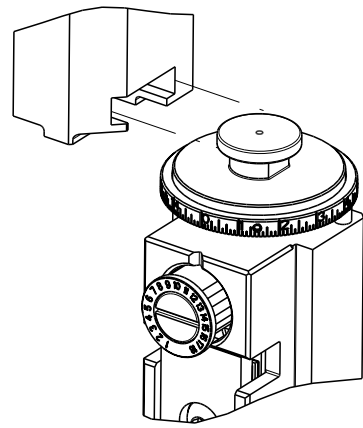

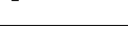


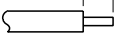



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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150544-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		INSULATION DIAMETER RANGE Ø2.29-4.32 mm [.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-2019 - -	
TERMINALS APPLIED 			
TE TERMINAL 63455-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		 INSULATION DIAMETER RANGE Ø 3.81 mm [.150 IN ] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
	-	-	-
TERMINALS APPLIED  			
TE TERMINAL 1217173-1	TE TERMINAL 1217173-3	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA		2.36+/-0.05 [.093+/- .002]		5.6
4000-4800 CMA		1.98+/-0.05 [.078+/- .002]		9.3



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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6 TERMINAL LUBRICANT IS RECOMMENDED.

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.

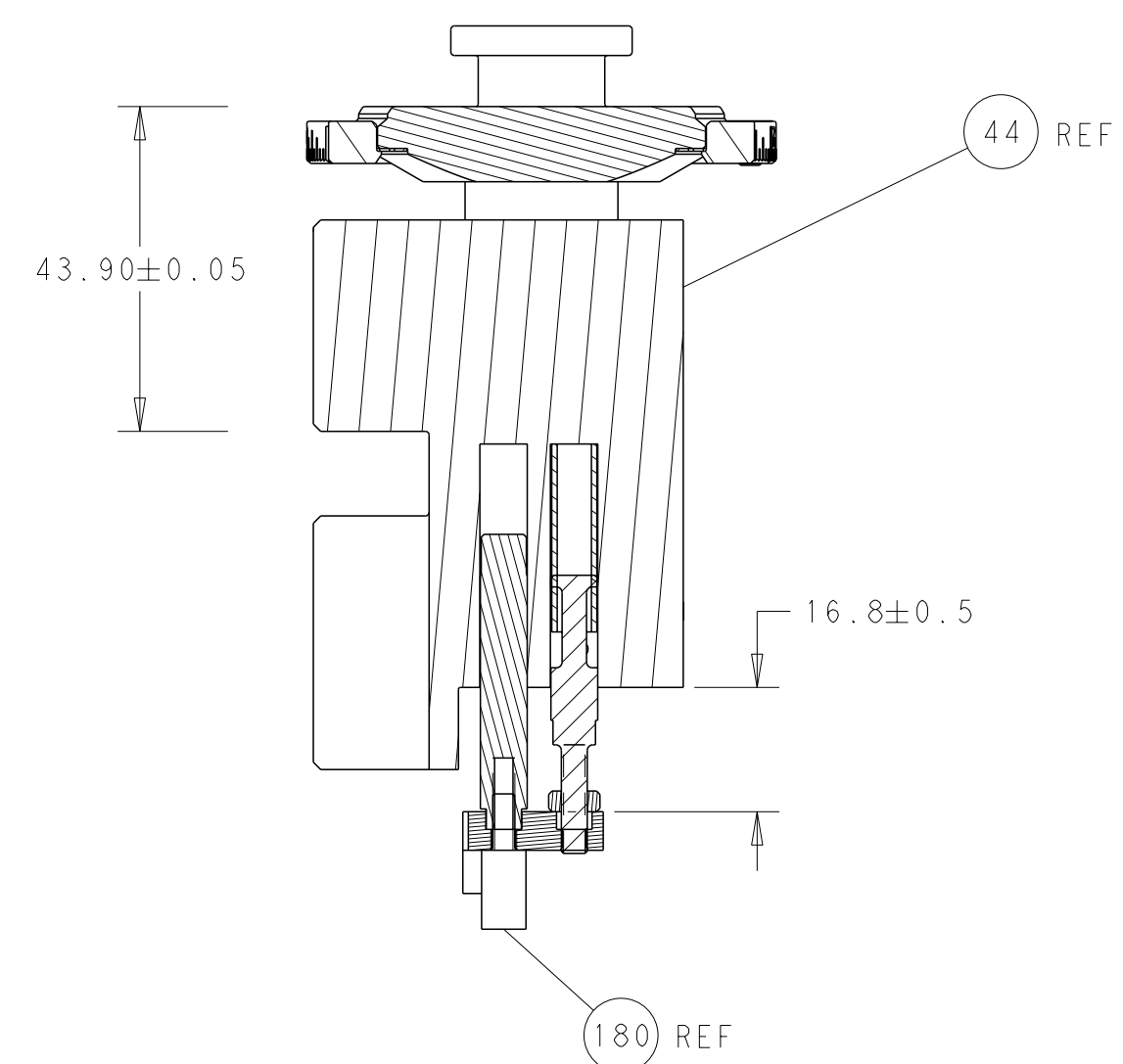
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1						
LOC	DIST	REVISIONS								
A	66	P	LTR	DESCRIPTION				DATE	DWN	APVD
			B	ECR-17-001231				27JAN2017	RK	TE
			C	ECR-18-016809				24OCT2018	MZ	KZ
			D	ECR-18-019120				10DEC2018	KH	LZ

