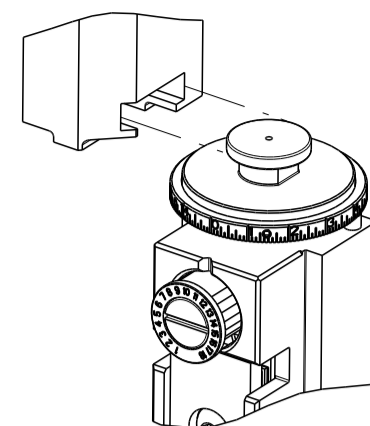


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150504-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150504-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150504-7	A	CRIMP TOOLING KIT	-

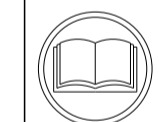
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 250SER. FASTIN-ON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.00 mm [.165-.197 IN]		Ø1.00-1.60 mm [.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962825-1	962825-2	962825-3	962825-5
962825-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.21 +/- 0.03 [.048 +/- .001]	5.5
0.35mm2	1.14 +/- 0.03 [.045 +/- .001]	6.3
0.25mm2	1.10 +/- 0.03 [.043 +/- .001]	6.7
0.20mm2	1.08 +/- 0.03 [.043 +/- .001]	6.9



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

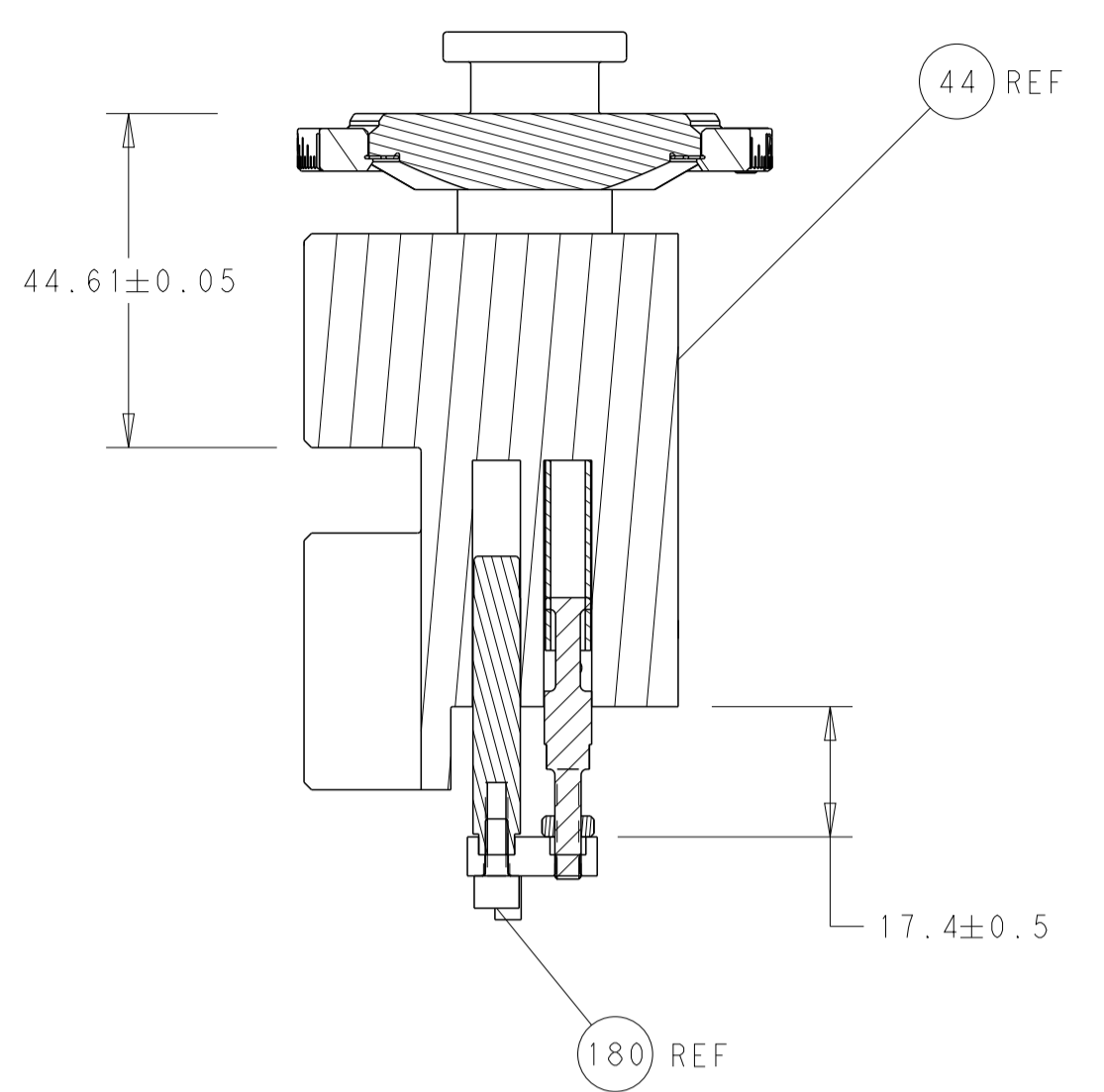
LOC	DIST	REVISIONS					
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		A		RELEASED	29DEC2014	KH	GB
		B		ECR-22-154754	06OCT2022	TB	RK
		C		ECR-22-159015	21NOV2022	ROY	JAH

