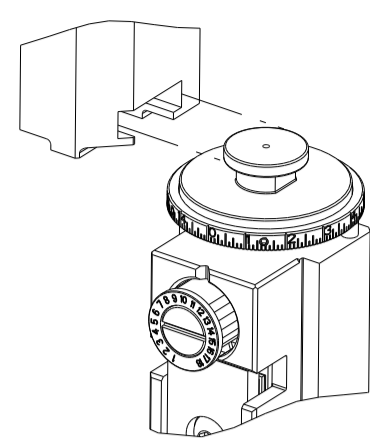


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2015	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150513-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150513-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150513-7	G	CRIMP TOOLING KIT	-

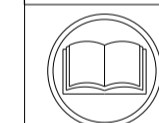
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	3.56 mm [.140]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON FLAG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm [.205-.235 IN]		∅2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2032	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62048-1	62048-2	63541-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.60 +/- 0.05 [.063 +/- .002]	5.0
16 AWG	1.40 +/- 0.05 [.055 +/- .002]	7.4
18 AWG	1.27 +/- 0.05 [.050 +/- .002]	8.7



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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.

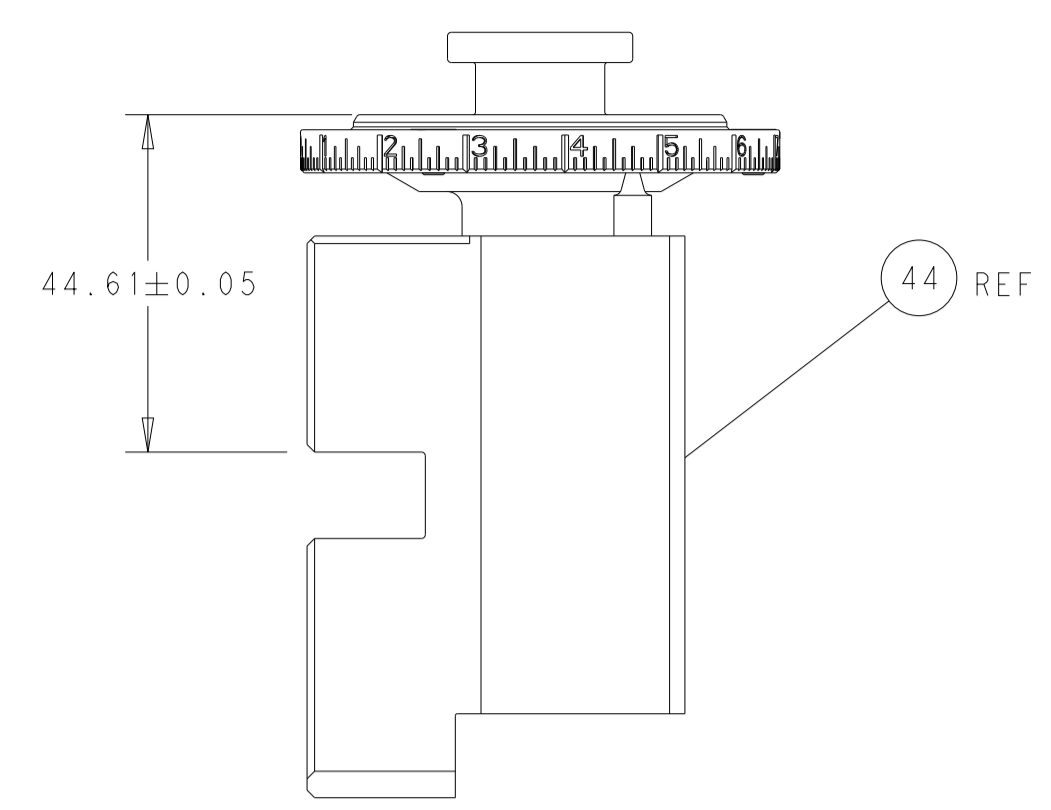
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-19-001342	25JAN2019	TB	TE
		E		ECR-21-002654	02MAR2021	JAH	RK
		F		ECR-21-109946	12AUG2021	JWC	RK
		G		ECR-23-173390	25APR2023	FZ	JAH

