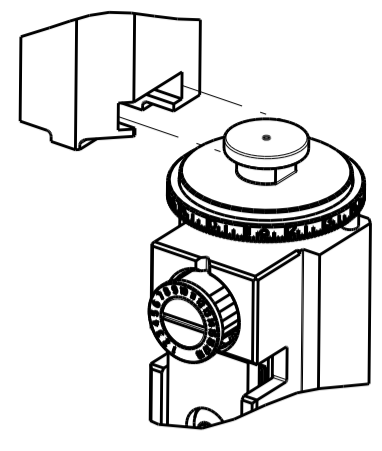


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150169-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150169-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150169-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150169-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150169-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.87 mm [.113]	F
INSUL	3.94 mm [.155]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: KET TERMINAL STIEBEL ELTRON CRIMP SPECIFICATION	
TERMINAL NAME: .250 CONNECTOR	
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	INSULATION DIAMETER RANGE Ø2.48-3.30 mm [.097-.130 IN]
TERMINAL APPLICATION SPECIFICATION CRIMPING TOOLS KET Rev 22.12.2015	
TERMINALS APPLIED	
TE TERMINAL	KET TERMINAL
1949542-1	ST730135-1
1949542-2	ST730135-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80 +/- 0.02 [.071 +/- .001]	8.8
15 AWG	1.80 +/- 0.02 [.071 +/- .001]	8.8

- 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. 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.

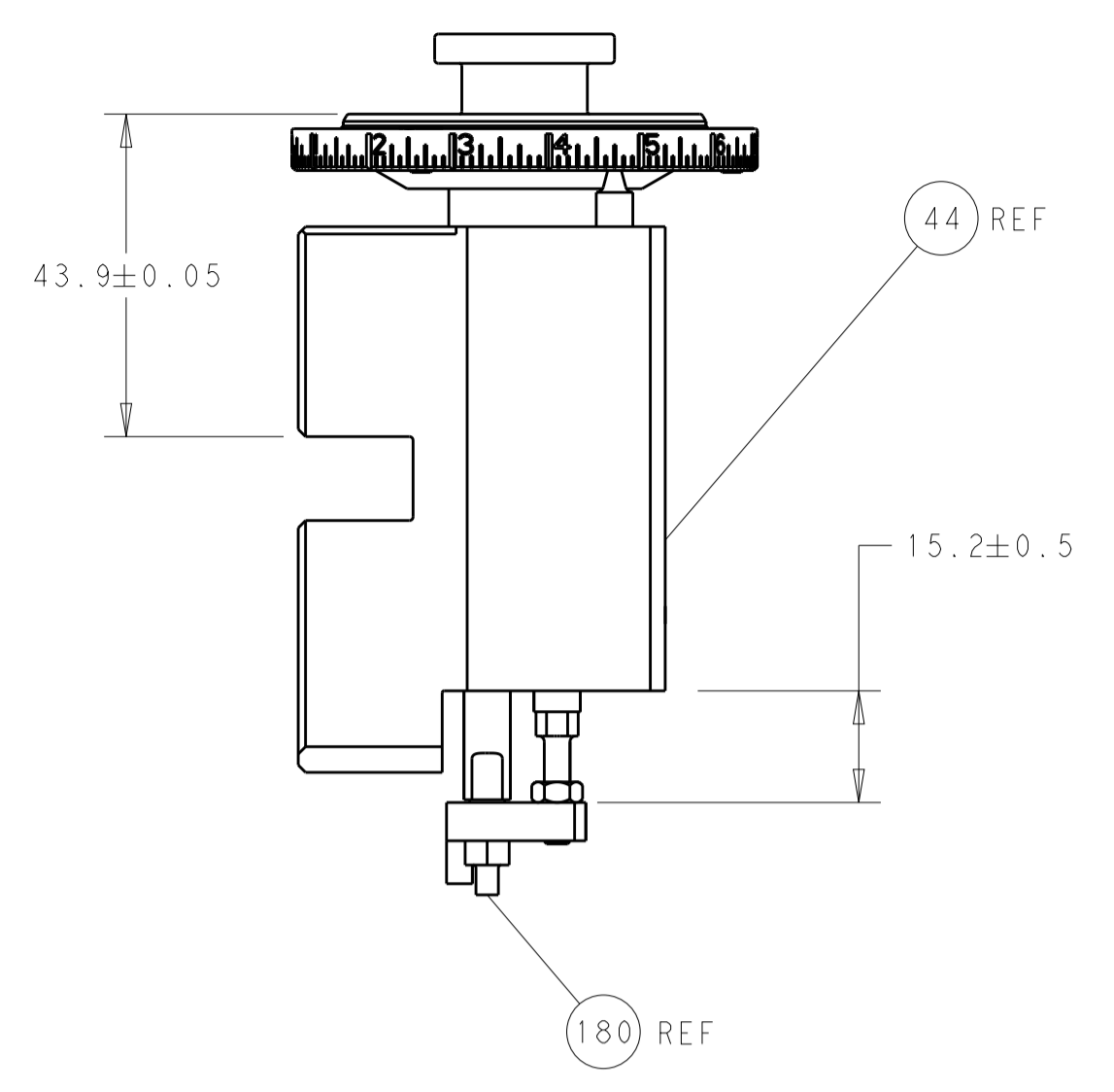
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	3		REDESIGNED	24FEB2016	BH	BH
		A		RELEASED	12APR2016	BH	BH
		B		ECR-18-017015	27OCT2018	TB	CT
		C		ECR-18-018902	04DEC2018	KH	LZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1	1-1976055-4	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	1	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	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	690495-7	PLATE, FRONT SHEAR	9	
1	2	2	1	1	4-1803059-0	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	2217206-5	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-240641-8	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	1-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	2	
1	2	2	1	1	7-1803188-6	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

