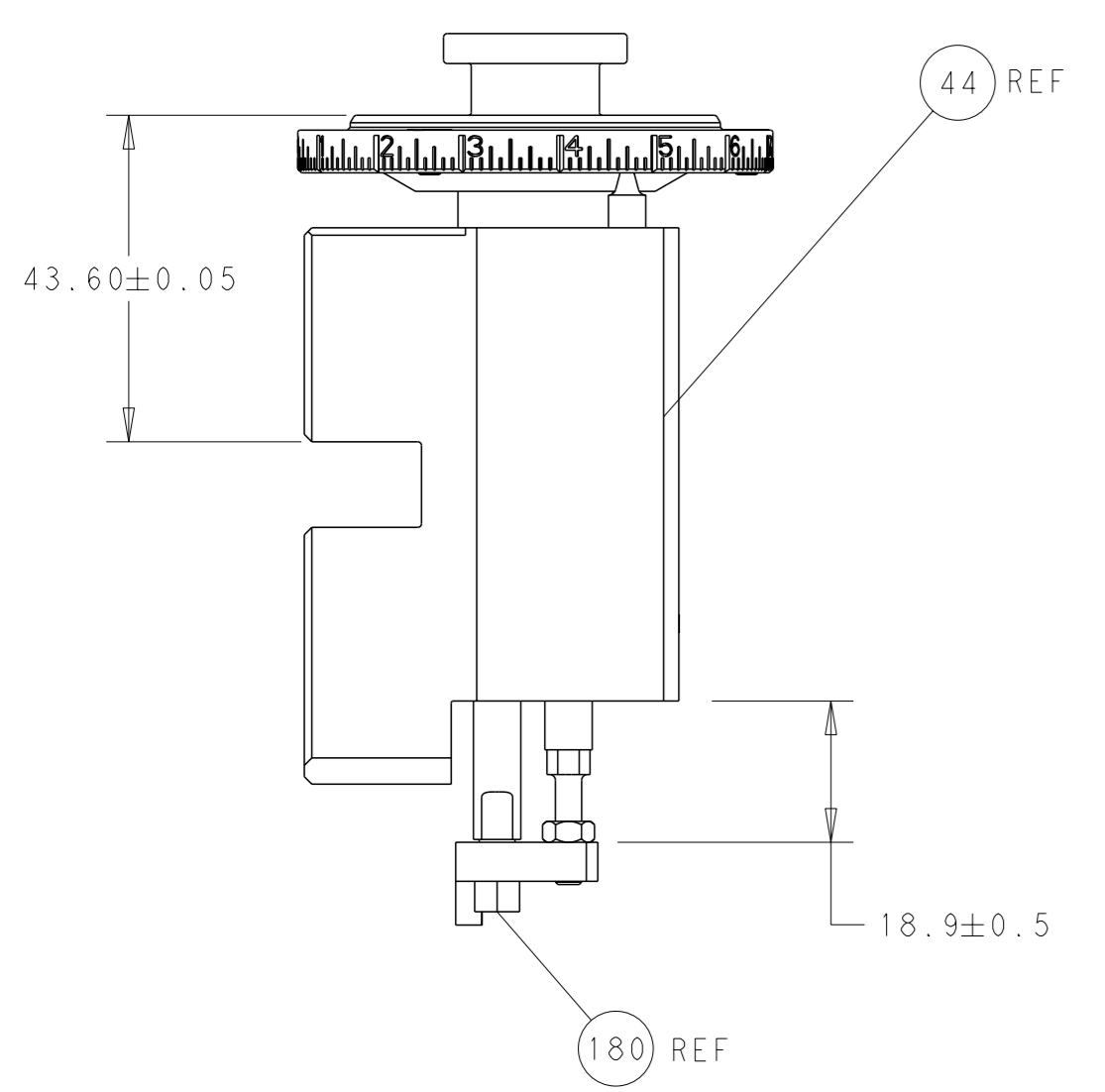
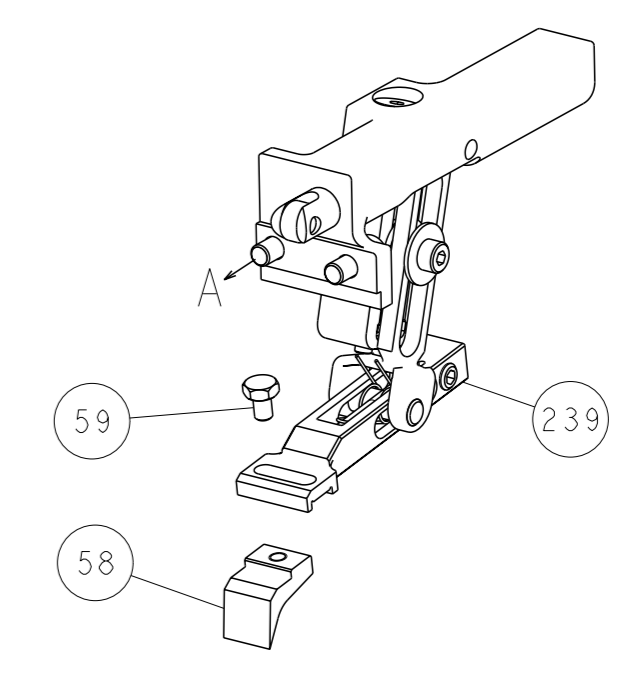


| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |

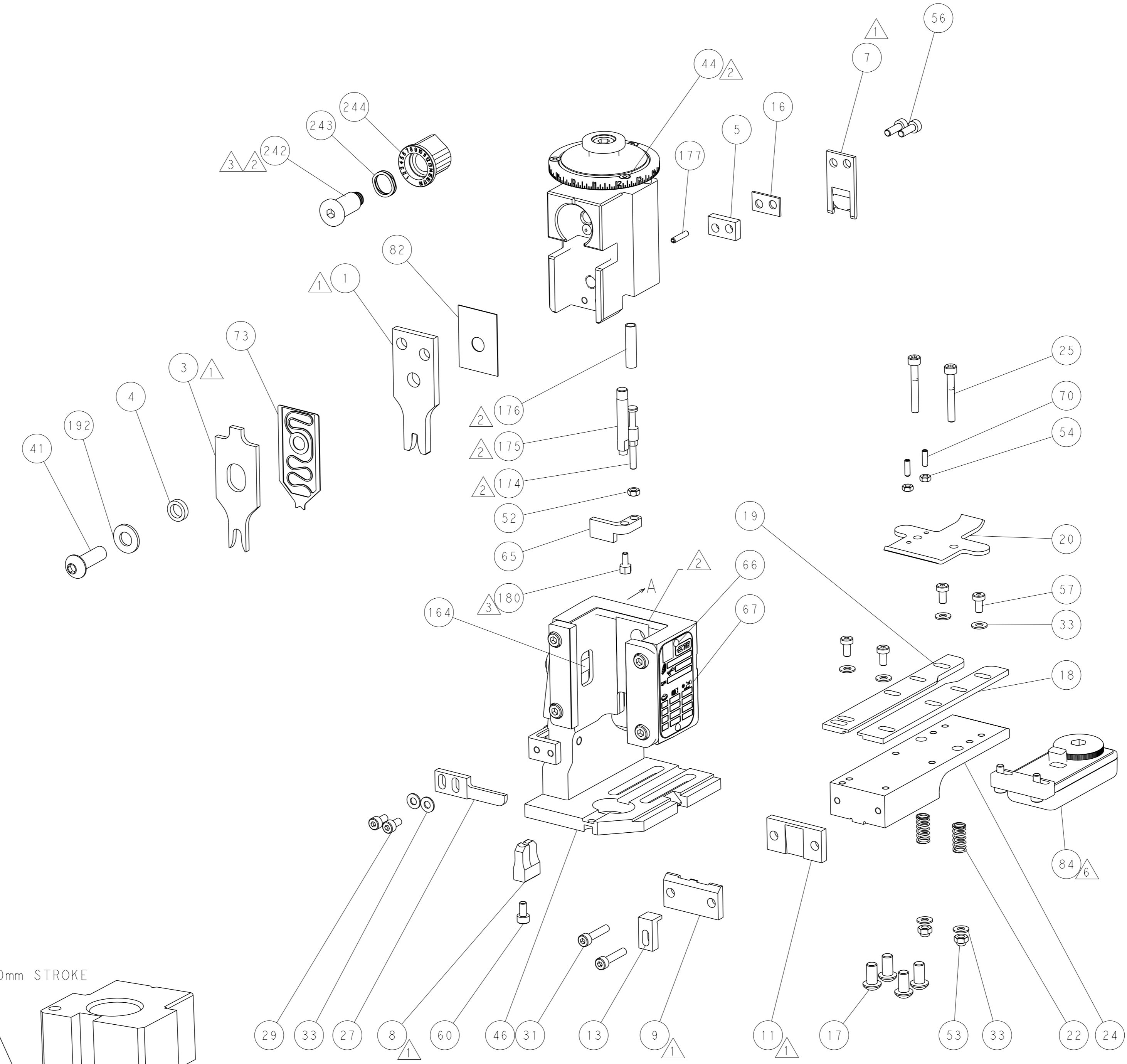
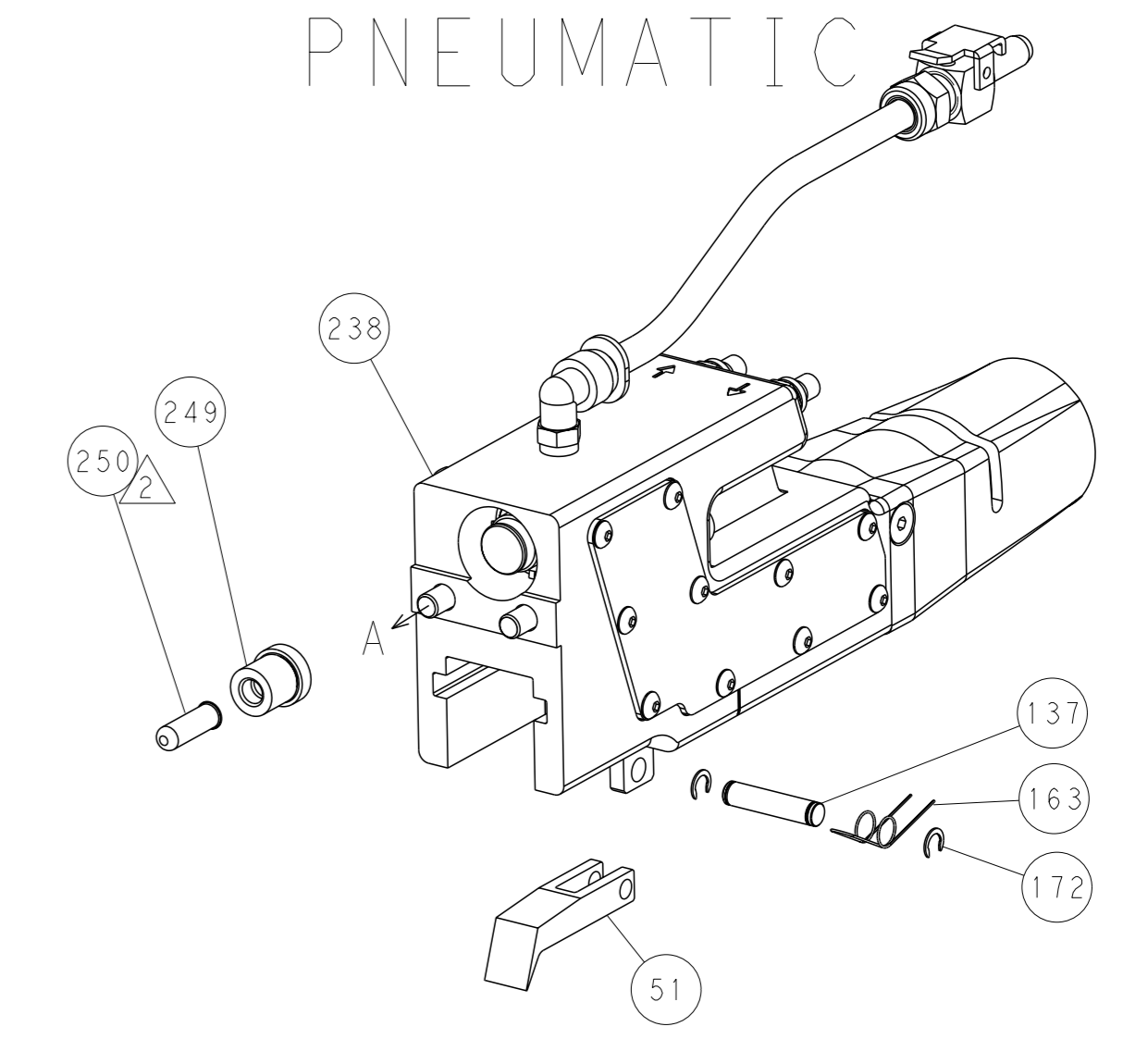


