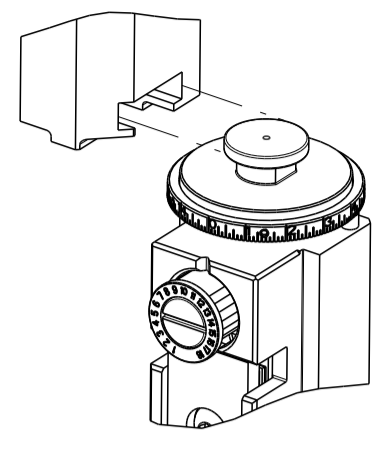


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150199-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150199-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150199-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150199-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150199-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.39-5.16 mm [.173-.203 IN]	Ø2.29-3.94 mm [.090-.155 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2074		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63854-1	63854-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85 +/- 0.05 [.073 +/- .002]	3.4
16 AWG	1.63 +/- 0.05 [.064 +/- .002]	5.6
18 AWG	1.47 +/- 0.05 [.058 +/- .002]	7.5

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 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 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.

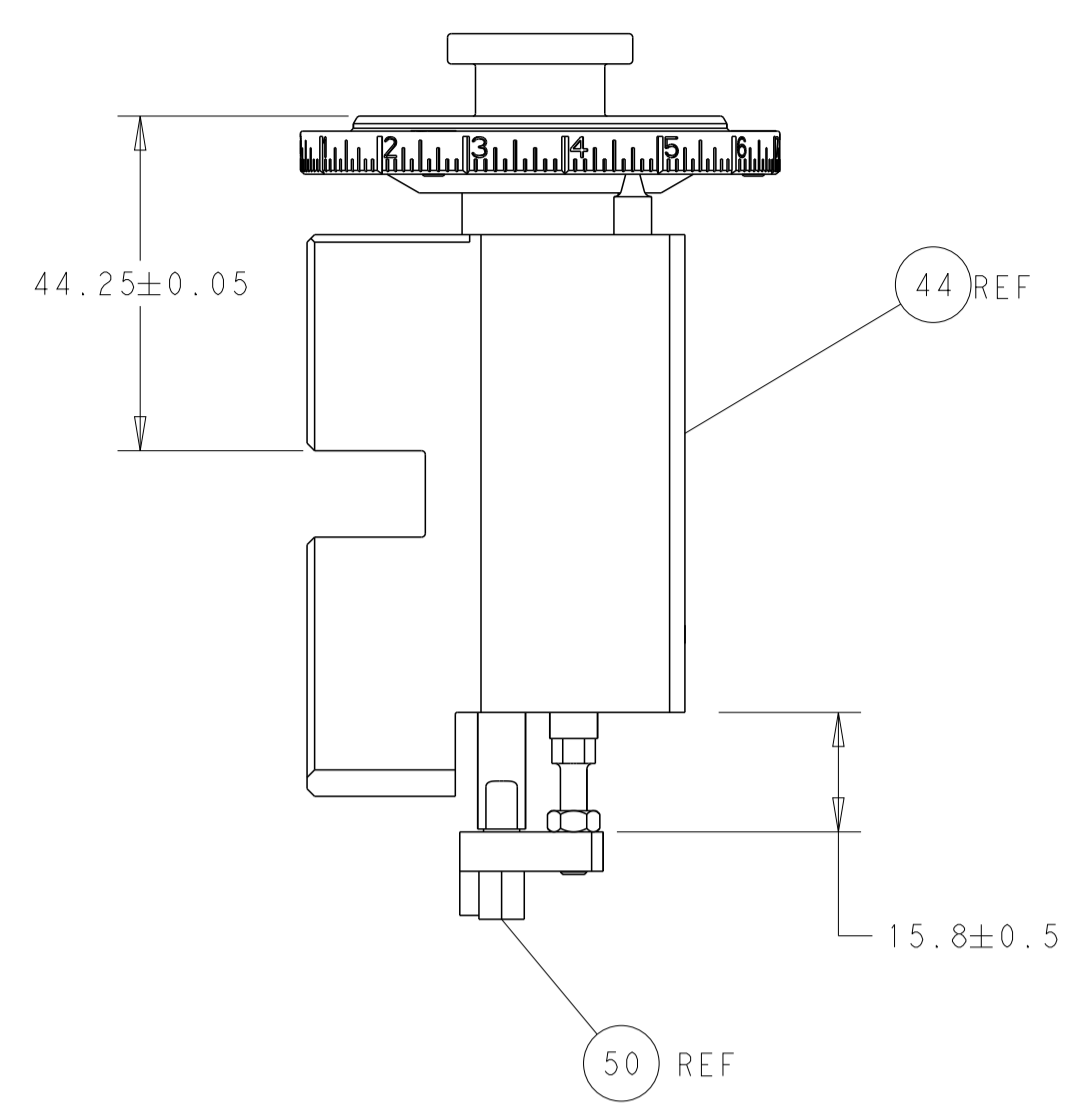
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		D		ECR-18-014691	17SEP2018	FZ	KZ
		E		ECR-20-004256	20MAR2020	TB	RK
		F		ECR-21-007025	26JUL2021	JWC	TE
		G		ECR-22-142428	14JUN2022	TB	TE

