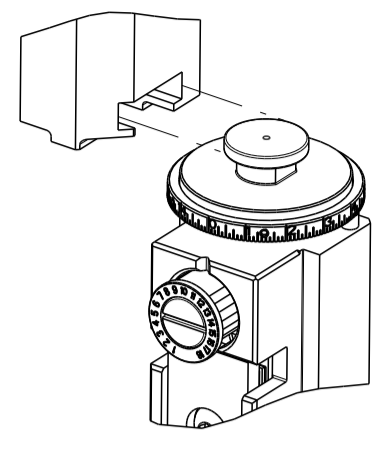


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150536-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150536-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150536-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150536-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150536-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE FASTON .250 SERIES		
WIRE STRIP LENGTH 6.02-6.78 mm [.237-.267 IN]	INSULATION DIAMETER RANGE Ø3.81-5.08 mm [.150-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	
TERMINALS APPLIED		
TE TERMINAL 62428-2	TE TERMINAL 62428-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.64 +/- 0.05 [.104 +/- .002]	3.8
12 AWG	2.21 +/- 0.05 [.087 +/- .002]	8.1

- 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 180.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-17-004318	24MAR2017	MR	CT
		B1		ECR-18-012451	06AUG2018	MZ	KZ
		C		ECR-18-016264	13OCT2018	TB	TE
		D		ECR-19-011869	27JUL2019	TB	TE

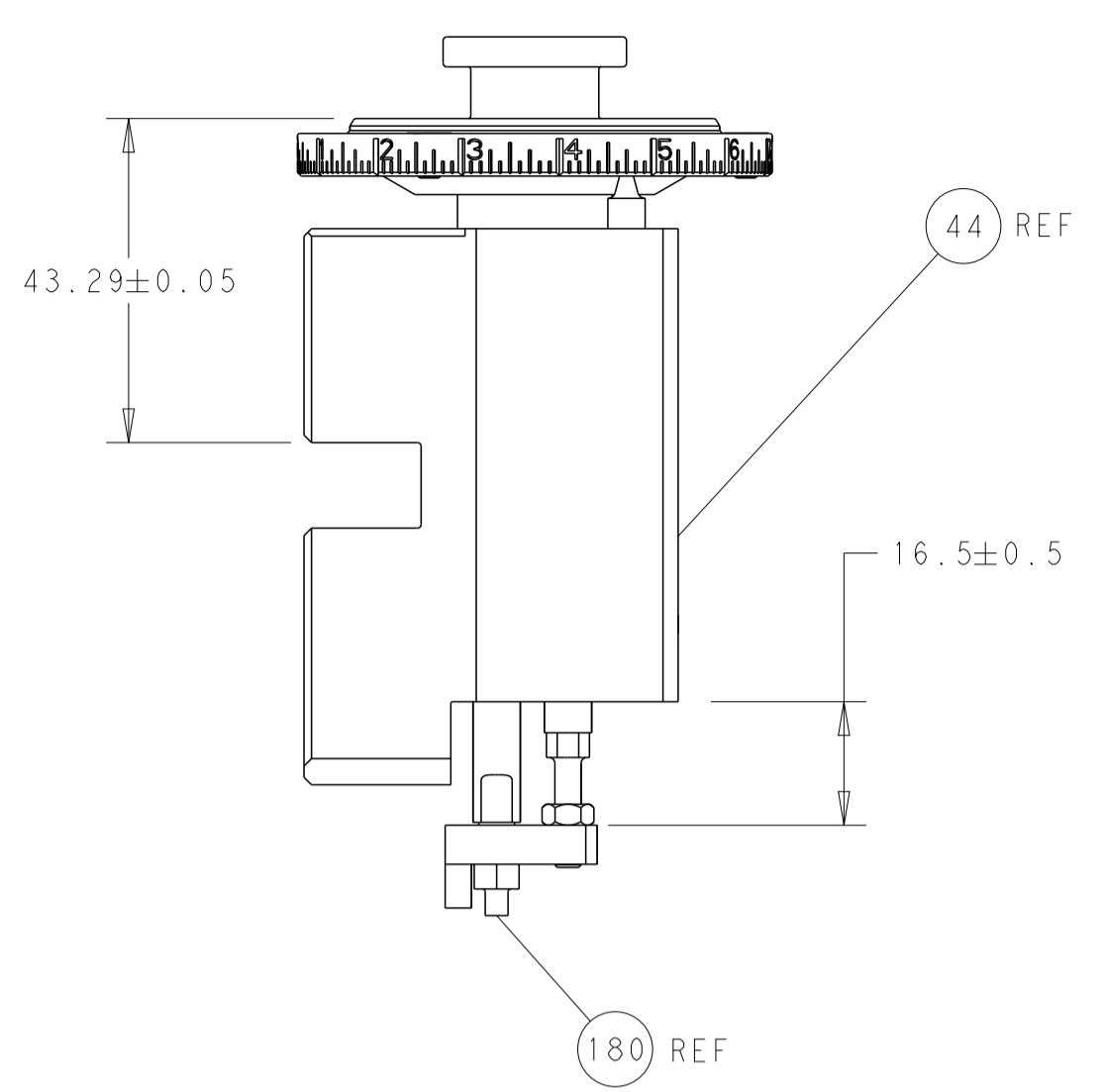
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239		
-	1	-	1	-	2844940-3	AIR FEED MODULE	238		
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
3	-	1	1	1	1-1976055-2	STANDOFF, HOLD-DOWN	180		
-	1	1	1	1	6-9931111-6	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	455888-5	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	1901681-5	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	-	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	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	240825-2	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	1901259-7	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	4-690495-3	PLATE, FRONT SHEAR	9		
1	1	2	2	1	1	7-1803000-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	690474-8	BLADE, SLUG	7	
-	-	-	-	-	-	-	6		
-	1	1	1	1	1	3-240641-2	SPACER	5	
-	1	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1	1-455888-2	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456415-0	CRIMPER, WIRE .155 F PREMIUM	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

