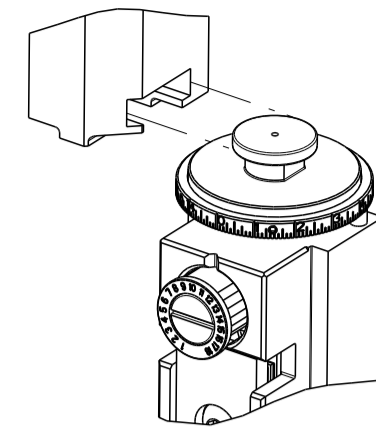


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150872-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150872-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150872-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150872-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150872-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	5.33 mm [.210]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES FASTON-FASTIN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.72-5.49 mm [.186-.216 IN]		∅3.81-4.83 mm [.150-.190 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2065		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42904-1	42904-2	62891-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.18+/-0.05 [.086+/-0.002]	4.8
14 AWG	1.83+/-0.05 [.072+/-0.002]	8.5
16 AWG	1.63+/-0.05 [.064+/-0.002]	10.5

- 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 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.

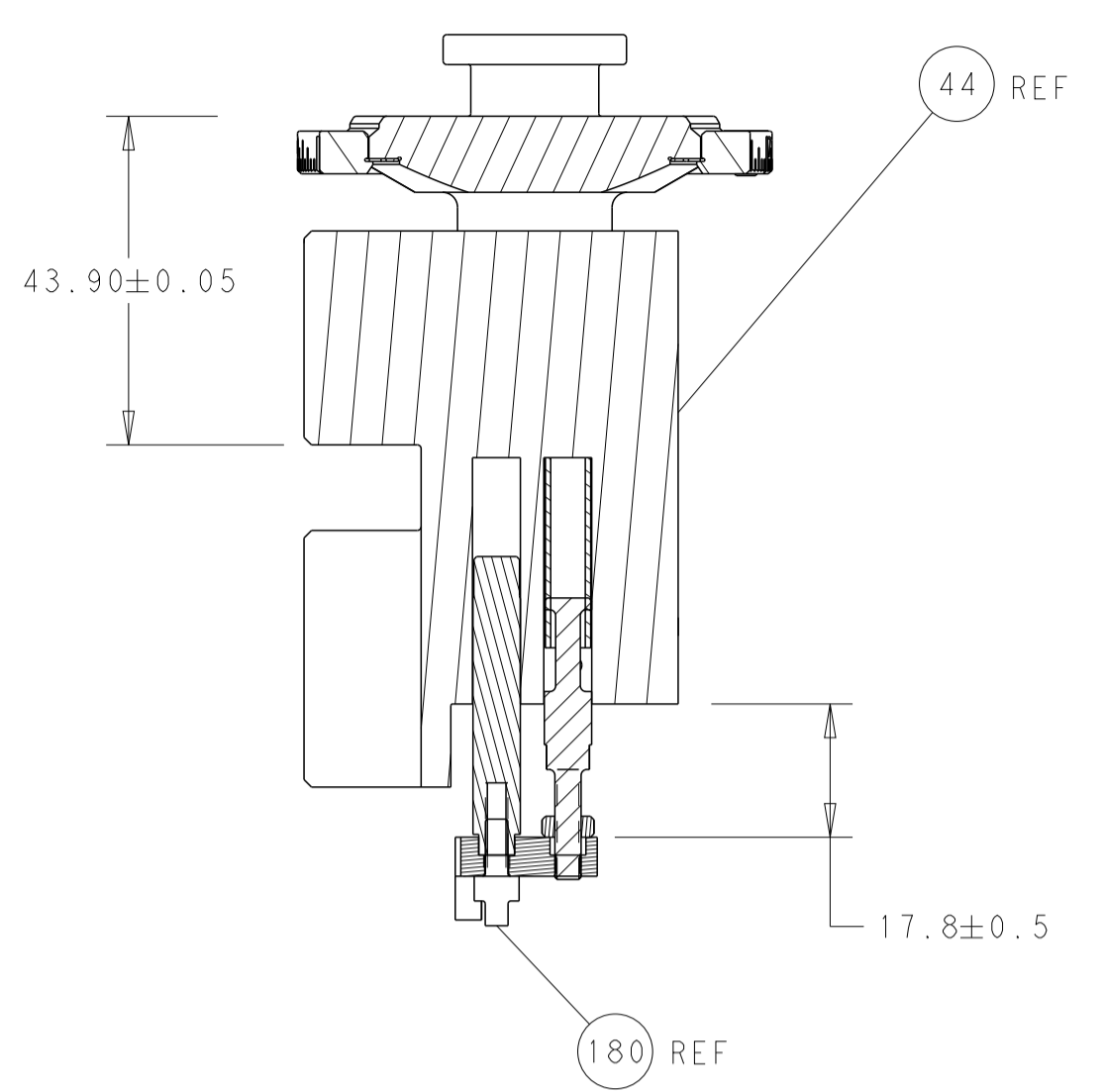
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		A		RELEASED	24JAN2018	TB	GB
		B		ECR-23-189305	10OCT2023	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	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	
	-	1	1	1	1-1976055-1	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	
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	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	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	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	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	1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-8	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	1901259-5	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240641-7	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
	-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
	1	2	2	1	1	6-1803074-4	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
	1	2	2	1	1	456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