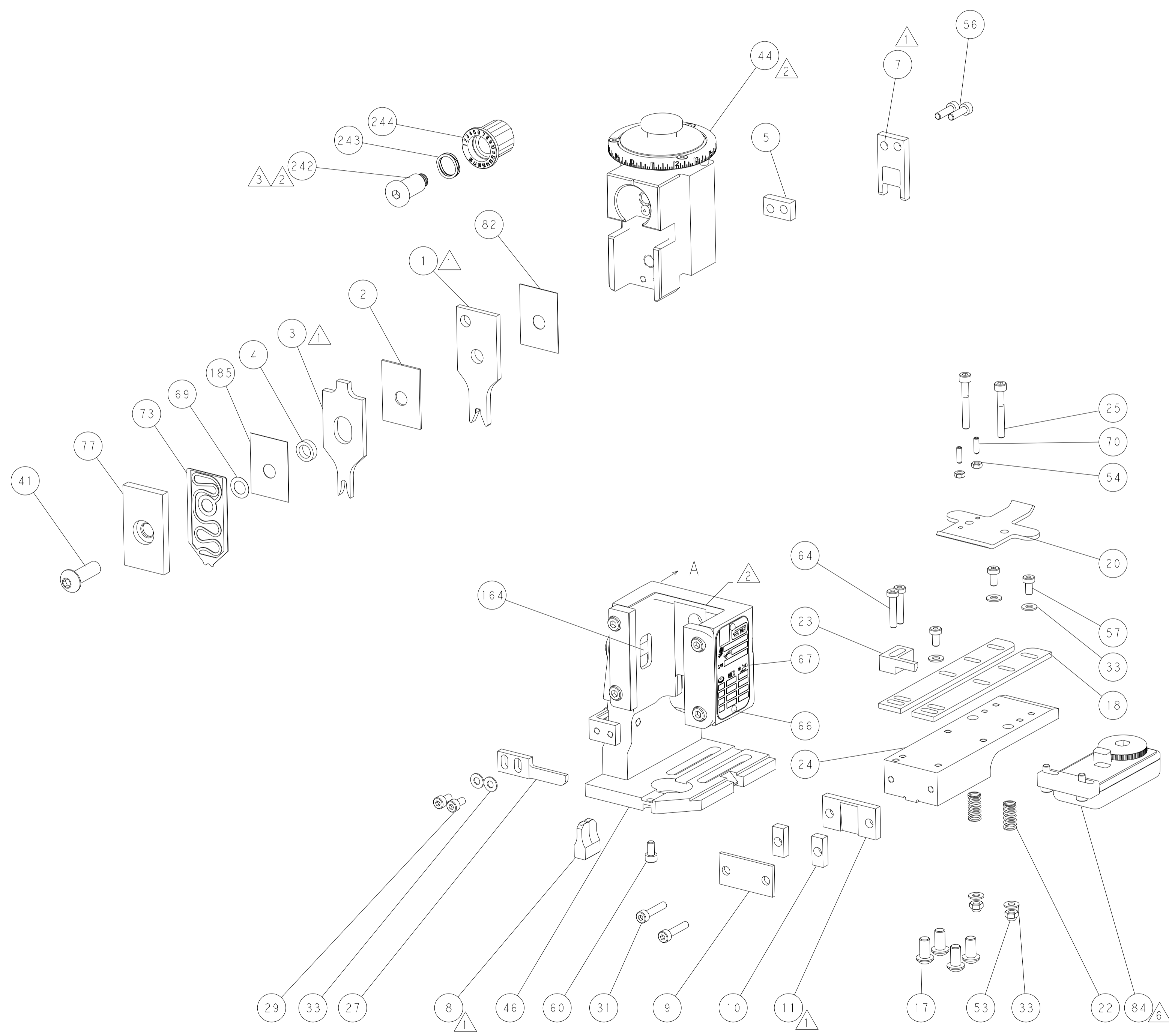
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
	-	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	2844940-4	AIR FEED MODULE	238		
-	1	1	455888-3	SPACER, CRIMPER	185		
-	REFREF		994970-2	COUNTER, MAGNETIC	164		
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	455888-4	SPACER, CRIMPER	82		
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77		
-	1	1	1-2119791-2	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		
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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		
-	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	1752371-2	PLATE, STRIP GUIDE	24		
-	1	1	240825-8	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	2	2	1901259-6	GUIDE, LOWER STRIP	18		
	-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
	-	1	240644-5	PLATE, REAR SHEAR	11		
	-	2	2-240645-4	SPACER, SHEAR PLATE	10		
	-	1	1-240642-0	PLATE, FRONT SHEAR	9		
	1	2	1	5-1803059-4	ANVIL, COMBINATION, END FEED	8	
	-	1	1	1-240651-9	BLADE, SLUG	7	
-	-	-	-	-	6		
-	1	1	1	1-240641-8	SPACER	5	
-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
	1	2	1	1633965-9	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1-455888-0	SPACER, CRIMPER	2	
	1	2	1	7-1633730-0	CRIMPER, WIRE	1	
-	77	72	-2	PART NO			
-				DESCRIPTION			ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER ZOMAR2014		TE Connectivity	
0 PLC ±		1 PLC ±		CHK: T. ELBIN ZOMAR2014		Harrisburg, PA 17105-3608	
2 PLC ±		3 PLC ±		APVD: T. ELBIN ZOMAR2014		NAME: Ocean End Feed Applicator	
4 PLC ±		ANGLES FINISH ±		PRODUCT SPEC		SIZE: A1	
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE: 00779	
				WEIGHT		DRAWING NO: 2150513	
				RESTRICTED TO		SCALE: 1:1	
				Customer Accessible Production Drawing		SHEET 1 OF 4	
				REV: G			