RAM AND HOLDDOWN SET-UP

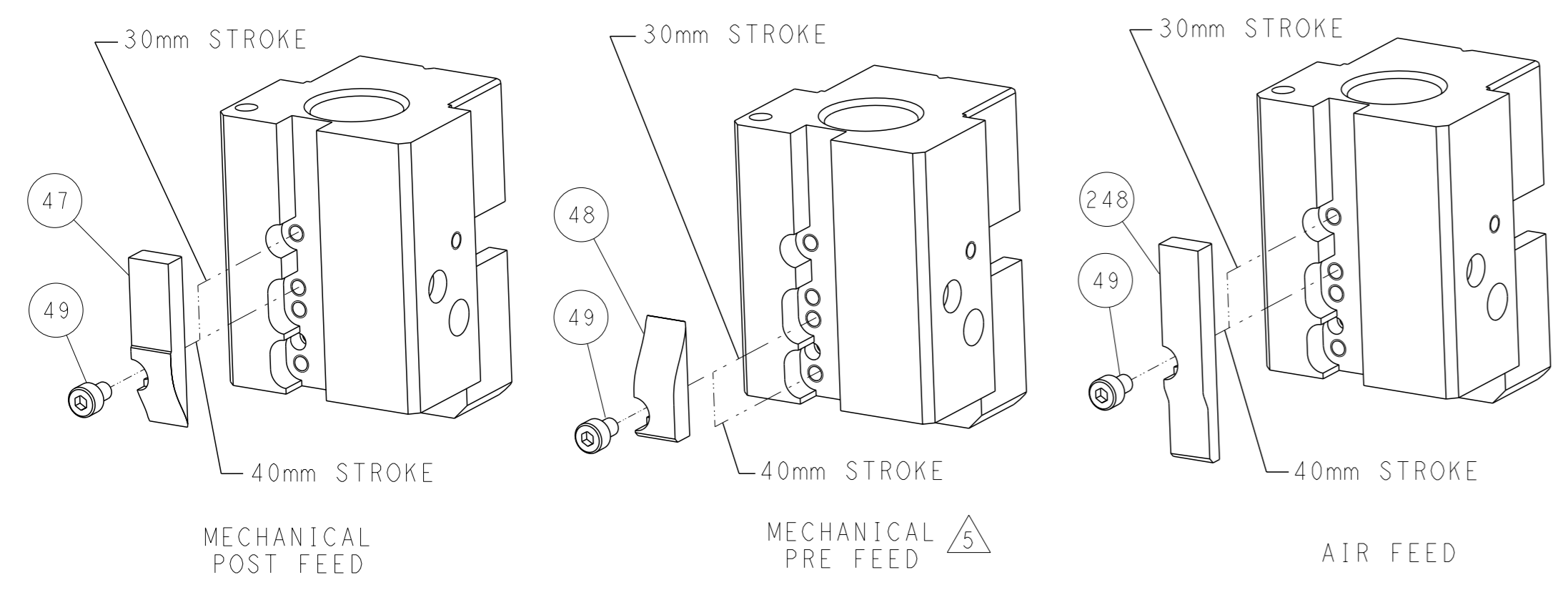
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

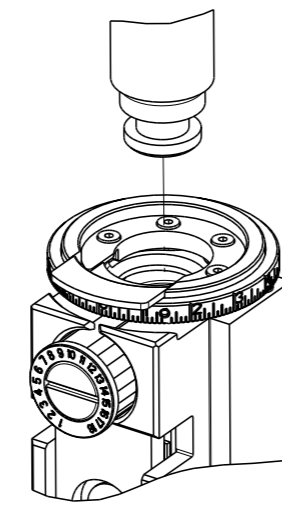


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | |
|---|--------------------------|--|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: J. HOU 14MAR2016 CHK: L. ZHANG 14MAR2016 APVD: H. GUO 14MAR2016 | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150653 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | WEIGHT: - MATERIAL: - | APPLICATION SPEC: - PRODUCT SPEC: - | RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: B | CUSTOMER DRAWING |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2150653-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2150653-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150653-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.56 mm [1.40] | F |
| INSUL | 5.59 mm [2.20] | O |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|--|-------------|
| TERMINAL NAME: RING TERMINAL | | | |
| WIRE STRIP LENGTH 5.56-6.32 mm [1.219-.249 IN] | | INSULATION DIAMETER RANGE Ø3.30-4.32 mm [1.130-.170 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-2084 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 63698-1 | 61624-1 | 61624-3 | 1217996-1 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 12 AWG | 2.49+/-0.05 [1.098+/-0.002] | 5.6 |
| 2X 16 AWG | 2.36+/-0.05 [1.093+/-0.002] | 7.3 |
| 14 AWG | 2.24+/-0.05 [1.088+/-0.002] | 8.8 |
| 16 AWG | 2.06+/-0.05 [1.081+/-0.002] | 10.8 |

- 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 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.
 - 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.

