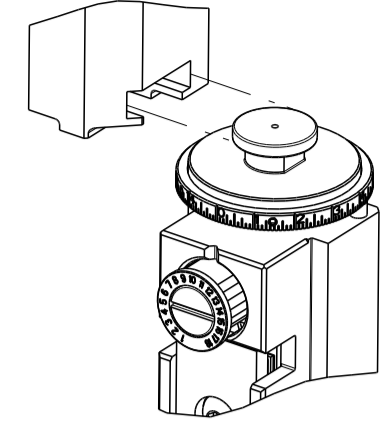


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150250-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150250-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150250-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150250-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150250-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.59 mm [.220]	Ø

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPLIVAR FASTON FLAG RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.38-4.40 mm [.173-.173 IN]		Ø2.79-3.81 mm [.110-.150 IN] OR 2 X Ø2.79 mm [.110 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2079		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742049-1	1742088-1	1742089-1	
	1742088-2	1742089-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.65+/-0.05 [.065+/-0.002]	5.5
2X 18 AWG	1.52+/-0.05 [.060+/-0.002]	6.7
16 AWG	1.42+/-0.05 [.056+/-0.002]	8.0
2X 20 AWG	1.37+/-0.05 [.054+/-0.002]	8.4
18 AWG	1.27+/-0.05 [.050+/-0.002]	9.6

- 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.
  - 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. 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.

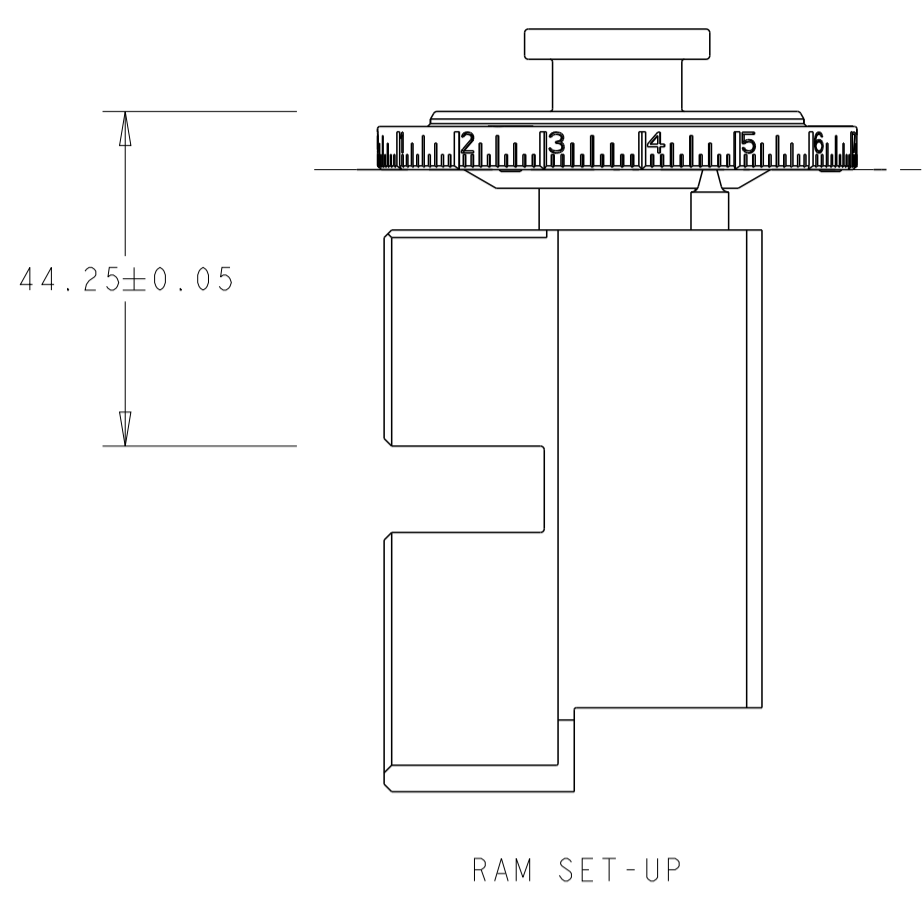
REVISIONS				
P	LTN	DESCRIPTION	DATE	APPV
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C1		ECR-15-006159	21APR2015	JH JT
D		ECR-17-001004	23JAN2017	TB GB
E		ECR-22-134485	05APR2022	JWC ROY

