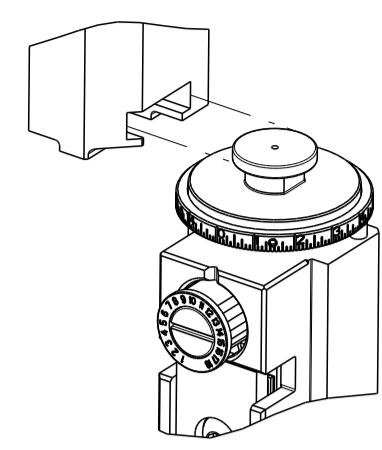


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150004-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150004-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150004-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150004-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150004-7	A	CRIMP TOOLING KIT	-

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 FASTON .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]		∅3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
737440-1	735220-1	444335-1	336236-1
737440-2	735220-2	444335-2	336236-3
737440-3	735220-3	444335-3	336236-5
	1-735220-2	444335-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.08 +/- 0.05 [.082 +/- .002]	6.2
2.00mm2	1.93 +/- 0.05 [.076 +/- .002]	7.8
1.50mm2	1.78 +/- 0.05 [.070 +/- .002]	9.4
1.00mm2	1.62 +/- 0.05 [.064 +/- .002]	11.2

- 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. 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.

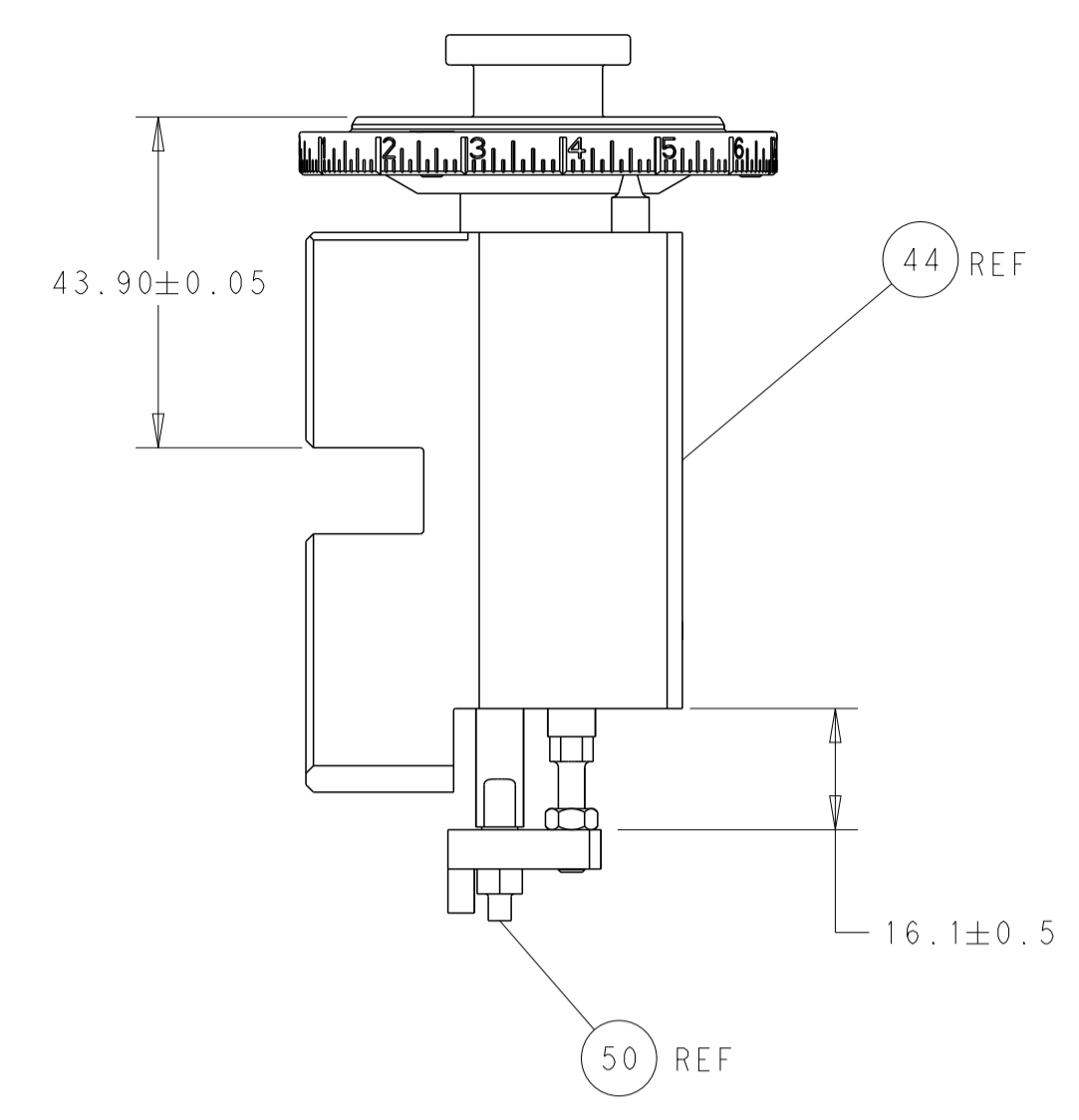
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66			RELEASE	18OCT2012	L.Z	S.X
		B		ECR-19-003831	11MAR2019	FZ	YY
		C		ECR-22-130192	21FEB2022	JWC	RK