-	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	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239					
-	1	-	1	-	2844940-3	AIR FEED MODULE	238					
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192					
-	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					
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84					
-	1	1	1	1	455888-6	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	1901681-1	HOLDDOWN, TERMINAL	65					
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64					
-	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	-	-	2063961-1	FEED FINGER	58					
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57					
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	1	1	1-1752354-0	STANDOFF,HOLD-DOWN	50					
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49					
-	-	1	-	-	2119652-1	FEED CAM, PRE FEED	48					
-	-	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					
-	7	7	7	7	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	240639-1	STRIPPER (MACHINING)	27					
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25					
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24					
-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23					
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22					
-	1	1	1	1	1803292-4	DRAG	20					
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18					
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17					
-	1	1	1	1	240641-6	SPACER	16					
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13					
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11					
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9					
-	1	2	2	1	1-1803000-2	ANVIL, COMBINATION, END FEED	8					
-	1	1	1	1	2217206-7	BLADE, SLUG	7					
-	1	1	1	1	4-240641-1	SPACER	5					
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4					
-	1	2	2	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3					
-	1	1	1	1	455888-8	SPACER, CRIMPER	2					
-	1	2	2	1	2-456408-8	CRIMPER, WIRE PREMIUM	1					
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

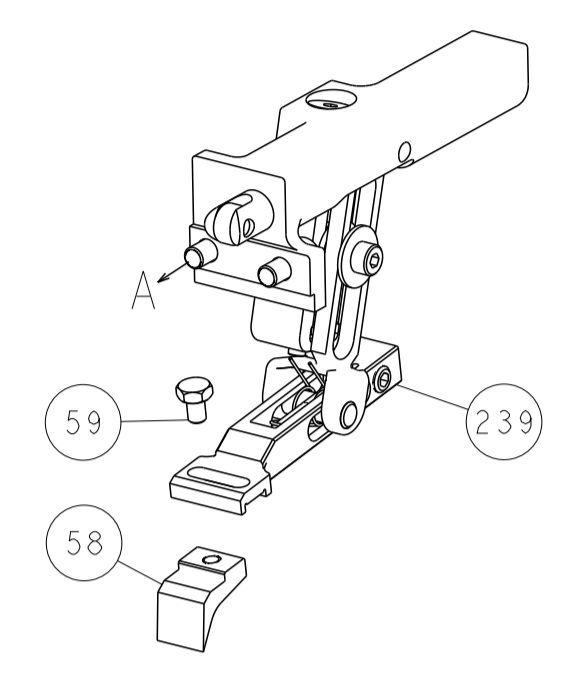
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG 07MAR2012		CHK S. XI 07MAR2012		APVD S. XI 07MAR2012		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
mm		0 PLC ±		S. XI		S. XI		S. XI		Ocean End Feed Applicator		A1		00779		C=2150199		-	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		1 OF 4		REV		G					

