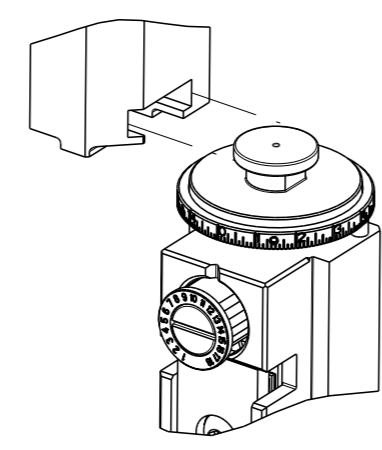


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150923-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150923-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150923-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150923-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150923-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	-	-

APPL INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm [.205-.235 IN]		Ø1.52-4.06 mm [.060-.160 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2079		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60960-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 x 12 AWG	3.12 +/- 0.05 [.123 +/- .002]	4.5
10 AWG	2.82 +/- 0.05 [.111 +/- .002]	7.5
2 x 14 AWG	2.56 +/- 0.05 [.101 +/- .002]	10.3
12 AWG	2.36 +/- 0.05 [.093 +/- .002]	12.4

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 5 PLACE ITEM 27 IN FRONT OF ITEM 1 TO STRIP OFF OF WIRE INSULATION.

\*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)

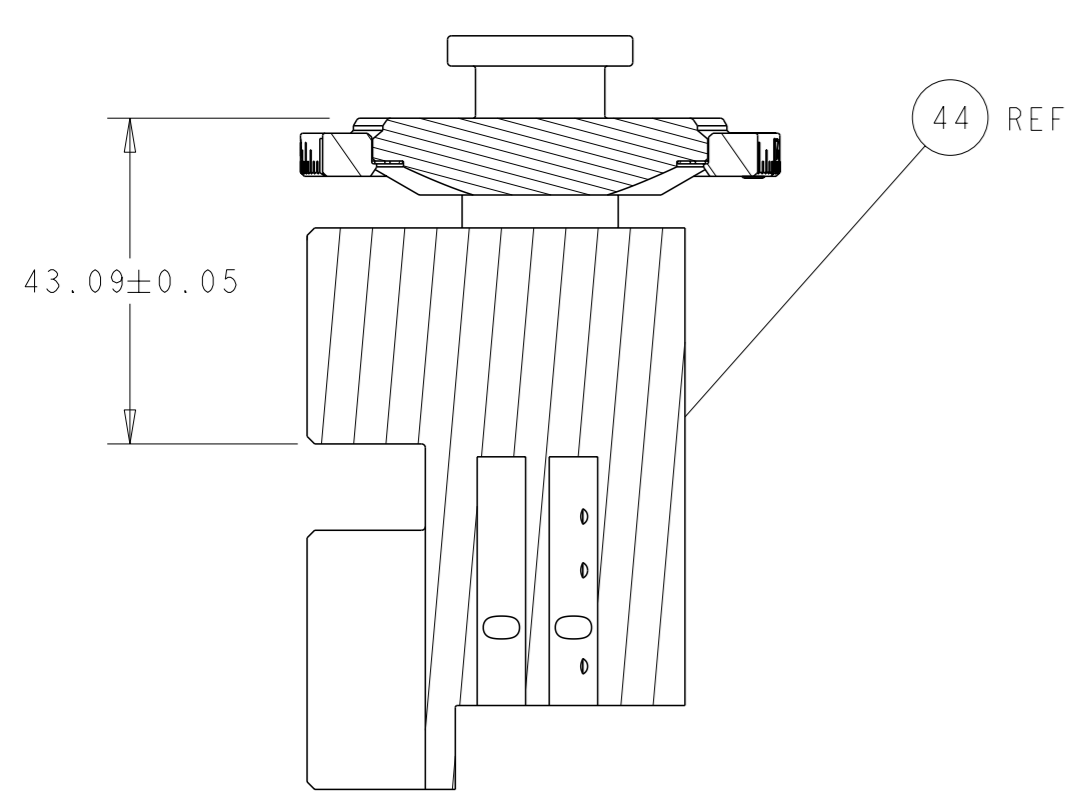
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	02AUG2018	MEH	TE
		B		ECR-19-004558	21MAR2019	LG	TE

-	1	1	1	1	2119534-1	MOUNT, STRIPPER, SIDE FEED	254	
-	1	1	1	1	2119533-2	STRIPPER, SIDE FEED	253	
-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	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	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	100	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	694433-2	FEED PAWL	58	
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	1	-	1	-	1803735-1	SPECIAL PAWL HOLDER, 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	2-2119655-7	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	
-	6	6	6	6	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2	2	1-2079383-6	SCR, BHSC, RoHS (M4 X 10)	30	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	690455-1	STRIPPER, FRONT CASTING	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-6	DRAG, TERMINAL	25	
-	1	1	1	1	1803727-1	PLATE, STRIP GUIDE	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	3-690487-9	GUIDE, FRONT STRIP	19	
-	1	1	1	1	9-1901695-6	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	318311-1	PLATE, RAMP	13	
-	1	1	1	1	1803759-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	1803728-1	BLOCK, SHEAR	9	
-	1	2	2	1	1803690-2	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1803154-2	BLADE, REAR SLUG	7	
-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1-1803504-9	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

