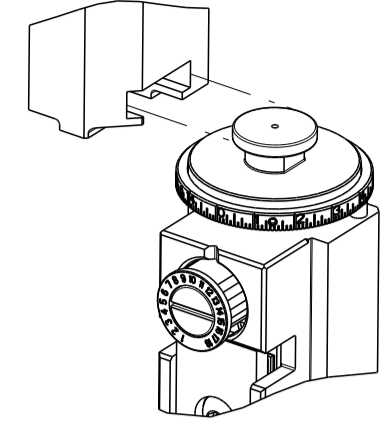


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150926-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150926-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150926-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150926-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150926-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.50 mm [.217-.256 IN]		Ø3.80-5.10 mm [.150-.201 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20023		
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180363-1	180363-2	180363-7	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79+/-0.03 [.110+/- .001]	3.8
4.00mm2	2.41+/-0.03 [.095+/- .001]	7.7

- 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.

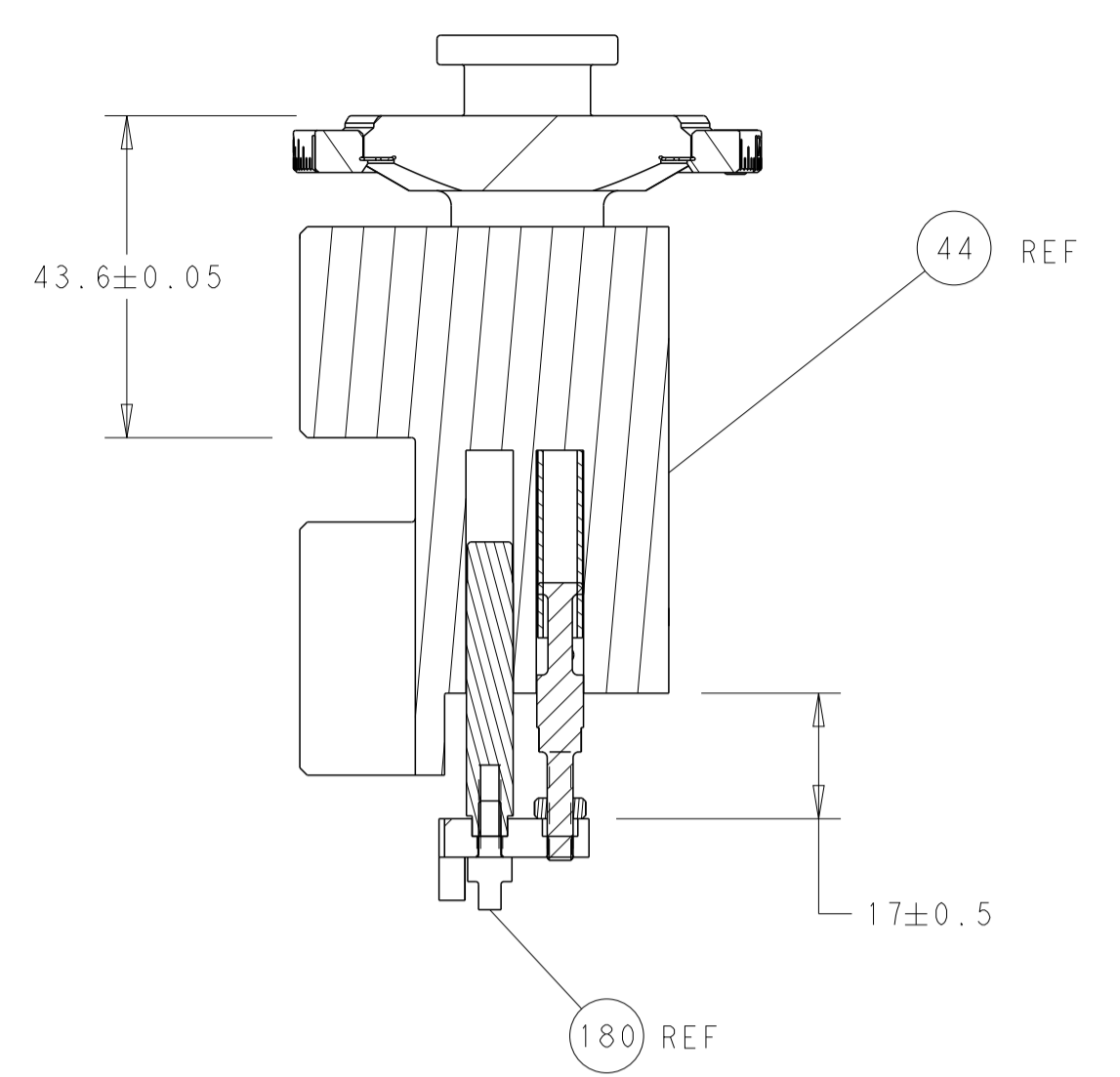
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	06JUN2018	TB	CT
		A		RELEASE	02JUL2018	AW	GB
		B		ECR-22-146575	18JUL2022	JWC	ROY
		C		ECR-23-175079	11MAY2023	JWC	JH

