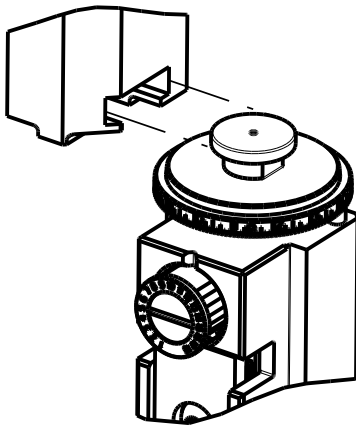


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150283-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150283-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE Ø2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
114-2084		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41580	41589	41579
41581	41590		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.45+/-0.05 [1.057+/-0.002]	9.6
(2)24	1.37+/-0.05 [1.054+/-0.002]	10.4
22 AWG	1.37+/-0.05 [1.054+/-0.002]	10.4
24 AWG	1.32+/-0.05 [1.052+/-0.002]	10.9

- 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 ITEMS 180. 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.

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

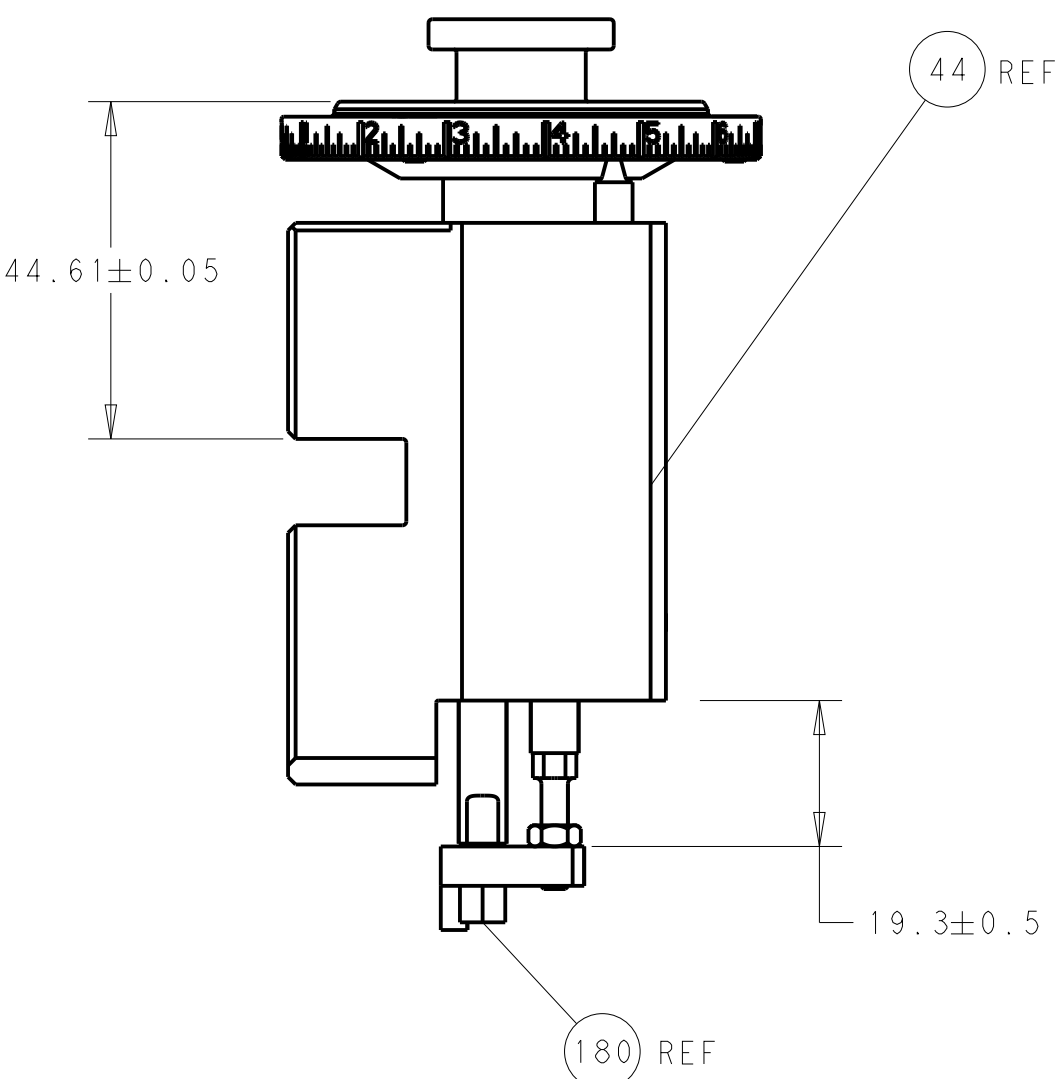
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				C		ECR-21-003095	11MAR2021