**\*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)

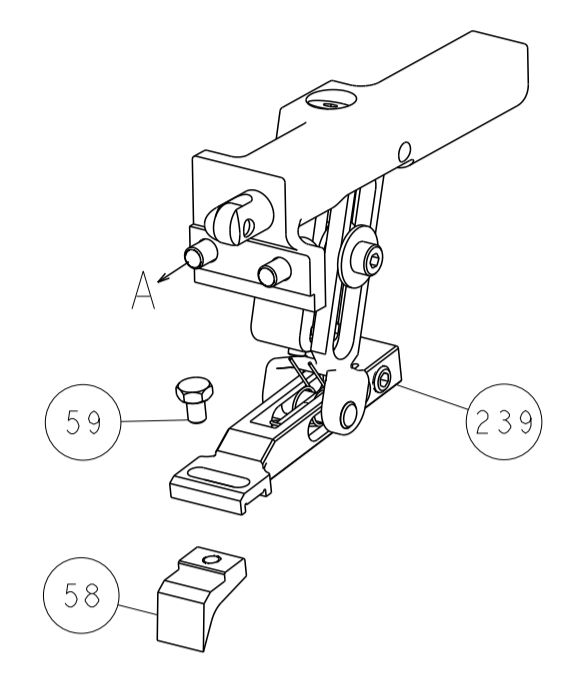
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2150536	1	4	D