-	1	1	1	1	2119791-7	DEPRESSOR, WIRE	282	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	
³	-	1	1	1	2-455888-2	SPACER, CRIMPER	185	
-	1	1	1	1	1-1976055-3	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	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-6	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	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	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	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
-	8	8	8	8	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	690455-2	STRIPPER, FRONT CASTING	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	1803152-1	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-1	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	5-240641-9	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
¹	-	1	1	1	4-690495-0	PLATE, FRONT SHEAR	9	
¹	1	2	2	1	3-1333223-4	ANVIL, COMBINATION	8	
¹	-	1	1	1	1-2217206-3	BLADE, SLUG	7	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6	
-	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
¹	1	2	2	1	7-1803016-9	CRIMPER, INSULATION F	3	
¹	1	2	2	1	456414-2	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

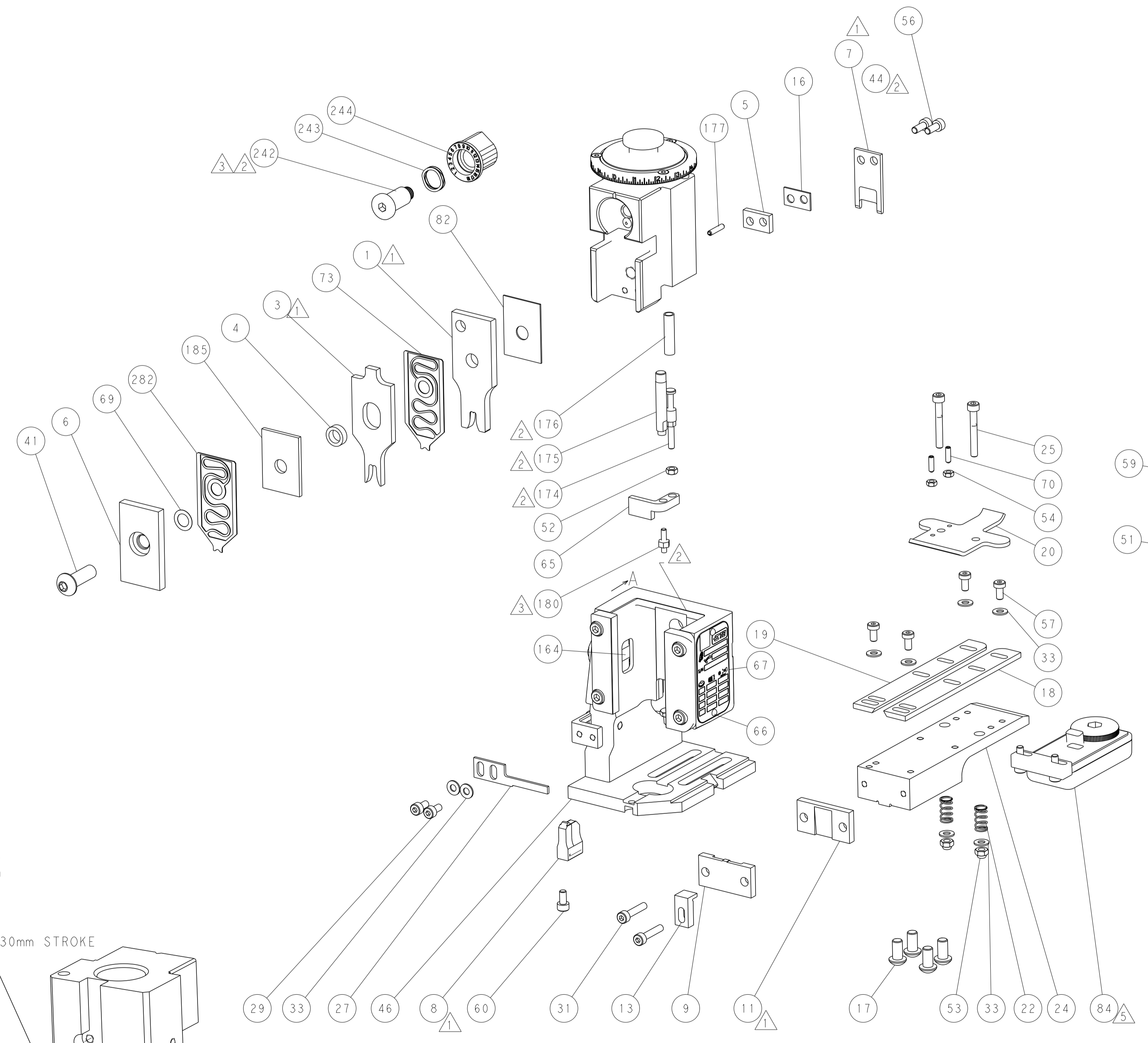
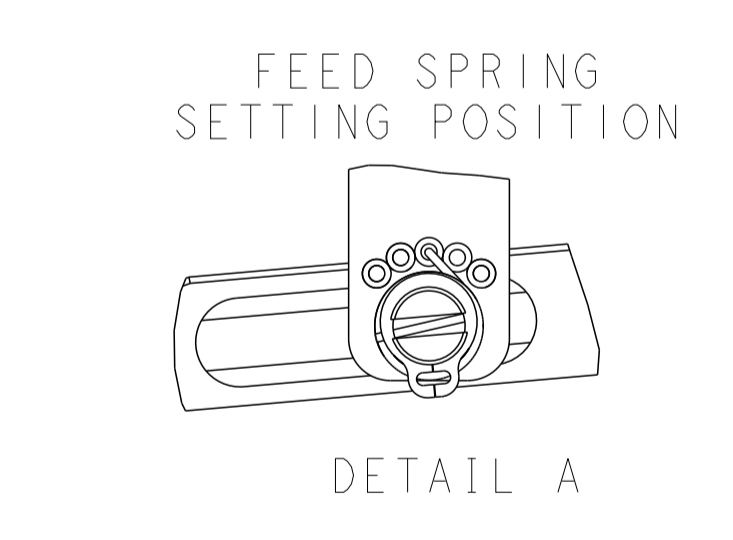
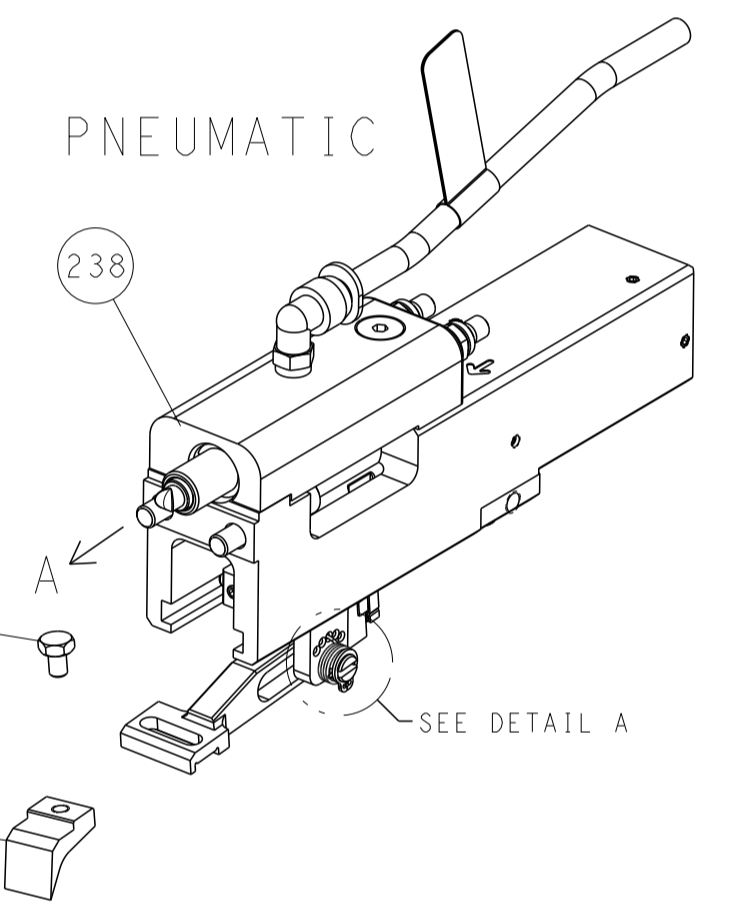
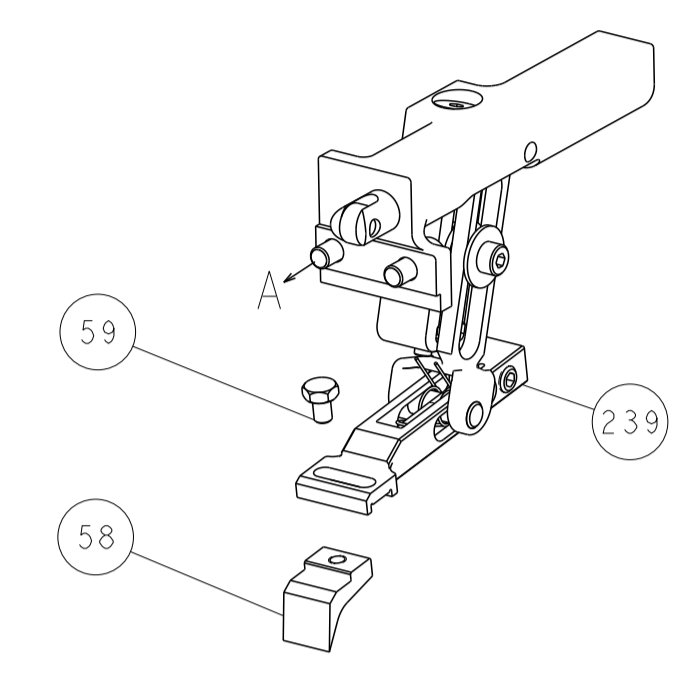
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