-	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
-	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	1752354-4	STANDOFF,HOLD-DOWN	180
-	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	2119791-9	DEPRESSOR, WIRE	73
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
-	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
-	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
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-1	DRAG	20
-	1	1	1	1	1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1901695-2	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	6-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-2	SPACER, SHEAR PLATE	10
-	1	1	1	1	2-240642-2	PLATE, FRONT SHEAR	9
1	2	2	1	1	1-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				CHK R. KNEPPER	8JAN2019	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APVD C. TOPFER	8JAN2019	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -				WEIGHT -		A1 00779 ©=2150283	
				Customer Accessible Production Drawing		SCALE 1:1	
				SHEET 1		OF 4	
				REV C			

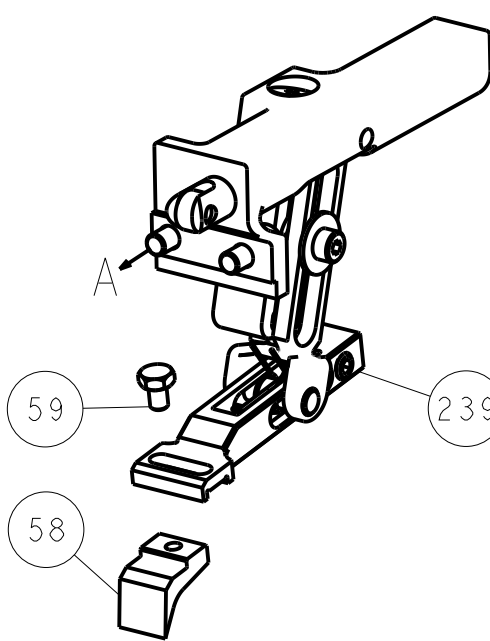
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