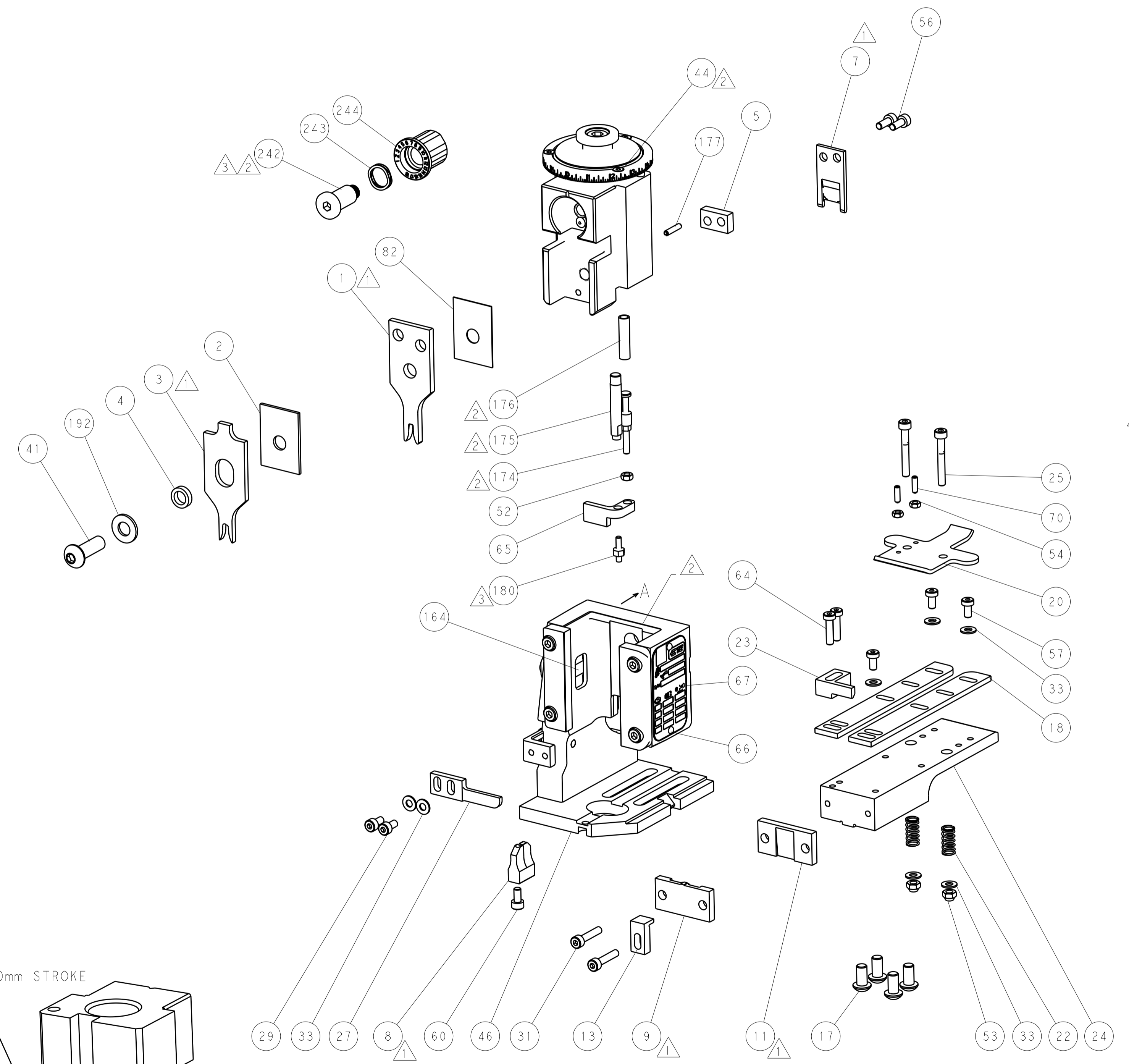
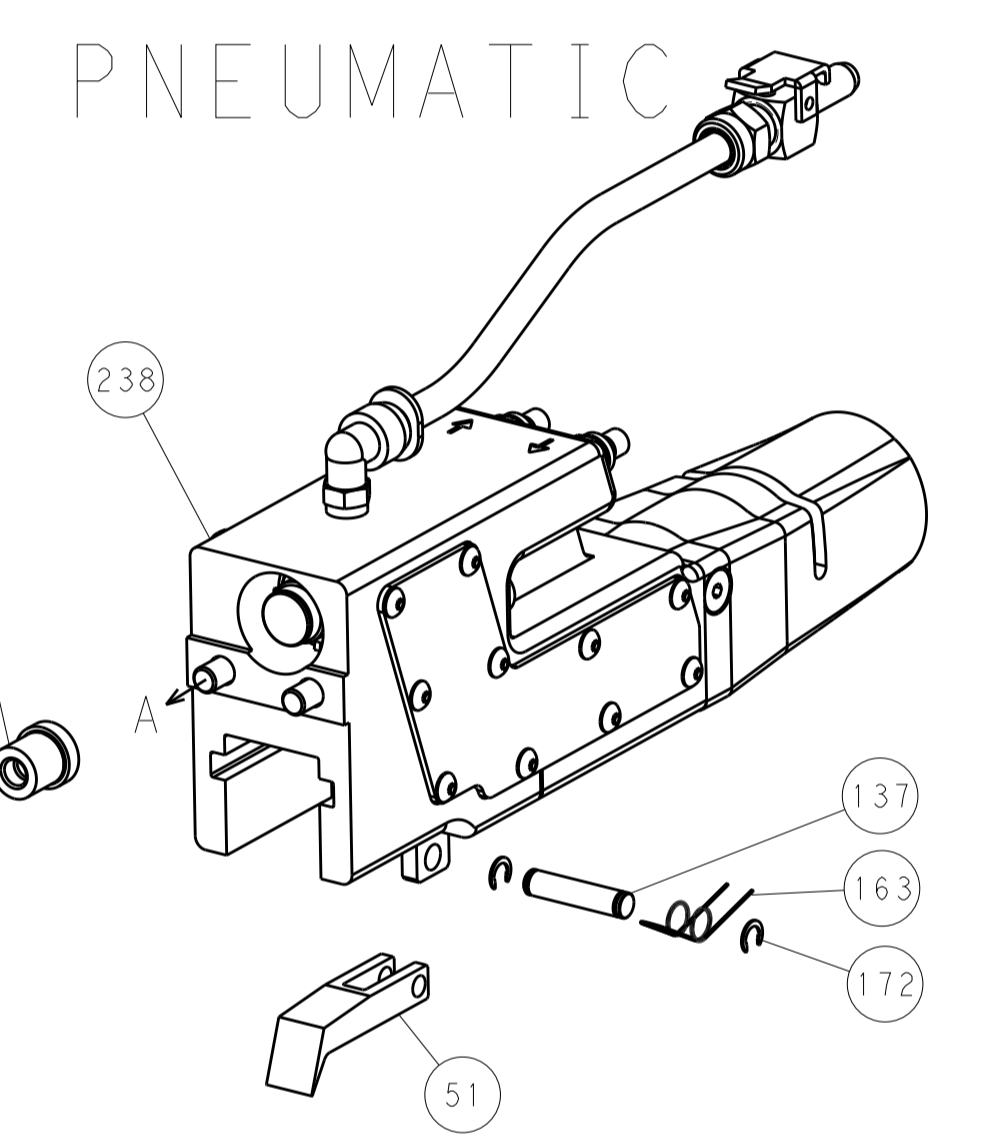
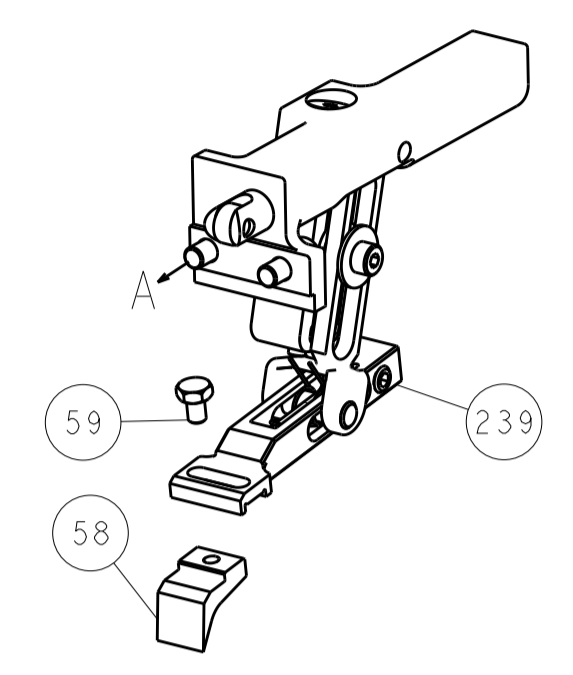
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 24FEB2016		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 24FEB2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T. ELBIN 24FEB2016		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
D		3 PLC ±		APPLICATION SPEC		A1 00779 C=2150169	
R		4 PLC ±		WEIGHT		SCALE: 1:1 SHEET 1 OF 4 REV C	
ANGLES		FINISH		Customer Accessible Production Drawing			

