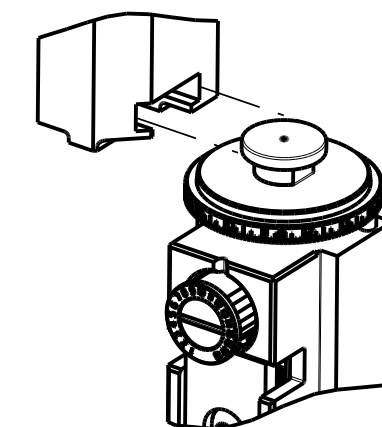


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150457-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150457-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150457-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150457-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150457-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .110 SERIES MINIATURE FASTON RECEPTACLE

WIRE STRIP LENGTH: 3.20-4.00 mm [.126-.157 IN] INSULATION DIAMETER RANGE: 1.50-2.80 mm [.059-.110 IN]

TERMINAL APPLICATION SPECIFICATION: 114-20109

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180423-1	1-180423-1	180437-2	
180423-2	180437-1	280429-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40 +/- 0.05 [.055 +/- .002]	7.1
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	8.0
0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	8.6
0.50mm2	1.22 +/- 0.05 [.048 +/- .002]	9.1

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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)

LOC: A DIST: 66

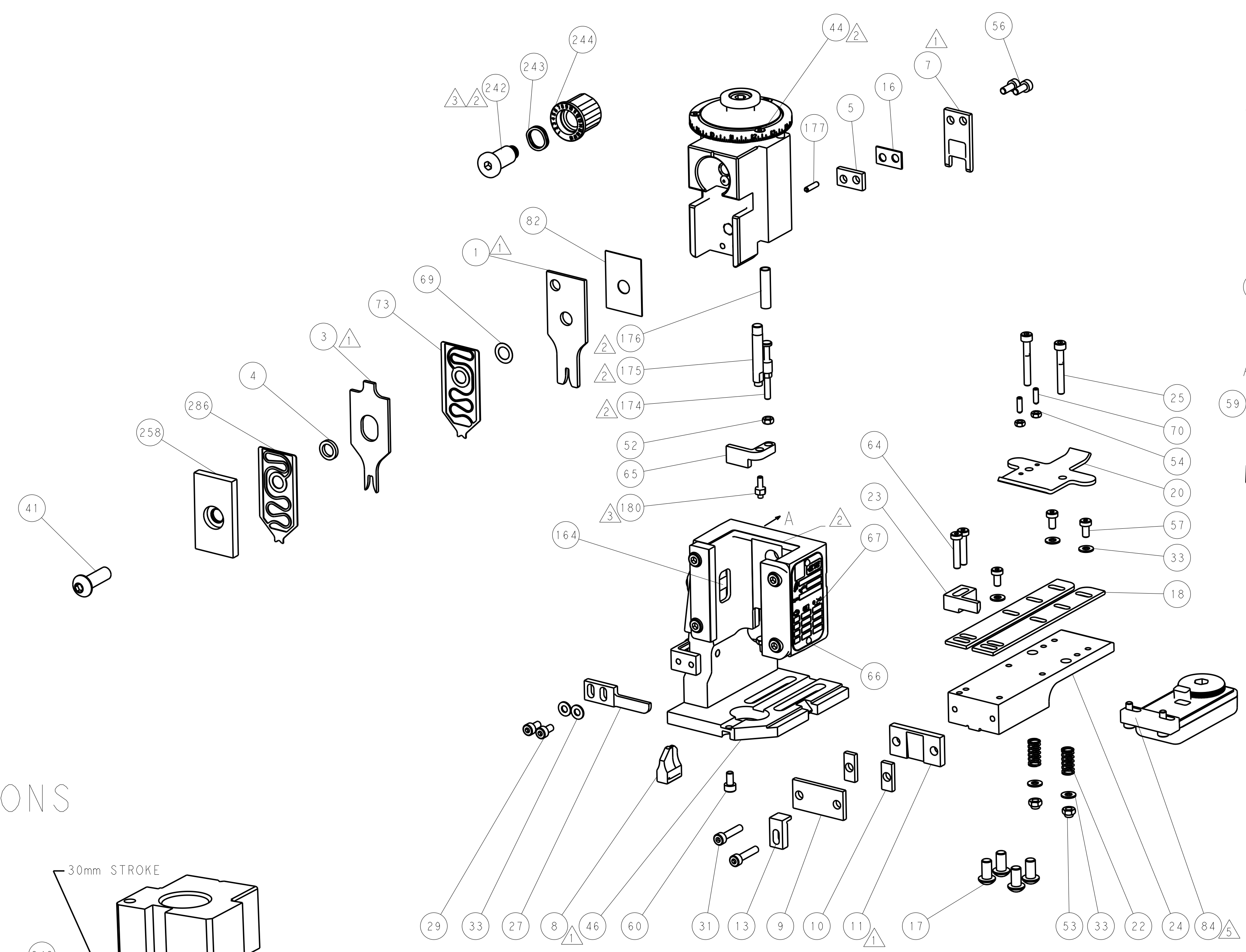
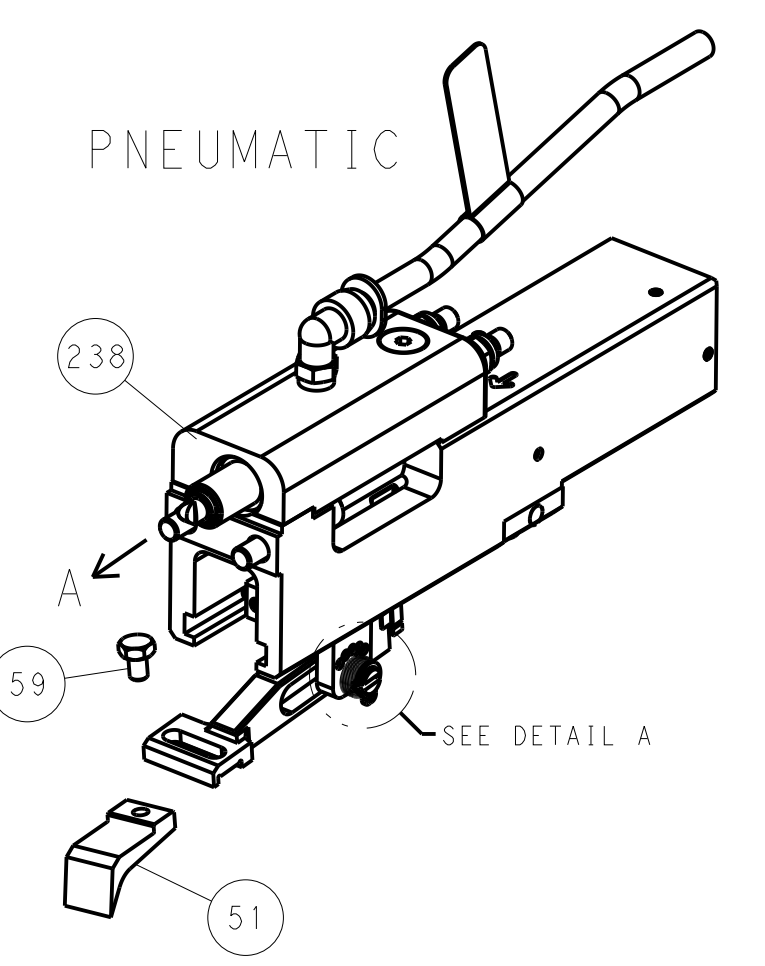
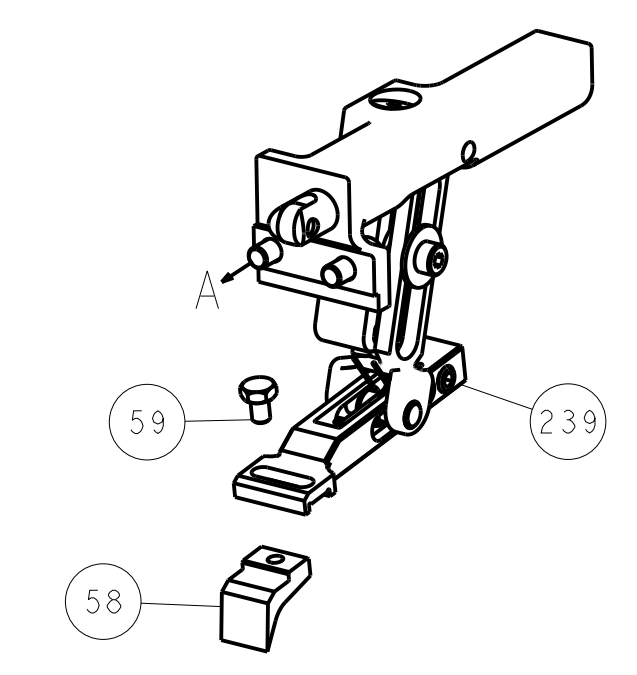
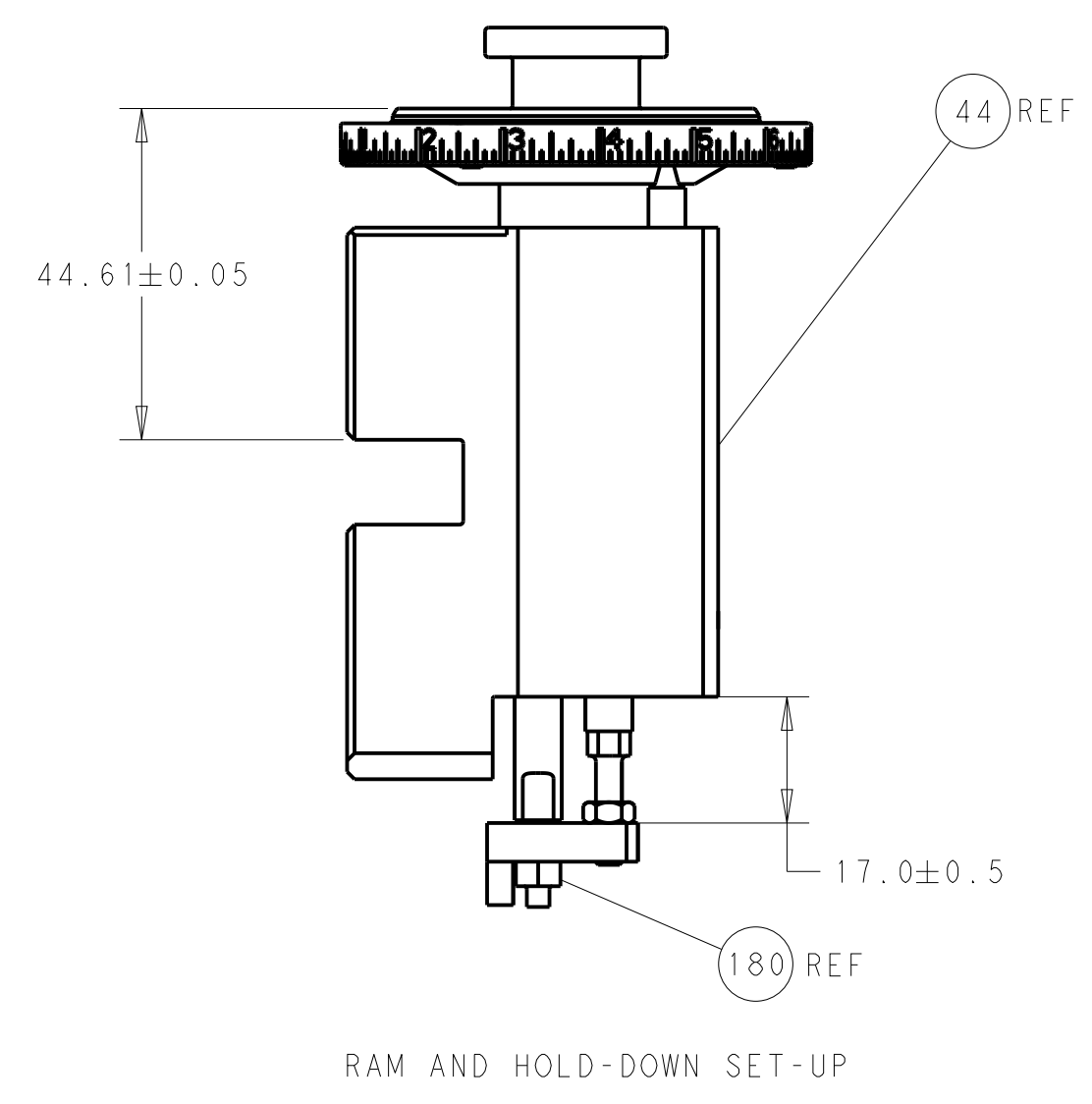
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C		ECR-19-018845	04DEC2019	FJ	TE
D		ECR-20-010238	20JUL2020	FJ	TE