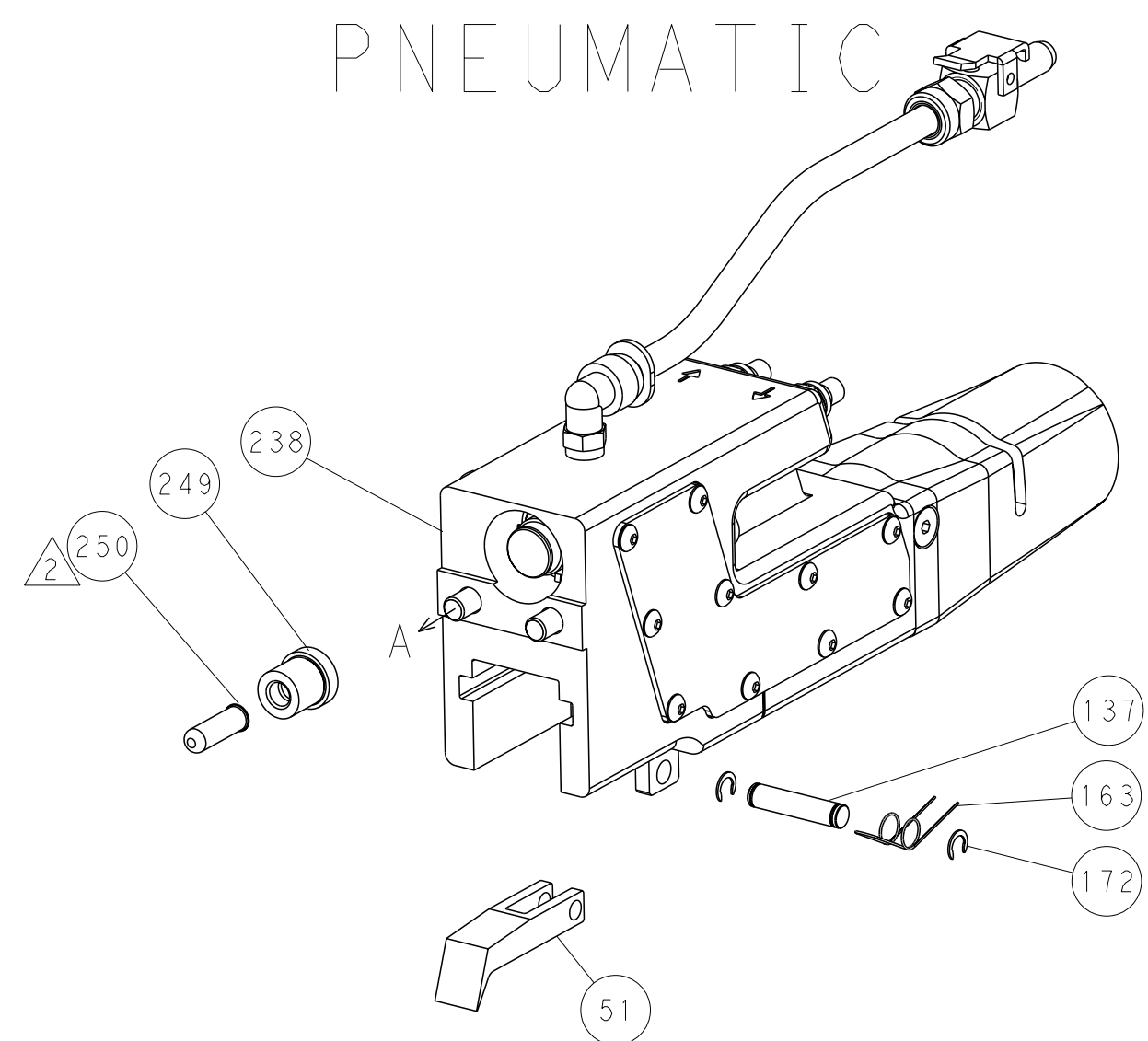
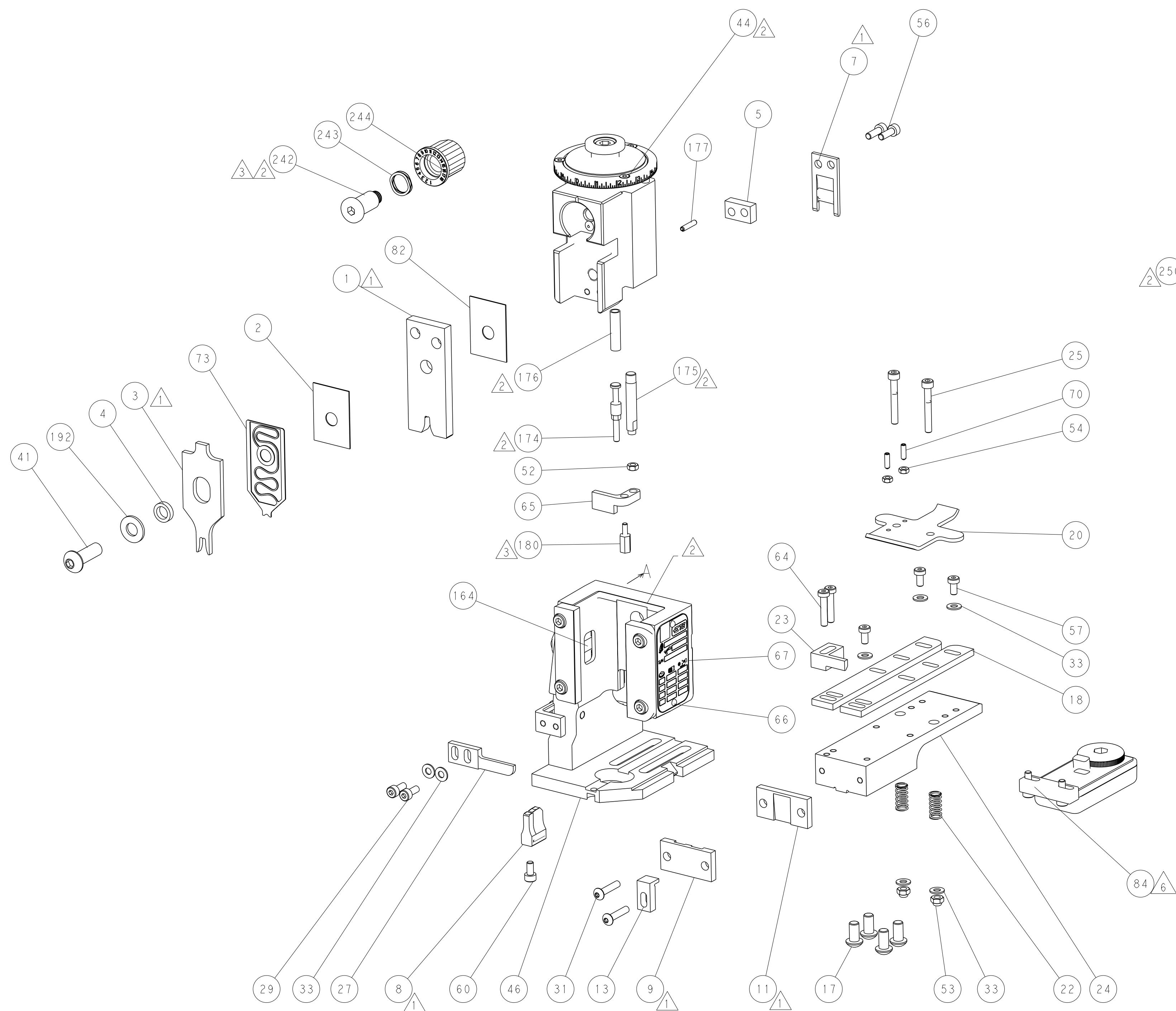
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	1	2063440-2	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	1	1	2-1752354-7	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
6	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	2119791-5	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	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119792-2	PAWL, EF, AIR	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	2119653-1	FEED CAM, POST FEED	47
-	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	2079383-5	SCR, BHSC, 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	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-7	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	1	1	240644-1	PLATE, REAR SHEAR	11
1	1	1	690482-5	PLATE, FRONT SHEAR	9
1	2	1	1803064-8	ANVIL, COMBINATION	8
-	1	1	4-690474-2	BLADE, SLUG	7
-	1	1	8-240641-8	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	2	1	462808-7	CRIMPER, BLUNT F	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE CASE CODE DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4	
				REV D	

