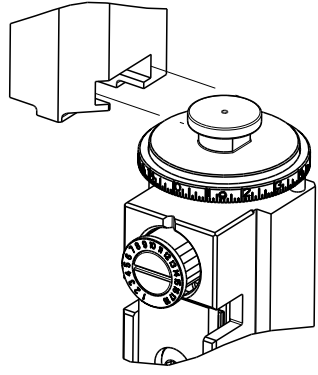
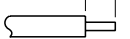




8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150278-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150278-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150278-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



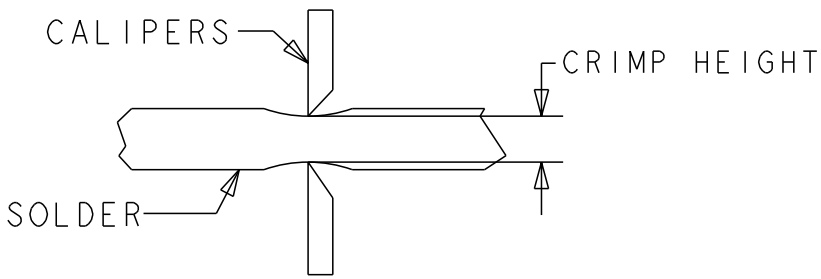
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.11 mm [.201]	D
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT,ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]			INSULATION DIAMETER RANGE Ø 4.19 mm MAX[.165 IN MAX]
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520334-2	9-520334-2	5-520336-2	
5-520334-2	2-520336-2	9-520336-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 OR (2) 22		1.79+/-0.05 [1.070+/- .002]		5.0	.19 in [4.83mm]
22 OR 20		1.65+/-0.05 [1.065+/- .002]		6.5	.19 in [4.83mm]



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- 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.
6. 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.

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			B1	ECR-18-012971	15AUG2018	TB	TE	
			C	ECR-19-008826	06JUN2019	LG	TE	
			D	ECR-20-003799	17MAR2020	JWC	TE	
			E	ECR-20-010828	30JUL2020	JWC	TE	

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2844940-3	AIR FEED MODULE	238
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	208
-	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	467500-1	SHEAR, FLOATING	205
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2161937-2	STABILIZER	154
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	2352966-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	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
-	2	2	5-22278-1	SPRING, COMPRESSION	36
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2-22280-7	SPRING, COMPRESSION	22
-	1	1	2161948-1	DRAG	20
-	1	1	683736-1	GUIDE, STRIP, REAR	19
-	1	1	683737-1	FRONT STRIP GUIDE	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	4-22280-7	SPRING, COMPRESSION	13
1	2	1	2161935-4	ANVIL, RIGHT HAND	8
-	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
1	2	1	467342-3	CRIMPER, RIGHT HAND	1
-	77	-72	-2	PART NO	ITEM NO
				DESCRIPTION	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN HOFFNER CHK T. ELBIN APVD T. ELBIN	11APRIL2012 12APRIL2012 12APRIL2012	TE Connectivity Harrisburg, PA 17105-3608	
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 A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
		WEIGHT -		DRAWING NO 2150278	
		Customer Accessible Production Drawing		RESTRICTED TO -	
		SCALE 1:1		SHEET 1 of 4	
				REV E	

