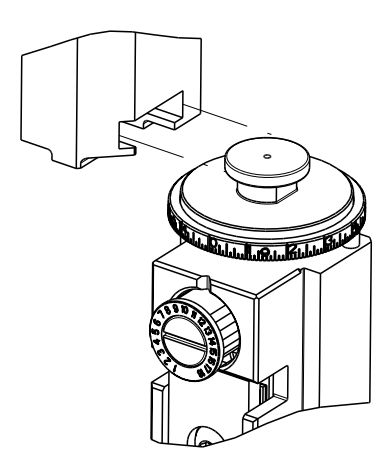


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150005-2 | N | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150005-2 | N | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150005-7 | K | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.06 mm [1.160] | F |
| INSUL | 5.33 mm [1.210] | OV |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: RINGTONGUE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.00-5.50 mm [1.97-.217 IN] | | ∅3.40-4.70 mm [1.34-.185 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18022 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 928927-4 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 4.00mm2 | 2.86 +/- 0.05 [1.113 +/- .002] | 7.0 |
| 3.50mm2 | 2.78 +/- 0.05 [1.109 +/- .002] | 8.0 |
| 3.00mm2 | 2.70 +/- 0.05 [1.106 +/- .002] | 8.9 |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

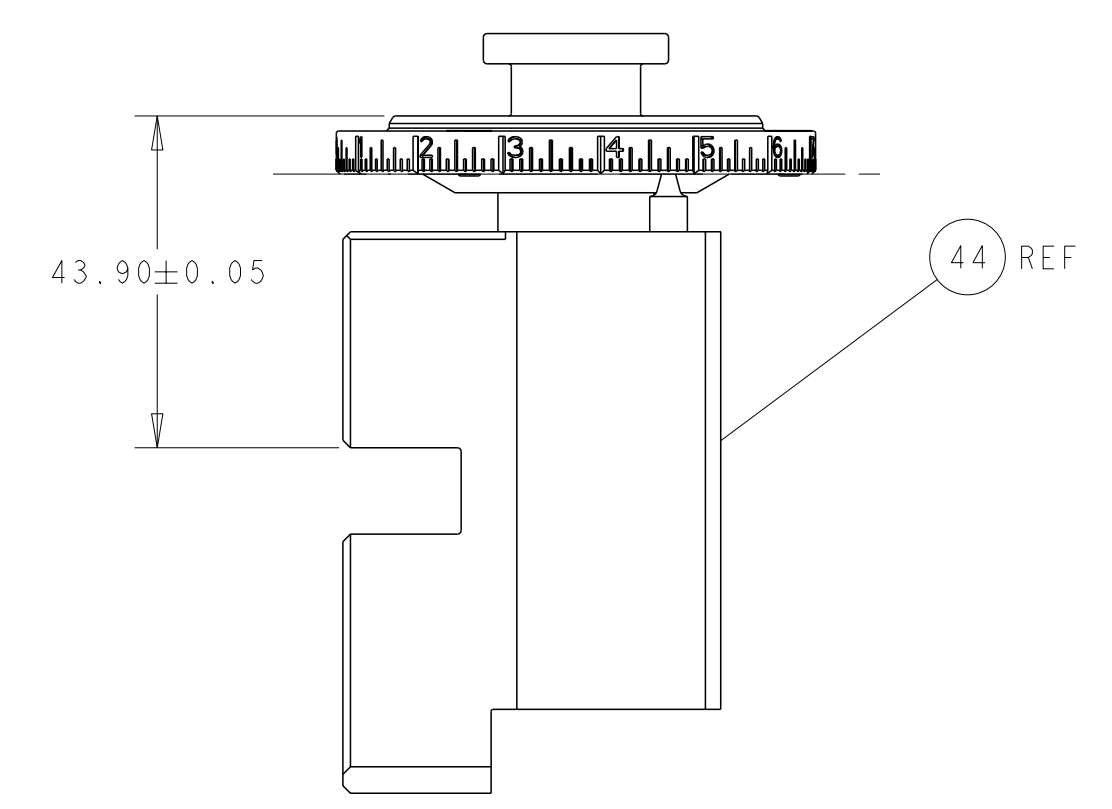
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LYH | DESCRIPTION | DATE | OWN | APVD |
| | | L | | ECR-18-014381 | 11SEP2018 | FL | TE |
| | | M | | ECR-19-013113 | 21AUG2019 | MZ | YY |
| | | N | | ECR-20-016388 | 18NOV2020 | FZ | TE |
| | | NI | | ECR-21-001531 | 04FEB2021 | JWC | GB |

