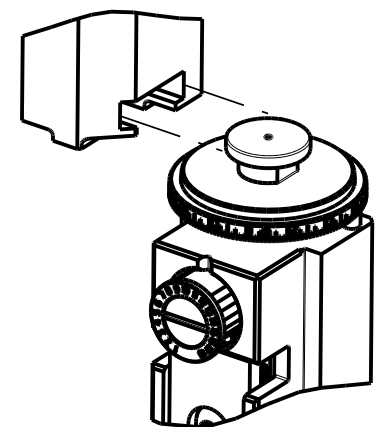


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150408-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-

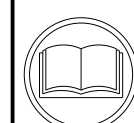
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.00 mm [.197]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 3.2ø CLUSTER REC. "L" TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-8.70 mm [.303-.343 IN]		∅2.20-3.20 mm [.087-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5215		
TERMINALS APPLIED <sup>5</sup> / <sub>6</sub>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.104ø+1.104ø+0.97ø	2.12+/-0.05 [.083+/- .002]	6.2
0.97ø+0.97ø+0.87ø	1.97+/-0.05 [.078+/- .002]	8.2
1.02ø+1.02ø	1.84+/-0.05 [.072+/- .002]	9.7
0.92ø+0.72ø	1.70+/-0.05 [.067+/- .002]	11.0



- 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 ITEM 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.

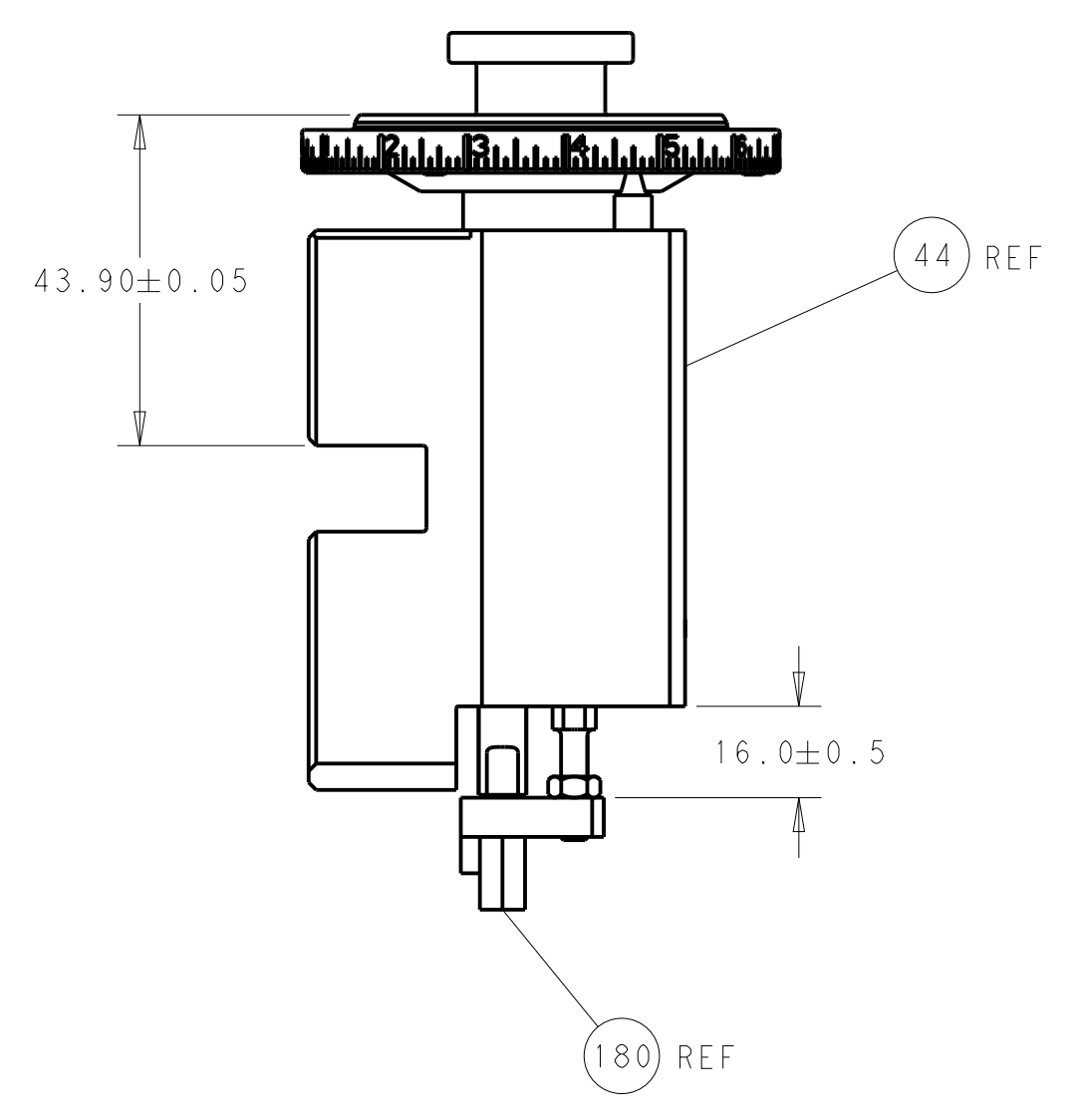
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
		REV	DATE	BY	CHK
A	66	B	19SEP2018	FZ	KZ
		C	11JUN2019	LG	TE
		D	01NOV2019	MZ	YY
		E	20MAY2021	FZ	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	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
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	2-1752354-3	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
6	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-4	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	4-1901681-5	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	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-1	FEED FINGER	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	690455-3	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	2-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	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	2-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	240833-6	PLATE, REAR SHEAR	11
1	-	2	2	7-240645-4	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1-240641-0	SPACER	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	1	409414-3	CRIMPER, WIRE	1
-	77-72	-	2	PART NO	DESCRIPTION	ITEM NO