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

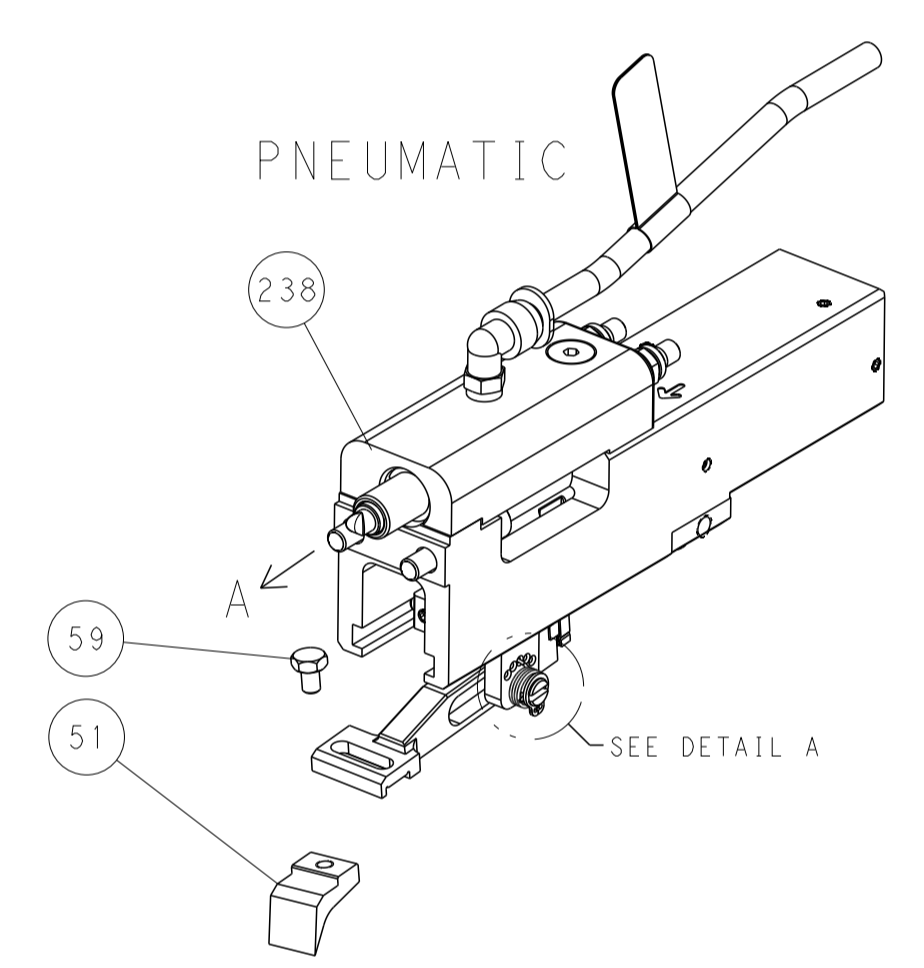


RAM AND HOLDDOWN SET-UP

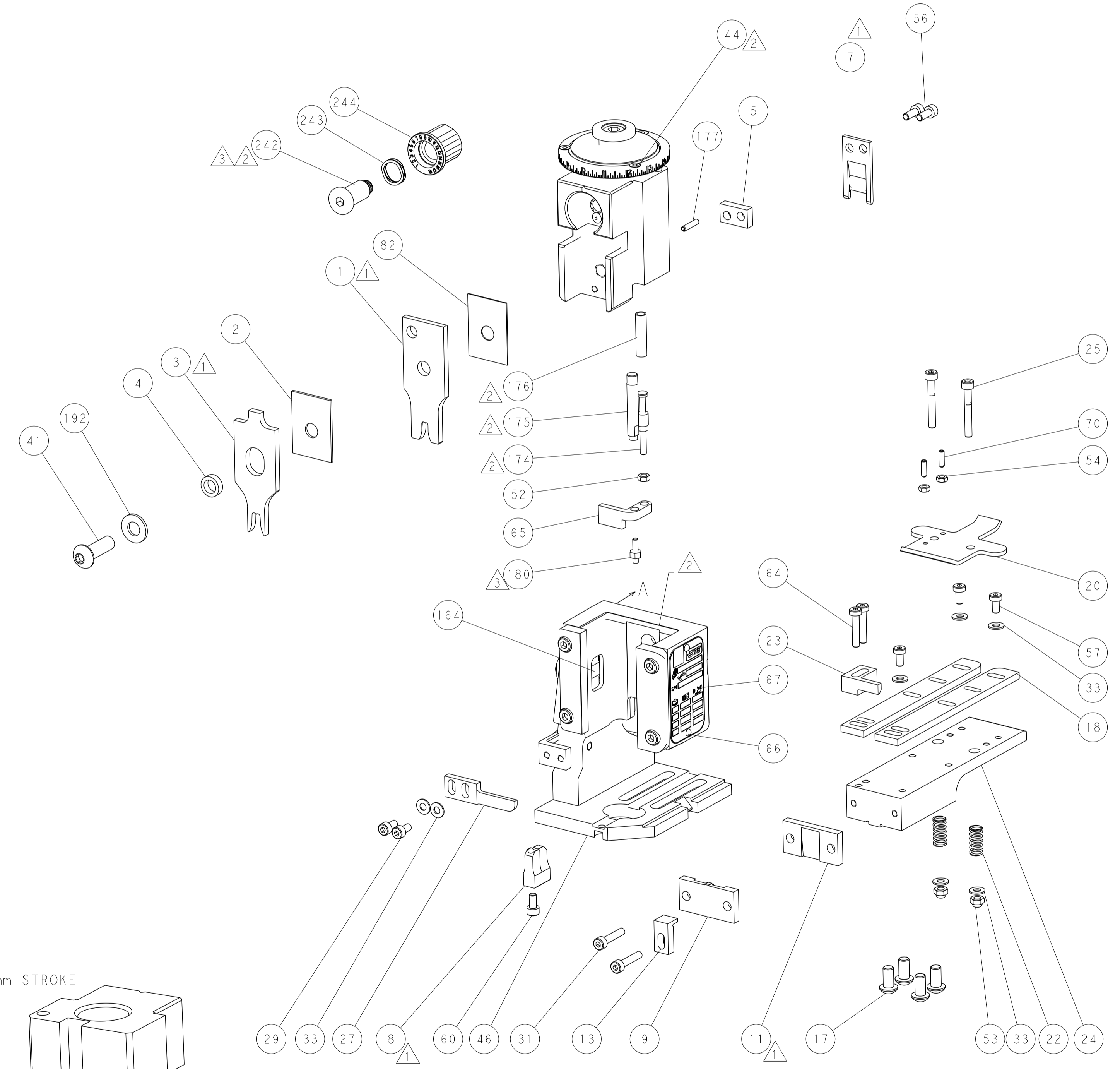
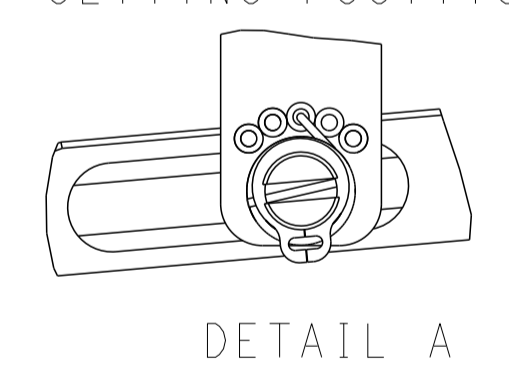
FEED TYPE  
MECHANICAL