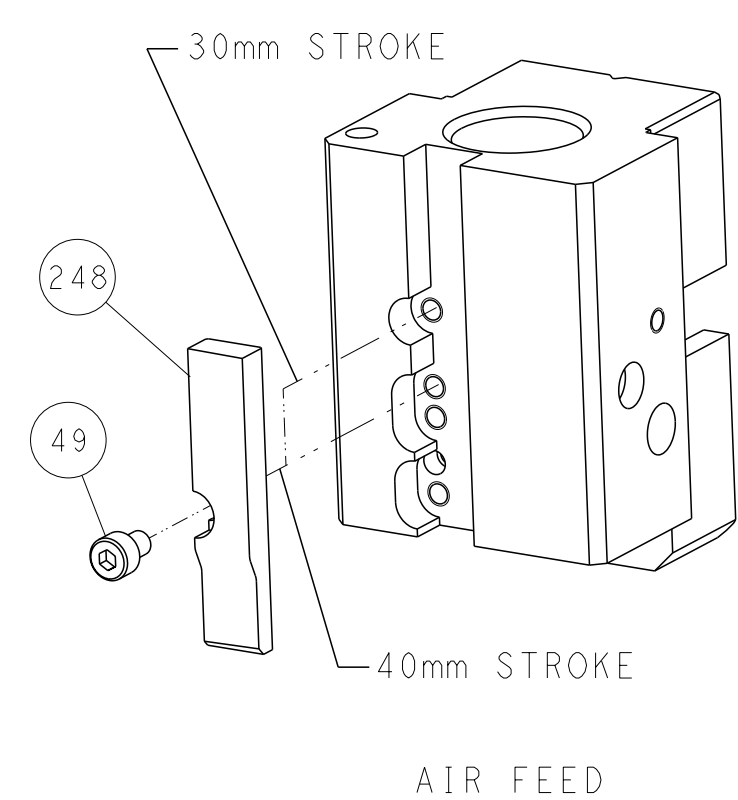
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



