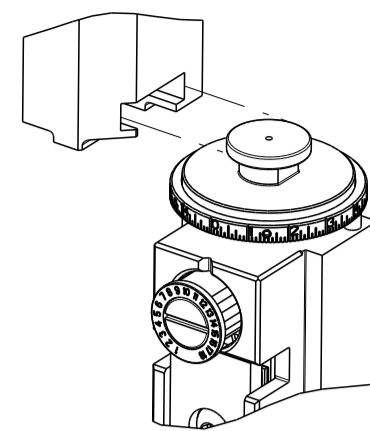


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150728-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150728-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150728-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150728-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150728-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.60 mm [.142]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES FLAG POS. LOCK RECEIPT.			
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]		INSULATION DIAMETER RANGE Ø1.50-2.80 mm [.059-.110 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5070			
TERMINALS APPLIED			
TE TERMINAL 172761-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm ²	1.61 +/- 0.05 [.063 +/- .002]	6.4
20 AWG OR 0.50mm ²	1.47 +/- 0.05 [.058 +/- .002]	8.0
22 AWG OR 0.30mm ²	1.41 +/- 0.05 [.056 +/- .002]	8.9

- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

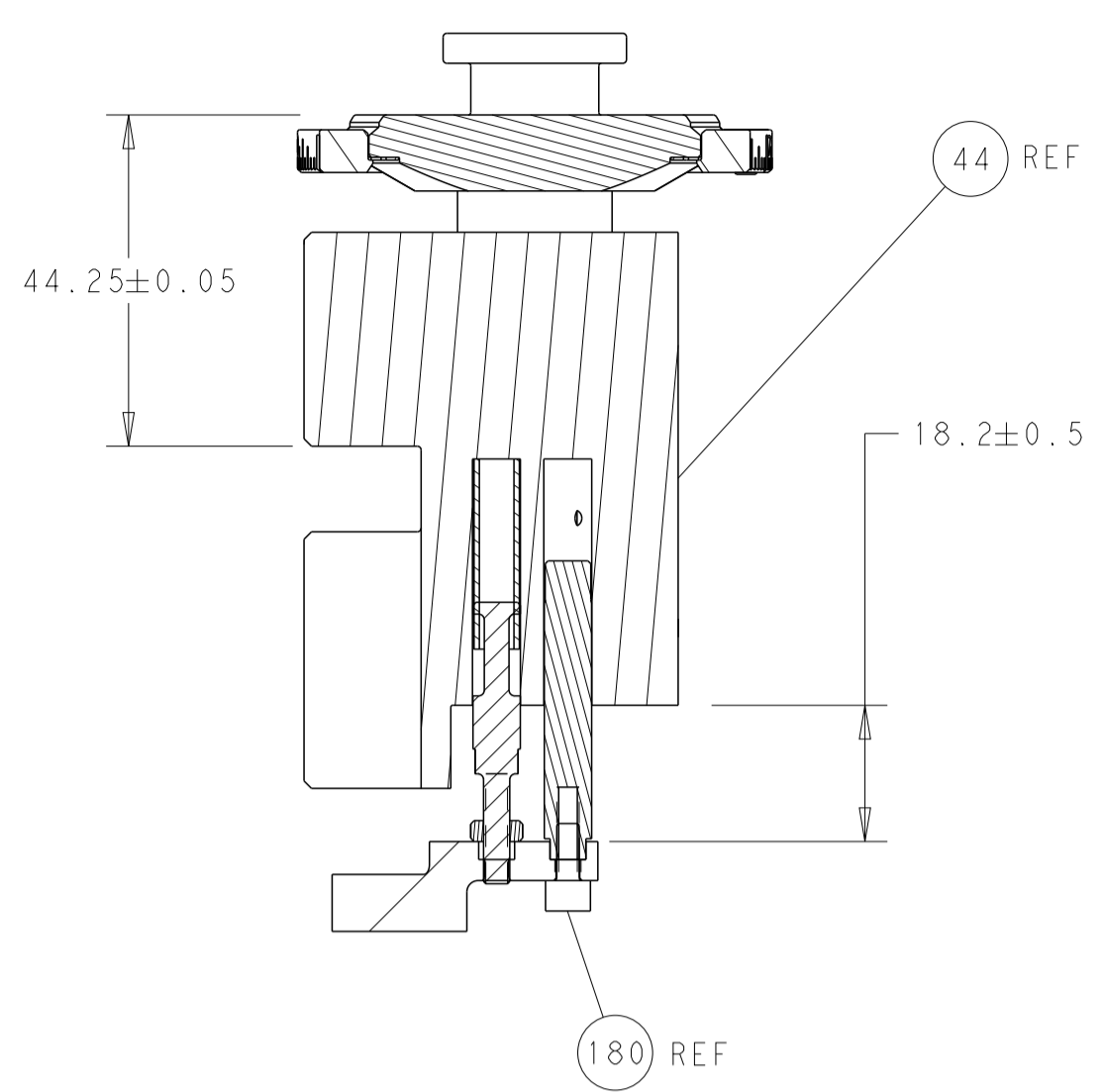
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		PRELIMINARY	14SEP2016	MEH	TE
		A		RELEASED	02DEC2016	MEH	TE
		B		ECR-19-011034	13JUL2019	TB	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	1	1	1	1	1803176-2	HOLDDOWN, TERMINAL	182	
3	-	1	1	1	1752354-1	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-6	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	2063961-1	FEED FINGER	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	1-2119655-7	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	
-	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	36	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-2	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	2161922-8	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1	1	1-1633168-2	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-4	DRAG, STOCK	20	
-	1	1	1	1	1803086-6	GUIDE, REAR STRIP	19	
-	1	1	1	1	8-1901695-7	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1803175-2	SUPPORT, TERMINAL	13	
1	-	1	1	1	461160-1	PLATE, REAR SHEAR	11	
-	2	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10	
1	-	1	1	1	1-455961-2	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	6-1803059-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1803186-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-238011-9	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1803108-7	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456405-4	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