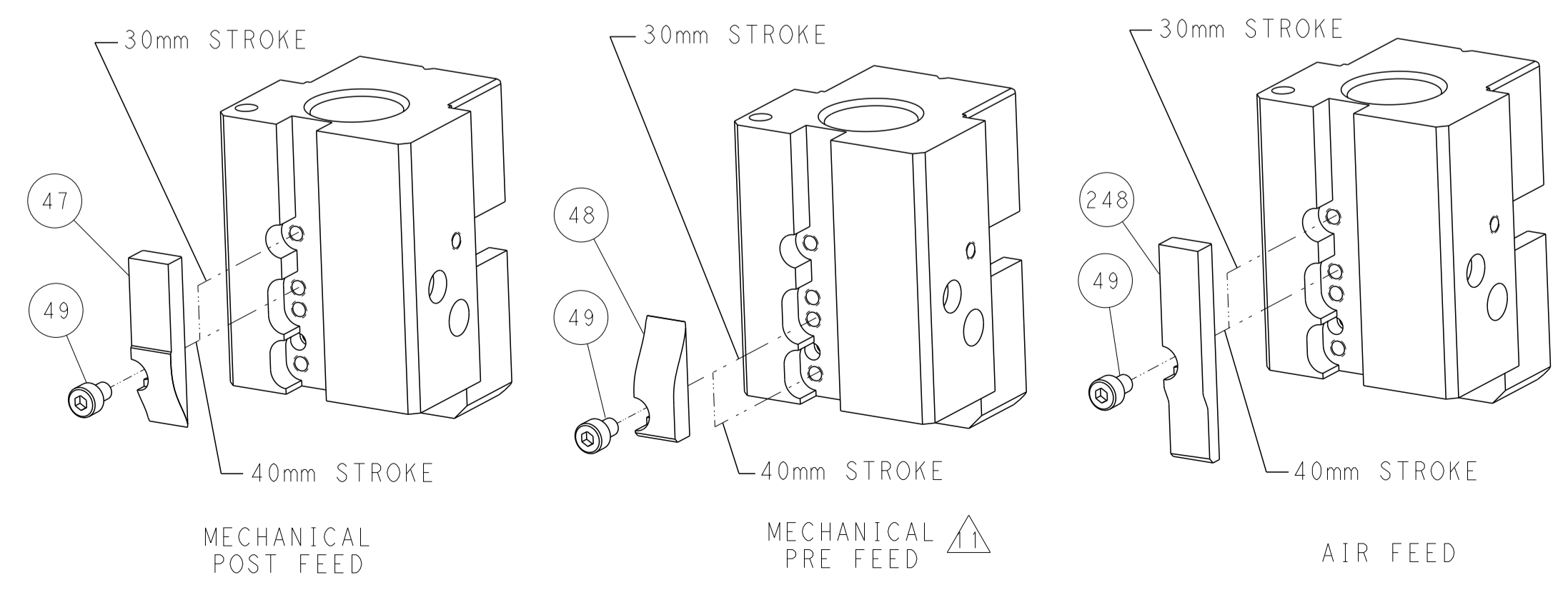
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

