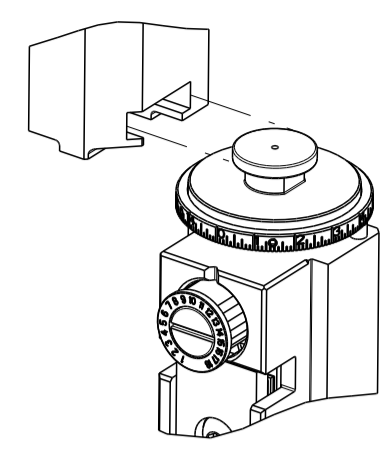


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150856-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150856-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150856-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.40 mm [.173]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [.177-.217 IN]		Ø2.80-3.80 mm [.110-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5070		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172763-1	172763-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.82+/-0.05 [.072+/-0.002]	8.0
16 AWG	1.62+/-0.05 [.064+/-0.002]	10.0
18 AWG	1.50+/-0.05 [.059+/-0.002]	11.1

- 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.
- LOCATE ITEM 27 IN FRONT OF ITEM 3.

***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.

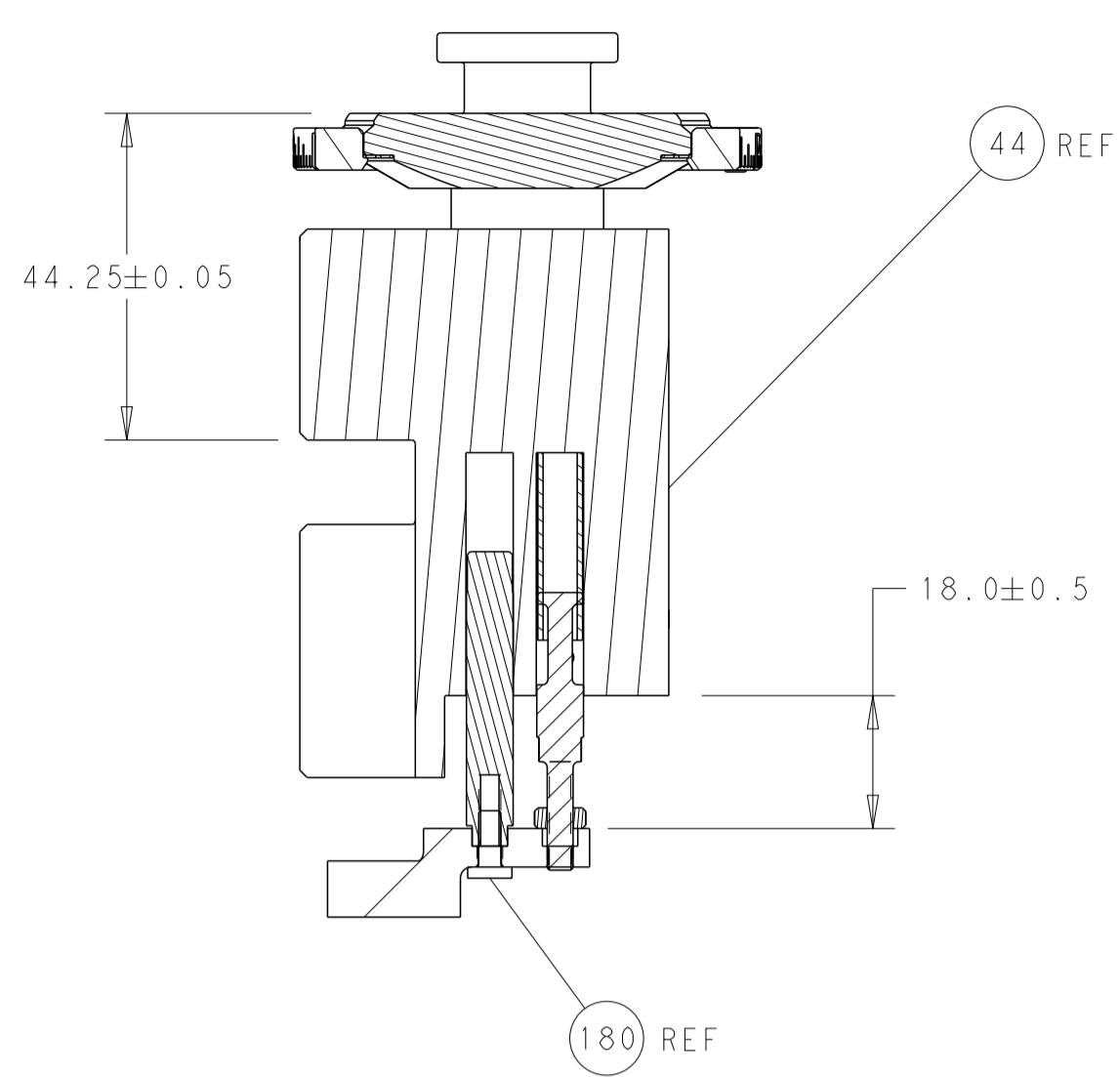
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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				ECR-19-008668	02JUN2019	TB	CT
				ECR-19-011869	27JUL2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	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	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	191
	-	1	4-1752354-4	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	92
-	1	1	455888-5	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	1803176-4	HOLDDOWN, TERMINAL	65
-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	55
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	2063961-5	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-2119655-7	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
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	690455-2	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
-	1	1	2161922-8	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1-1633168-5	ARM, STOCK DRAG	21
-	1	1	2-464452-7	DRAG, STOCK	20
-	1	1	2-1901259-2	GUIDE, LOWER STRIP	19
-	1	1	9-1901695-3	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1213862-9	ANVIL, SPLICE TYPE	16
-	1	1	1803687-1	STOP BLOCK	13
	-	1	1-240644-7	PLATE, REAR SHEAR	11
-	2	2	5-240645-6	SPACER, SHEAR PLATE	10
	1	2	1-1213862-0	ANVIL, SPLICE TYPE	8
	-	1	1803186-5	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1-1803108-0	CRIMPER, INSULATION O	3
-	1	1	3-455888-2	SPACER, CRIMPER	2
	1	2	456408-8	CRIMPER, WIRE PREMIUM	1