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

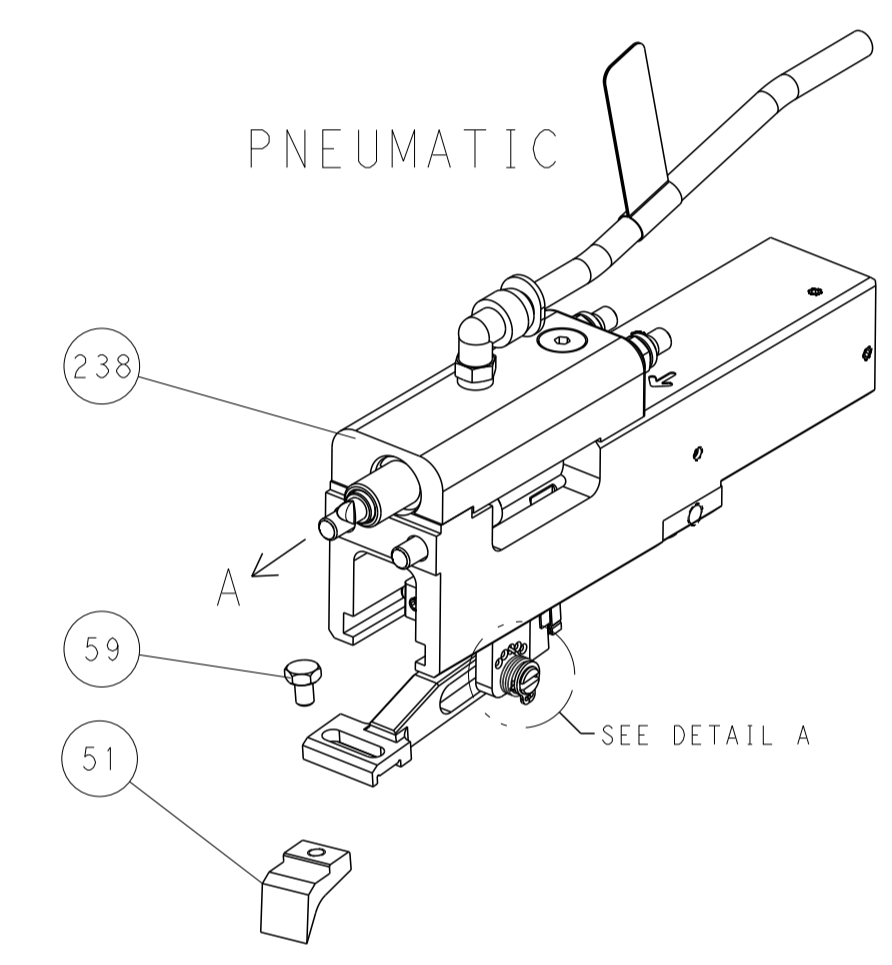


RAM AND HOLDDOWN SET-UP

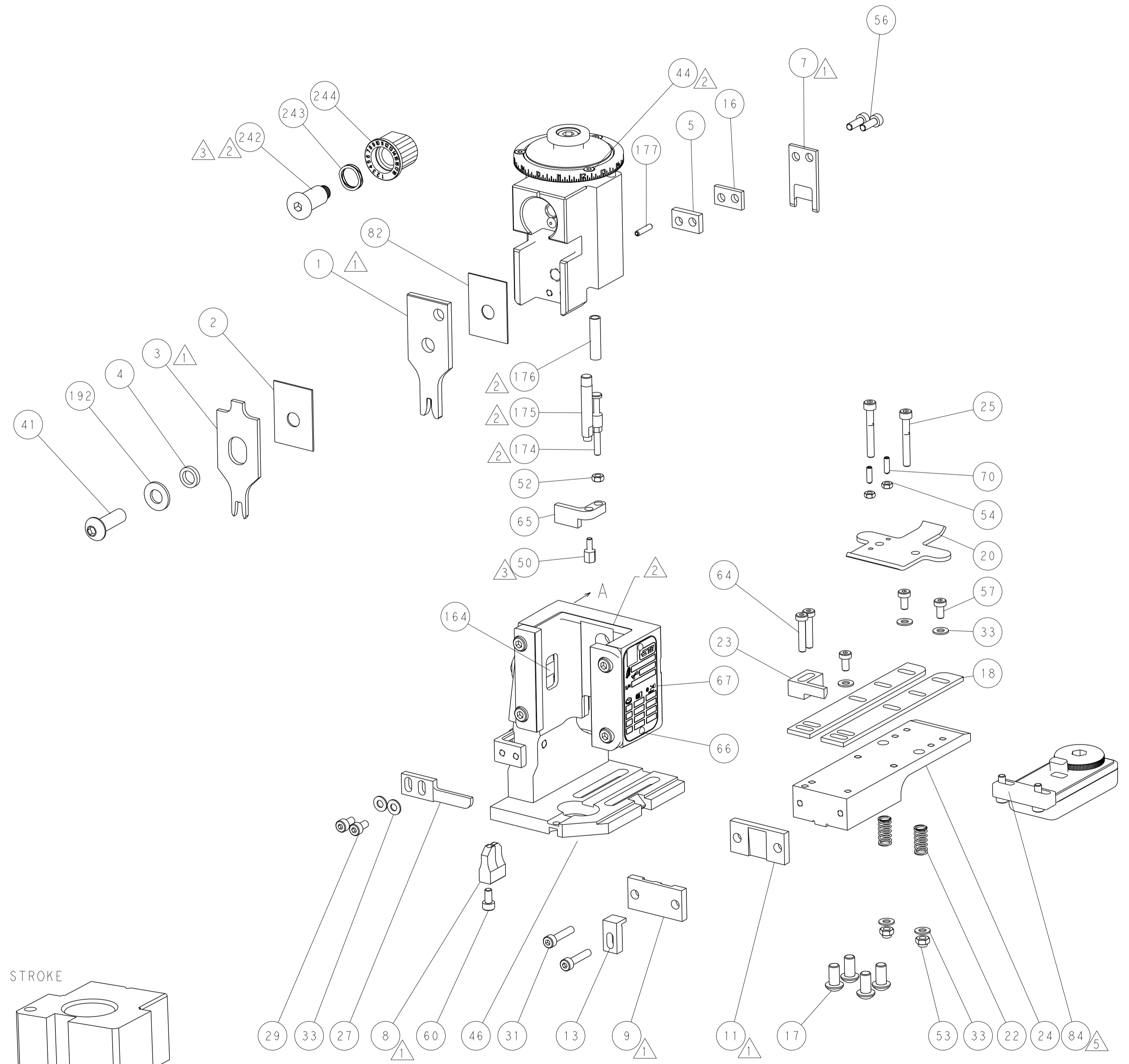
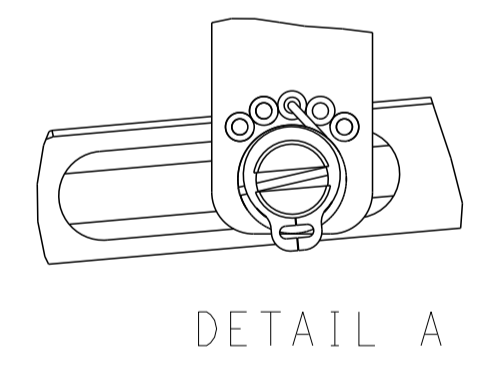
FEED TYPE
MECHANICAL