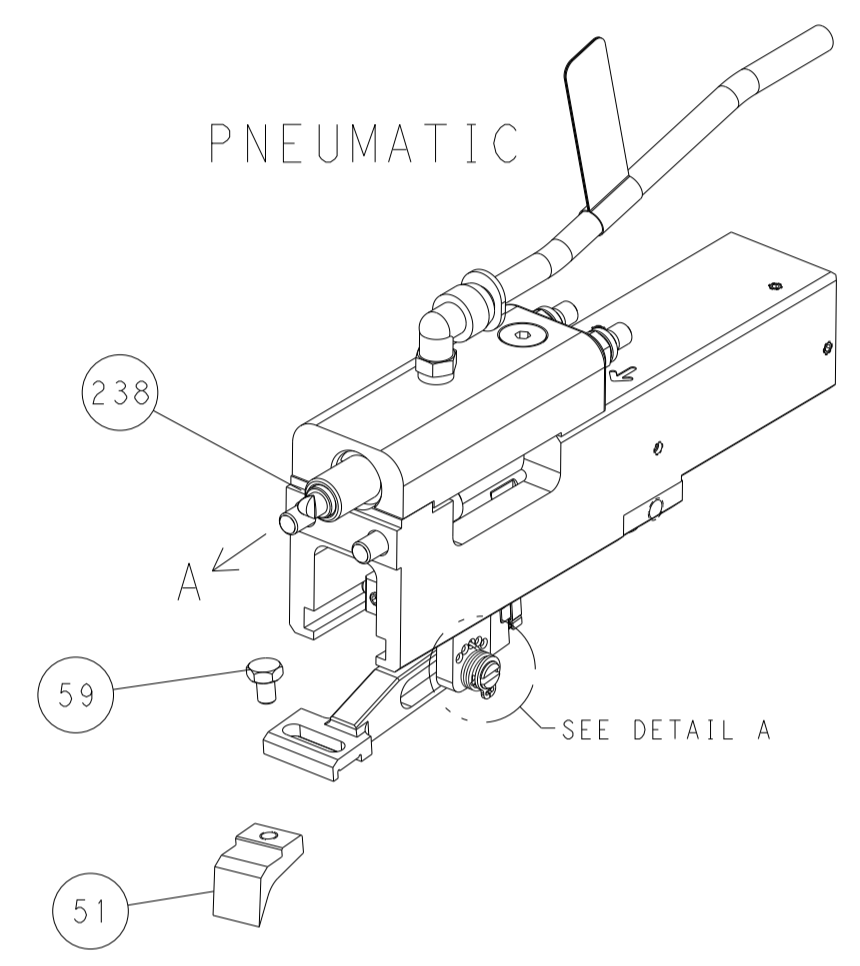
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1	-	-	-



