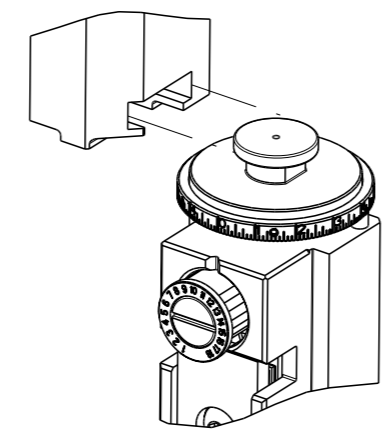


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150021-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150021-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150021-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm [.228-.260 IN]		Ø3.18-5.33 mm [.125-.210 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626037-1	626037-3	626038-1	626038-3
626037-2	626037-4	626038-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.61 +/- 0.05 [.142 +/- .002]	8.1
5.00mm2	3.43 +/- 0.05 [.135 +/- .002]	10.1
4.00mm2	3.25 +/- 0.05 [.128 +/- .002]	11.8

- 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 50. 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.

***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.

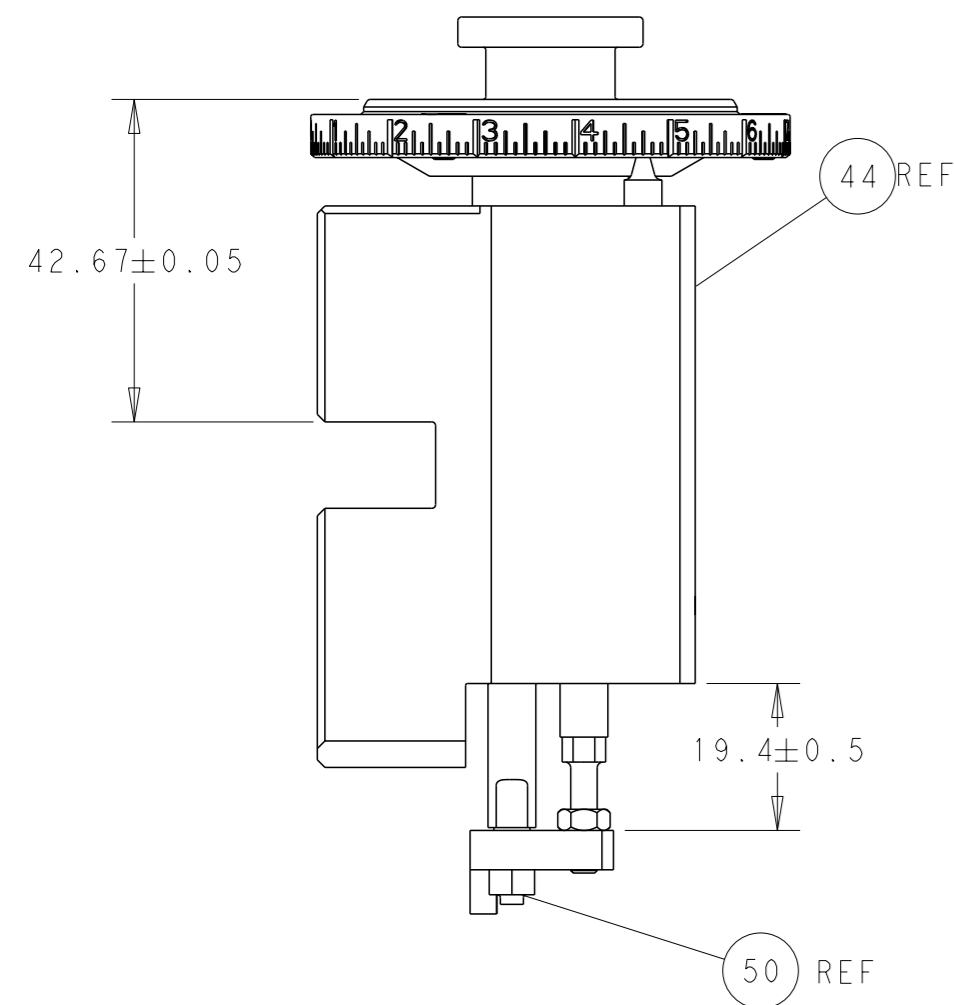
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	27APR2012	KH	SX
		B		ECR-19-019942	24DEC2019	FZ	TE