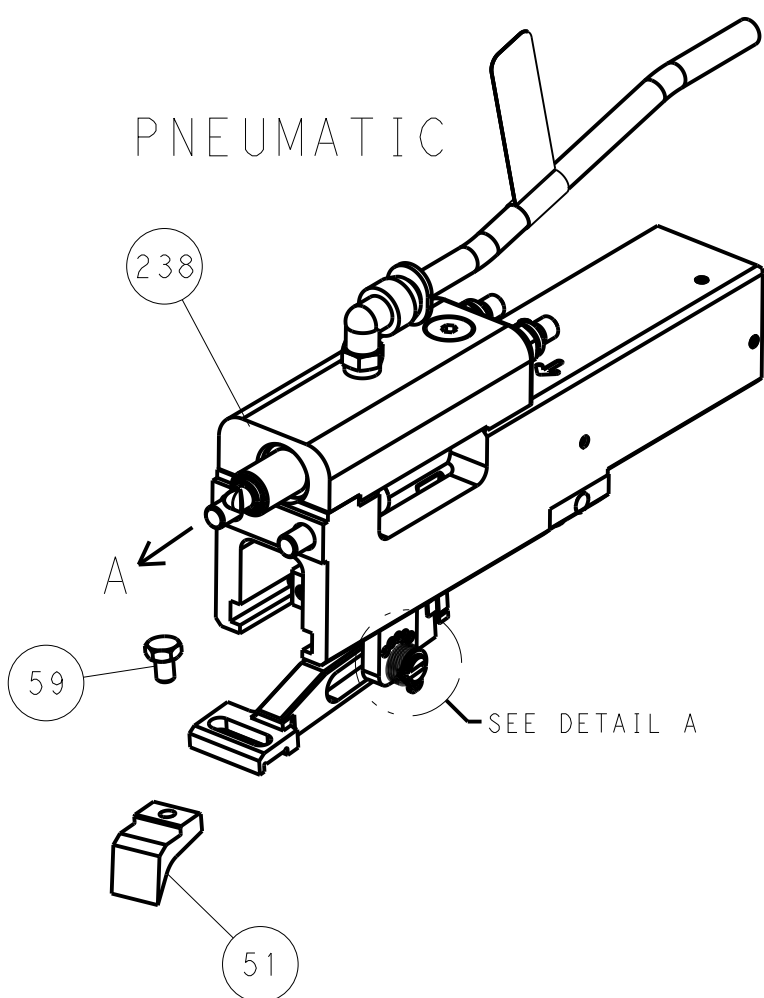


RAM AND HOLDDOWN SET-UP

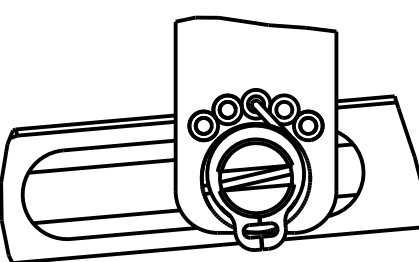