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

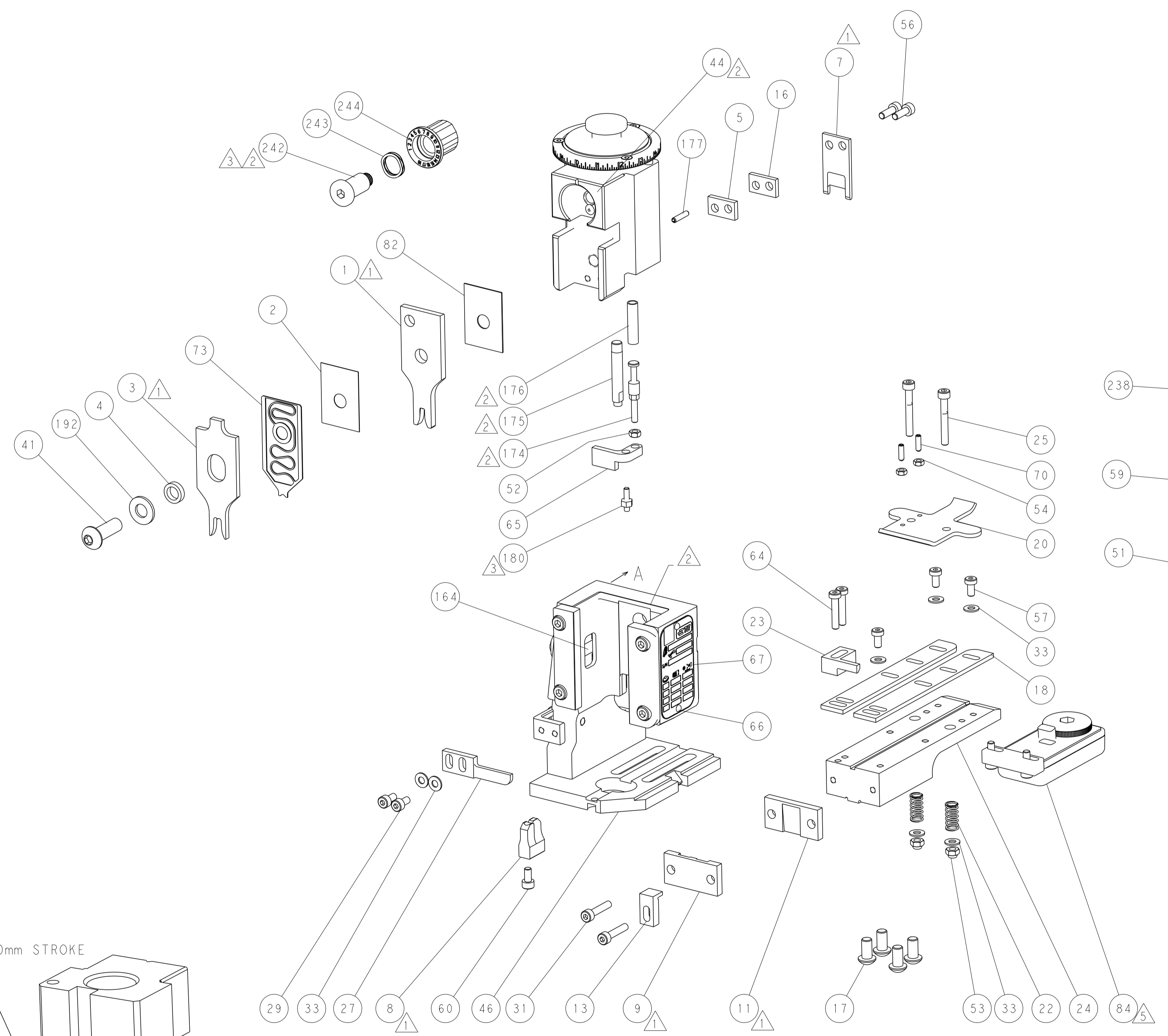
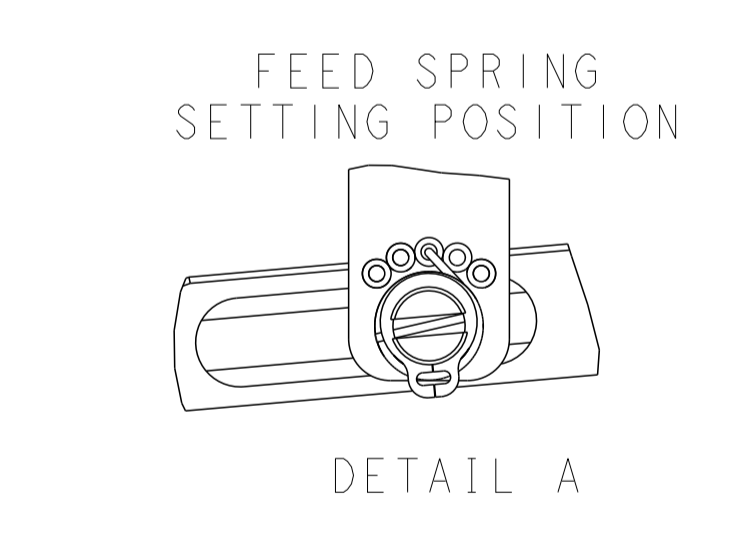
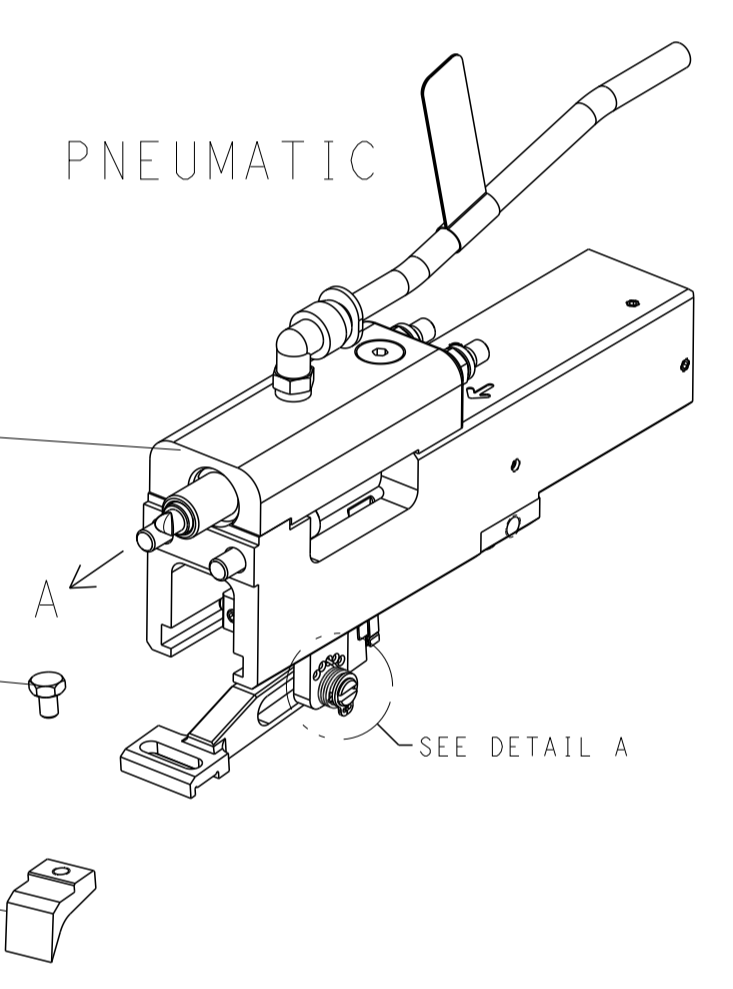
