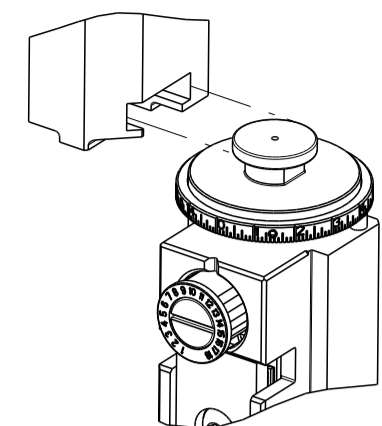


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150163-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150163-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150163-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	5.84 mm [.230]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES TAB ECONOSEAL 3 HC			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.00-5.50 mm [.197-.217 IN]		∅ 1.50-2.40mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3036		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
344069-1			347707-1	1.6-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [.071+/-0.002]	7.0
1.00mm2	1.60+/-0.05 [.063+/-0.002]	9.6
0.75mm2	1.50+/-0.05 [.059+/-0.002]	10.5
0.50mm2	1.37+/-0.05 [.054+/-0.002]	11.9



- 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 50.
- 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.

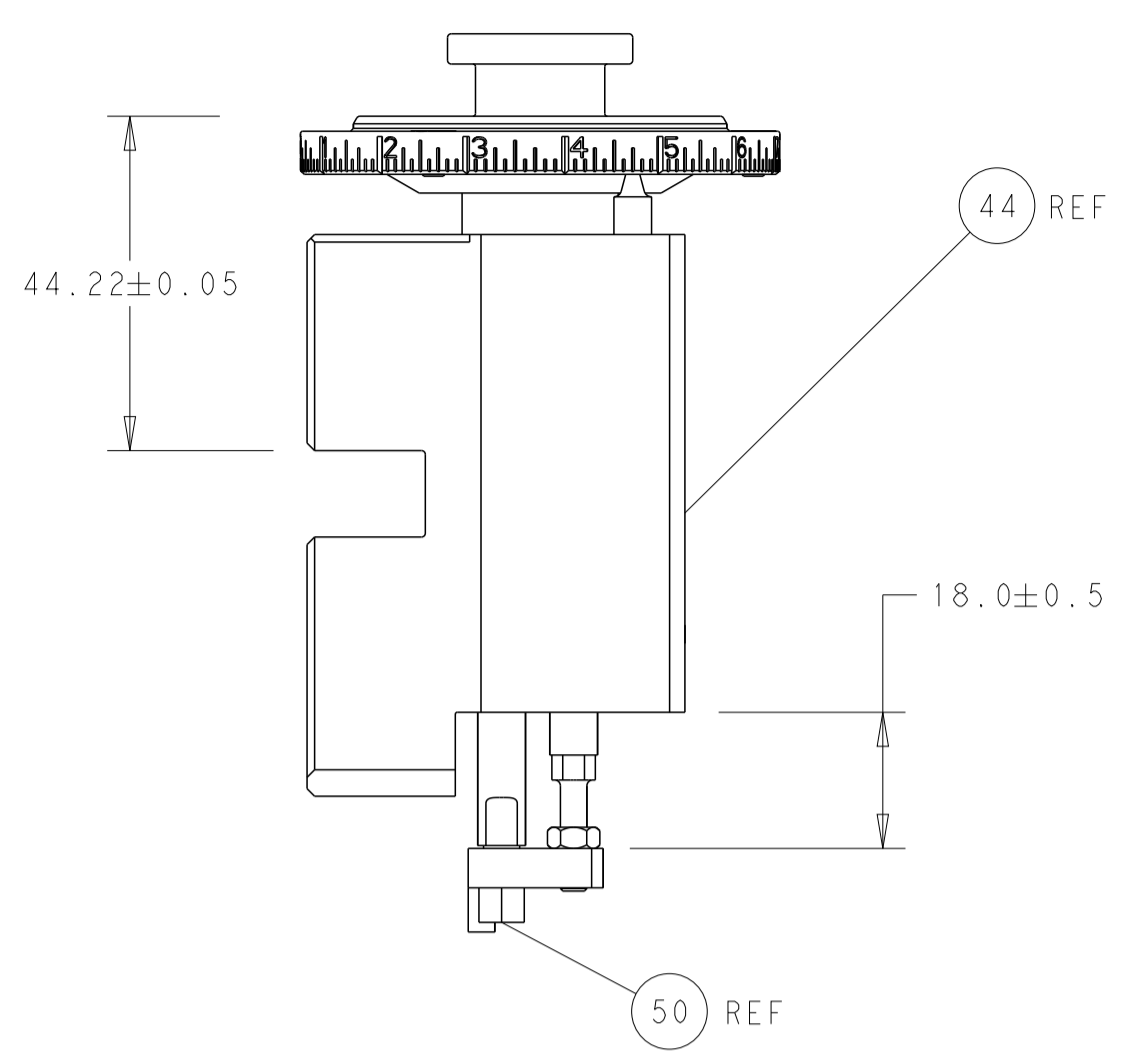
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		A		RELEASED	14JUN2012	CC	SX
		B		ECR-19-015226	28SEP2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-	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	1	455888-6	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	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	1901681-9	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	1752354-3	STANDOFF,HOLD-DOWN	50
-	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	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	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	2	2	1-1901259-0	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1-240641-0	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2-240645-4	SPACER, SHEAR PLATE	10
-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	2	1	1333295-2	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1-240651-9	BLADE, SLUG	7
-	1	1	6-240641-8	SPACER	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1-1803018-4	CRIMPER, INSULATION O	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	5-456405-0	CRIMPER, WIRE PREMIUM	1
-	77	-72	-2	PART NO	
				DESCRIPTION	ITEM NO