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

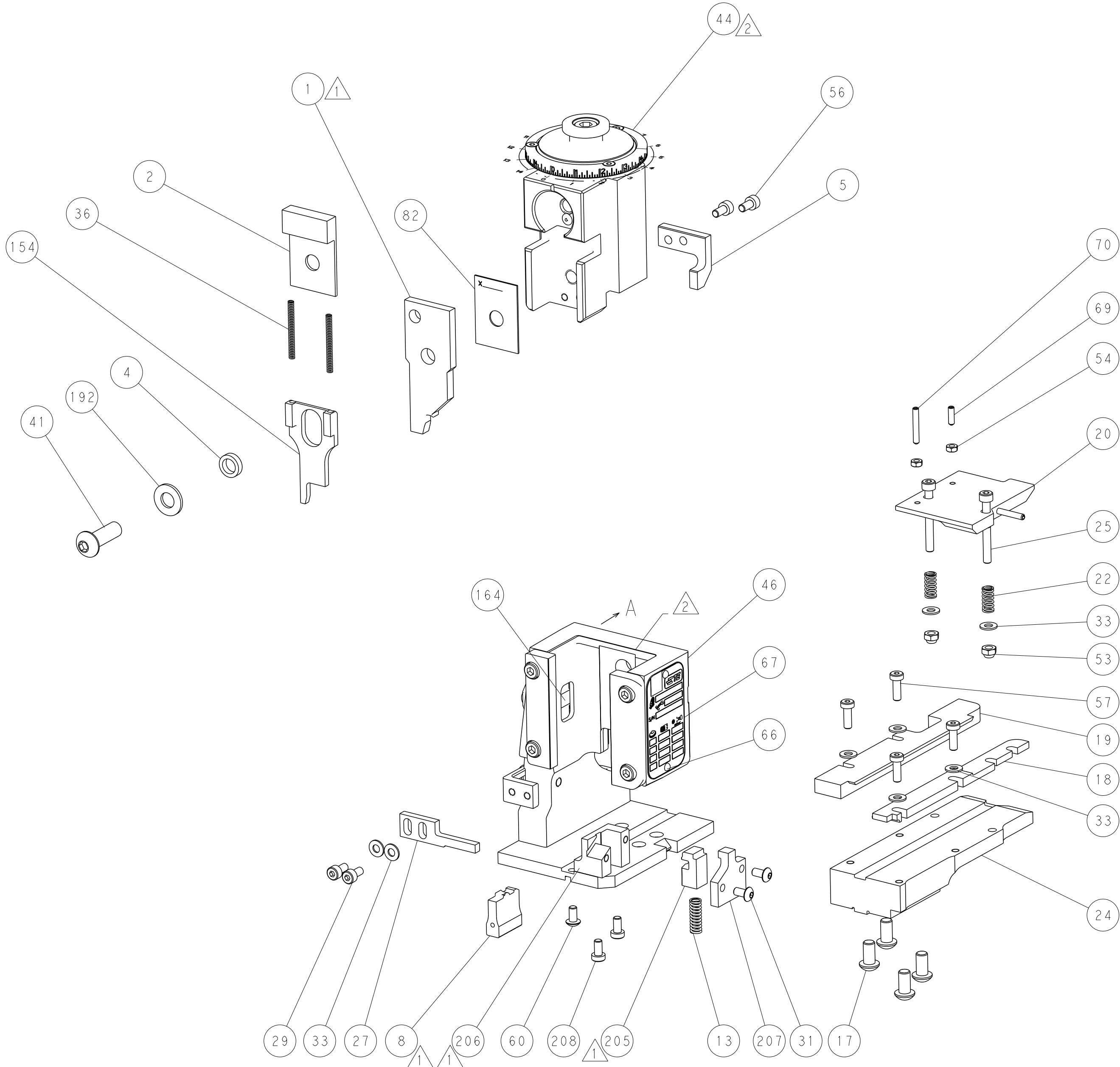
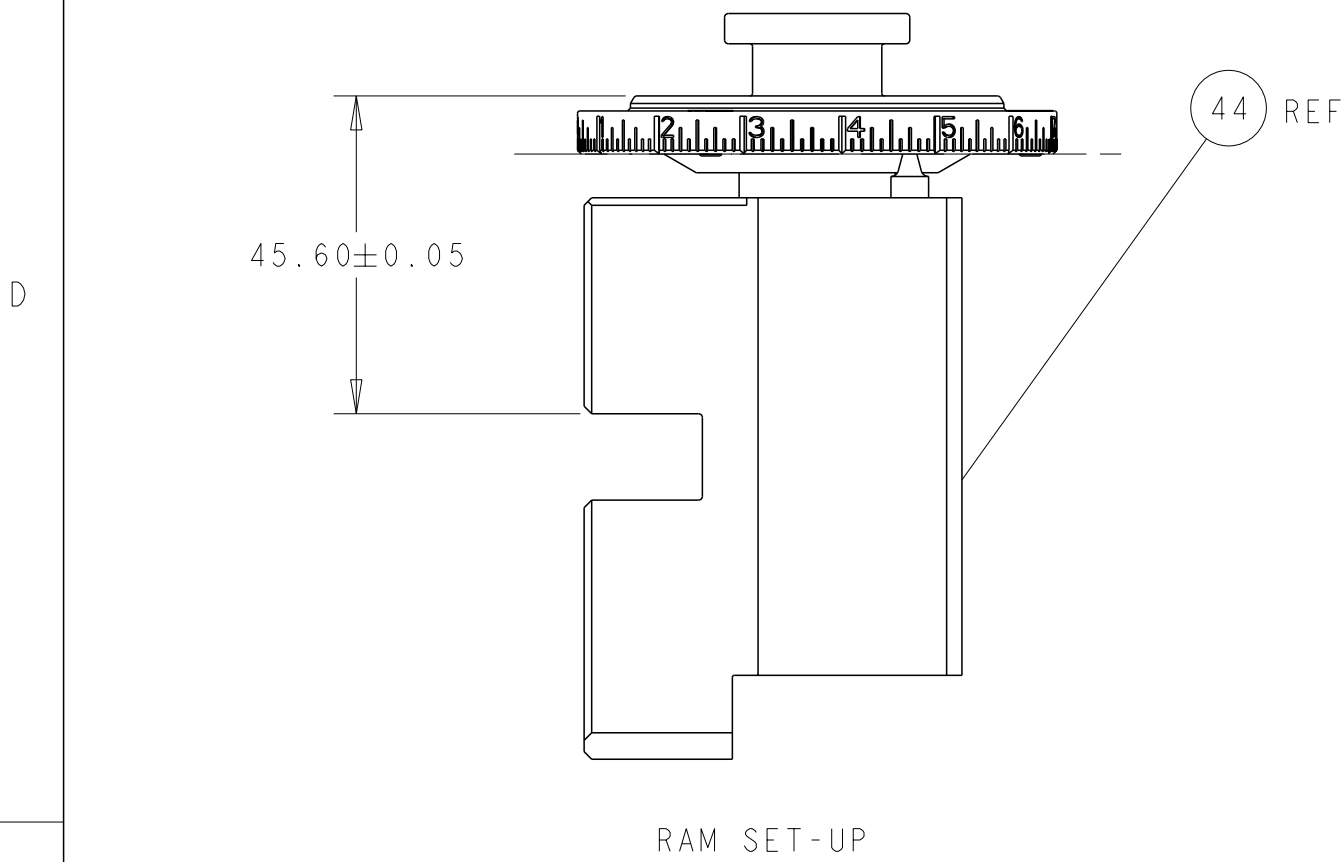
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

