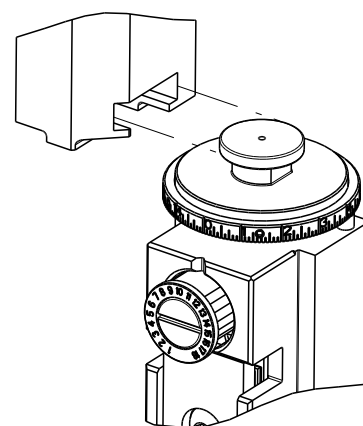


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150421-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150421-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150421-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150421-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150421-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.57 mm [1.80]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .187 SERIES			
WIRE STRIP LENGTH 6.10-5.33 mm [.240-.210 IN]		INSULATION DIAMETER RANGE Ø3.30-2.29 mm [.130-.090 IN]	
TERMINAL APPLICATION 		(A) 114-2023	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL (A) 60435-1	TE TERMINAL (A) 152368	TE TERMINAL (A) 152368-1	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG			1.52+/-0.05 [.060+/- .002]		3.9
18 AWG			1.32+/-0.05 [.052+/- .002]		6.1
20 AWG			1.19+/-0.05 [.047+/- .002]		7.7
22 AWG			1.14+/-0.05 [.045+/- .002]		7.9



- 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 242.
APPLY PART NUMBER 2-23419-6 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 22AWG WIRE TO BE USED FOR TERMINAL 60435-1 ONLY.
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.

ATLANTIC VERSION

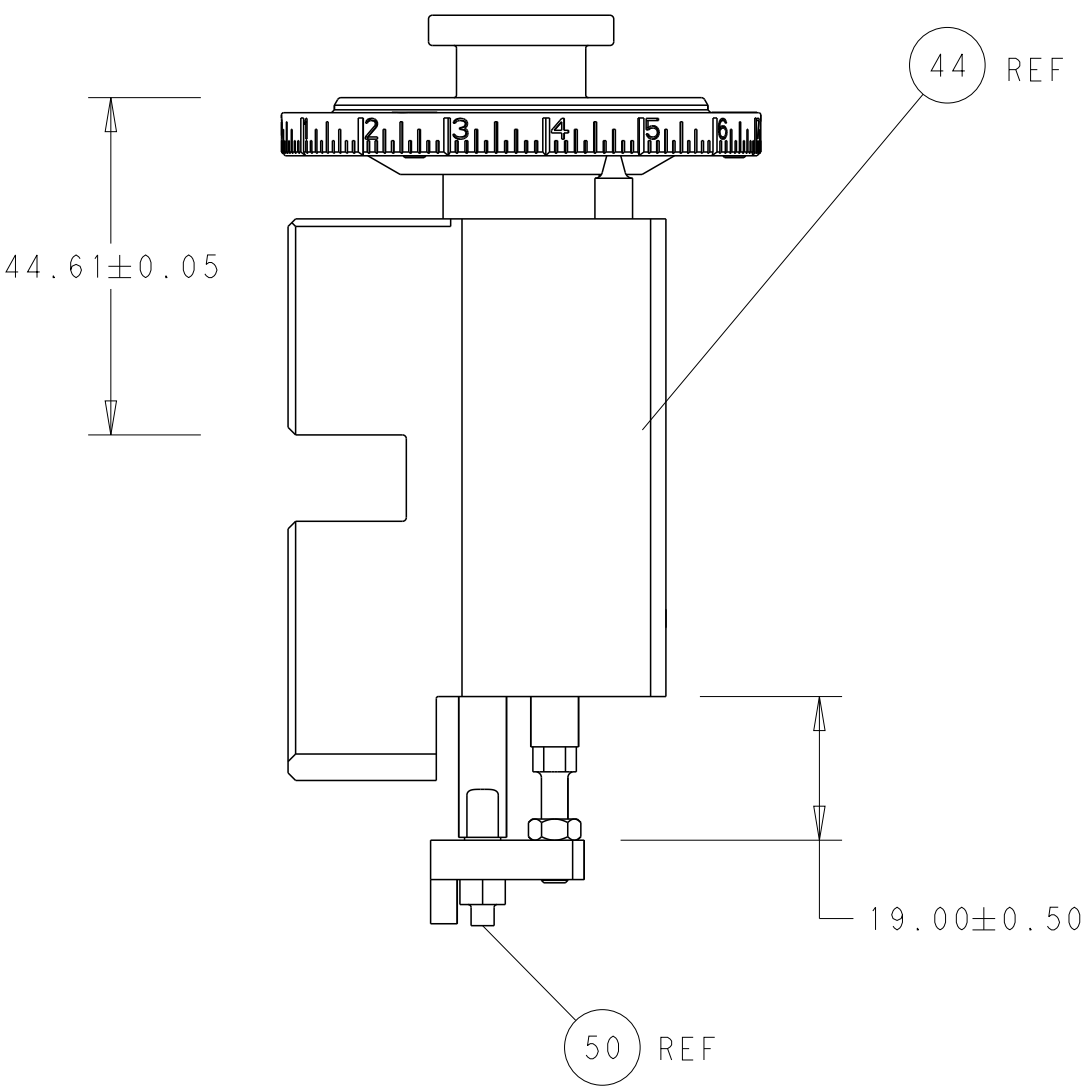
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DRN	APVD
			A	RELEASED	25MAR2014	RW	GB
			B	ECR-22-129511	14FEB2022	JWC	TE
			B1	ECR-22-162257	28DEC2022	JWC	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	6-9931111-6	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	17
	-	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
3	-	1	-	1	-	2063961-1	FEED FINGER	51
	-	1	1	1	1	1976055-9	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752371-3	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-4	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	1-1901259-0	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	4-240641-9	SPACER	16
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	4-1803000-5	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-690474-9	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	240641-3	SPACER	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
	-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

