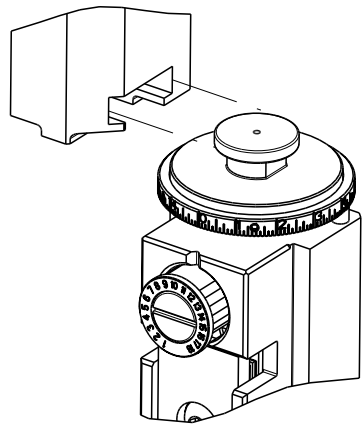


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150891-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150891-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150891-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.75 mm [.148]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: M-US TYPE TERMINAL MALE			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø1.50-3.40 mm [.059-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	WA2144A Rev 2012/01/27	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
3311115-1	7114-2883-02	3311115-2	7114-2883

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.00mm2		1.70+/-0.05 [1.067+/- .002]		7.5
1.50mm2		1.50+/-0.05 [1.059+/- .002]		9.8
1.25mm2		1.45+/-0.05 [1.057+/- .002]		10.3
0.85mm2		1.40+/-0.05 [1.055+/- .002]		10.8



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

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

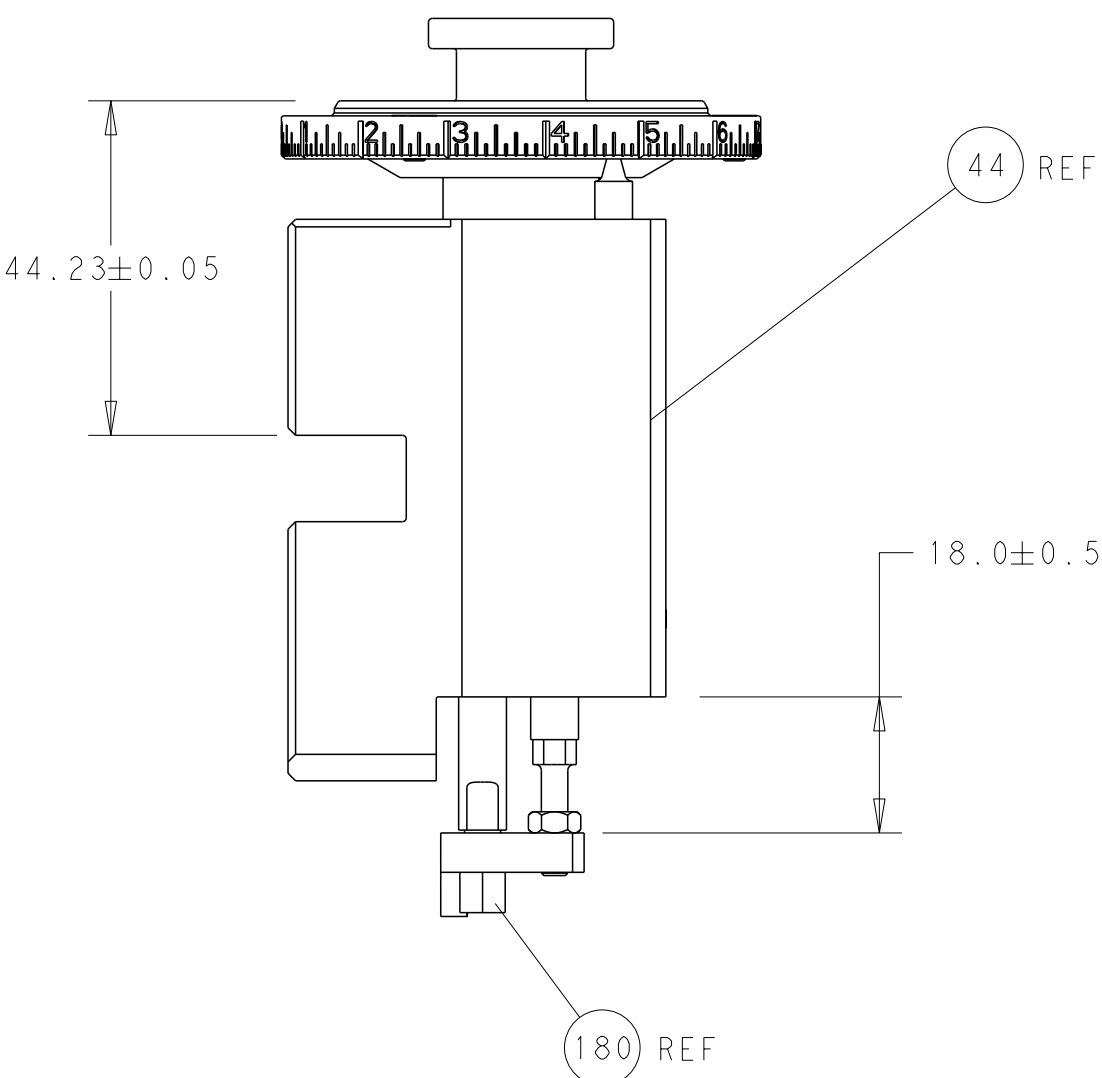
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
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			D	ECR-19-016758	28OCT2019	JAH	GB	
			D1	ECR-20-012124	27AUG2020	FJ	TE	
			E	ECR-20-013087	15SEP2020	JWC	GB	

