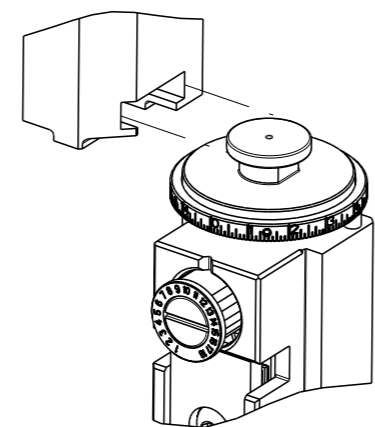


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2150539-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150539-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2150539-7	A	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, MARK III			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø3.81-5.08 mm [.150-.200 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2074			
TERMINALS APPLIED			
TE TERMINAL 1217096-1	TE TERMINAL 1217096-2	TE TERMINAL 1217114-1	TE TERMINAL 1217114-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.60+/-0.05 [.063+/-0.002]	7.0
2x 18 AWG	1.52+/-0.05 [.060+/-0.002]	8.0
16 AWG	1.42+/-0.05 [.056+/-0.002]	9.2
18 AWG	1.30+/-0.05 [.051+/-0.002]	10.7

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED
- 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.

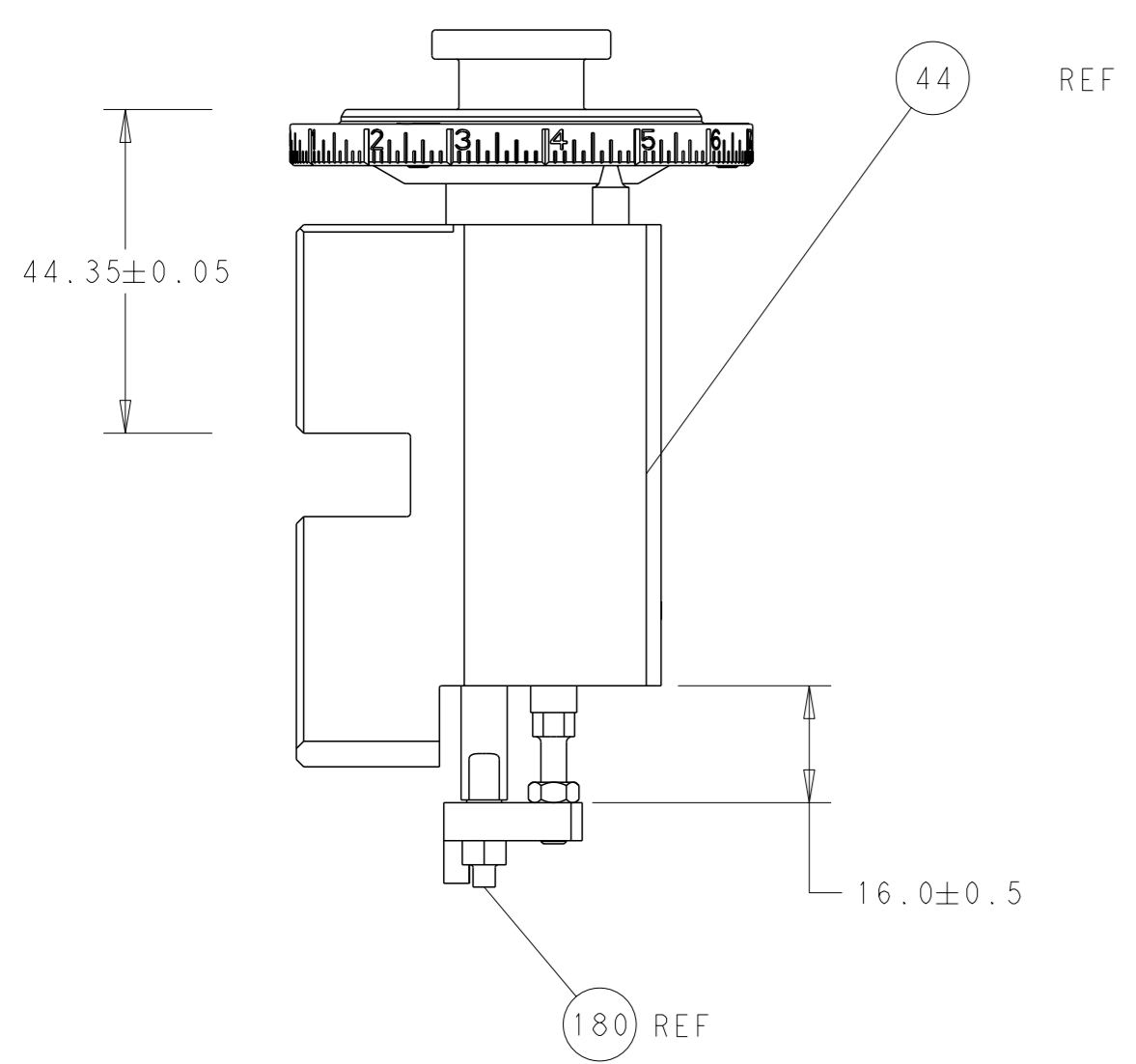
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	20APR2015	MR	TE
		B		ECR-16-014767	18OCT2016	LG	GB
		C		ECR-19-009814	24JUN2019	JAH	TE