-	1	1	1	1	2119791-7	DEPRESSOR, WIRE	286
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	258
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	1976055-9	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119791-5	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	2119943-1	WASHER, SPACER	69
-	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	-	2063961-9	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
-	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	240825-4	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	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	5-240641-9	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	2	2	1	1333216-2	ANVIL, COMBINATION	8
-	1	1	1	1	1-240651-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	3-240641-0	SPACER	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1-456405-2	CRIMPER, WIRE PREMIUM	1

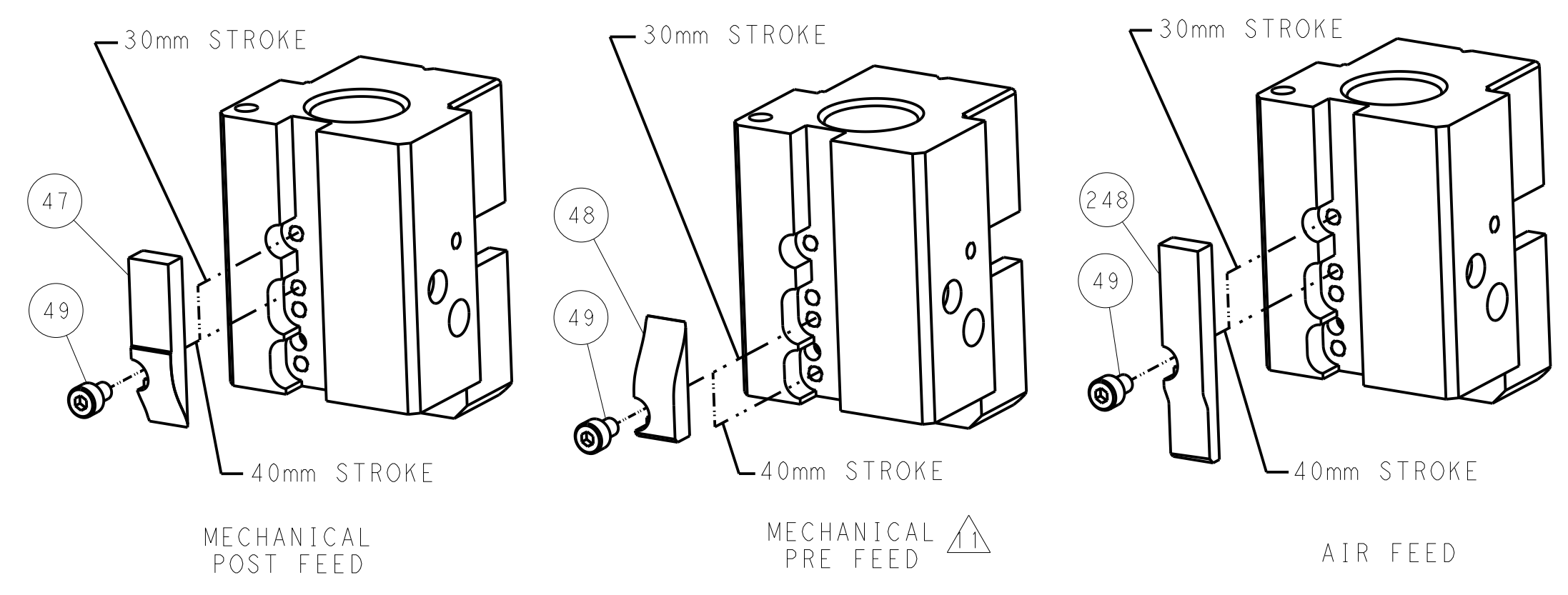
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PLC 0		±		CHK: T. ELBIN 09JUL2014		NAME: Ocean End Feed Applicator	
PLC 1		±		APPV: T. ELBIN 09JUL2014		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
PLC 2		±		PRODUCT SPEC:		A1 00779 ©=2150457	
PLC 3		±		APPLICATION SPEC:		SCALE: 1:1 SHEET 1 OF 4 REV D	
PLC 4		±		WEIGHT:		Customer Accessible Production Drawing	
ANGLES:		±		MATERIAL:			
FINISH:		±		FINISH:			

