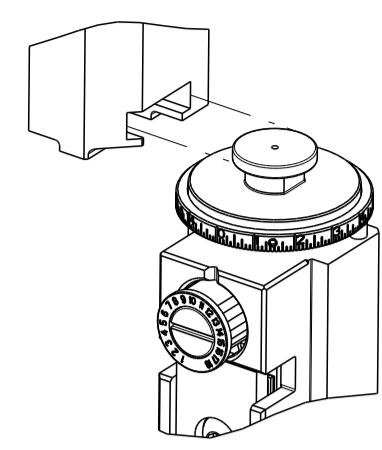


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150251-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150251-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150251-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150251-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150251-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	4.32 mm [.170]	F

APPL INSTRUCTIONS 408-35043

TERMINAL DATA: STOCKO TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3mm RECEPTACLE	
WIRE STRIP LENGTH 5.00-5.80 mm [.197-.228 IN]	INSULATION DIAMETER RANGE Ø3.40-4.40 mm [.134-.173 IN]
TERMINAL APPLICATION SPECIFICATION NONE	
TERMINALS APPLIED	
TE TERMINAL 1949156-1	STOCKO TERMINAL RSB 8152 F 6.3-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.59+/-0.05 [.102+/- .002]	8.3
5.1.5+1.5+2.5mm2	2.56+/-0.05 [.101+/- .002]	8.5
2.5+2.5mm2	2.49+/-0.05 [.098+/- .002]	9.2
5.1.0+1.5+2.5mm2	2.49+/-0.05 [.098+/- .002]	9.2
5.00mm2	2.49+/-0.05 [.098+/- .002]	9.2
4.00mm2	2.29+/-0.05 [.090+/- .002]	11.3
1.5+1.5mm2	2.20+/-0.05 [.087+/- .002]	12.0
3.00mm2	2.20+/-0.05 [.087+/- .002]	12.0

- 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 THREE WIRE COMBINATION NOT 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.