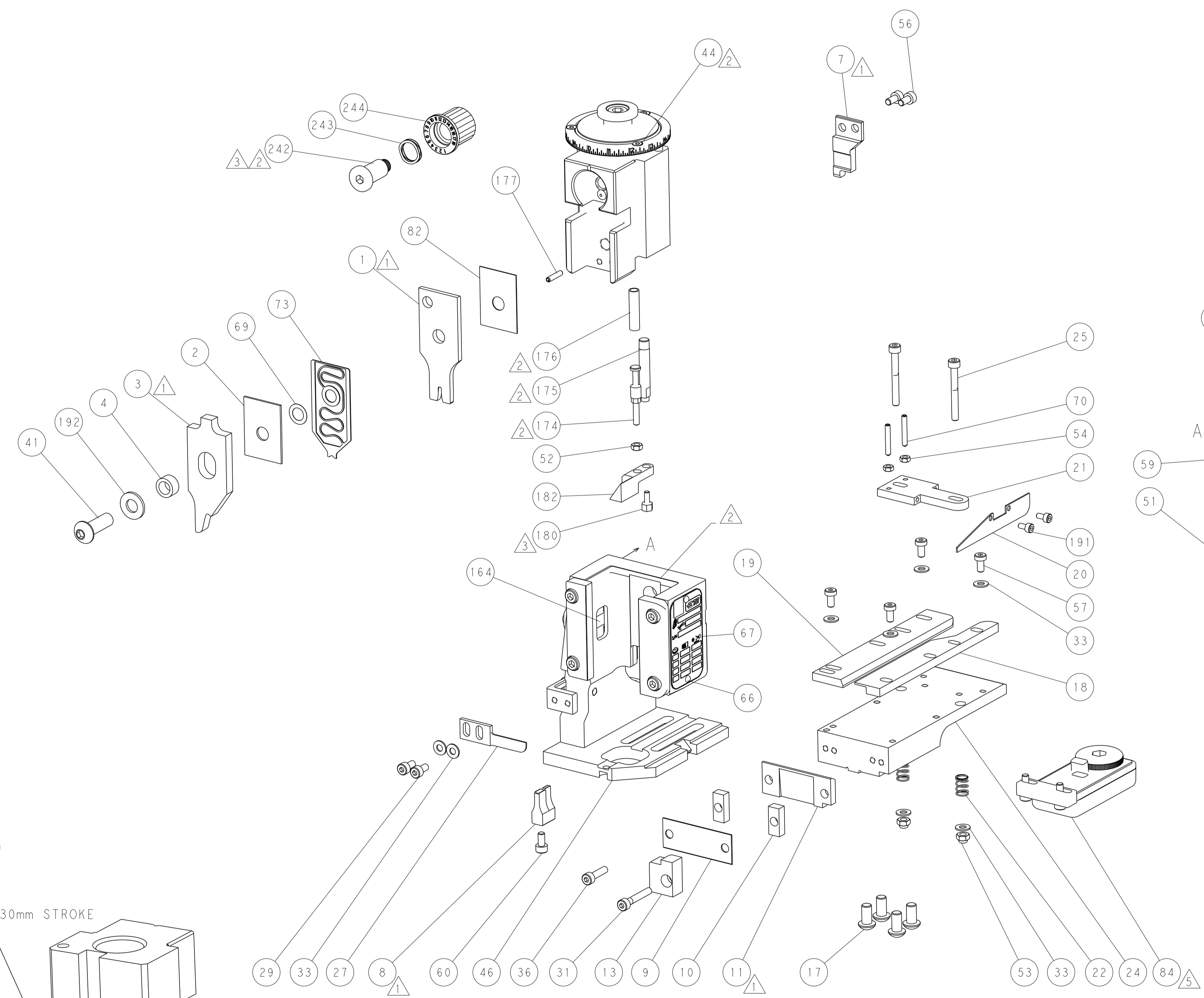
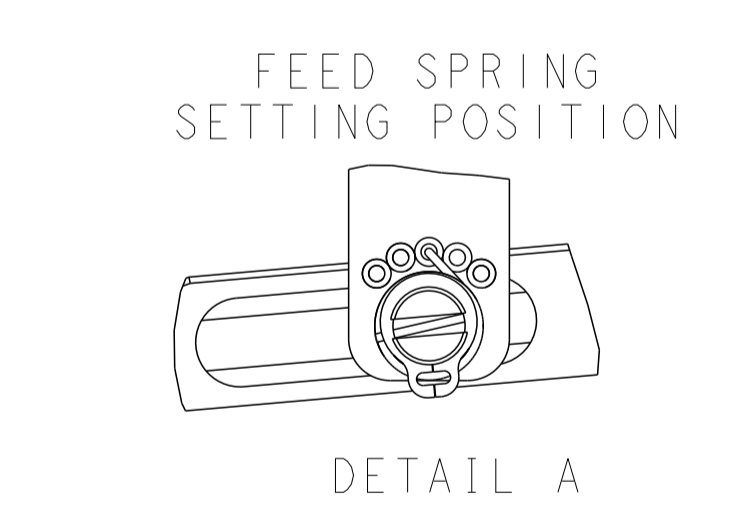
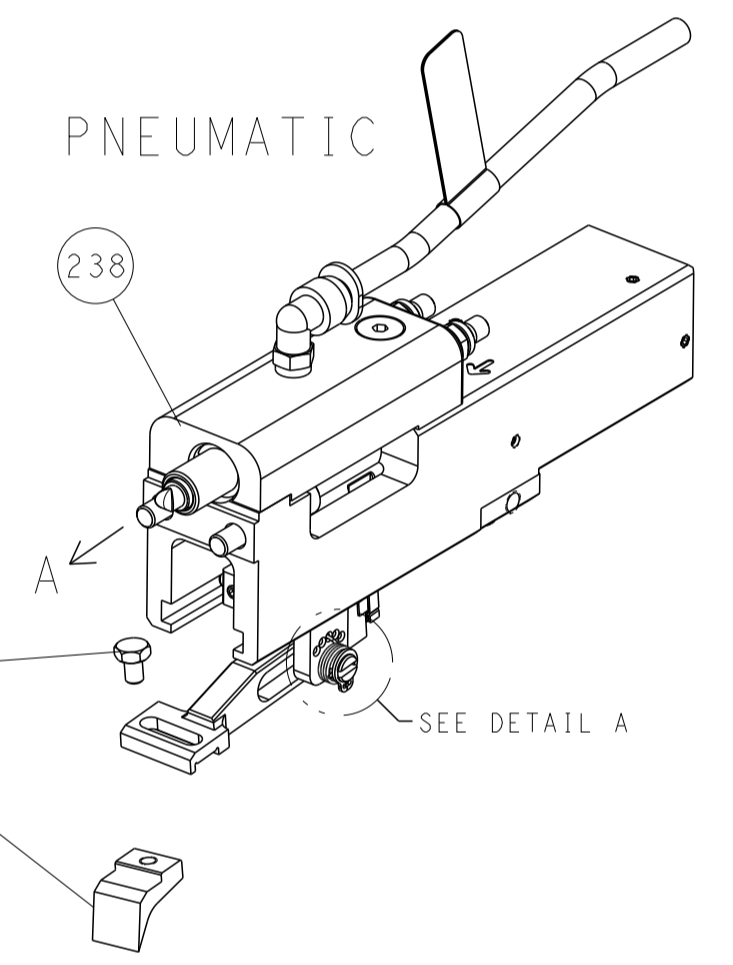
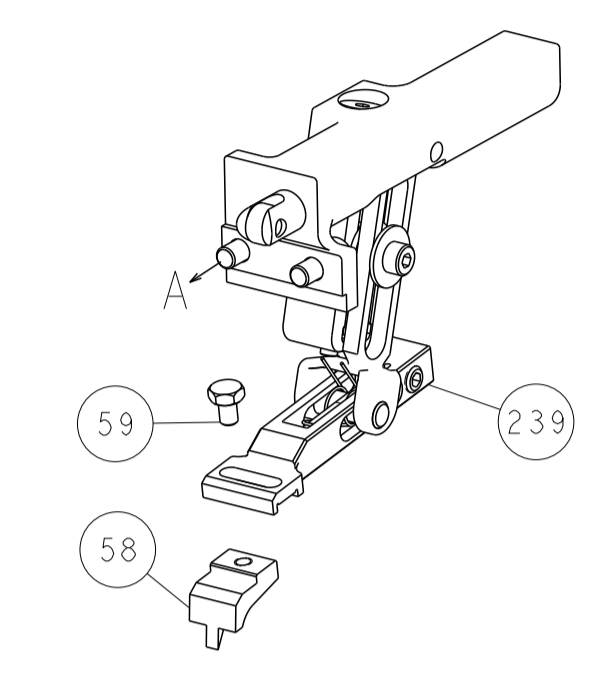
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	M. HERR	14SEP2016	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	14SEP2016	Ocean End Feed Applicator	
MATERIAL	FINISH	WEIGHT	SCALE	APVD	NAME	SIZE	CAGE CODE
			1:1	T. ELBIN		A1	00779
			SHEET	PRODUCT SPEC			1
			OF	APPLICATION SPEC			4
			REV				B