-	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	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	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	
-	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	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	1	1	1	1-1976055-2	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-1	DRAG	20	
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	4-690495-4	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	7-1633384-2	ANVIL, COMBINATION	8
-	1	1	1	1	5-690474-2	BLADE, SLUG	7	
-	1	1	1	1	2-240641-0	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	2-456408-1	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

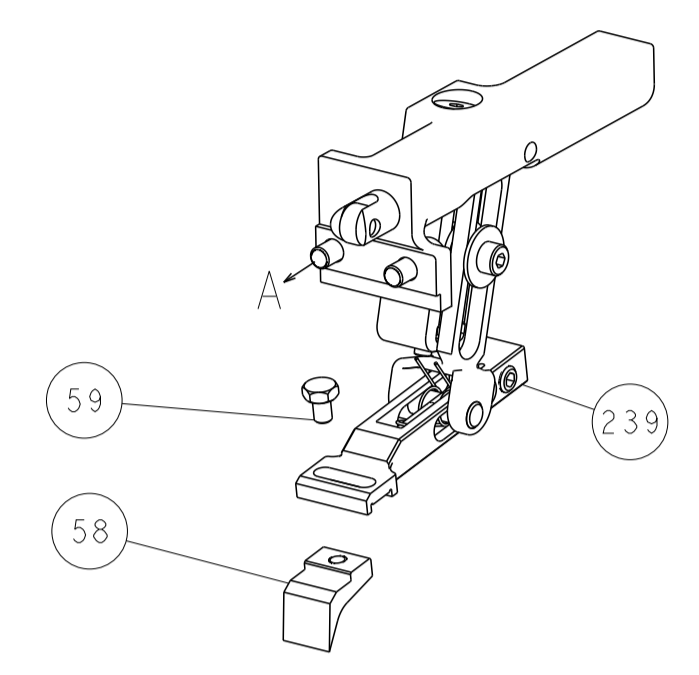
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 05MAR2012		CHK L. ZHANG 05MAR2012		NAME Ocean End Feed Applicator	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	APVD S. XI 05MAR2012	SIZE A1	CAGE CODE 00779	DRAWING NO C=2150004	RESTRICTED TO	Customer Accessible Production Drawing
MATERIAL	FINISH	WEIGHT	SCALE	1:1	SHEET	1	OF	4	REV C