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

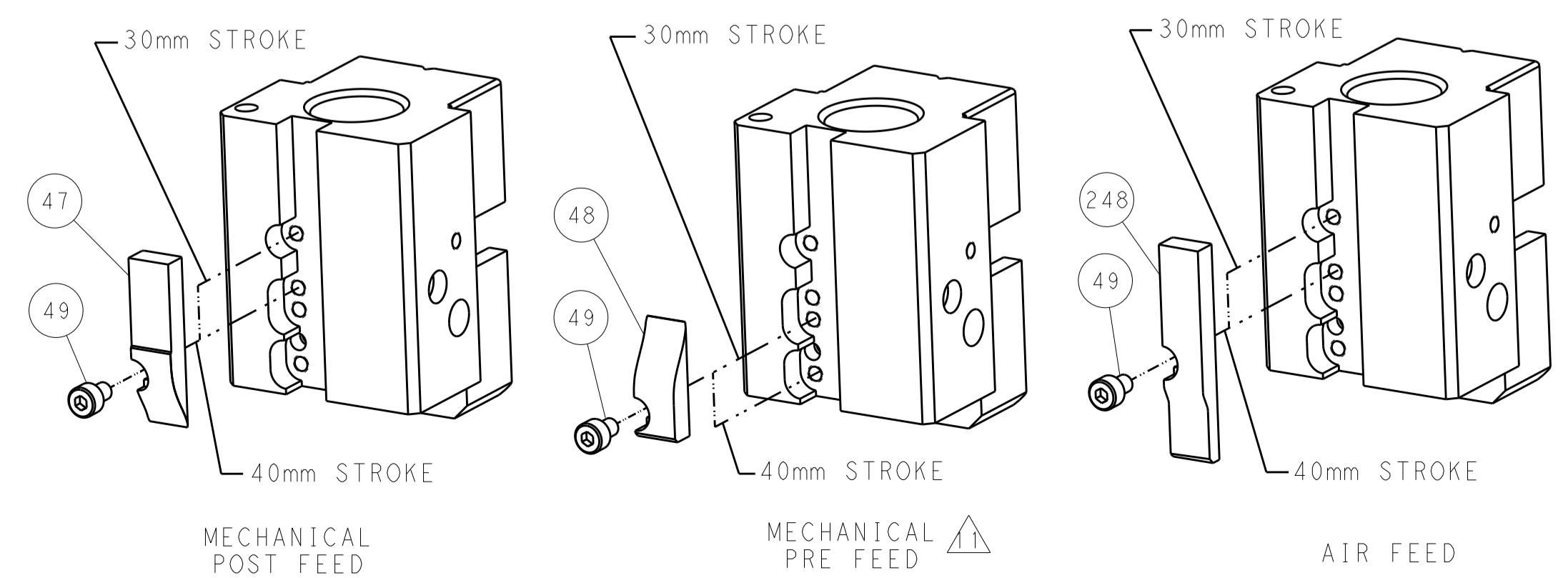


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

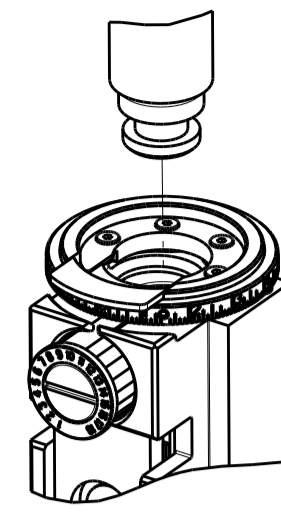


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 24FEB2016		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 24FEB2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T. ELBIN 24FEB2016		NAME: Ocean End Feed	
H		2 PLC ±		PRODUCT SPEC		Applicator	
D		3 PLC ±		APPLICATION SPEC		SIZE: CAGE CODE DRAWING NO	
R		4 PLC ±		WEIGHT		A1 00779 C=2150169	
ANGLES		FINISH		Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE: 1:1		SHEET 2 OF 4 REV C	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150169-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150169-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150169-7	A	CRIMP TOOLING KIT	-

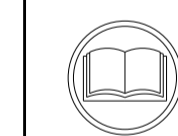
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.87 mm [1.113]	F
INSUL	3.94 mm [1.551]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: KET TERMINAL STIEBEL ELTRON CRIMP SPECIFICATION			
TERMINAL NAME: .250 CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [1.77-.217 IN]		2.48-3.30 mm [1.097-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
1949542-1	ST730135-1	1949542-3	ST730135-3
1949542-2	ST730135-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.02 [1.071+/-0.001]	8.8
15 AWG	1.80+/-0.02 [1.071+/-0.001]	8.8



- 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. 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.