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

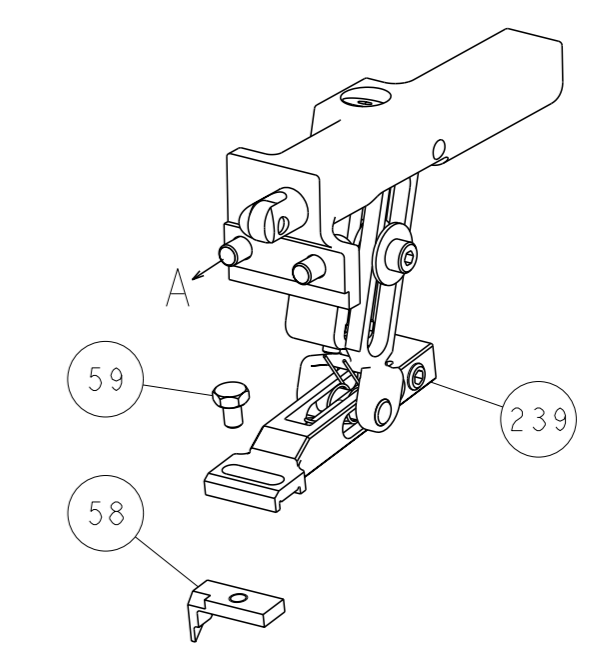
OWN	M. HERR	08JUN2018
CHK	T. ELBIN	08JUN2018
APVD	T. ELBIN	08JUN2018
NAME	Ocean End Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150923
Customer Accessible Production Drawing	SCALE	1:1
SHEET	1	OF 4
REV	B	