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

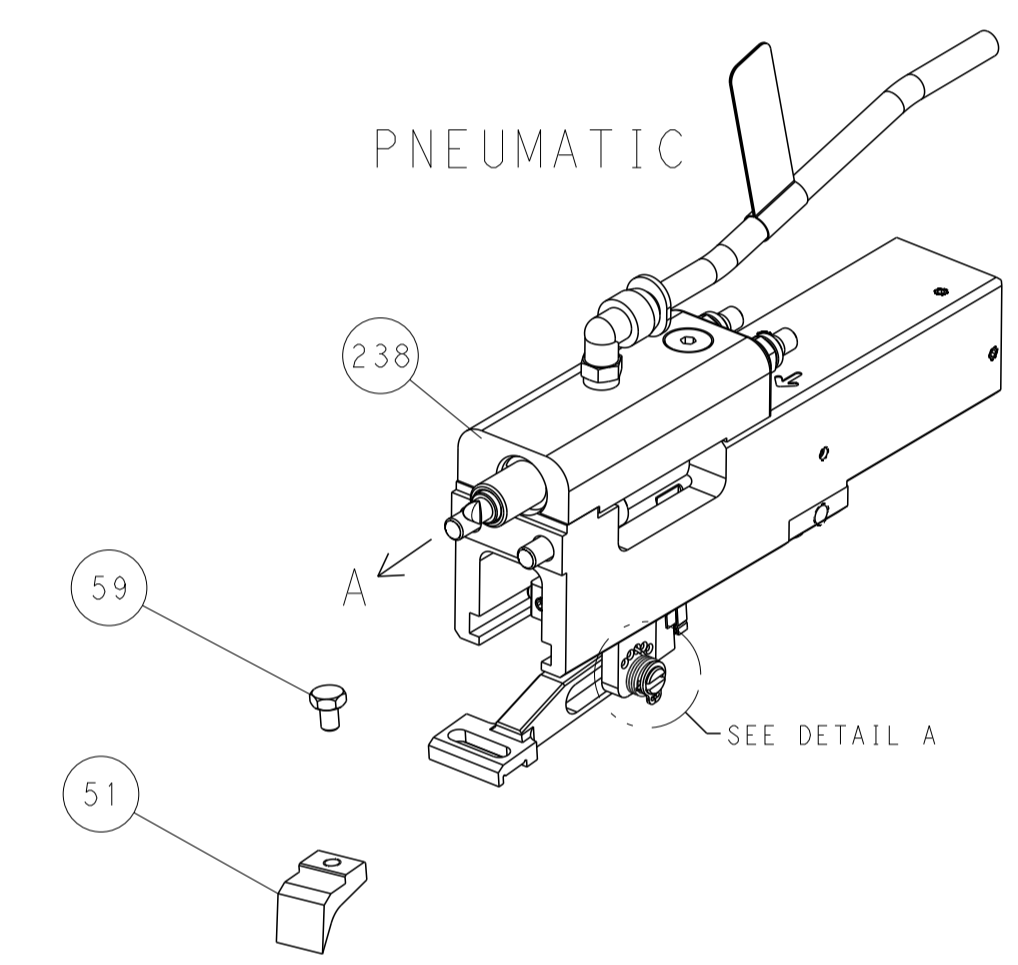


RAM AND HOLDDOWN SET-UP

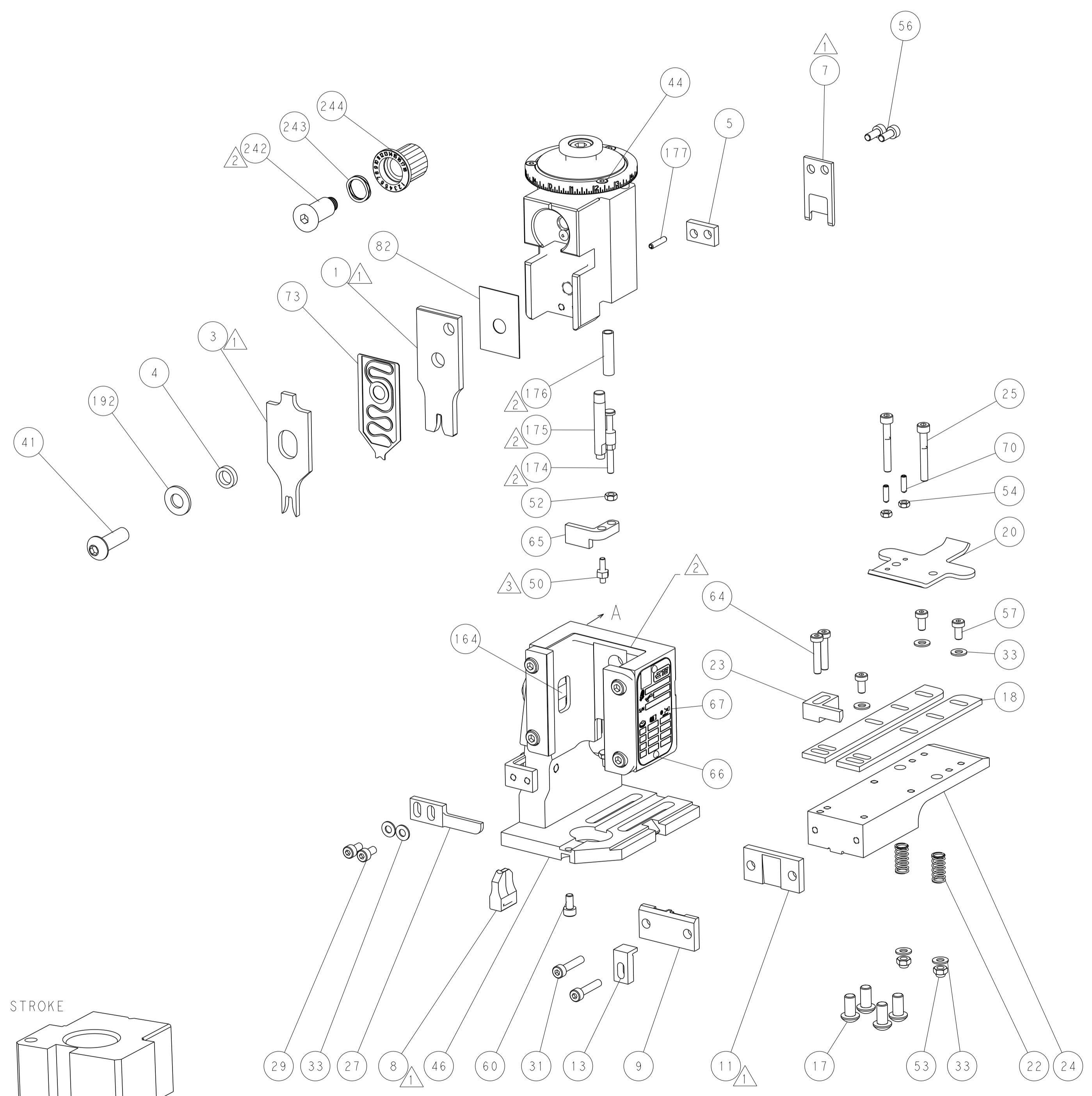
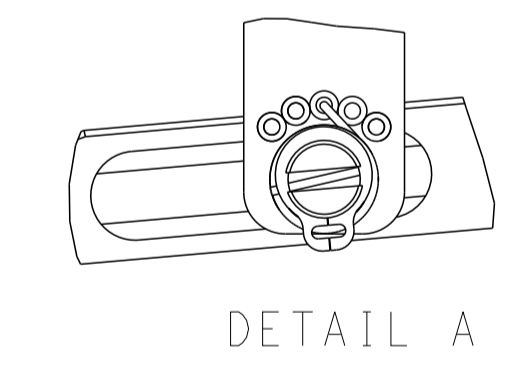
FEED TYPE
MECHANICAL