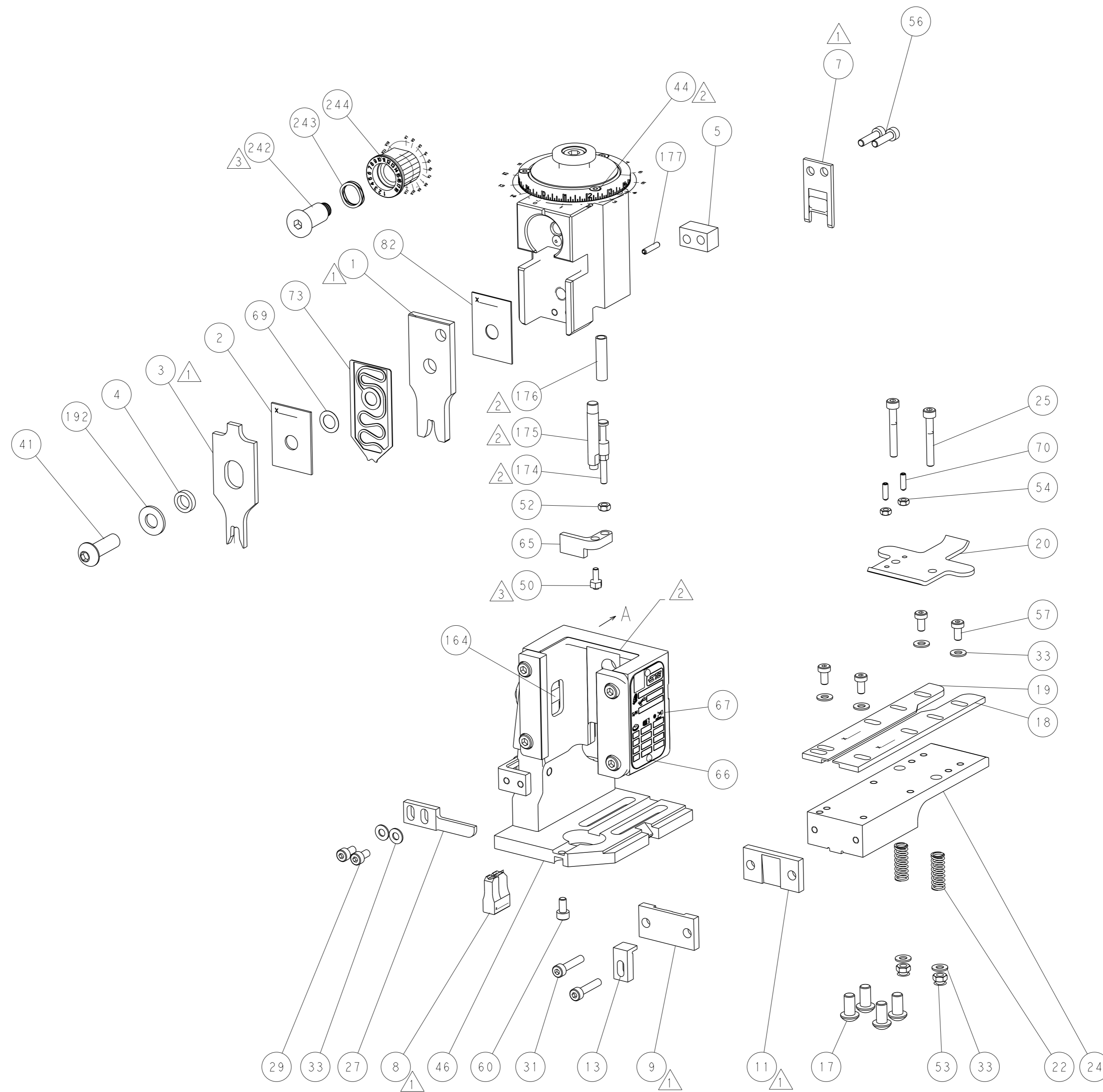
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	6-993111-6	PIN, SLOTTED 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	
-	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1-2119791-1	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2063961-9	FEED FINGER	51	
-	1	1	1976055-3	STANDOFF, HOLD-DOWN	50	
-	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	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	4-22281-1	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	2-1901696-1	STRIP GUIDE, REAR	19	
-	1	1	2-1901695-1	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-7	PLATE, FRONT SHEAR	9	
-	1	2	1-1333223-3	ANVIL, COMBINATION	8	
-	1	1	2-690474-0	BLADE, SLUG	7	
-	1	1	6-240641-1	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	1-1633962-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1-455888-0	SPACER, CRIMPER	2	
-	1	2	456412-7	CRIMPER, WIRE .180 F PREMIUM	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	H. HUANG	29DEC2011	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		CHK	S. XI	29DEC2011	
MATERIAL:		FINISH:		APVD	J. CRUZ	29DEC2011	NAME
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE DRAWING NO	
				RESTRICTED CUSTOMER		A1 00779 C=2150021	
				SCALE		SHEET 1 OF 4	
				REV		B	