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

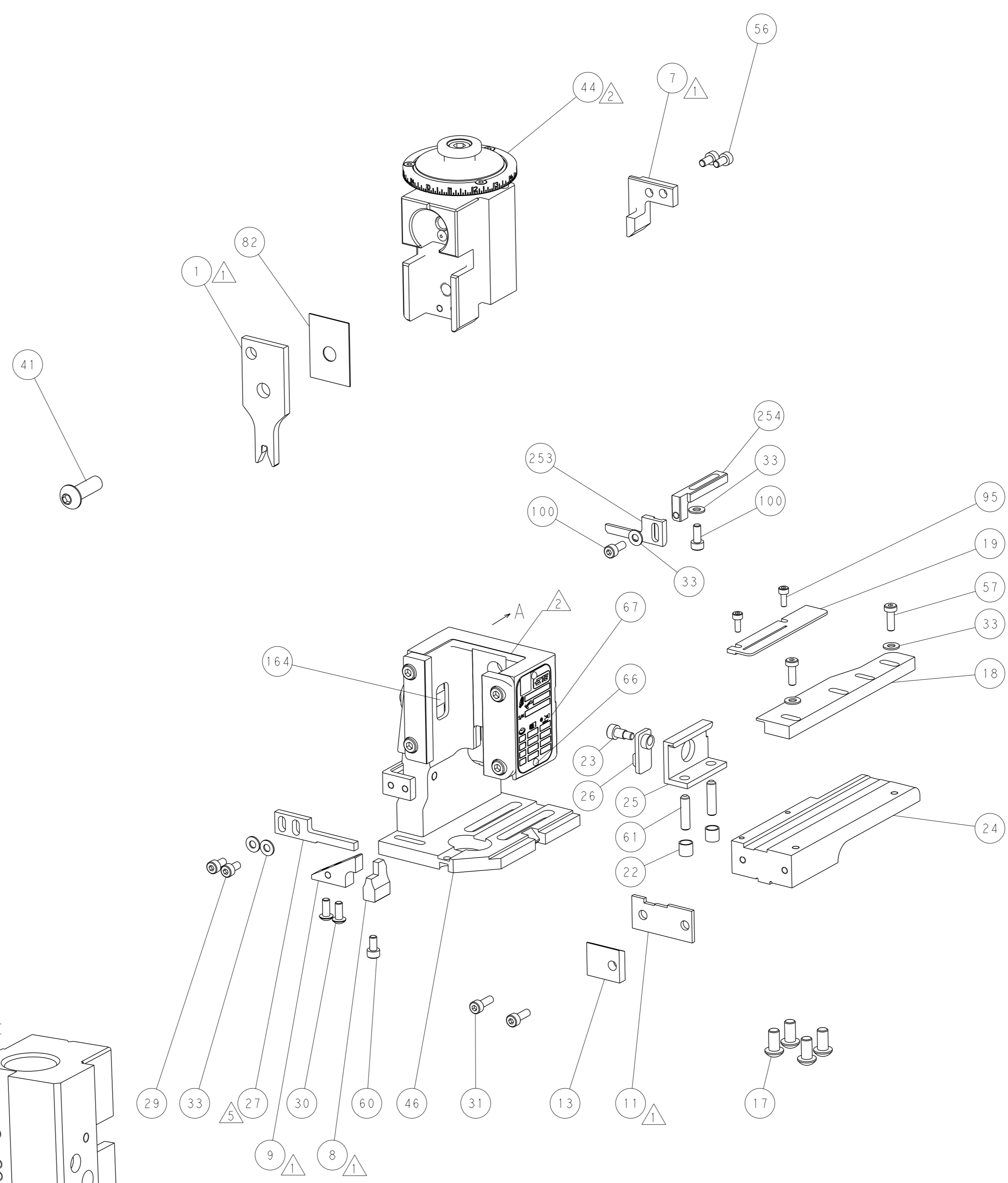
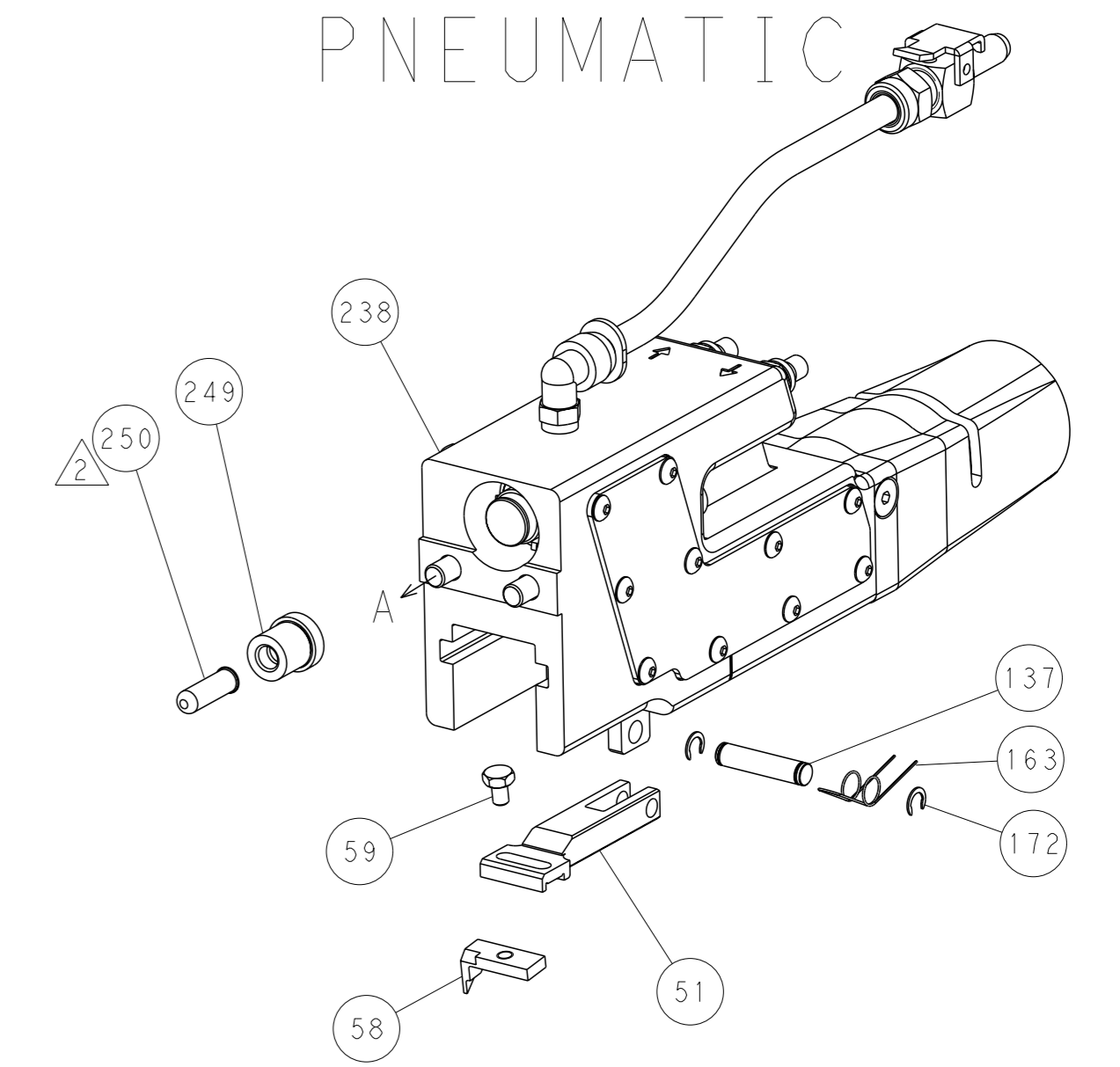