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1752354-2	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	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	1976052-1	HOLDDOWN, TERMINAL	65	
-	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	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1	2063961-1	FEED FINGER	51	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2119655-5	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	
-	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	1-1752371-6	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-2	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-2	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	6-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	10	
1	-	1	1	5-690482-8	PLATE, FRONT SHEAR	9
1	1	2	1	2-1333215-4	ANVIL, COMBINATION	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	7-240641-8	SPACER	5
-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	5-1803019-2	CRIMPER, INSULATION O	3
-	1	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	2	1	1-456404-8	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

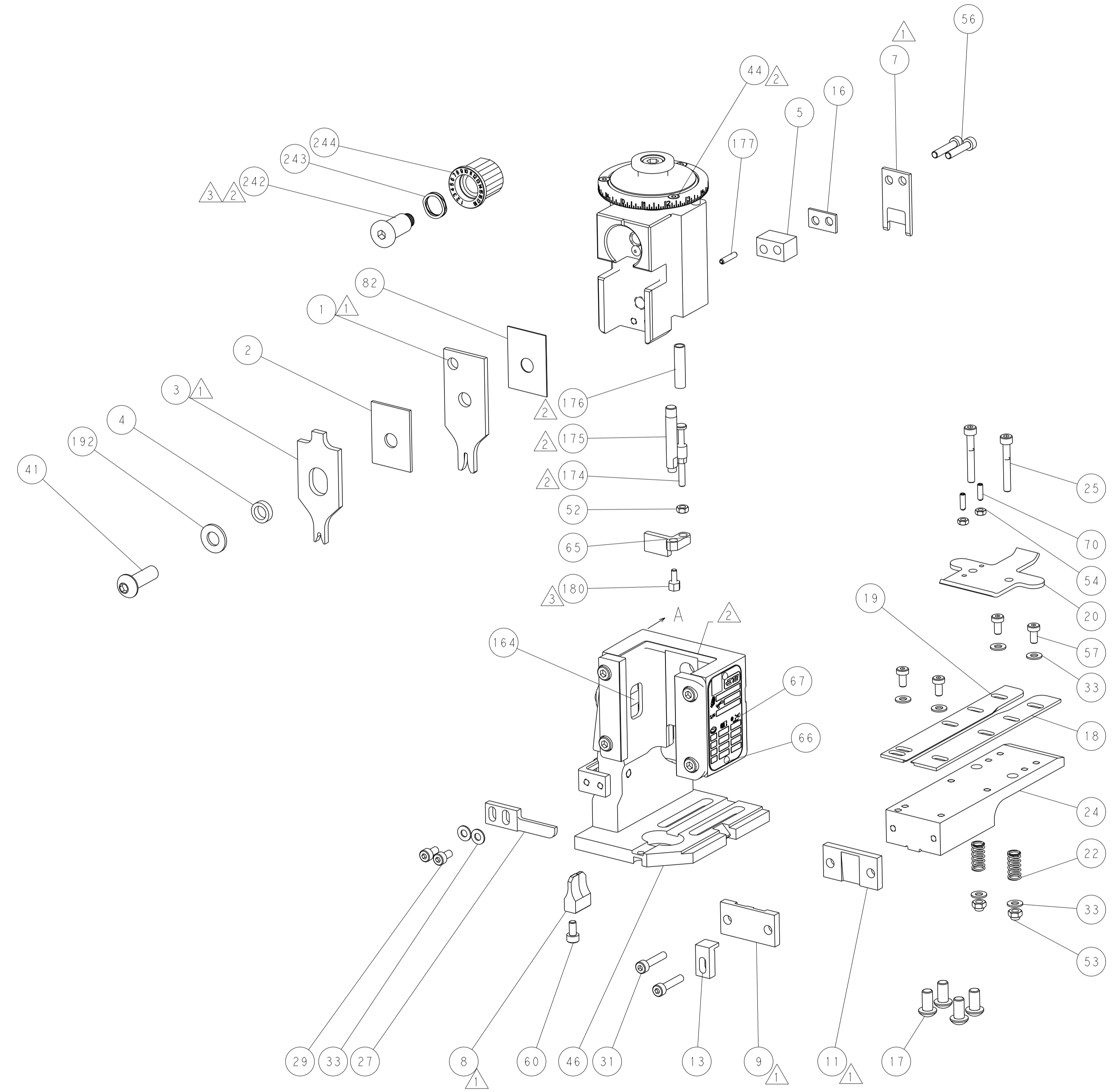
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	H. HUANG	L. ZHANG	U. GUO	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		A 00779 C=2150504		1 OF 4		C	