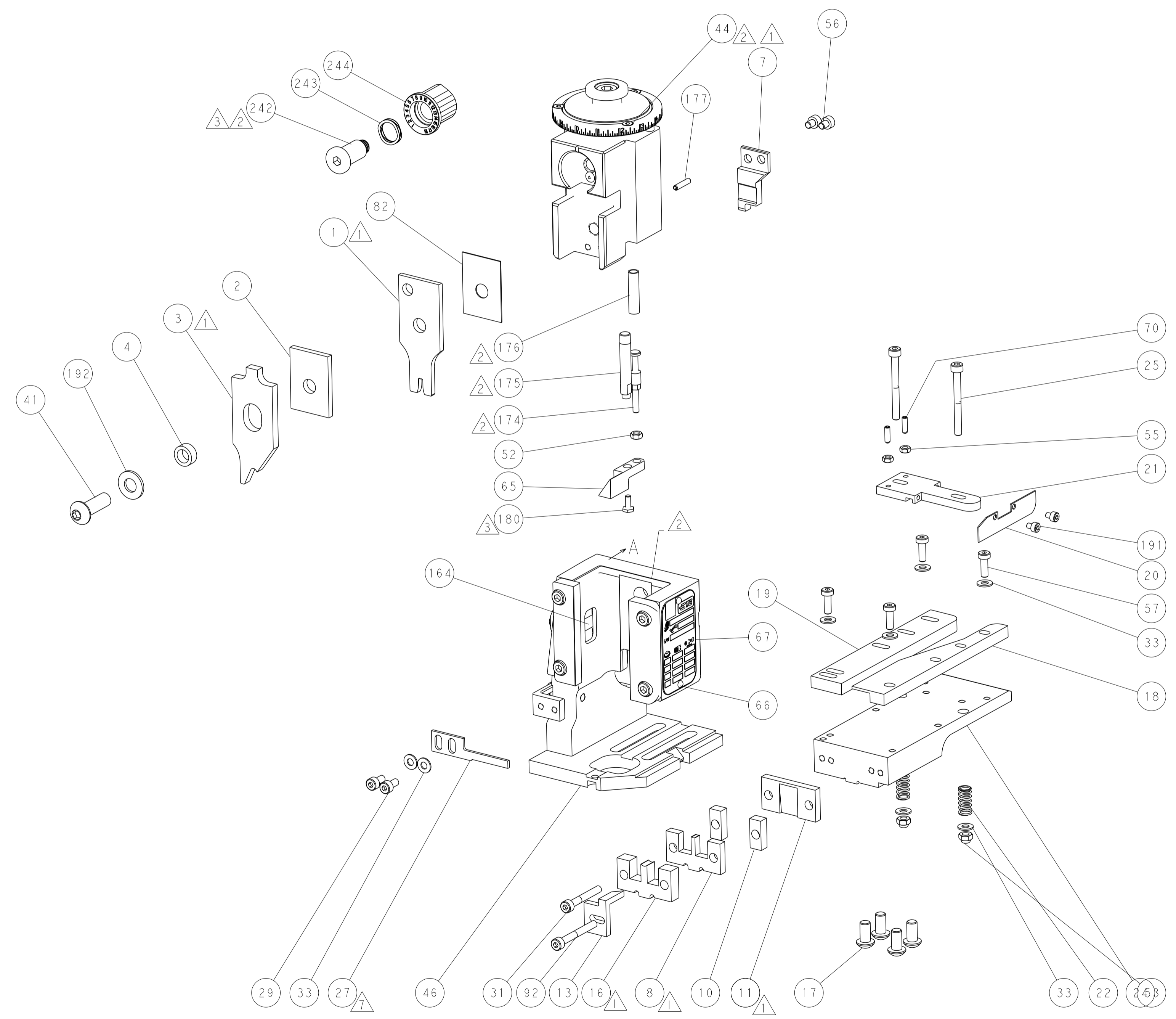
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 1 OF 4		REV C			