-	1	1	2119640-1	PUSH ROD, AIR FEED	250		
-	1	1	2079988-1	BUSHING, LCH5-12, MISUMI	249		
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
6	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2063440-1	AIR FEED MODULE	238		
-	1	1	1803052-1	FEED FINGER ASSEMBLY, EF	184		
6	-	1	1	1-1976055-0	STANDOFF, HOLD-DOWN	180	
-	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		
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172		
-	1	1	240638-1	SPRING, FEED FINGER	163		
-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	131		
-	1	1	455888-5	SPACER, CRIMPER	82		
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77		
-	1	1	1-2119791-4	DEPRESSOR, WIRE	73		
-	1	1	1803607-2	DOCUMENTATION PACKAGE	71		
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70		
-	1	1	2119943-1	WASHER, SPACER	69		
-	1	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1	1901681-4	HOLDDOWN, TERMINAL	65		
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64		
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60		
-	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	1	2031314-1	FEED FINGER SUBASSEMBLY	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46		
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44		
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	240639-1	STRIPPER (MACHINING)	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1752371-5	PLATE, STRIP GUIDE	24		
-	1	1	240825-8	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		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	3-240641-6	SPACER	16		
-	1	1	1752360-1	SPACER, HOLD-DOWN	13		
1	-	-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	10	
1	-	-	1	690482-6	PLATE, FRONT SHEAR	9	
1	1	2	1	7-1803001-6	ANVIL, COMBINATION, END FEED	8	
1	-	-	1	2217206-4	BLADE, SLUG	7	
-	1	1	1	8-240641-6	SPACER	5	
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	72	-	2	PART NO	DESCRIPTION	ITEM NO