-	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
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-4	AIR FEED MODULE	238
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	188
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-455888-3	SPACER, CRIMPER	82
-	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	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
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	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	2161920-1	NARROW PAWL, 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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	240639-4	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	1	464452-4	DRAG, STOCK	20
-	1	1	1	1	5-1901696-7	STRIP GUIDE, REAR	19
-	1	1	1	1	5-1901695-7	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	2	2	2	2	469633-1	BLOCK, SUPPORT	14
-	1	1	1	1	455961-5	PLATE, FRONT SHEAR	11
-	2	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10
-	1	1	1	1	461160-3	PLATE, REAR SHEAR	9
-	1	2	2	1	1-1803000-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2161927-1	BLADE, SLUG	7
-	1	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	2
-	1	2	2	1	2-464112-3	CRIMPER, WIRE	1

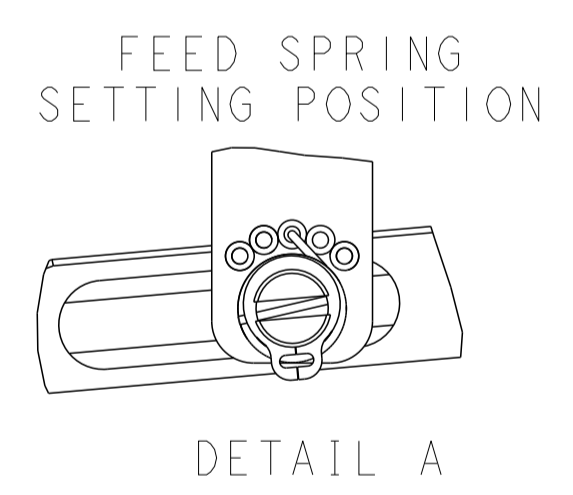
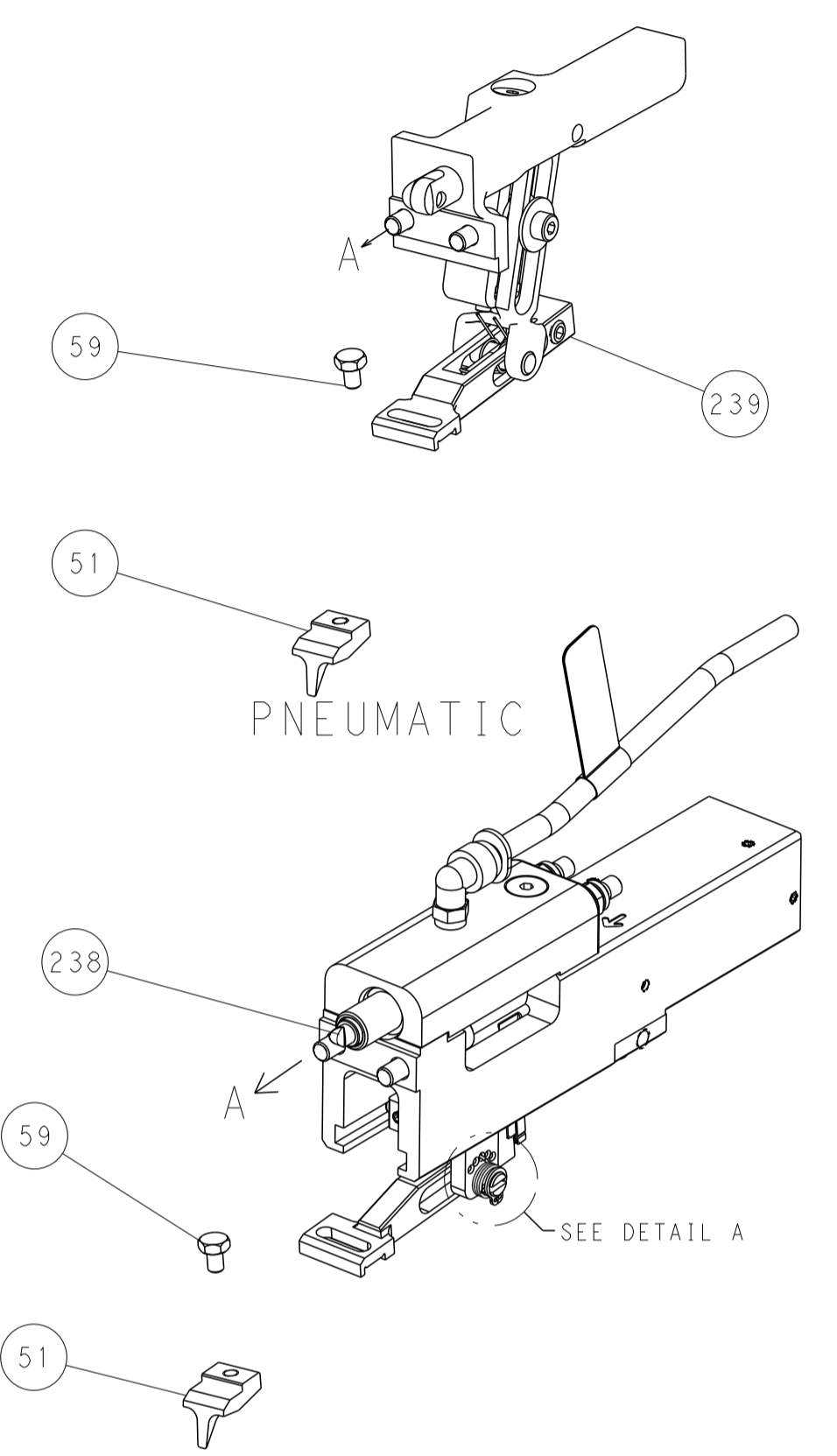
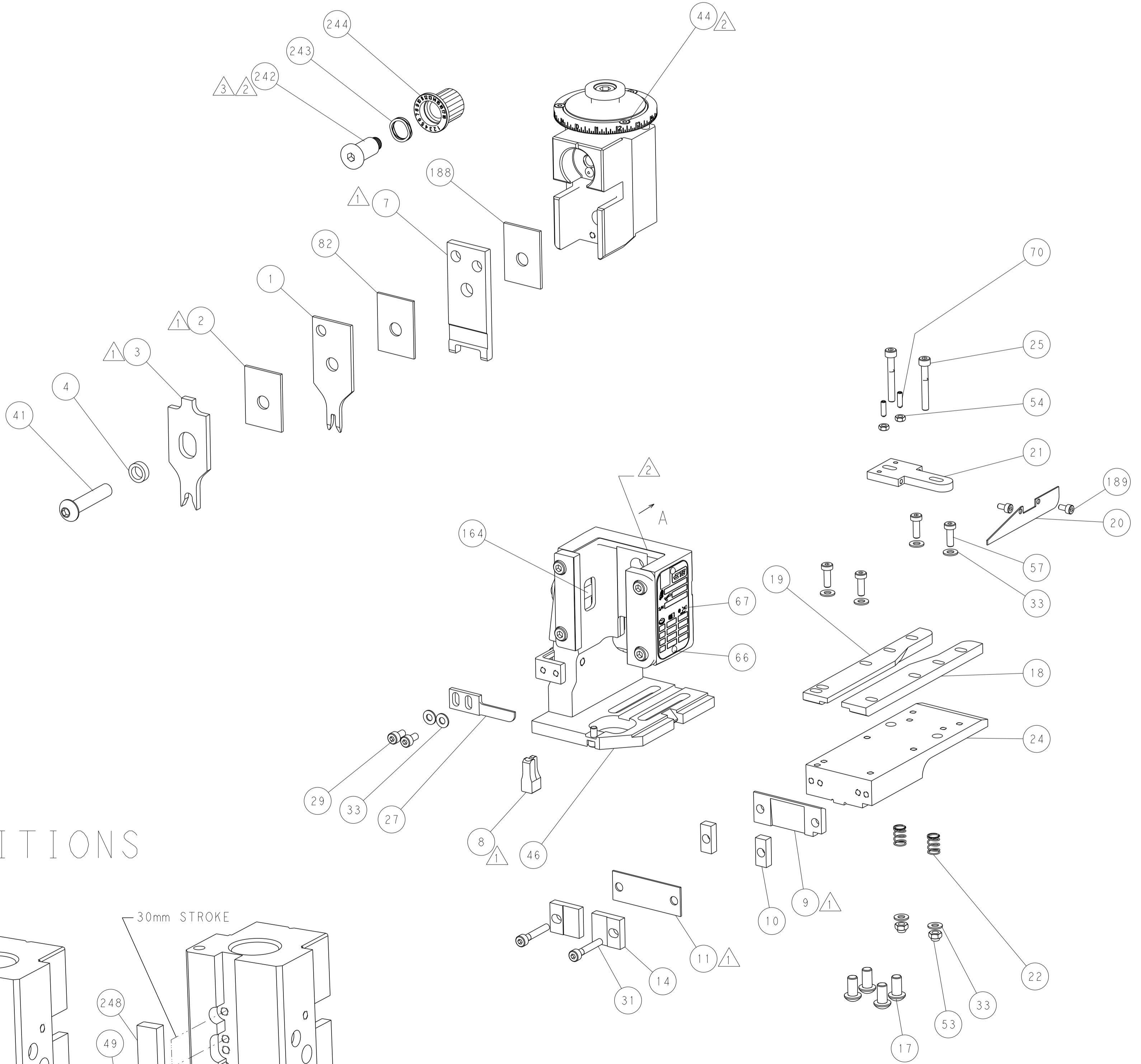
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWG		NAME	
DIMENSIONS: mm		C. MOYER	Z1MAR2012	Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		G. BAILEY	Z1MAR2012	-	
0 PLC	±	G. BAILEY	Z1MAR2012	-	
1 PLC	±	APPLICATOR SPEC			
3 PLC	±	SIZE CAGE CODE DRAWING NO RESTRICTED TO			
4 PLC	±	A1 C=2150250			
ANGLES	±	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:1 SHEET 1 OF 4 REV E			
FINISH	±				