D

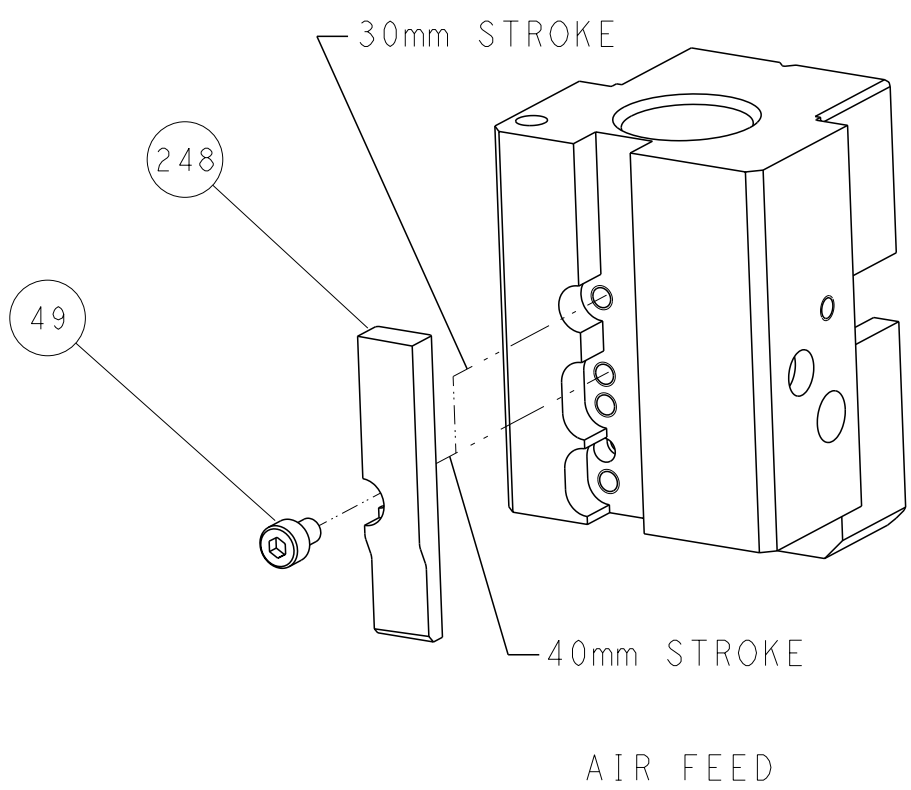
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B