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

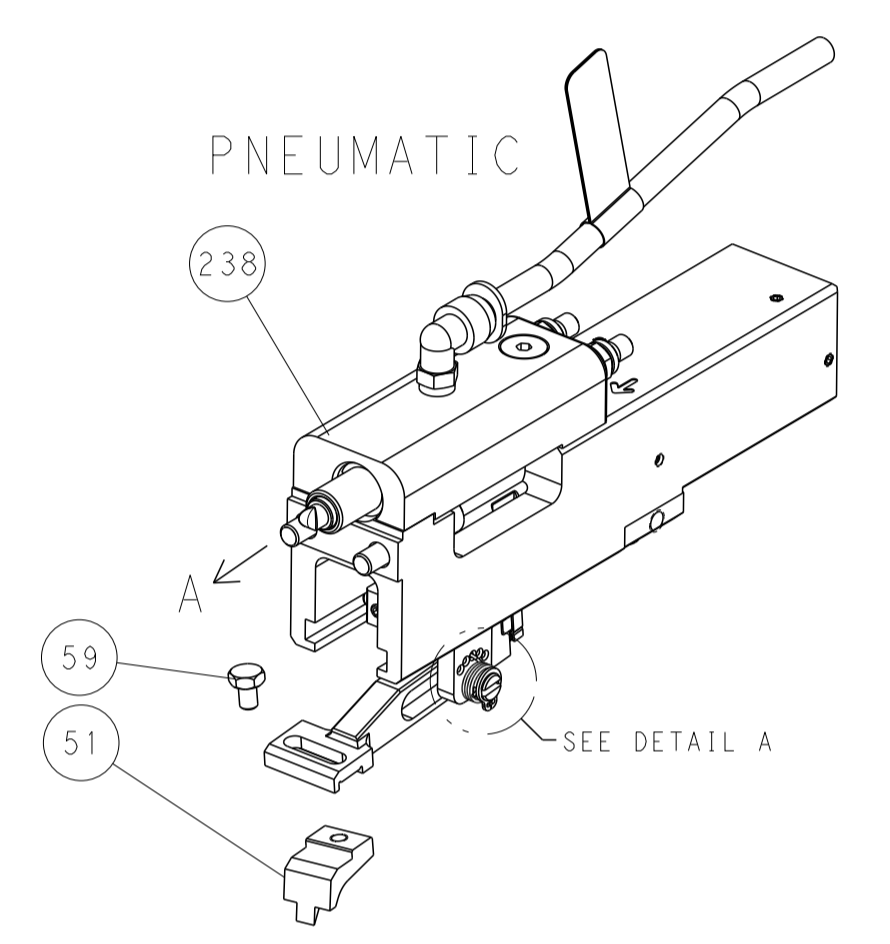
LOC	DIST	REV	DATE	BY	APPD
A	66				
REVISIONS			DATE	BY	APPD
DESCRIPTION					
SEE SHEET 1					