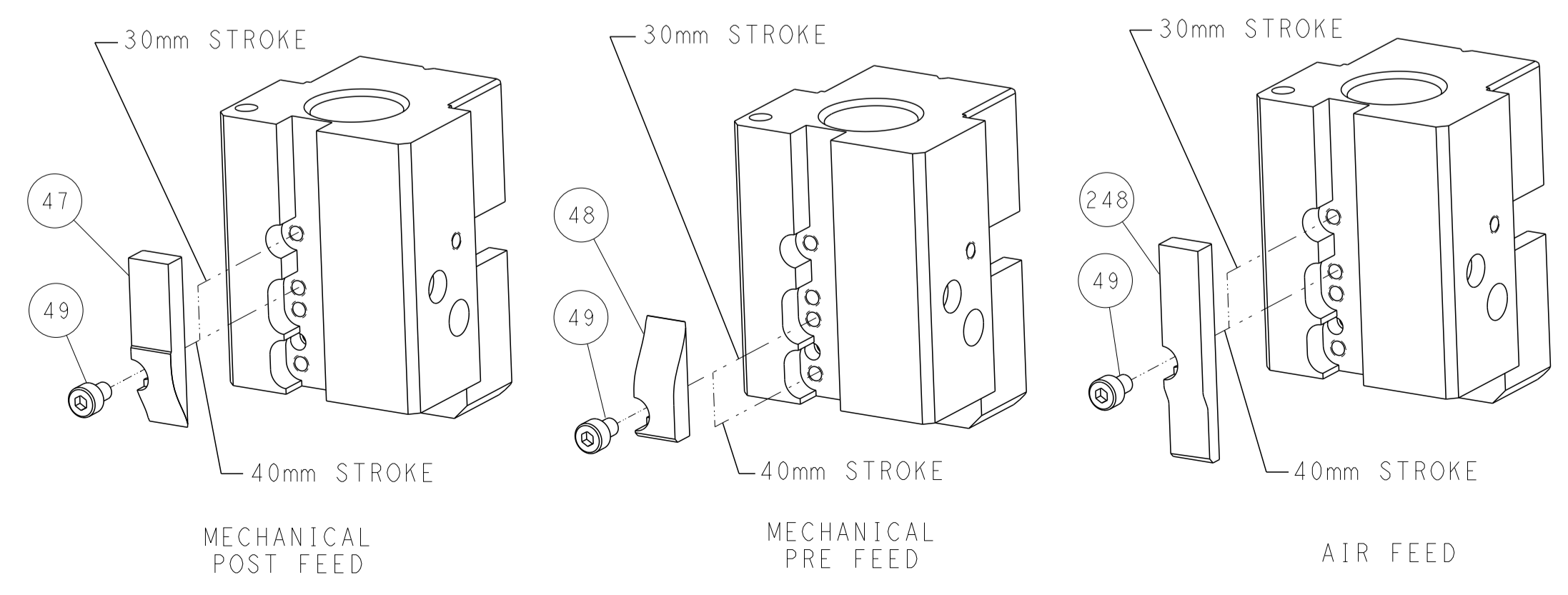
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

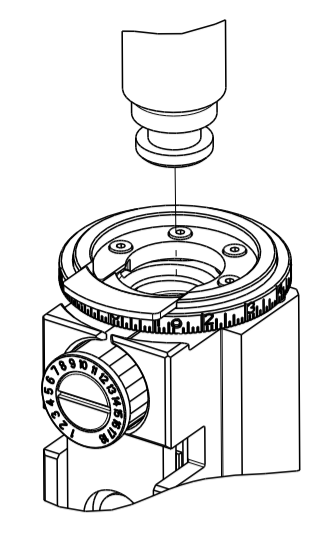


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 07MAR2012 CHK S. XI 07MAR2012 APVD S. XI 07MAR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150199 SCALE 1:1 SHEET 2 OF 4 REV G	
-----------------------	--	---	--	---	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150199-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150199-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150199-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.57 mm (.180)	F

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.39-5.16 mm (.173-.203 IN)	∅2.29-3.94 mm (.090-.155 IN)

TERMINAL APPLICATION SPECIFICATION 114-2074

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63854-1	63854-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [.073+/-0.002]	3.4
16 AWG	1.63+/-0.05 [.064+/-0.002]	5.6
18 AWG	1.47+/-0.05 [.058+/-0.002]	7.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 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 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.