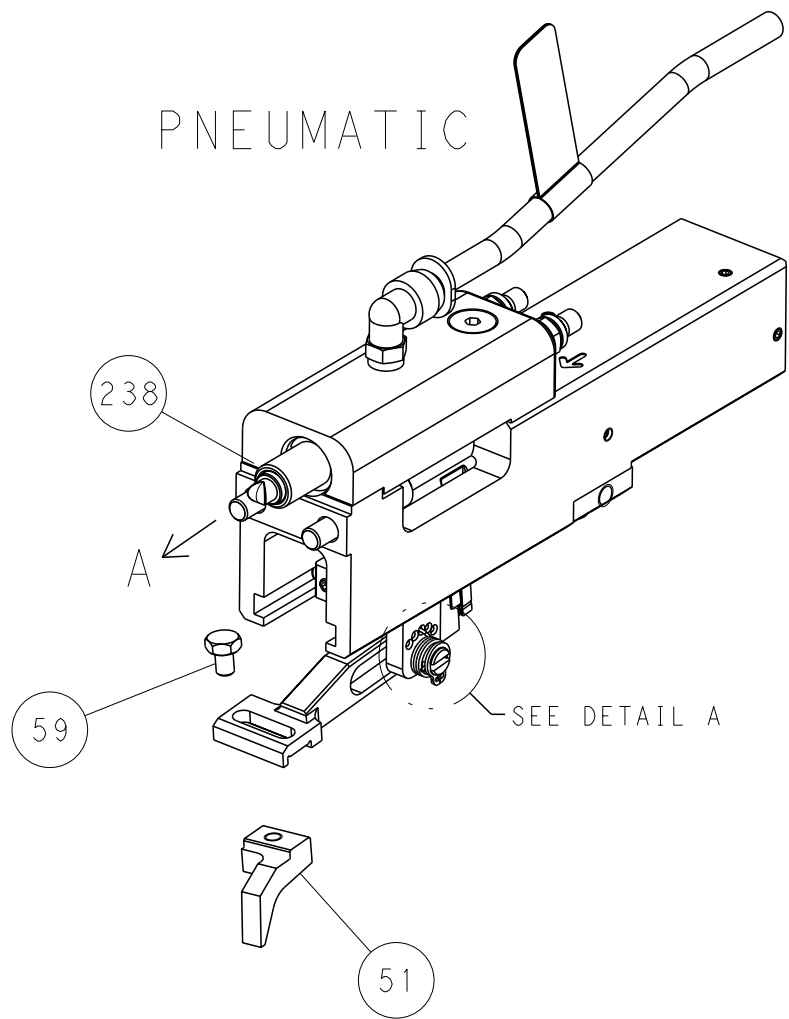
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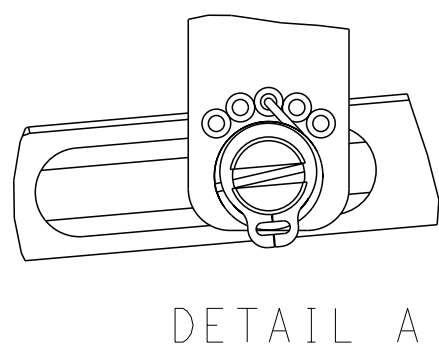
## CAM POSITION




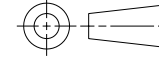
## FEED TYPE



## FEED SPRING SETTING POSITION

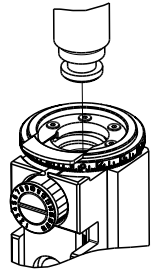


ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

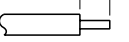

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				CHK	T.ELBIN	12APRIL2012		Harrisburg, PA 17105-3608		
				APVD	T.ELBIN	12APRIL2012		NAME		
				PRODUCT SPEC				Ocean End Feed Applicator		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC				SIZE		
mm		0 PLC ±		-				A1		
		1 PLC ±		-				C=2150278		
		2 PLC ±		-				Customer Accessible Production Drawing		
		3 PLC ±		-				1:1		
		4 PLC ±		-				2		
		ANGLES		FINISH				4		
MATERIAL		-		-				E		