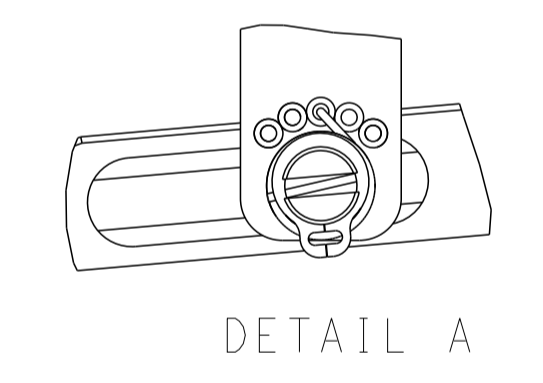
RAM AND HOLDDOWN SET-UP



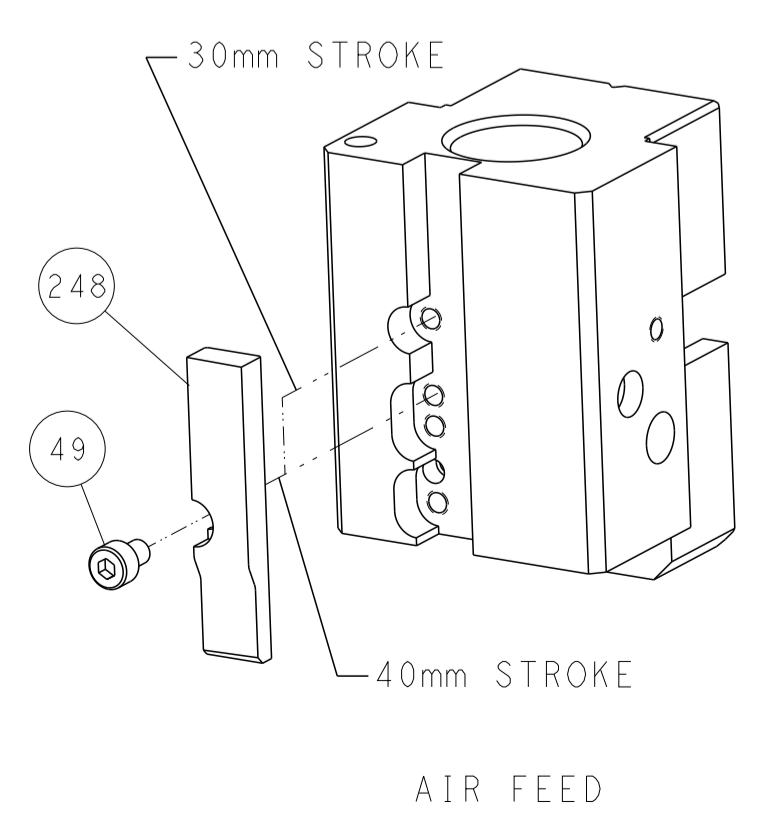
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