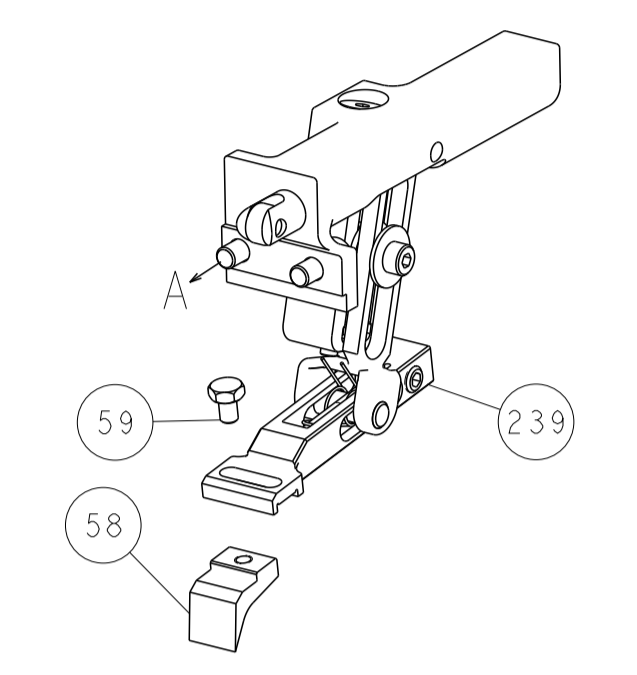
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	1	4	B	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