FEED TYPE  
MECHANICAL



PNEUMATIC

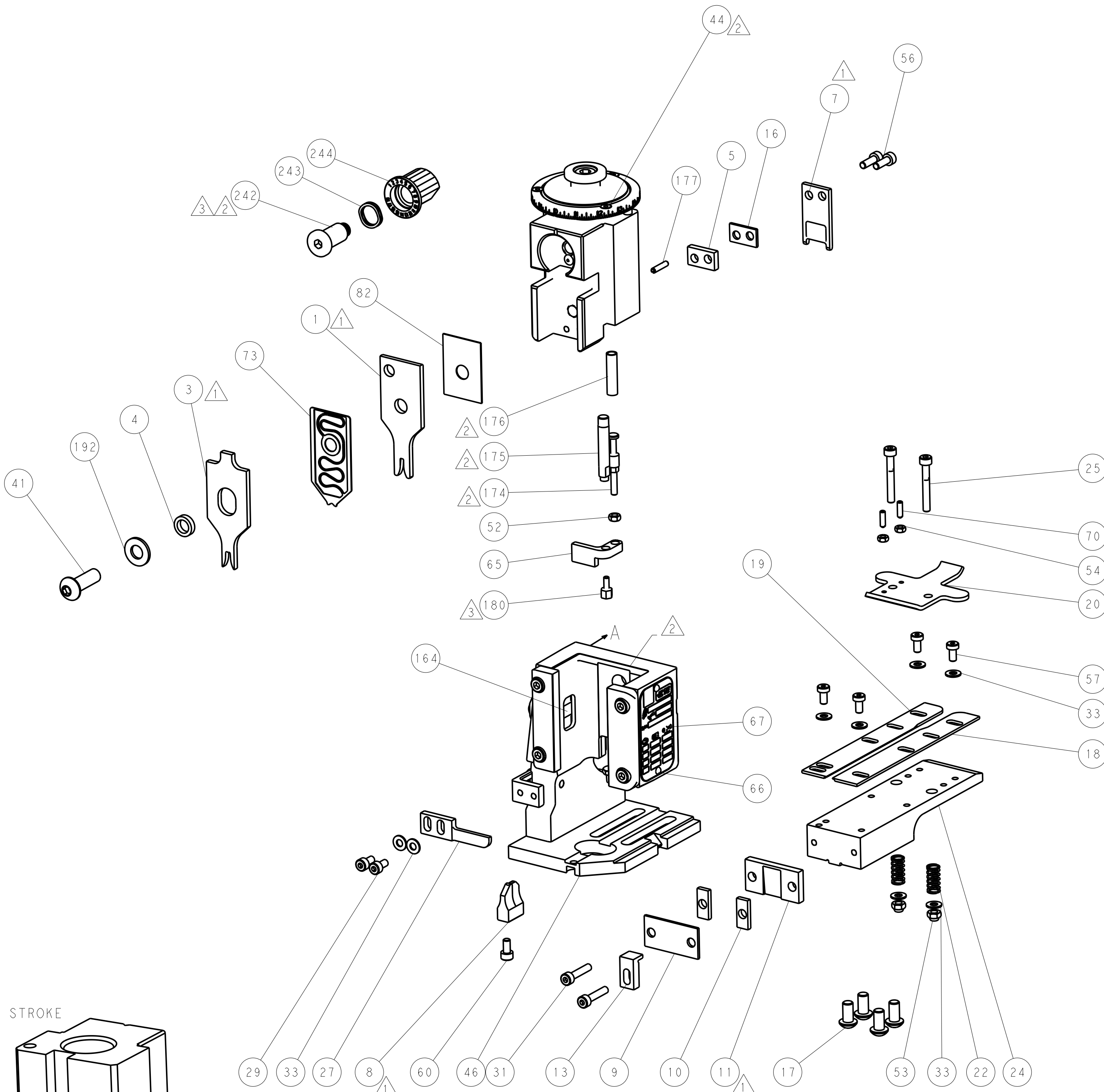
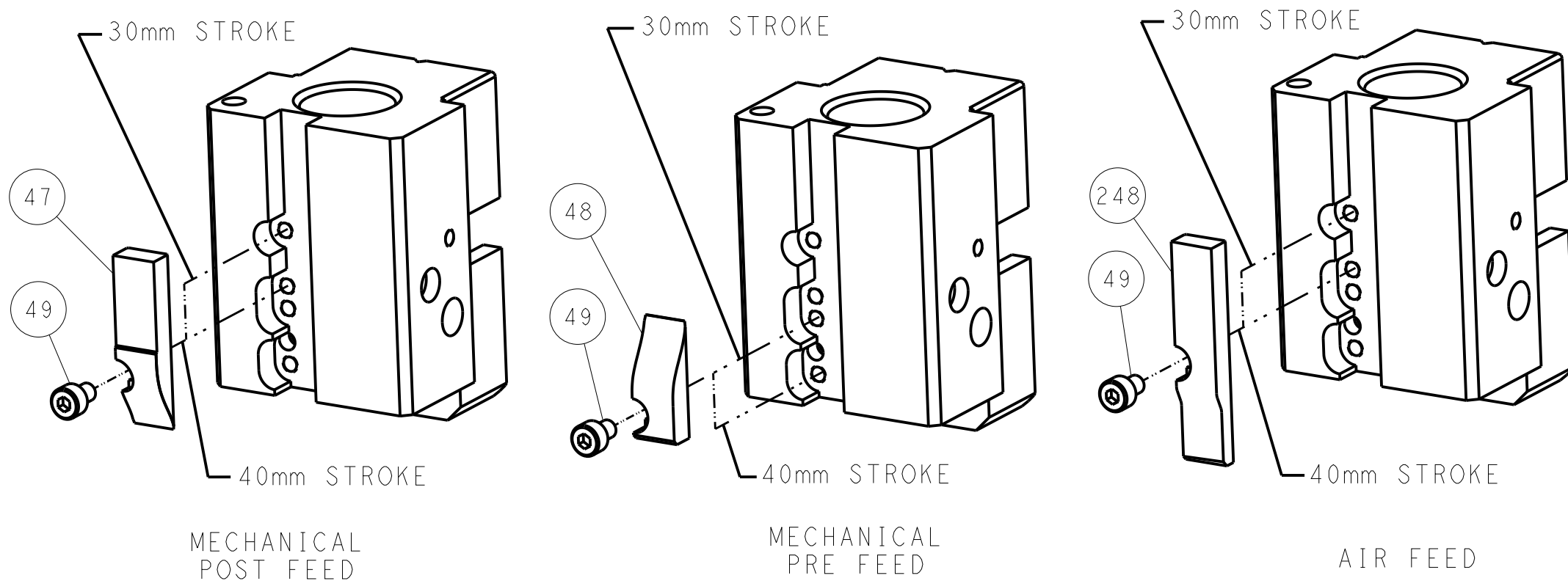