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

FEED TYPE MECHANICAL



CAM POSITIONS

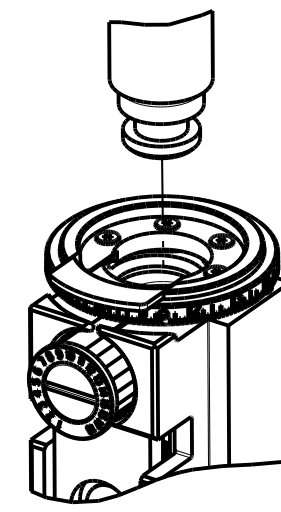


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09JUL2014		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 09JUL2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APPV: T. ELBIN 09JUL2014	SIZE: A		CAGE CODE: 00779
	2 PLC	±		PRODUCT SPEC:	DRAWING NO: 2150457		REV: D
	3 PLC	±		APPLICATION SPEC:	SCALE: 1:1		SHEET 2 OF 4
	4 PLC	±		WEIGHT:	Customer Accessible Production Drawing		REV: D
	ANGLES	±					

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150457-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150457-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150457-7	A	CRIMP TOOLING KIT	-

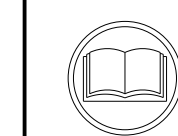
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [1.40]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	.110 SERIES MINIATURE FASTON RECEPTACLE	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	
3.20-4.00 mm [1.26-.157 IN]	1.50-2.80 mm [1.059-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20109	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
180423-1	1-180423-1	180437-2
180423-2	180437-1	280429-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40 +/- 0.05 [1.055 +/- .002]	7.1
1.00mm2	1.32 +/- 0.05 [1.052 +/- .002]	8.0
0.75mm2	1.27 +/- 0.05 [1.050 +/- .002]	8.6
0.50mm2	1.22 +/- 0.05 [1.048 +/- .002]	9.1



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. TERMINAL LUBRICANT IS RECOMMENDED.
6. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
7. 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)