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150278-2	E	PNEUMATIC	SERVO LATCH PLATE
7-2150278-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.11 mm [.201]	D
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT,ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]			INSULATION DIAMETER RANGE Ø 4.19 mm MAX[.165 IN MAX]
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520334-2	9-520334-2	5-520336-2	
5-520334-2	2-520336-2	9-520336-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 OR (2) 22		1.79+/-0.05 [.070+/-0.002]		5.0	.19 in [4.83mm]
22 OR 20		1.65+/-0.05 [.065+/-0.002]		6.5	.19 in [4.83mm]



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- 
- 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.
6. 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)

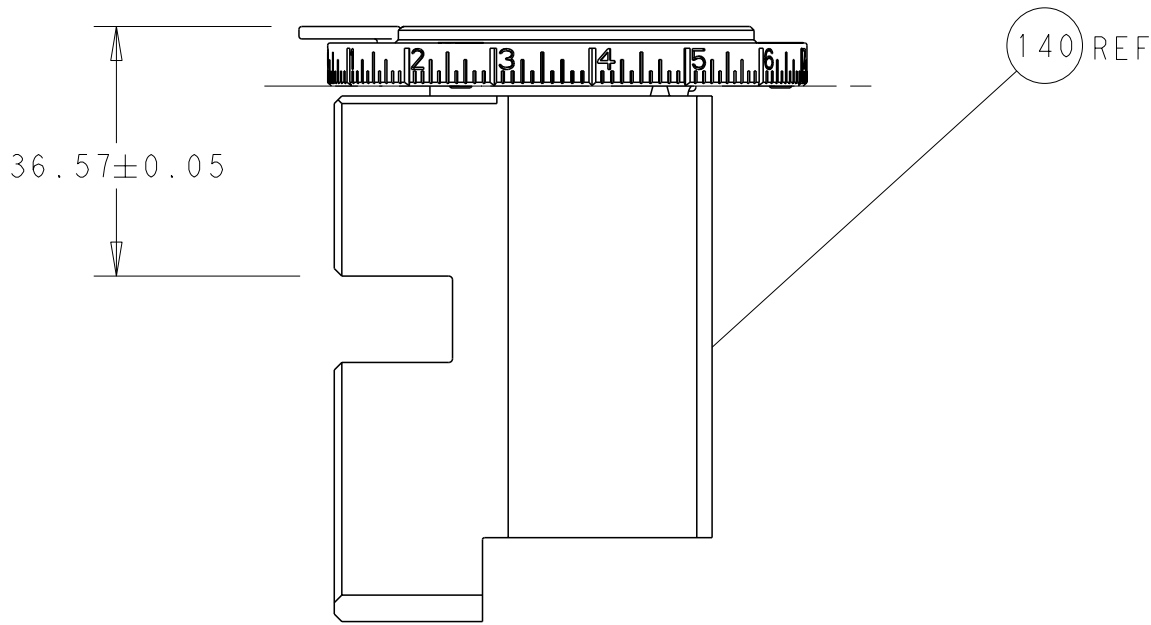
2		1						
LOC	DIST	REVISIONS						
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	2844940-3	AIR FEED MODULE	238
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	209
-	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	467500-1	SHEAR, FLOATING	205
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2161937-2	STABILIZER	154
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	1-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-6	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2352966-1	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
-	2	5-22278-1	SPRING, COMPRESSION	36
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2-22280-7	SPRING, COMPRESSION	22
-	1	2161948-1	DRAG	20
-	1	683736-1	GUIDE, STRIP, REAR	19
-	1	683737-1	FRONT STRIP GUIDE	18
-	1	4-22280-7	SPRING, COMPRESSION	13
-	1	2161935-4	ANVIL, RIGHT HAND	8
-	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	467342-3	CRIMPER, RIGHT HAND	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