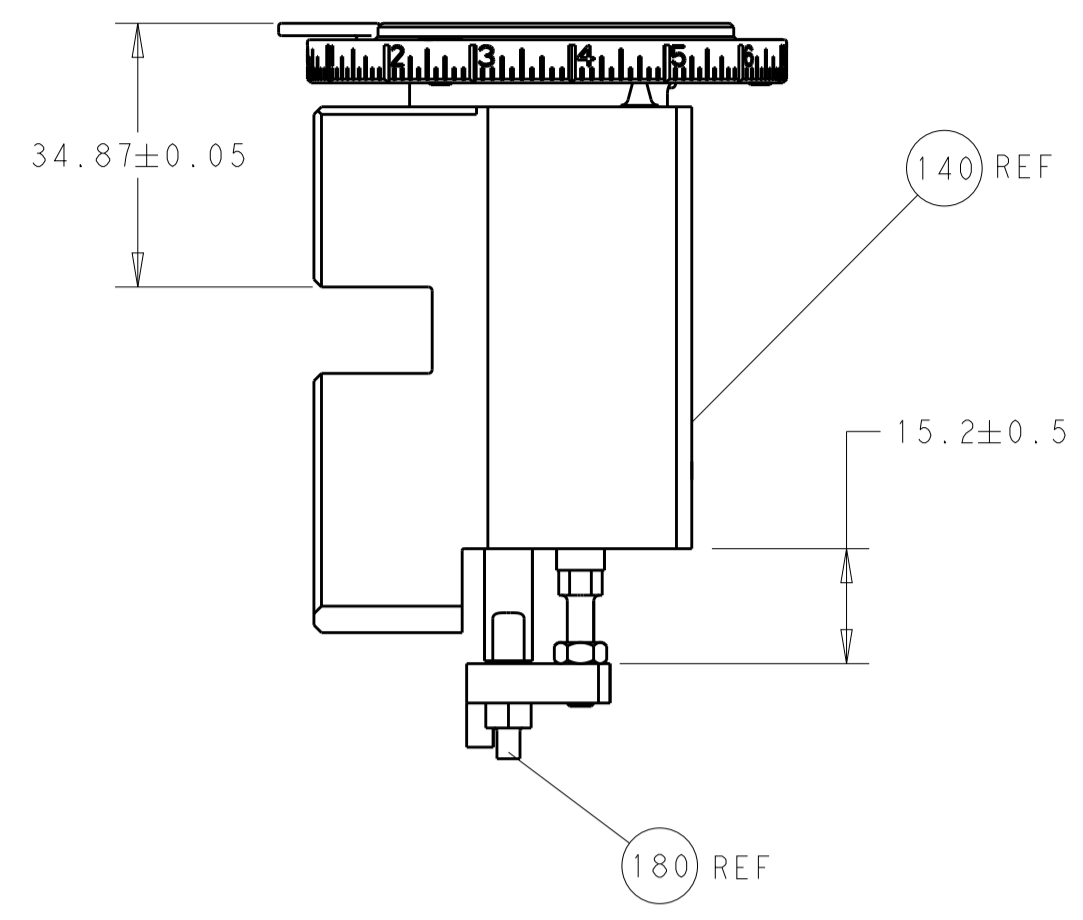
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					

REVISIONS						
REV	DATE	BY	CHKD	APVD	DESCRIPTION	DATE
-	-	-	-	-	SEE SHEET 1	-
-	1	1			2119640-1	PUSH ROD, AIR FEED
-	1	1			1803259-1	BUSHING, FLANGED
-	1	1			2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT
-	1	1			2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST
3	-	1			2119083-1	RETAINER, INSULATION DIAL
-	-	1			2119580-1	MECHANICAL FEED ASSEMBLY
-	1	-			2063440-1	AIR FEED MODULE
-	1	1			1-18028-0	WASHER, FLAT, REG M8
-	4	4			2079383-9	SCR, BHSC, RoHS (M6 X 20)
3	-	1			1-1976055-4	STANDOFF, HOLD-DOWN
-	1	1			6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0
-	1	1			8-22280-7	SPRING, COMPRESSION
-	1	1			1752353-2	GUIDE PIN, HOLDDOWN
-	1	1			1901680-2	GUIDE PIN, HOLDDOWN
-	2	2			21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT
-	REF	REF			994970-2	COUNTER, MAGNETIC
-	1	1			240638-1	SPRING, FEED FINGER
-	1	-			2119641-2	FEED CAM, AIR FEED
-	1	1			2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16
-	-	1			2119653-2	FEED CAM, POST FEED
-	1	1			2119655-6	APPLICATOR BASIC ASSEMBLY, EF
-	1	1			1803518-1	RAM ASSEMBLY, EF PACIFIC
-	1	1			3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854
-	1	1			455888-4	SPACER, CRIMPER
-	1	1			1803607-2	DOCUMENTATION PACKAGE
-	2	2			2-18032-2	SCR, SET, FLT PNT, M3 X 10.0
-	1	1			2119740-1	TAG, IDENTIFICATION
-	2	2			2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188
-	1	1			1901681-1	HOLDDOWN, TERMINAL
-	2	2			2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16
-	1	1			5-18022-5	SCR, HEX HD CAP, M4 X 6.0
-	-	1			2063961-1	FEED FINGER
-	3	3			2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8
-	2	2			1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10
-	2	2			5018030-1	NUT, HEX, REG, RoHS, M3
-	2	2			986965-8	NUT, LOCK, HEX, TORQUE (M4)
-	1	1			1-5018030-0	NUT, HEX, REG, RoHS, M3.5
-	1	-			2119792-2	PAWL, EF, AIR
-	1	2			18023-9	SCR, SKT HD CAP M4 X 6.0
-	-	1			2119652-1	FEED CAM, PRE FEED
-	1	1			1803602-1	SCR, BHSC, RoHS (M8 X 25)
-	7	7			1-18028-2	WASHER, FLAT, REG M4
-	2	2			2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20
-	2	2			2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0
-	1	1			240639-1	STRIPPER (MACHINING)
-	2	2			1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30
-	1	1			1752371-5	PLATE, STRIP GUIDE
-	1	1			240825-1	PLATE, STRIP HOLD DOWN
-	2	2			2-22281-3	SPRING, COMPRESSION
-	1	1			1803292-4	DRAG
-	2	2			1901259-6	GUIDE, LOWER STRIP
-	1	1			1752360-1	SPACER, HOLD-DOWN
1	-	1			240644-9	PLATE, REAR SHEAR
-	-	-			-	-
1	-	1			690495-7	PLATE, FRONT SHEAR
1	1	1			4-1803059-0	ANVIL, COMBINATION, END FEED
1	-	1			2217206-5	BLADE, SLUG
-	-	-			-	-
-	1	1			1-240641-8	SPACER
-	1	1			238011-2	BLOCK, CRIMPER SPACER
1	1	1			1-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM
-	1	1			1-455888-5	SPACER, CRIMPER
1	1	1			7-1803188-6	CRIMPER, WIRE
-	77	22	21		PART NO	DESCRIPTION
-	-	-	-		ITEM NO	