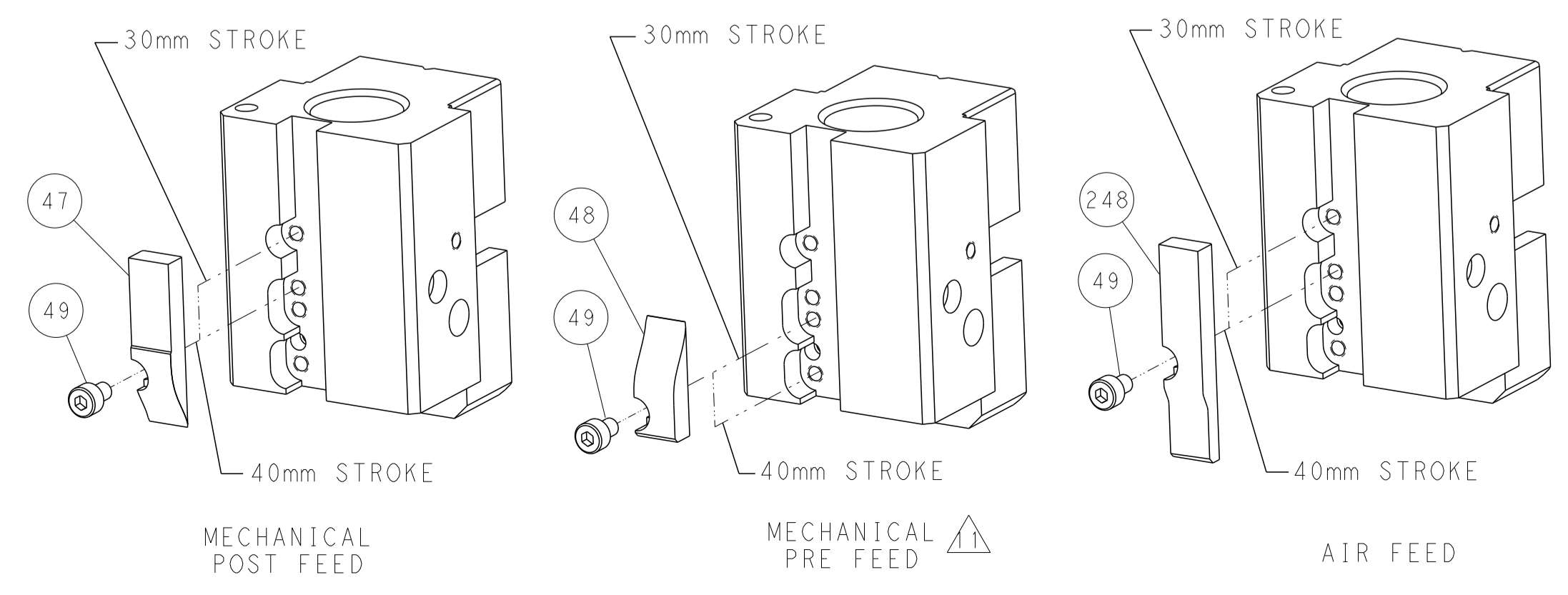


RAM AND HOLDDOWN SET-UP

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		OWN: E. ZHANG ZODEC2017 CHK: K. ZHANG ZODEC2017 APVD: K. ZHANG ZODEC2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150872 SCALE: 1:1 SHEET: 2 of 4 REV: B		RESTRICTED TO:	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150872-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150872-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150872-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	5.33 mm [2.10]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES FASTON-FASTIN TERMINAL			
WIRE STRIP LENGTH 4.72-5.49 mm [1.86-.216 IN]		INSULATION DIAMETER RANGE Ø3.81-4.83 mm [1.50-.190 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2065	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42904-1	42904-2	62891-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.18+/-0.05 [1.086+/-0.002]	4.8
14 AWG	1.83+/-0.05 [1.072+/-0.002]	8.5
16 AWG	1.63+/-0.05 [1.064+/-0.002]	10.5

- 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.