RAM SET-UP

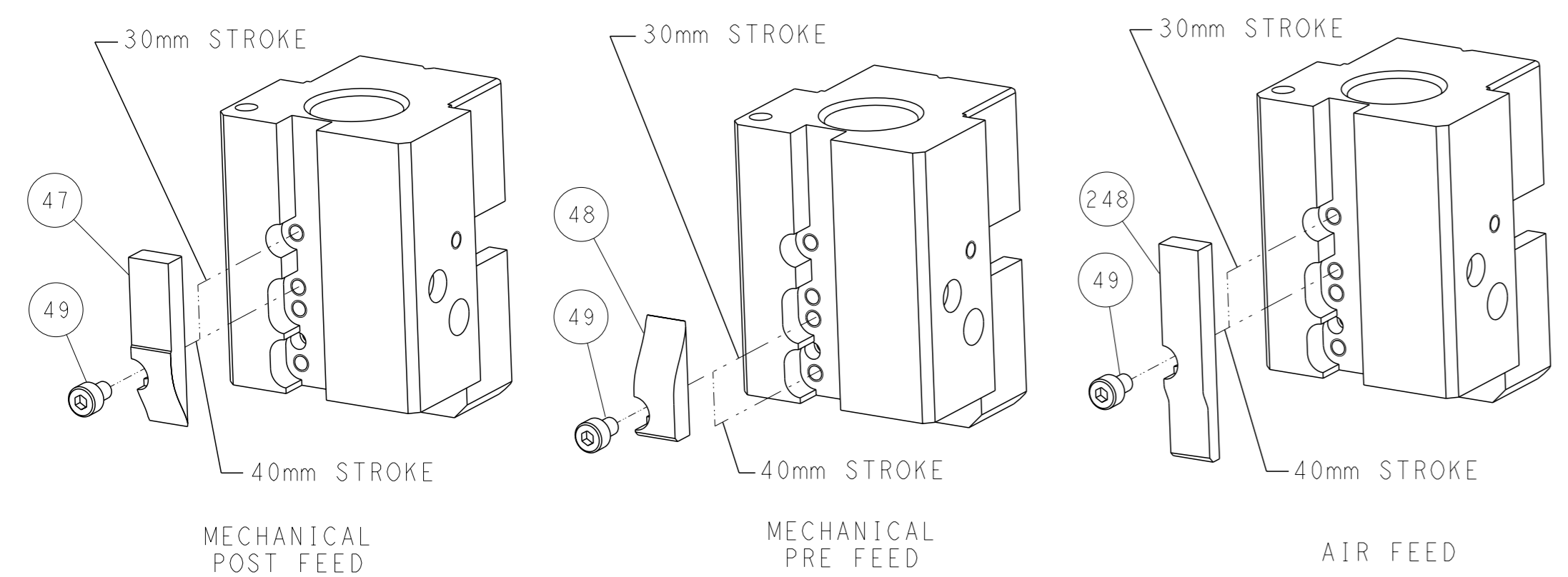
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

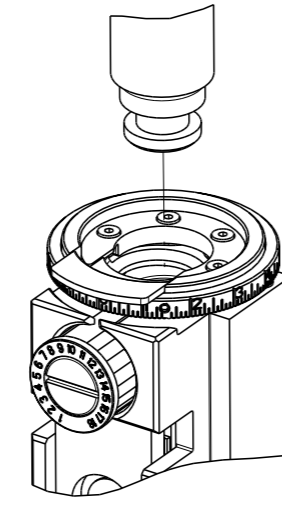


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: T. ELBIN DATE: 08JUN2018 PRODUCT SPEC: 08JUN2018	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150923 SCALE: 1:1 SHEET: 2 of 4 REV: B
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL: - FINISH: - WEIGHT: -	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		2018			
COPYRIGHT 2018 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150923-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2150923-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150923-7	A	CRIMP TOOLING KIT	-				

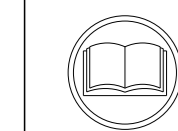
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm (.140)	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm (.205-.235 IN)		Ø1.52-4.06 mm (.060-.160 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2079	-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60960-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 x 12 AWG	3.12 +/- 0.05 [.123 +/- .002]	4.5
10 AWG	2.82 +/- 0.05 [.111 +/- .002]	7.5
2 x 14 AWG	2.56 +/- 0.05 [.101 +/- .002]	10.3
12 AWG	2.36 +/- 0.05 [.093 +/- .002]	12.4