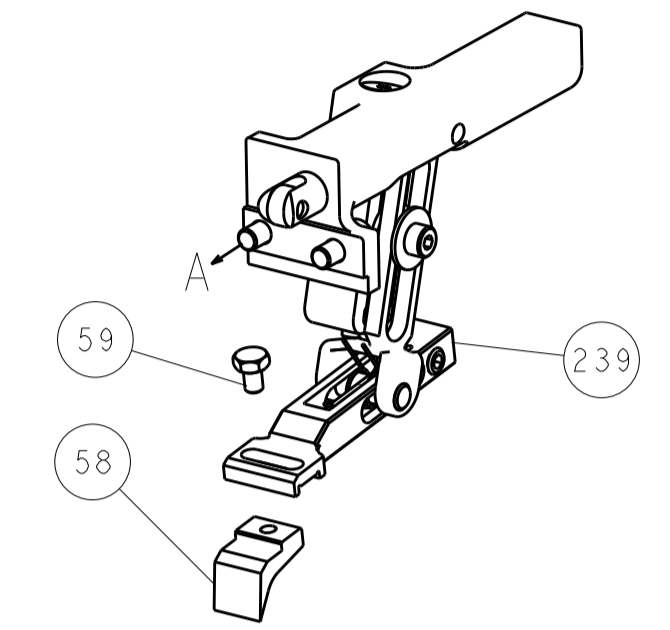
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0 PLC ±		1 PLC ±		CHK: T. ELBIN 24FEB2016		NAME: Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 24FEB2016		SIZE: A1	
4 PLC ±		ANGLES ±		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL: -		FINISH: -		APPLICATION SPEC		DRAWING NO: 2150169	
WEIGHT: -		SCALE: 1:1		REVISIONS: 3 OF 4		REV: C	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET: 3 OF 4		REV: C	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