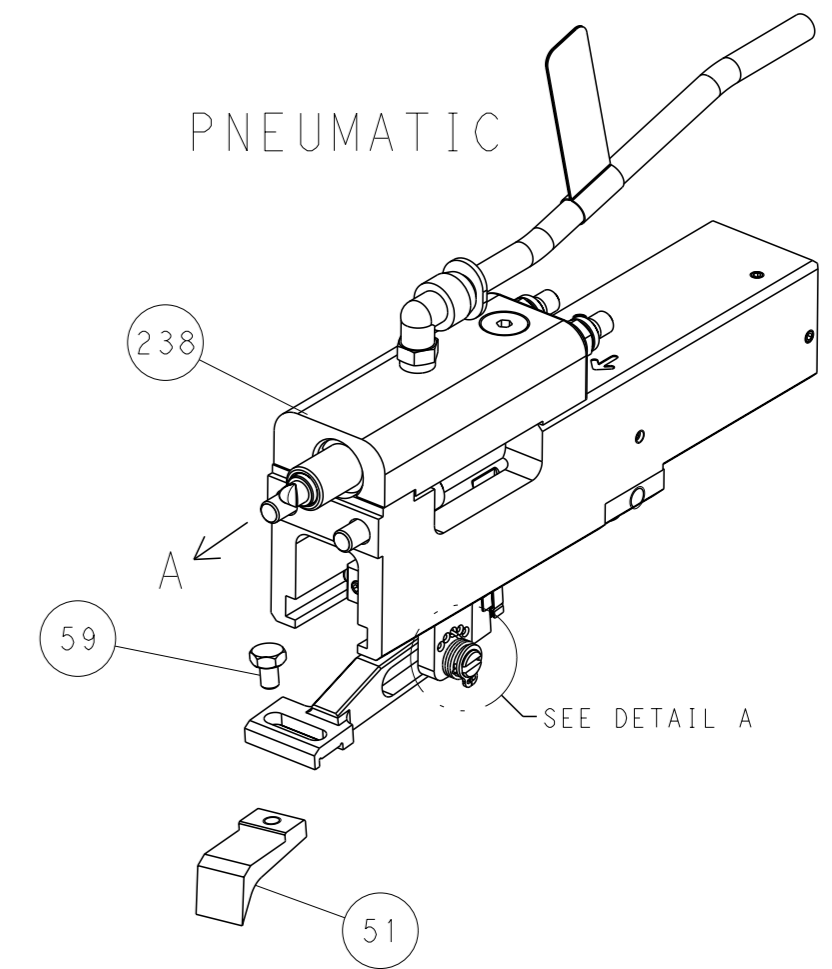
LOC	DIST	REV	DESCRIPTION	DATE	DWN	APVD
A	66	-	SEE SHEET 1	-	-	-
REVISIONS						



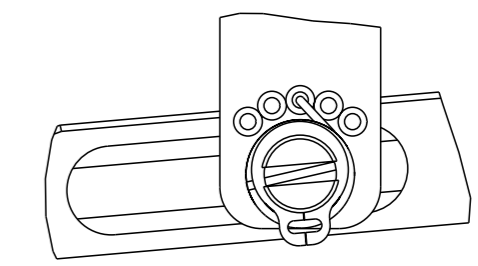
RAM AND HOLDDOWN SET-UP



FEED TYPE

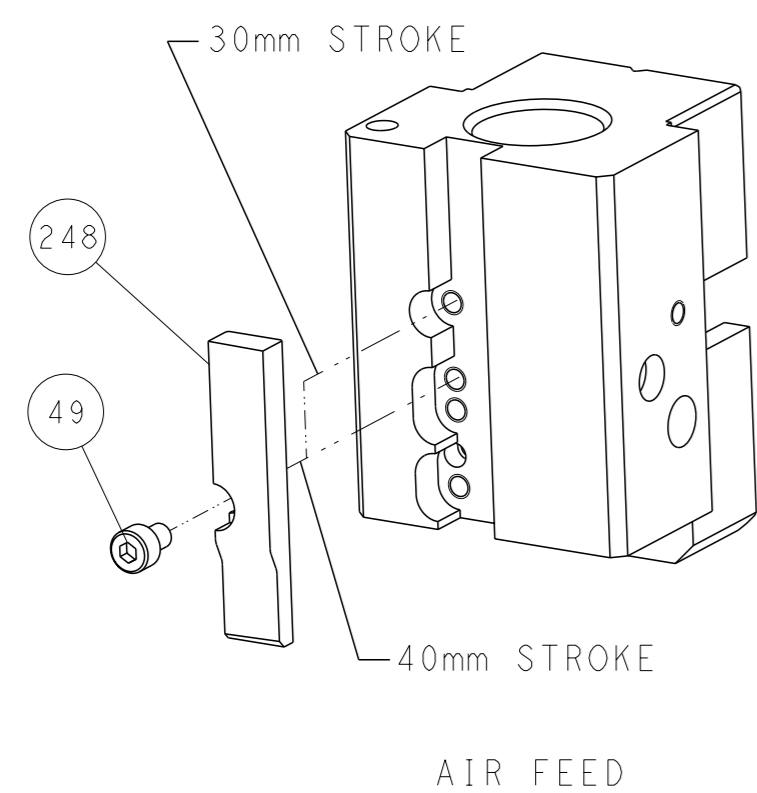


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION

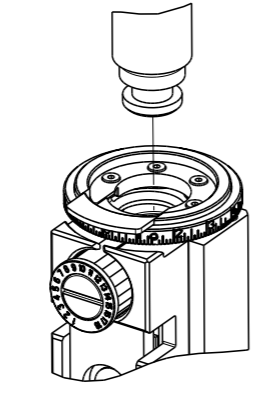


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN K HUANG 29DEC2011	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±		CHK S XI 29DEC2011	
		1 PLC ±		APVD J CRUZ 29DEC2011	
		2 PLC ±		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		APPLY PRODUCT SPEC	SIZE CAGE CODE DRAWING NO. RESTRICTED TO
				APPLY APPLICATION SPEC	A 00779 ©=2150021
				APPLY ANGLES	RESTRICTED CUSTOMER
				APPLY FINISH	SCALE 1:1 SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150021-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150021-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	5.59 mm [.220]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING TONGUE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.80-6.60 mm [.228-.260 IN]	∅3.18-5.33 mm [1.25-.210 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626037-1	626037-3	626038-1	626038-3
626037-2	626037-4	626038-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.61+/-0.05 [1.42+/-0.002]	8.1
5.00mm2	3.43+/-0.05 [1.35+/-0.002]	10.1
4.00mm2	3.25+/-0.05 [1.28+/-0.002]	11.8



- 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 ITEM 50. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