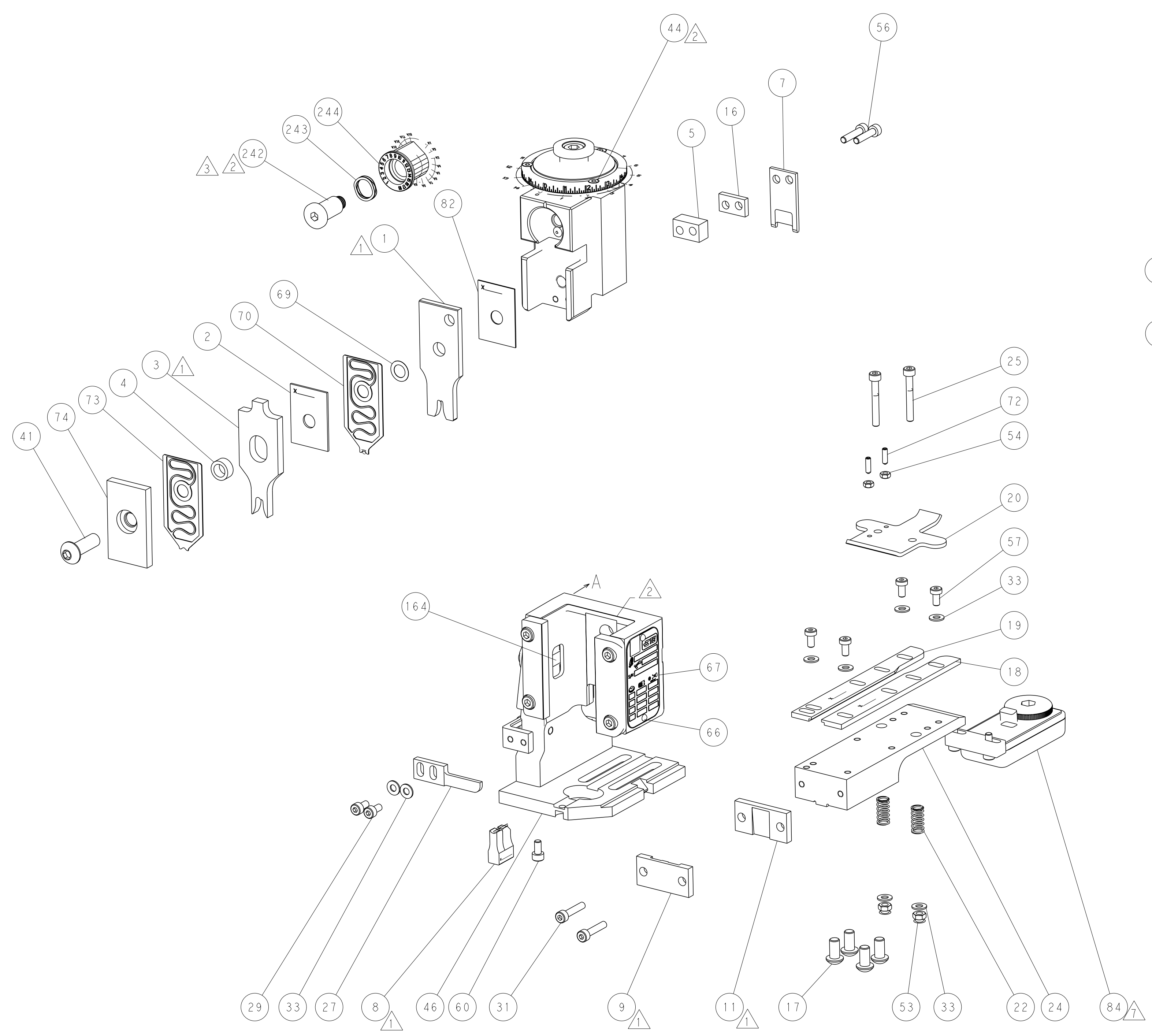
| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-------------------------------------|---------|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| | - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 2844940-4 | AIR FEED MODULE | 238 | |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| | - | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1803203-1 | BLOCK, FRONT DEPRESSOR | 74 | |
| - | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 73 | |
| - | 2 | 2 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 72 | |
| - | 1 | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 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 | 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 | |
| - | 4 | 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | |
| - | 2 | 2 | 2-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 18 | 56 | |
| - | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 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 | |
| - | 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 | 1-1901696-0 | STRIP GUIDE, REAR | 19 | |
| - | 1 | 1 | 1-1901695-0 | STRIP GUIDE, FRONT | 18 | |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 4-240641-6 | SPACER | 16 | |
| | - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | 10 | |
| | - | 1 | 1 | 7-690482-0 | PLATE, FRONT SHEAR | 9 |
| | 1 | 2 | 1 | 1333223-5 | ANVIL, COMBINATION | 8 |
| | - | 1 | 1 | 1-2217206-5 | BLADE, SLUG | 7 |
| - | 1 | 1 | 6-240641-0 | SPACER | 5 | |
| - | 1 | 1 | 5-238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| | 1 | 2 | 1 | 1803139-3 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 2 | |
| | 1 | 2 | 1 | 456414-9 | CRIMPER, WIRE | 1 |
| - | 77 | 72 | -2 | PART NO | DESCRIPTION | ITEM NO |