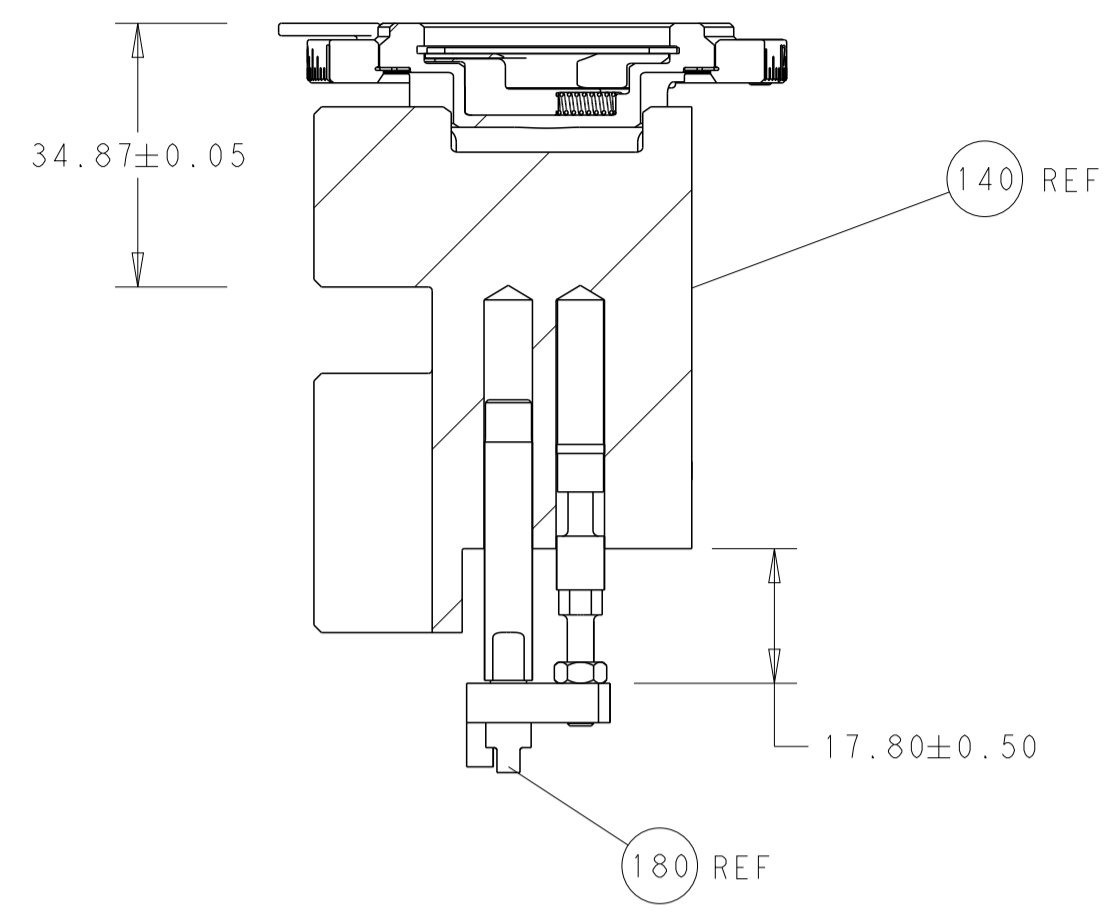
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-2		A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-2			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
-	4	4	2079383-9			SCR, BHSC, RoHS (M6 X 20)			186
3	-	1	1-1976055-1			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
-	REFREF	-	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	2119655-6			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	455888-5			SPACER, CRIMPER			82
-	1	1	2119791-5			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	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	2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20			64
-	1	1	5-18022-5			SCR, HEX HD CAP, M4 X 6.0			59
-	-	1	2063961-1			FEED FINGER			58
-	3	3	2168400-4			SHCS, LOW HEAD, RoHS, M4 X 8			57
-	2	2	2168083-3			SCR, SKT HD CAP, RoHS, M4 X 12.0			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
-	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	1752371-3			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	1901259-5			GUIDE, LOWER STRIP			18
-	1	1	240641-7			SPACER			16
-	1	1	1752360-1			SPACER,HOLD-DOWN			13
1	-	1	240644-1			PLATE, REAR SHEAR			11
-	-	-	-			-			10
1	-	1	690482-4			PLATE, FRONT SHEAR			9
1	1	1	6-1803074-4			ANVIL, COMBINATION, END FEED			8
1	-	1	1-2217206-0			BLADE, SLUG			7
-	-	-	-			-			6
-	1	1	240641-5			SPACER			5
-	1	1	238011-2			BLOCK, CRIMPER SPACER			4
1	1	1	1633961-1			CRIMPER, INSULATION F PREMIUM			3
-	1	1	455888-2			SPACER, CRIMPER			2
1	1	1	456409-8			CRIMPER, WIRE .120 "F" PREMIUM			1
-	77-22-21	-	PART NO			DESCRIPTION			ITEM NO