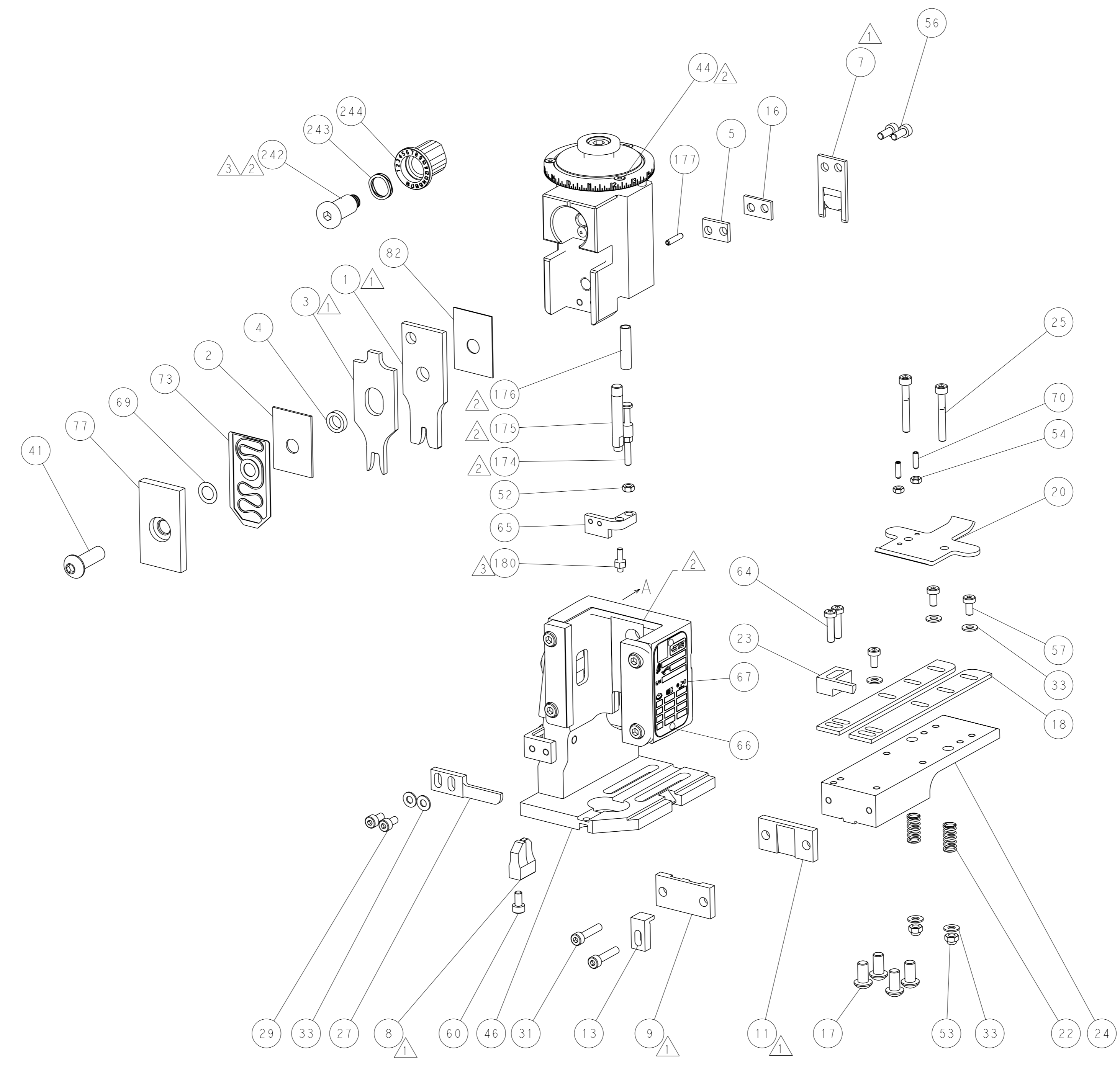
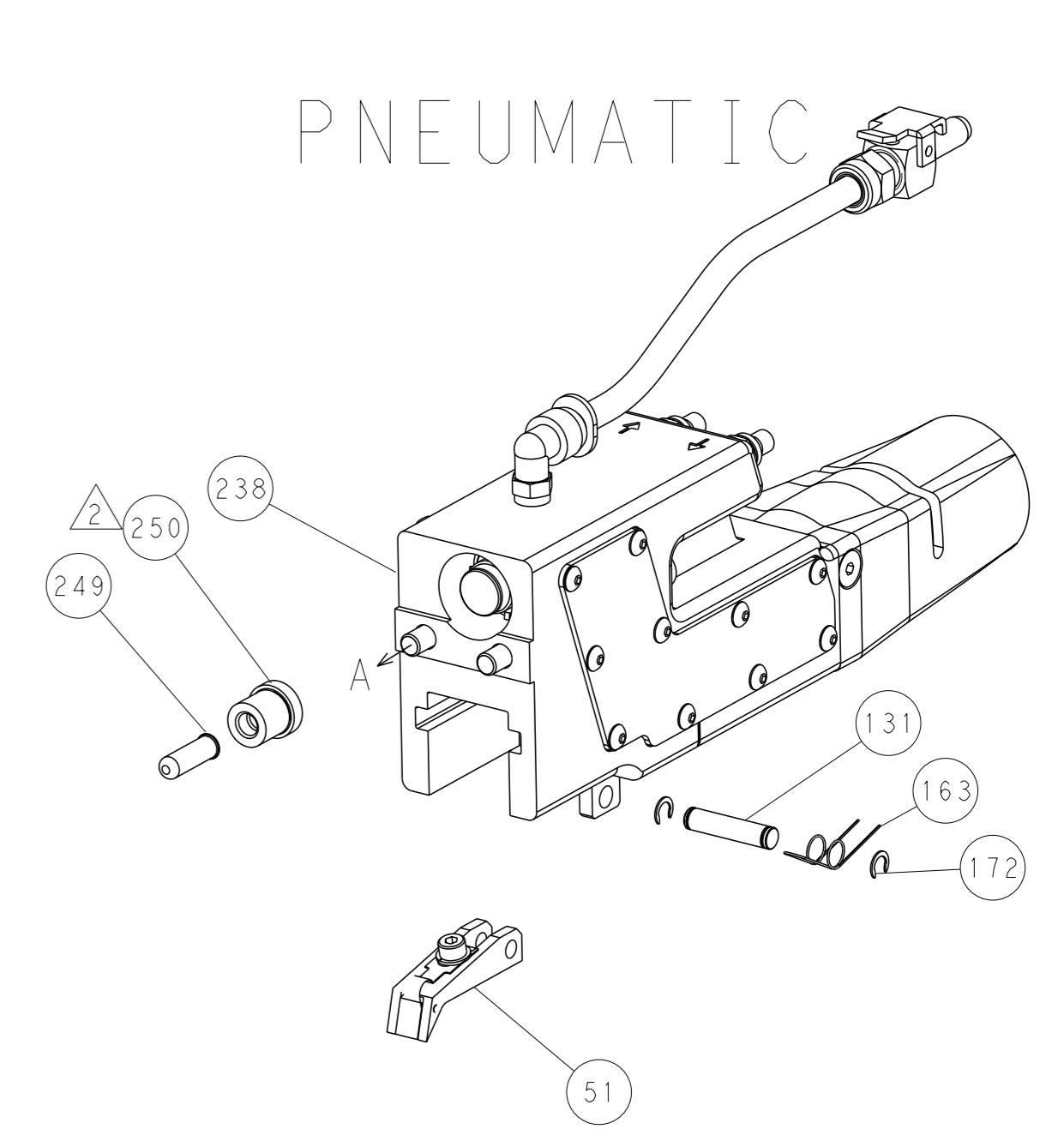
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mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	APVD		SIZE		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SCALE		REV	
						A1 00779 ©=2150539		Customer Accessible Production Drawing	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