| | | | | | | | |
|-------------|--|--|--|--|--|-------------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG Y. YIN 01FEB2012 | | TE Connectivity | |
| mm | | 0 PLC ± | | CHK G. BAILEY 01FEB2012 | | Harrisburg, PA 17105-3608 | |
| | | 1 PLC ± | | APVD S. YI 01FEB2012 | | NAME | |
| | | 2 PLC ± | | PRODUCT SPEC | | Ocean End Feed | |
| | | 3 PLC ± | | APPLICATION SPEC | | Applicator | |
| | | 4 PLC ± | | SIZE | | CAGE CODE DRAWING NO | |
| | | ANGLES FINISH | | WEIGHT | | RESTRICTED TO | |
| | | | | A1 00779 | | ©=2150005 | |
| | | | | Customer Accessible Production Drawing | | SCALE 1:1 SHEET 1 OF 4 REV N1 | |

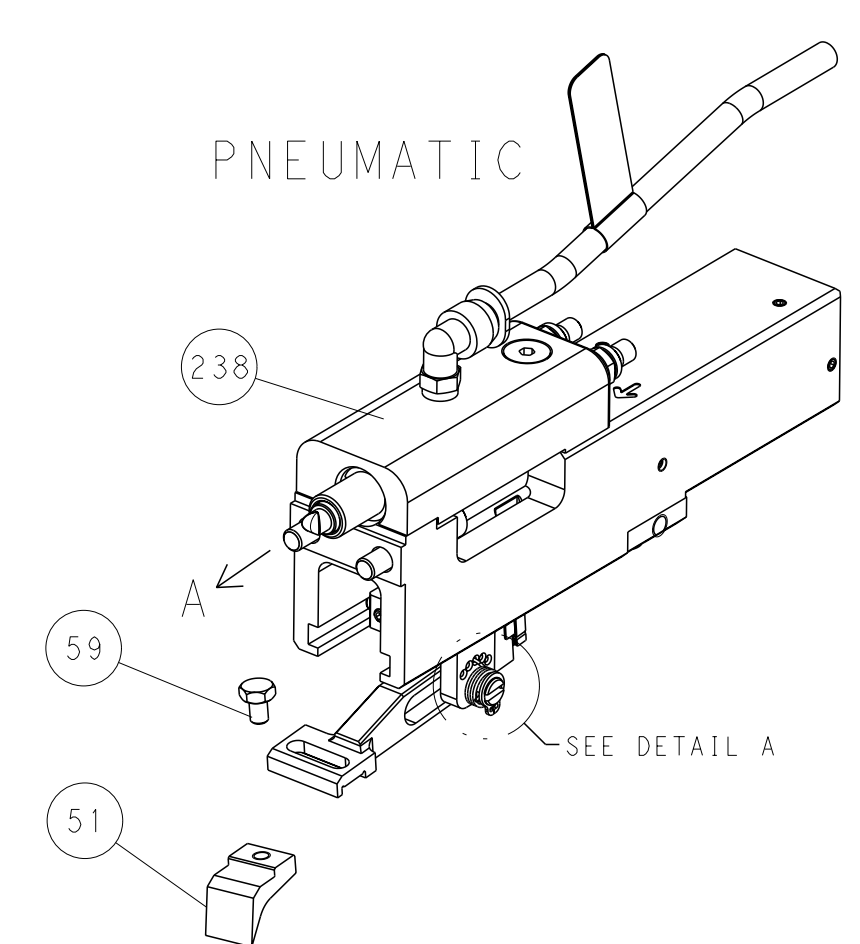
| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|-----|------|
| P | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | SEE SHEET 1 | - | - | - |
| | | | | | |
| | | | | | |



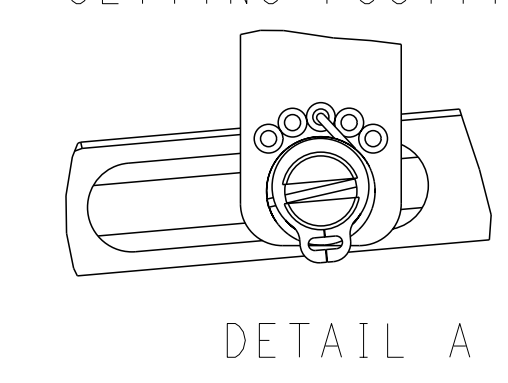
RAM SET-UP



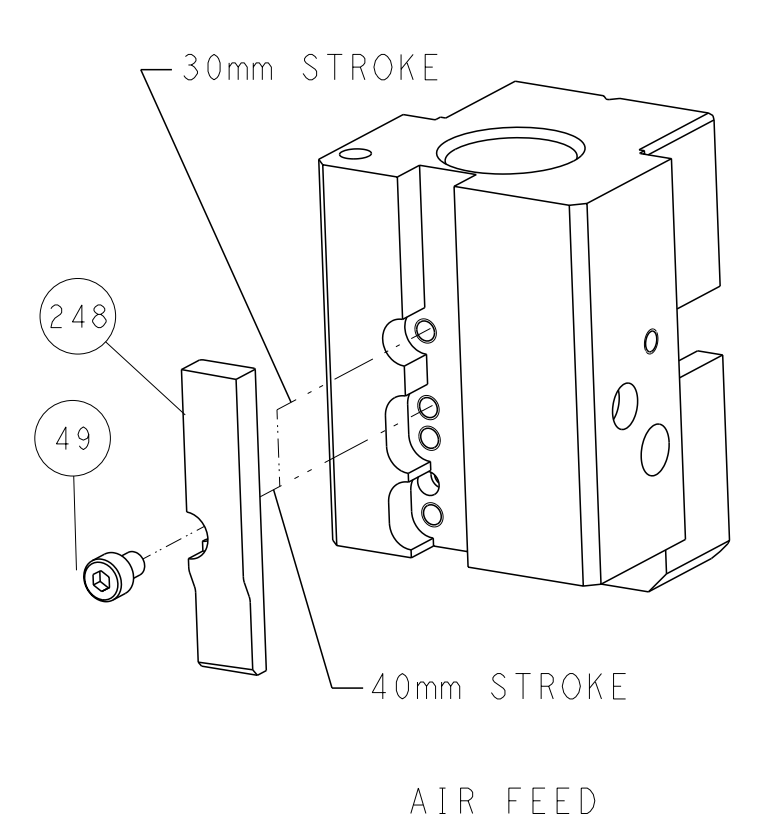
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