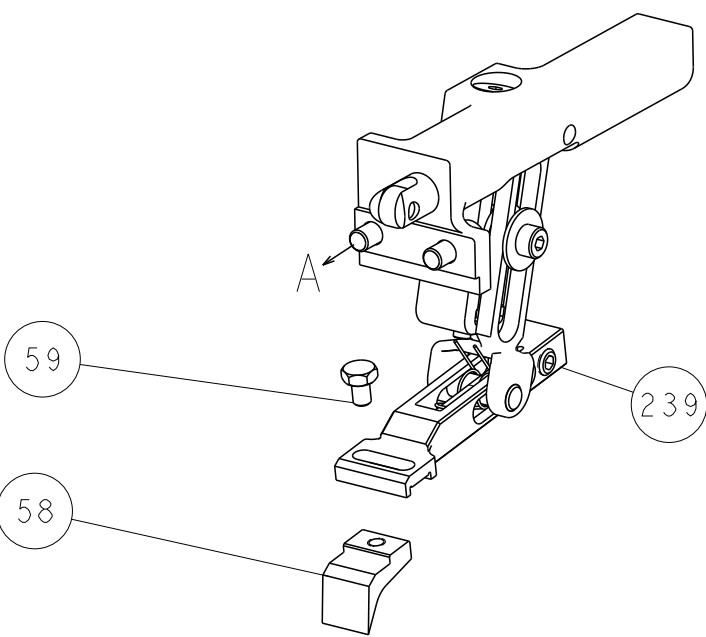
THIS DRAWING IS A COMPUTER GENERATED FILE. ALL DIMENSIONS ARE APPROXIMATE. DIMENSIONS SHOULD BE CONTACTED TO THE TOOLING DESIGNER.		DWN W. O. WILSON 20FEB2014		 TE Connectivity		Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK K. J. STAREK 21FEB2014		NAME Ocean End Feed Applicator	
mm		0 PLC ±.1 1 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APPR T. L. FLEBIN 21FEB2014		SIZE CAGE CODE DRAWING NO	
		PRODUCT SPEC		APPLICATION SPEC		A 00779 C-2150421	
MATERIAL -		FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production				SCALE 1:1		SHEET 1 OF 4 REV B	