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

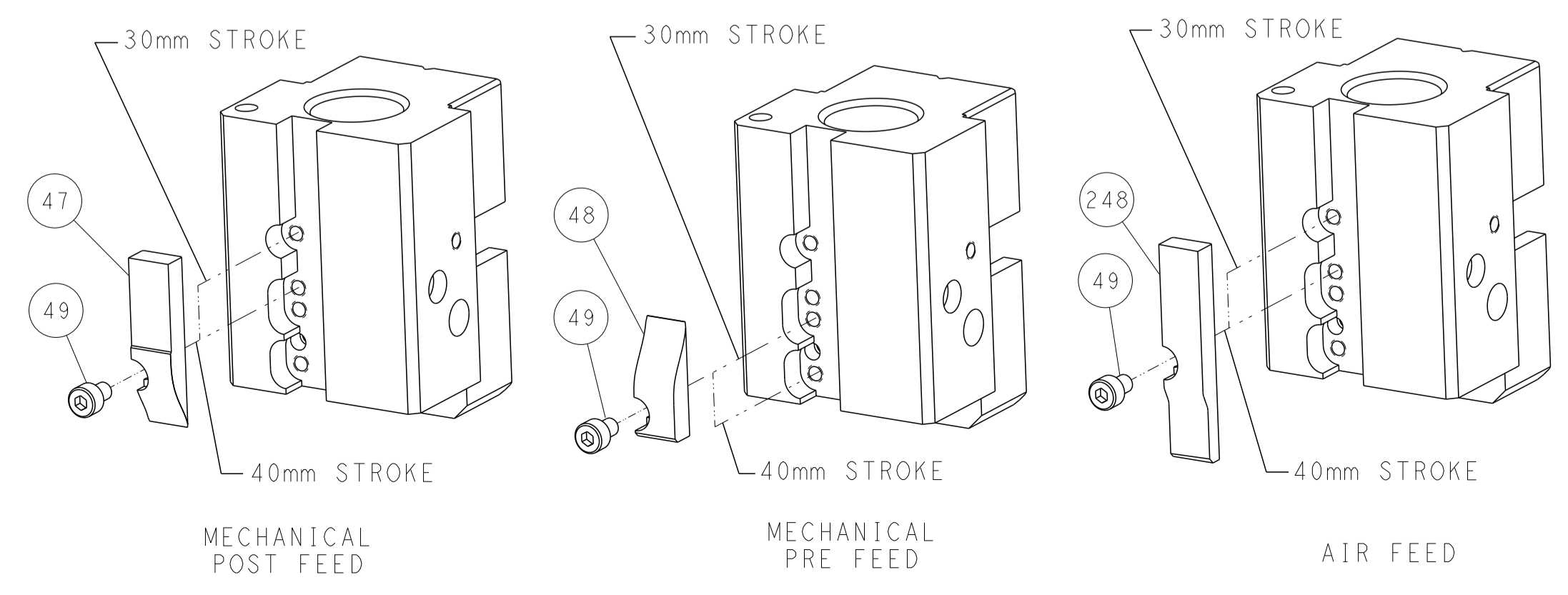


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

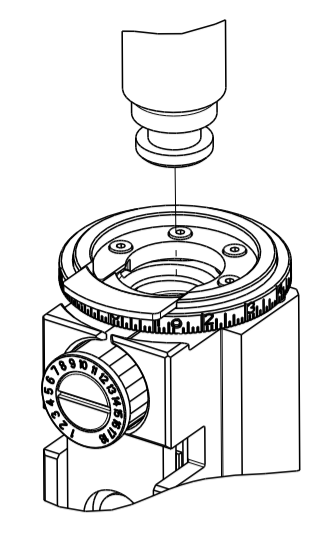


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 06JUN2018		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL:		WEIGHT:		SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
				A1	00779	©=2150926	
Customer Accessible Production Drawing				SCALE:	1:1	SHEET:	2 of 4
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION							

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150926-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150926-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150926-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.60]	F
INSUL	5.33 mm [2.10]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.50-6.50 mm [1.217-.256 IN]	Ø3.80-5.10 mm [1.150-.201 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180363-1	180363-2	180363-7	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79+/-0.03 [1.110+/-0.001]	3.8
4.00mm2	2.41+/-0.03 [0.95+/-0.001]	7.7

- 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. 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.

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

LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD		
-	1	1		2119791-7				DEPRESSOR, WIRE	282
-	1	1		2119082-9				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
-	4	4		2079383-9				SCR, BHSC, RoHS (M6 X 20)	186