FEED SPRING  
SETTING POSITION



DETAIL A

CAM POSITIONS



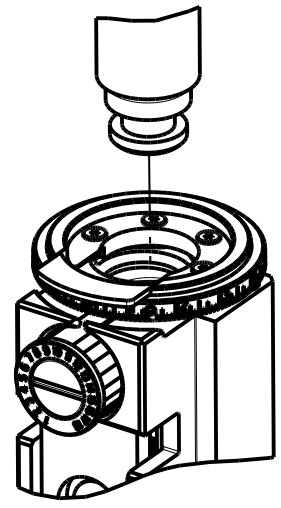
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)


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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				NAME: Ocean End Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A11 00779 ©=2150283			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV C			







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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150283-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE Ø2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION  114-2084		-	-
SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41580	41589	41579
41581	41590		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
20 AWG		1.45+/-0.05 [ .057+/- .002 ]		9.6
(2)24		1.37+/-0.05 [ .054+/- .002 ]		10.4
22 AWG		1.37+/-0.05 [ .054+/- .002 ]		10.4
24 AWG		1.32+/-0.05 [ .052+/- .002 ]		10.9



 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 ITEMS 180.  
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.

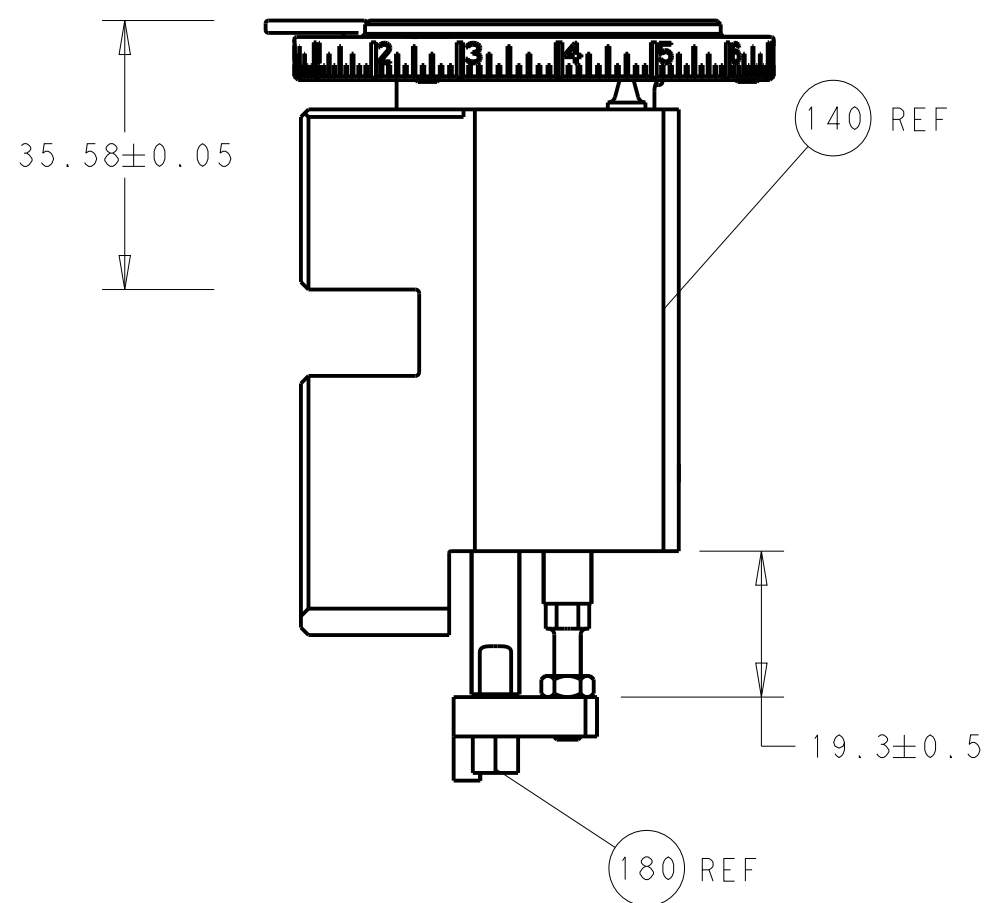
\*WARNING  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING  
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER  
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING,  
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