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

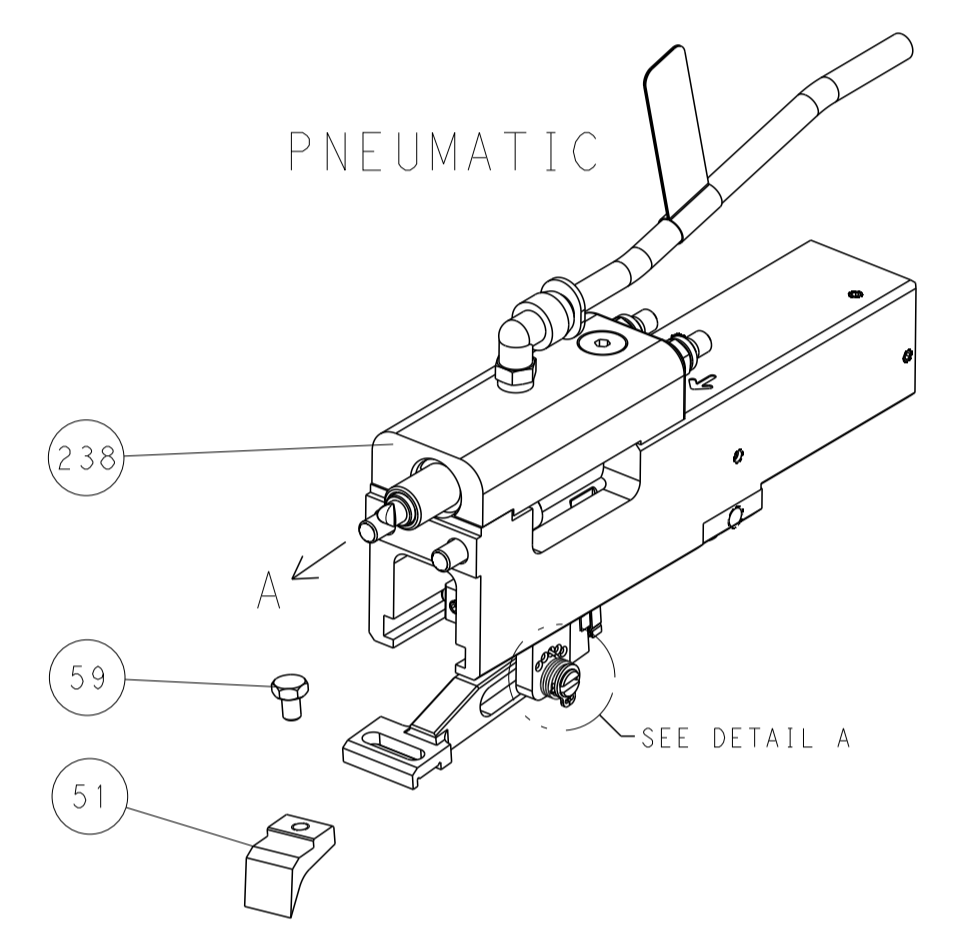


RAM AND HOLDDOWN SET-UP

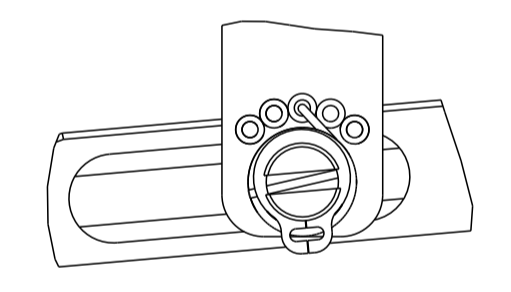


FEED TYPE

PNEUMATIC

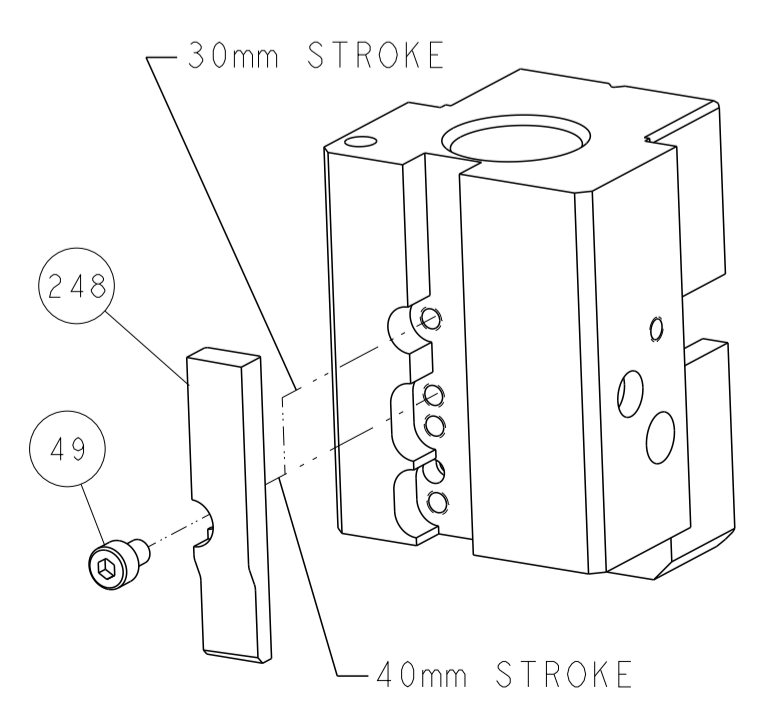


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



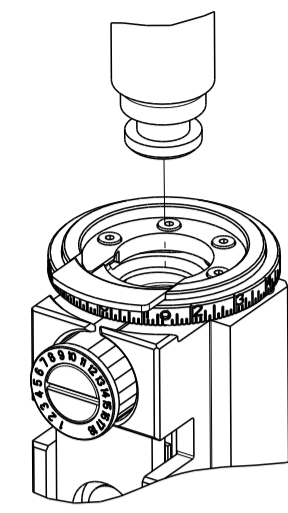
AIR FEED

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:		DWG: K. HUANG 28OCT2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK: L. ZHANG 28OCT2014	NAME: Ocean End Feed Applicator		
MATERIAL:				APVD: J. GUO 28OCT2014	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150504
				RESTRICTED TO:	SCALE: 1:1	SHEET: 2 OF 4	REV: C

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150504-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150504-7	A	CRIMP TOOLING KIT	-				

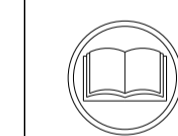