## RAM AND HOLDDOWN SET-UP




CAM POSITION



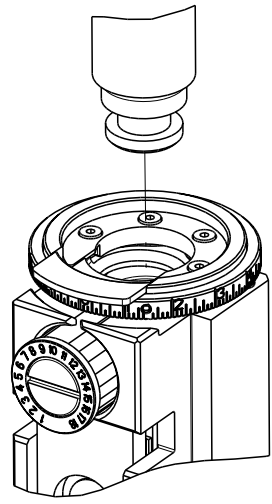
AIR FEED

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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						CHK 10APRIL2015		Harrisburg, PA 17105-3608	
DIMENSIONS:						G. BAILEY		NAME	
mm						FIBIN		Ocean End Feed Applicator	
						PRODUCT SPEC			
TOLERANCES UNLESS OTHERWISE SPECIFIED:						APPLICATION SPEC		SIZE CASE CODE DRAWING NO	
0 PLC ± .005								A   00779 C=2150544	
.005 PLC ± .005								RESTRICTED TO	
.010 PLC ± .010								-	
.015 PLC ± .015									
ANGLES ± .5°									
FINISH						WEIGHT			
-						-			
MATERIAL						Customer Accessible Porting Drawing		SCALE 1:1 SHEET 2 of 4 REV D	
-									

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150544-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		INSULATION DIAMETER RANGE Ø2.29-4.32 mm [.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION			
114-2019			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		INSULATION DIAMETER RANGE Ø 3.81 mm [.150 IN ] MAX	
TERMINAL APPLICATION SPECIFICATION		114-2019	
TERMINALS APPLIED		5 6	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA		2.36+/-0.05 [.093+/- .002]		5.6
4000-4800 CMA		1.98+/-0.05 [.078+/- .002]		9.3



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.


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)

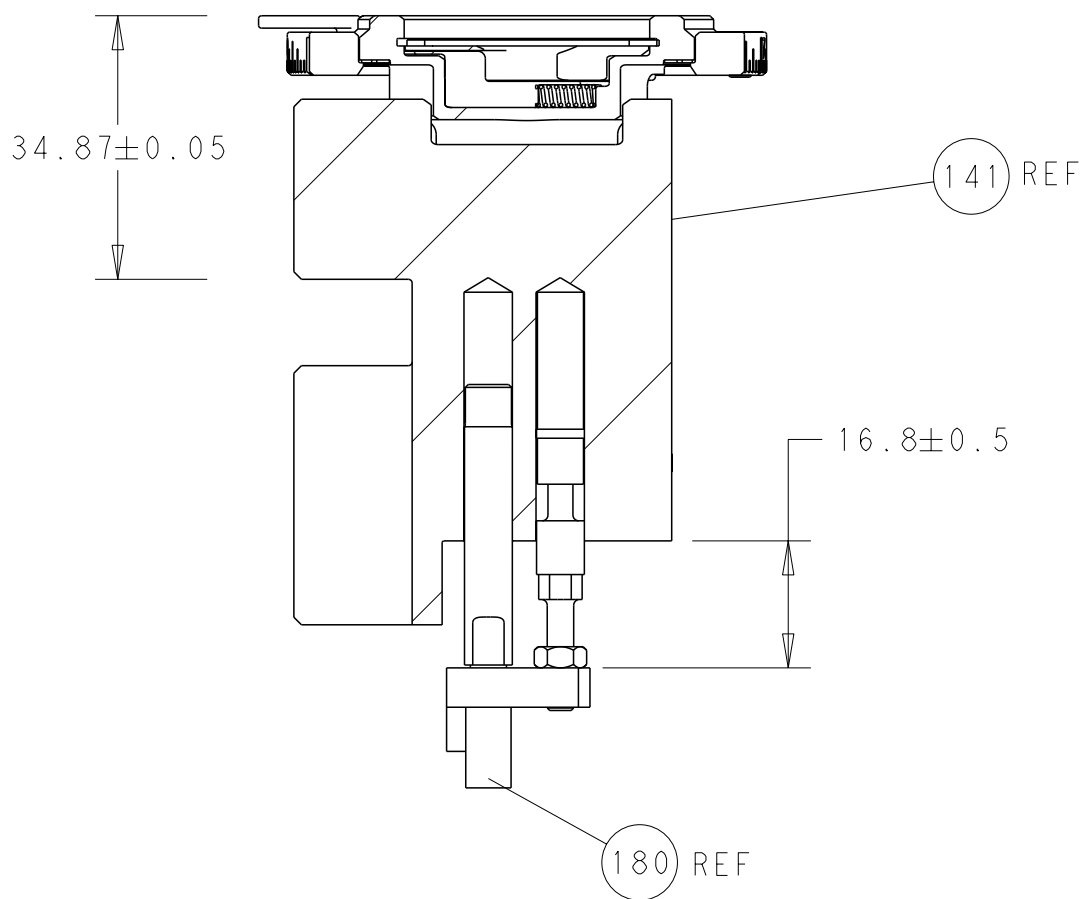
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	2063440-2	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	2-1752354-7	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
-	REF	994970-2	COUNTER, MAGNETIC	164
-	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
-	-	2119653-2	FEED CAM, POST FEED	142
-	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	137
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	2063961-1	FEED FINGER	58
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119792-2	PAWL, EF, AIR	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1803064-8	ANVIL, COMBINATION	8
-	1	4-690474-2	BLADE, SLUG	7
-	1	8-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	462808-7	CRIMPER, BLUNT F	1