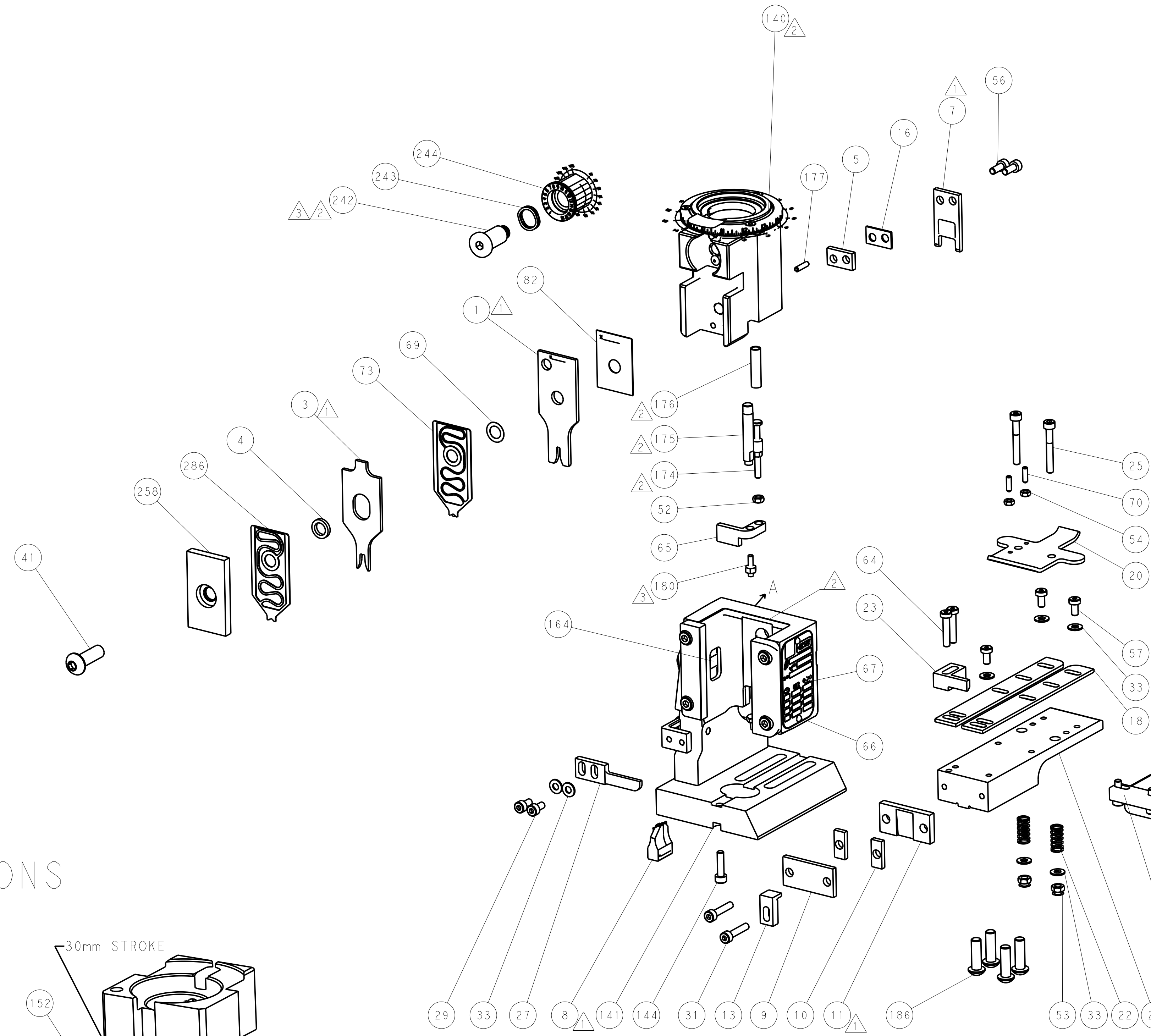
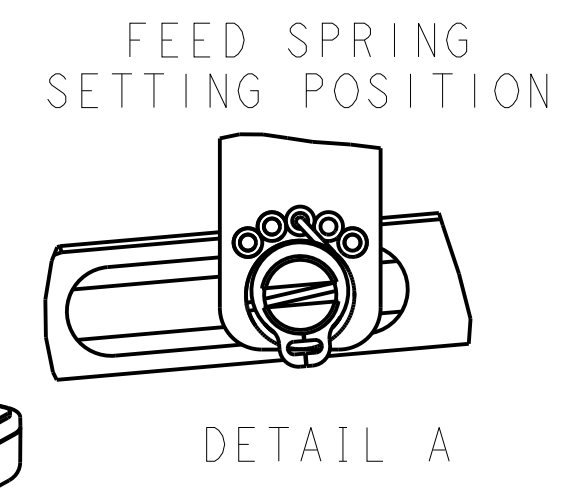
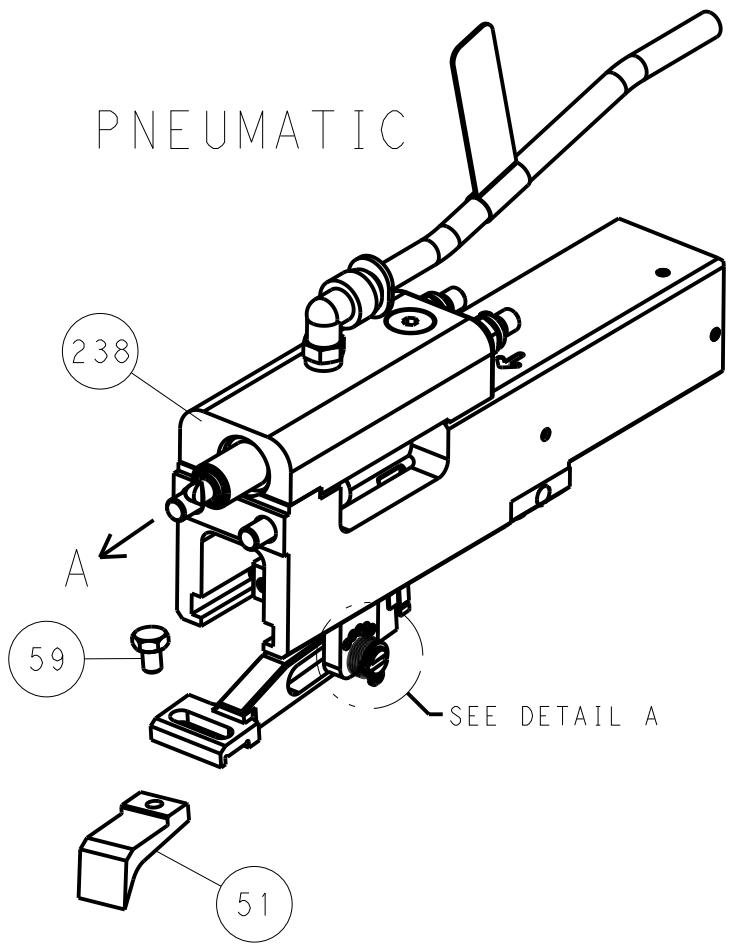
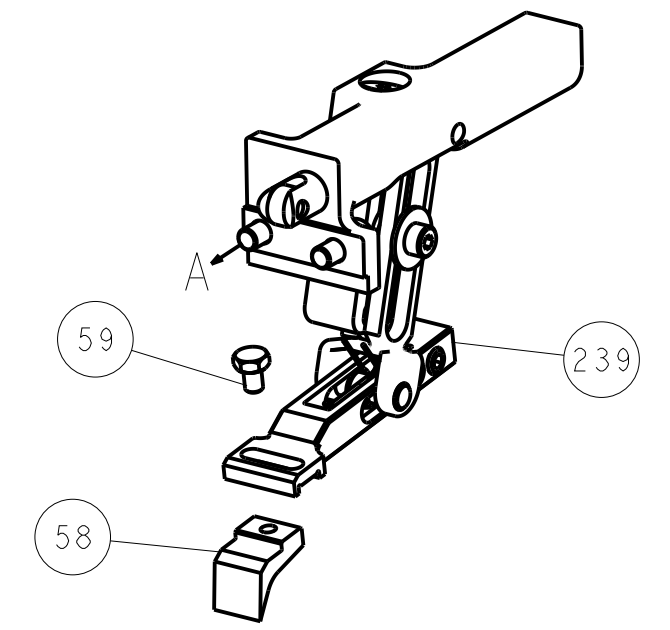
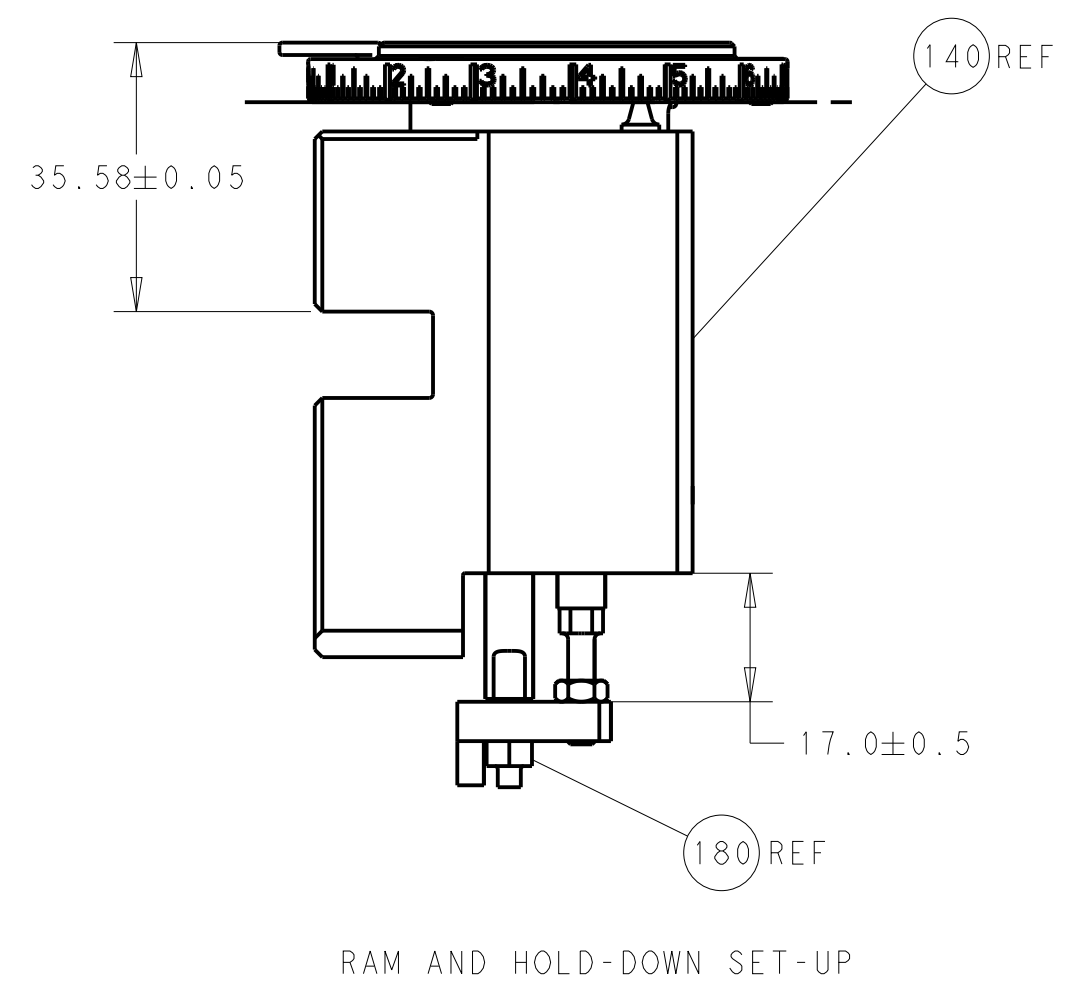
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REVISIONS						
REV	DATE	BY	CHK	APPV	DESCRIPTION	QTY
-	-	-	-	-	SEE SHEET 1	-
-	1	1			2119791-7	DEPRESSOR, WIRE
-	1	1			1803203-1	BLOCK, FRONT DEPRESSOR
-	1	1			2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT
-	1	1			2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST
-	1	1			2119083-1	RETAINER, INSULATION DIAL
-	-	1			2119580-1	MECHANICAL FEED ASSEMBLY
-	1	-			2844940-3	AIR FEED MODULE
-	4	4			2079383-9	SCR, BHSC, RoHS (M6 X 20)
-	1	1			1976055-9	STANDOFF, HOLD-DOWN
-	1	1			993111-8	PIN, SLOTTED SPRING 3.0 X 12.0
-	1	1			8-22280-7	SPRING, COMPRESSION
-	1	1			1752353-2	GUIDE PIN, HOLDDOWN
-	1	1			1901680-2	GUIDE PIN, HOLDDOWN
-	REF	REF			994970-2	COUNTER, MAGNETIC
-	1	-			2119641-2	FEED CAM, AIR FEED