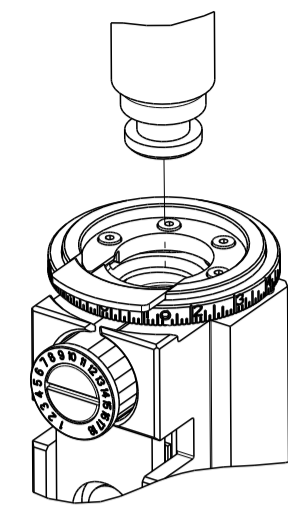


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: M. ZHAO 24NOV2017 CHK: K. ZHANG 24NOV2017 APVD: K. ZHANG 24NOV2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150856 WEIGHT:	RESTRICTED TO: SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL:		Customer Accessible Production Drawing	

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150856-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150856-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.40 mm [.173]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [.177-.217 IN]		Ø2.80-3.80 mm [.110-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5070	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172763-1	172763-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.82+/-0.05 [.072+/- .002]	8.0
16 AWG	1.62+/-0.05 [.064+/- .002]	10.0
18 AWG	1.50+/-0.05 [.059+/- .002]	11.1



- △ 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.
- △ LOCATE ITEM 27 IN FRONT OF ITEM 3.

***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.

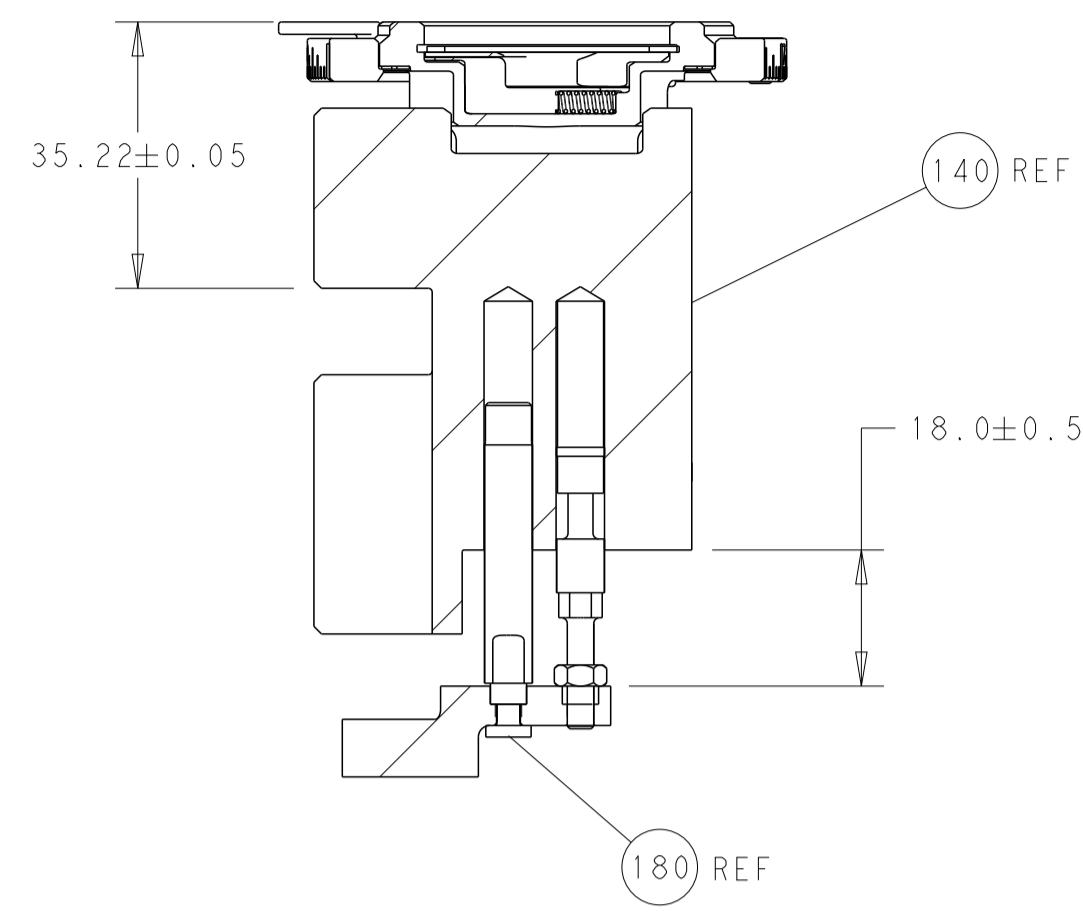
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