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

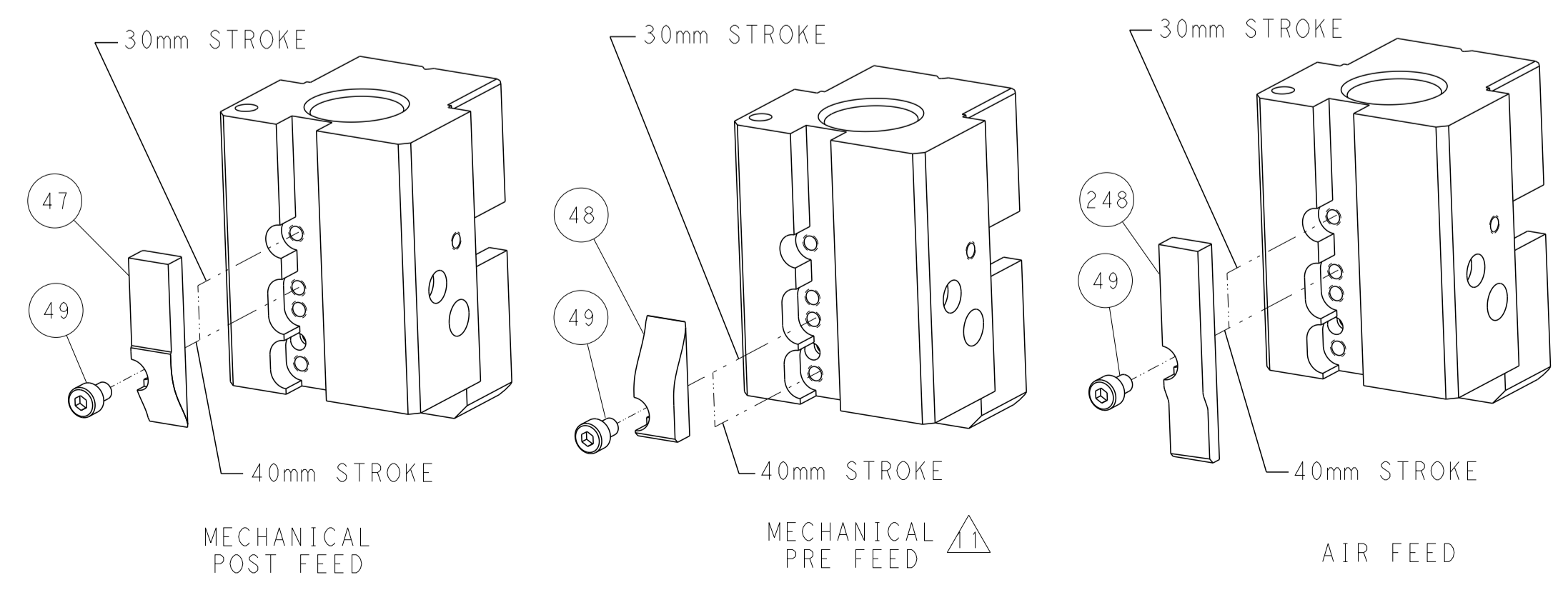


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

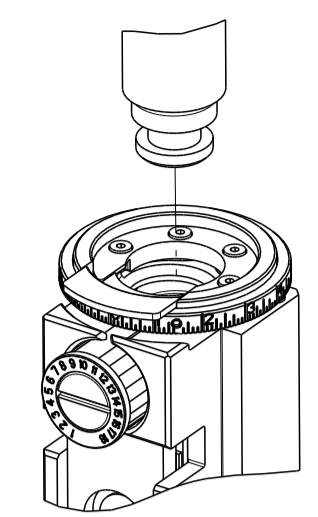


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN M_HERR 14SEP2016 CHK T_ELBIN 14SEP2016 APVD T_ELBIN 14SEP2016 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150728 SCALE 1:1 SHEET 2 OF 4 REV B		RESTRICTED TO - SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150728-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150728-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150728-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.60 mm [1.42]	Ø

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 250 SERIES FLAG POS. LOCK RECEPT.

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.50-5.50 mm [1.177-.217 IN]	Ø1.50-2.80 mm [1.059-.110 IN]

TERMINAL APPLICATION SPECIFICATION 114-5070

TERMINALS APPLIED 5

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172761-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4
18 AWG OR 0.75mm ²	1.61+/-0.05 [1.063+/-0.002]	6.4
20 AWG OR 0.50mm ²	1.47+/-0.05 [1.058+/-0.002]	8.0
22 AWG OR 0.30mm ²	1.41+/-0.05 [1.056+/-0.002]	8.9

- 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 LUBRICANT IS RECOMMENDED.
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.