-	1	1			2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16
-	-	1			2119653-2	FEED CAM, POST FEED
-	1	1			2119655-6	APPLICATOR BASIC ASSEMBLY, EF
-	1	1			1803518-1	RAM ASSEMBLY, EF PACIFIC
-	1	1			2119955-2	ASSY, LUBRICATOR, END FEED
-	1	1			455888-4	SPACER, CRIMPER
-	1	1			2119791-5	DEPRESSOR, WIRE
-	1	1			1803607-4	DOCUMENTATION PACKAGE
-	2	2			2-18032-2	SCR, SET, FLT PNT, M3 X 10.0
-	1	1			2119943-1	WASHER, SPACER
-	1	1			2119740-1	TAG, IDENTIFICATION
-	2	2			2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188
-	1	1			1901681-5	HOLDDOWN, TERMINAL
-	2	2			2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20
-	-	2			5-18022-5	SCR, HEX HD CAP, M4 X 6.0
-	-	1			2063961-1	FEED FINGER
-	3	3			2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8
-	2	2			1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10
-	2	2			5018030-1	NUT, HEX, REG, RoHS, M3
-	2	2			986965-8	NUT, LOCK, HEX, TORQUE (M4)
-	1	1			1-5018030-0	NUT, HEX, REG, RoHS, M3.5
-	1	-			2063961-9	FEED FINGER
-	1	2			18023-9	SCR, SKT HD CAP M4 X 6.0