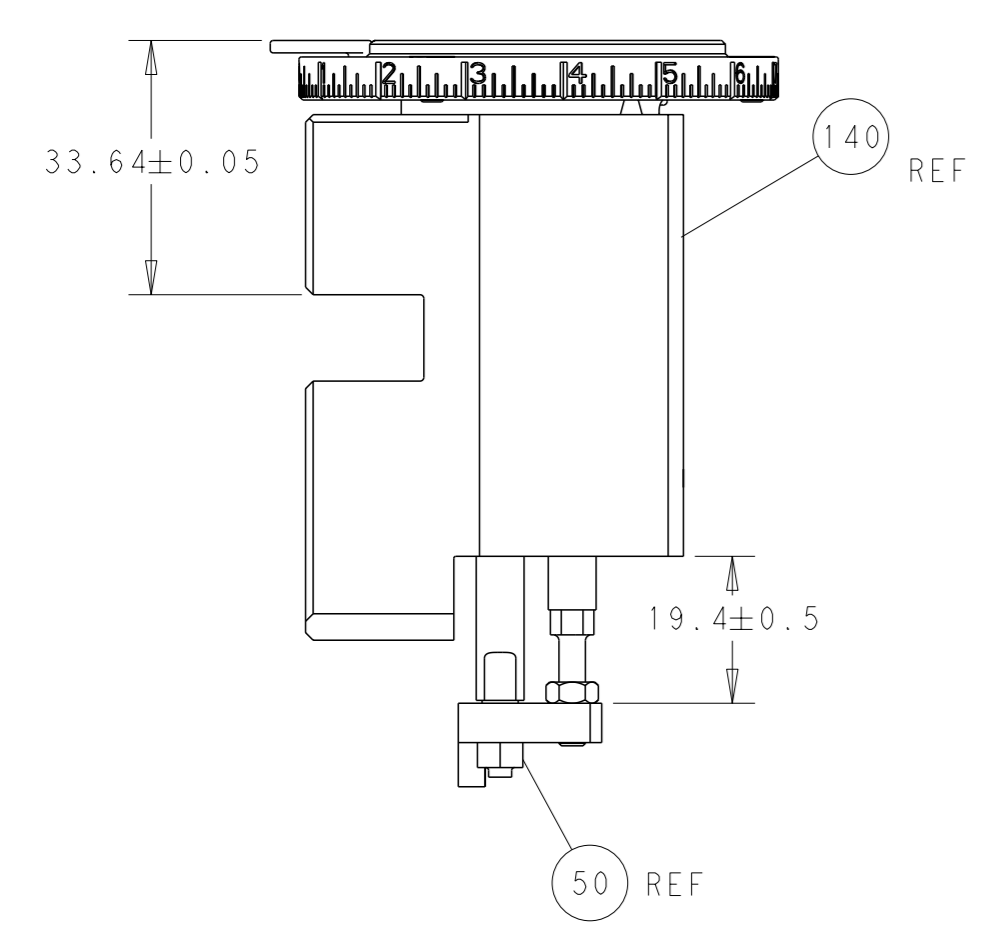
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	OWN	APPV
-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-4			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	455888-6			82
-	1	1-2119791-1			73
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119943-1			69
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-1			65
-	1	5-18022-5			59
-	4	2168400-4			57
-	2	2168083-8			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-9			51
-	1	1976055-3			50
-	1	18023-9			49
-	1	1803602-1			41
-	8	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	240639-1			27
-	2	1-2168083-5			25
-	1	1752371-1			24
-	2	4-22281-1			22
-	1	1803292-1			20
-	1	2-1901696-1			19
-	1	2-1901695-1			18
-	1	1752360-1			13
-	1	240644-1			11
-	-	-			10
-	1	690482-7			9
1	1	1-1333223-3			8
-	1	2-690474-0			7
-	1	6-240641-1			5
-	1	238011-2			4
1	1	1-1633962-4			3
-	1	1-455888-0			2
1	1	456412-7			1

