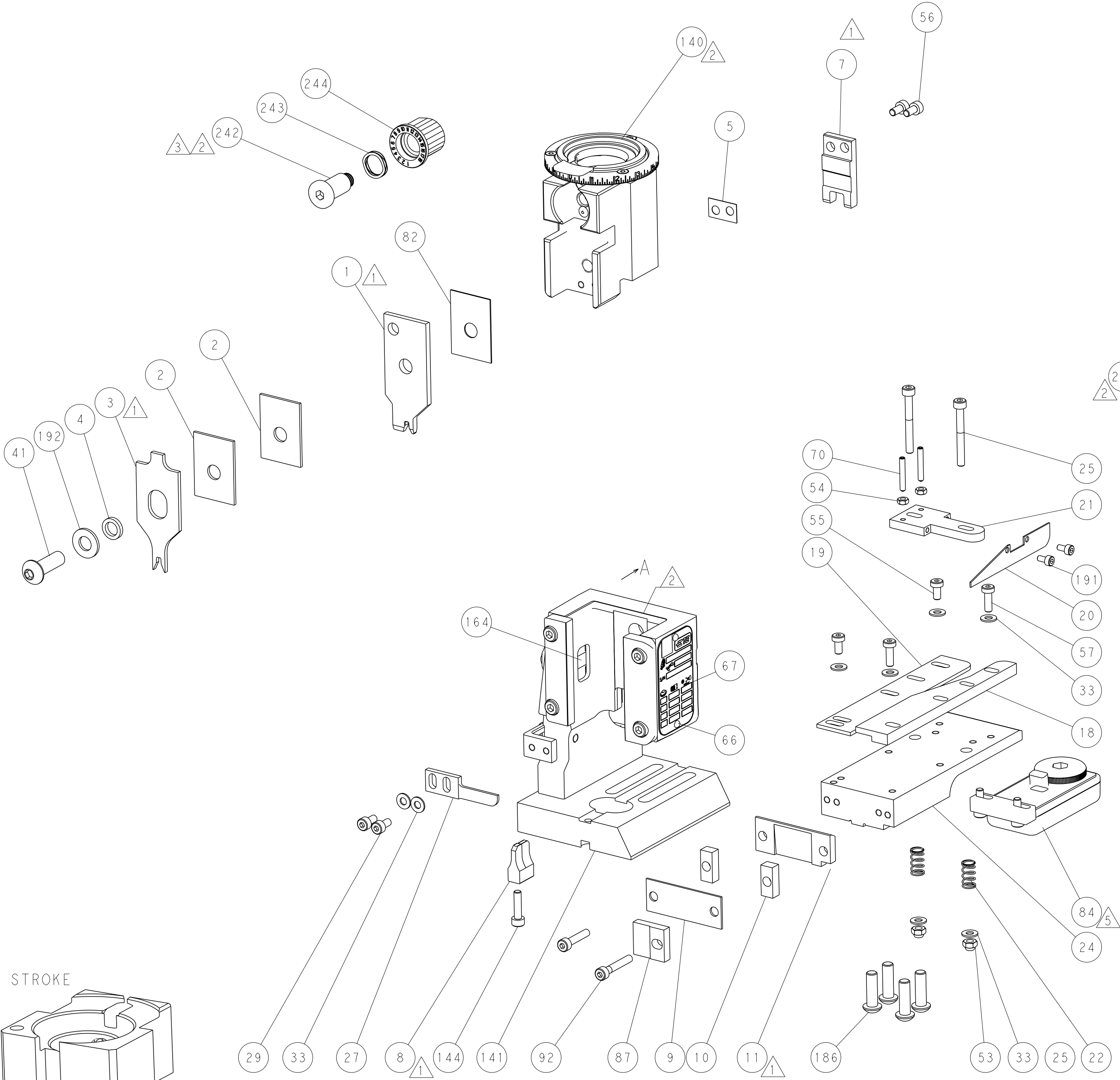
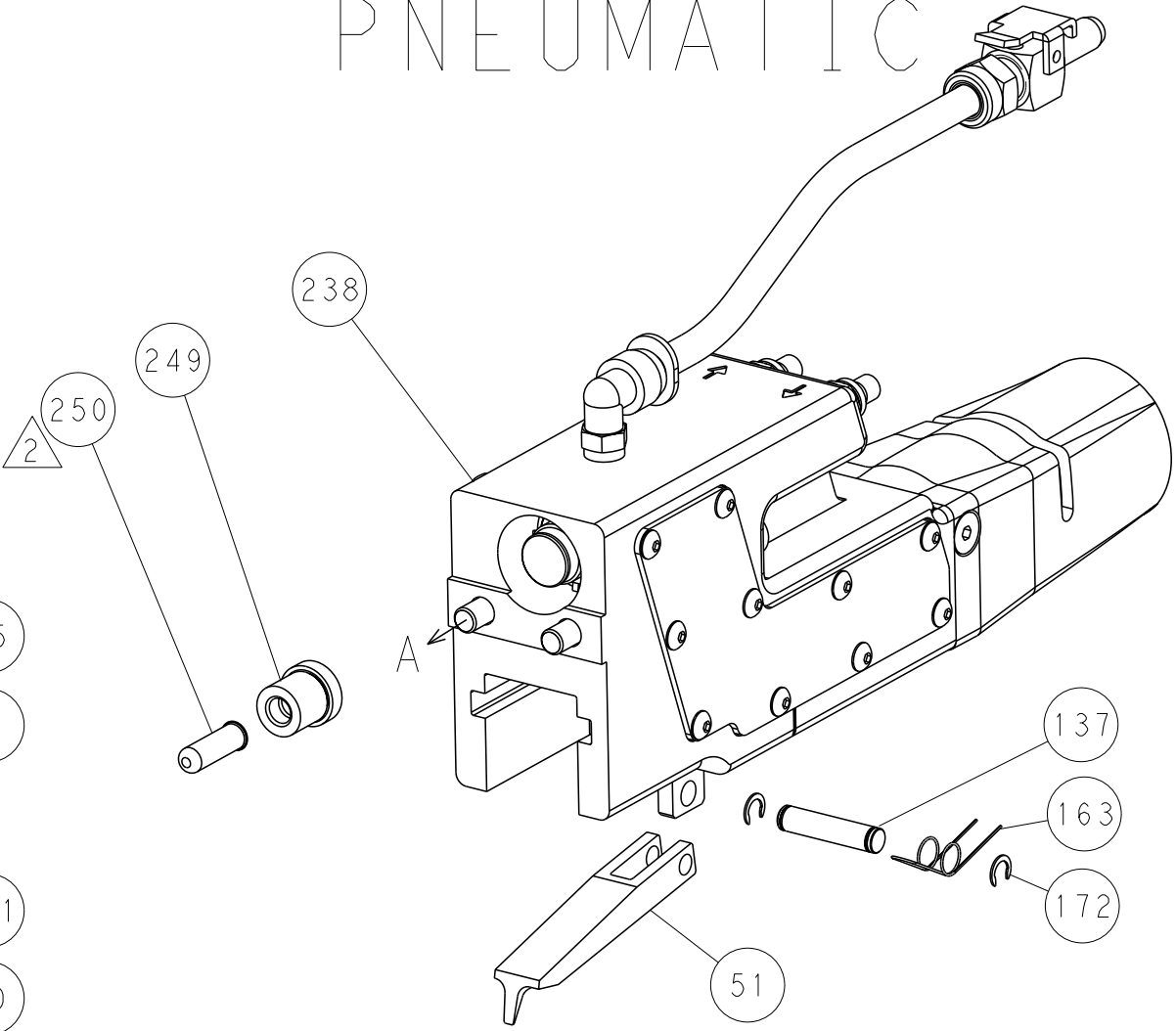