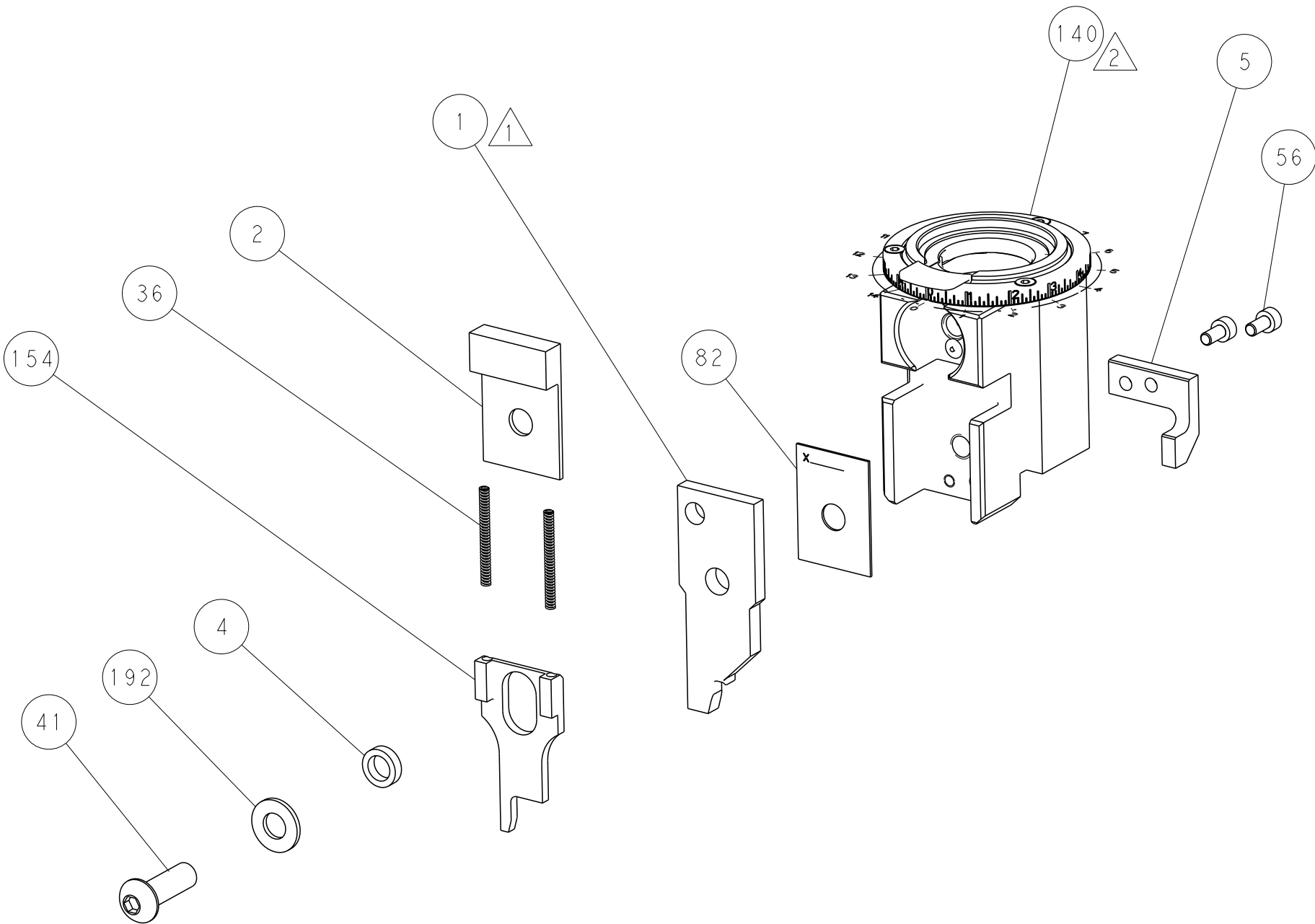
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DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME Ocean End Feed Applicator	SIZE A1	CAGE CODE 00779
MATERIAL -	FINISH -	APPLICATION SPEC -	DRAWING NO 2150278	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:1	SHEET 3	OF 4
		REV E		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