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-8	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	1752354-6	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
	-	1	1	455888-7	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2-2168083-6	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	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	240639-1	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1-1752371-4	PLATE, STRIP GUIDE	24
	-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-1	DRAG	20
	-	2	2	1901259-4	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	240641-6	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	6-1803060-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	8-240641-3	SPACER	5
	-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	3-1803199-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	1	2	1	3-456408-0	CRIMPER, WIRE PREMIUM	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

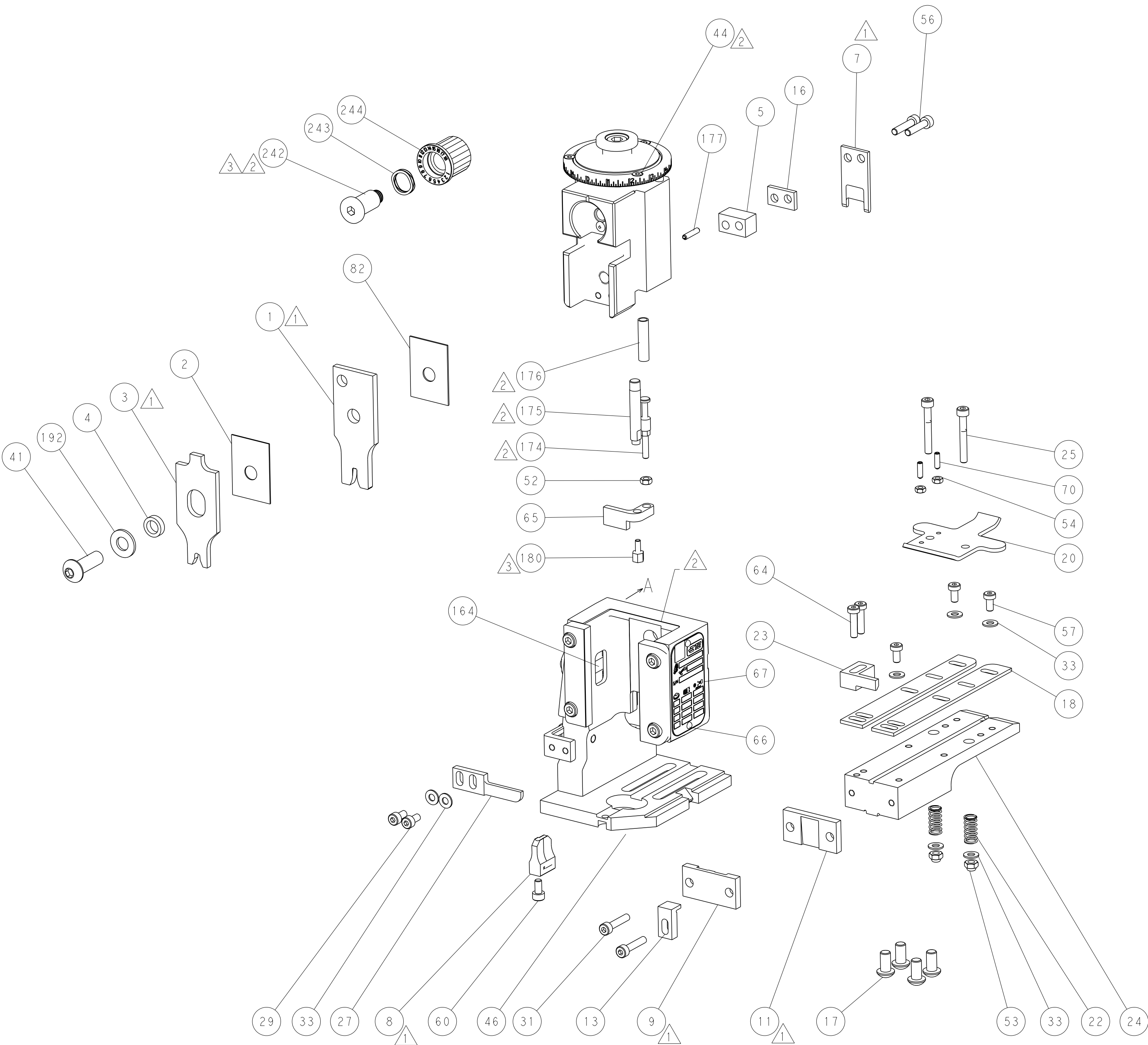
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		Ocean End Feed Applicator			
		FINISH		SIZE CASE CODE DRAWING NO			
MATERIAL		-		A1 00779 ©=2150891			
Customer Accessible Production Drawing				RESTRICTED TO			
SCALE 1:1				SHEET 1 OF 4			
REV E				REV E			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