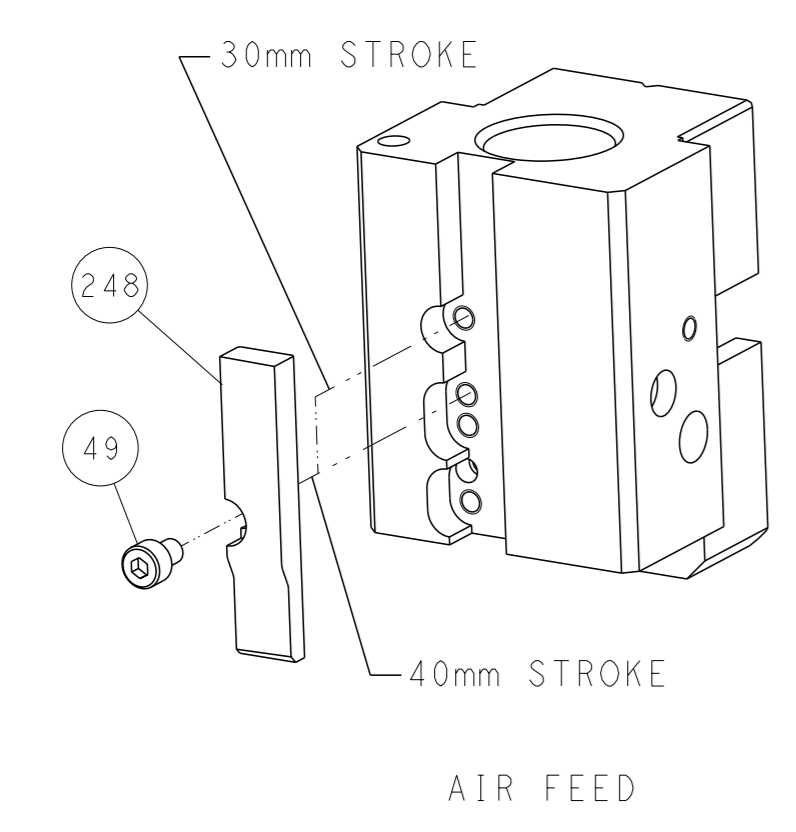


RAM AND HOLDDOWN SET-UP

FEED TYPE
 PNEUMATIC



CAM POSITION



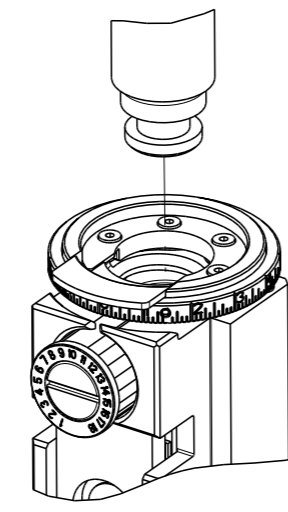
AIR FEED

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 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:1	SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing		

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150539-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150539-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.201]	F
INSUL	5.59 mm [2.201]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, MARK III			
WIRE STRIP LENGTH 4.39-5.16 mm [1.73-.203 IN]		INSULATION DIAMETER RANGE Ø3.81-5.08 mm [1.150-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217096-1	1217096-2	1217114-1	1217114-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.60 +/- 0.05 [1.063 +/- .002]	7.0
2x 18 AWG	1.52 +/- 0.05 [1.060 +/- .002]	8.0
16 AWG	1.42 +/- 0.05 [1.056 +/- .002]	9.2
18 AWG	1.30 +/- 0.05 [1.051 +/- .002]	10.7

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED
- 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.

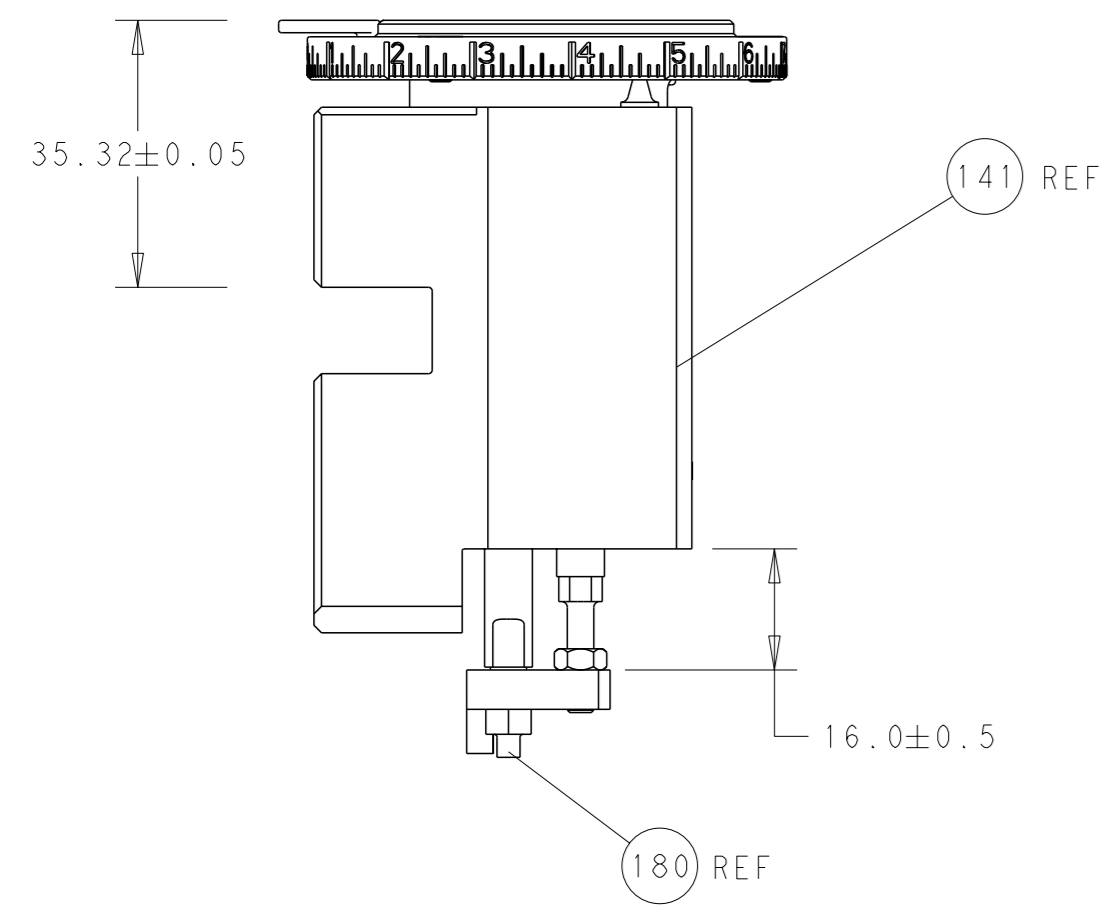
LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-1	AIR FEED MODULE	238
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1803052-1	FEED FINGER ASSEMBLY, EF	184
△	1	1-1976055-0	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	131
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1-2119791-4	DEPRESSOR, WIRE	73
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-4	HOLDDOWN, TERMINAL	65
-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2031314-1	FEED FINGER SUBASSEMBLY	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1-1901259-0	GUIDE, LOWER STRIP	18
-	1	3-240641-6	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
△	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
△	1	690482-6	PLATE, FRONT SHEAR	9
△	1	7-1803001-6	ANVIL, COMBINATION, END FEED	8
△	1	2217206-4	BLADE, SLUG	7
-	1	8-240641-6	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
△	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
△	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1