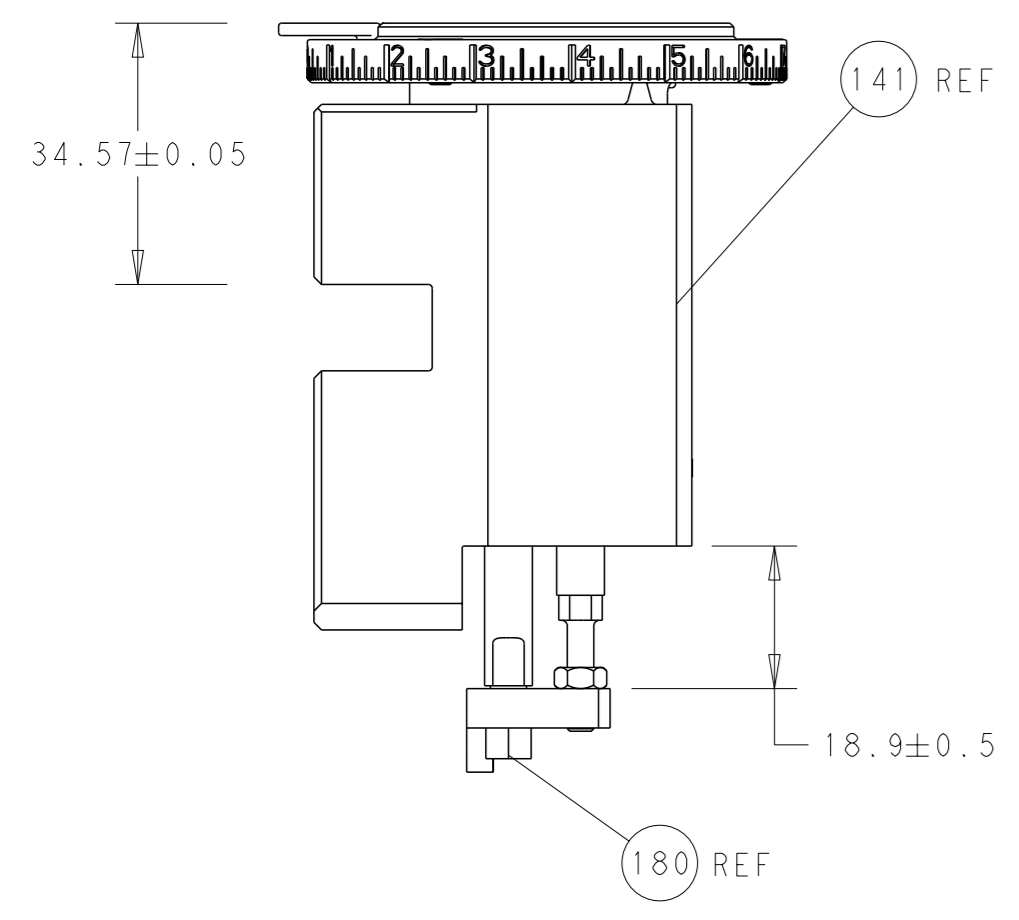
| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|-------------|----|------|
| A | 66 | REV | DATE | BY | APPV |
| - | - | 1 | SEE SHEET 1 | - | - |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | 1 | 1 | 1803259-1 | BUSHING, FLANGED | 249 |
| - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 3 | - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 2063440-1 | 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 |
| 3 | - | 1 | 1752354-1 | 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 |
| - | 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 | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| 6 | - | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1 | 455888-4 | 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 |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | 1 | 2063961-1 | FEED FINGER | 58 |
| - | 4 | 4 | 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 | - | 2119792-2 | PAWL, EF, AIR | 51 |
| - | 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 |
| - | 8 | 8 | 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 |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1803292-4 | DRAG | 20 |
| - | 1 | 1 | 1-1901696-5 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1-1901695-5 | STRIP GUIDE, FRONT | 18 |
| - | 1 | 1 | 5-240641-4 | SPACER | 16 |
| - | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 |
| 1 | - | 1 | 240644-9 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | 10 |
| 1 | - | 1 | 6-690482-8 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1 | 4-1803059-3 | ANVIL, COMBINATION, END FEED | 8 |
| 1 | - | 1 | 2217206-6 | BLADE, SLUG | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 240641-3 | SPACER | 5 |
| - | 1 | 1 | 6-238011-9 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 4-1803018-8 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | 2 |
| 1 | 1 | 1 | 456411-1 | CRIMPER, WIRE PREMIUM | 1 |
| - | - | - | - | - | 1 |

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

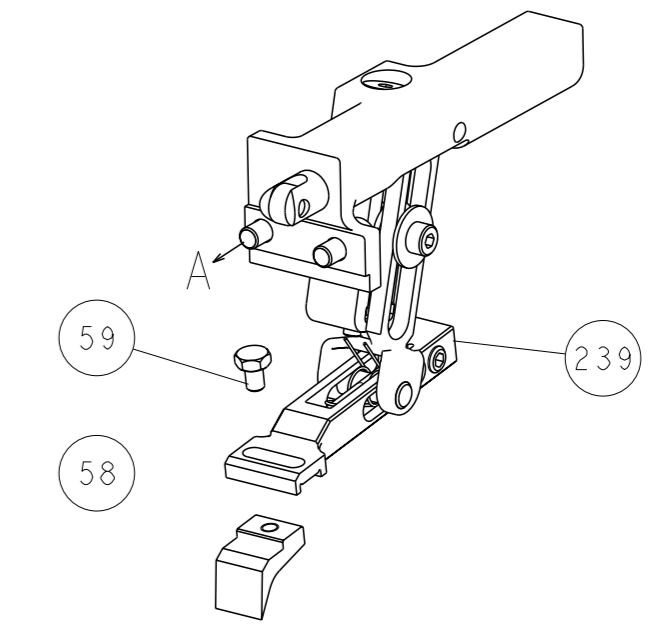
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|------------------|---------|--|---------|--------------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| ANGLES | FINISH | | SCALE | | |
| MATERIAL | FINISH | | SCALE | | |
| CUSTOMER DRAWING | | SCALE | | SHEET 3 OF 4 | |