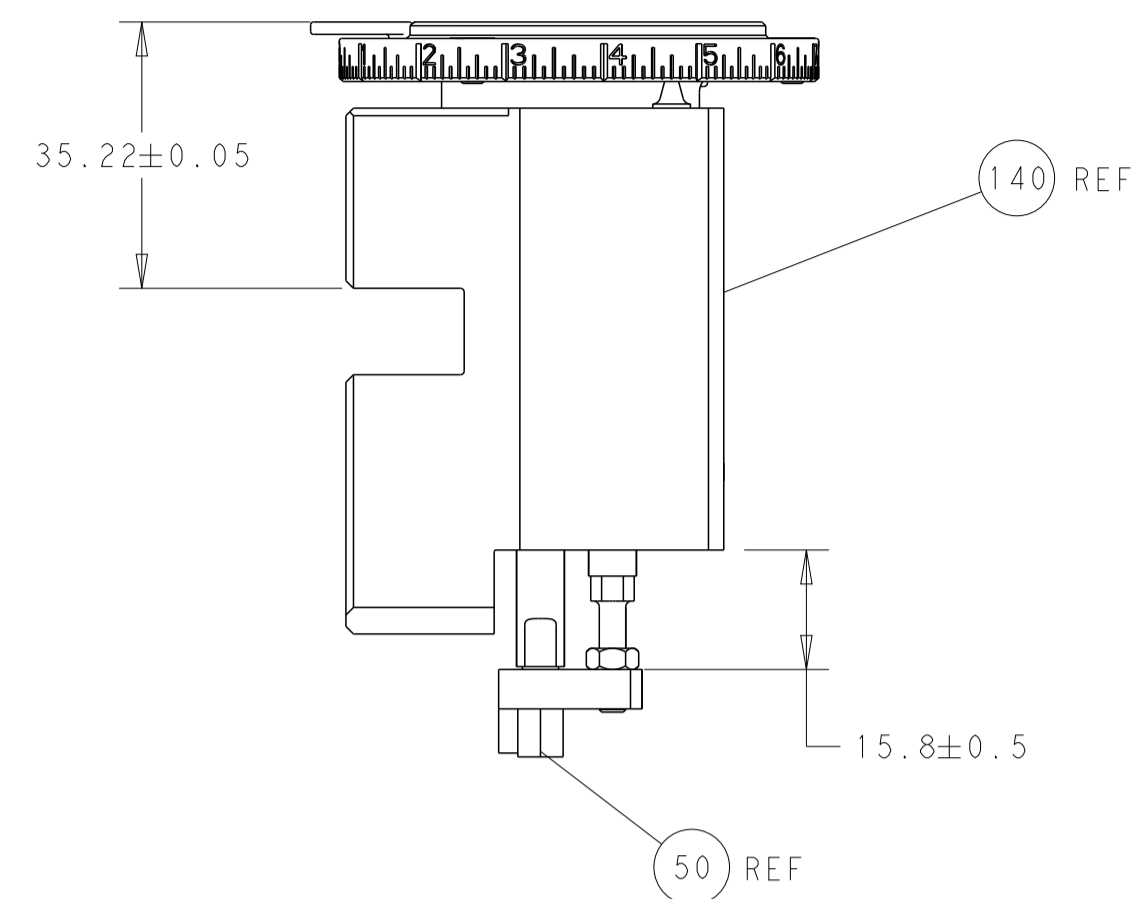
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	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	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	-	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	455888-6	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	
3	-	1	1-1752354-0	STANDOFF,HOLD-DOWN	50	
-	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	
-	7	7	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	1	1	240641-6	SPACER	16	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	240644-1	PLATE, REAR SHEAR	11	
1	-	1	690482-5	PLATE, FRONT SHEAR	9	
1	1	1	1-1803000-2	ANVIL, COMBINATION, END FEED	8	
1	-	1	2217206-7	BLADE, SLUG	7	
-	1	1	4-240641-1	SPACER	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-8	SPACER, CRIMPER	2	
1	1	1	2-456408-8	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