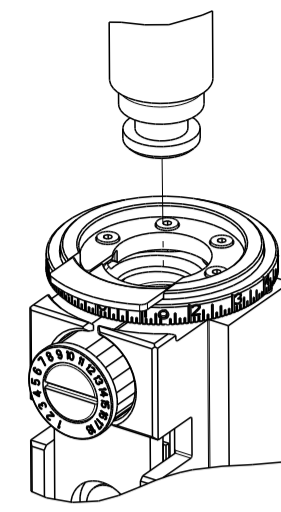


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN J. HOU 10MAR2015 CHK L. ZHANG 10MAR2015 APVD H. GUO 10MAR2015		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150536	
MATERIAL		WEIGHT		SCALE 1:1		SHEET 2 OF 4 REV D	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150536-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150536-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150536-7	A	CRIMP TOOLING KIT	-

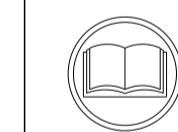
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [1.155]	F
INSUL	5.59 mm [1.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.02-6.78 mm [1.237-.267 IN]		Ø3.81-5.08 mm [1.150-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62428-2	62428-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.64+/-0.05 [1.104+/-0.002]	3.8
12 AWG	2.21+/-0.05 [1.087+/-0.002]	8.1



- 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 180.
- 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.

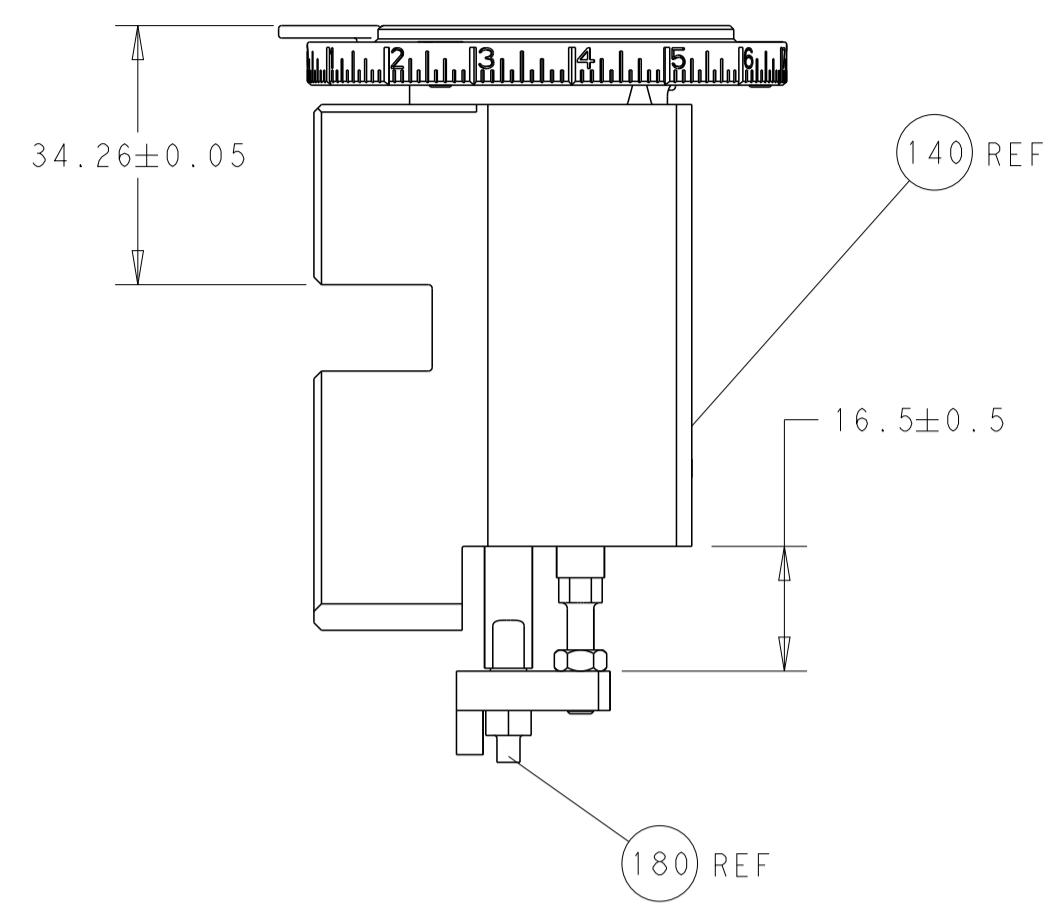
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-3	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	1-1976055-2	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
-	1	1	455888-5	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	1901681-5	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	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	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	4-690495-3	PLATE, FRONT SHEAR	9
1	1	1	7-1803000-3	ANVIL, COMBINATION, END FEED	8
1	-	1	690474-8	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	3-240641-2	SPACER	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	1	1-456415-0	CRIMPER, WIRE .155 F PREMIUM	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)