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
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**\*WARNING**  
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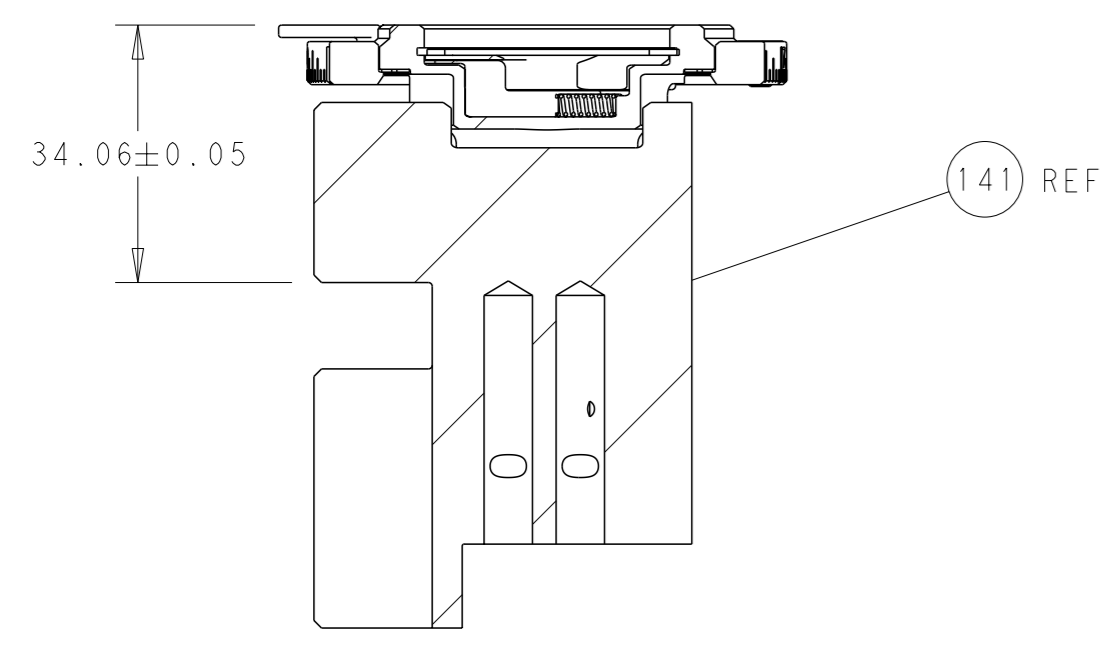
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119534-1	MOUNT, STRIPPER, SIDE FEED	254
-	1	1	2119533-2	STRIPPER, SIDE FEED	253
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	2-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	100
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	694433-2	FEED PAWL	58
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	1	-	1803735-1	SPECIAL PAWL HOLDER, EF, AIR	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
-	6	6	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-6	DRAG, TERMINAL	25
-	1	1	1803727-1	PLATE, STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	3-690487-9	GUIDE, FRONT STRIP	19
-	1	1	9-1901695-6	STRIP GUIDE, FRONT	18
-	1	1	318311-1	PLATE, RAMP	13
-	1	1	1803759-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	1803728-1	BLOCK, SHEAR	9
-	1	1	1803690-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1803154-2	BLADE, REAR SLUG	7
-	-	-	-	-	6
-	-	-	-	-	4
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-	-	-	-	-	2
-	1	1	1-1803504-9	CRIMPER, WIRE	1

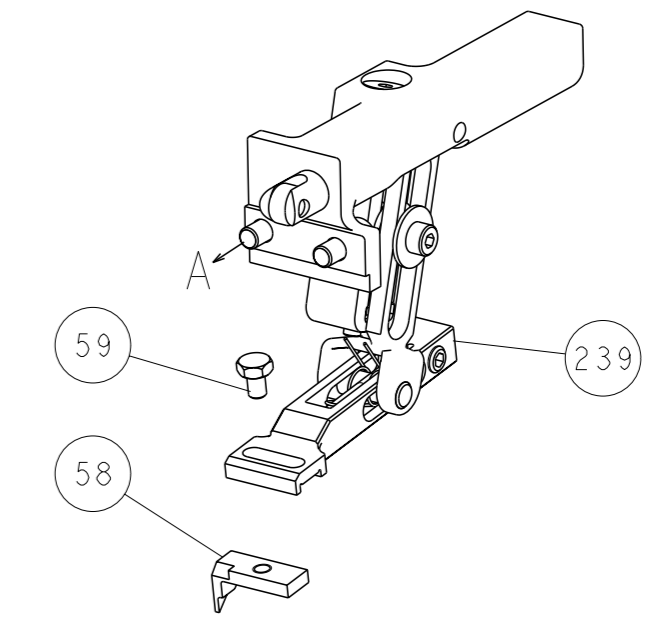
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mm		0 PLC	±	CHK	T	ELBIN	08JUN2018	Harrisburg, PA 17105-3608		
		1 PLC	±	APVD	T	ELBIN	08JUN2018	NAME		
		3 PLC	±	PRODUCT SPEC		Ocean End Feed Applicator				
		4 PLC	±	APPLICATION SPEC		-				
MATERIAL		FINISH	±	WEIGHT		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO
-		-	-	-		A1		00779	©=2150923	-
				Customer Accessible Production Drawing		SCALE		1:1	SHEET	3 of 4