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

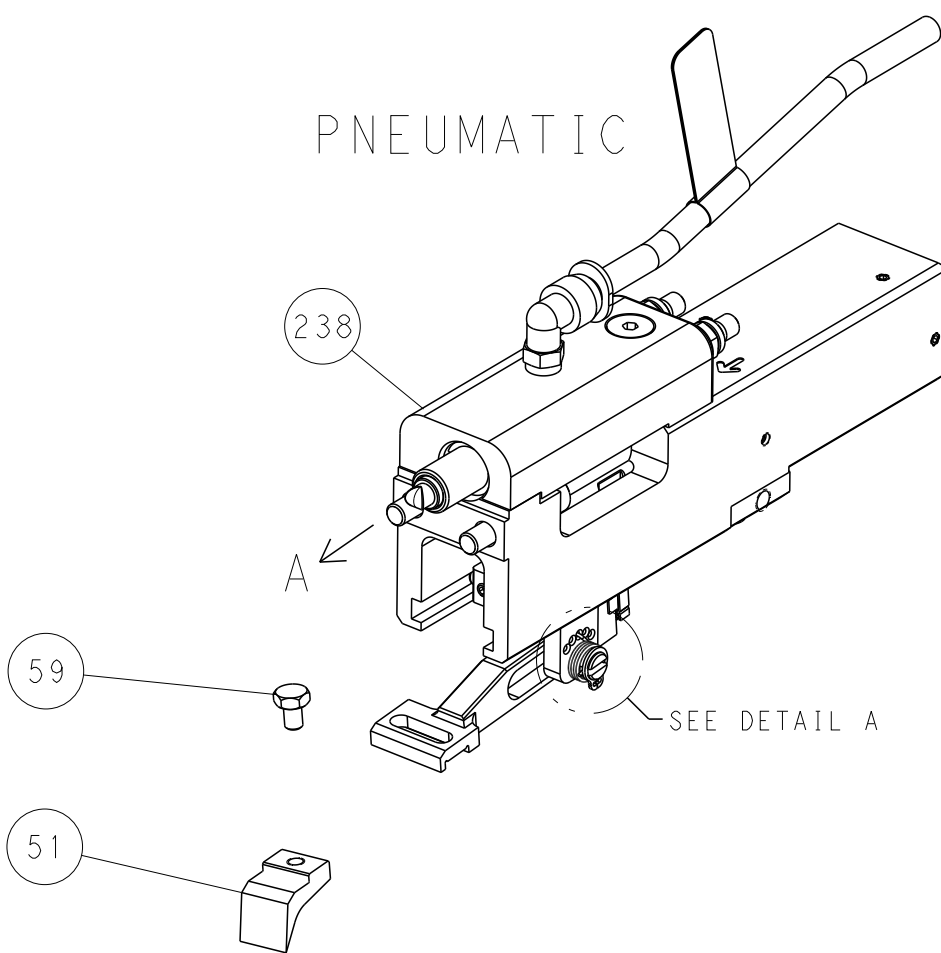


RAM AND HOLDDOWN SET-UP