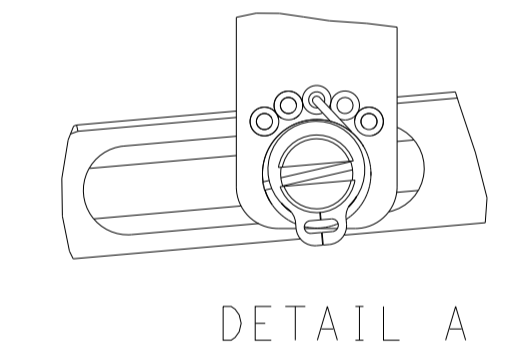
RAM SET-UP



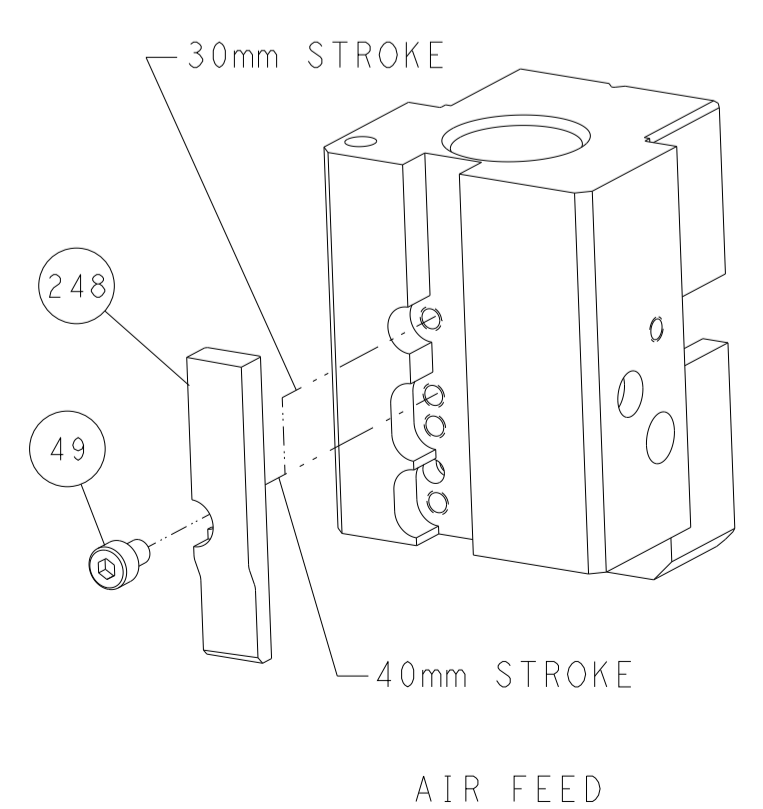
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



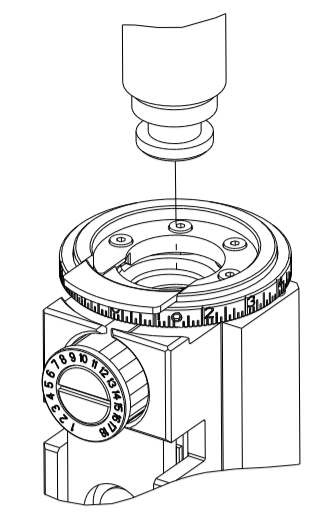
AIR FEED

**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 UNPUBLISHED. RELEASED FOR PUBLICATION 2015. COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER CHK: T. ELBIN APVD: T. ELBIN	ZOMAR2014 ZOMAR2014 ZOMAR2014	NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150513	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1 SHEET: 2 of 4 REV: G	RESTRICTED TO: -	Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150513-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150513-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	3.56 mm [.140]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON FLAG			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2032			
TERMINALS APPLIED			
TE TERMINAL 62048-1	TE TERMINAL 62048-2	TE TERMINAL 63541-1	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.60 +/- 0.05 [0.063 +/- .002]	5.0
16 AWG	1.40 +/- 0.05 [0.055 +/- .002]	7.4
18 AWG	1.27 +/- 0.05 [0.050 +/- .002]	8.7