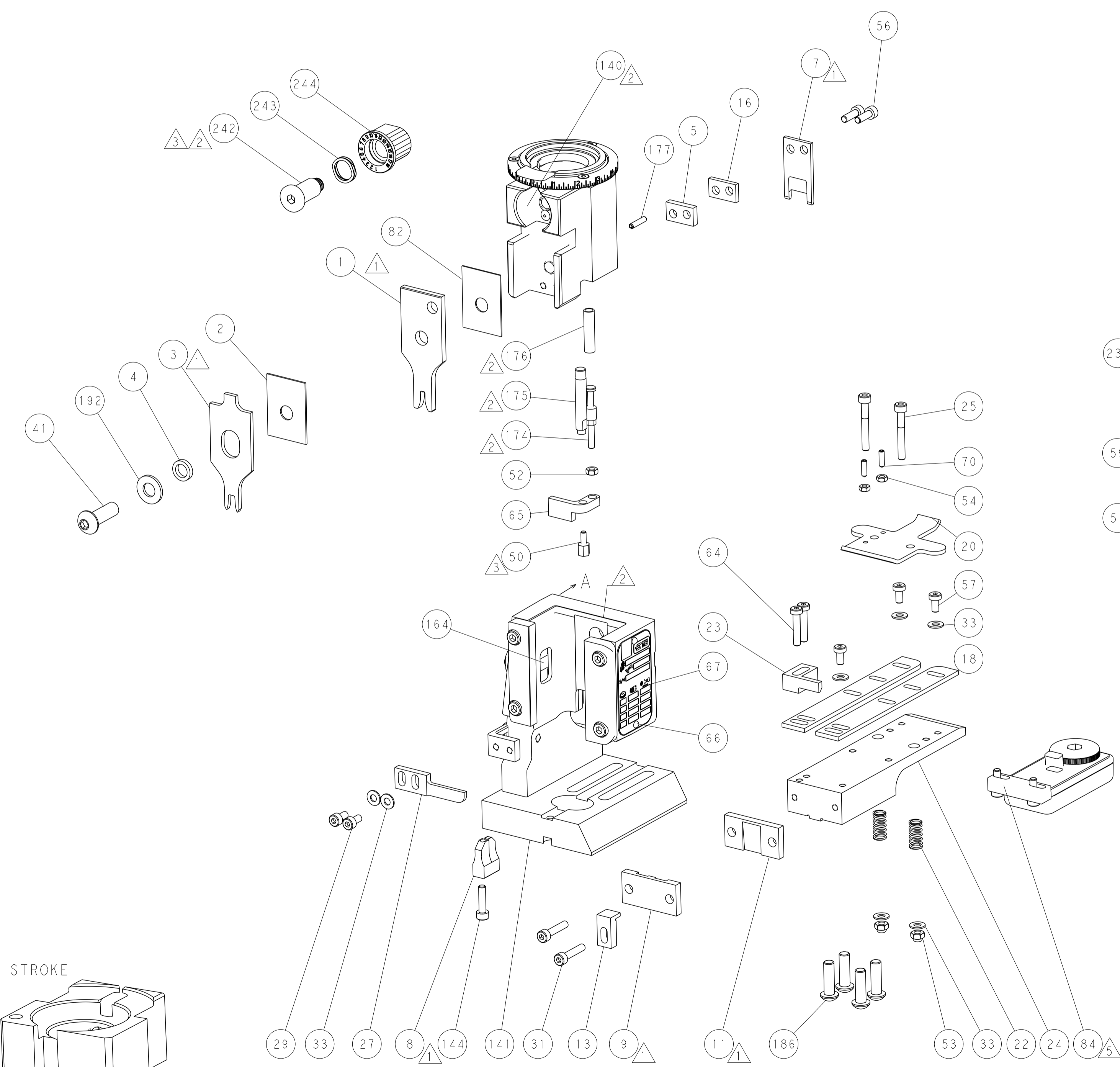
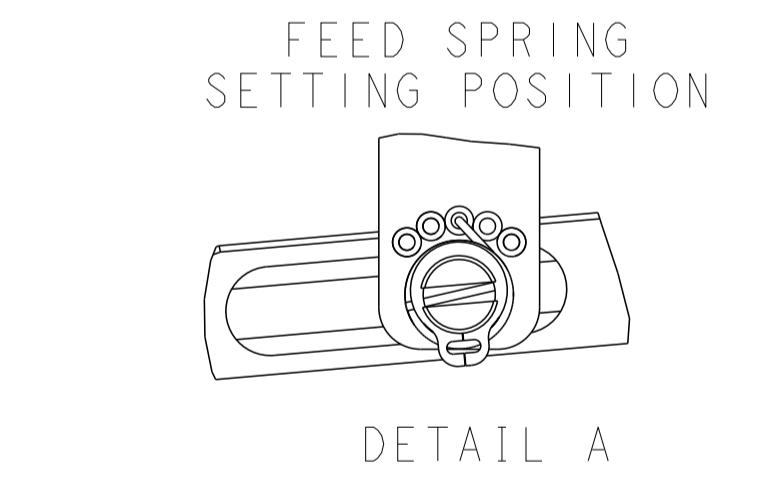
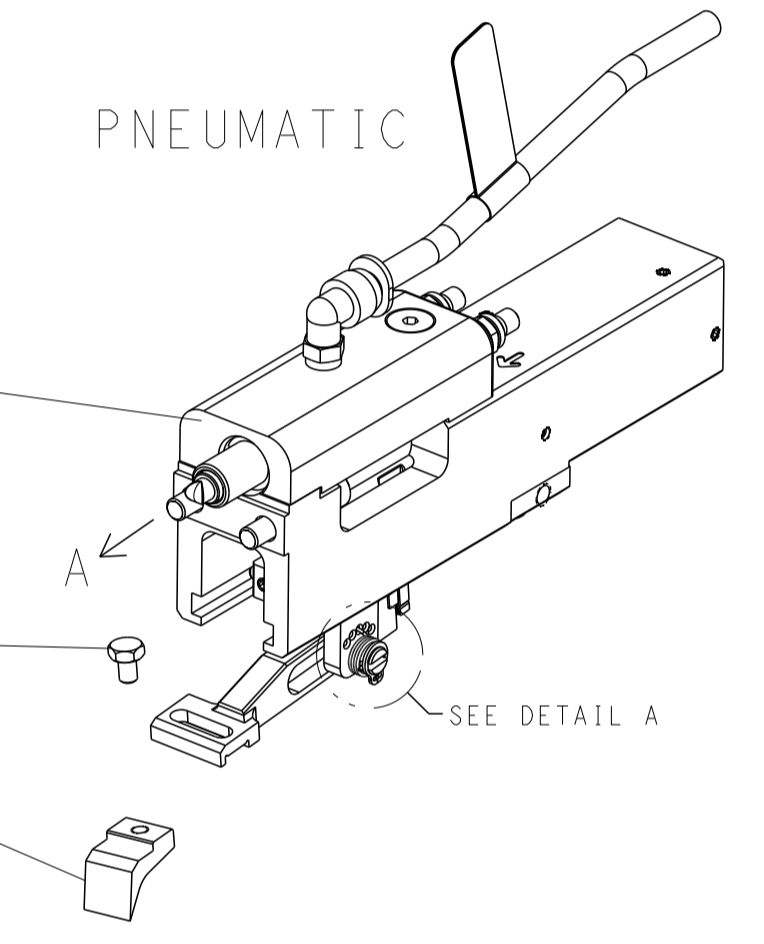
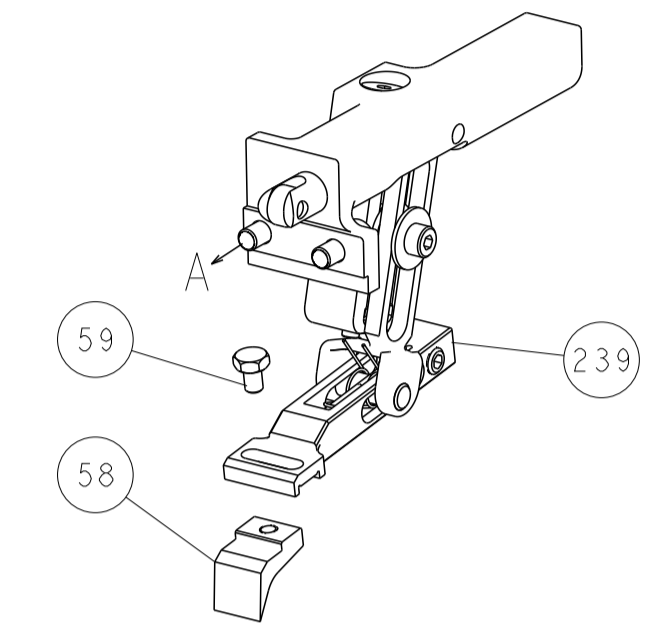
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	07MAR2012	OWN
	3 PLC ±	4 PLC ±	ANGLES ±	07MAR2012	CHK
	FINISH				S.XI
MATERIAL		WEIGHT		APVD	S.XI
				07MAR2012	S.XI
					NAME
					PRODUCT SPEC
					APPLICATION SPEC
					SIZE
					CAGE CODE
					DRAWING NO
					RESTRICTED TO
					SCALE
					SHEET
					OF
					REV
					G