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

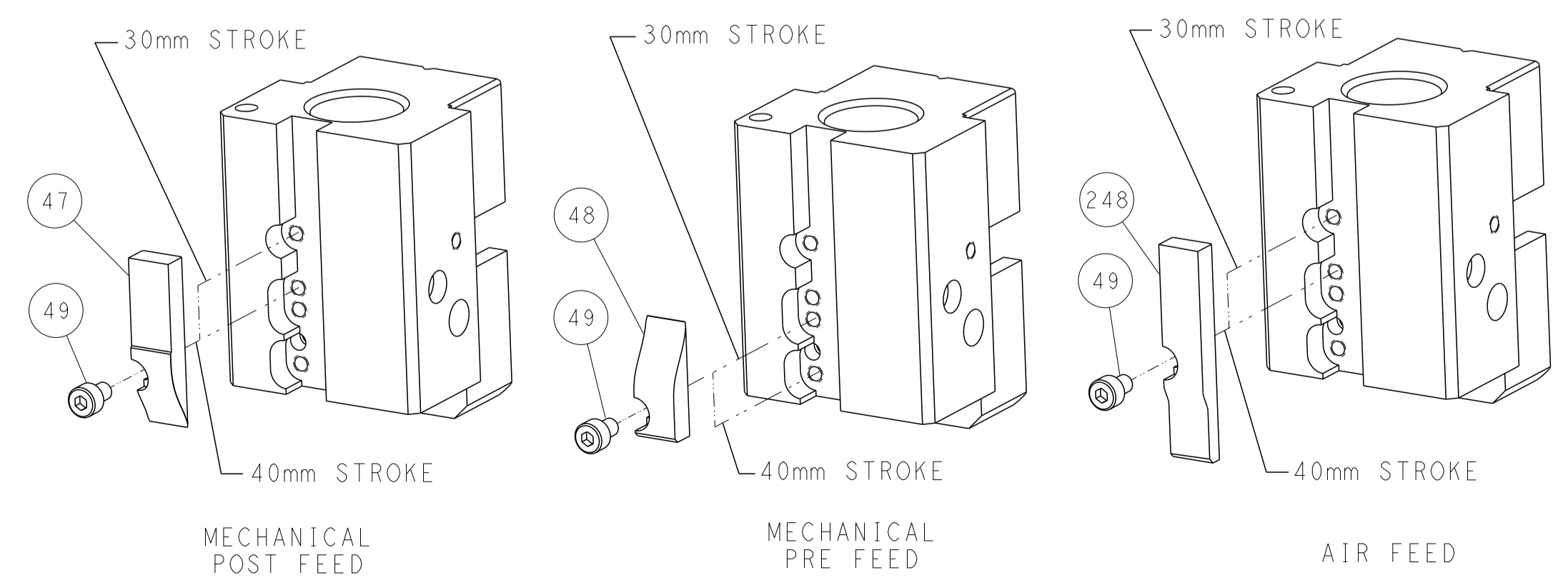
REVISIONS				
P	LTN	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-



# FEED TYPE MECHANICAL



# CAM POSITIONS

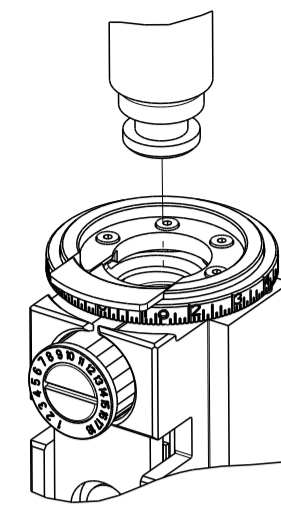


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: C. MOYER 21MAR2012	TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 21MAR2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: G. BAILEY 21MAR2012	NAME: Ocean End Feed Applicator
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC	SIZE: A1
MATERIAL:		APPLICATION SPEC	CAGE CODE: C=2150250
FINISH:		WEIGHT:	SCALE: 1:1
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO:	SHEET 2 OF 4
			REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150250-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150250-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150250-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER

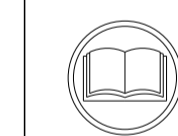


REVISIONS				
P	LTN	DESCRIPTION	DATE	OWN
-	-	SEE SHEET 1	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.59 mm [.220]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPLIVAR FASTON FLAG RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.38-4.40 mm [.173-.173 IN]		Ø 2.79-3.81 mm [.110-.150 IN] OR 2 X Ø 2.79 mm [.110 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2079	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742049-1	1742088-1	1742089-1	
	1742088-2	1742089-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.65 +/- 0.05 [.065 +/- .002]	5.5
2X 18 AWG	1.52 +/- 0.05 [.060 +/- .002]	6.7
16 AWG	1.42 +/- 0.05 [.056 +/- .002]	8.0
2X 20 AWG	1.37 +/- 0.05 [.054 +/- .002]	8.4
18 AWG	1.27 +/- 0.05 [.050 +/- .002]	9.6



- 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.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

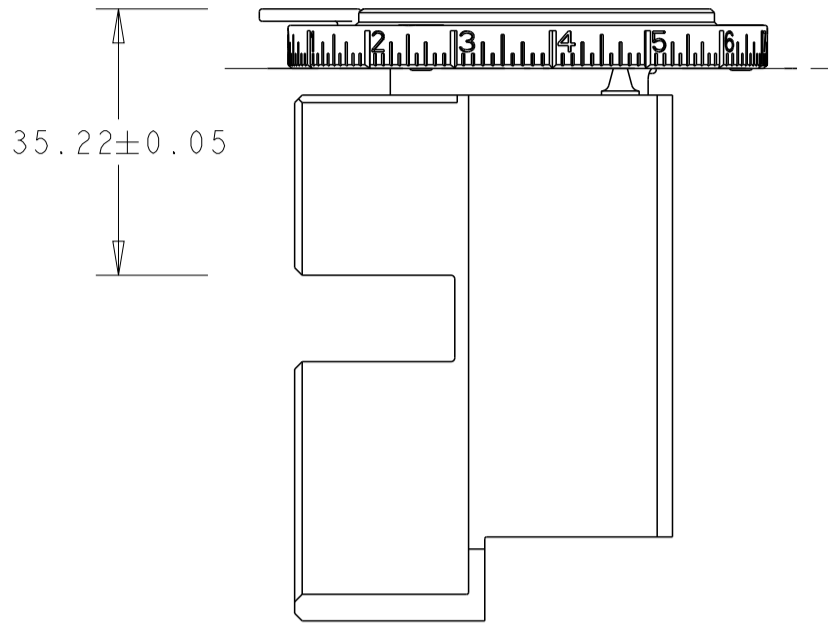
**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

-	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	-	2844940-4	AIR FEED MODULE	238	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189	
-	1	1	1-455888-6	SPACER, CRIMPER	188	
-	REF	REF	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	1-455888-3	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	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2161920-1	NARROW PAWL, 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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-4	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	2161922-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	464452-4	DRAG, STOCK	20	
-	1	1	5-1901696-7	STRIP GUIDE, REAR	19	
-	1	1	5-1901695-7	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	2	2	469633-1	BLOCK, SUPPORT	14	
1	-	1	455961-5	PLATE, FRONT SHEAR	11	
-	2	2	1-240645-9	SPACER, SHEAR PLATE	10	
1	-	1	461160-3	PLATE, REAR SHEAR	9	
1	1	1	1-1803000-0	ANVIL, COMBINATION, END FEED	8	
1	-	1	2161927-1	BLADE, SLUG	7	
-	1	1	238011-1	BLOCK, CRIMPER SPACER	4	
1	1	1	1-1633966-1	CRIMPER, INSULATION O	3	
-	1	1	1-455888-6	SPACER, CRIMPER	2	
1	1	1	2-464112-3	CRIMPER, WIRE	1	
-	77	22	21	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)