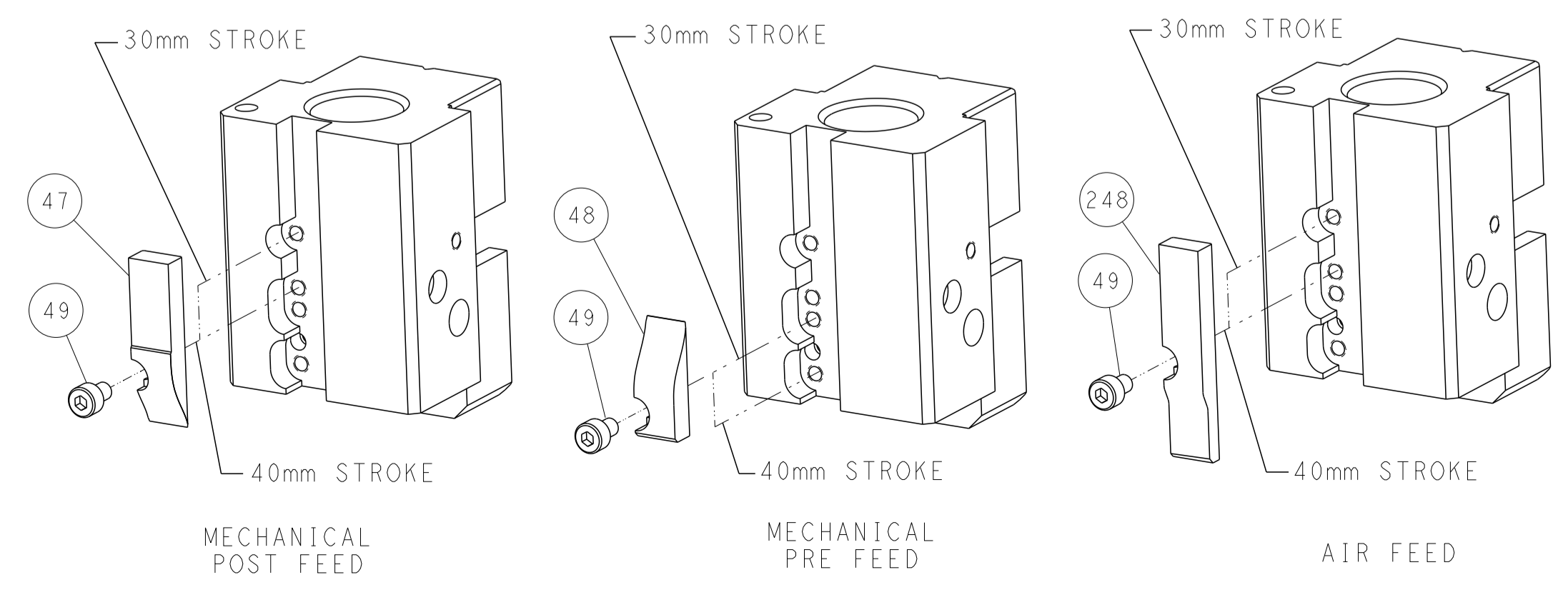
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