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250SER. FASTIN-ON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.00 mm [.165-.197 IN]		Ø1.00-1.60 mm [.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18022	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962825-1	962825-2	962825-3	962825-5
962825-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.21+/-0.03 [.048+/- .001]	5.5
0.35mm2	1.14+/-0.03 [.045+/- .001]	6.3
0.25mm2	1.10+/-0.03 [.043+/- .001]	6.7
0.20mm2	1.08+/-0.03 [.043+/- .001]	6.9



- 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.
- 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.

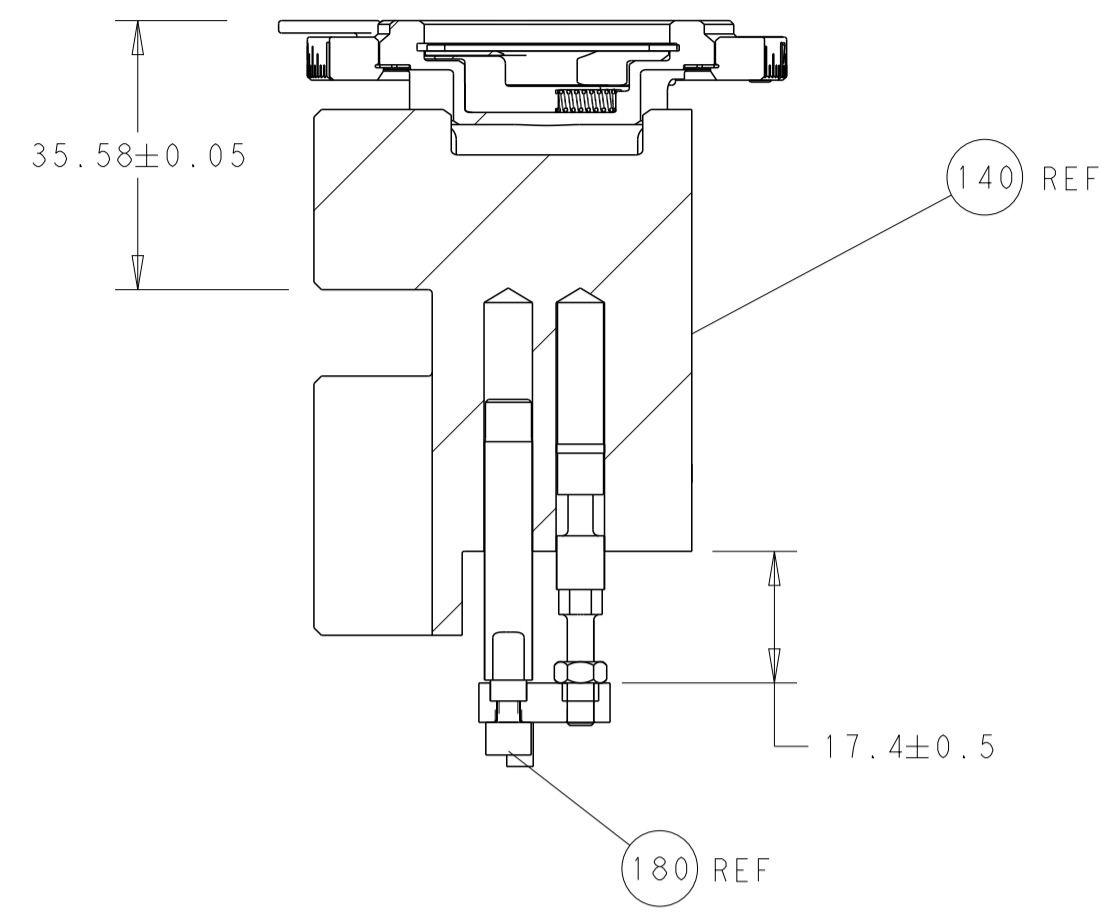
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1752354-2	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	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	1976052-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	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	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1-1752371-6	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1-1901696-2	STRIP GUIDE, REAR	19	
-	1	1-1901695-2	STRIP GUIDE, FRONT	18	
-	1	6-240641-4	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	5-690482-8	PLATE, FRONT SHEAR	9	
1	1	2-1333215-4	ANVIL, COMBINATION	8	
-	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	6	
-	1	7-240641-8	SPACER	5	
-	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	5-1803019-2	CRIMPER, INSULATION O	3	
-	1	1-455888-5	SPACER, CRIMPER	2	
1	1	1-456404-8	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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG CHK L. ZHANG APVD J. GUO		280CT2014 280CT2014 280CT2014		NAME Ocean End Feed Applicator	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	mm	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	SCALE 1:1 SHEET 3 OF 4 REV C	
MATERIAL		FINISH		WEIGHT		A1 00779		Customer Accessible Production Drawing	