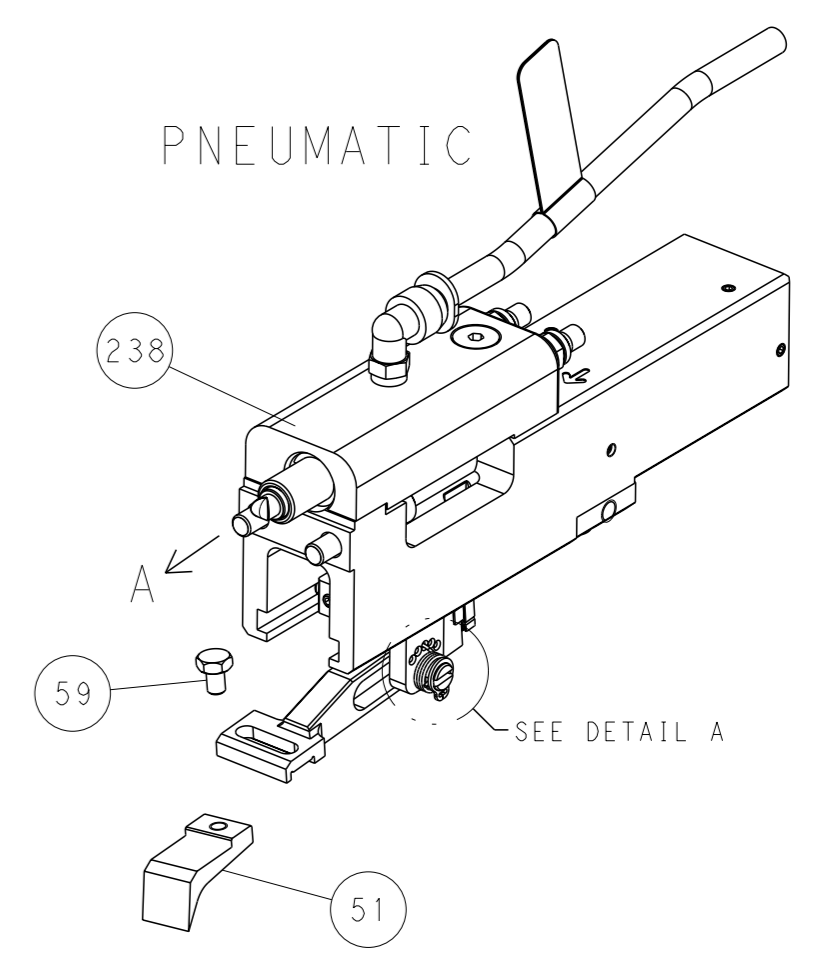
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APPV	DATE	DESCRIPTION	ITEM NO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	H. HUANG	S. XI	J. CRUZ	29DEC2011	TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		RESTRICTED CUSTOMER		SCALE 1:1 SHEET 3 OF 4		REV B	

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

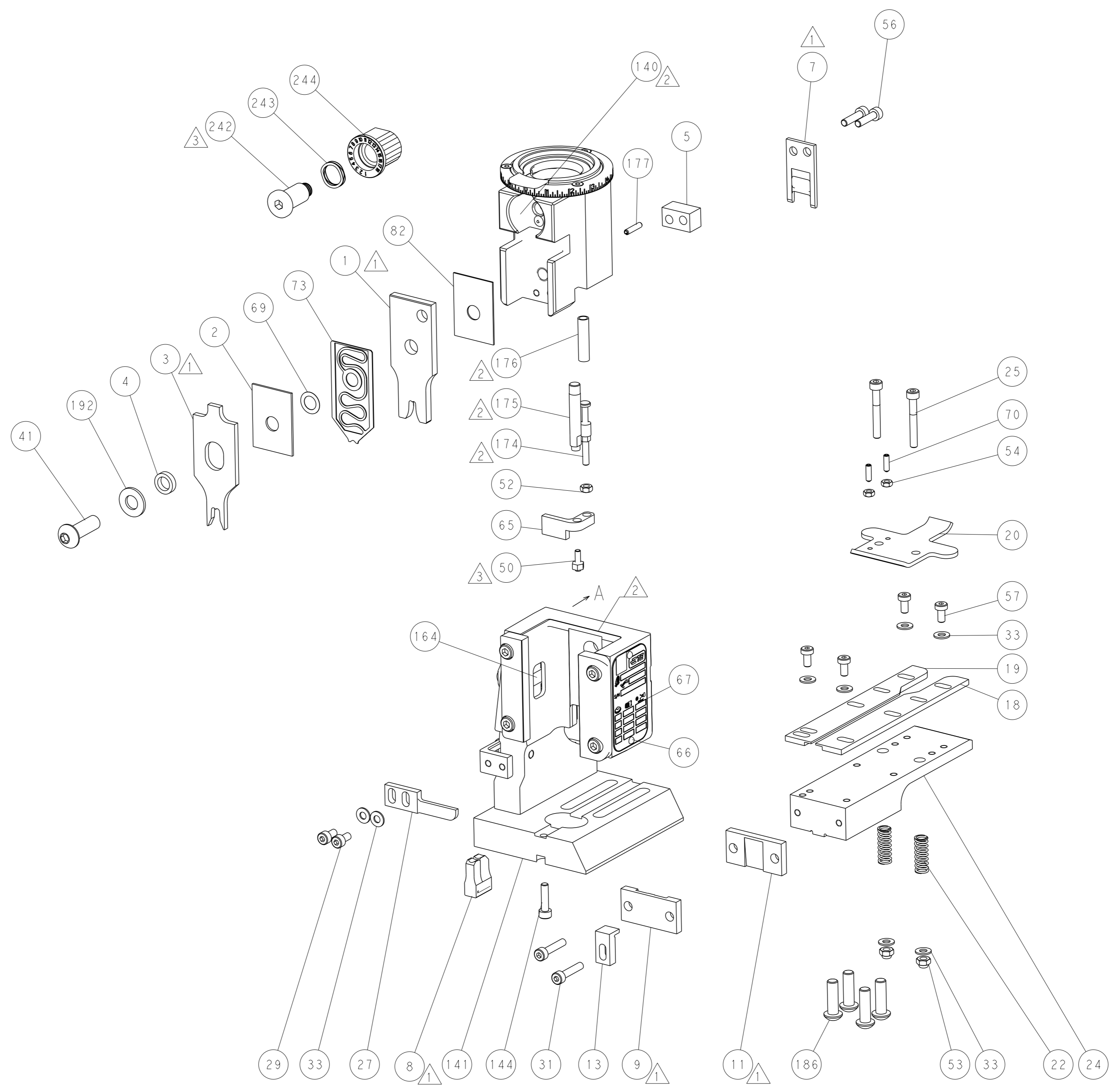
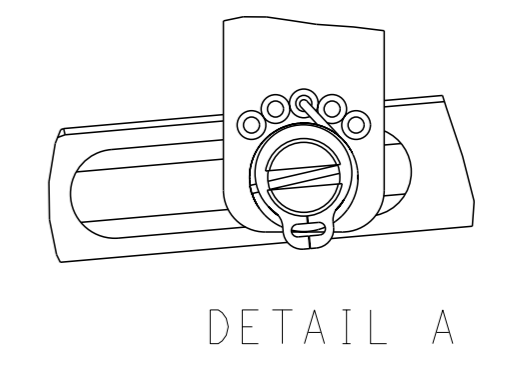