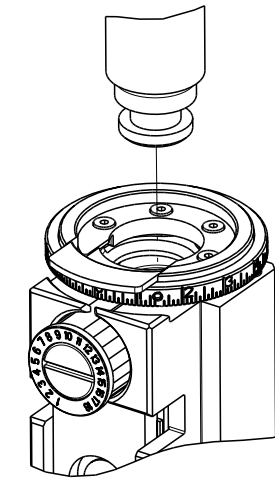


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | |
|--|--|---|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN Y.YIN 01FEB2012 CHK G.BAILEY 01FEB2012 APVD S.XI 01FEB2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH * | | NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1 | SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150005 SHEET 2 OF 4 REV N1 |
| MATERIAL: | | Customer Accessible Production Drawing | |

| THIS DRAWING IS UNPUBLISHED. | RELEASED FOR PUBLICATION | | |
|--|--------------------------|--------------------------|-----------|
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2150005-2 | N | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150005-7 | K | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.06 mm [1.60] | F |
| INSUL | 5.33 mm [2.10] | OV |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|---|-------------|
| TERMINAL NAME: RINGTONGUE | | | |
| WIRE STRIP LENGTH 5.00-5.50 mm [1.97-.217 IN] | | INSULATION DIAMETER RANGE Ø3.40-4.70 mm [1.34-.185 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18022 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 928927-4 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 4.00mm2 | 2.86 +/- 0.05 [1.13 +/- .002] | 7.0 |
| 3.50mm2 | 2.78 +/- 0.05 [1.09 +/- .002] | 8.0 |
| 3.00mm2 | 2.70 +/- 0.05 [1.06 +/- .002] | 8.9 |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

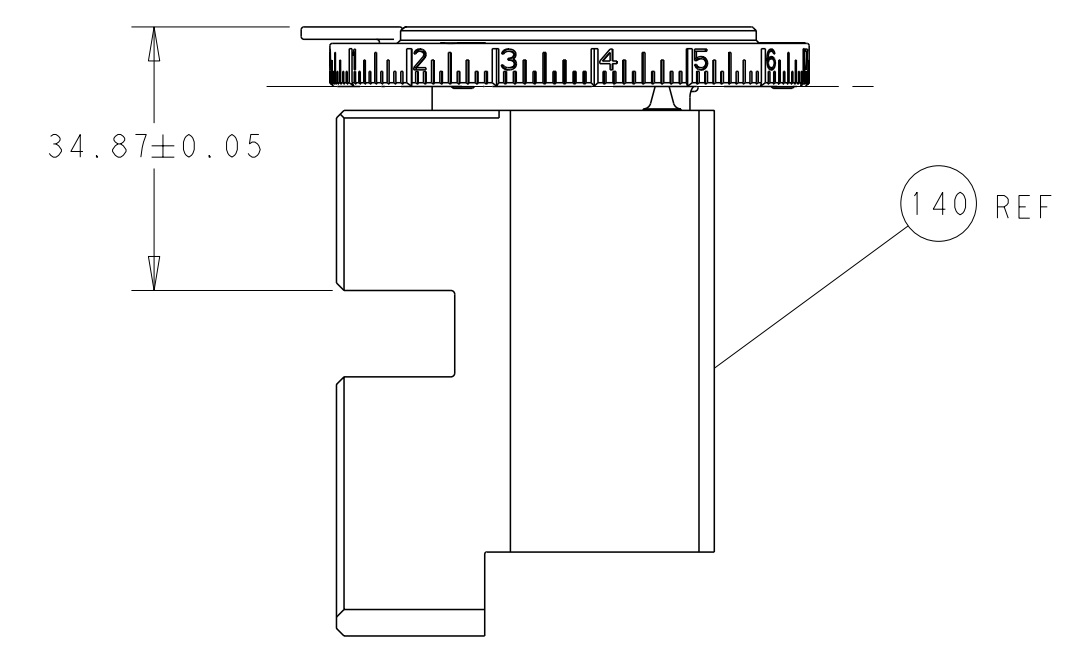
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