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

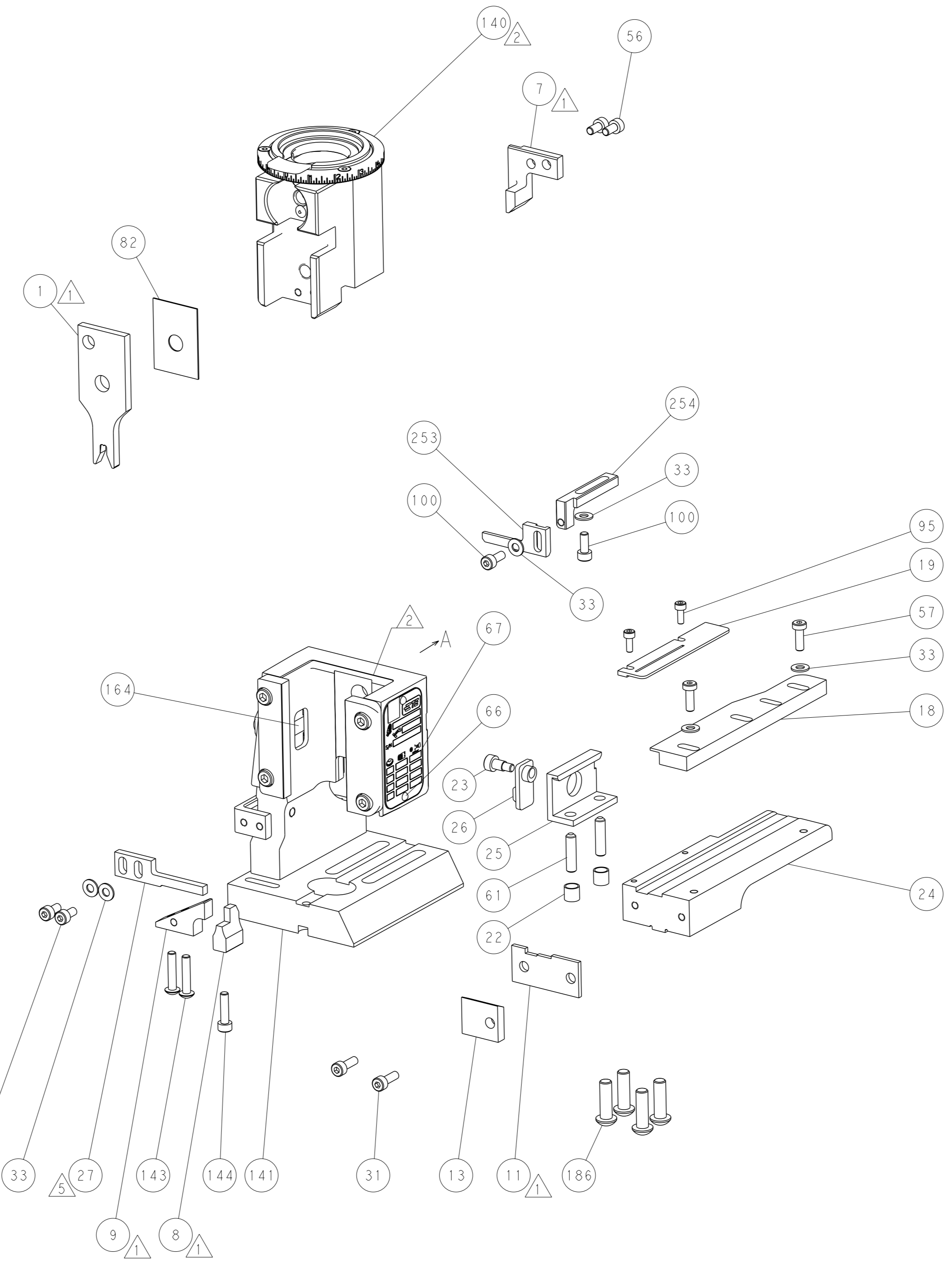
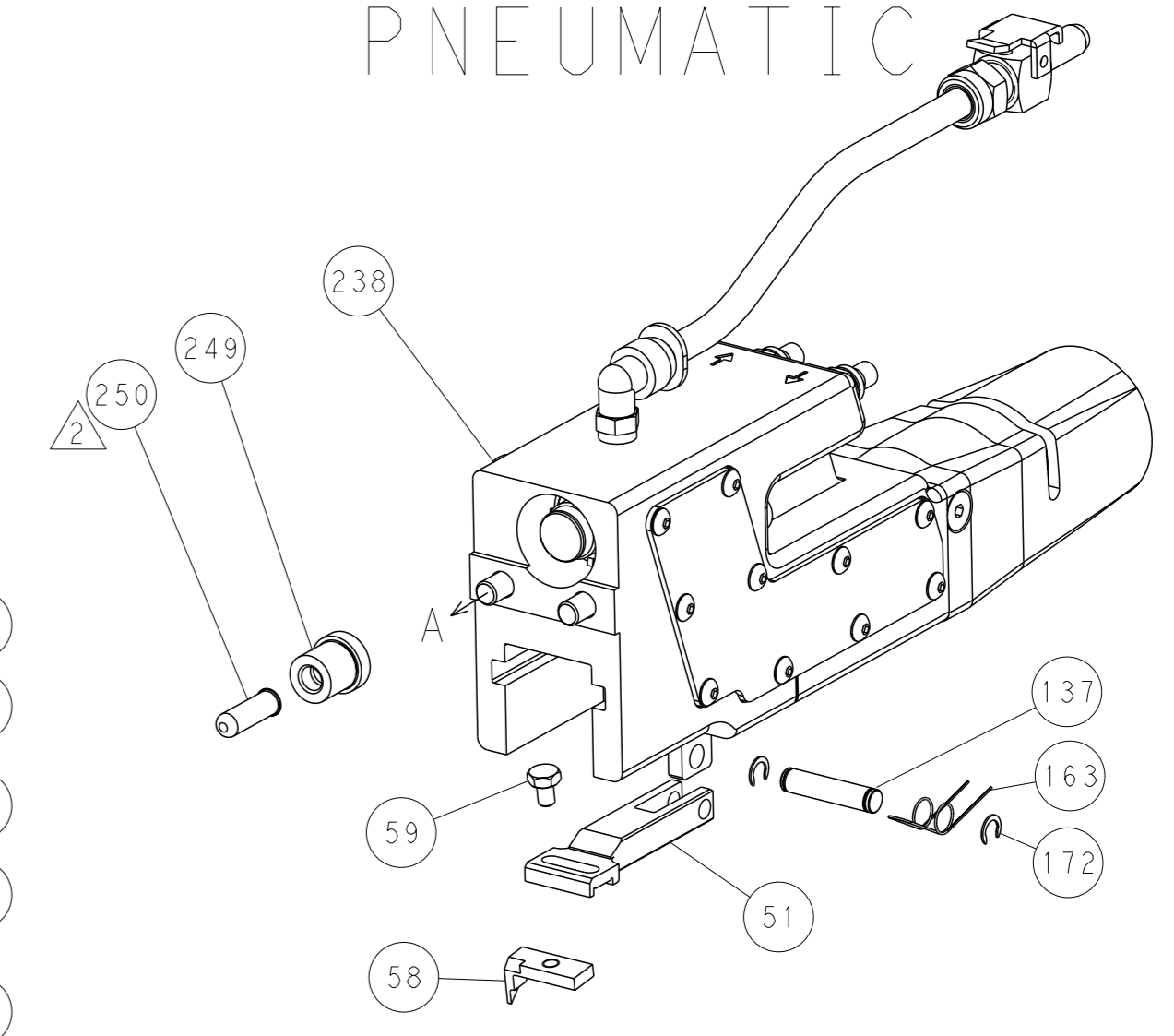