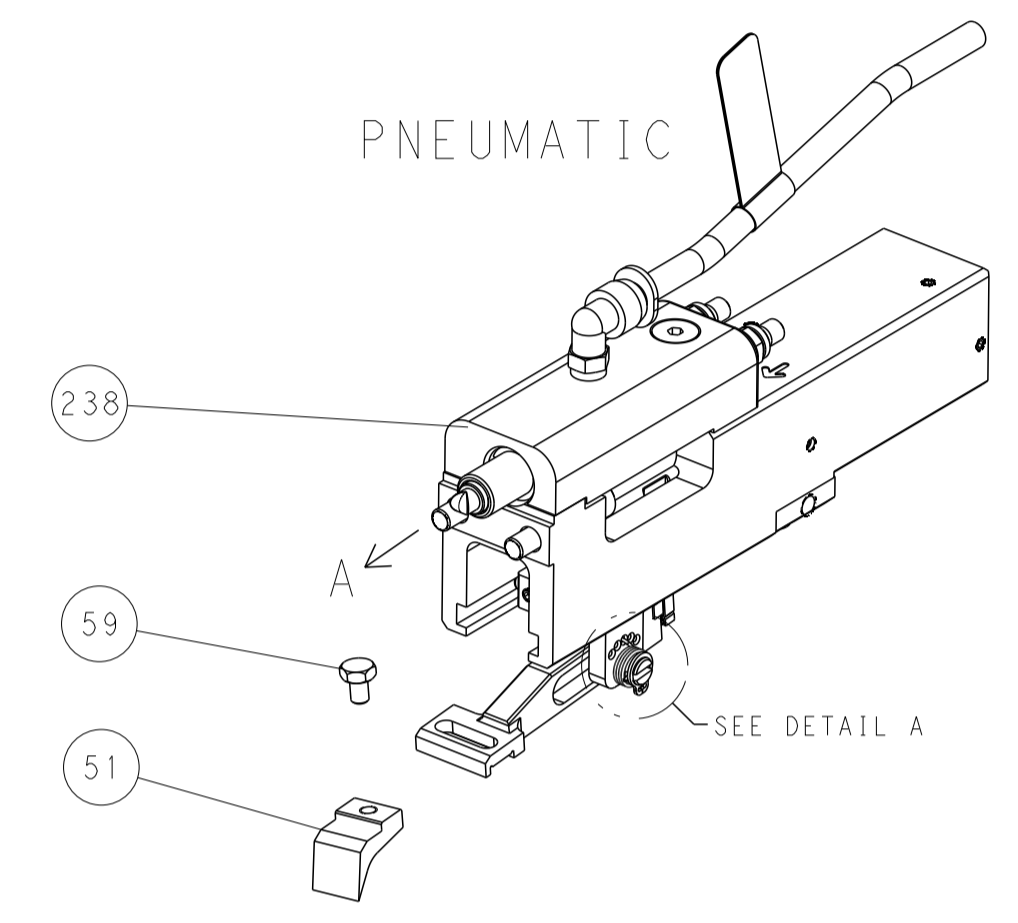
LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	-	SEE SHEET 1	-	-	-