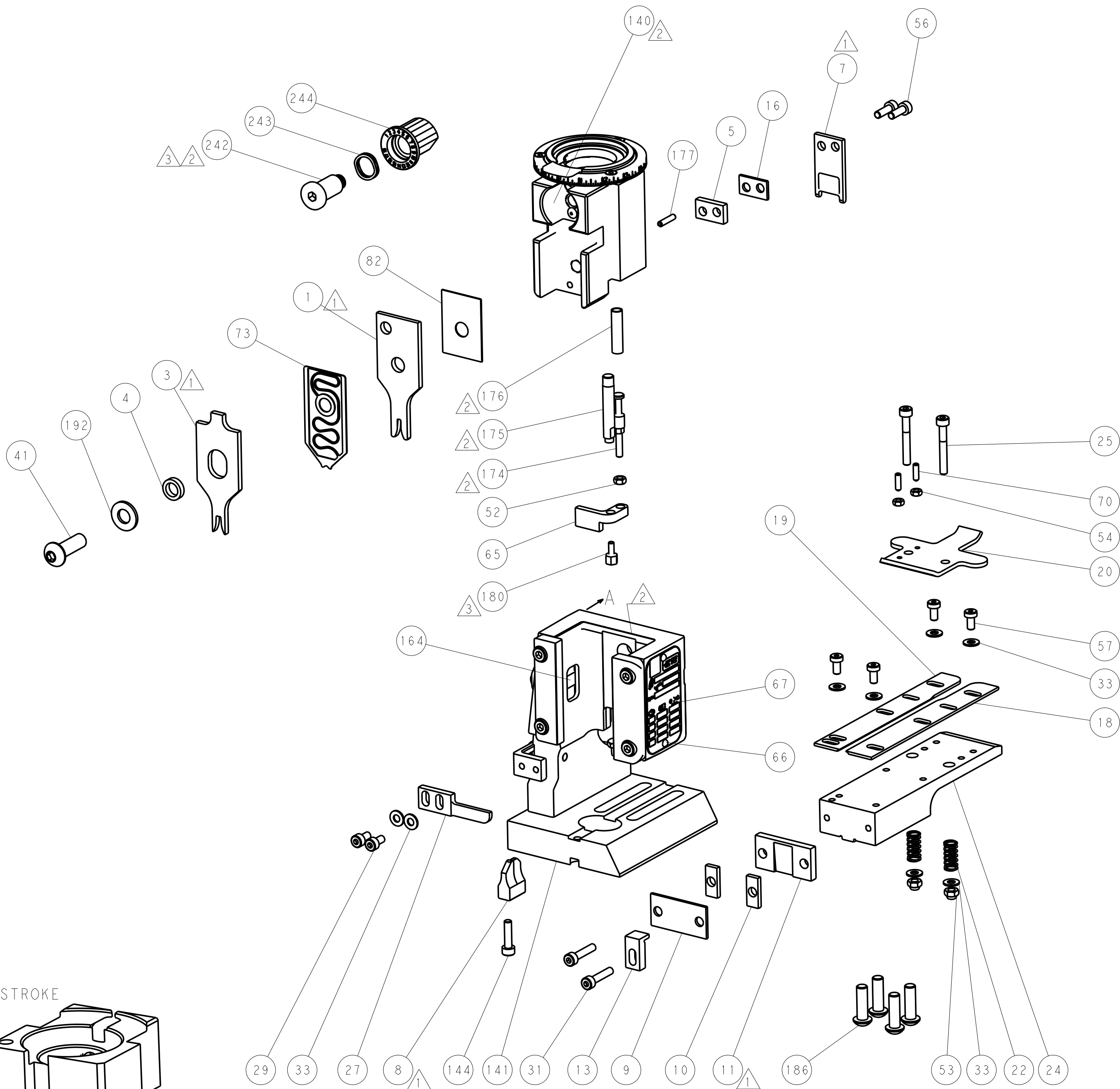
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<small>(THIS DRAWING IS A COMPUTER GENERATED FILE AND THEREFORE NO DIMENSIONAL VERIFICATION SHOULD BE CONDUCTED ON THIS FILED PRINT) DATE OF PLOT: 08/29/2019</small>				DWG J. HAYNES 8JAN2019		 TE Connectivity Morrisburg, VA 17105-3608			
DIMENSIONS:  mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK R. KNEPPER 8JAN2019		NAME		Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPR TOPPER 8JAN2019		PRODUCT SPEC			
						APPLICATION SPEC			
MATERIAL		FINISH		WEIGHT		SIZE, CASE CODE, DRAWING NO.		RESTRICTED TO	
-		-		-		A   00779 C=2150283		-	
Customer Accessible Production Drawing						SCALE		SHEET 3 OF 4 REV C	