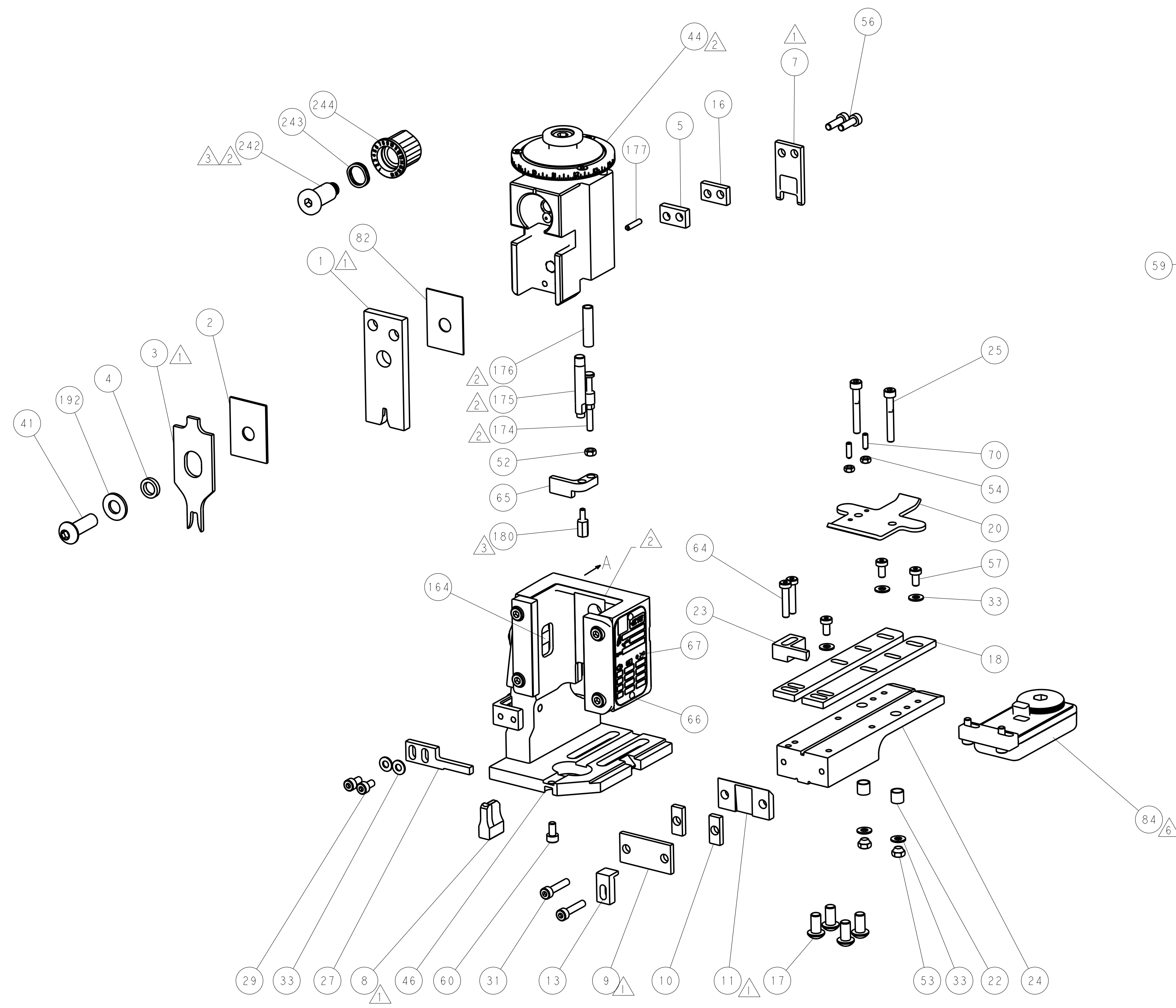
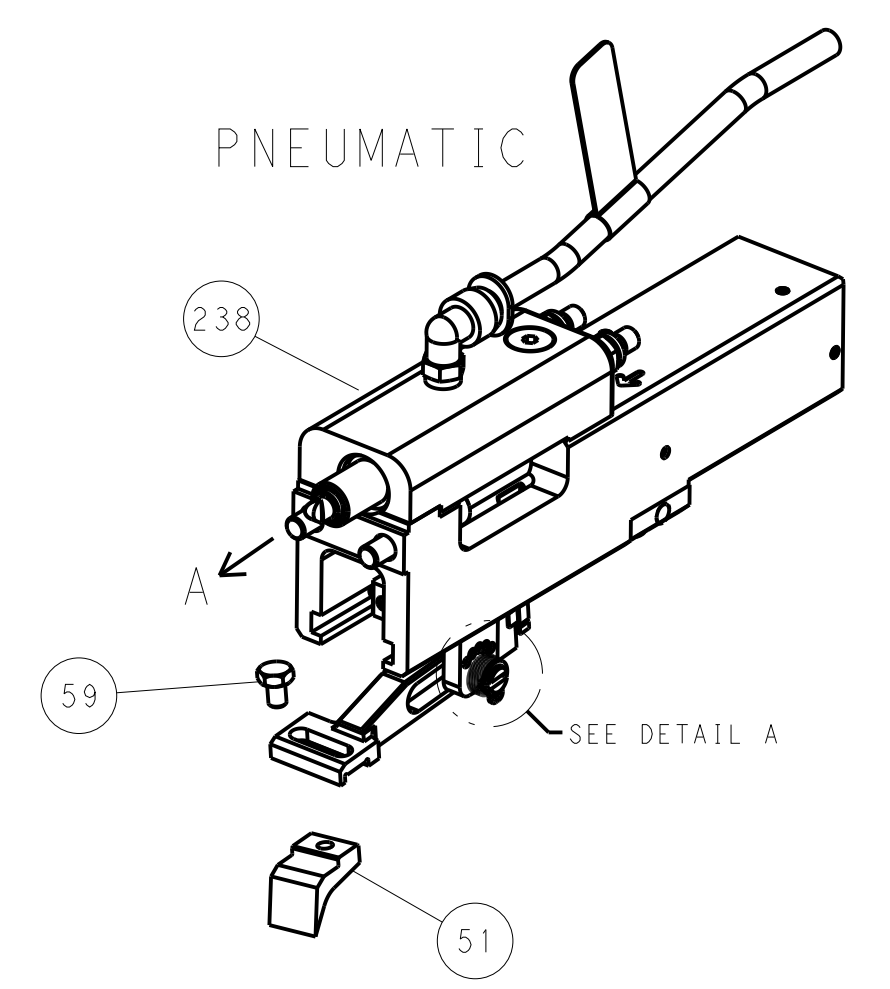
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	ANGLES ±	FINISH ±				L. ZHAO	14JAN2014	T. ELBIN	Harrisburg, PA 17105-3608
						L. ZHANG			Ocean End Feed Applicator
									SIZE CAGE CODE DRAWING NO RESTRICTED TO
									A1 00779 C=2150408
									Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV E