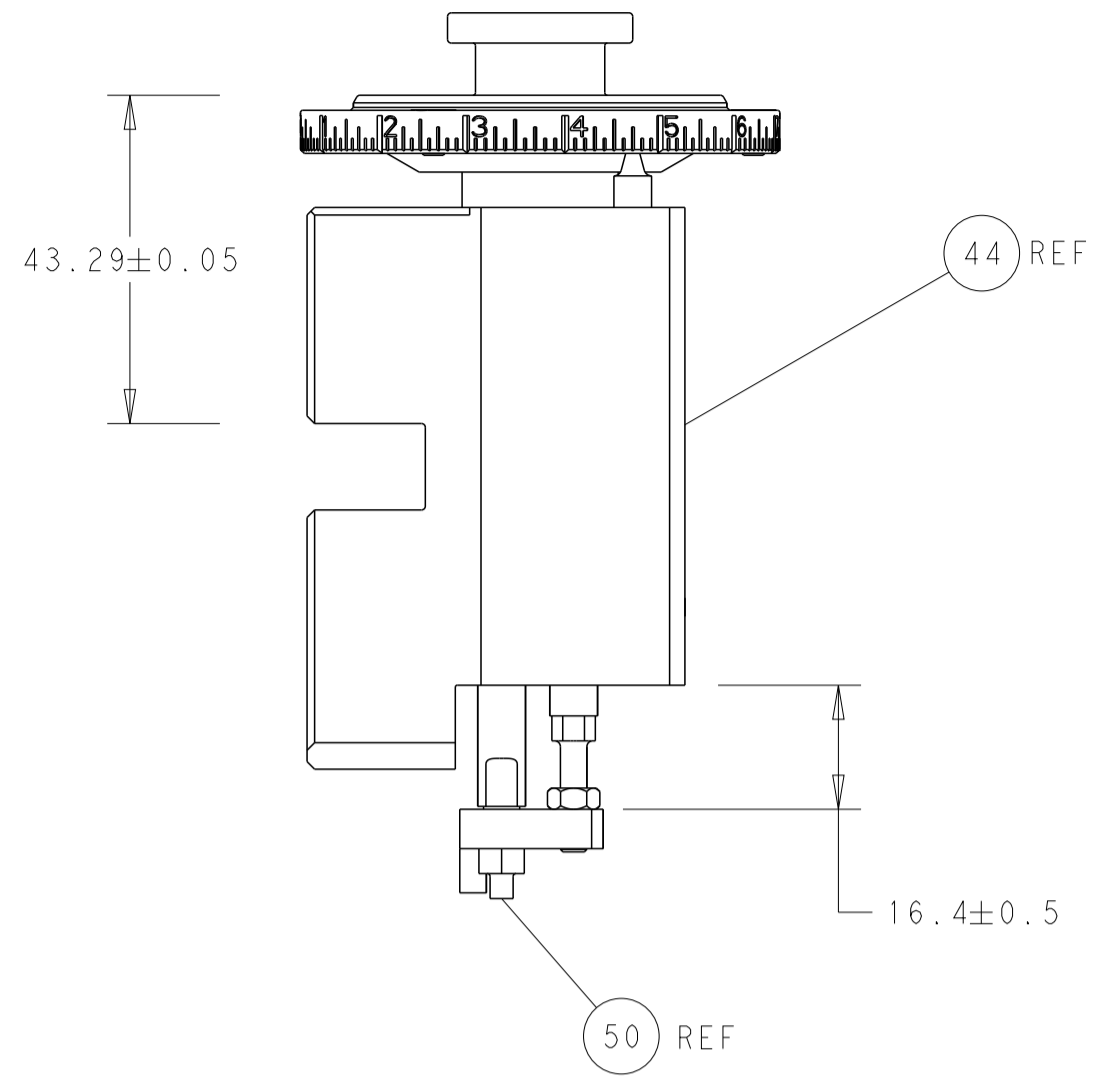
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASE	23MAY2012	L. Z	S. X
		B		ECR-18-001379	29JAN2018	JAH	GB
		C		ECR-22-130650	24FEB2022	TB	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	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1	1	2119791-9	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	2168400-5	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	1-1976055-1	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	240825-4	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	240833-3	PLATE, REAR SHEAR	11
-	1	1	1	1	2-690495-6	PLATE, FRONT SHEAR	9
1	2	2	1	1	1633383-7	ANVIL, COMBINATION	8
1	1	1	1	1	2-690474-8	BLADE, SLUG	7
-	1	1	1	1	1-240641-8	SPACER	5
-	1	1	1	1	1-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	3-1633961-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	456415-6	CRIMPER, WIRE .155 F PREMIUM	1
-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO

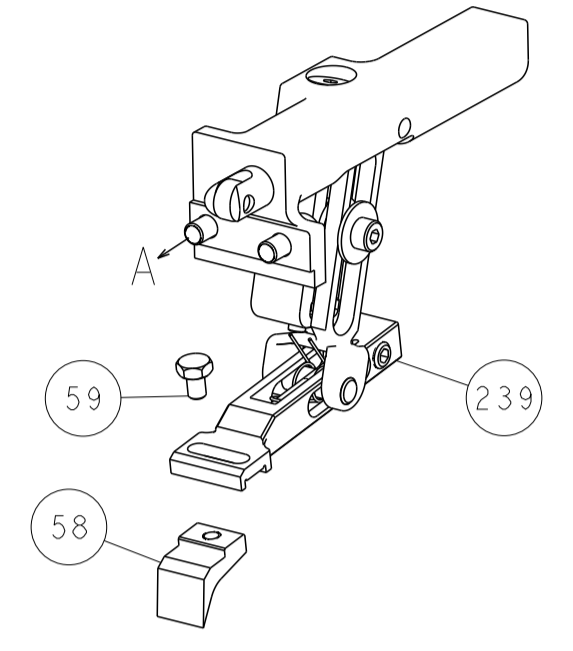
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: L. ZHANG 19MAR2012	TE Connectivity Harrisburg, PA 17105-3608
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		CHK: L. ZHANG 19MAR2012	
MATERIAL: .		FINISH: .		APVD: S. XI 19MAR2012	NAME: Ocean End Feed Applicator
CUSTOMER DRAWING		SCALE: 1:1		WEIGHT: .	RESTRICTED TO: .
				SHEET: 1 OF 4	REV: C