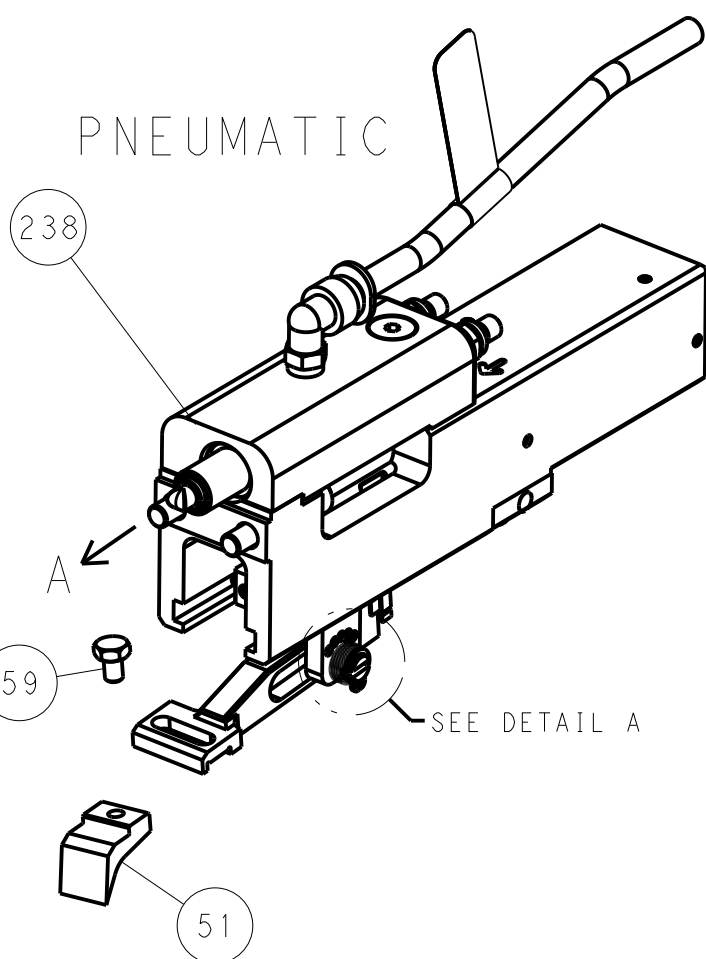
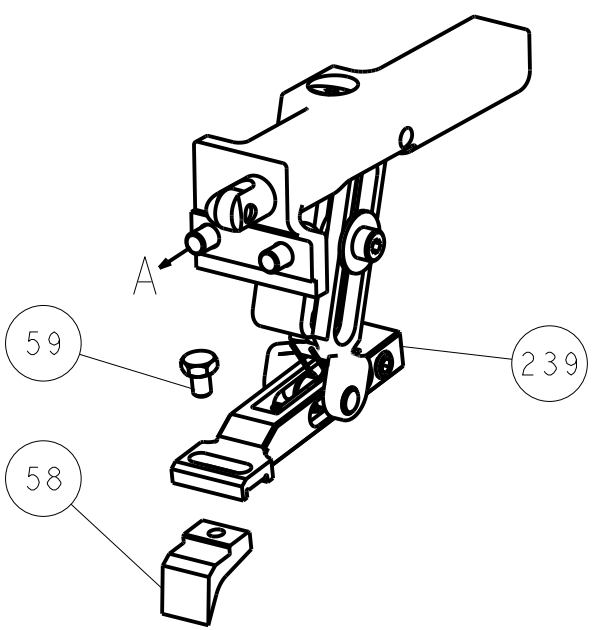
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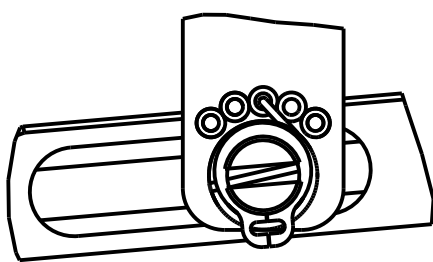
RAM AND HOLDDOWN SET-UP