△	-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-3	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	191
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
△	-	1	4-1752354-4	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	92
	-	1	455888-5	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	1803176-4	HOLDDOWN, TERMINAL	65
	-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	55
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	2063961-5	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
	-	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	1	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	31
	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
△	-	1	690455-2	STRIPPER, FRONT CASTING	27
	-	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
	-	1	2161922-8	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1-1633168-5	ARM, STOCK DRAG	21
	-	1	2-464452-7	DRAG, STOCK	20
	-	1	2-1901259-2	GUIDE, LOWER STRIP	19
	-	1	9-1901695-3	STRIP GUIDE, FRONT	18
△	-	1	1213862-9	ANVIL, SPLICE TYPE	16
	-	1	1803687-1	STOP BLOCK	13
△	-	1	1-240644-7	PLATE, REAR SHEAR	11
	-	2	5-240645-6	SPACER, SHEAR PLATE	10
△	1	1	1-1213862-0	ANVIL, SPLICE TYPE	8
△	-	1	1803186-5	BLADE, SLUG	7
	-	-	-	-	6
	-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
△	1	1	1-1803108-0	CRIMPER, INSULATION 0	3
	-	1	3-455888-2	SPACER, CRIMPER	2
△	1	1	456408-8	CRIMPER, WIRE PREMIUM	1
	-	77-22	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)

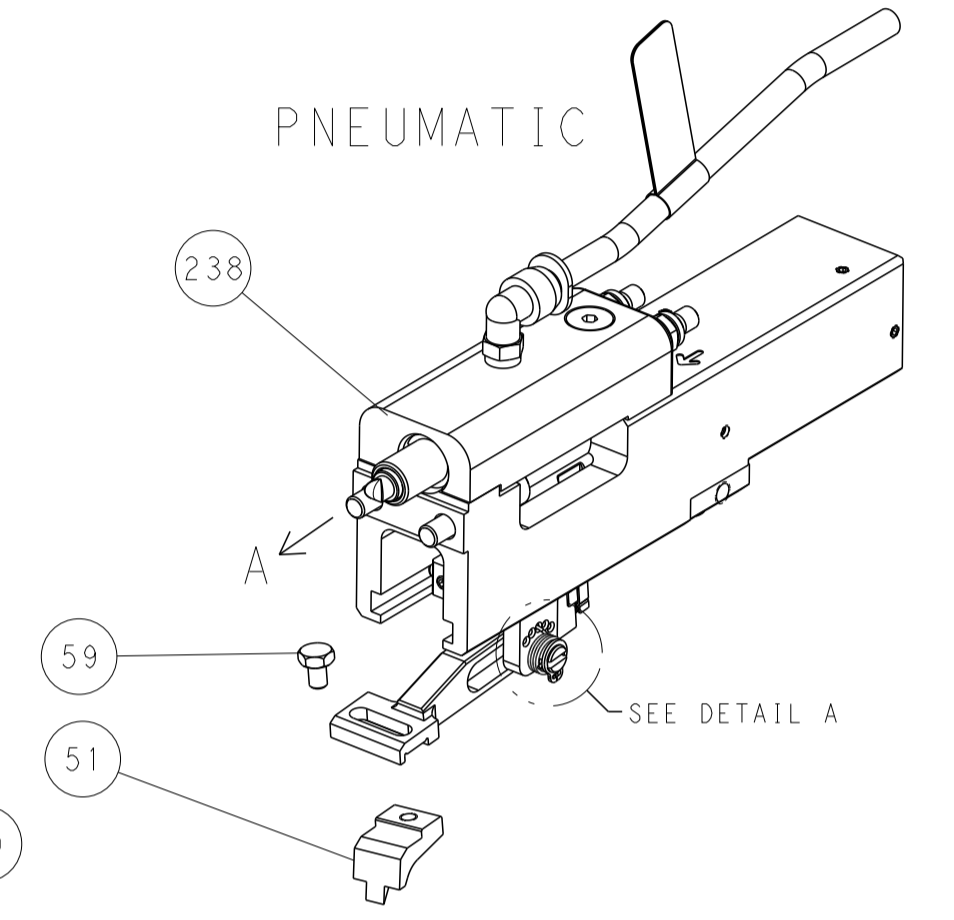
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150856	RESTRICTED TO: -
MATERIAL: -								WEIGHT: -		SCALE: 1:1 SHEET 3 OF 4	
Customer Accessible Production Drawing								Customer Accessible Production Drawing			