-	-	1			2119652-1	FEED CAM, PRE FEED
-	1	1			1803602-1	SCR, BHSC, RoHS (M8 X 25)
-	7	7			1-18028-2	WASHER, FLAT, REG M4
-	2	2			2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20
-	2	2			2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0
-	1	1			240639-1	STRIPPER (MACHINING)
-	2	2			1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30
-	1	1			1752371-5	PLATE, STRIP GUIDE
-	1	1			240825-4	PLATE, STRIP HOLD DOWN
-	2	2			2-22281-3	SPRING, COMPRESSION
-	1	1			1803292-4	DRAG
-	2	2			1901259-4	GUIDE, LOWER STRIP
-	1	1			5-240641-9	SPACER
-	1	1			1752360-1	SPACER, HOLD-DOWN
-	1	1			240644-1	PLATE, REAR SHEAR
-	2	2			1-240645-4	SPACER, SHEAR PLATE
-	1	1			240642-1	PLATE, FRONT SHEAR
-	1	1			1333216-2	ANVIL, COMBINATION
-	1	1			1-240651-8	BLADE, SLUG
-	-	-			-	-
-	1	1			3-240641-0	SPACER
-	1	1			238011-8	BLOCK, CRIMPER SPACER
-	1	1			2-2119582-4	CRIMPER, INSULATION F PREMIUM
-	-	-			-	-
-	1	1			1-456405-2	CRIMPER, WIRE PREMIUM
-	77-22-21				PART NO	DESCRIPTION
-						ITEM NO