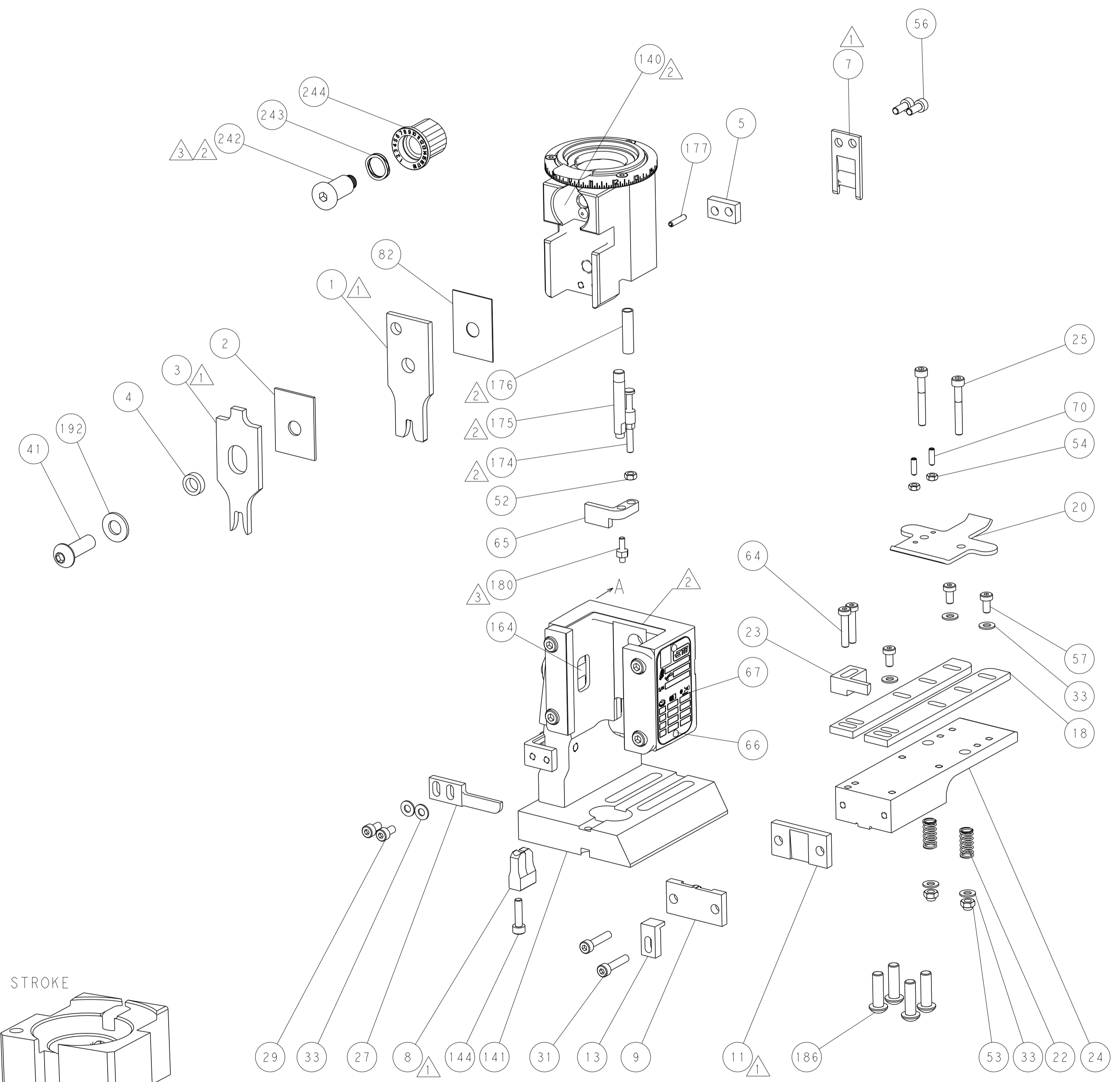
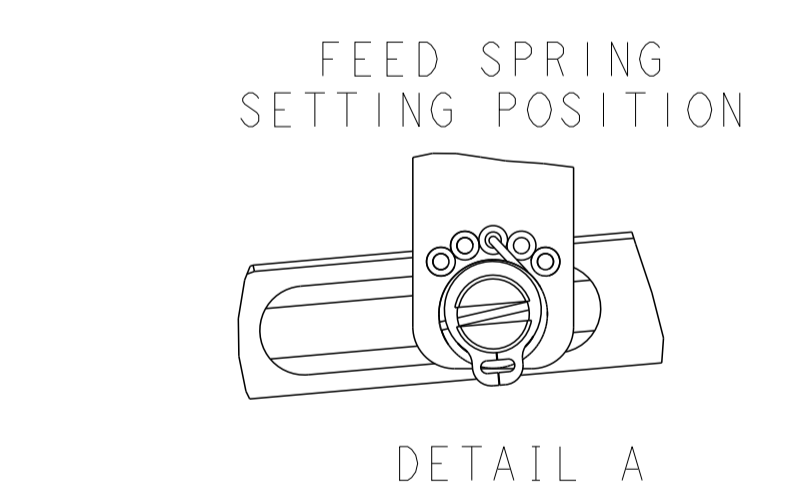
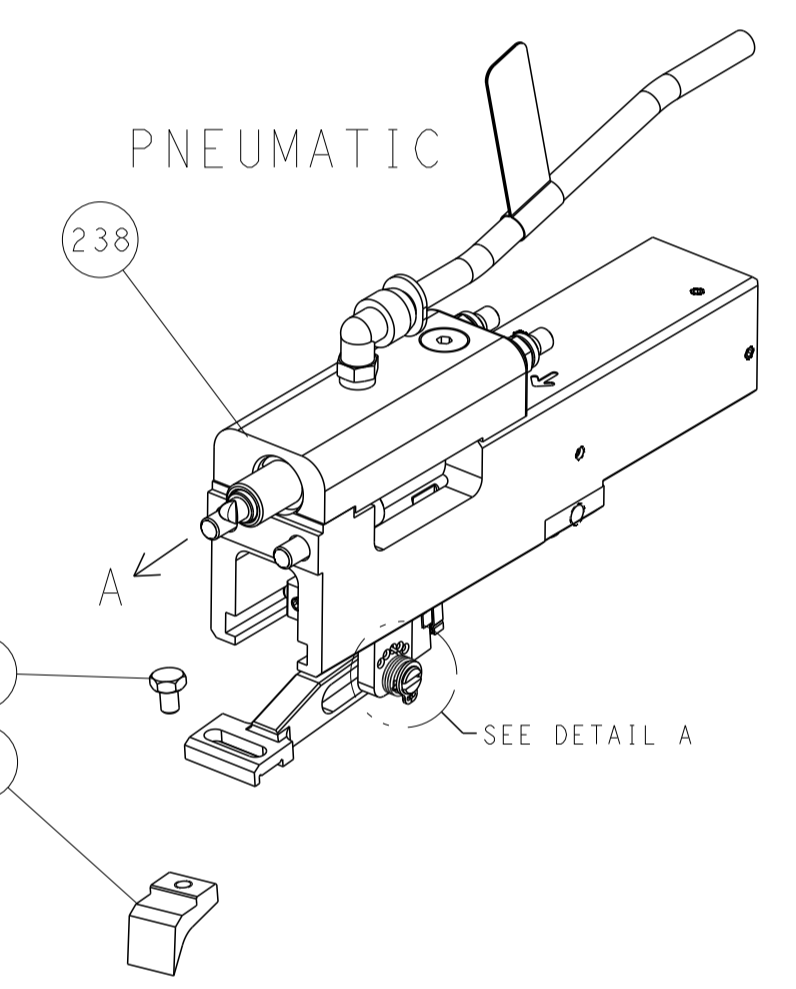
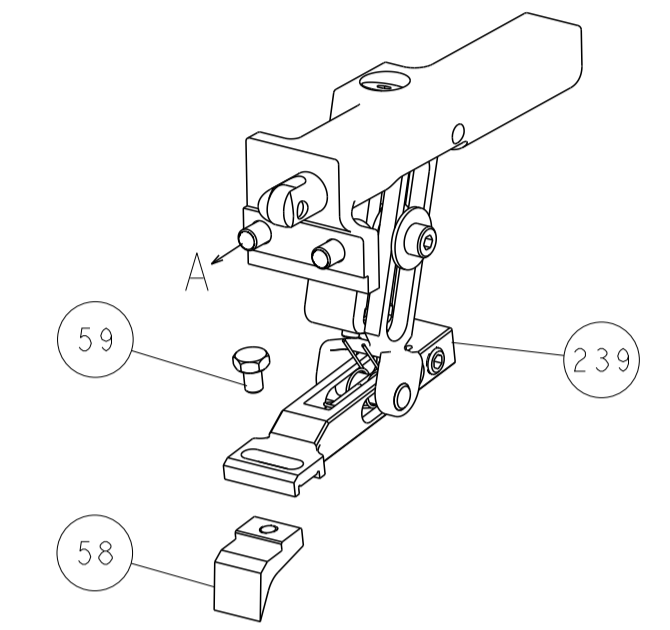
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 10MAR2015		CHK: L. ZHANG 10MAR2015		APVD: J. GUO 10MAR2015		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150536	RESTRICTED TO: -
MATERIAL: -								WEIGHT: -	Customer Accessible Production Drawing		SCALE: 1:1
								SHEET 3 OF 4		REV D	