- 77-22		PART NO	DESCRIPTION			ITEM NO
ON-1702 ELECTRONIC COMPONENTS AND MANUFACTURING ORGANIZATION LATEST REVISION.		OWN R. STAKEN CHK G. BAILEY APVD T. ELBIN	04APRIL2015 04APRIL2015 04APRIL2015		 TE Connectivity Harrisburg, PA 17105-3608	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME				
LC LC LC LC LES ISH	± ± ± ± ± ±	PRODUCT SPEC - APPLICATION SPEC -				
		SIZE	CAGE CODE	DRAWING NO		
		A1	00779	C=2150544	-	
Customer Accessible Production Drawing			SCALE	1:1	SHEET 3 OF 4	REV D

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

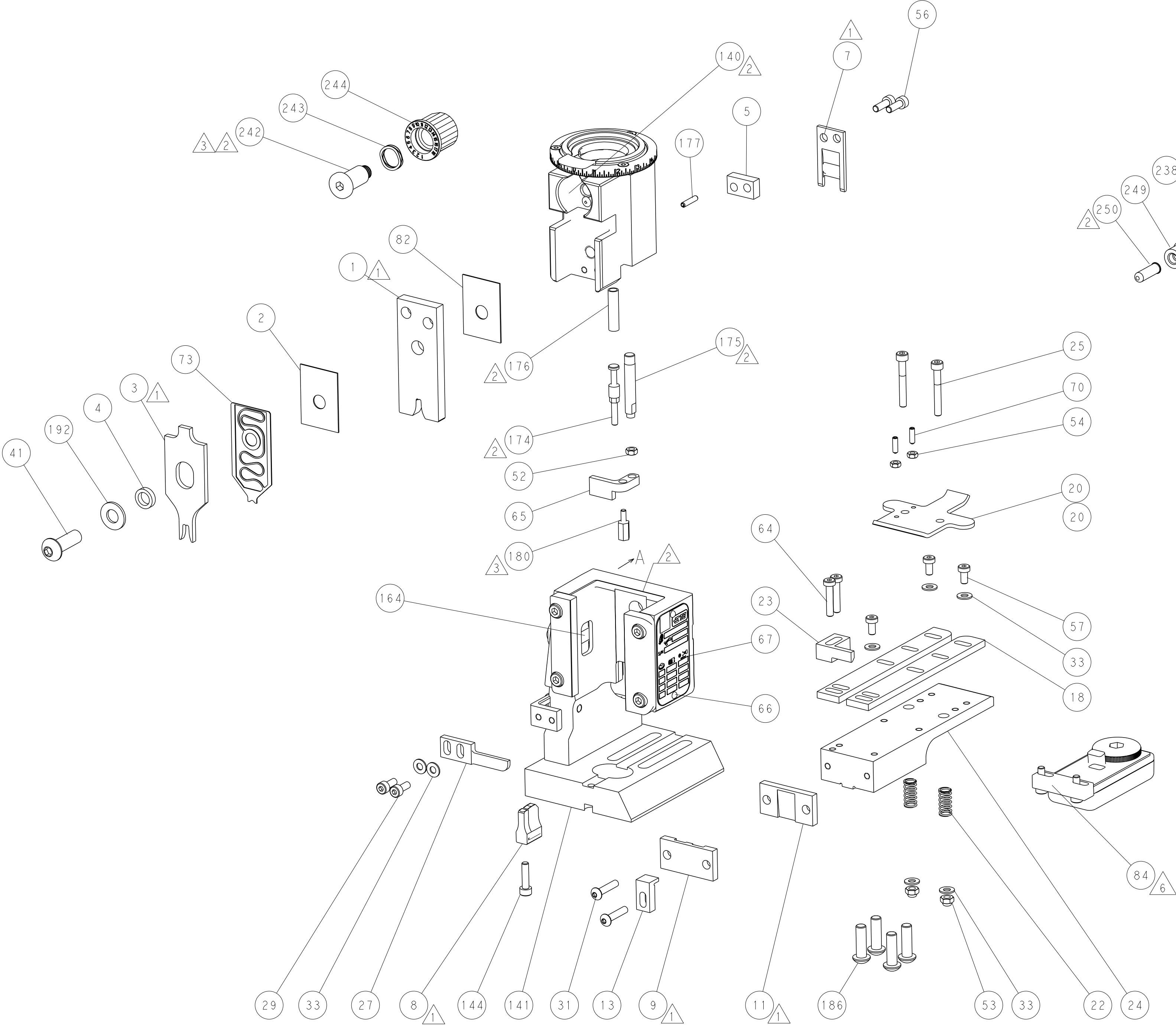
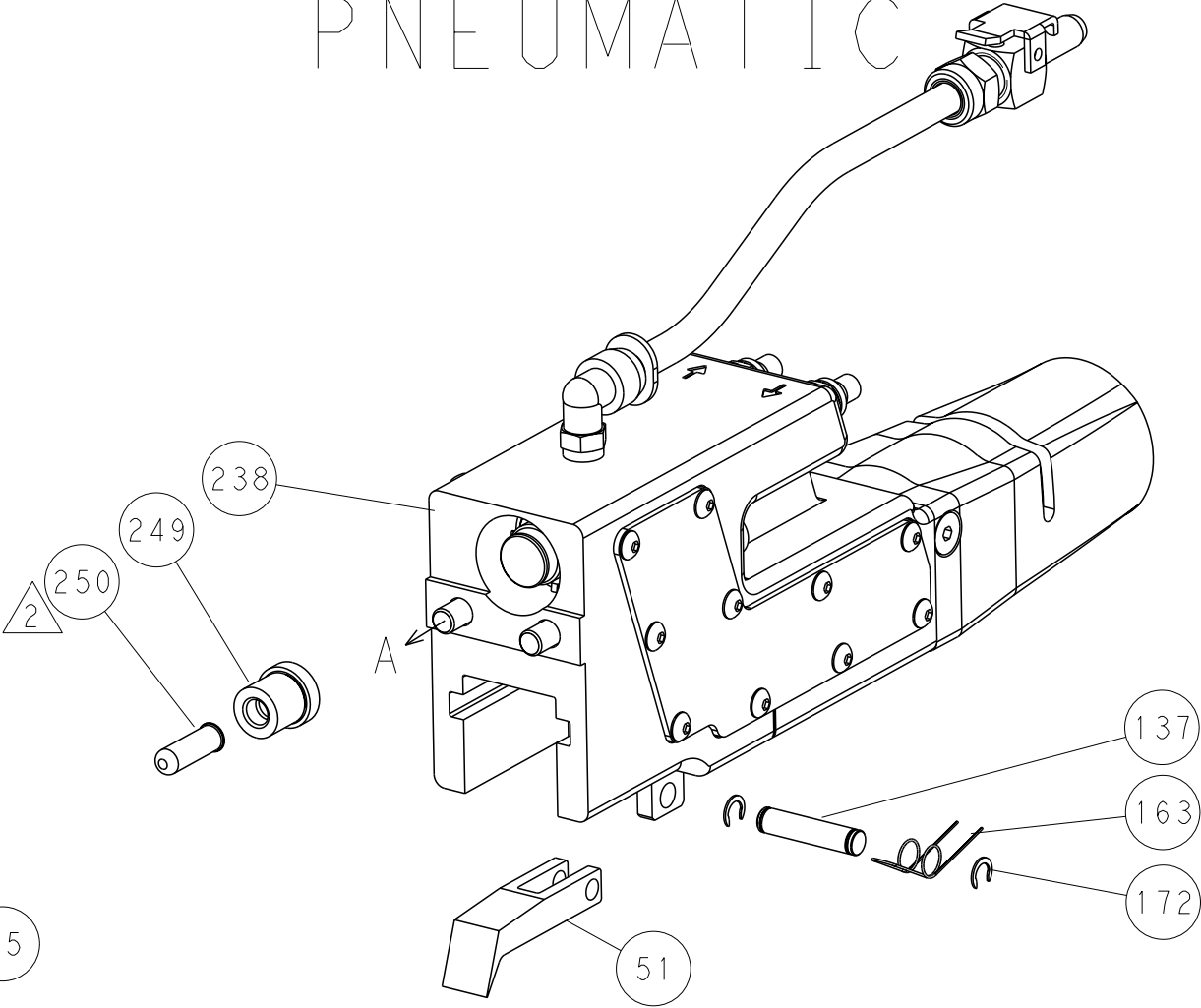
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