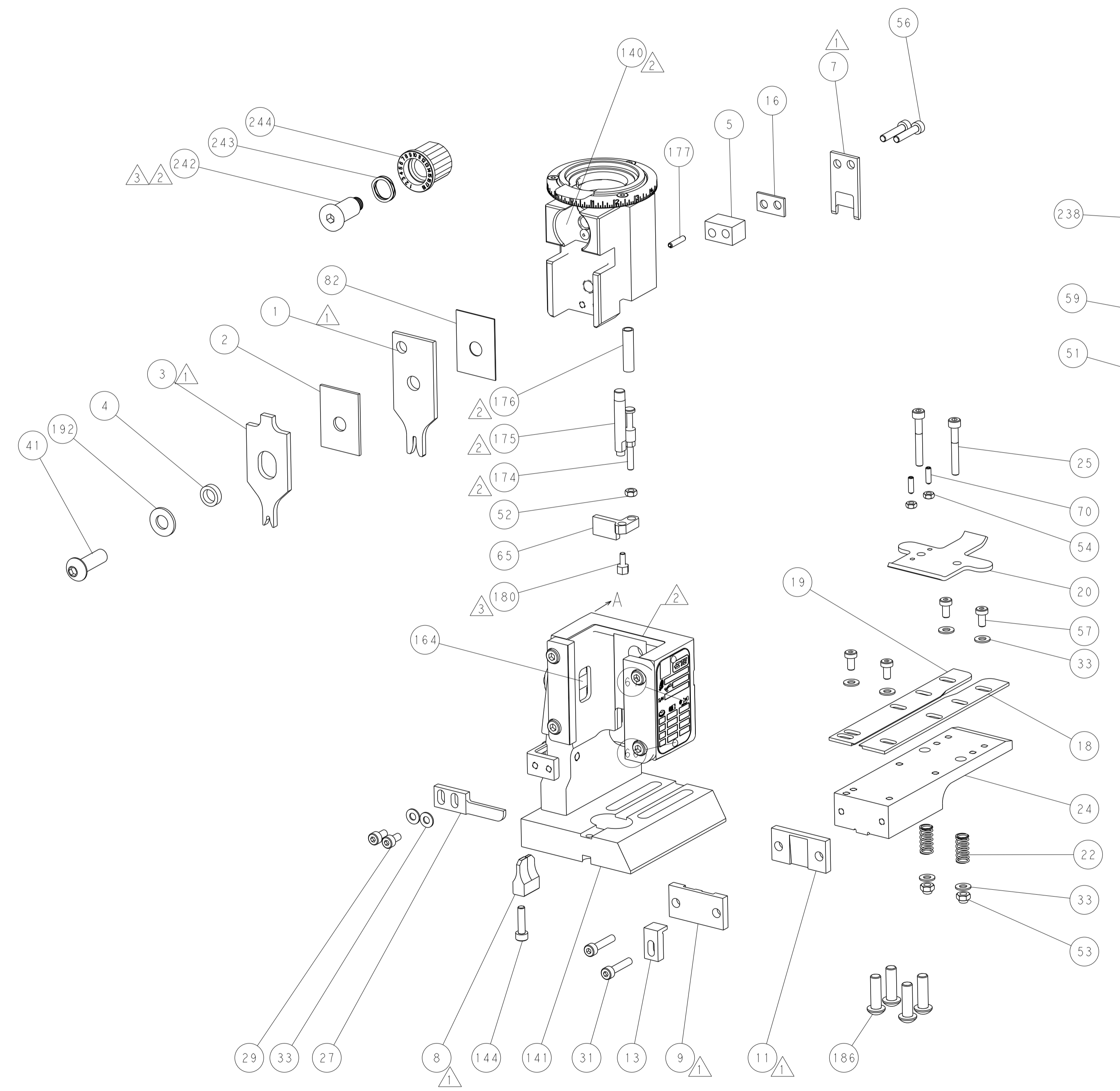
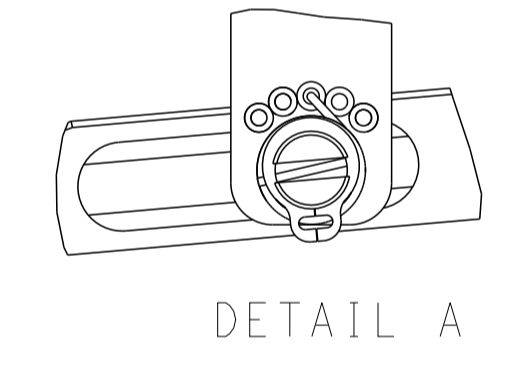
RAM AND HOLDDOWN SET-UP