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

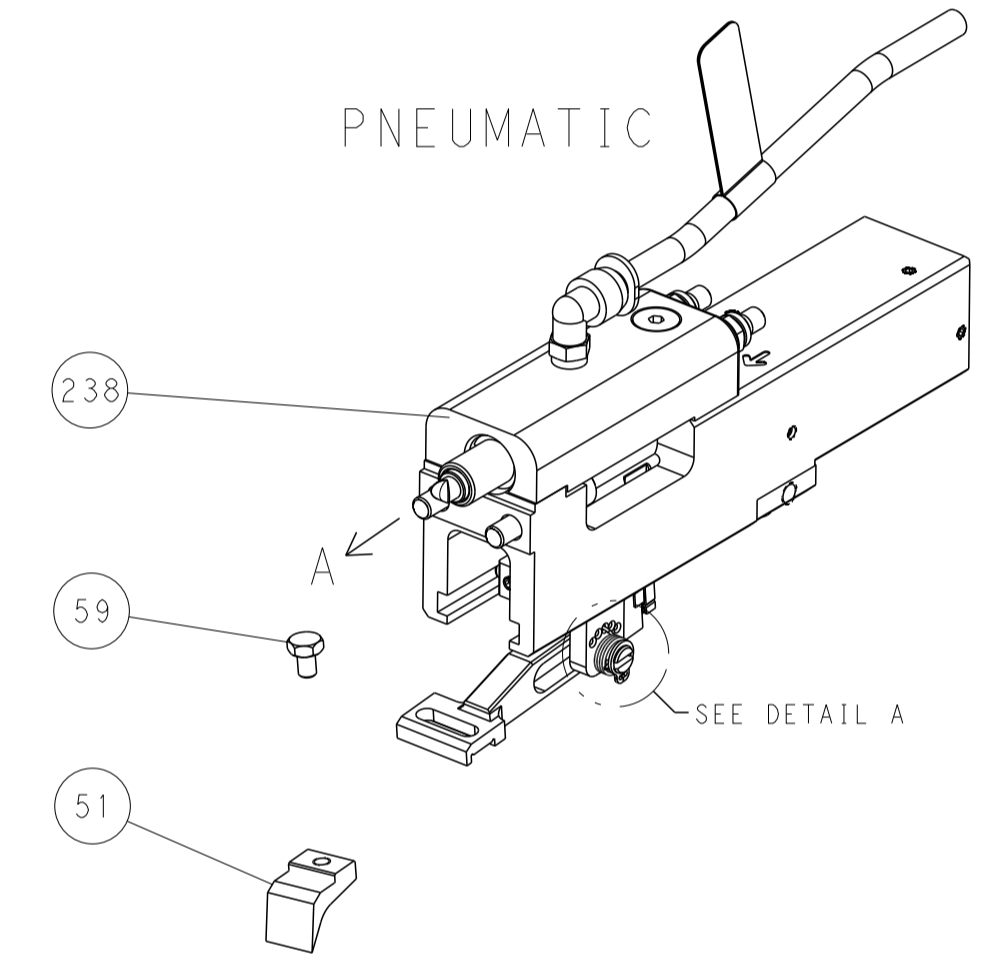


RAM AND HOLDDOWN SET-UP

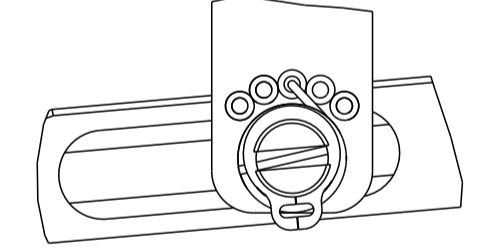
FEED TYPE
MECHANICAL



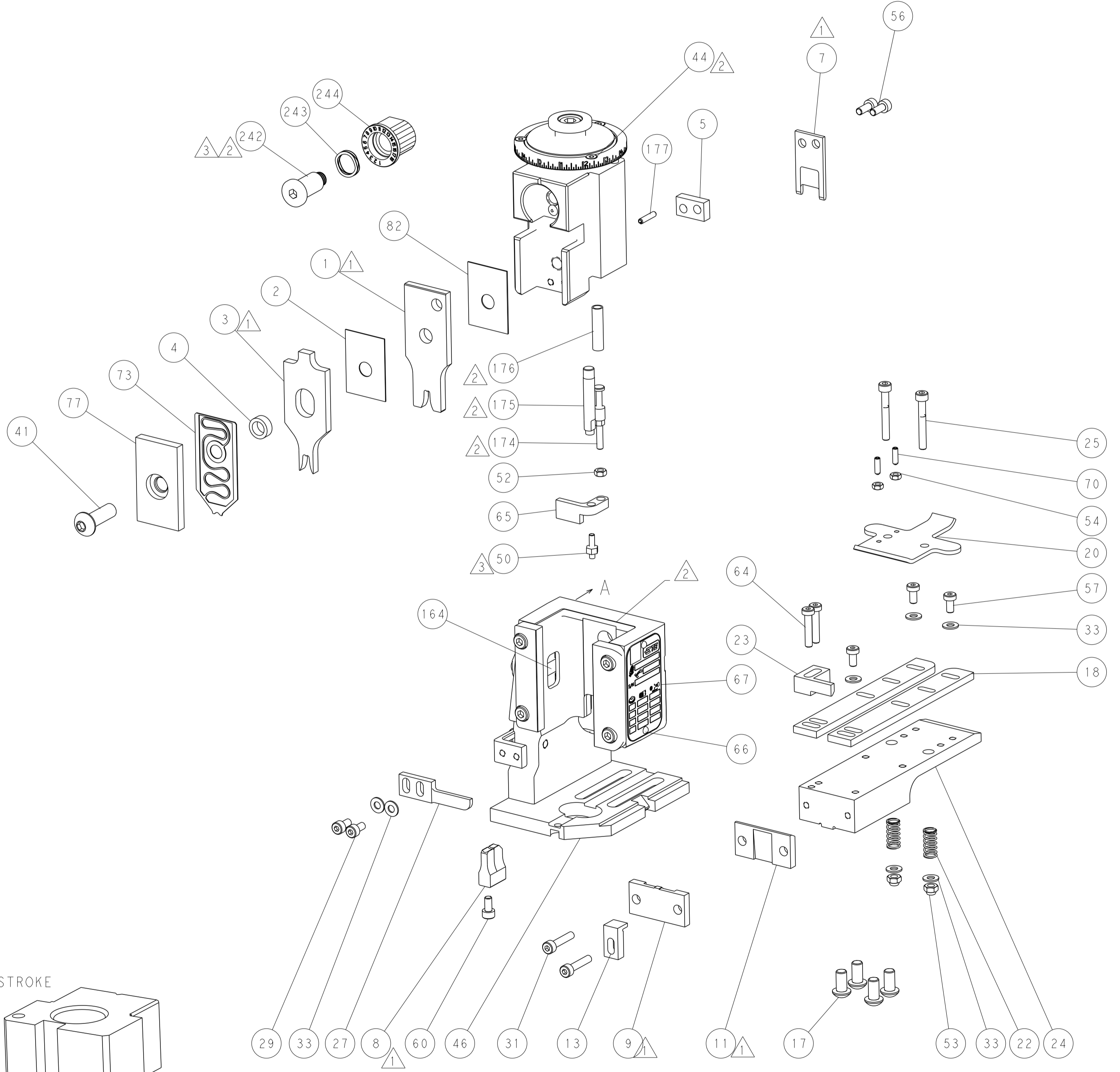
PNEUMATIC



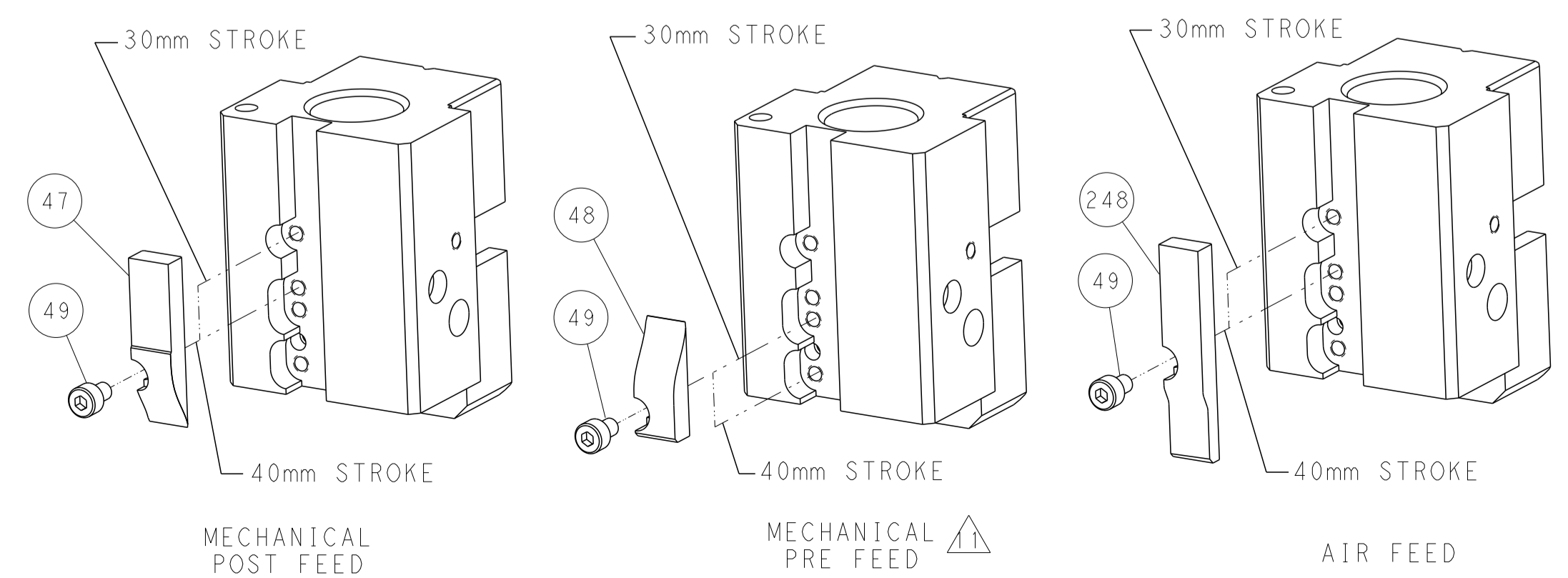
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS

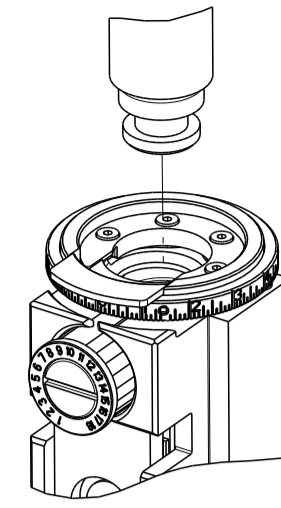


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 19MAR2012		TE Connectivity	
MATERIAL		FINISH		CHK L. ZHANG 19MAR2012		Harrisburg, PA 17105-3608	
				APVD S. XI 19MAR2012		NAME	