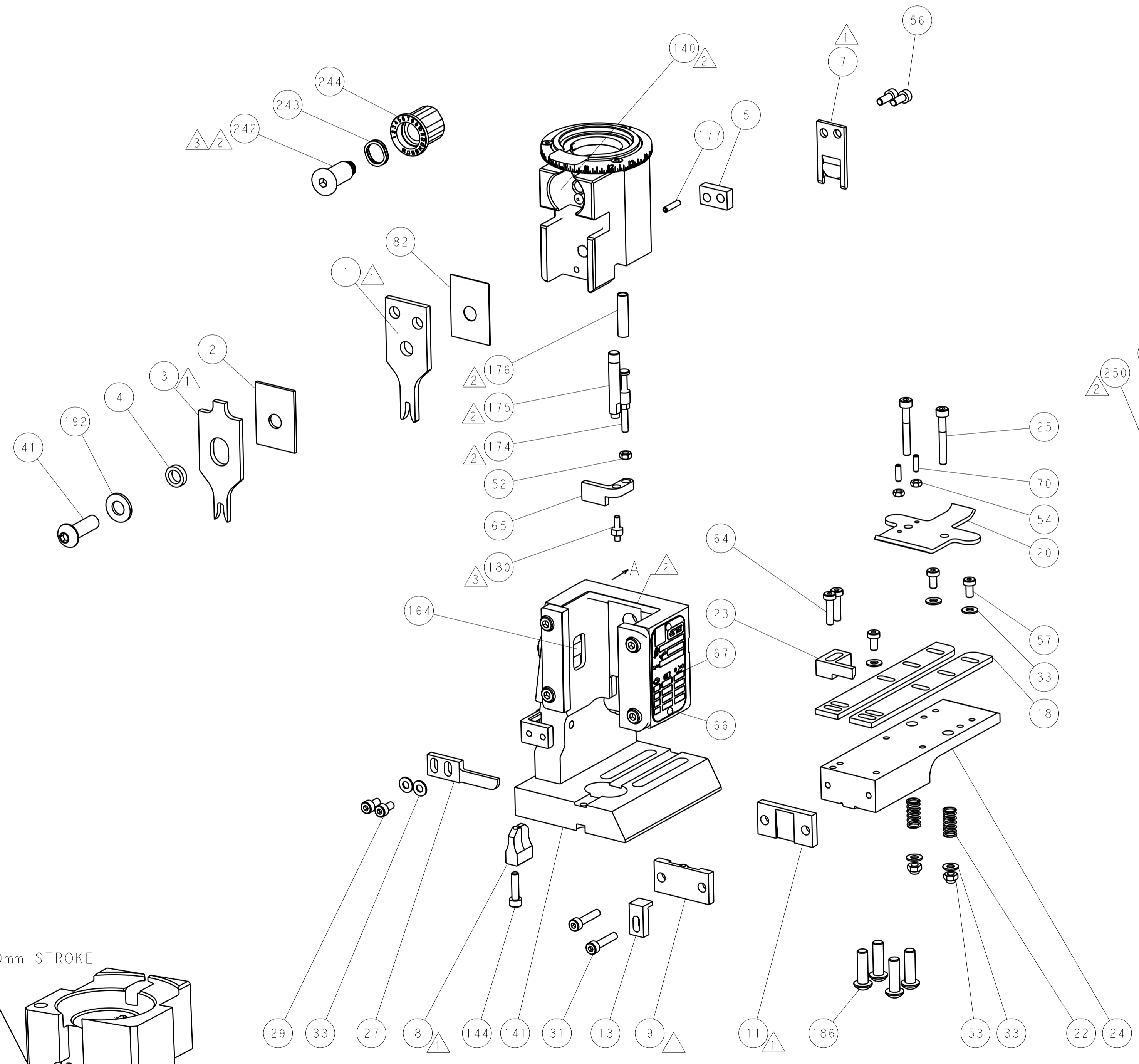
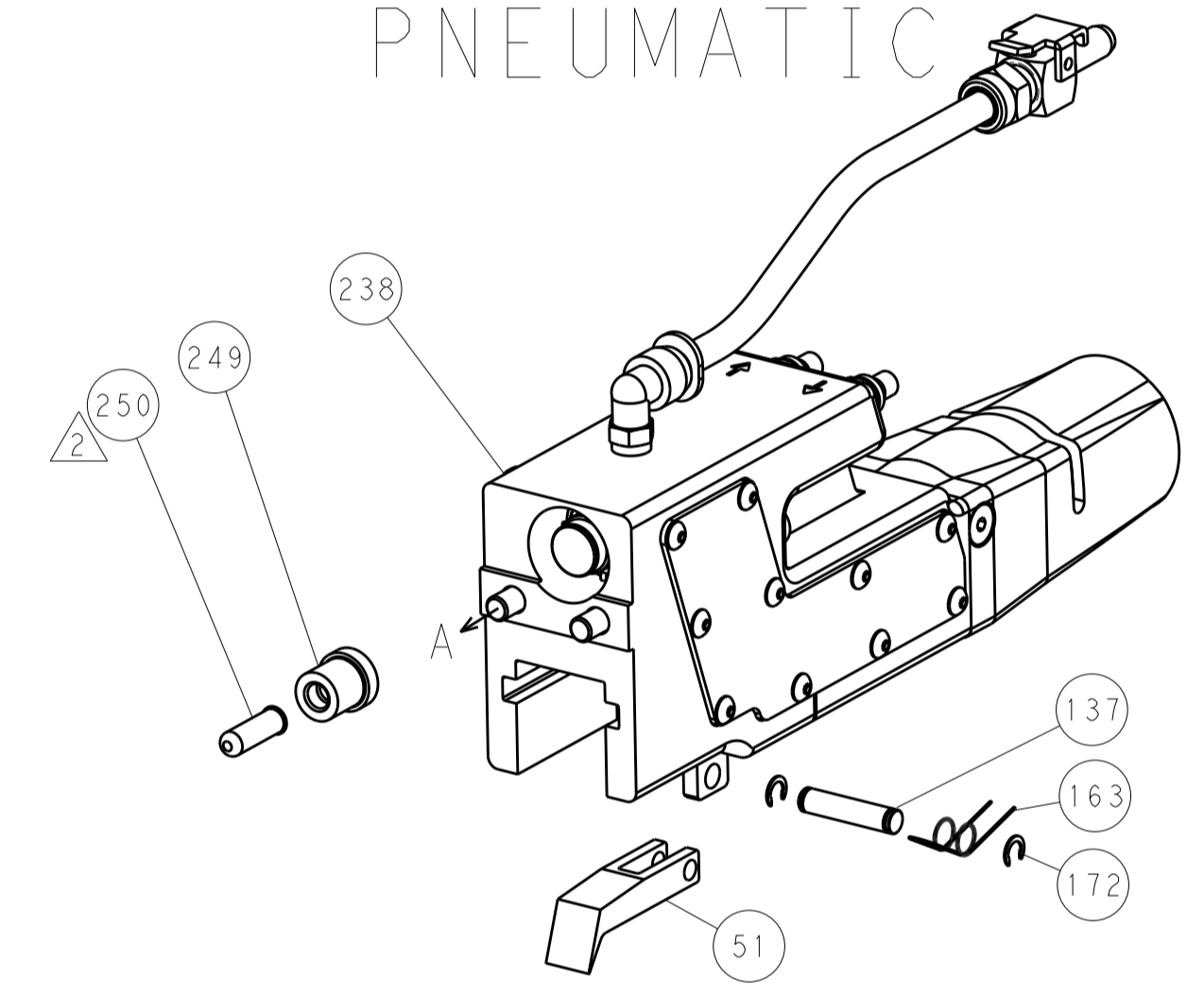