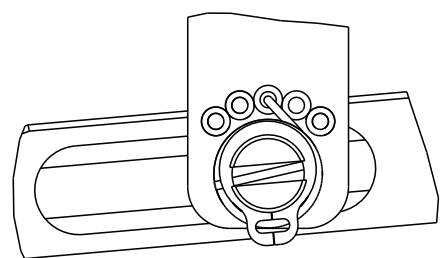
FEED TYPE
MECHANICAL



PNEUMATIC

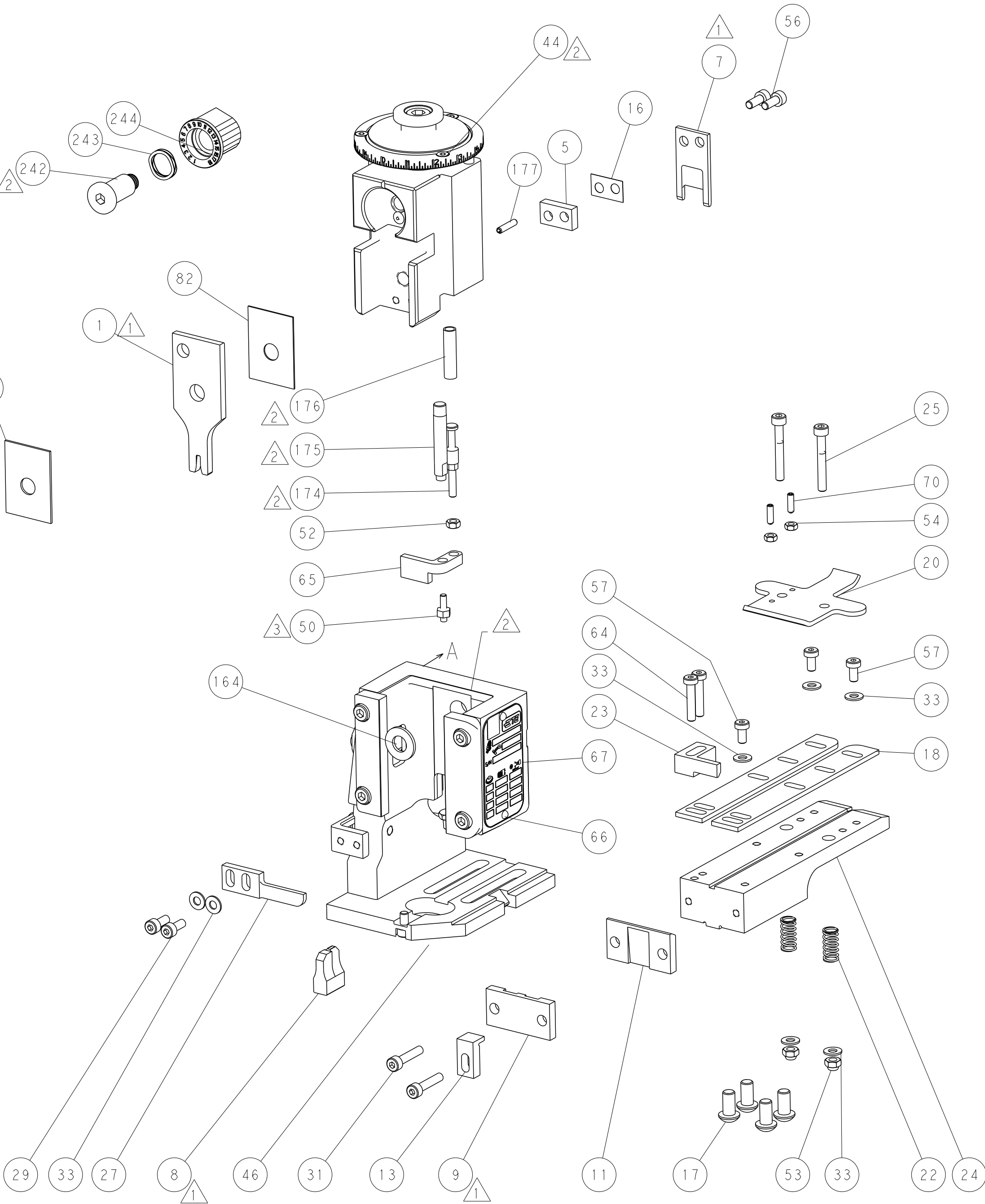
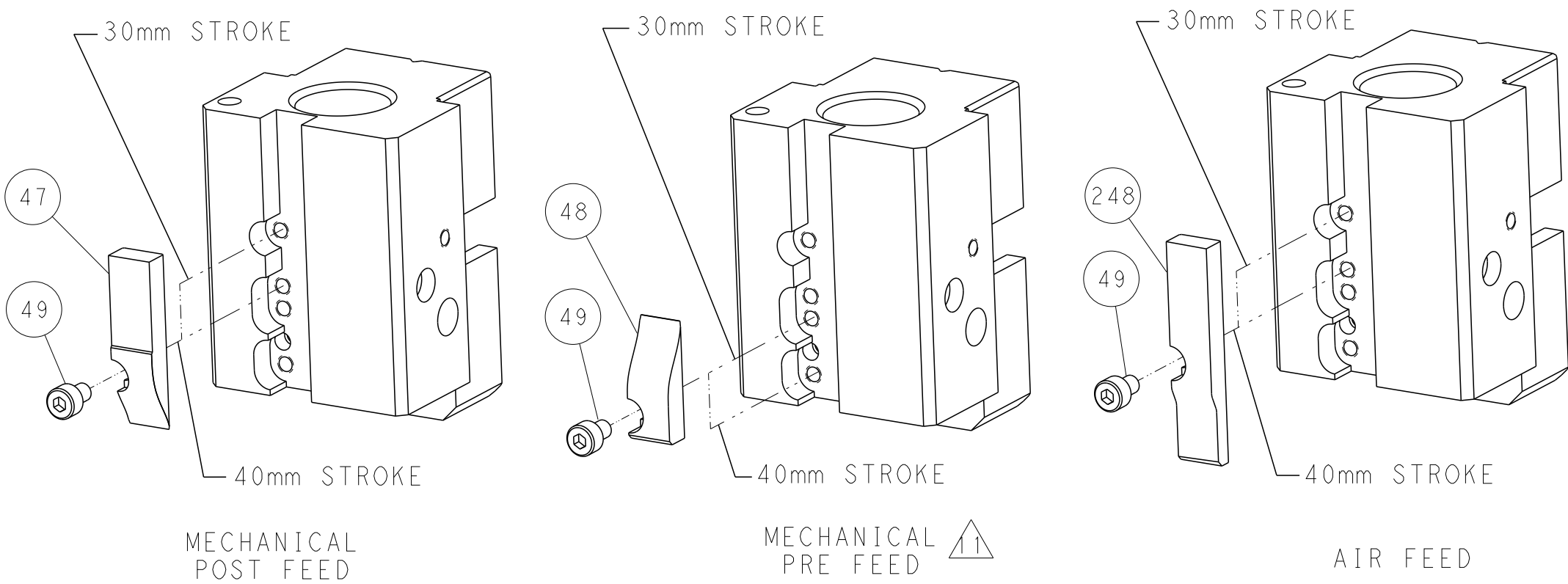