| REV | DATE | DESCRIPTION | DATE | BY | APPV |
|---------|-------------|-------------------------------------|---------|----|------|
| - 1 | 2119082-9 | 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 | | |
| - 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 | | |
| - 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 | 1803203-1 | BLOCK, FRONT DEPRESSOR | 74 | | |
| - 1 | 2119791-9 | DEPRESSOR, WIRE | 73 | | |
| - 2 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 72 | | |
| - 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 | | |
| - 1 | 2119791-5 | DEPRESSOR, WIRE | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | | |
| - 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | | |
| - 2 | 2-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 18 | 56 | | |
| - 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | | |
| - 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | | |
| - 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 | | |
| - 8 | 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 | | |
| - 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | | |
| - 1 | 1803292-4 | DRAG | 20 | | |
| - 1 | 1-1901696-0 | STRIP GUIDE, REAR | 19 | | |
| - 1 | 1-1901695-0 | STRIP GUIDE, FRONT | 18 | | |
| - 1 | 4-240641-6 | SPACER | 16 | | |
| - 1 | 240644-1 | PLATE, REAR SHEAR | 11 | | |
| - - | - | - | 10 | | |
| - 1 | 7-690482-0 | PLATE, FRONT SHEAR | 9 | | |
| 1 1 | 1333223-5 | ANVIL, COMBINATION | 8 | | |
| - 1 | 1-2217206-5 | BLADE, SLUG | 7 | | |
| - 1 | 6-240641-0 | SPACER | 5 | | |
| - 1 | 5-238011-4 | BLOCK, CRIMPER SPACER | 4 | | |
| 1 1 | 1803139-3 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 | | |
| - 1 | 1-455888-0 | SPACER, CRIMPER | 2 | | |
| 1 1 | 456414-9 | CRIMPER, WIRE | 1 | | |
| - 77-22 | PART NO | DESCRIPTION | ITEM NO | | |