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

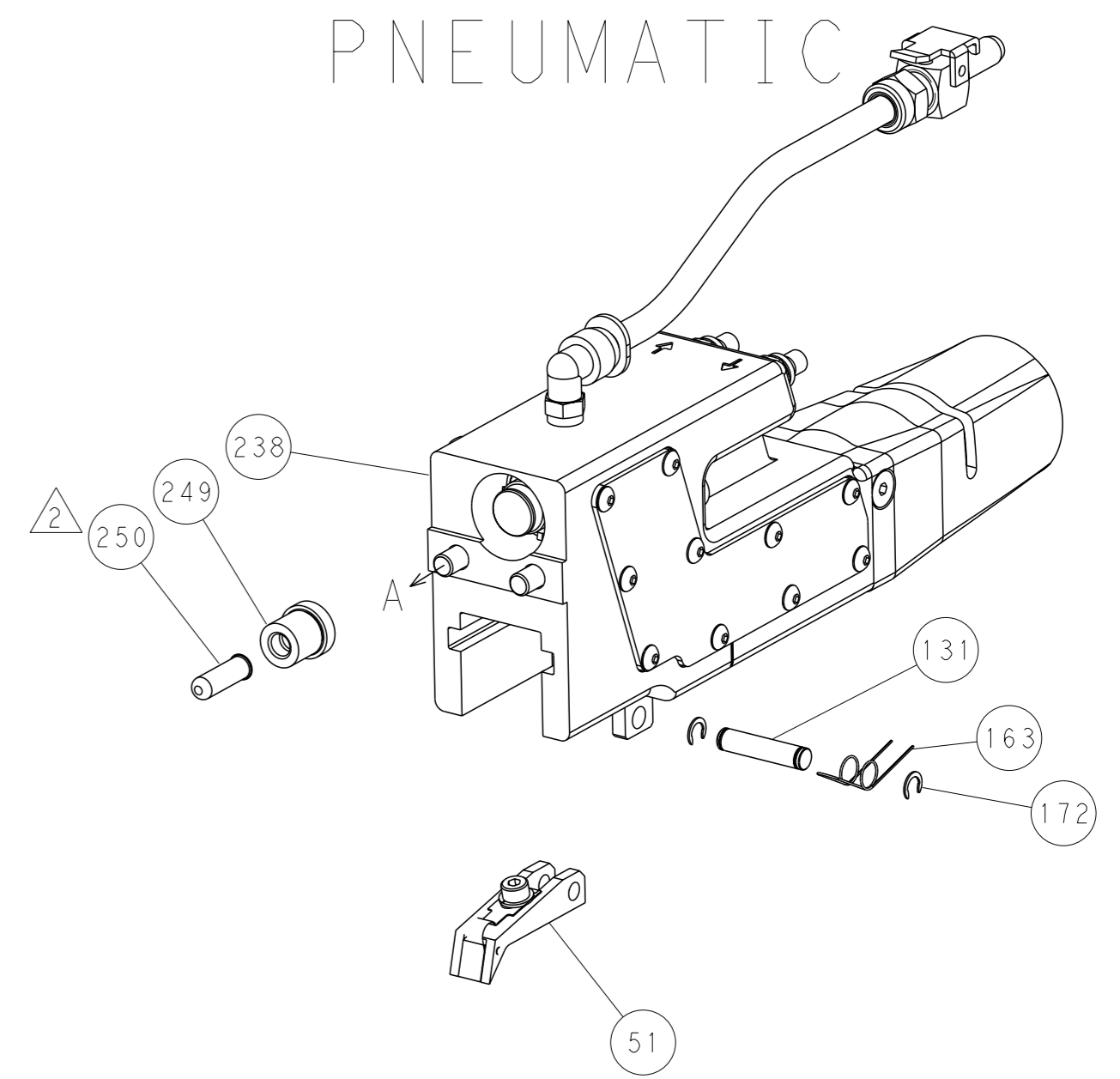
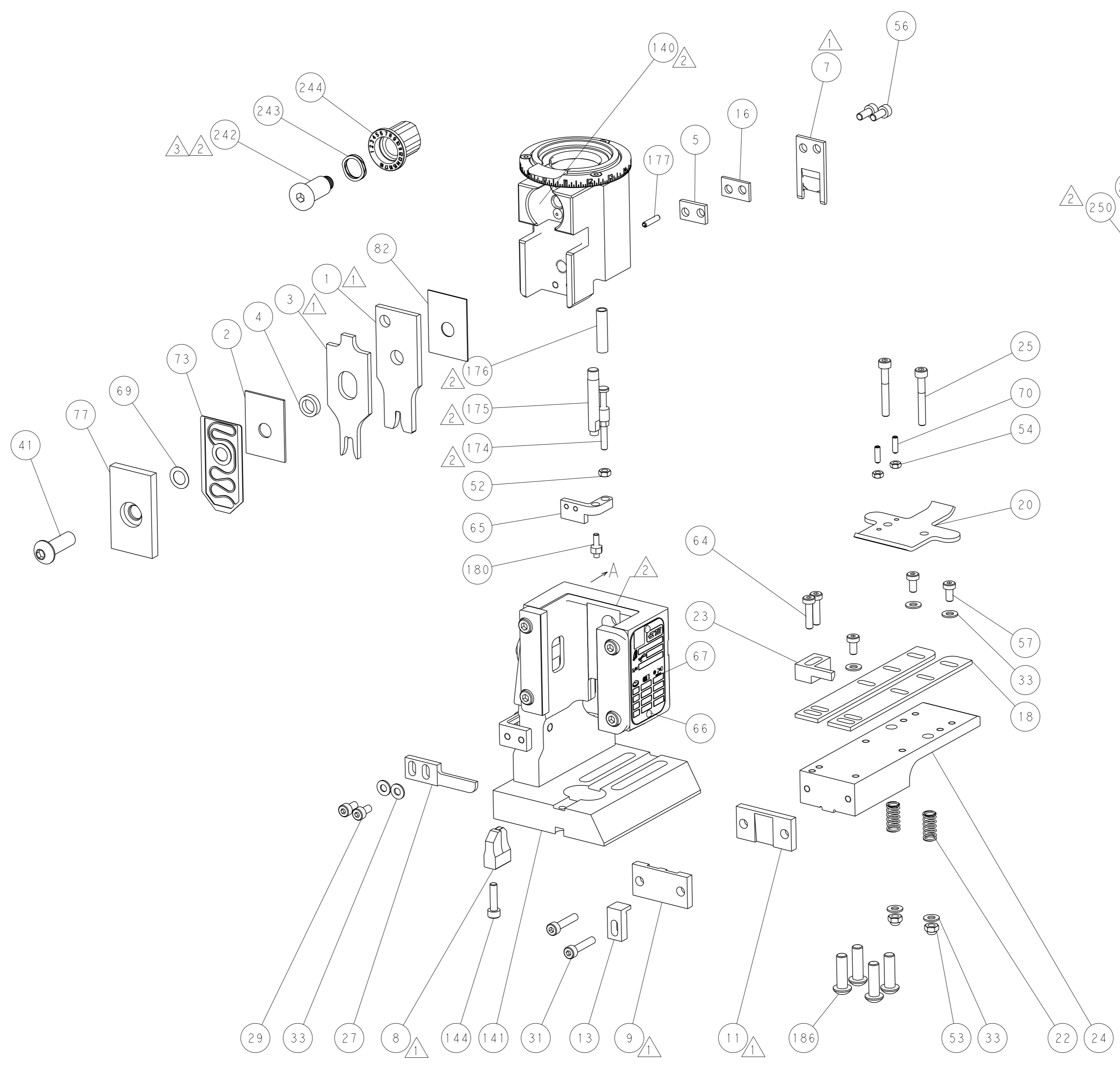
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER SHOULD CONTACT THE SUPPLIER FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: T. L. ELBIN DATE: 20MAR2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150539	RESTRICTED TO: - SCALE: 1:1 SHEET: 3 of 4 REV: C
MATERIAL: -		Customer Accessible Production Drawing	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