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



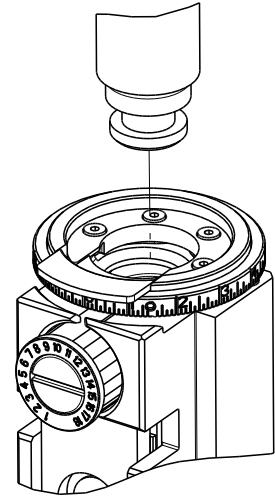
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK K.J.STAKEM 21FEB2014				APVD T.L.ELBIN 21FEB2014	PRODUCT SPEC	Ocean End Feed Applicator	
APPLICATION SPEC				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL				WEIGHT	A1	00779	©=2150421
Customer Accessible Production Drawing				SCALE	1:1	SHEET	2 of 4
				REV	B1		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150421-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150421-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150421-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .187 SERIES			
WIRE STRIP LENGTH 6.10-5.33 mm [.240-.210 IN]		INSULATION DIAMETER RANGE Ø3.30-2.29 mm [.130-.090 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-2023	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 60435-1	(A) 152368	(A) 152368-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.52+/-0.05 [.060+/- .002]	3.9
18 AWG	1.32+/-0.05 [.052+/- .002]	6.1
20 AWG	1.19+/-0.05 [.047+/- .002]	7.7
22 AWG	1.14+/-0.05 [.045+/- .002]	7.9



- 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 242.
APPLY PART NUMBER 2-23419-6 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 22AWG WIRE TO BE USED FOR TERMINAL 60435-1 ONLY.
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)

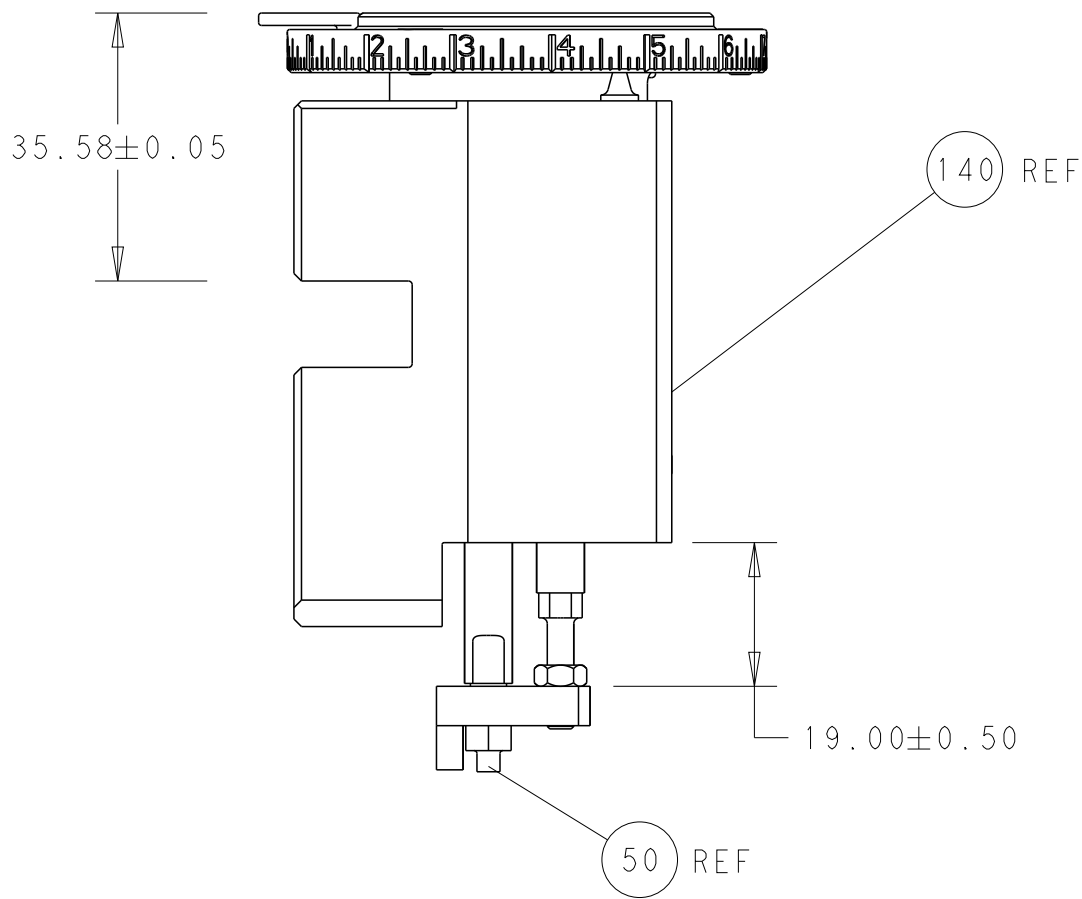
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