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

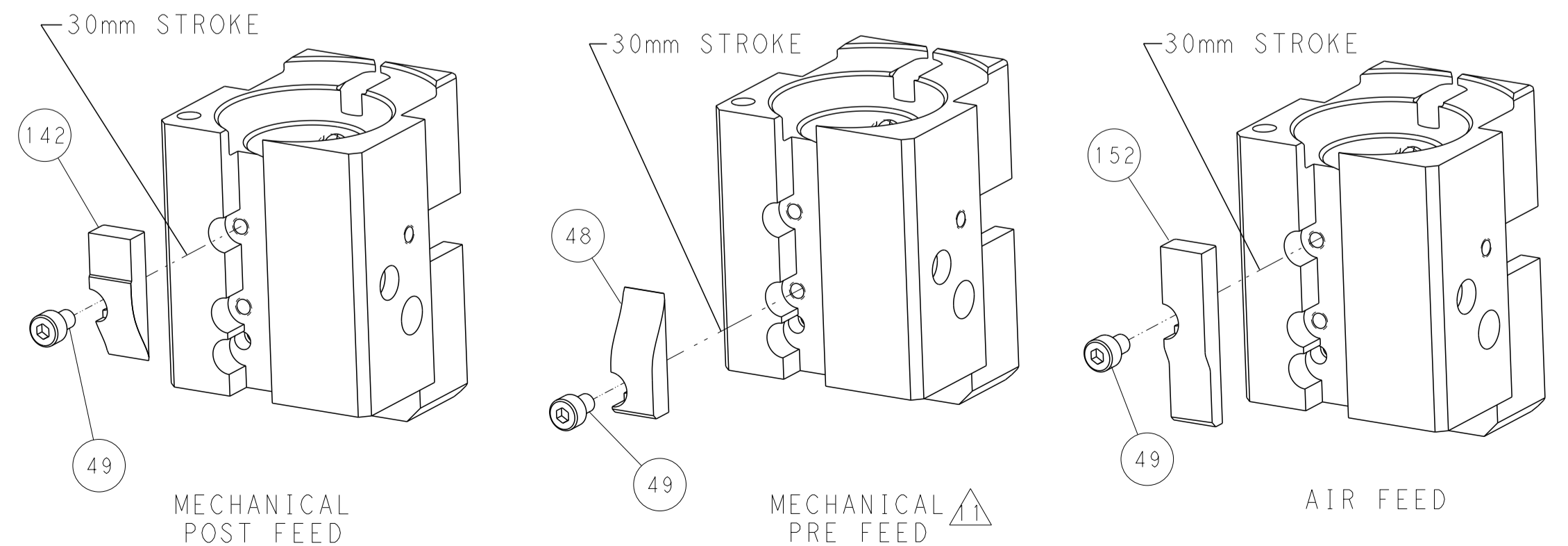


RAM AND HOLDDOWN SET-UP

# 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 J. HOU 10MAR2015		CHK L. ZHANG 10MAR2015		APVD H. GUO 10MAR2015		NAME		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	9 PLC ±	10 PLC ±	SIZE	CAGE CODE
												A1	00779
MATERIAL	FINISH	WEIGHT	Customer Accessible Production Drawing		SCALE	SHEET	OF	REV	RESTRICTED TO				
					1:1	4	4	D					