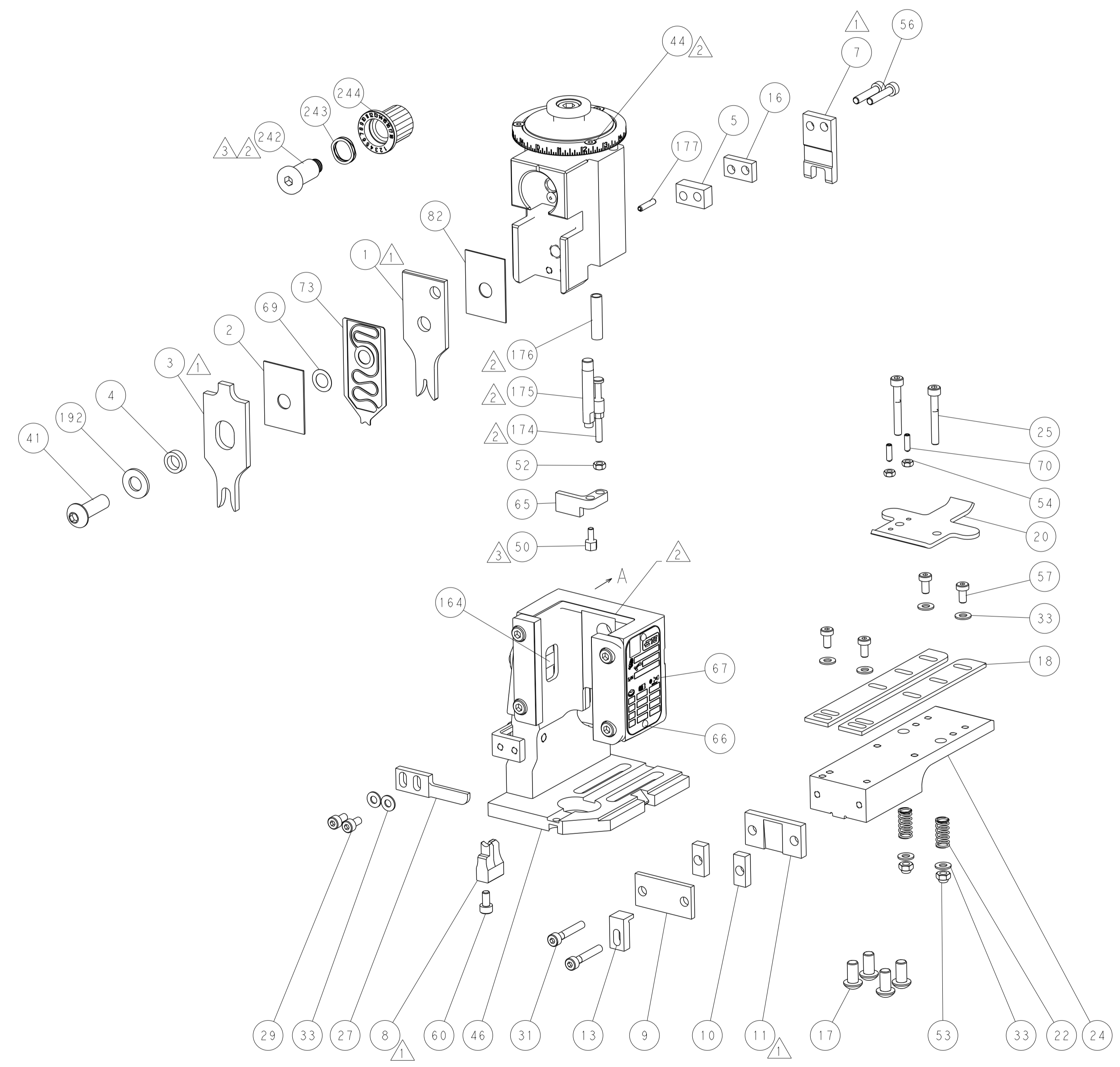
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
WIRE	2.03 mm [.080]	INSUL	5.84 mm [.230]	CRIMP	F
APPL INSTRUCTIONS		APPL INSTRUCTIONS		APPL INSTRUCTIONS	
408-35043		408-35043		408-35043	