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMIANL LUBRICANT IS RECOMMENDED.
- 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	REVISIONS				
		P	LTN	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

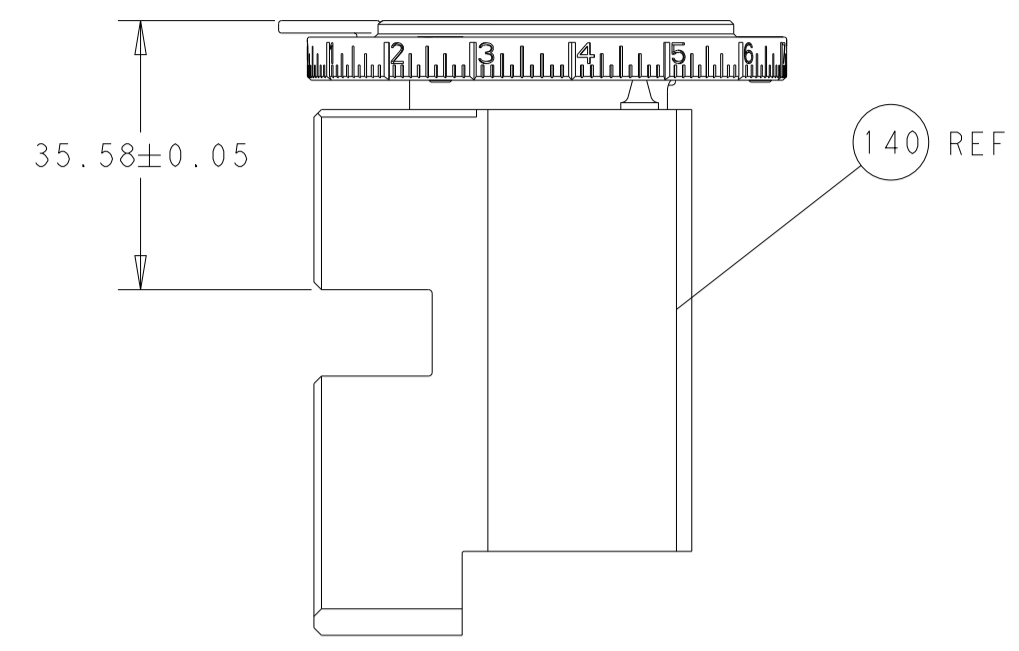
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	455888-3	SPACER, CRIMPER	185
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	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	455888-4	SPACER, CRIMPER	82
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1-2119791-2	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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
-	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	1752371-2	PLATE, STRIP GUIDE	24
-	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	240644-5	PLATE, REAR SHEAR	11
-	2	2-240645-4	SPACER, SHEAR PLATE	10
-	1	1-240642-0	PLATE, FRONT SHEAR	9
-	1	5-1803059-4	ANVIL, COMBINATION, END FEED	8
-	1	1-240651-9	BLADE, SLUG	7
-	-	-	-	6
-	1	1-240641-8	SPACER	5
-	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
-	1	7-1633730-0	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

OWN	CHEK	APVD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
B. WEAVER	ZOMAR2014	T. ELBIN	ZOMAR2014	A1	00779	2150513	-