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

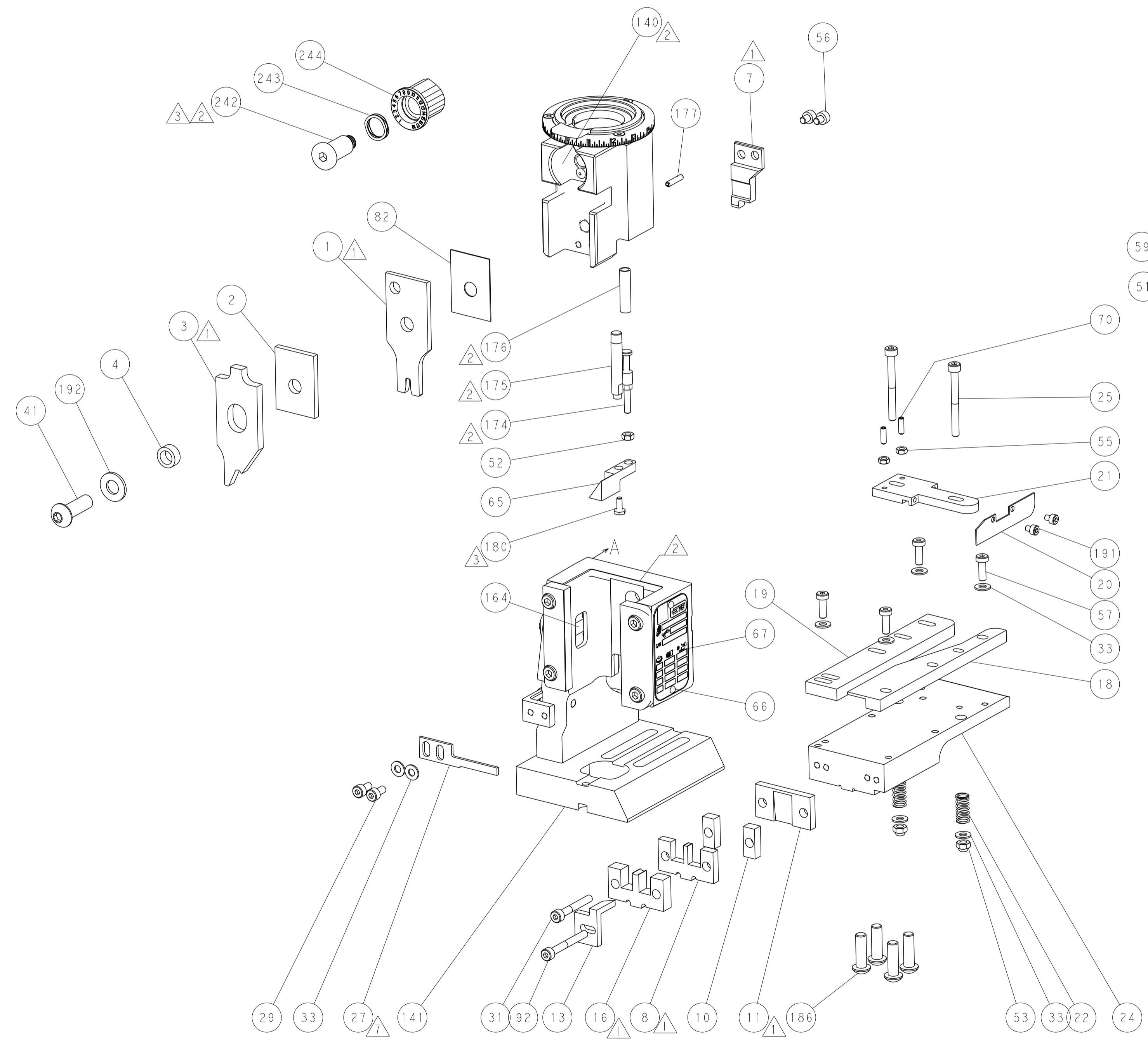
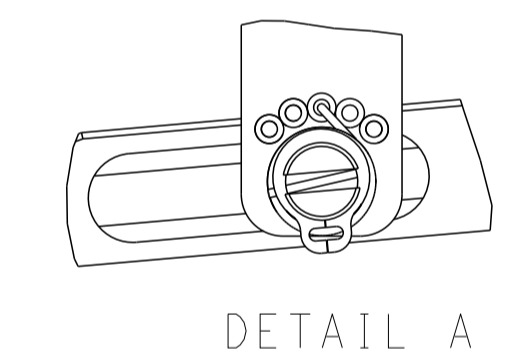