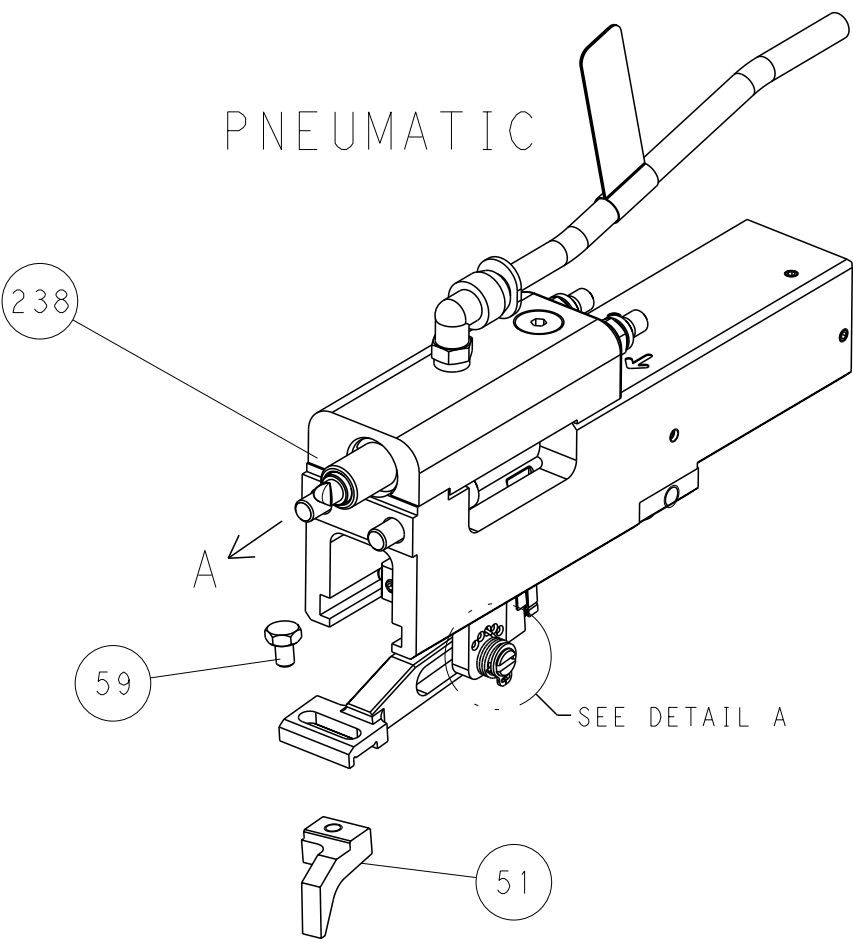
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