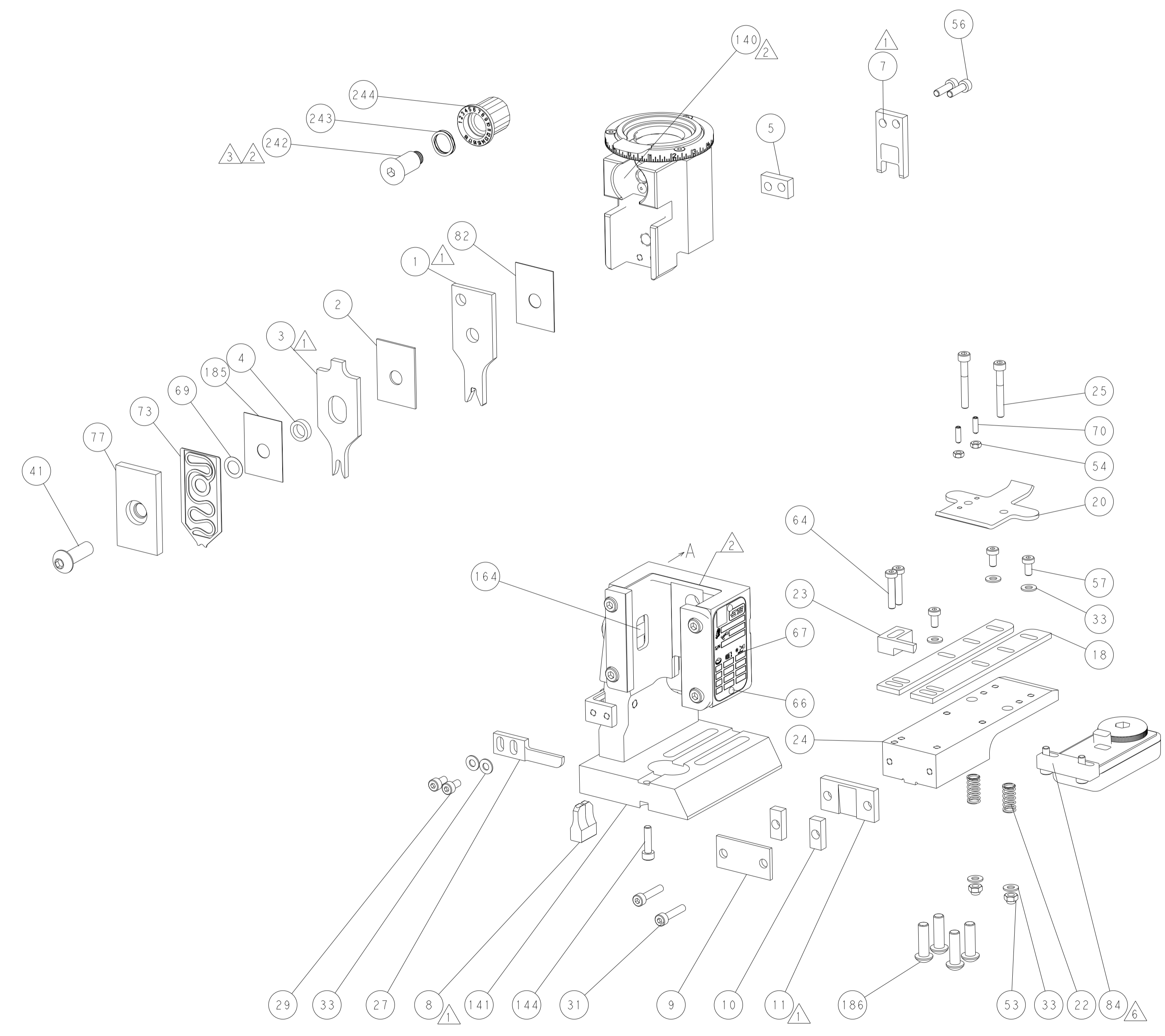
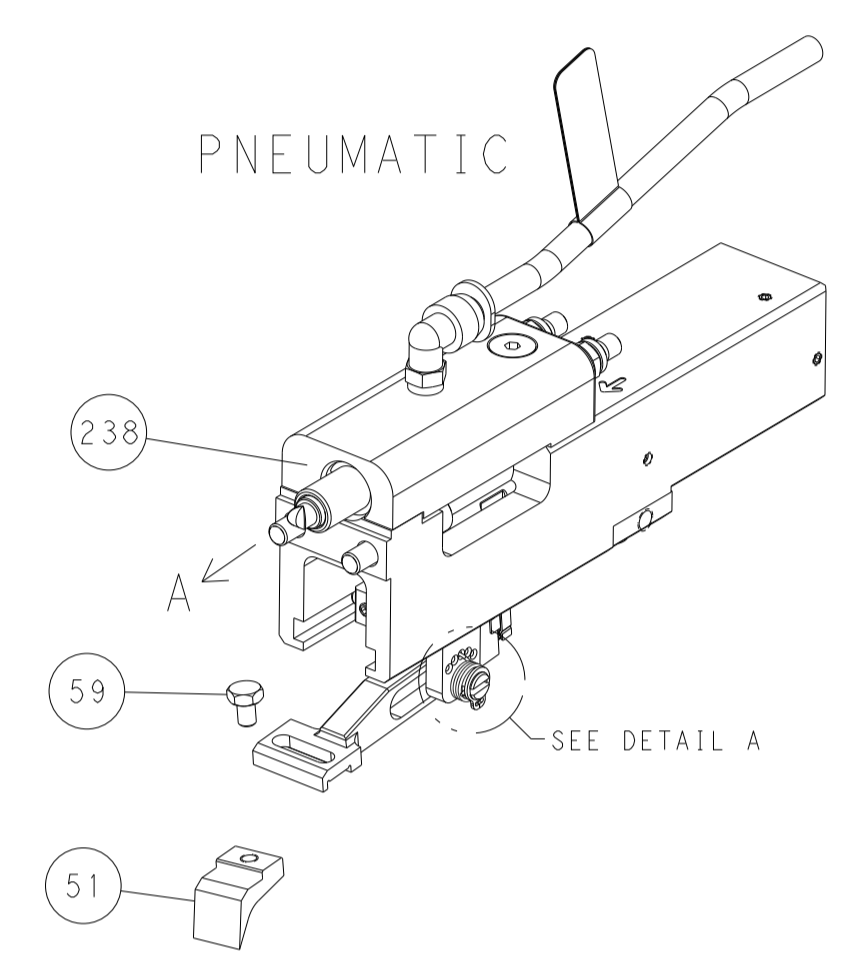
Customer Accessible Production Drawing SCALE 1:1 SHEET 3 OF 4 REV G