-	1	1	2119082-9	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
-	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	-	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	455888-5	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	1901681-5	HOLDDOWN, TERMINAL	65
-	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	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-1	FEED FINGER	51
-	1	1	1976055-9	STANDOFF, HOLD-DOWN	50
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	240825-4	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1-1901259-0	GUIDE, LOWER STRIP	18
-	1	1	4-240641-9	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-6	PLATE, FRONT SHEAR	9
1	1	1	4-1803000-5	ANVIL, COMBINATION, END FEED	8
-	1	1	1-690474-9	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
-77-22-21	PART NO			DESCRIPTION	ITEM NO

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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	
MATERIAL -		WEIGHT -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO C=2150421	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3	
				OF 4	
				REV B1	

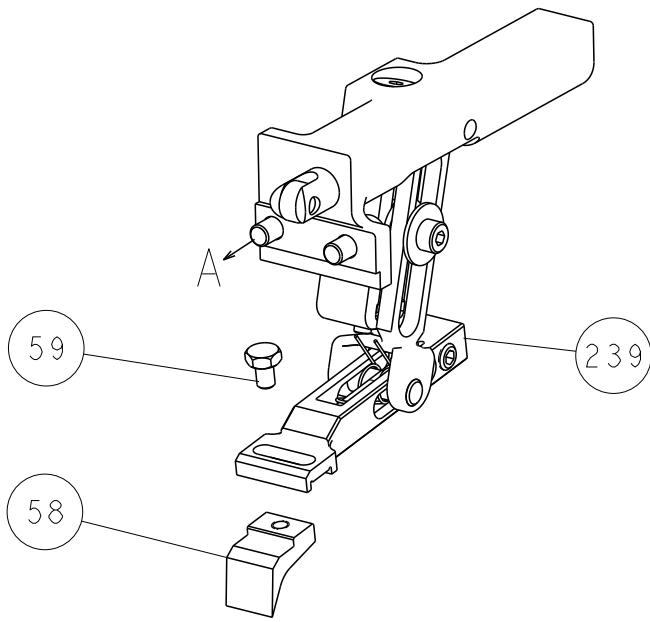
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