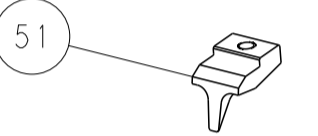
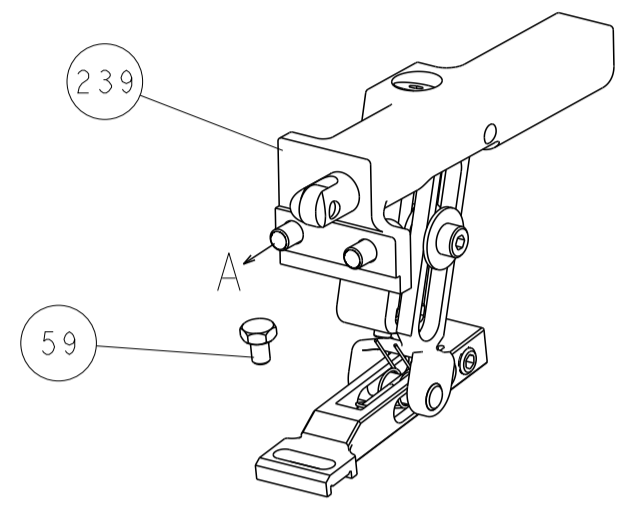
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	ANGLES ±	FINISH ±			
APPLICATOR DATA		APPLICATOR SPEC		WEIGHT	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1		SHEET 3 OF 4	