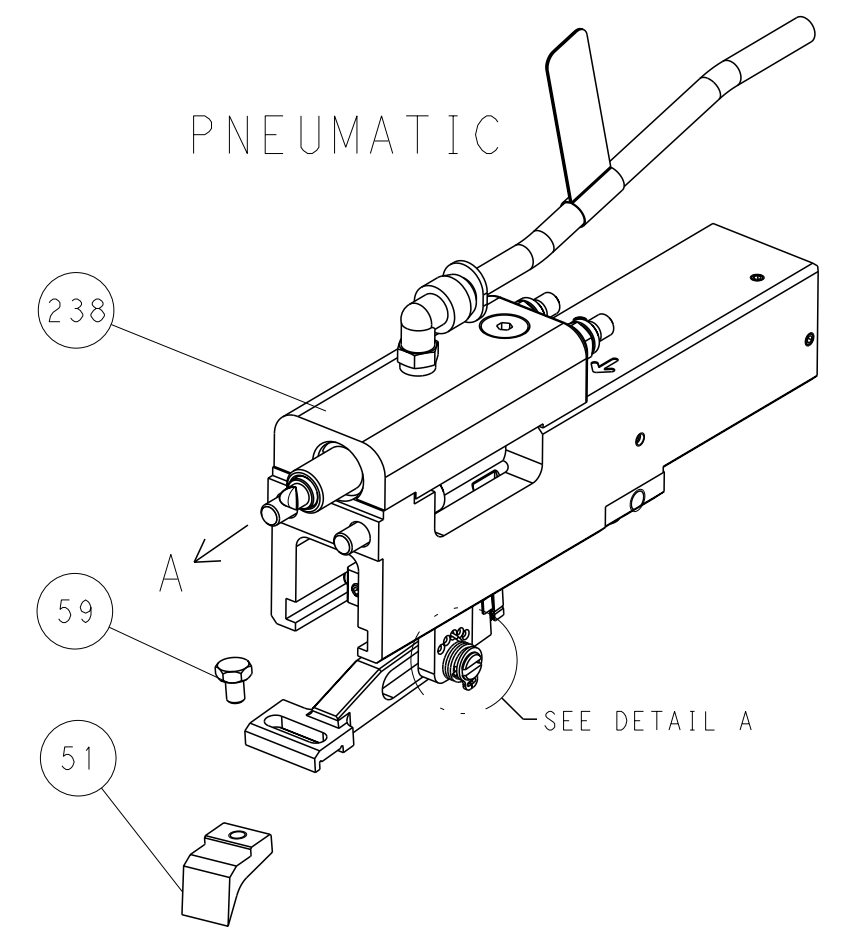
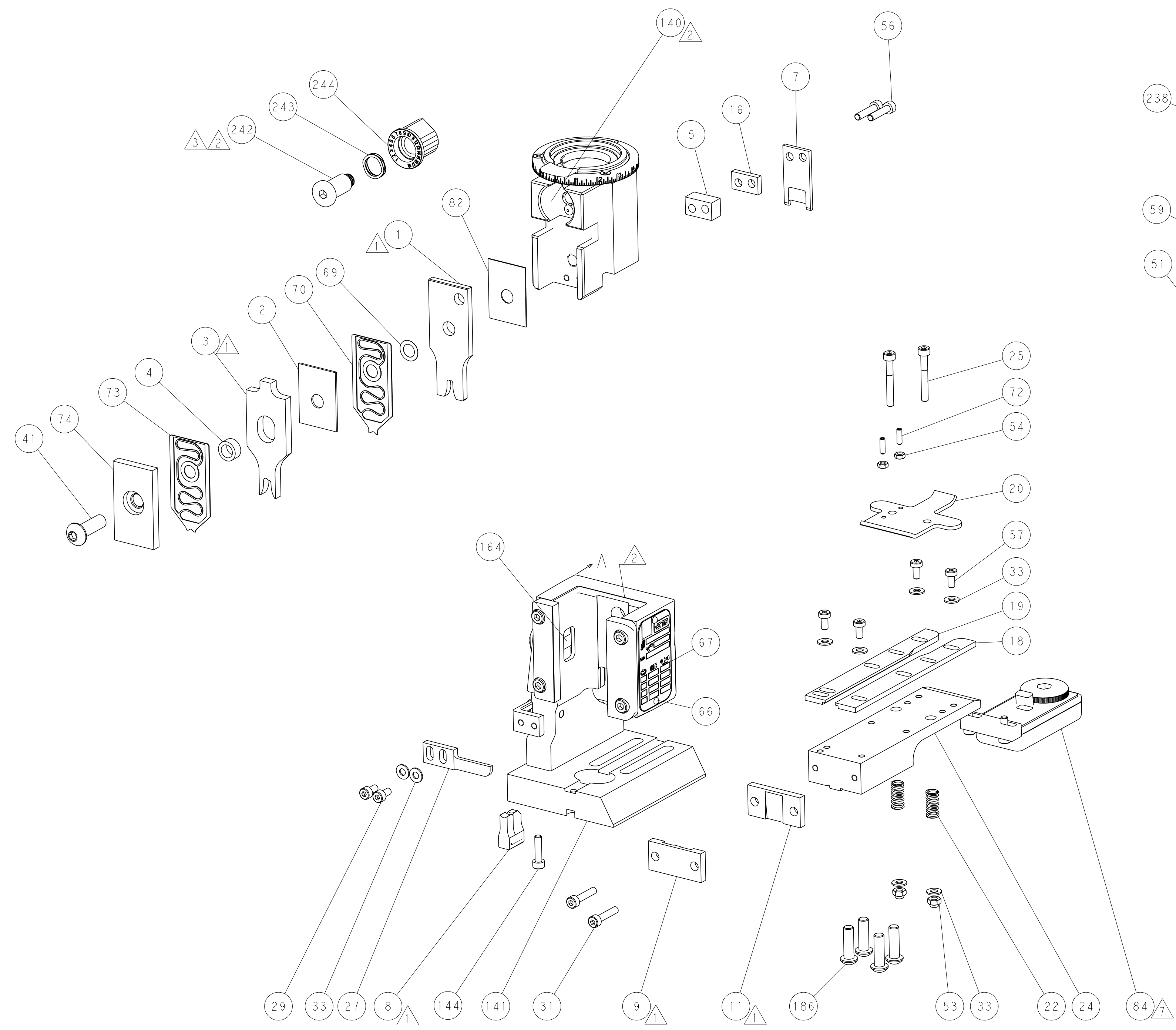
| | | | | | |
|--|---|--|---|---------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN Y. YIN 01FEB2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± | ± | ± | CHK G. BAILEY 01FEB2012 | |
| MATERIAL: | | FINISH: | | APV S. YI 01FEB2012 | NAME Ocean End Feed Applicator |
| WEIGHT: | | SCALE: | | SIZE CAGE CODE DRAWING NO | RESTRICTED TO |
| Customer Accessible Production Drawing | | SCALE 1:1 | | 00779 ©=2150005 | 3 of 4 |