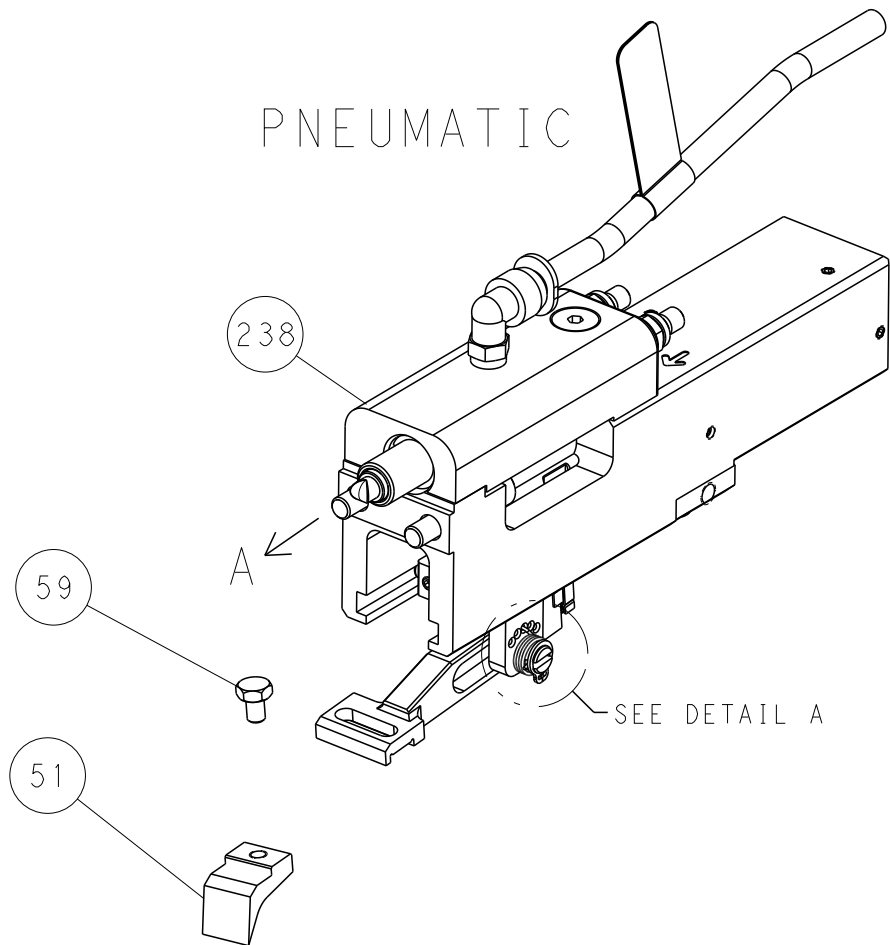


RAM AND HOLDDOWN SET-UP

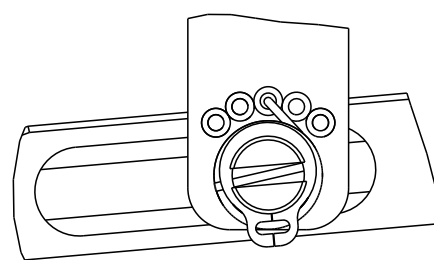
FEED TYPE
MECHANICAL



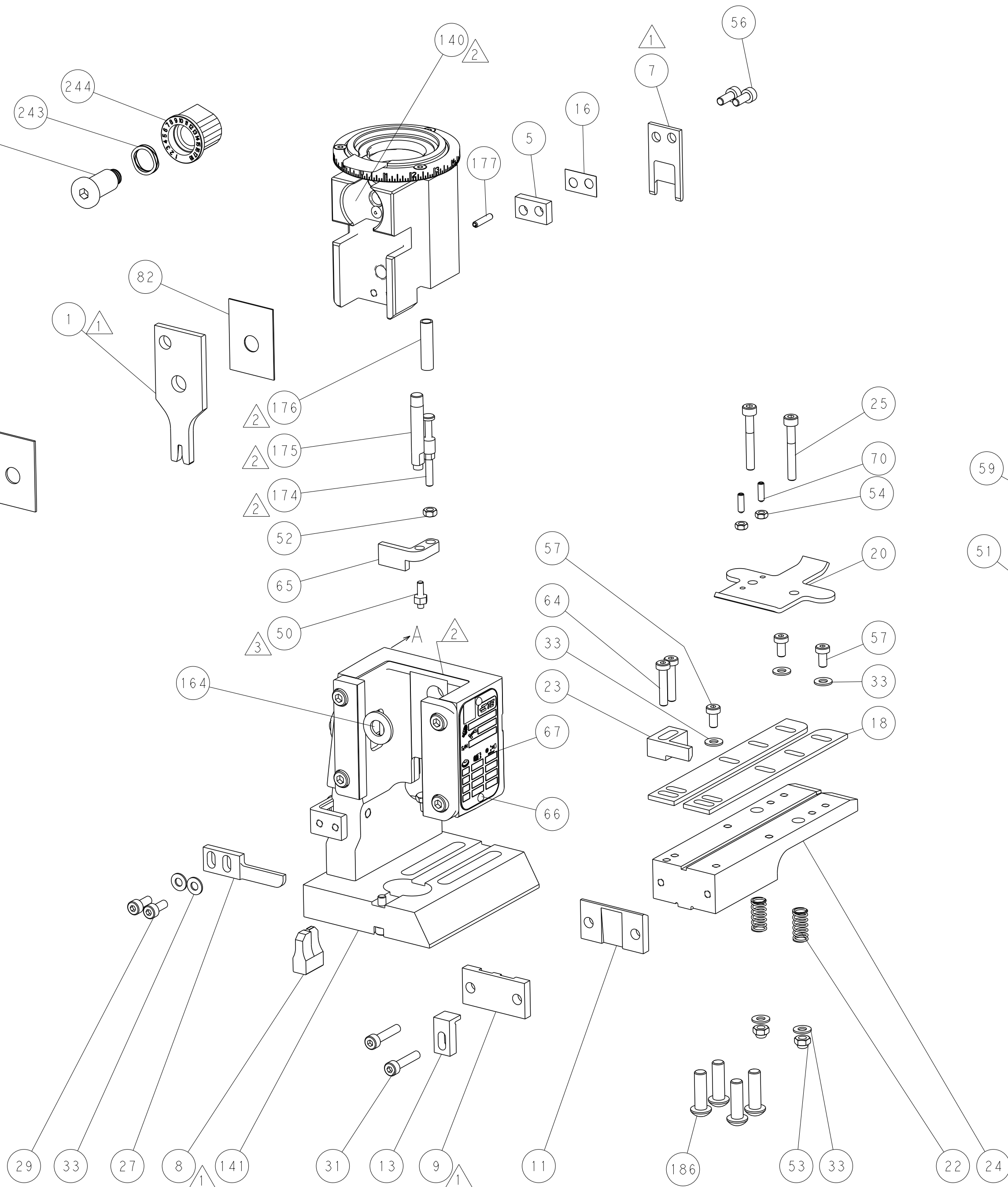
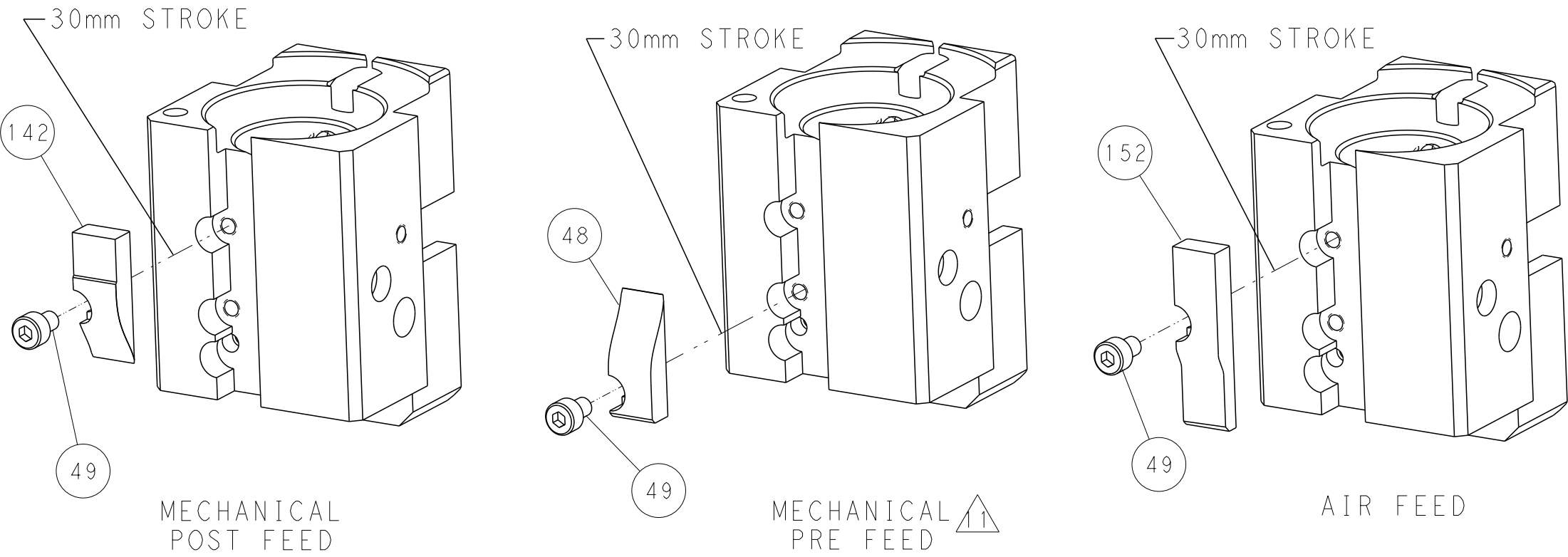
PNEUMATIC



FEED SPRING
SETTING POSITION



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS AND ASSEMBLY BEFORE USE. FOR THE LATEST NOTIFICATION, CONTACT THE SUPPLIER.				DWN: R.O. WILSON 20FEB2014 CHK: K.J. STAKEM 21FEB2014 APVD: T.L. ELBIN 21FEB2014				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH -				NAME: Ocean End Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150421			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 4 OF 4 REV B1			