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

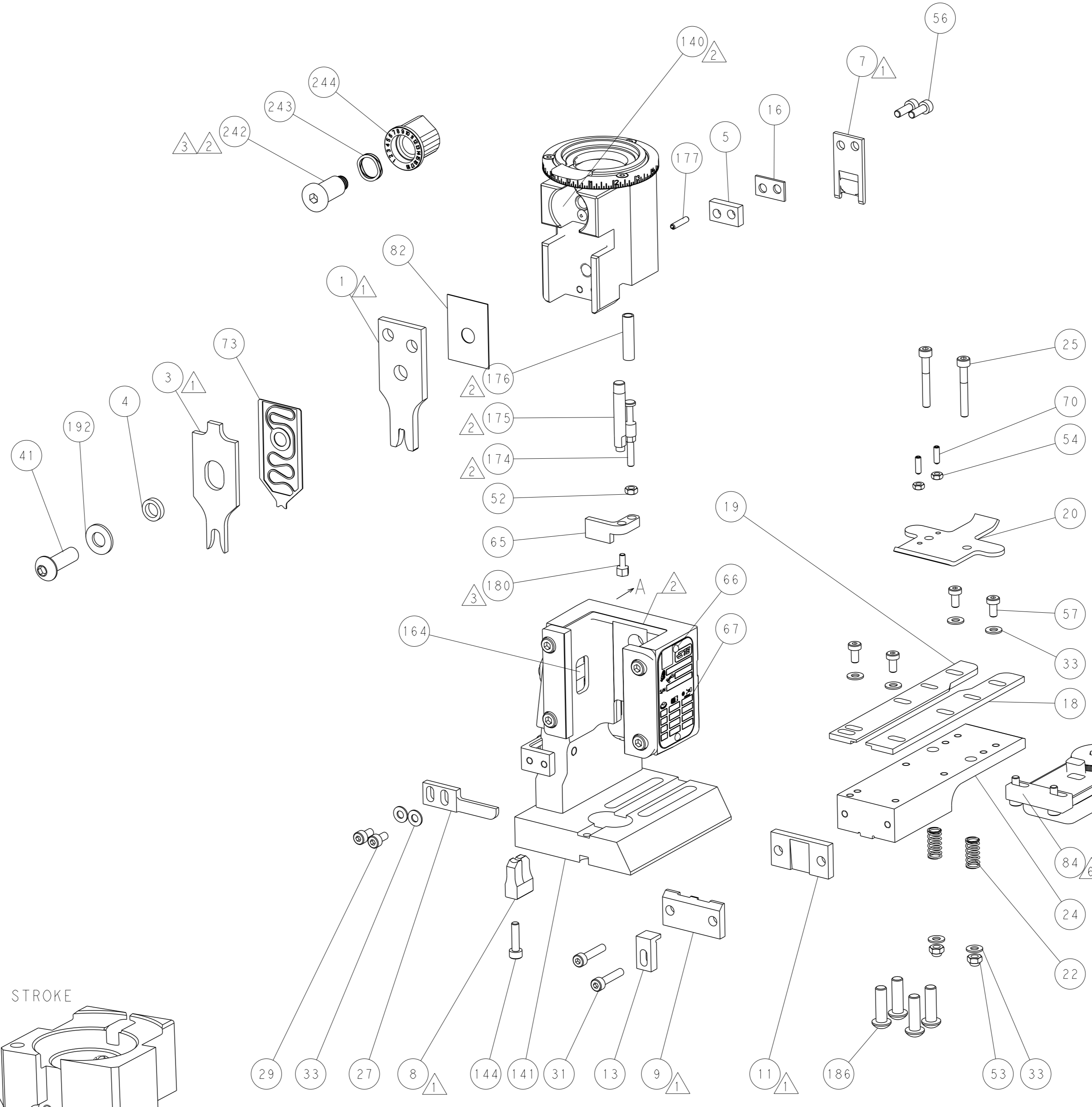
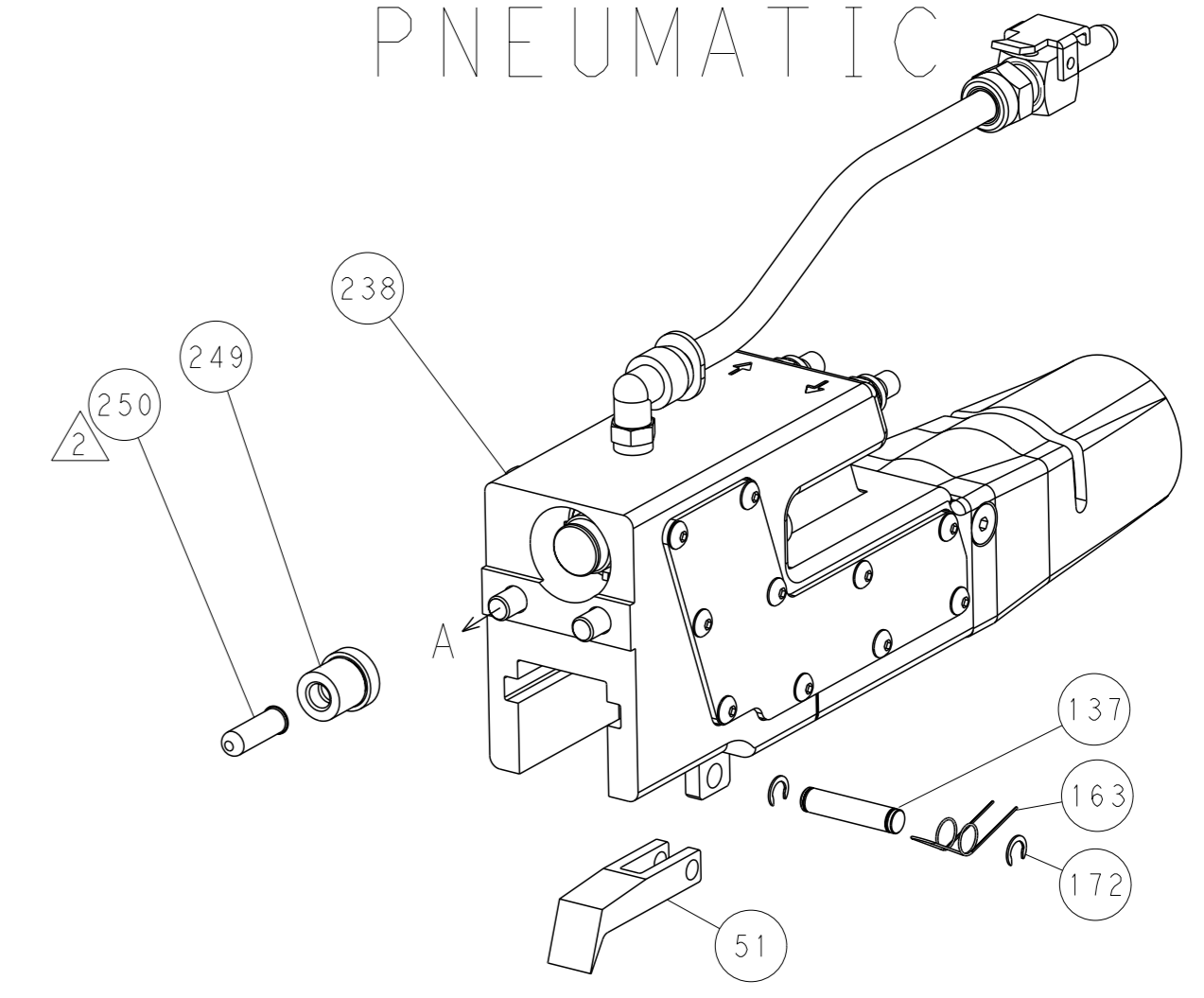