RAM SET-UP

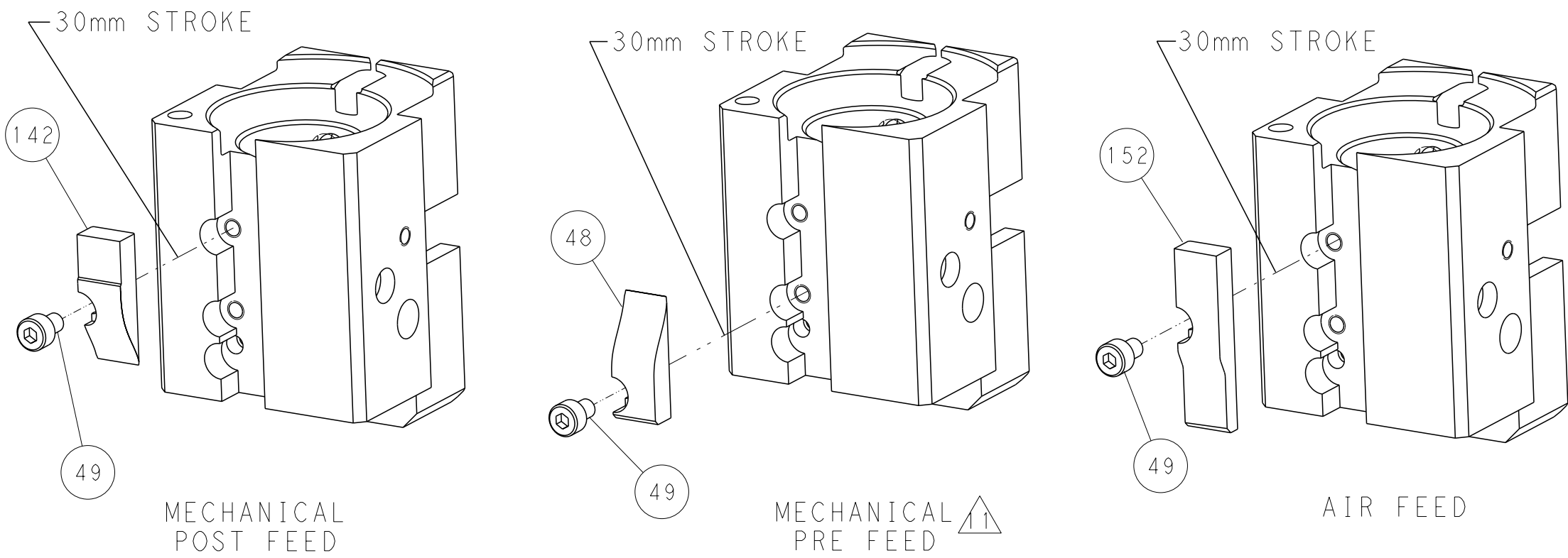
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

1111 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				OWN B. WEAVER	27FEB2015	TE Connectivity Harrisburg, PA 17105-3608	
				CHK T. ELBIN	27FEB2015		
				APVD T. ELBIN	27FEB2015	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2150532	
				Customer Accessible Production Drawing		RESTRICTED TO -	