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-

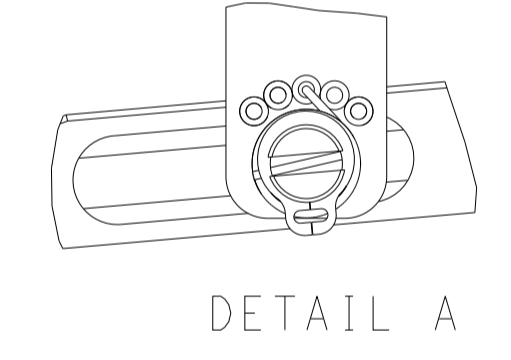


RAM SET-UP

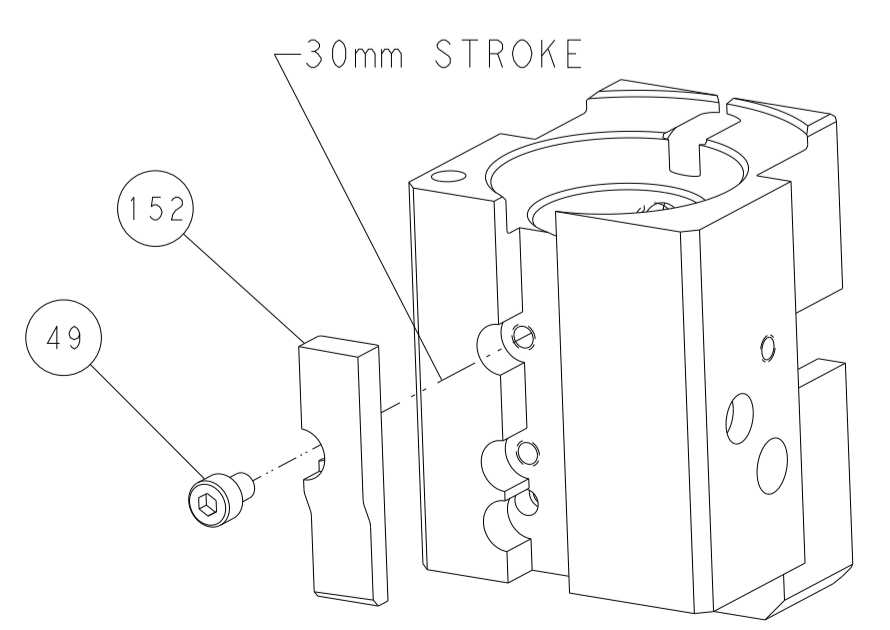
FEED TYPE



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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1 SHEET: 4 OF 4 REV: G	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	DATE: - DMN: - APVD: -	DATE: - DMN: - APVD: -	DATE: - DMN: - APVD: -