LOC	DIST	REV	DATE	BY	APPV
A	66				

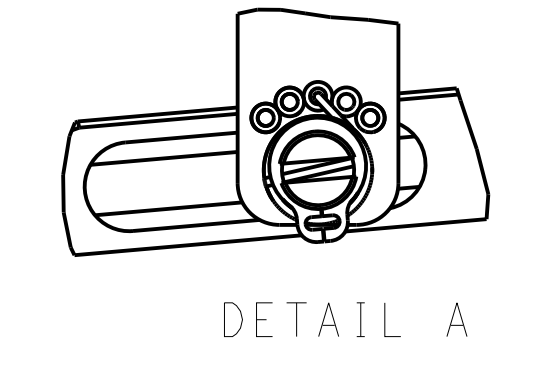


RAM AND HOLDDOWN SET-UP

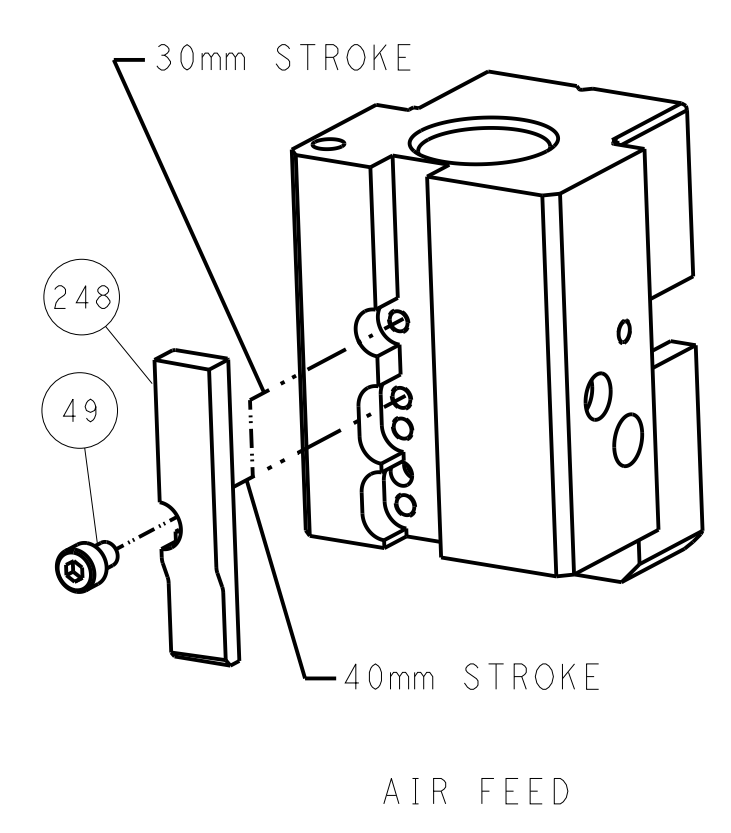
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

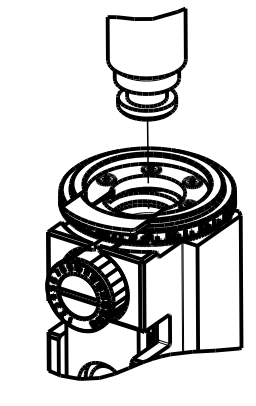


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN X.ZHAO 14JAN2014 CHK L.ZHANG 14JAN2014 APVD T.FLRIN 14JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150408		RESTRICTED TO: - SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150408-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	5.00 mm [1.971]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 3.2ø CLUSTER REC. "L" TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-8.70 mm [1.303-.343 IN]		∅2.20-3.20 mm [1.087-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5215		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.104ø+1.104ø+0.97ø	2.12+/-0.05 [1.083+/-0.002]	6.2
0.97ø+0.97ø+0.87ø	1.97+/-0.05 [1.078+/-0.002]	8.2
1.02ø+1.02ø	1.84+/-0.05 [1.072+/-0.002]	9.7
0.92ø+0.72ø	1.70+/-0.05 [1.067+/-0.002]	11.0



- 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 ITEM 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.