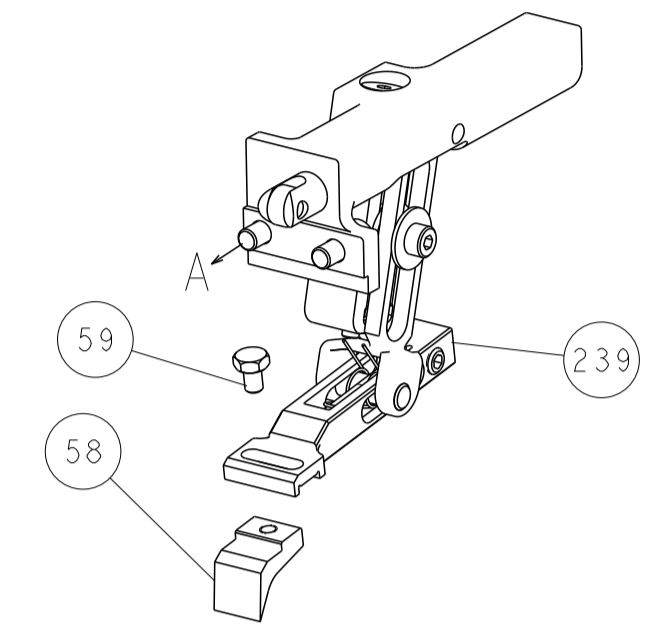
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: F. ZHANG ZODEC2017		CHK: K. ZHANG ZODEC2017		NAME: TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: K. ZHANG ZODEC2017	PRODUCT SPEC	Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET 3 OF 4	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 3 OF 4		REV B		RESTRICTED TO	