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

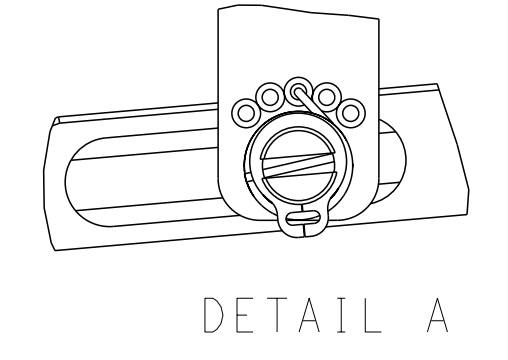


RAM SET-UP

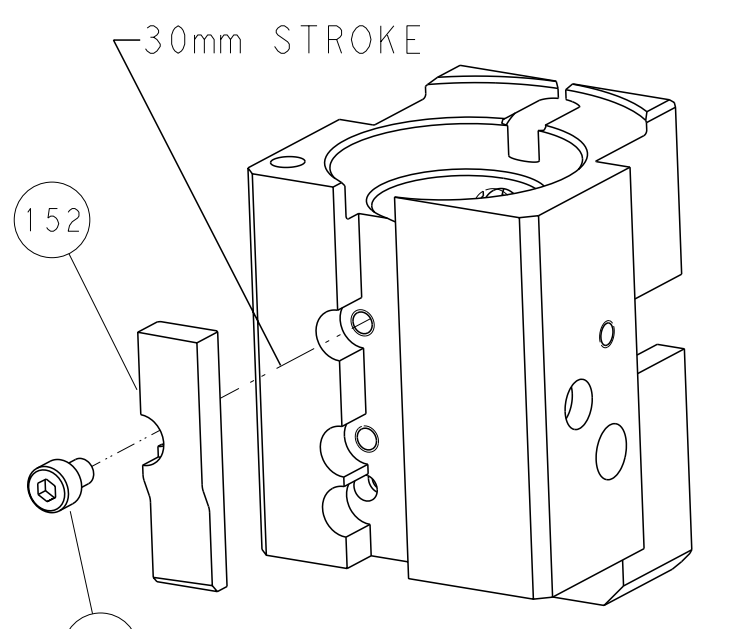
FEED TYPE



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)

| | | | |
|--|--|---|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN Y.YIN 01FEB2012 CHK G.BAILEY 01FEB2012 APVD S.XI 01FEB2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH * | | NAME Ocean End Feed Applicator APPLICATION SPEC WEIGHT SCALE 1:1 | SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150005 SHEET 4 OF 4 REV N1 |
| MATERIAL: | | Customer Accessible Production Drawing | |