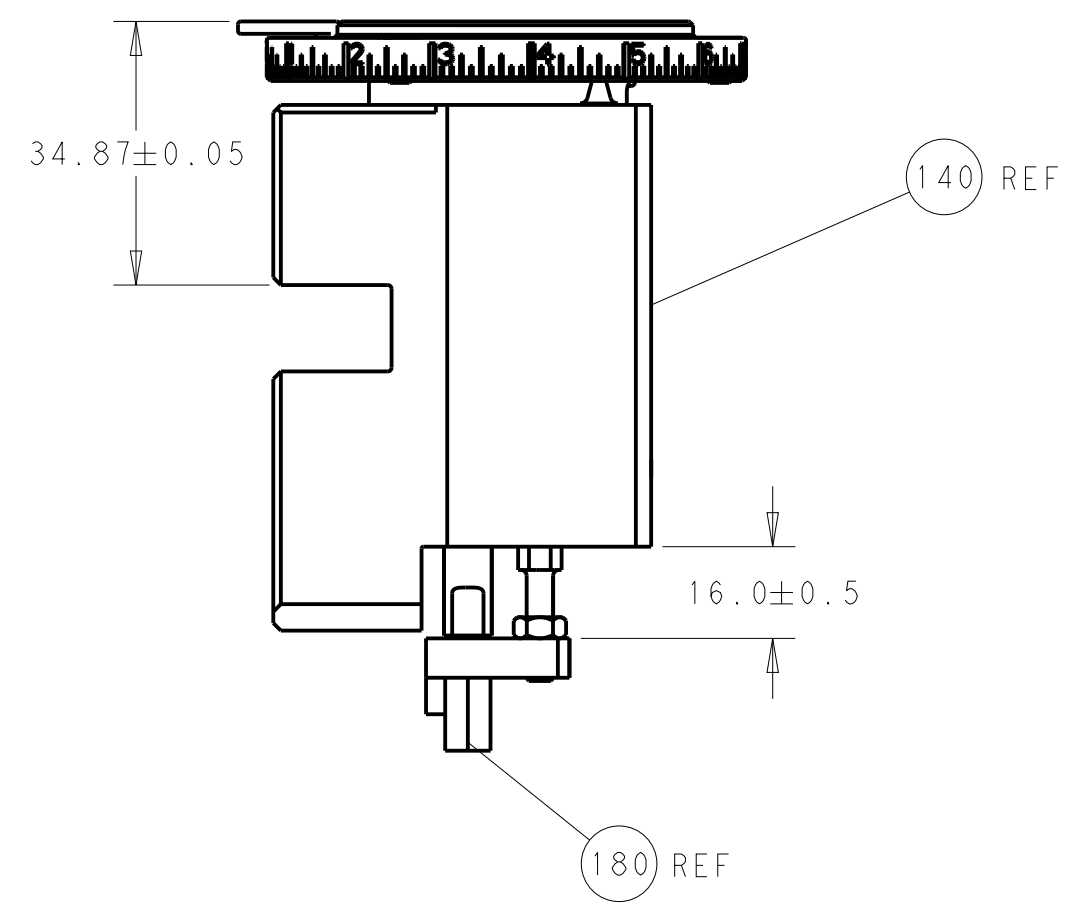
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	2-1752354-3	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
-	REF	994970-2	COUNTER, MAGNETIC	164
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	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	4-1901681-5	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
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-1	FEED FINGER	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	690455-3	STRIPPER, FRONT CASTING	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	2-240641-4	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240833-6	PLATE, REAR SHEAR	11
-	2	7-240645-4	SPACER, SHEAR PLATE	10
-	1	240642-1	PLATE, FRONT SHEAR	9
1	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
-	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	6
-	1	1-240641-0	SPACER	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1-455888-0	SPACER, CRIMPER	2
1	1	409414-3	CRIMPER, WIRE	1