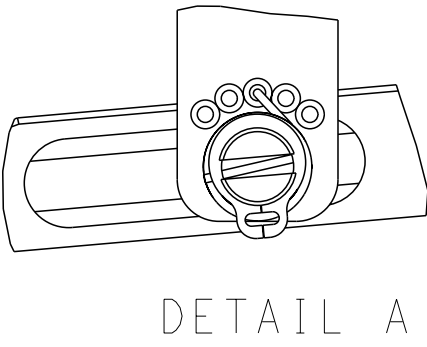
RAM SET-UP



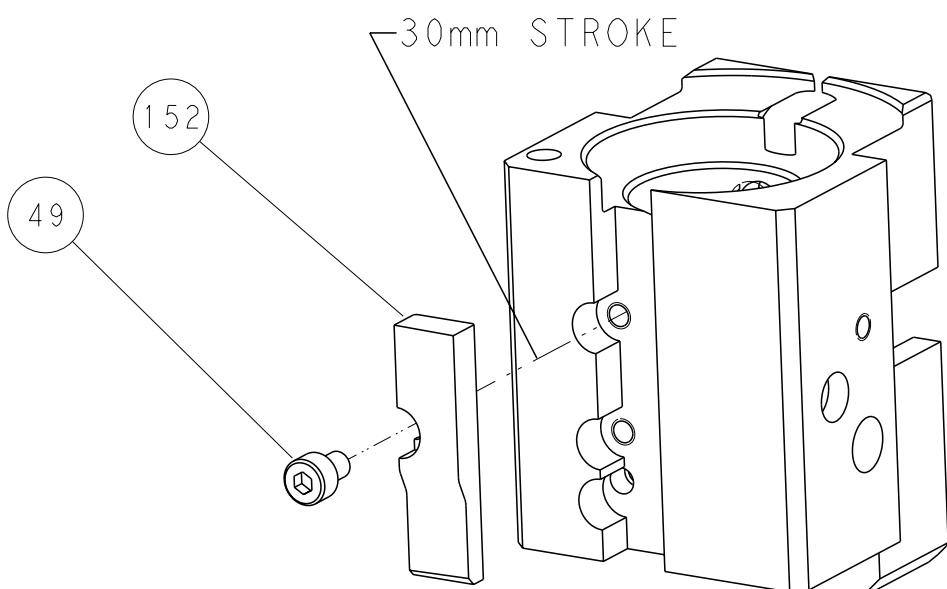
FEED TYPE



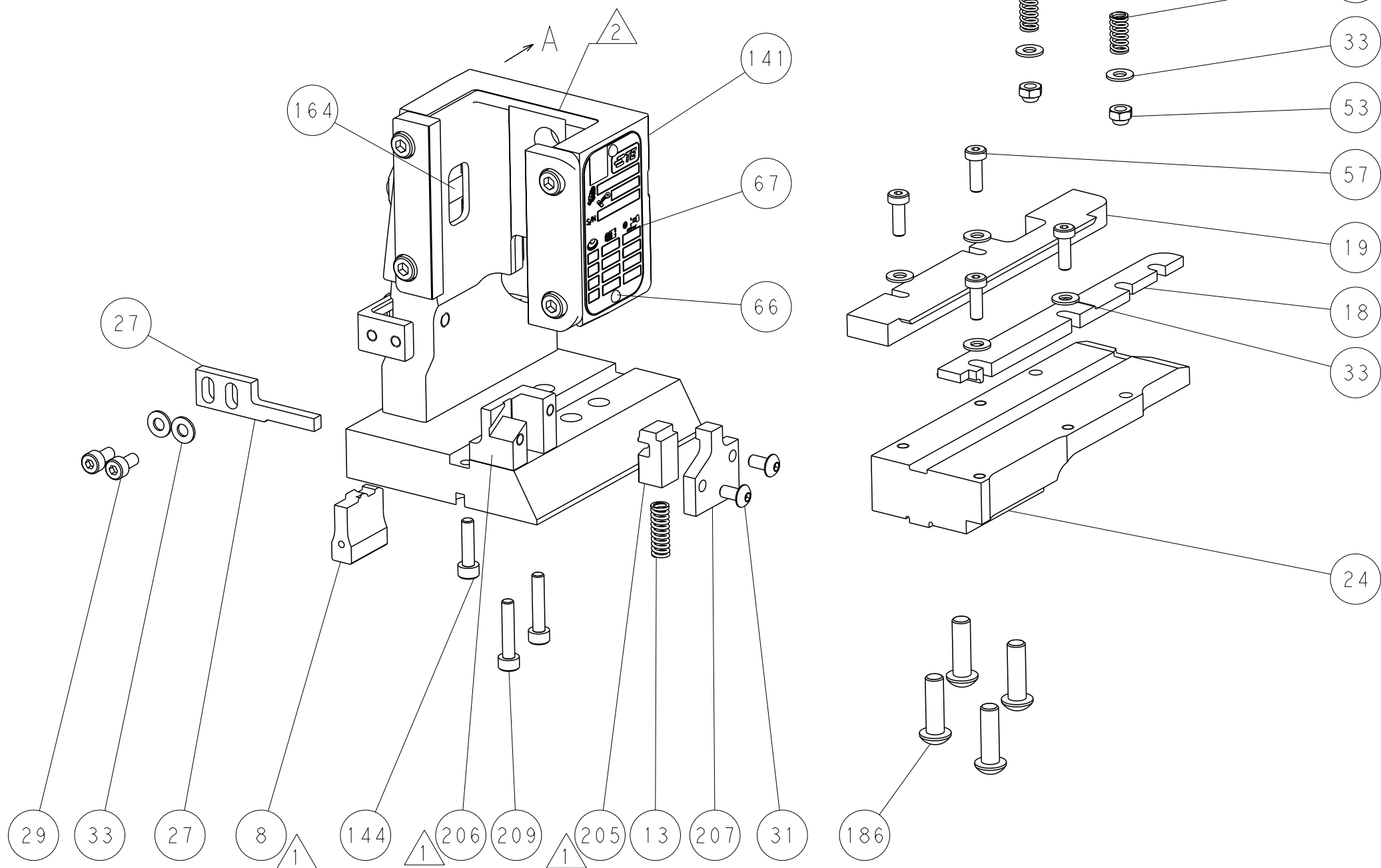
FEED SPRING SETTING POSITION





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)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		-			
		ANGLES ±		APPLICATION SPEC		-			
MATERIAL		FINISH		WEIGHT		SIZE A1	CAGE CODE 00779	DRAWING NO C=2150278	RESTRICTED TO
-		-		-		-			
Customer Accessible Production Drawing									
						SCALE	1:1	SHEET	4 OF 4
						REV E			

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