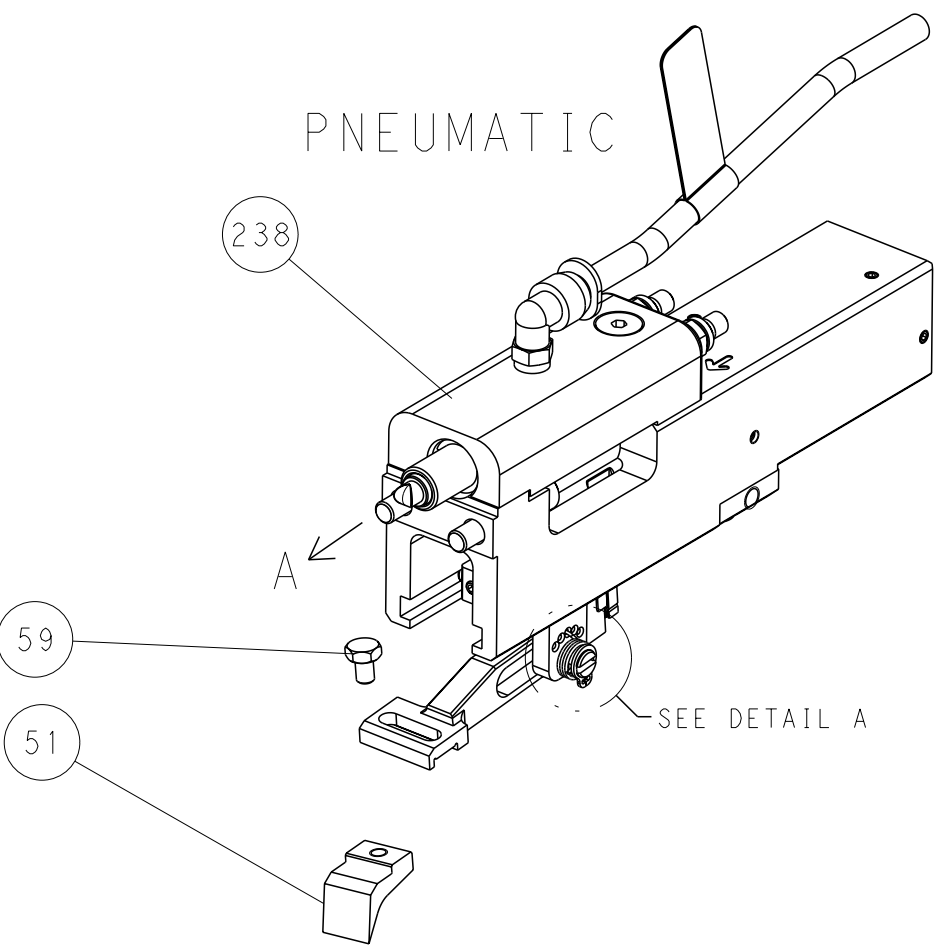
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