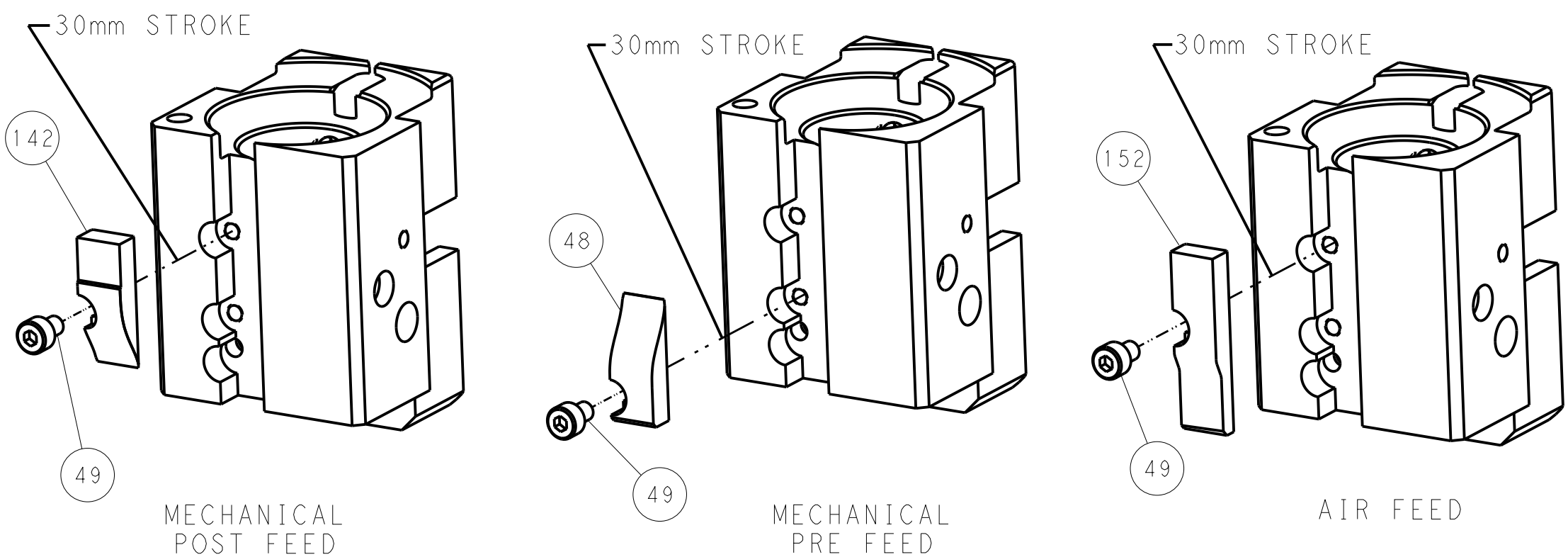
FEED TYPE  
MECHANICAL





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)

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DIMENSIONS:										CHK R. KNEPPER 8JAN2019					
mm										APVD C. TOPPER 8JAN2019		NAME Ocean End Feed Applicator			
										PRODUCT SPEC		SIZE A   00779 C-2150283		RESTRICTED TO -	
										APPLICATION SPEC					
MATERIAL -										WEIGHT -		Customer Accessible Production Drawing			
FINISH -										SCALE 1:1		SHEET 4 OF 4		REV C	