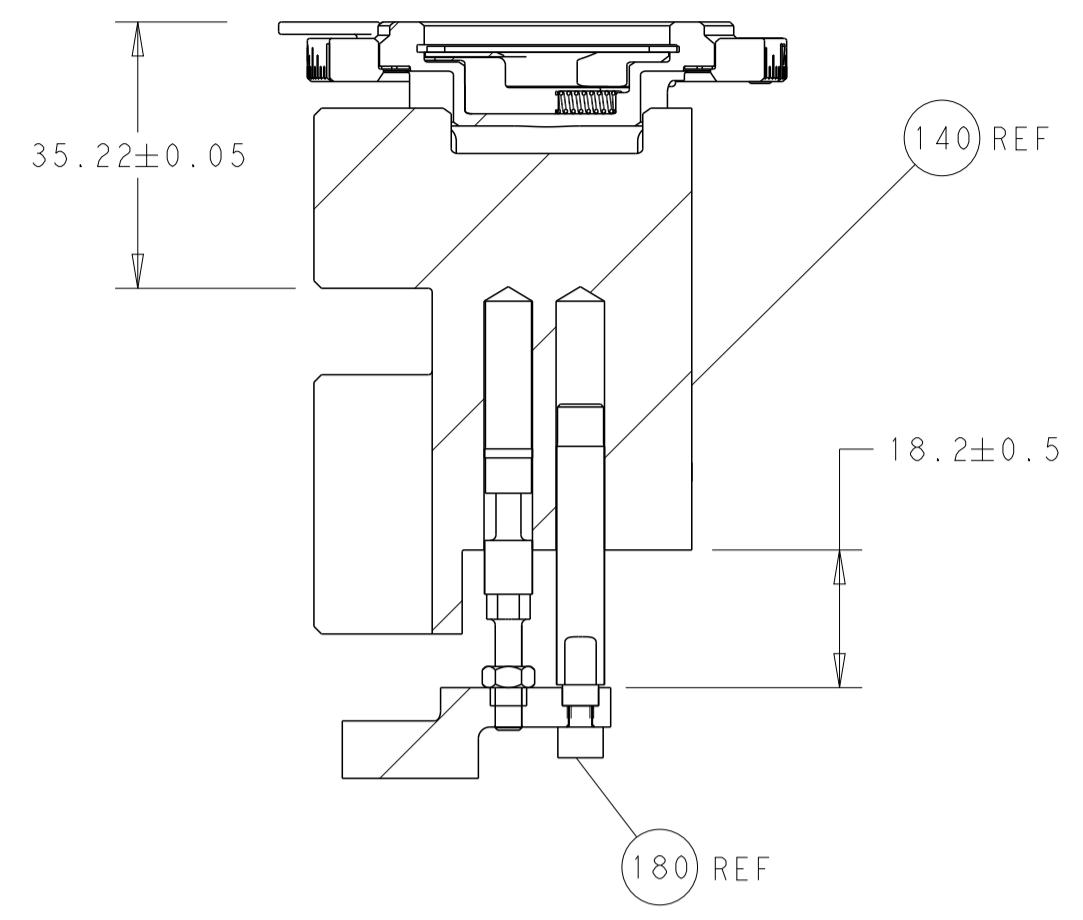
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	1803176-2	HOLDDOWN, TERMINAL	182
3	-	1	1752354-1	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	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-6	FEED FINGER	58
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	2063961-1	FEED FINGER	51
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	36
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-2	STRIPPER (MACHINING)	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-8	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1-1633168-2	ARM, STOCK DRAG	21
-	1	1	464452-4	DRAG, STOCK	20
-	1	1	1803086-6	GUIDE, REAR STRIP	19
-	1	1	8-1901695-7	STRIP GUIDE, FRONT	18
-	1	1	1803175-2	SUPPORT, TERMINAL	13
1	-	1	461160-1	PLATE, REAR SHEAR	11
-	2	2	1-240645-9	SPACER, SHEAR PLATE	10
1	-	1	1-455961-2	PLATE, FRONT SHEAR	9
1	1	1	6-1803059-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1803186-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1803108-7	CRIMPER, INSULATION O	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1-456405-4	CRIMPER, WIRE PREMIUM	1
-	77-22-21	-	PART NO	DESCRIPTION	ITEM NO