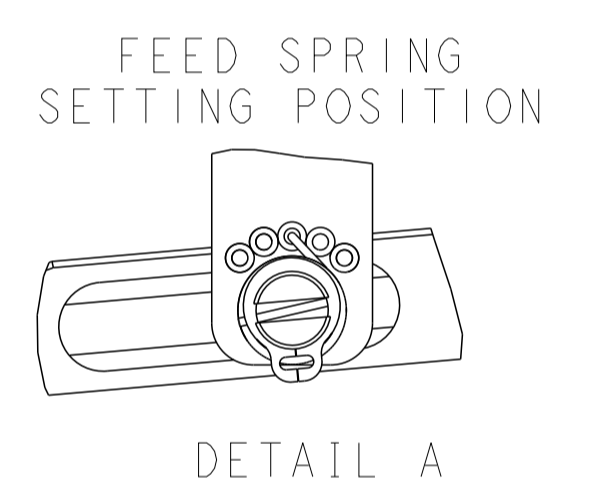
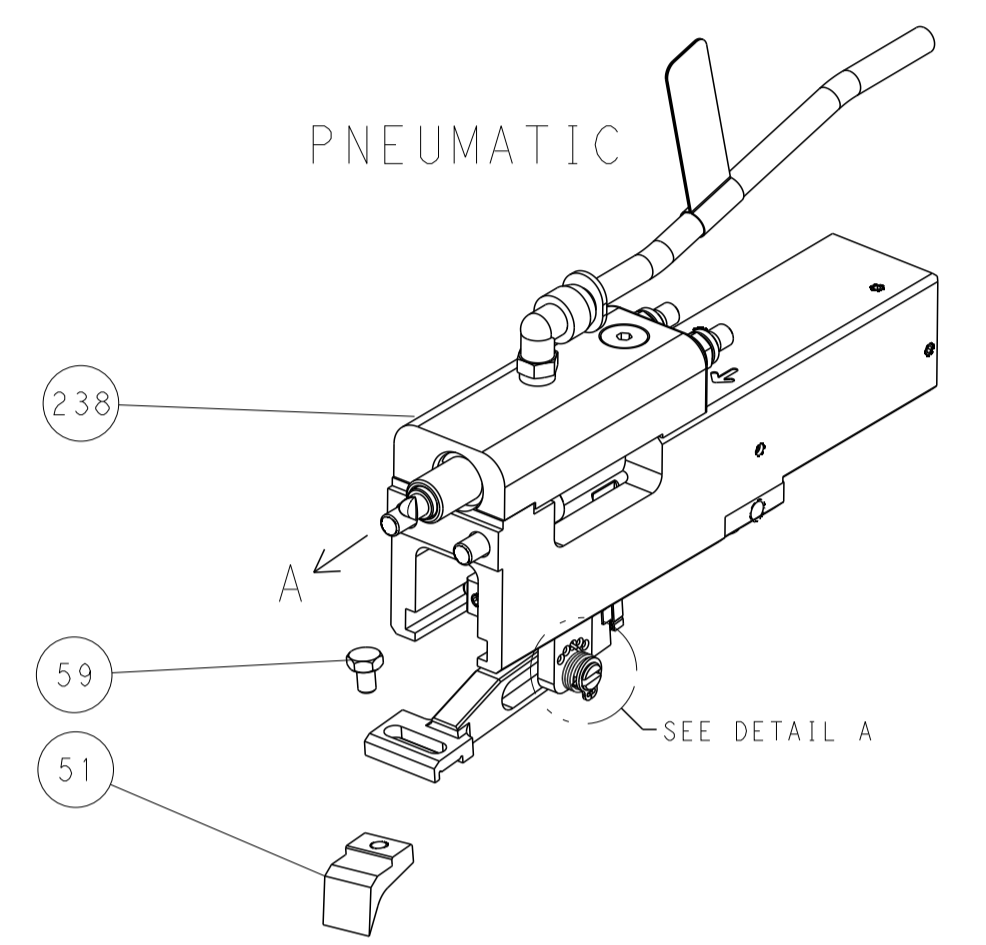
REV ISIONS		DATE	DNW	APVD
P	LYN	SEE SHEET 1	-	-