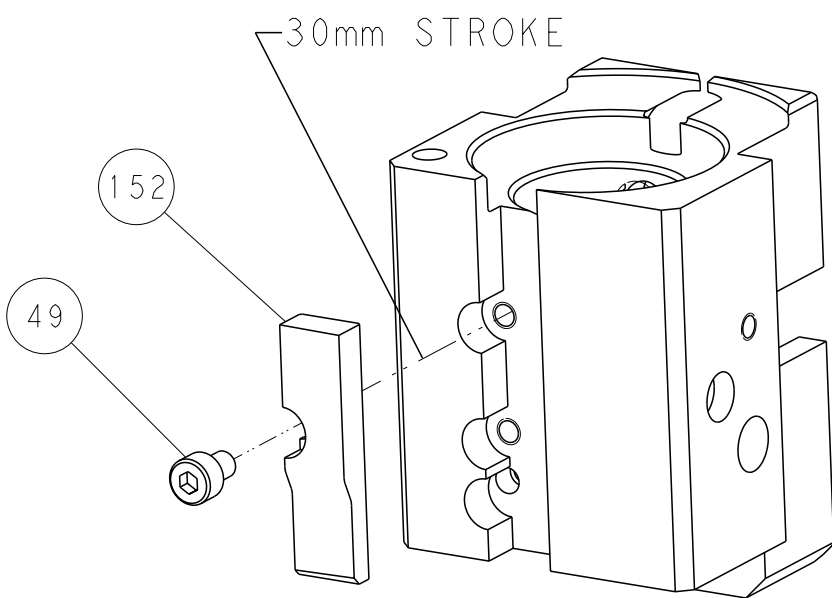
RAM AND HOLDDOWN SET-UP

FEED TYPE

PNEUMATIC



CAM POSITION



AIR FEED

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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				CHK G. BAILEY	10APRIL2015		
				APVD T. ELBIN	10APRIL2015	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2150544	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1		SHEET 4	
						OF 4	
						REV D	

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[2150544-2](#)