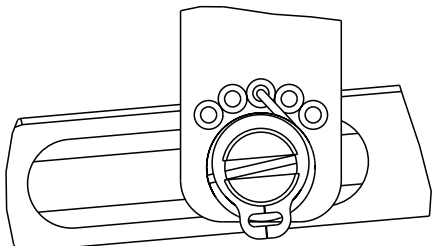
RAM AND HOLDDOWN SET-UP



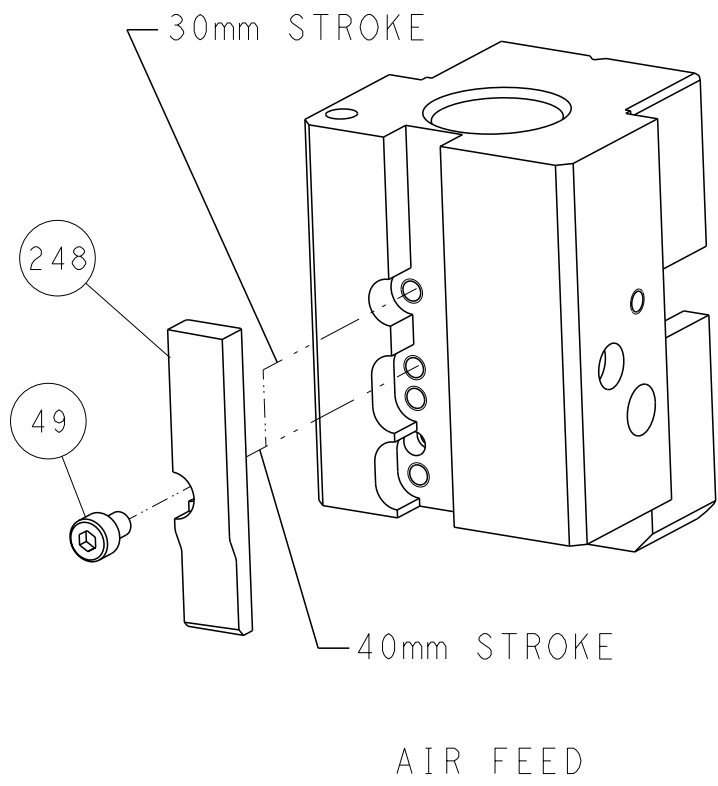
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

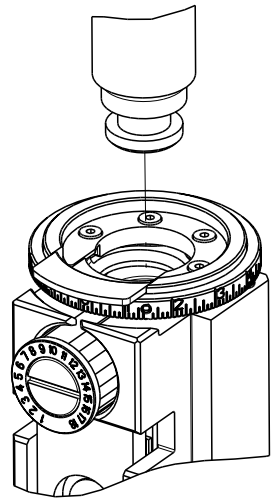


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1111 IS SUBJECT TO CHANGE AND TO BE CONFIRMED BY THE CUSTOMER. THE CUSTOMER SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN C. TOPPER 01MAR2018	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 01MAR2018	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. DEGRANGE 01MAR2018	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
FINISH -		APPLICATION SPEC -	DRAWING NO C=2150891	
		WEIGHT -	Customer Accessible Production Drawing	
		SCALE 1:1	SHEET 2 of 4	
			REV E	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150891-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150891-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.75 mm [.148]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: M-US TYPE TERMINAL MALE			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø1.50-3.40 mm [.059-.134 IN]	
TERMINAL APPLICATION SPECIFICATION WA2144A Rev 2012/01/27		-	
TERMINALS APPLIED		5	
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
3311115-1	7114-2883-02	3311115-2	7114-2883

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	4
2.00mm2		1.70+/-0.05 [.067+/-0.002]		7.5	
1.50mm2		1.50+/-0.05 [.059+/-0.002]		9.8	
1.25mm2		1.45+/-0.05 [.057+/-0.002]		10.3	
0.85mm2		1.40+/-0.05 [.055+/-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 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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	REVISONS	
A	66	P	LYR
			DESCRIPTION
			DATE
			OWN
			APVD
			SEE SHEET 1

	-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	1	1752354-6	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	455888-7	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2-2168083-6	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	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	240639-1	STRIPPER (MACHINING)	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1-1752371-4	PLATE, STRIP GUIDE	24
	-	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-1	DRAG	20
	-	2	1901259-4	GUIDE, LOWER STRIP	18
	-	1	240641-6	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	6-1803060-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	6
	-	1	8-240641-3	SPACER	5
	-	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803199-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	455888-5	SPACER, CRIMPER	2
1	1	1	3-456408-0	CRIMPER, WIRE PREMIUM	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	
MATERIAL -		FINISH -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO 2150891	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3	
				OF 4	
				REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION



THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE PROPERTIES AND SPECIFICATIONS OF THE ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 01MAR2018 CHK G. TOPPER 01MAR2018 APP'D G. BAILEY 01MAR2018 DATE DEGRANGE 01MAR2018		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean End Feed Applicator -	
MATERIAL -		FINISH -		RESTRICTED TO -	
WEIGHT -		SIZE A1		CAGE CODE 00779	
SCALE 1:1		DRAWING NO C-2150891		SHEET 4	
OF 4		REV F		CUSTOMER ACCESSIBLE PRODUCTION DRAWING Customer Accessible Production Drawing	