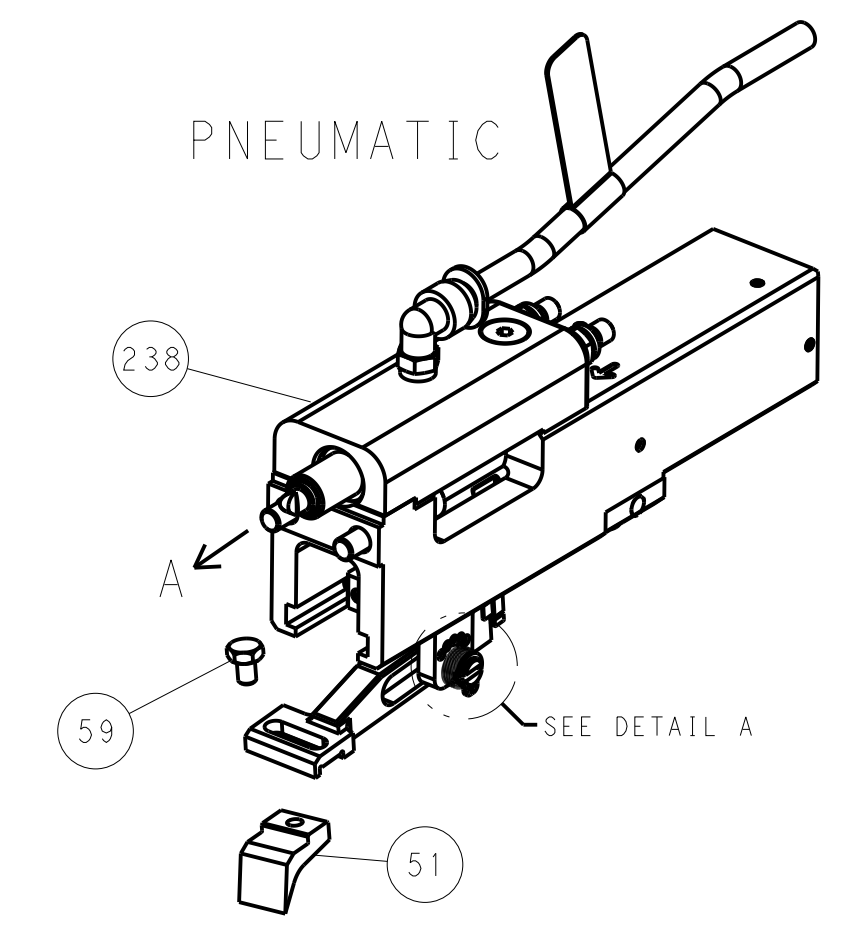
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	CHK	14JAN2014	TE Connectivity	Harrisburg, PA 17105-3608
	FINISH	OTHERWISE SPECIFIED:				APPV	14JAN2014	Ocean End Feed	Applicator