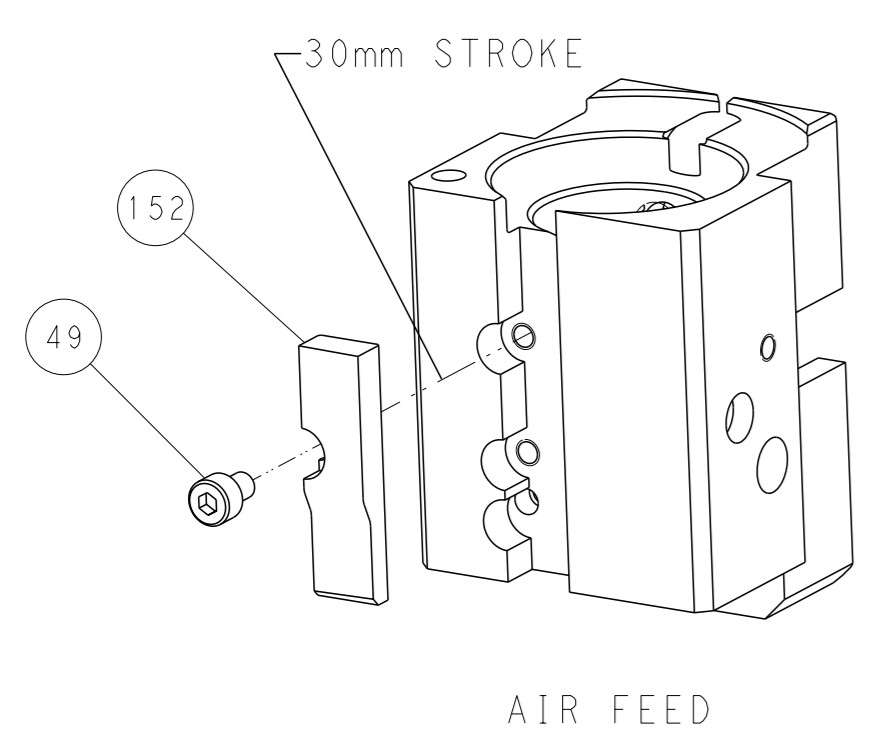


RAM AND HOLDDOWN SET-UP

FEED TYPE
PNEUMATIC



CAM POSITION



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND EXISTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: T. L. ELBIN	DATE: 20MAR2015 DATE: 23MAR2015 DATE: 23MAR2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150539	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:1	SHEET 4 OF 4	REV C

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[TE Connectivity:](#)

[7-2150539-7](#)