-	1	1		2-455888-2				SPACER, CRIMPER	185
3	-	1		1-1976055-3				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		455888-7				SPACER, CRIMPER	82
-	1	1		2119791-6				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
-	1	1		1901681-5				HOLDDOWN, TERMINAL	65
-	1	1		5-18022-5				SCR, HEX HD CAP, M4 X 6.0	59
-	-	1		2063961-1				FEED FINGER	58
-	4	4		2168400-4				SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2		1-2168083-0				SCR, SKT HD CAP, RoHS, M4 X 10	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
-	8	8		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		690455-2				STRIPPER, FRONT CASTING	27
-	2	2		1-2168083-5				SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1		1-1752371-2				PLATE, STRIP GUIDE	24
-	2	2		22281-8				SPRING, COMPRESSION	22
-	1	1		1803292-4				DRAG	20
-	1	1		1803152-1				STRIP GUIDE, REAR	19
-	1	1		1803151-1				STRIP GUIDE, FRONT	18
-	1	1		5-240641-9				SPACER	16
1	-	1		1752360-1				SPACER,HOLD-DOWN	13
-	1	1		240644-5				PLATE, REAR SHEAR	11
-	-	-		-				-	10
1	-	1		4-690495-0				PLATE, FRONT SHEAR	9
1	1	1		3-1333223-4				ANVIL, COMBINATION	8
-	1	1		1-2217206-3				BLADE, SLUG	7
-	1	1		1803203-1				BLOCK, FRONT DEPRESSOR	6
-	1	1		240641-1				SPACER	5
1	-	1		4-238011-2				BLOCK, CRIMPER SPACER	4
1	1	1		7-1803016-9				CRIMPER, INSULATION F	3
1	1	1		456414-2				CRIMPER, WIRE	1

LOC	DIST	REV	DATE	BY	APPD
A	66				

TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed
 Applicator

Customer Accessible Production Drawing

SCALE 1:1 SHEET 3 OF 4 REV C