MATERIAL						SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
						A1	00779	2150408	Customer Accessible Production Drawing
						SCALE	1:1	SHEET 3 OF 4	REV E

LOC	DIST	REV	DATE	BY	APPV
A	66				

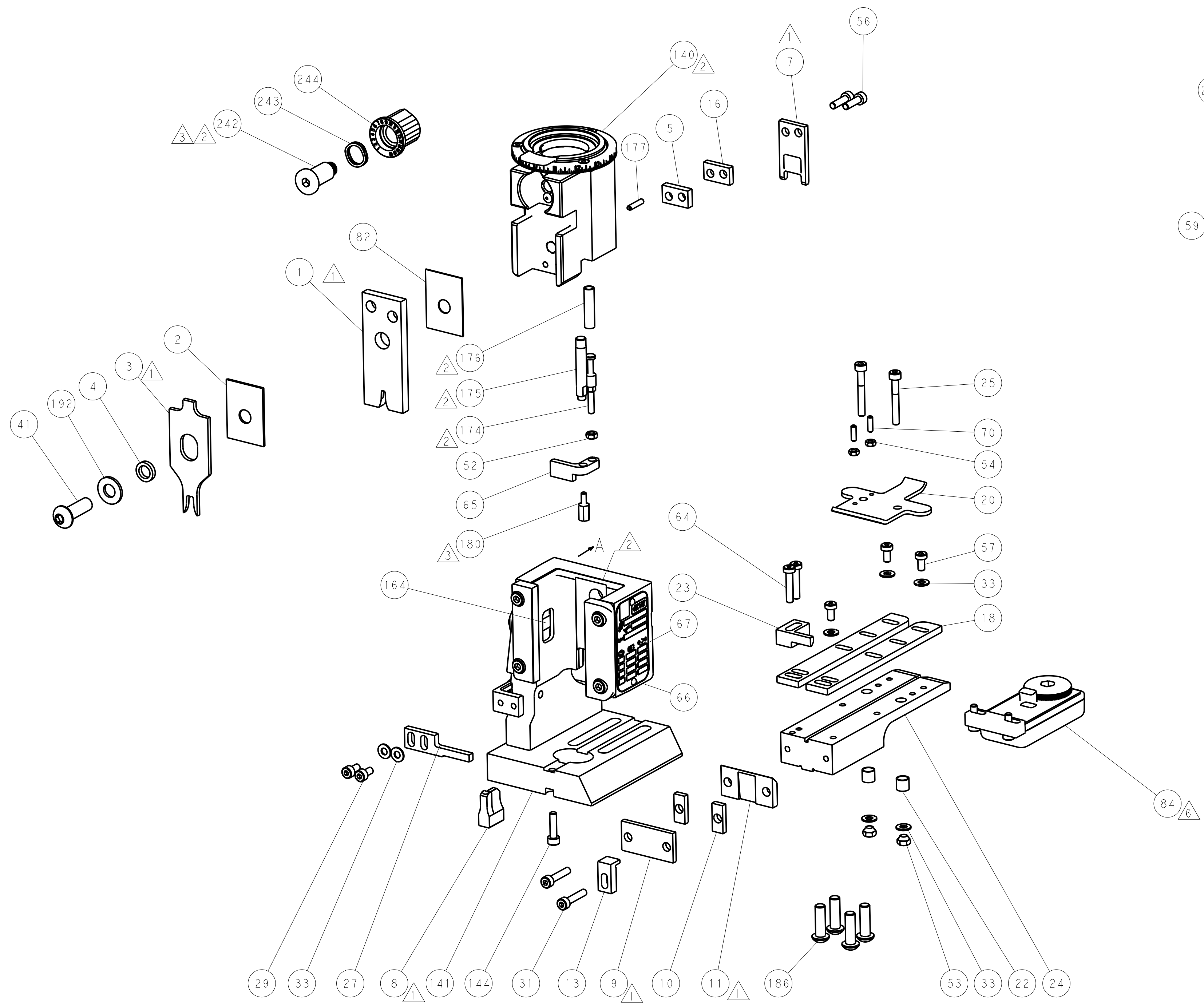
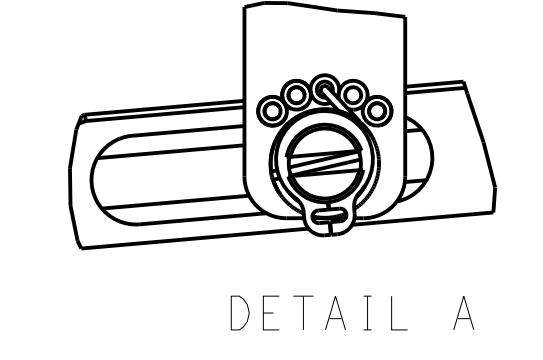