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

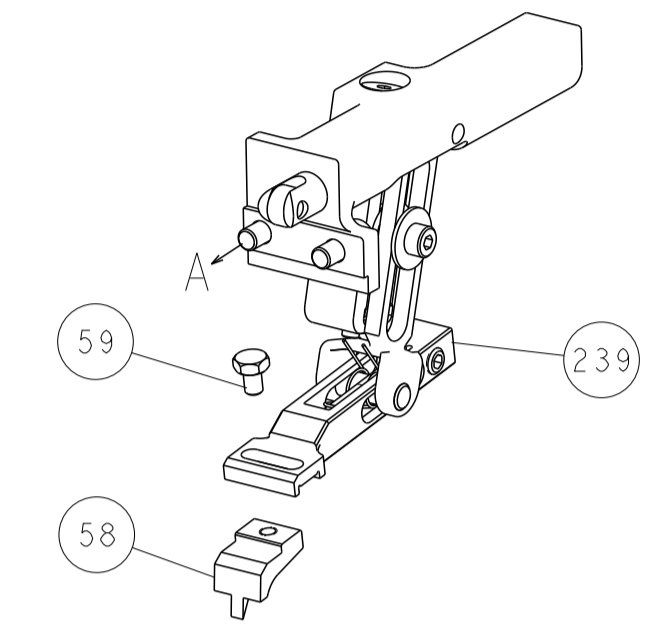
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2 PLC ±		3 PLC ±		APPLICATION SPEC: -		CAGE CODE: 00779		DRAWING NO: 2150728	
4 PLC ±		ANGLES: ±		WEIGHT: -		SCALE: 1:1		SHEET 3 OF 4	
FINISH: -		MATERIAL: -		RESTRICTED TO: -		Customer Accessible Production Drawing		REV B	