REVISIONS				
P.	LTN.	DESCRIPTION	DATE	OWN. APVD.
-	-	SEE SHEET 1	-	-

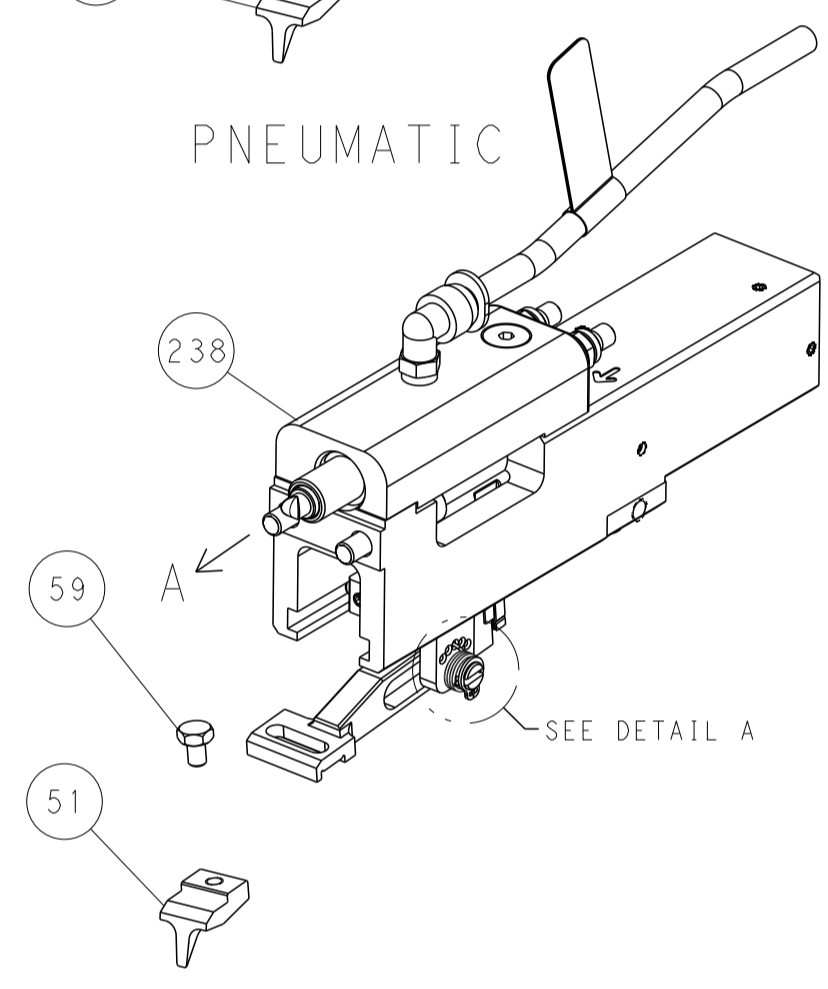


RAM SET-UP

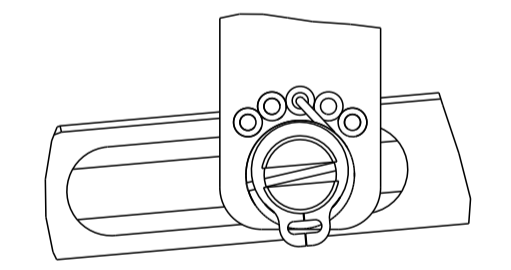
FEED TYPE  
MECHANICAL



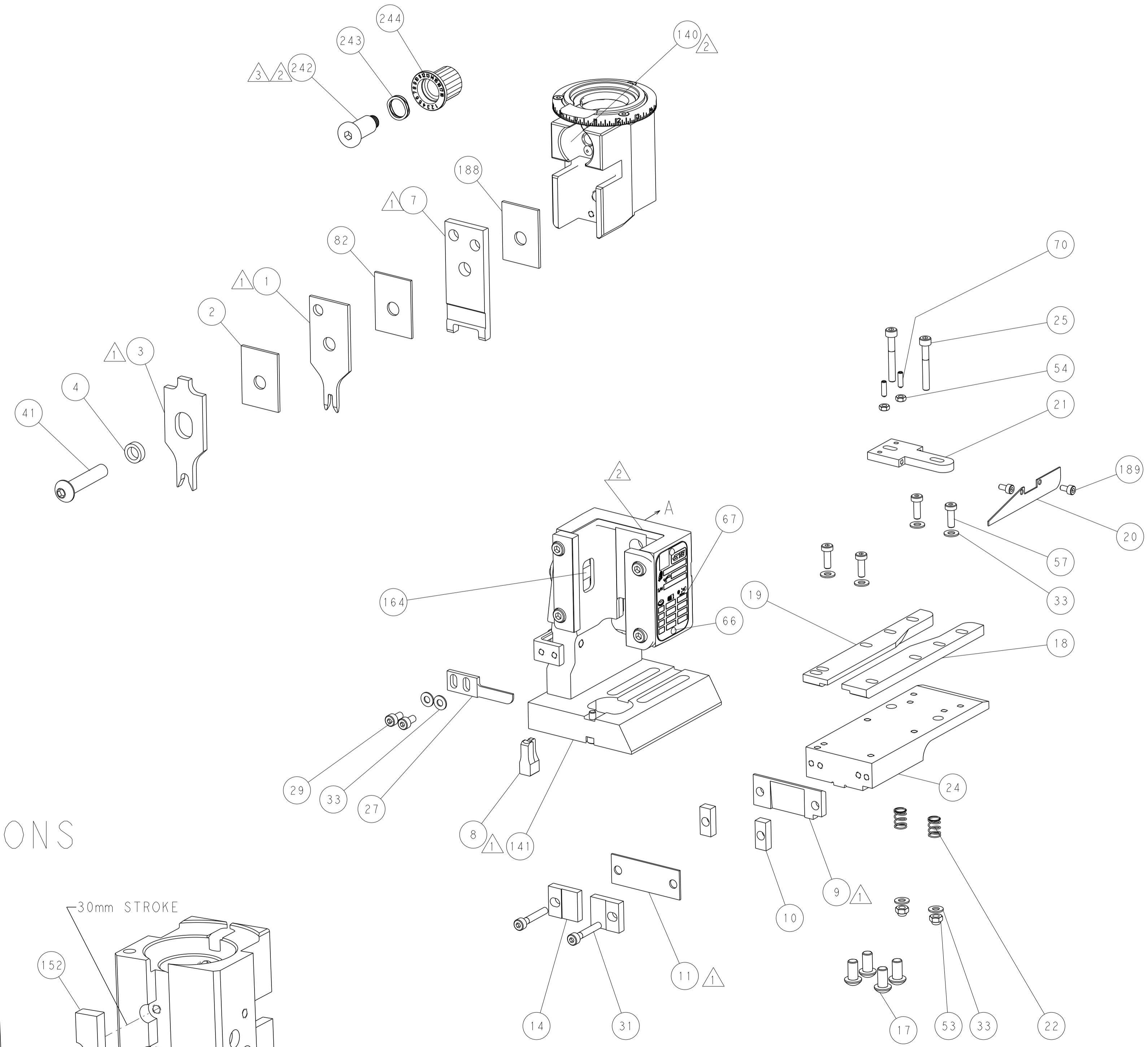
PNEUMATIC



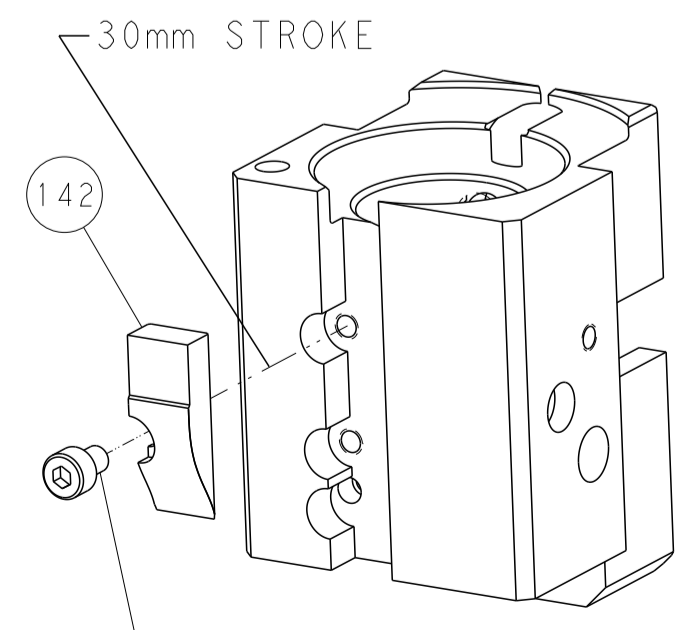
FEED SPRING  
SETTING POSITION



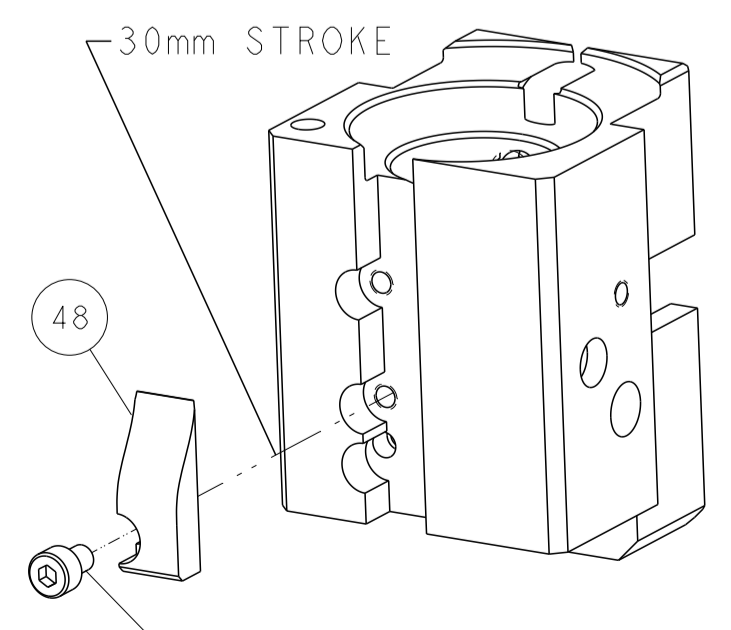
DETAIL A



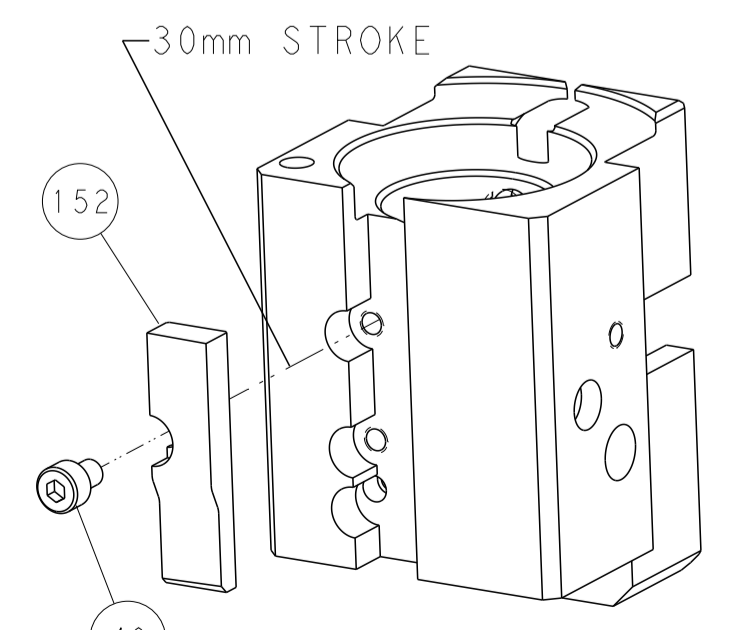
CAM POSITIONS



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)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: C. MOYER 21MAR2012	TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 21MAR2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: G. BAILEY 21MAR2012	NAME: Ocean End Feed Applicator
0 PLC	±	PRODUCT SPEC	SIZE: A1
1 PLC	±	APPLICATION SPEC	CAGE CODE: C=2150250
2 PLC	±	WEIGHT	SCALE: 1:1
3 PLC	±	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4
4 PLC	±		REV E
ANGLES	±		
FINISH	-		