FEED TYPE

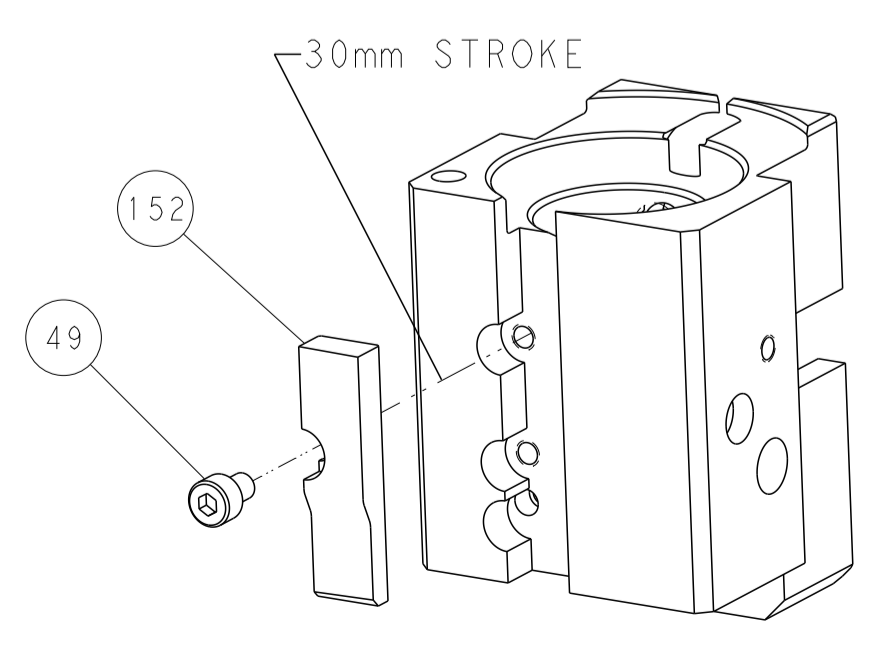
PNEUMATIC



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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:		DWN K. HUANG 28OCT2014		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: L. ZHANG 28OCT2014	NAME:	RESTRICTED TO:	
			1:1	U. GUO 28OCT2014	Ocean End Feed Applicator		
				Customer Accessible Production Drawing	00779 ©=2150504		
					SHEET 4 OF 4		