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

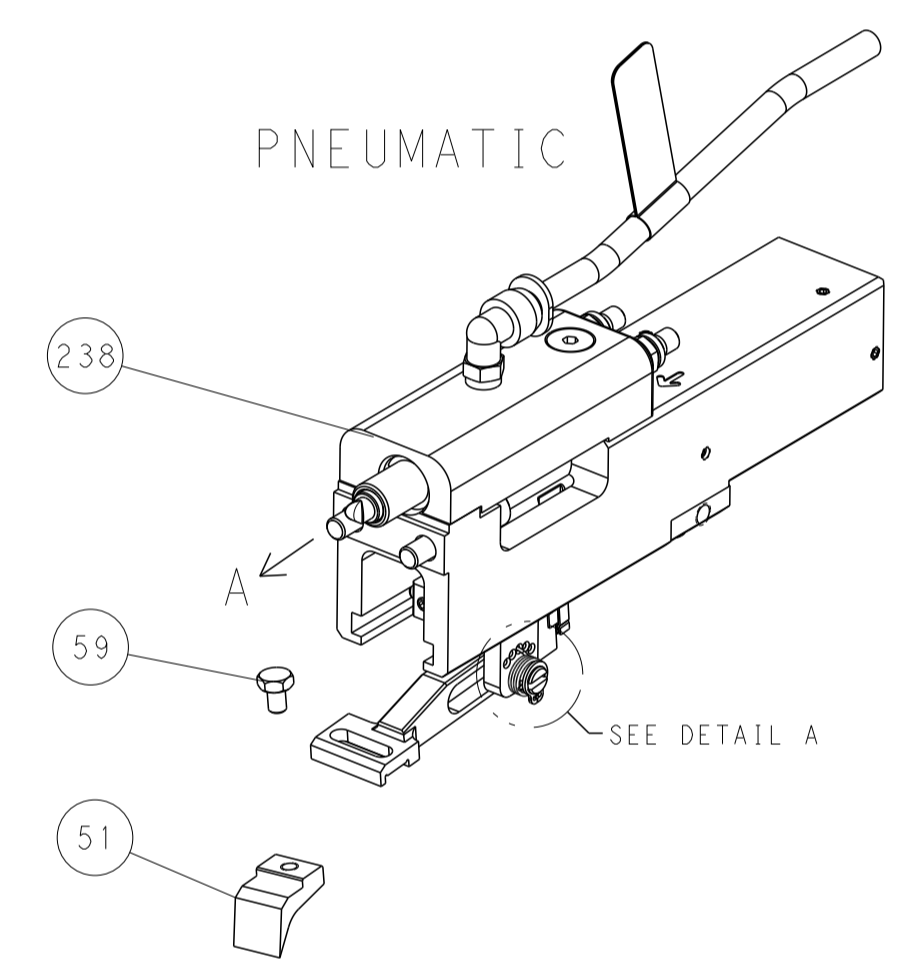


RAM AND HOLDDOWN SET-UP

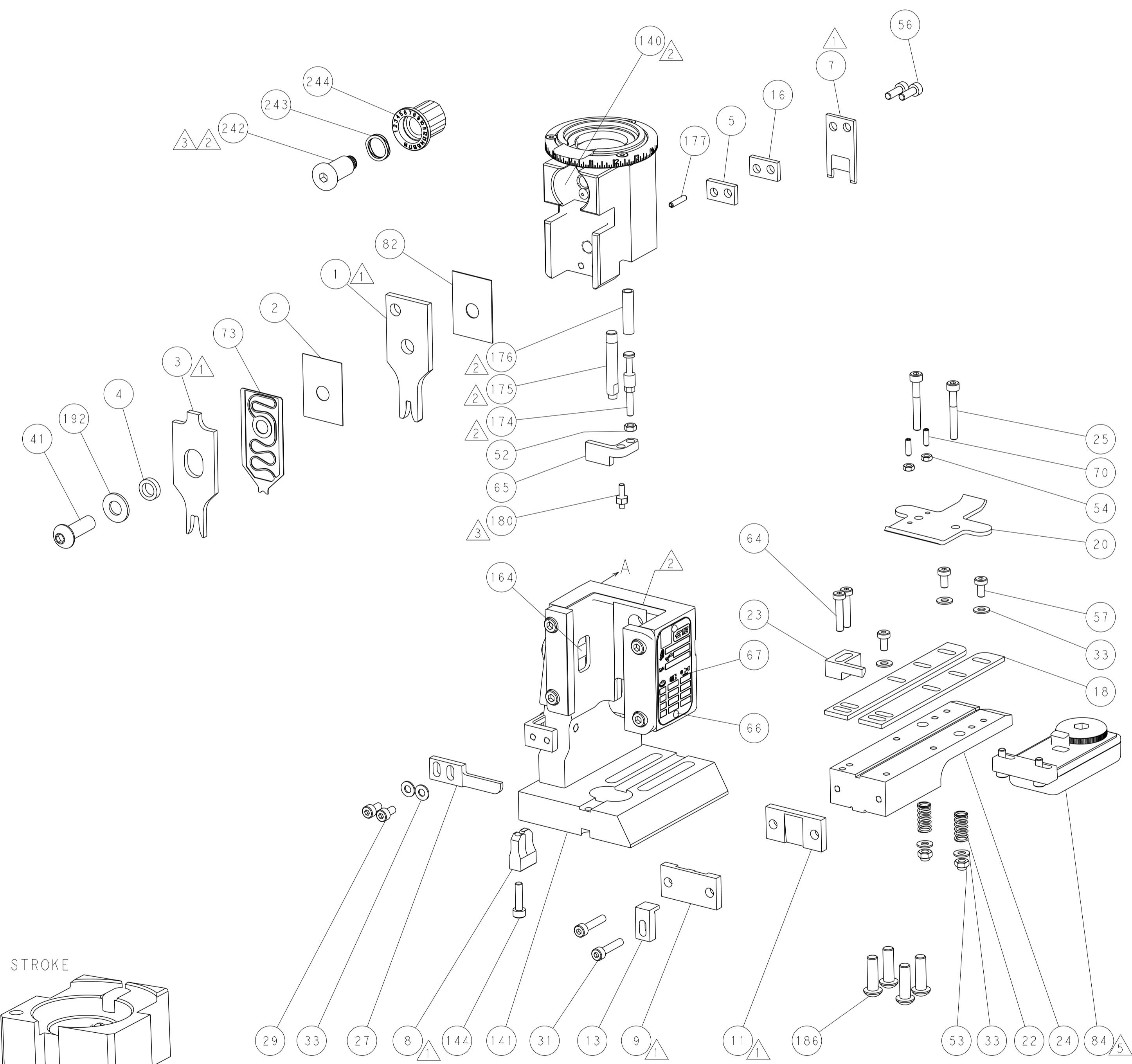
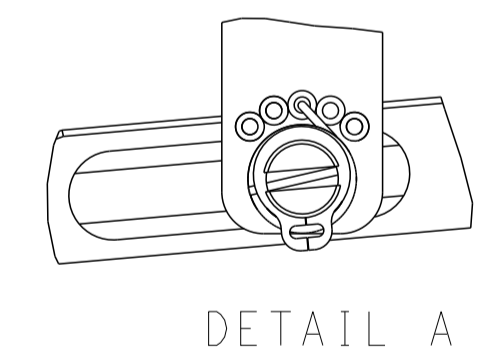
FEED TYPE
MECHANICAL