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

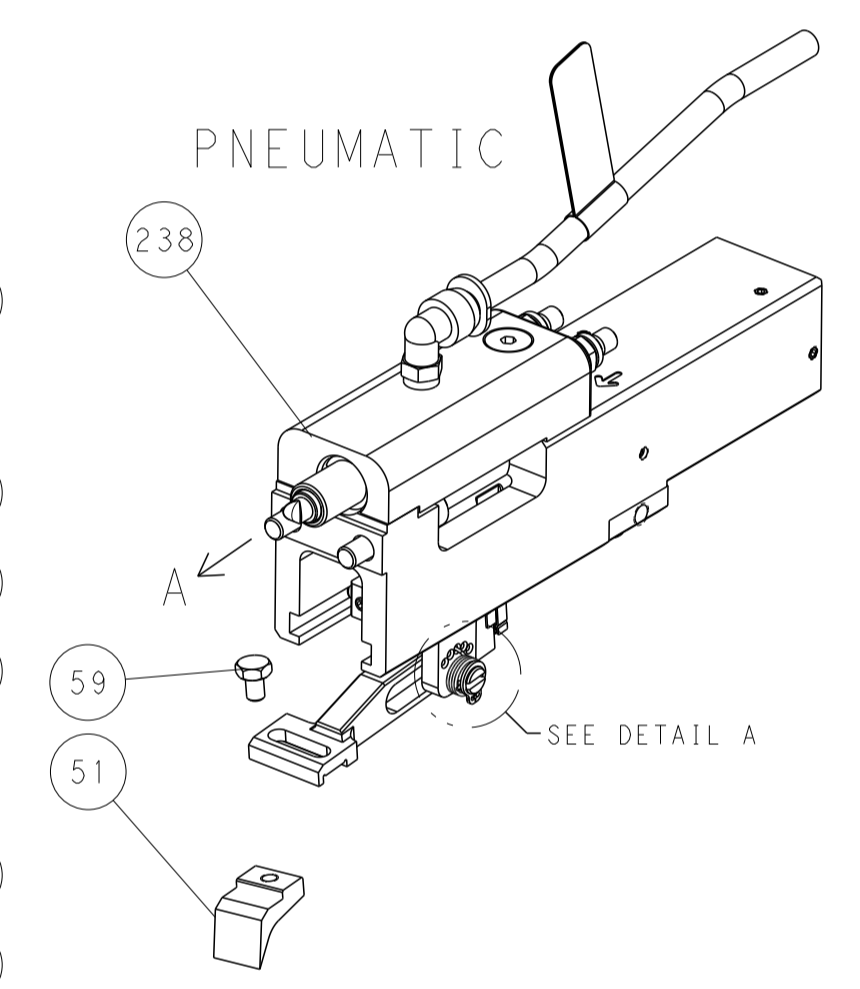


RAM AND HOLDDOWN SET-UP

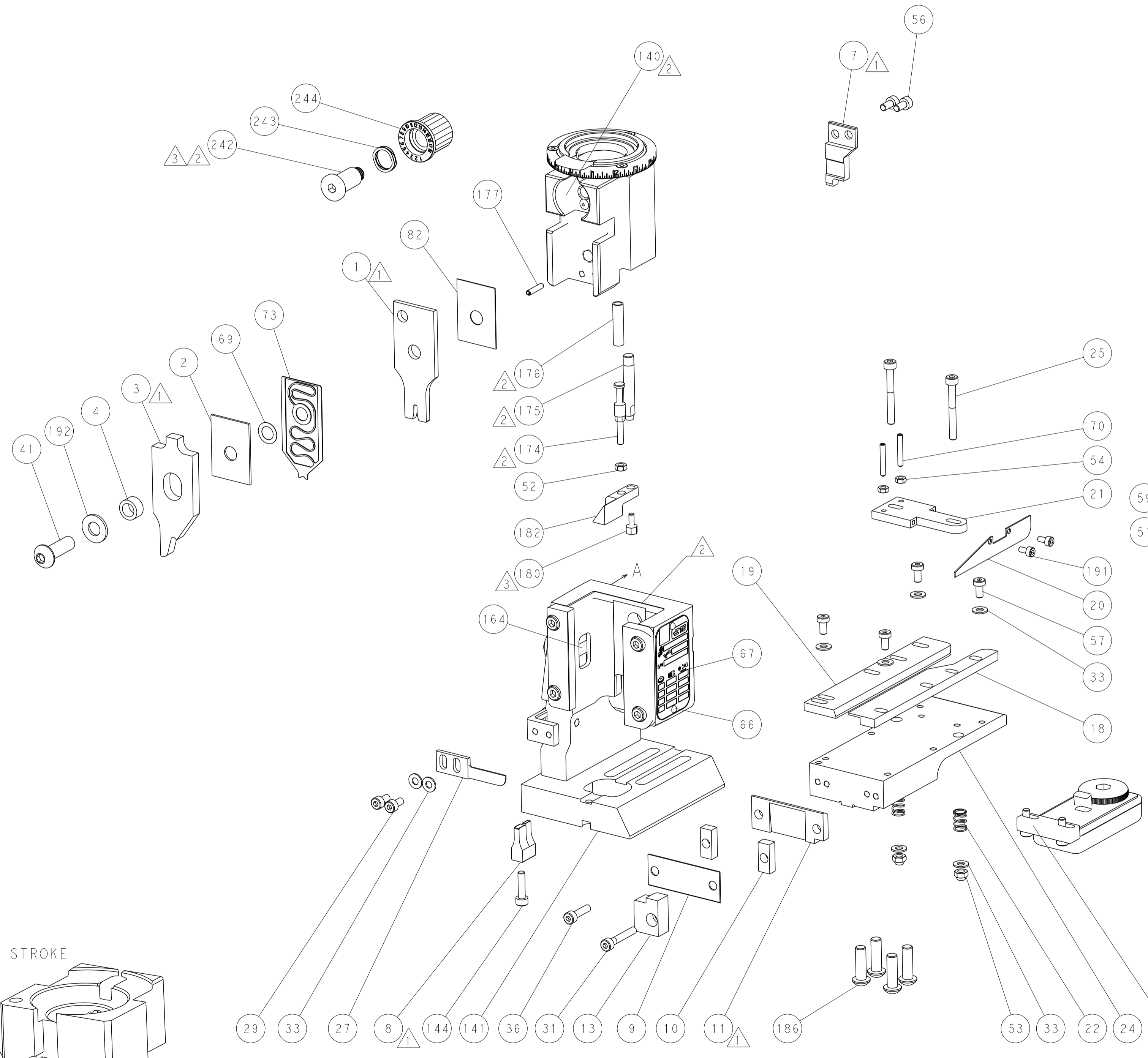
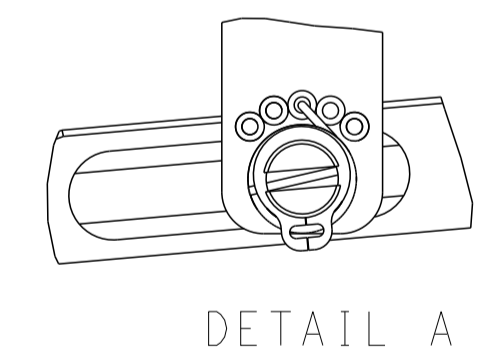
FEED TYPE
MECHANICAL



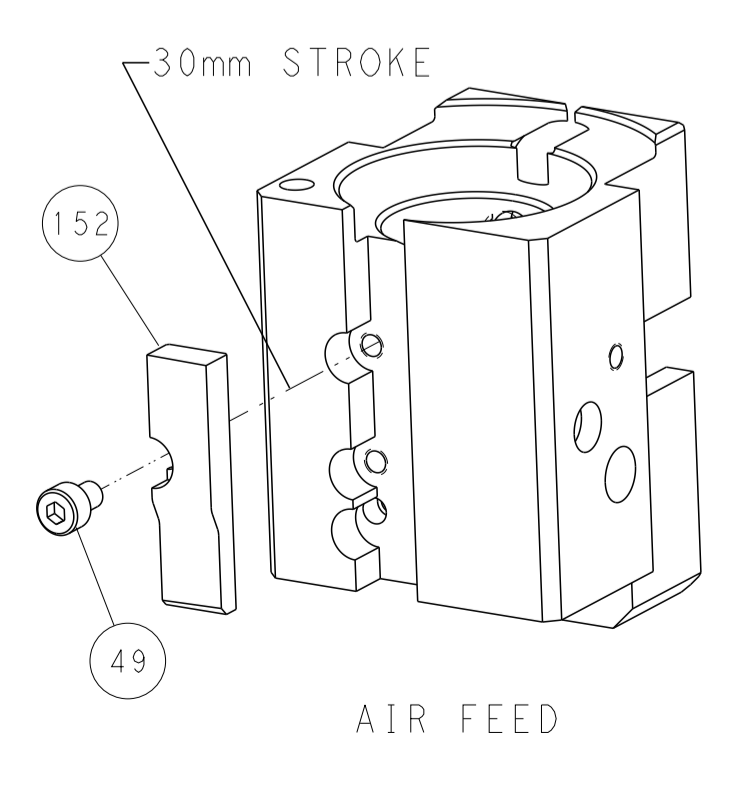
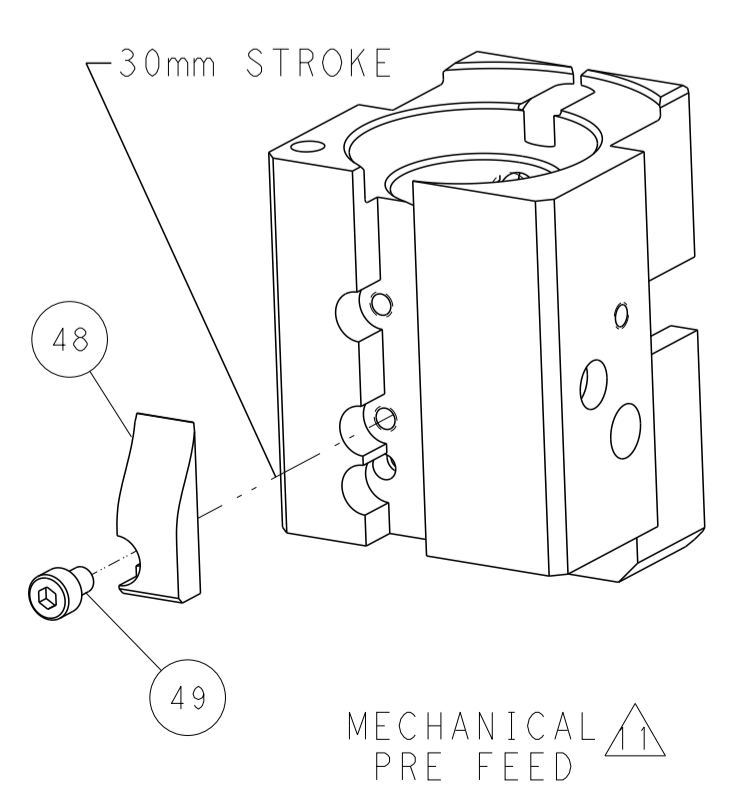
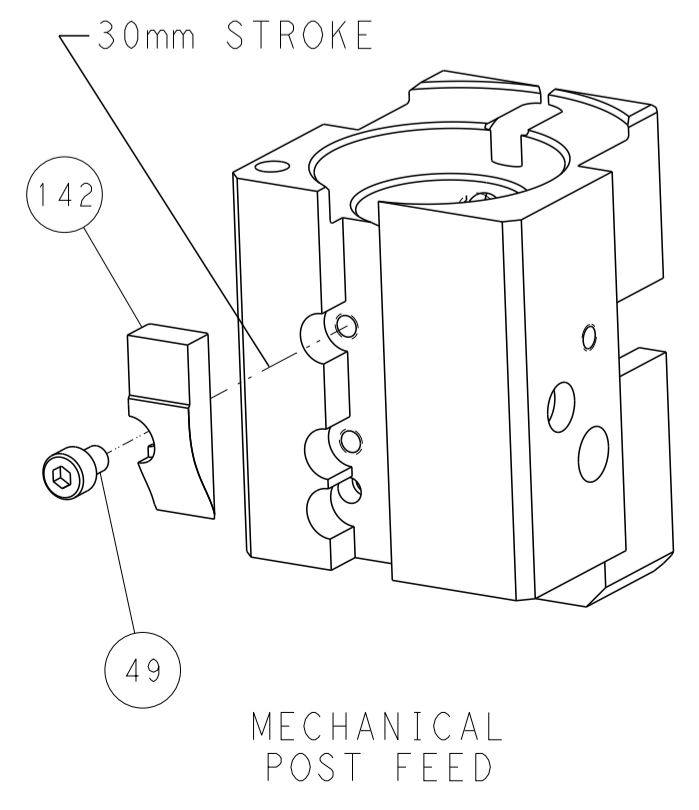
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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: M. HERR 14SEP2016		CHK: T. ELBIN 14SEP2016		APVD: T. ELBIN 14SEP2016		NAME: STE TE Connectivity Harrisburg, PA 17105-3608			
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO						
	1 PLC	±		A1	00779	©=2150728							
	2 PLC	±		Customer Accessible Production Drawing		SCALE	1:1	SHEET	4	OF	4	REV	B
	3 PLC	±											
	4 PLC	±											
	ANGLES	±											
	FINISH	±											