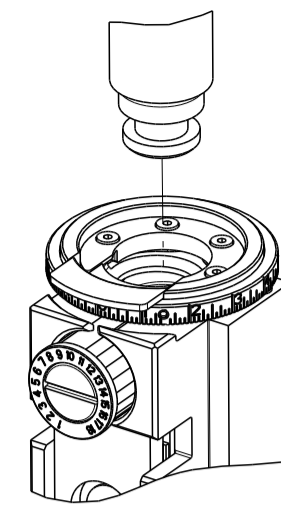


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN L. ZHANG 05MAR2012 CHK L. ZHANG 05MAR2012 APVD S. XI 05MAR2012	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 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. 2150004 SHEET 2 OF 4 REV C
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150004-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150004-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150004-7	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 FASTON .250 SERIES			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
737440-1	735220-1	444335-1	336236-1
737440-2	735220-2	444335-2	336236-3
737440-3	735220-3	444335-3	336236-5
	1-735220-2	444335-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.08+/-0.05 [.082+/-0.002]	6.2
2.00mm2	1.93+/-0.05 [.076+/-0.002]	7.8
1.50mm2	1.78+/-0.05 [.070+/-0.002]	9.4
1.00mm2	1.62+/-0.05 [.064+/-0.002]	11.2

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

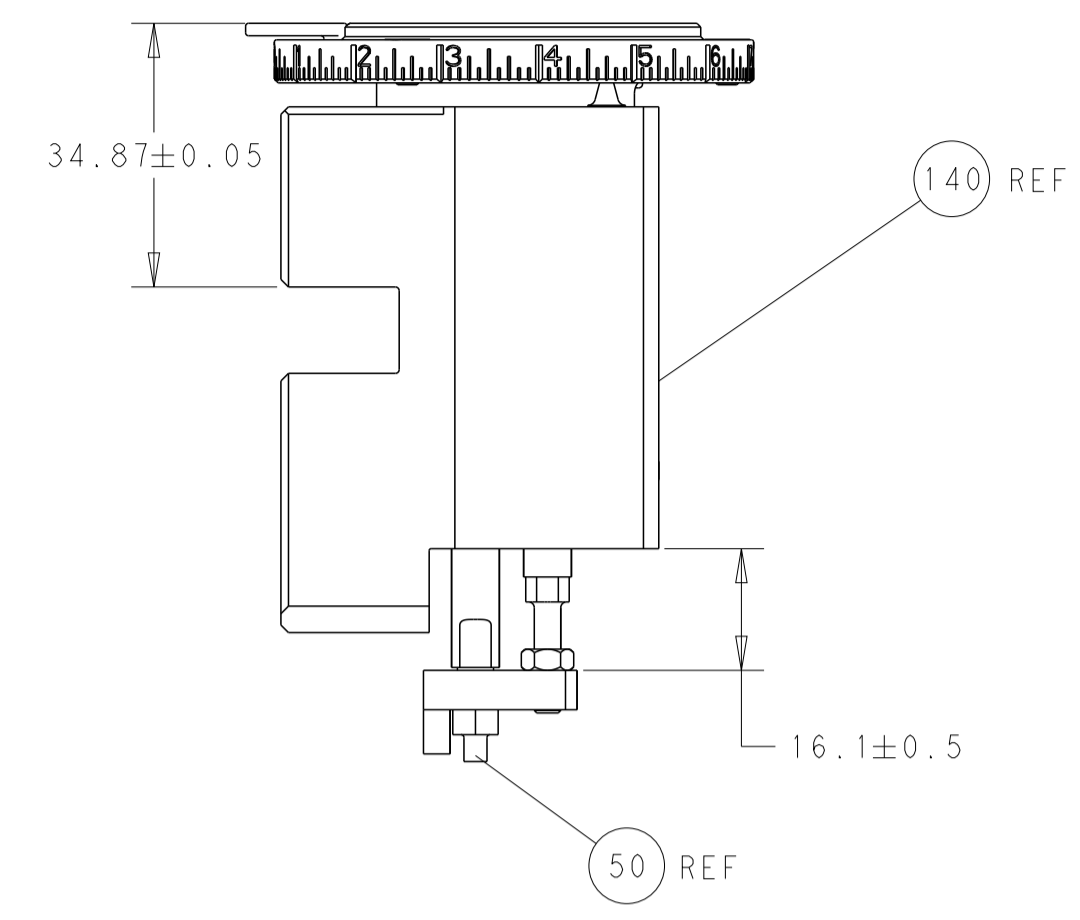
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