RAM AND HOLDDOWN SET-UP

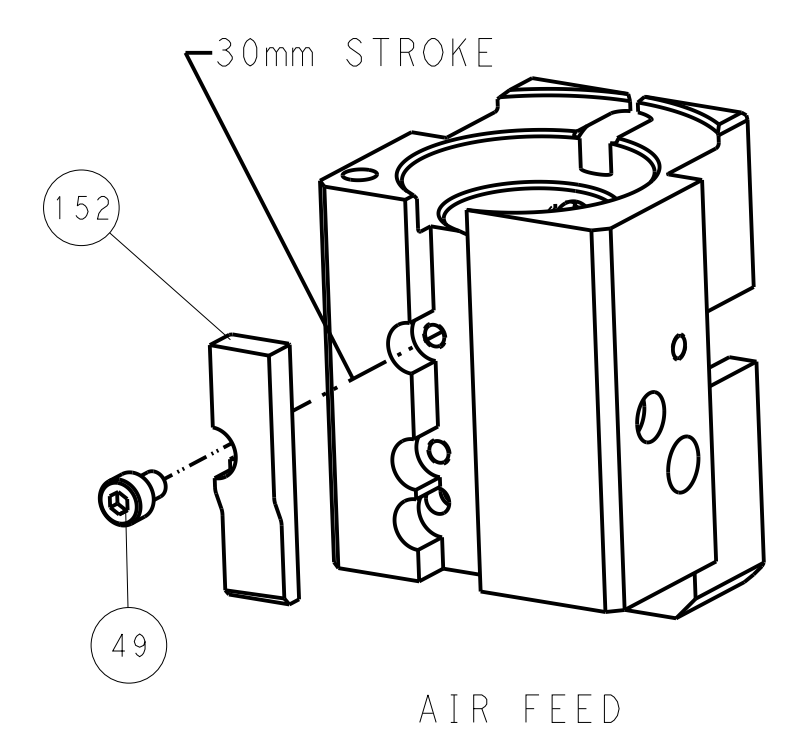
FEED TYPE



FEED SPRING SETTING POSITION



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150408 SHEET 4 OF 4 REV E
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	

# Mouser Electronics

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