RAM SET-UP

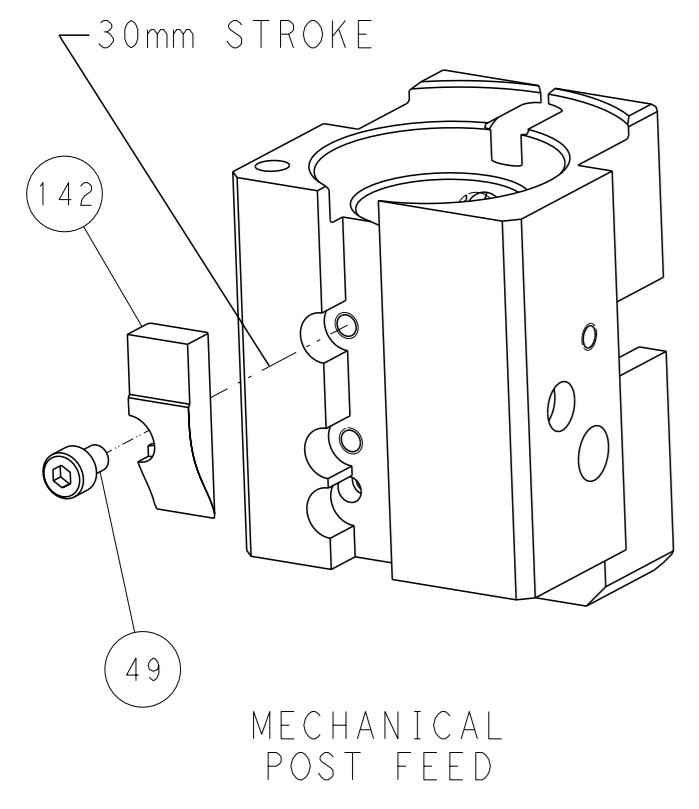
FEED TYPE  
MECHANICAL



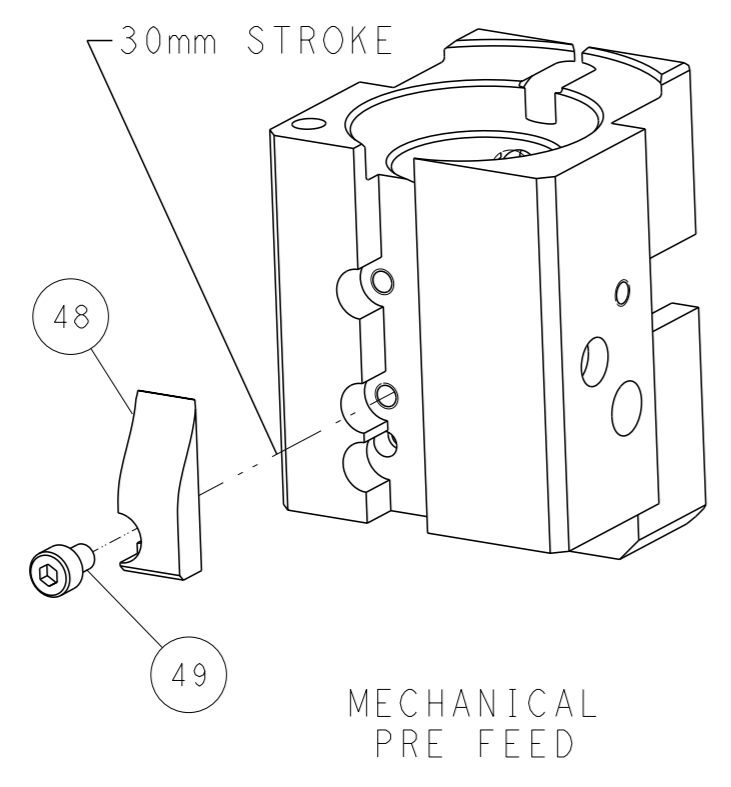
PNEUMATIC



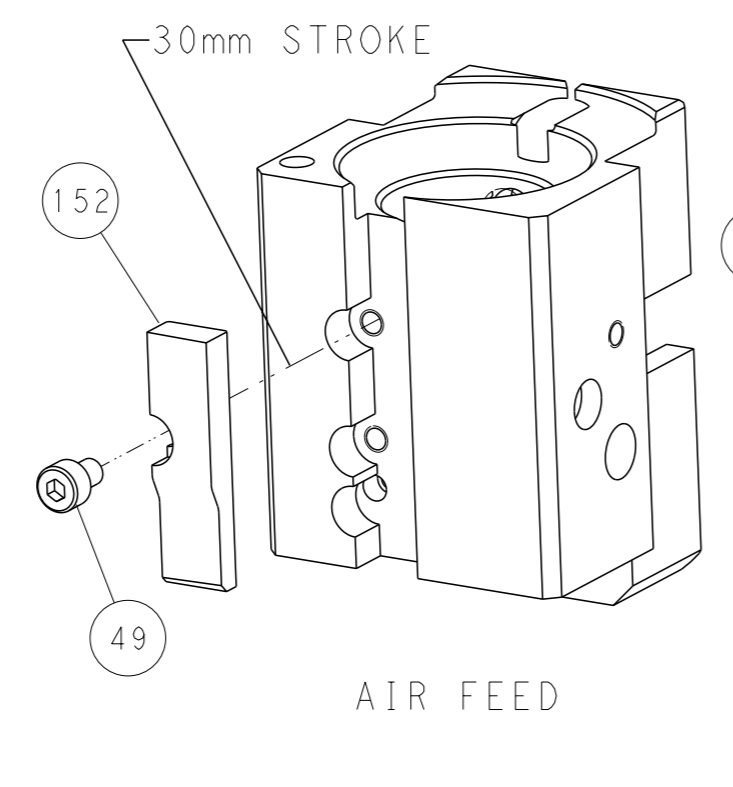
CAM POSITIONS



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)

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