RAM AND HOLDDOWN SET-UP

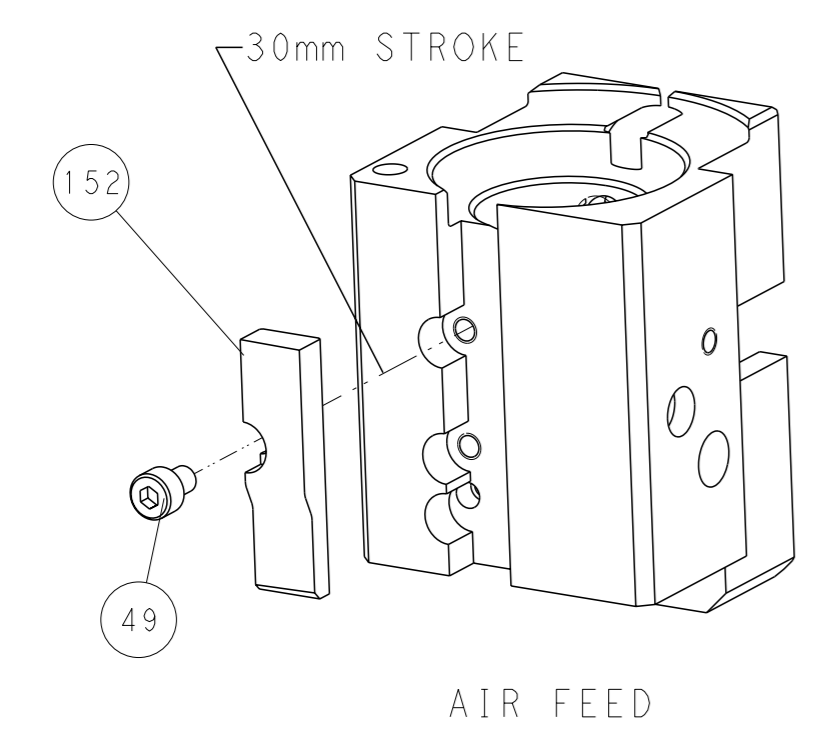
FEED TYPE



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. HUANG CHK: S. XI APVD: J. CRUZ	29DEC2011 29DEC2011 29DEC2011	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150021	RESTRICTED TO: RESTRICTED CUSTOMER
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:1	SHEET: 4 OF: 4	REV: B	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	