RAM AND HOLDDOWN SET-UP

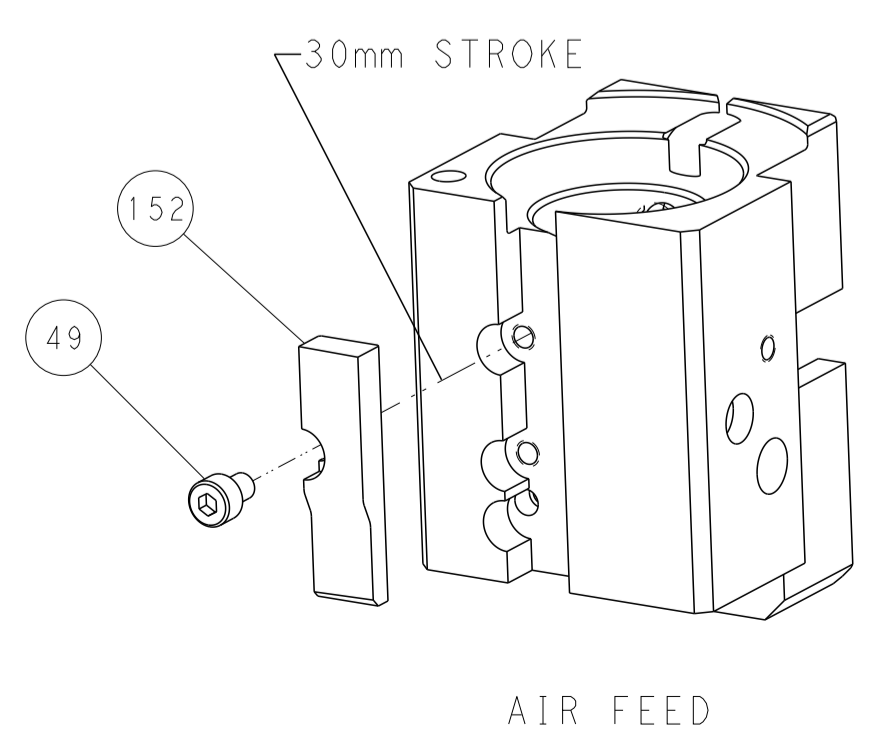
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 FINISH ±		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO WEIGHT A 00779 C=2150856	RESTRICTED TO SCALE 1:1 SHEET 4 OF 4 REV C
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	