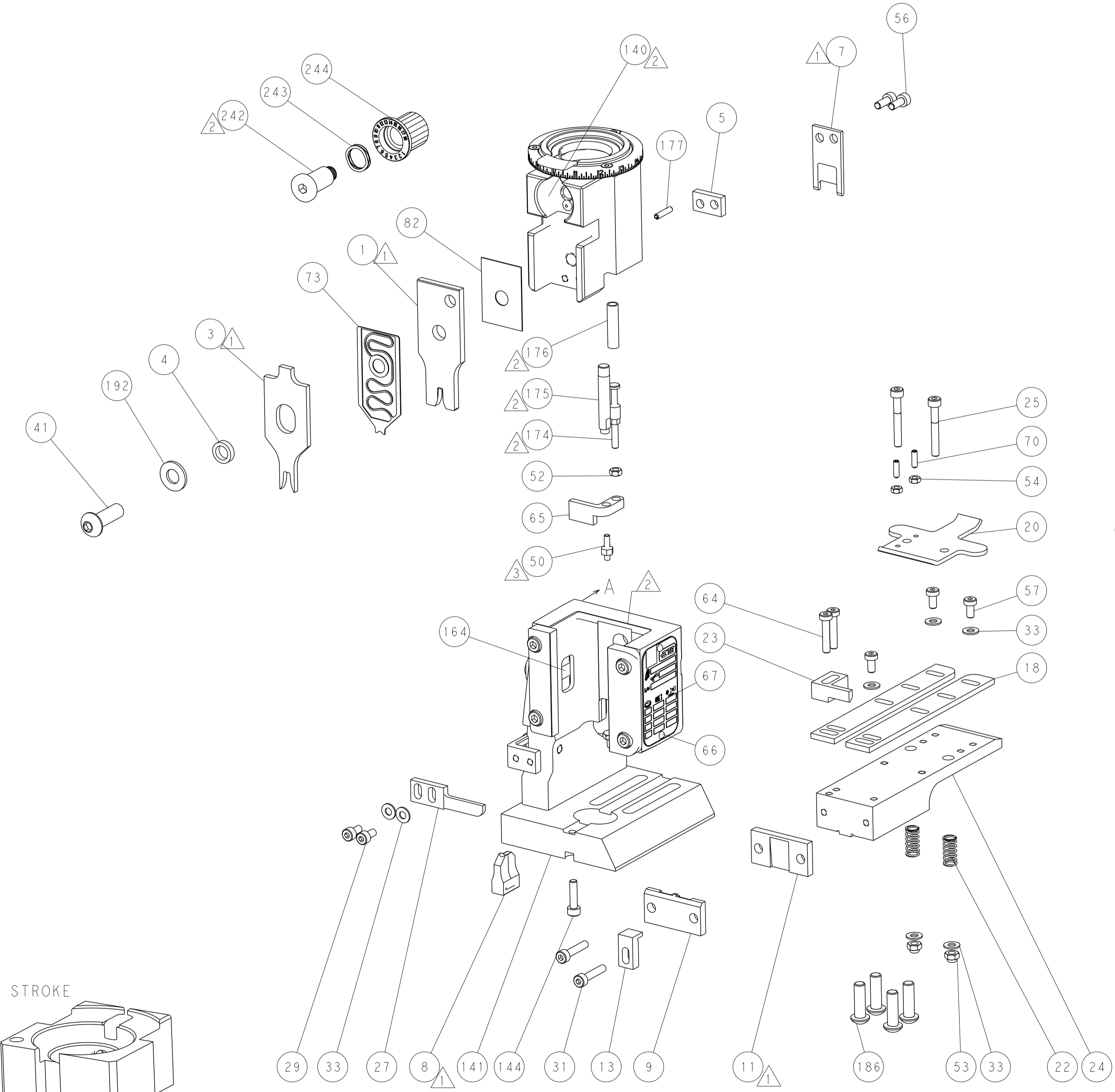
LOC		DIST		REVISIONS			
A	66	P	LYN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-
-	1	1		2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1		2119083-1	RETAINER, INSULATION DIAL		242
-	-	1		2119580-1	MECHANICAL FEED ASSEMBLY		239
-	1	-		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
-	1	1		455888-4	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		2119740-1	TAG, IDENTIFICATION		67
-	2	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1		1901681-5	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		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	1		1-1976055-2	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		1-1752371-2	PLATE, STRIP GUIDE		24
-	1	1		240825-1	PLATE, STRIP HOLD DOWN		23
-	2	2		2-22281-3	SPRING, COMPRESSION		22
-	1	1		1803292-1	DRAG		20
-	2	2		1901259-6	GUIDE, LOWER STRIP		18
-	1	1		1752360-1	SPACER, HOLD-DOWN		13
-	1	1		240644-9	PLATE, REAR SHEAR		11
-	-	-		-	-		10
-	1	1		4-690495-4	PLATE, FRONT SHEAR		9
-	1	1		7-1633384-2	ANVIL, COMBINATION		8
-	1	1		5-690474-2	BLADE, SLUG		7
-	1	1		2-240641-0	SPACER		5
-	1	1		238011-2	BLOCK, CRIMPER SPACER		4
-	1	1		2119582-3	CRIMPER, INSULATION F PREMIUM		3
-	-	-		-	-		2
-	1	1		2-456408-1	CRIMPER, WIRE PREMIUM		1
-	77	22	21	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 05MAR2012		CHK L. ZHANG 05MAR2012		NAME S. XI 05MAR2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
	ANGLES	FINISH	WEIGHT	SCALE	1:1	SHEET	3	OF	4	REV	C
Customer Accessible Production Drawing										RESTRICTED TO	