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

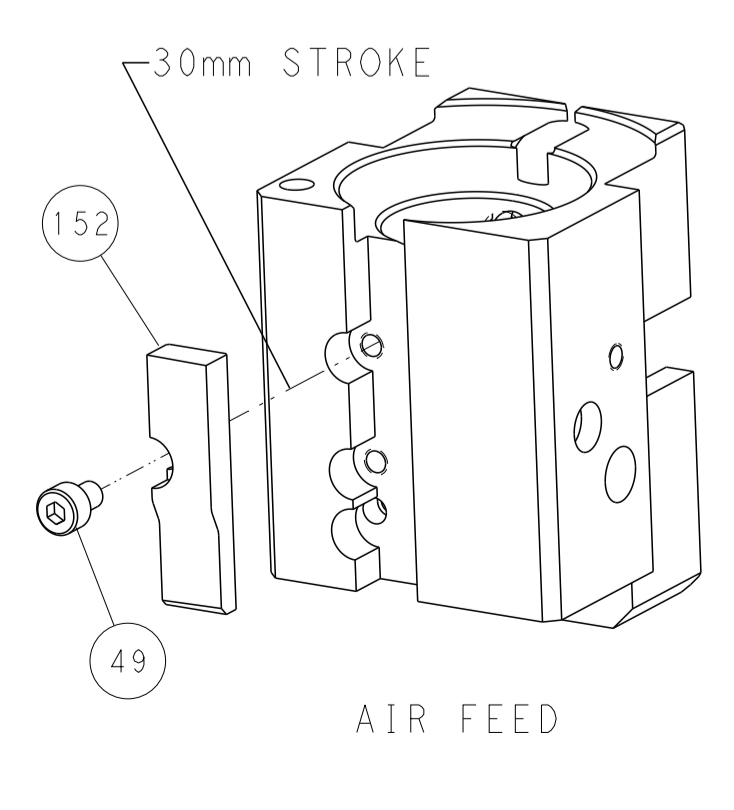
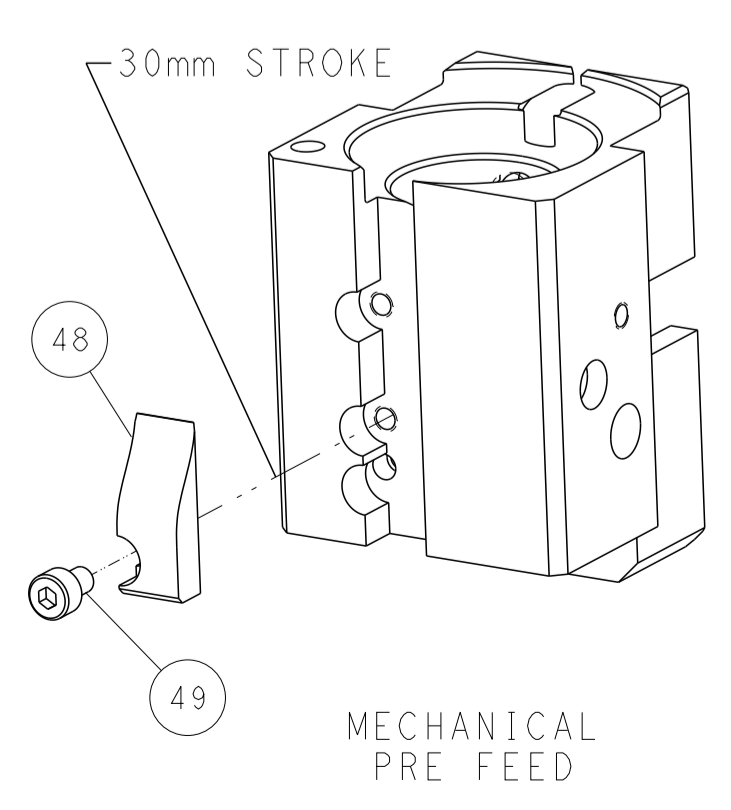
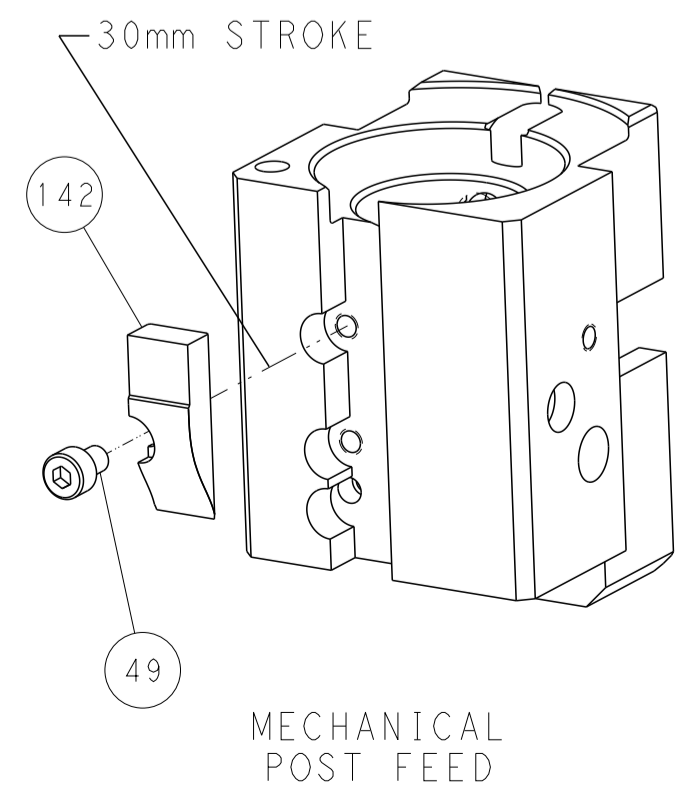


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS



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 07MAR2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK S.XI 07MAR2012	NAME	SIZE	CAGE CODE
				APVD S.XI 07MAR2012	Product Spec	A1	00779
MATERIAL				PRODUCT SPEC	APPLICATION SPEC	SCALE	1:1
				WEIGHT	Customer Accessible Production Drawing	SHEET	4 of 4
						REV	G