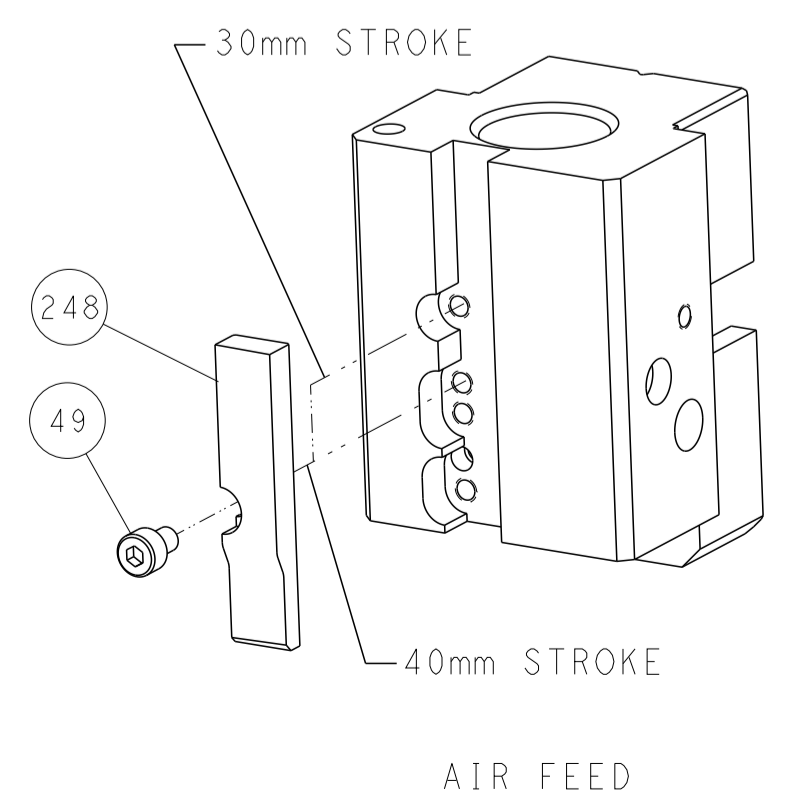
RAM AND HOLDDOWN SET-UP



FEED TYPE



CAM POSITION

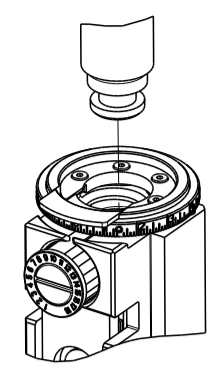


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 23FEB2012		TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±		CHK: S. XI 23FEB2012		
		2 PLC ±		APVD: J. CRUZ 23FEB2012		
MATERIAL:		3 PLC ±		NAME: Ocean End Feed Applicator		
		4 PLC ±		PRODUCT SPEC		
		ANGLES ±		APPLICATION SPEC		
		FINISH ±		SIZE: CAGE CODE DRAWING NO		RESTRICTED TO
				WEIGHT: A1 00779 C=2150163		SCALE: 1:1 SHEET 2 OF 4 REV B
				RESTRICTED CUSTOMER		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150163-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150163-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	5.84 mm [.230]	O

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 250 SERIES TAB ECONOSEAL 3 HC

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	1.50-2.40mm [.059-.094 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
344069-1			347707-1	1.6-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [.071+/-0.002]	7.0
1.00mm2	1.60+/-0.05 [.063+/-0.002]	9.6
0.75mm2	1.50+/-0.05 [.059+/-0.002]	10.5
0.50mm2	1.37+/-0.05 [.054+/-0.002]	11.9



- 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 50.
- 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.

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	DESCRIPTION	DATE	BY	APPD
-	1	2119082-9 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	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	455888-6 SPACER, CRIMPER	82		
-	1	2119791-5 DEPRESSOR, WIRE	73		
-	1	1803607-4 DOCUMENTATION PACKAGE	71		
-	2	2-18032-2 SCR, SET, FLT PNT, M3 X 10.0	70		
-	1	2119943-1 WASHER, SPACER	69		
-	1	2119740-1 TAG, IDENTIFICATION	67		
-	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1901681-9 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	1752354-3 STANDOFF,HOLD-DOWN	50		
-	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	1-2168083-2 SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-5 PLATE, STRIP GUIDE	24		
-	2	2-22281-3 SPRING, COMPRESSION	22		
-	1	1803292-1 DRAG	20		
-	2	1-1901259-0 GUIDE, LOWER STRIP	18		
-	1	1-240641-0 SPACER	16		
-	1	1752360-1 SPACER,HOLD-DOWN	13		
-	1	240644-1 PLATE, REAR SHEAR	11		
-	2	2-240645-4 SPACER, SHEAR PLATE	10		
-	1	240642-1 PLATE, FRONT SHEAR	9		
1	1	1333295-2 ANVIL, COMBINATION, SPECIAL	8		
-	1	1-240651-9 BLADE, SLUG	7		
-	1	6-240641-8 SPACER	5		
-	1	4-238011-5 BLOCK, CRIMPER SPACER	4		
1	1	1-1803018-4 CRIMPER, INSULATION O	3		
-	1	455888-7 SPACER, CRIMPER	2		
1	1	5-456405-0 CRIMPER, WIRE PREMIUM	1		