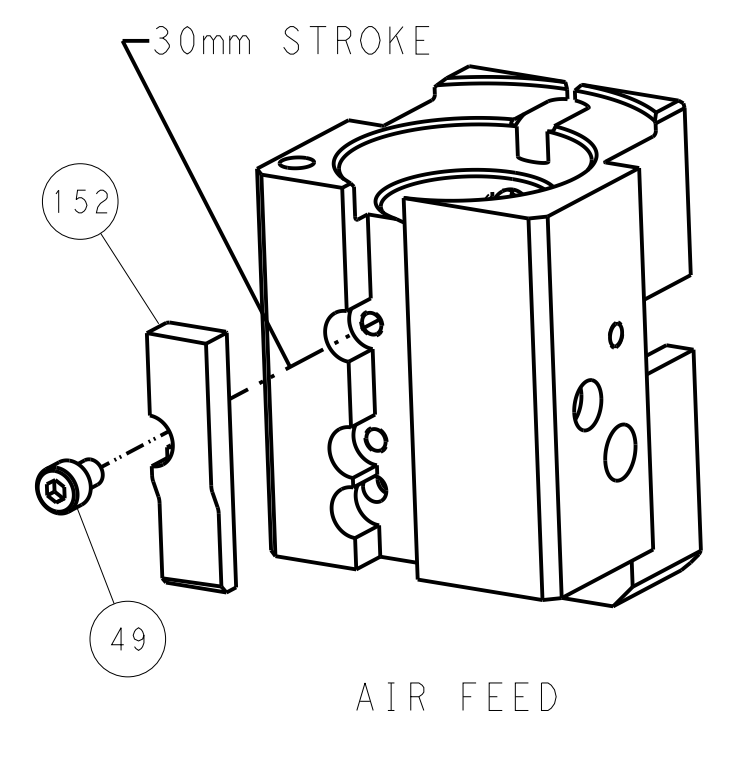
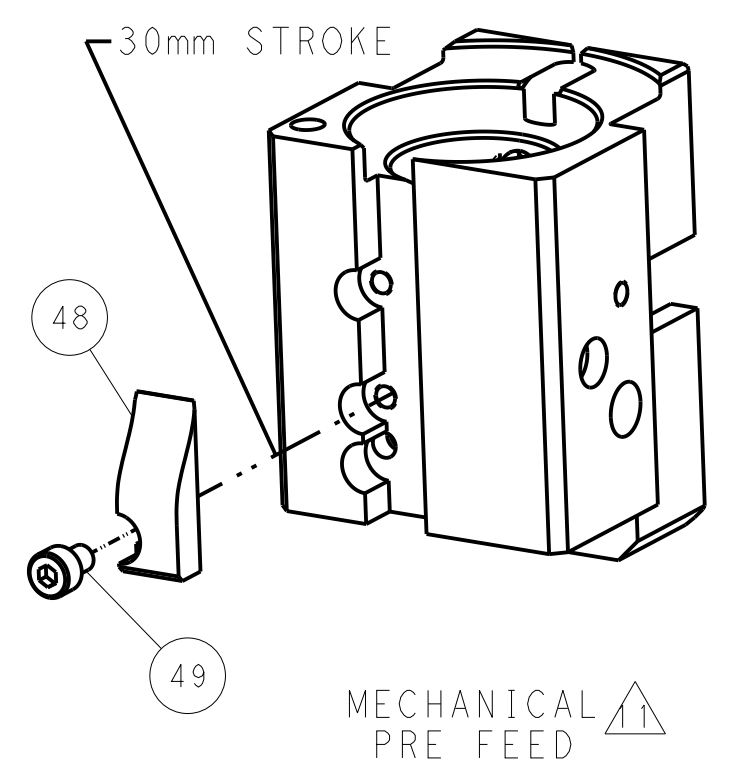
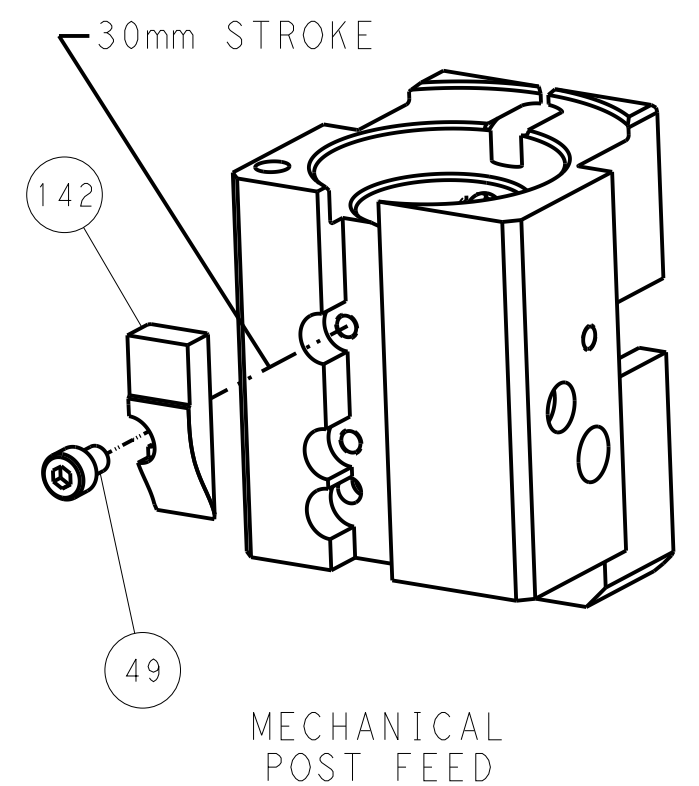
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09JUL2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean End Feed Applicator	
MATERIAL:		FINISH:		APVD: T. ELBIN 09JUL2014		SIZE: A1	
				WEIGHT:		SCALE: 1:1	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 3 OF 4	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			

FEED TYPE MECHANICAL



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: B. WEAVER 09JUL2014 CHK: T. ELBIN 09JUL2014 APVD: T. ELBIN 09JUL2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		NAME	Ocean End Feed Applier		
	1 PLC	±		PRODUCT SPEC			
	2 PLC	±		APPLICATION SPEC			
	3 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
	4 PLC	±		A11	00779	©=2150457	
MATERIAL	FINISH	WEIGHT	ANGLES	Customer Accessible Production Drawing		SCALE	1:1 SHEET 4 OF 4 REV D

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2150457-1](#)