RAM AND HOLDDOWN SET-UP

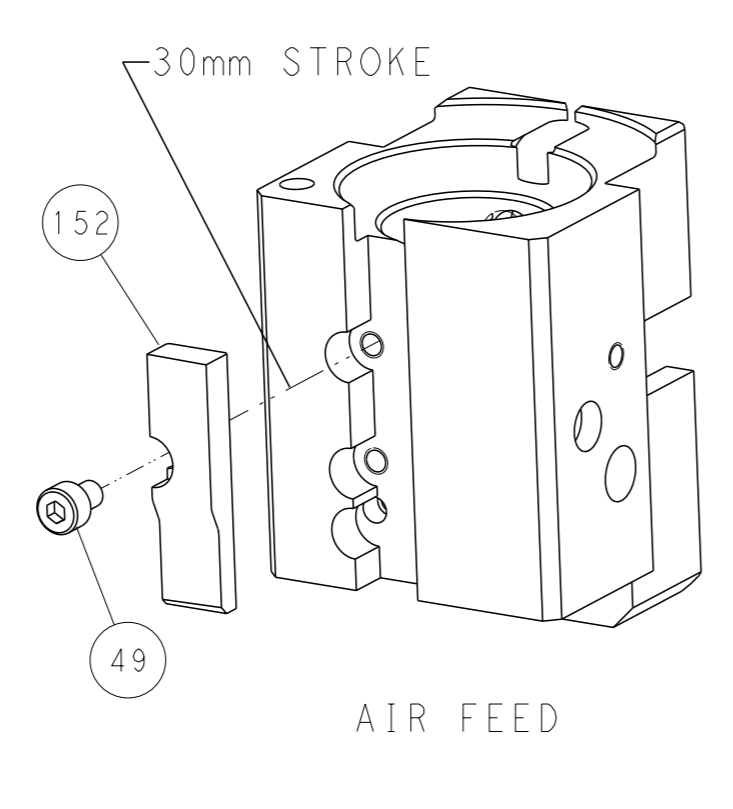
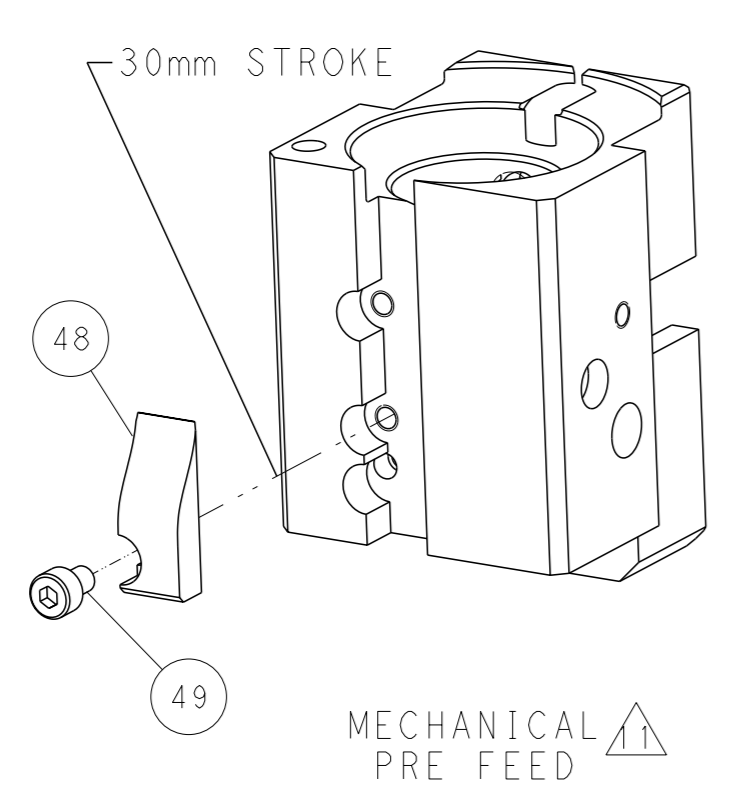
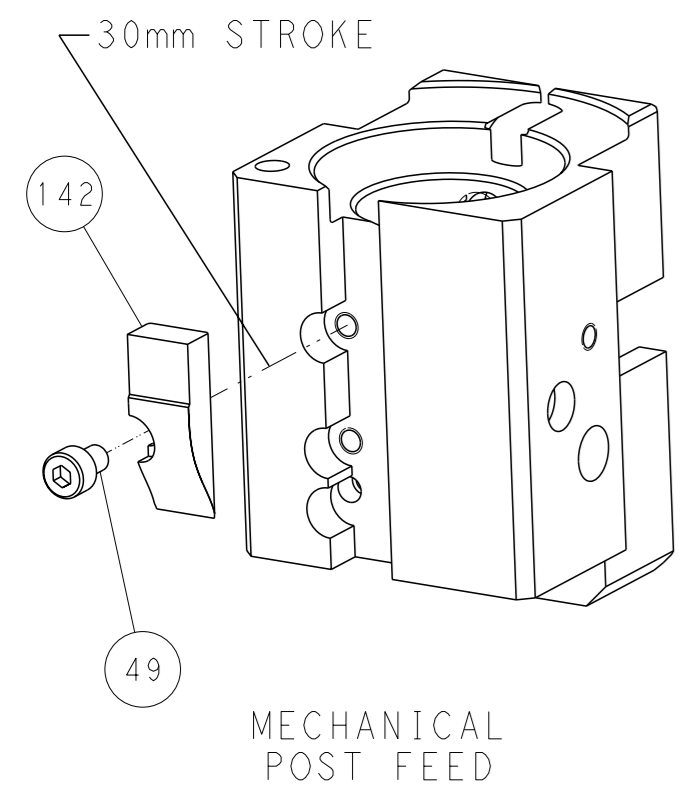
FEED TYPE
MECHANICAL



PNEUMATIC



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | OWN J. HOU 14MAR2016 CHK L. ZHANG 14MAR2016 APVD U. GUO 14MAR2016 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING | | NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150653 SCALE 1:1 SHEET 4 OF 4 REV B | | RESTRICTED TO | |
| THE DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION. | | | | STE TE Connectivity Harrisburg, PA 17105-3608 | | SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION | | | |

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