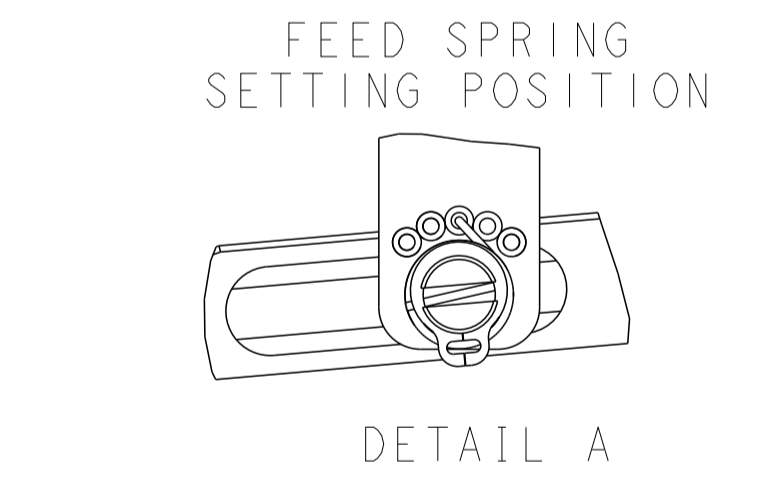
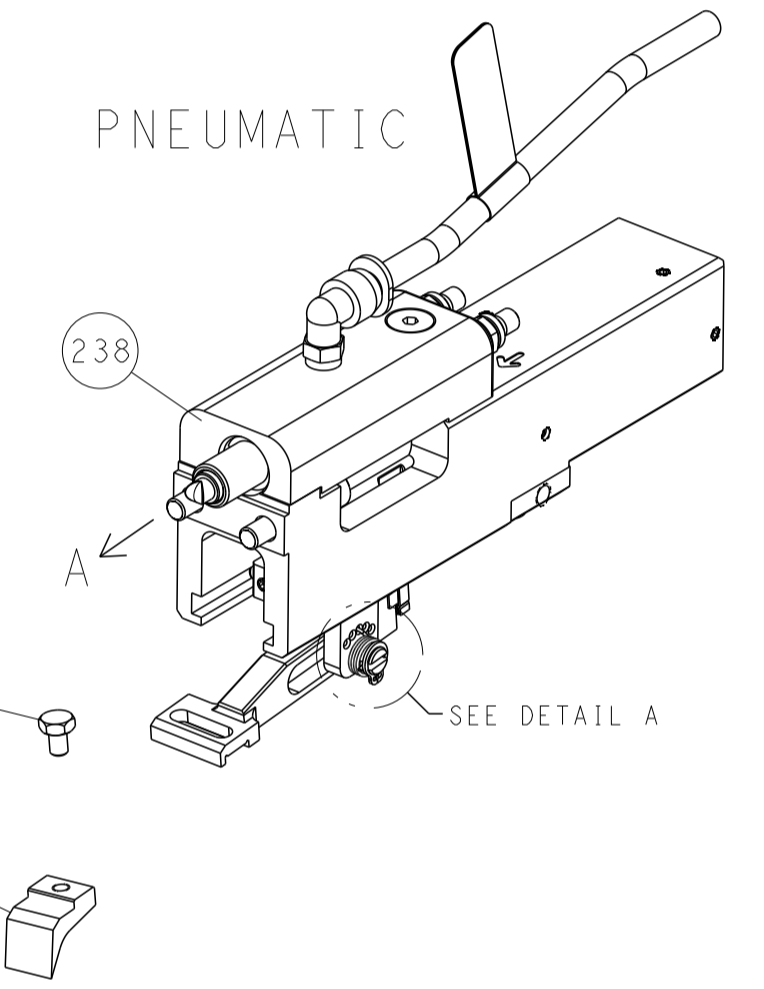
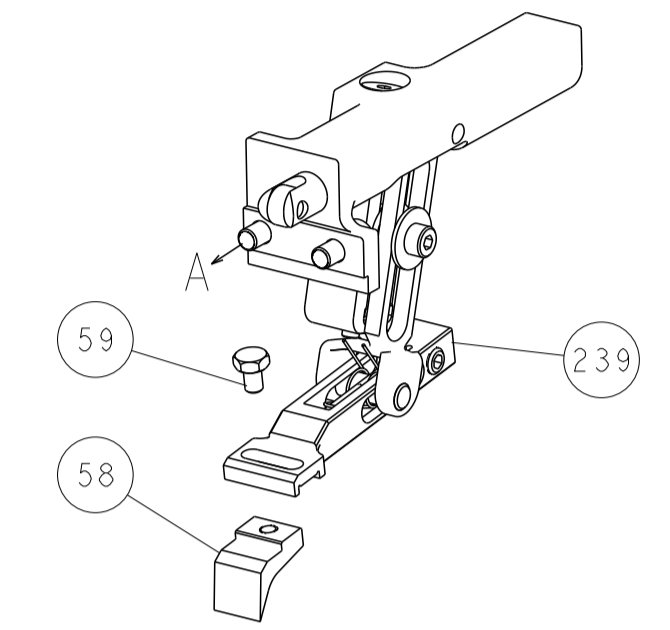
LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



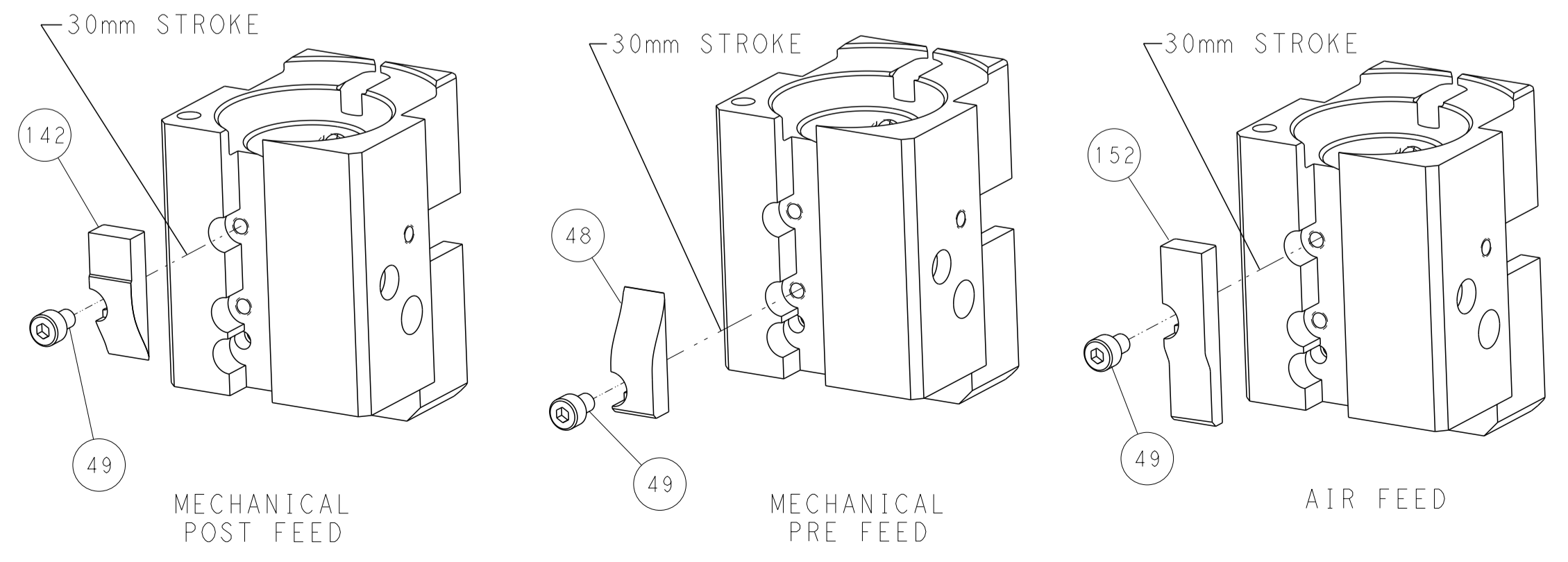
RAM AND HOLDDOWN SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT SCALE 1:1 SHEET 4 OF 4 REV C	STE TE Connectivity Harrisburg, PA 17105-3608 Customer Accessible Production Drawing	