ITEM NO	PART NO	DESCRIPTION
-77-22		

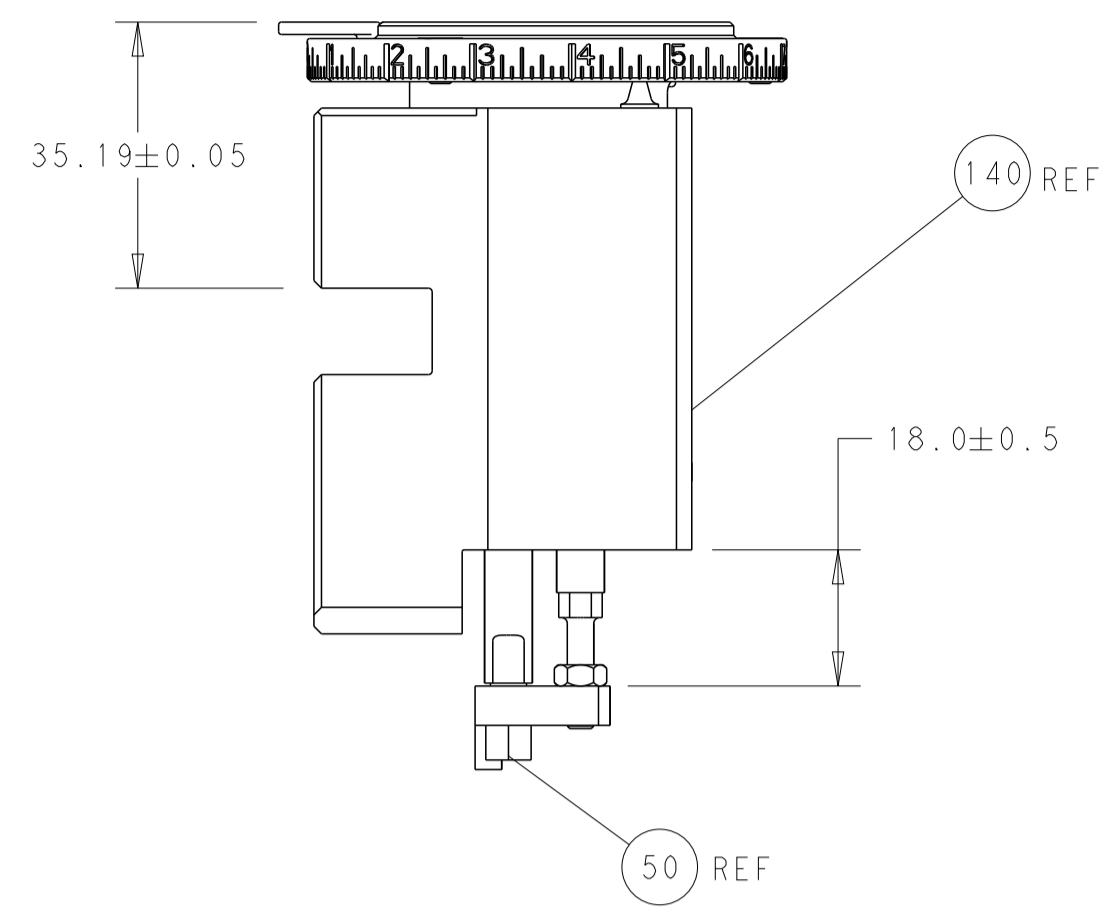
DATE	23FEB2012	BY	C. CHEN
CHK	23FEB2012	BY	S. XI
APVD	23FEB2012	BY	J. CRUZ

TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed
 Applicator

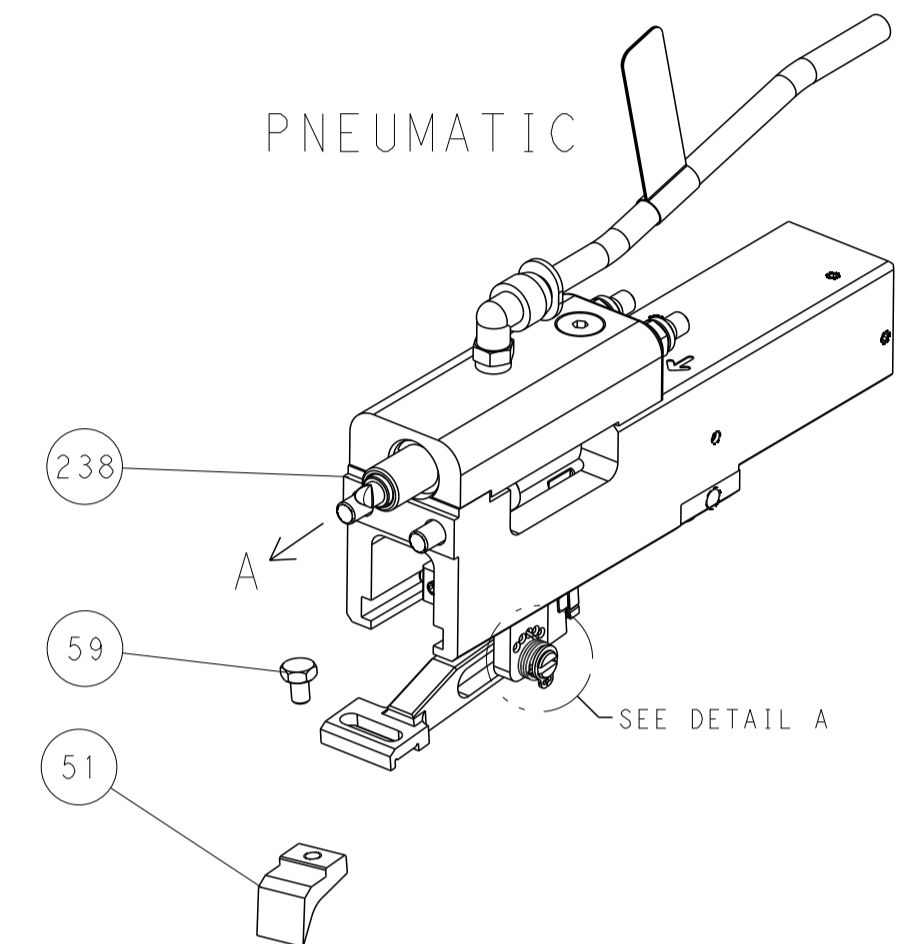
SCALE: 1:1 SHEET 3 OF 4 REV B

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

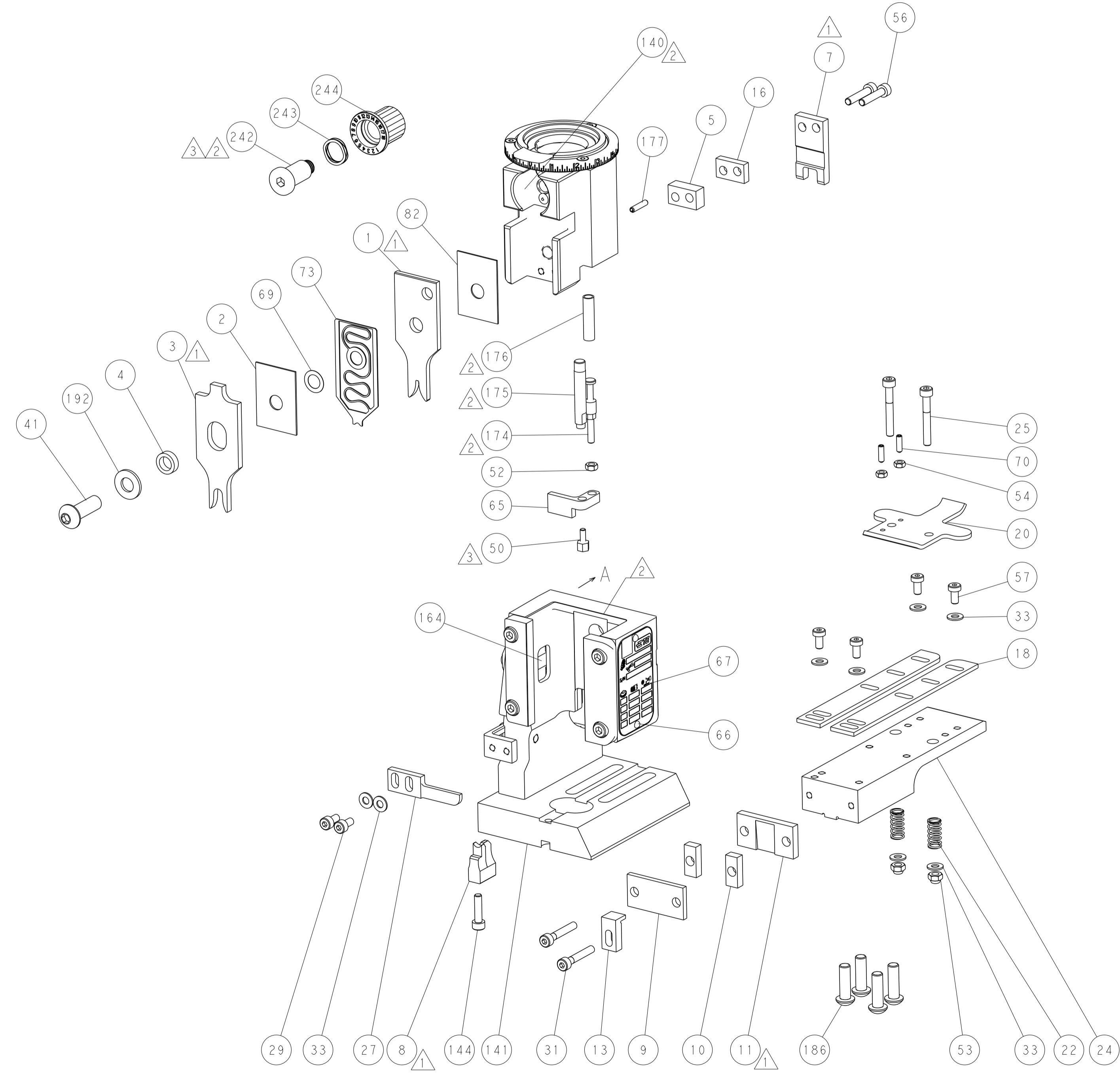
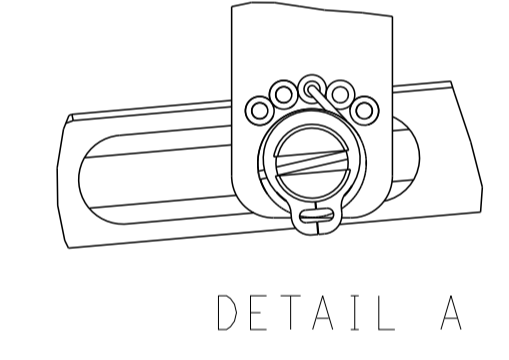


RAM AND HOLDDOWN SET-UP

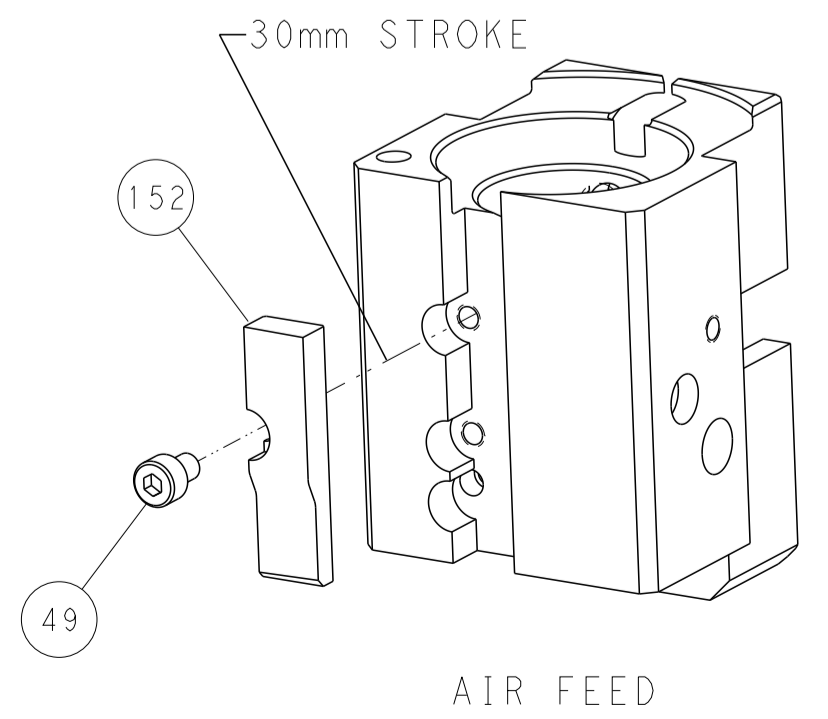
FEED TYPE



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN C.CHEN 23FEB2012 CHK S.XI 23FEB2012 APVD J.CRUZ 23FEB2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C=2150163
MATERIAL:		WEIGHT:	RESTRICTED CUSTOMER SCALE 1:1 SHEET 4 OF 4 REV B