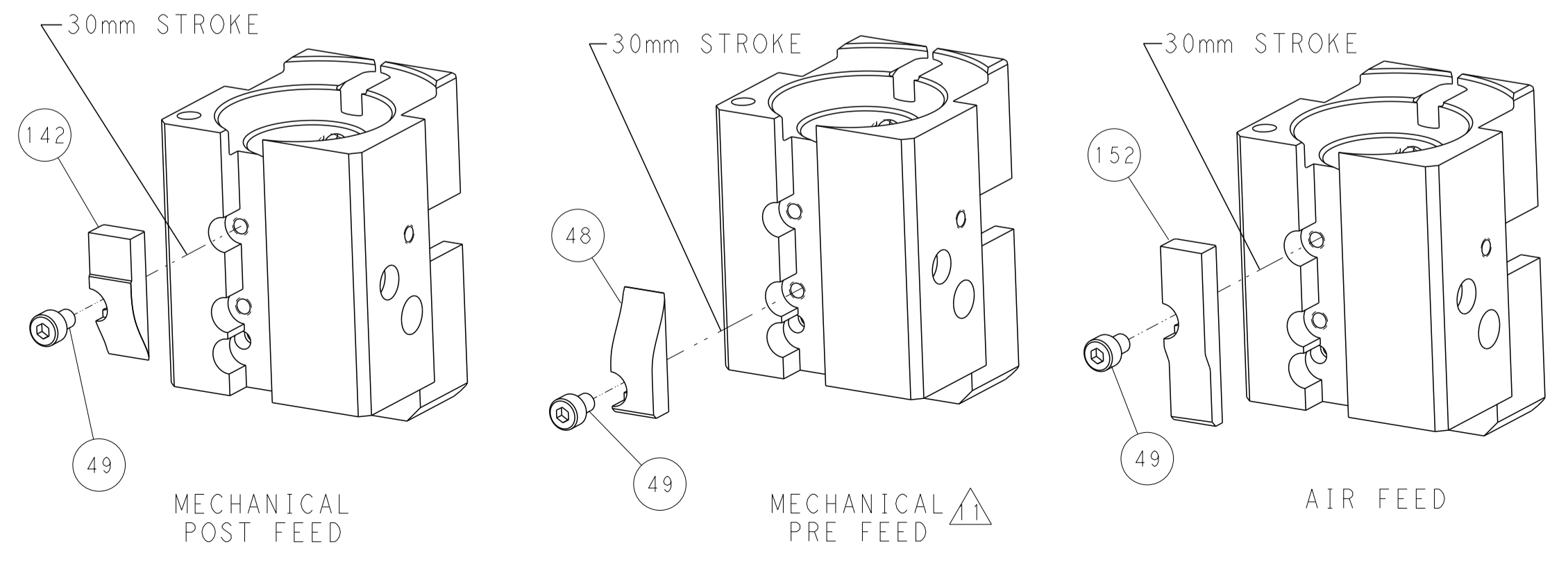
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN F. ZHANG Z0DEC2017 CHK K. ZHANG Z0DEC2017 APVD K. ZHANG Z0DEC2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A 00779 C-2150872 SCALE 1:1 SHEET 4 OF 4 REV B		RESTRICTED TO	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				STE TE Connectivity Harrisburg, PA 17105-3608		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION			