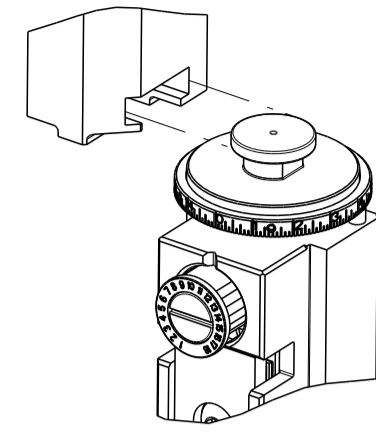


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150482-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150482-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150482-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150482-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150482-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		Ø0.76-1.78 mm [.030-.070 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61368-1	61368-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	1.30+/-0.05 [.051+/-0.002]	8.4
22 AWG OR 0.35mm ²	1.24+/-0.05 [.049+/-0.002]	9.2
0.25mm ²	1.19+/-0.05 [.047+/-0.002]	9.5
24 AWG OR 0.21mm ²	1.17+/-0.05 [.046+/-0.002]	9.6

- 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 180. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- LUBRICANT IS RECOMMENDED.

***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.

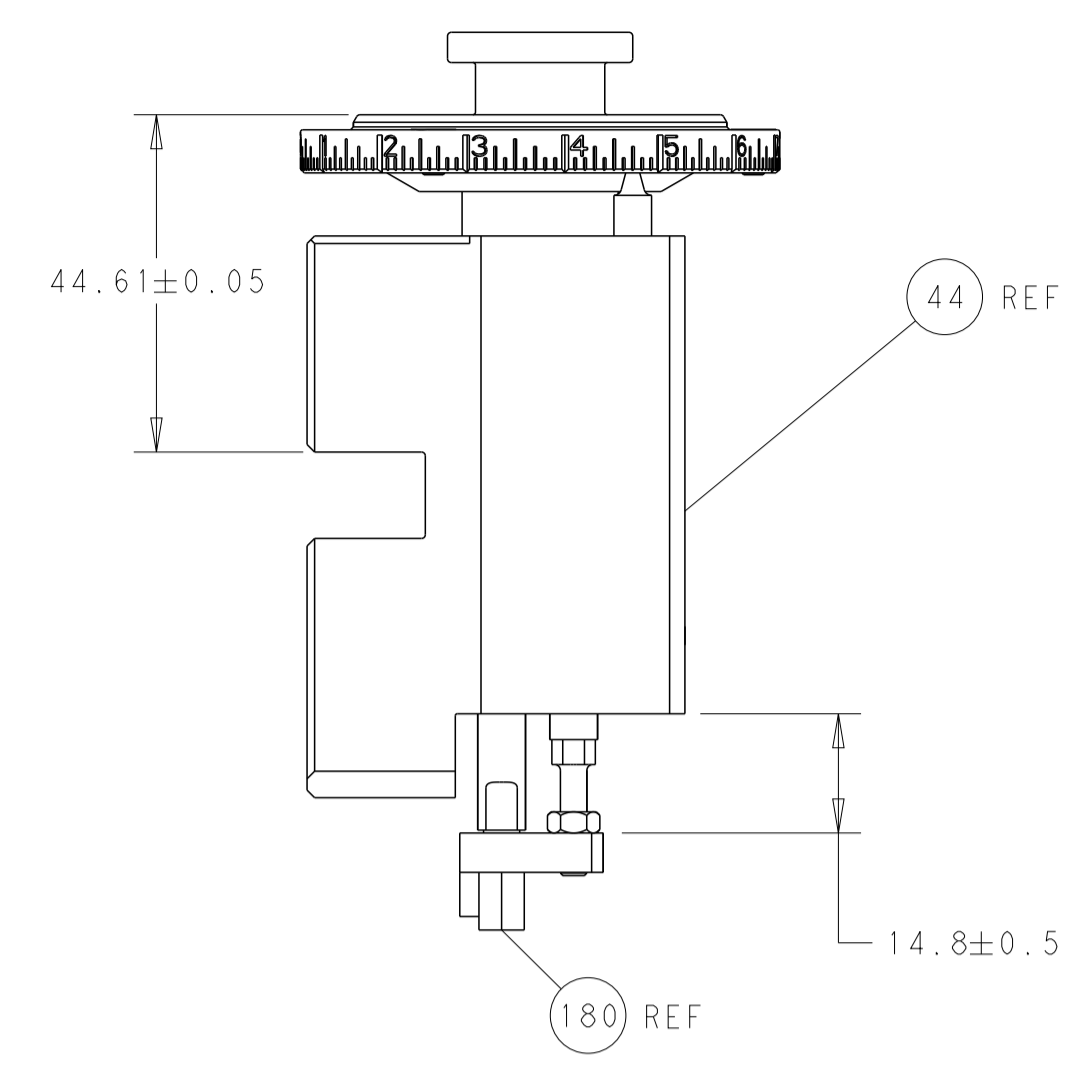
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-18-014768	19SEP2018	FL	TE
		C		ECR-19-001578	30JAN2019	FL	CT
		D		ECR-21-006397	22JUN2021	JWC	TE
		E		ECR-21-007030	20JUL2021	JWC	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	-	2844940-3	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	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	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	-	1	1-2063961-0	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	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	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	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-9	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	2-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
	1	1	1	1	690495-6	PLATE, FRONT SHEAR	9
	1	2	2	1	1-1333215-3	ANVIL, COMBINATION	8
	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-6	SPACER	5
-	1	1	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
	1	2	2	1	7-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
	1	2	2	1	3-456404-9	CRIMPER, WIRE PREMIUM	1
	-77-72-71-2-1				PART NO	DESCRIPTION	ITEM NO

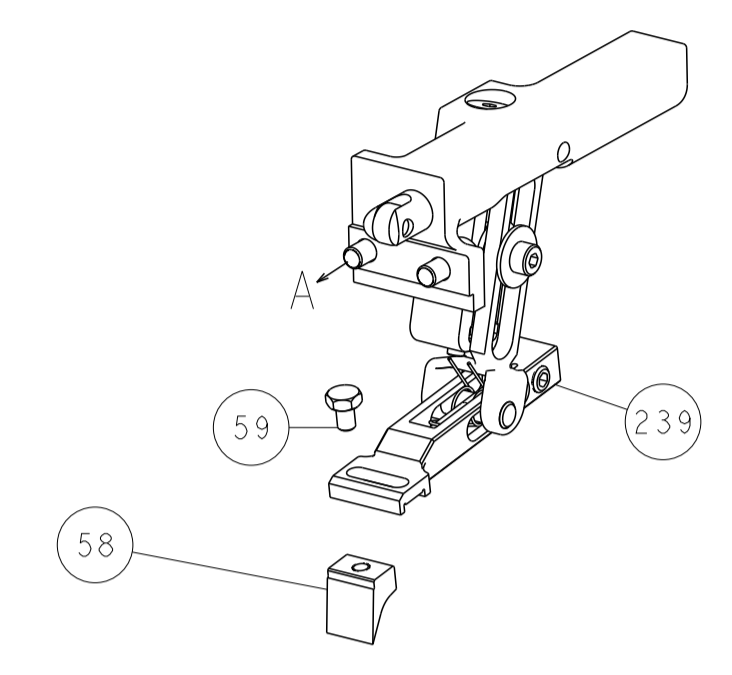
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	
DWN H. HUANG 23SEP2014 CHK L. ZHANG 23SEP2014 APVD J. GUO 23SEP2014				NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150482 SCALE 1:1 SHEET 1 OF 4 REV F			

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

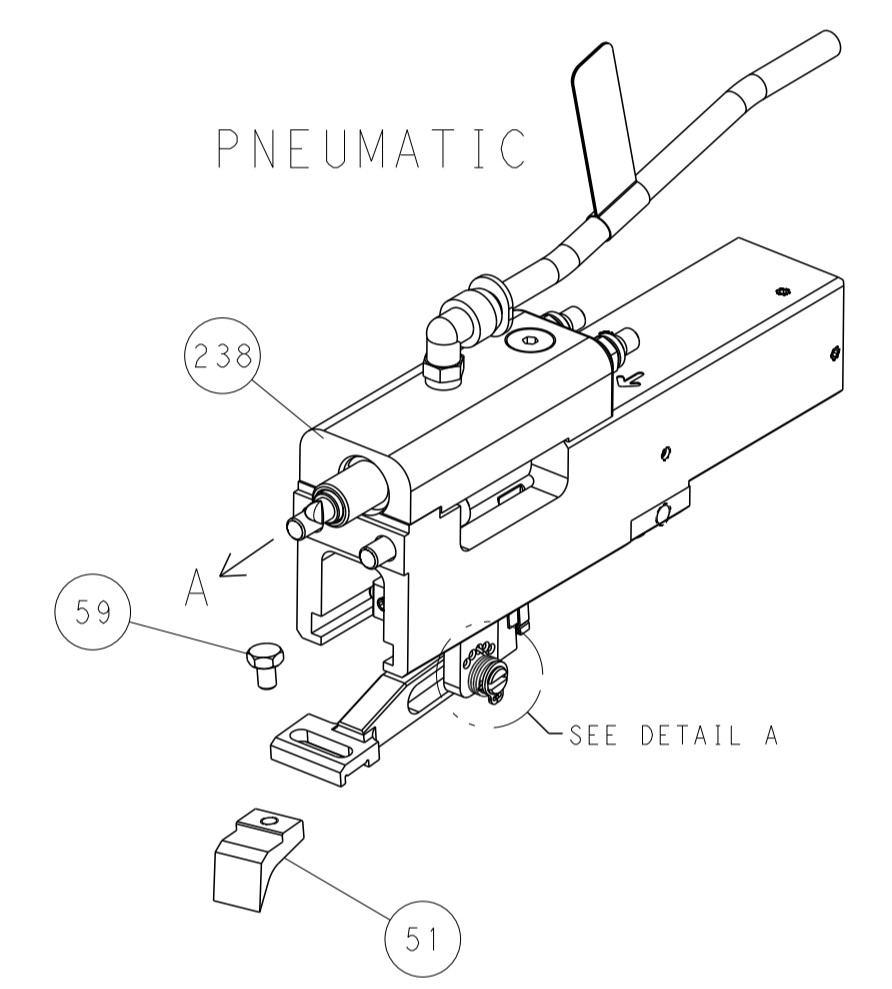


RAM AND HOLDDOWN SET-UP

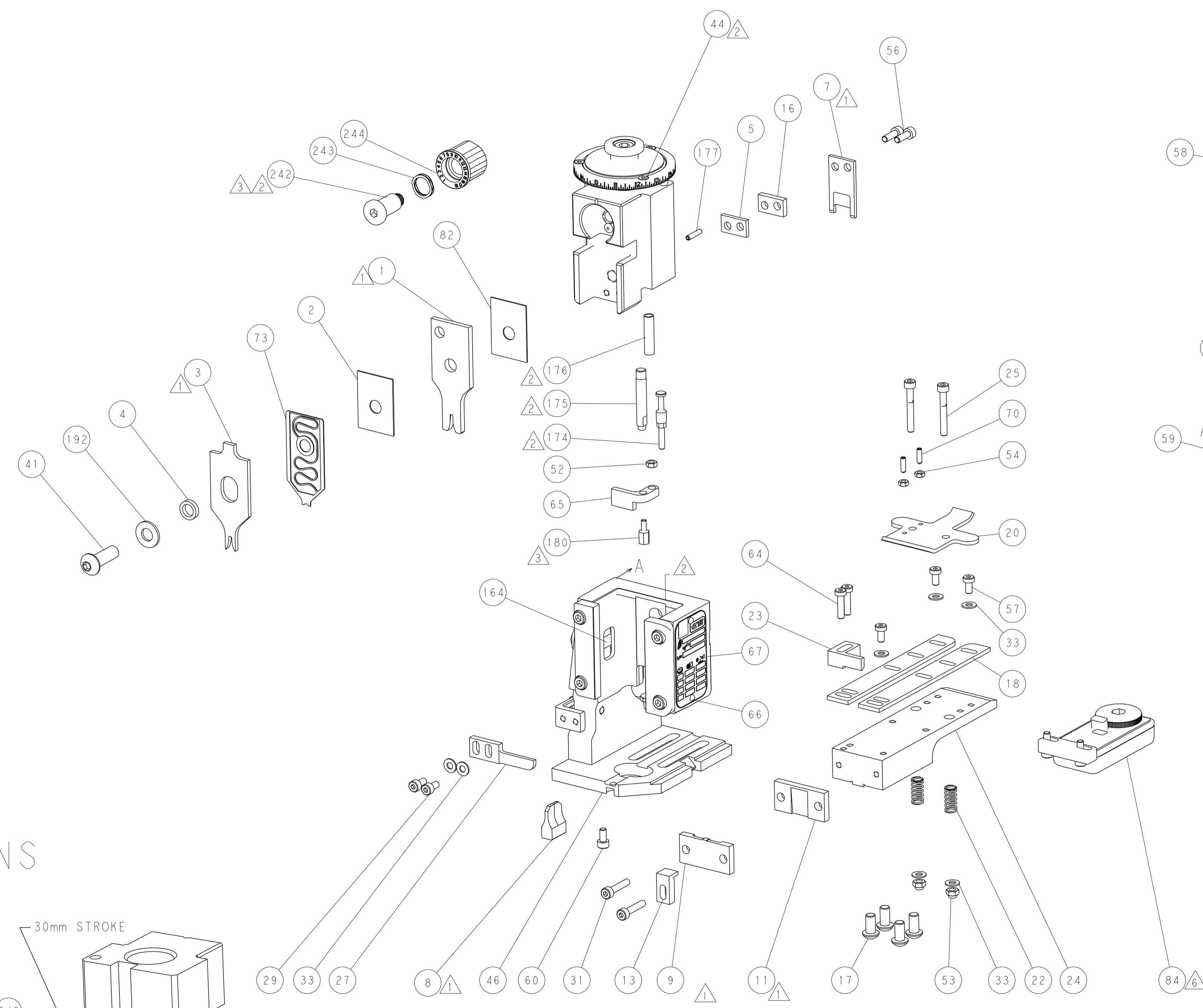
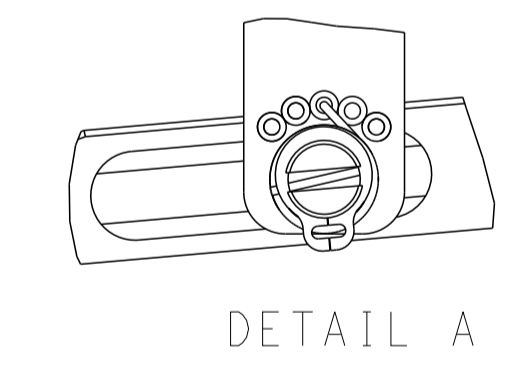
FEED TYPE
MECHANICAL



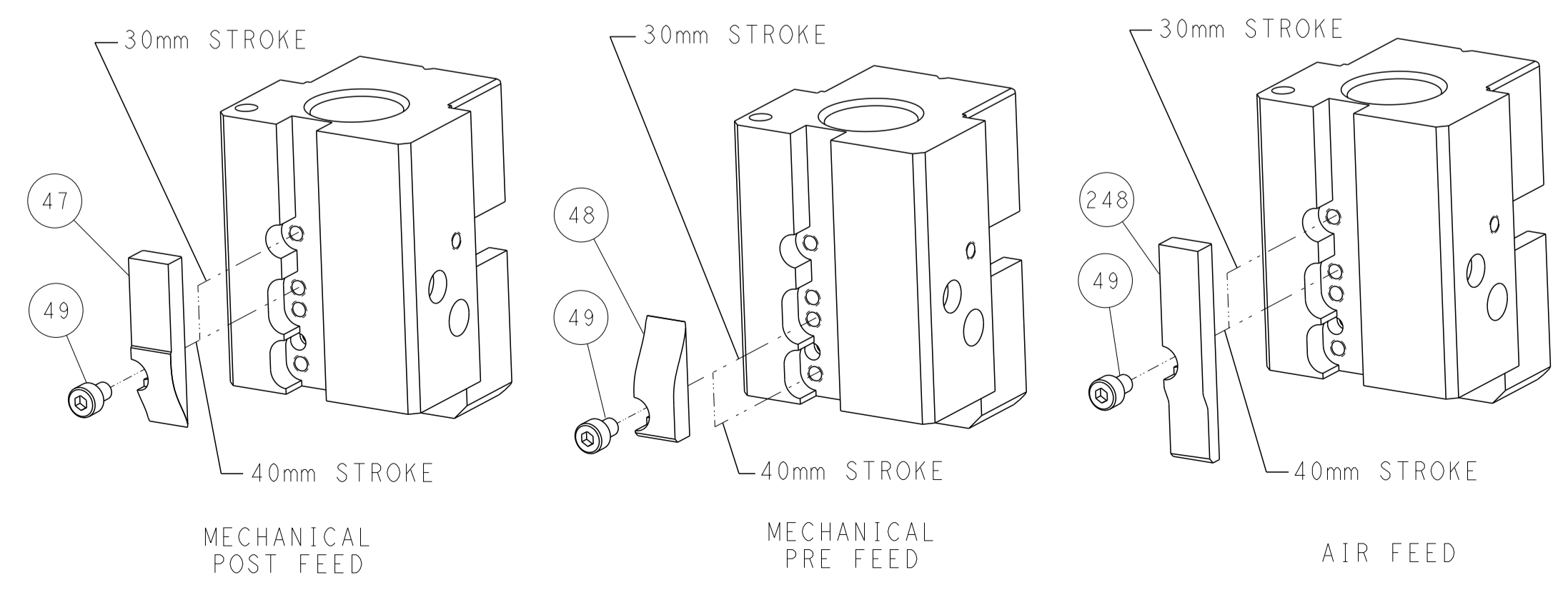
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

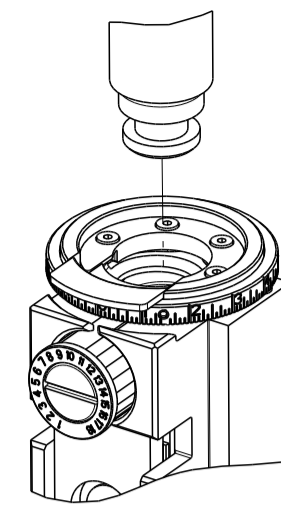


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN K. HUANG 23SEP2014 CHK L. ZHANG 23SEP2014 APVD J. GUO 23SEP2014	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. A1 00779 ©=2150482 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV F

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COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150482-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150482-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150482-7	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)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm (.173-.203 IN)		INSULATION DIAMETER RANGE Ø0.76-1.78 mm (.030-.070 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61368-1	61368-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.30 +/- 0.05 [.051 +/- .002]	8.4
22 AWG OR 0.35mm2	1.24 +/- 0.05 [.049 +/- .002]	9.2
0.25mm2	1.19 +/- 0.05 [.047 +/- .002]	9.5
24 AWG OR 0.21mm2	1.17 +/- 0.05 [.046 +/- .002]	9.6



- 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 180. 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.
- 6 LUBRICANT IS RECOMMENDED.

***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.

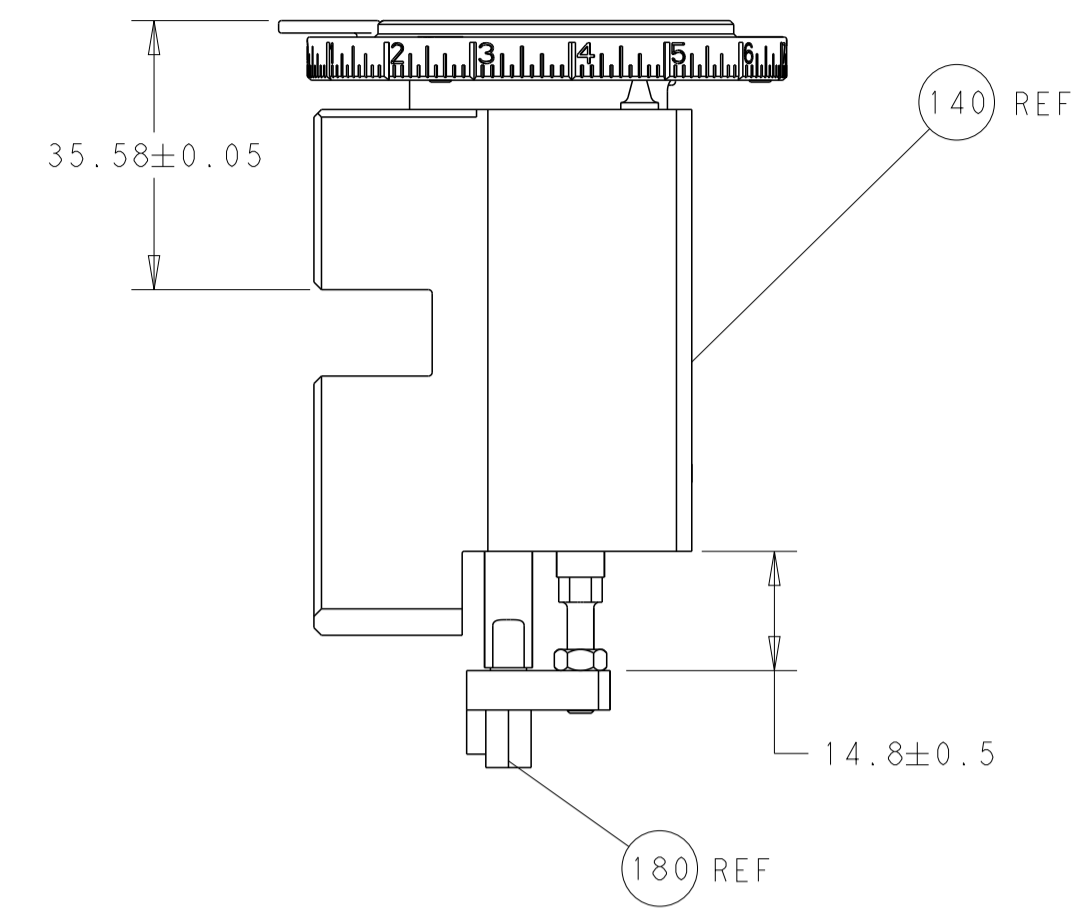
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-5	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
3	-	1	1-1752354-5	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	-	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
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	1-2063961-0	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
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	240825-9	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	2-240641-4	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690495-6	PLATE, FRONT SHEAR	9
1	1	1	1-1333215-3	ANVIL, COMBINATION	8
1	-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-240641-6	SPACER	5
-	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	7-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO
-	-	-	-	DESCRIPTION	ITEM NO

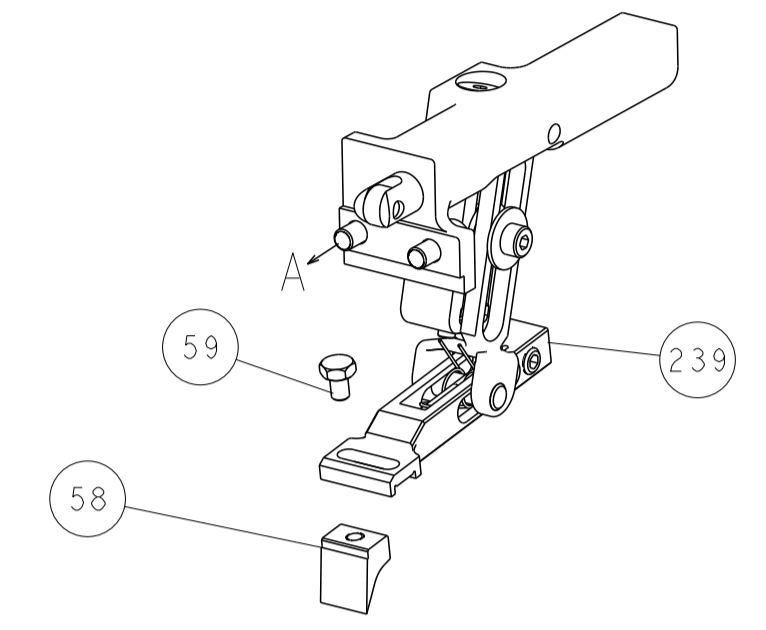
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG 23SEP2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		APVD J. GUO 23SEP2014		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				APPLICATION SPEC		A1 00779 ©=2150482	
				WEIGHT		SCALE 1:1 SHEET 3 OF 4 REV F	
				Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	

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

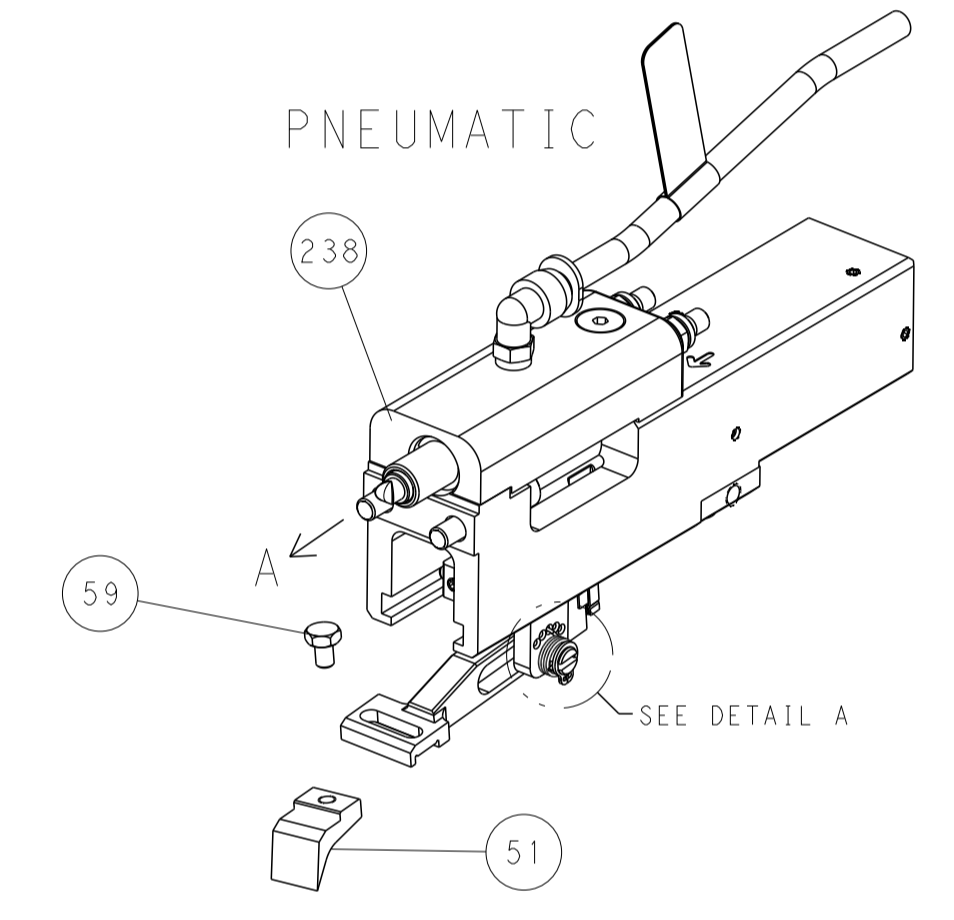


RAM AND HOLDDOWN SET-UP

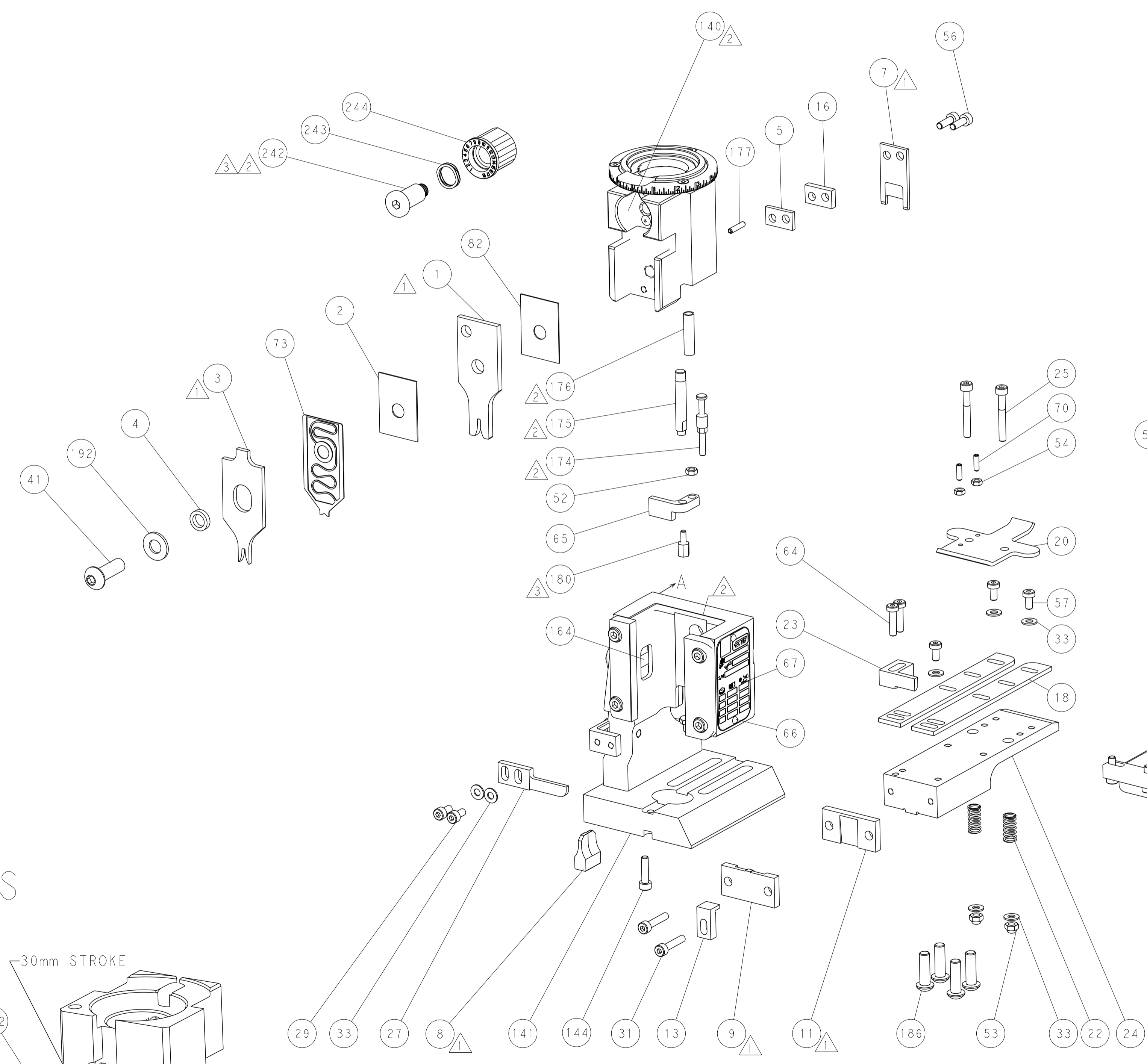
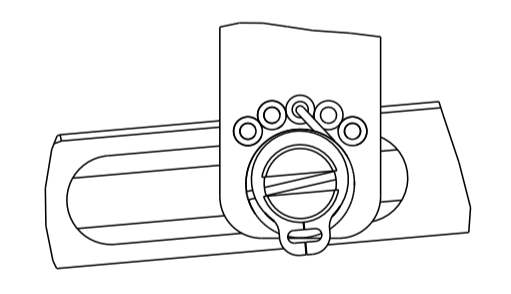
FEED TYPE
MECHANICAL



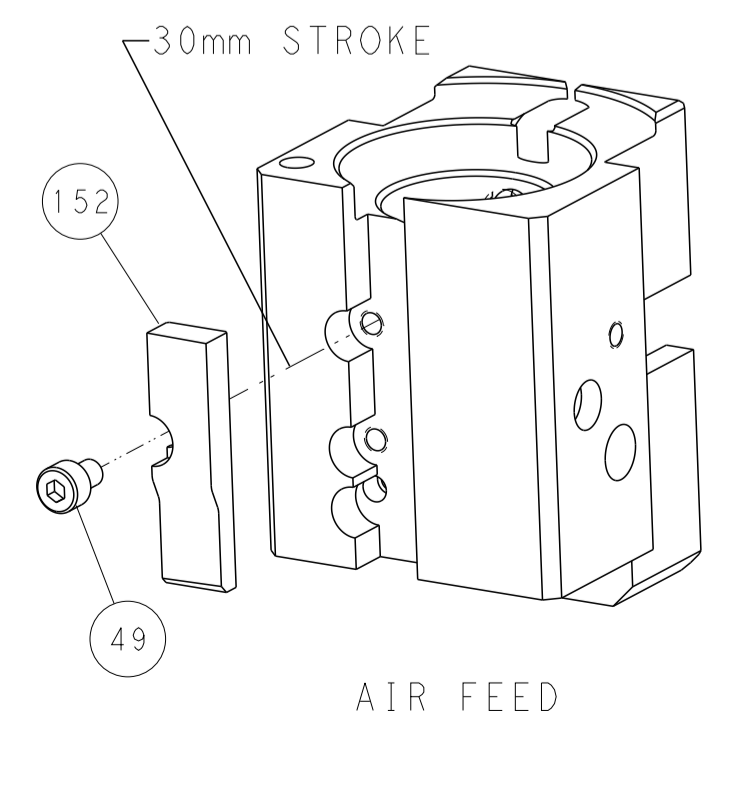
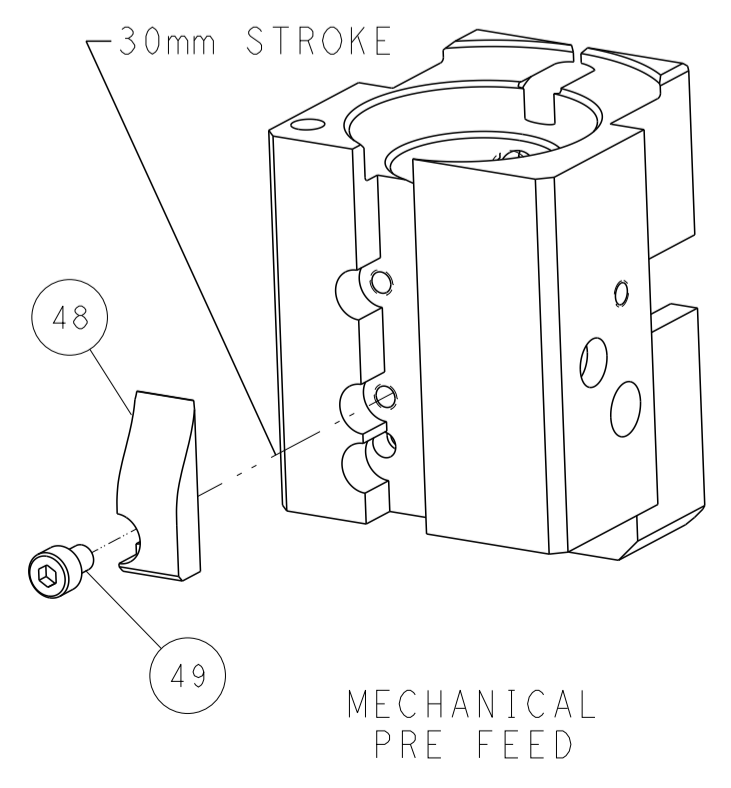
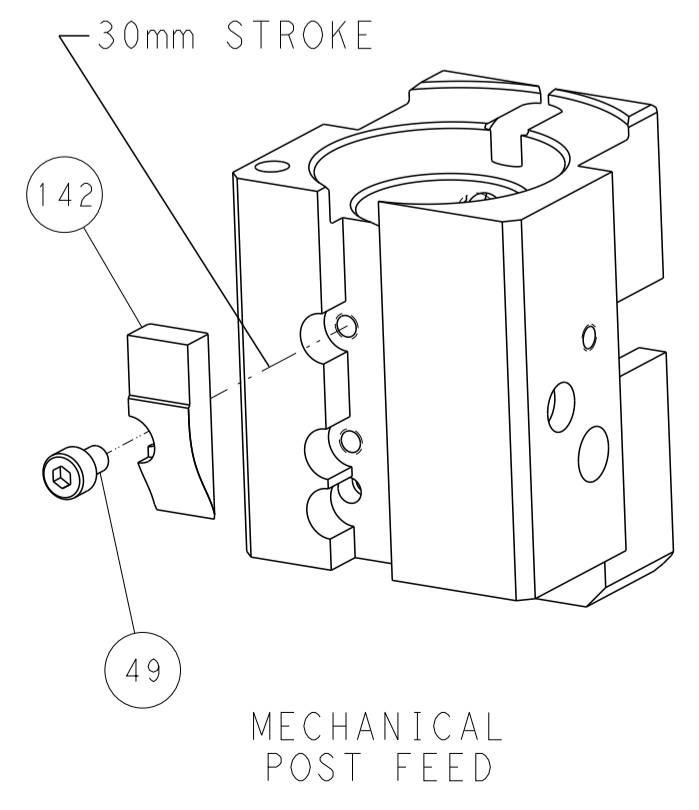
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: K. HUANG 23SEP2014 CHK: L. ZHANG 23SEP2014 APVD: J. GUO 23SEP2014		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150482 SCALE: 1:1 SHEET: 4 OF: 4 REV: F	
MATERIAL:		WEIGHT:		RESTRICTED TO:		Customer Accessible Production Drawing	