RAM AND HOLDDOWN SET-UP

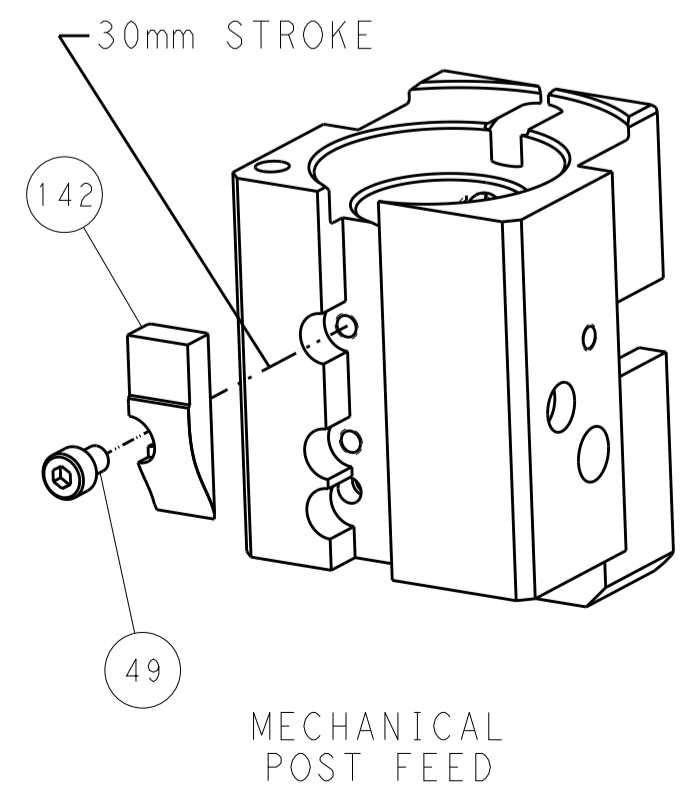
FEED TYPE
MECHANICAL



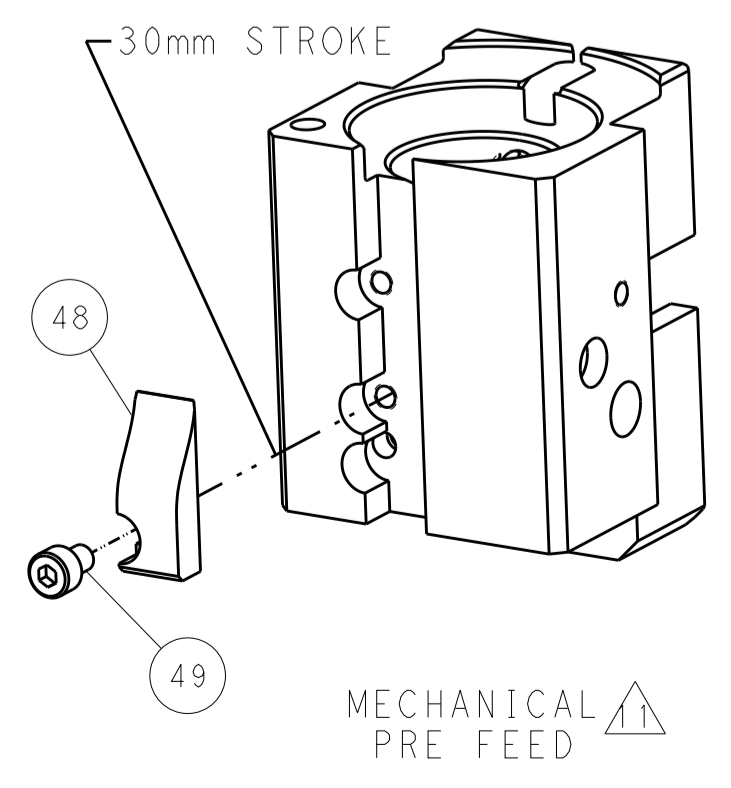
PNEUMATIC



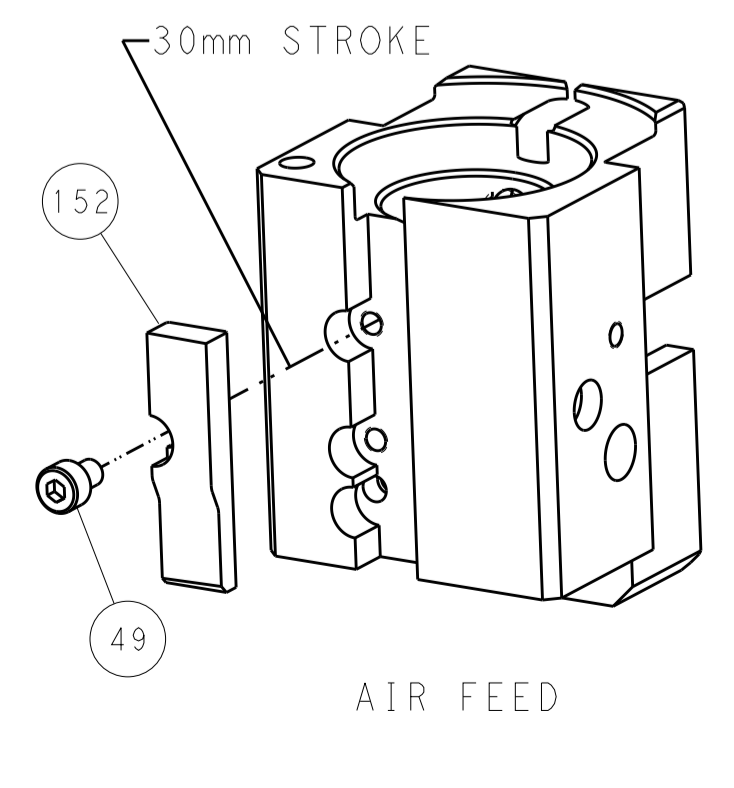
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 24FEB2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: T. ELBIN 24FEB2016		NAME: Ocean End Feed Applier	
MATERIAL:				PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				APPLICATION SPEC		A1 00779 ©=2150169	
				WEIGHT		SCALE: 1:1 SHEET 4 OF 4 REV C	
				Customer Accessible Production Drawing			