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				CUSTOMER DRAWING		A1 00779 C=2150251	
				SCALE		SHEET 2 OF 4 REV C	

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150251-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2150251-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150251-7	A	CRIMP TOOLING KIT	-				

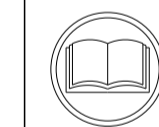
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3mm RECEPTACLE			
WIRE STRIP LENGTH 5.00-5.80 mm [.197-.228 IN]		INSULATION DIAMETER RANGE Ø3.40-4.40 mm [.134-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
1949156-1	RSB 8152 F 6.3-6		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.59 +/- 0.05 [.102 +/- .002]	8.3
△ 1.5+1.5+2.5mm2	2.56 +/- 0.05 [.101 +/- .002]	8.5
2.5+2.5mm2	2.49 +/- 0.05 [.098 +/- .002]	9.2
△ 1.0+1.5+2.5mm2	2.49 +/- 0.05 [.098 +/- .002]	9.2
5.00mm2	2.49 +/- 0.05 [.098 +/- .002]	9.2
4.00mm2	2.29 +/- 0.05 [.090 +/- .002]	11.3
1.5+1.5mm2	2.20 +/- 0.05 [.087 +/- .002]	12.0
3.00mm2	2.20 +/- 0.05 [.087 +/- .002]	12.0



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- △ 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.
- △ THREE WIRE COMBINATION NOT 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.

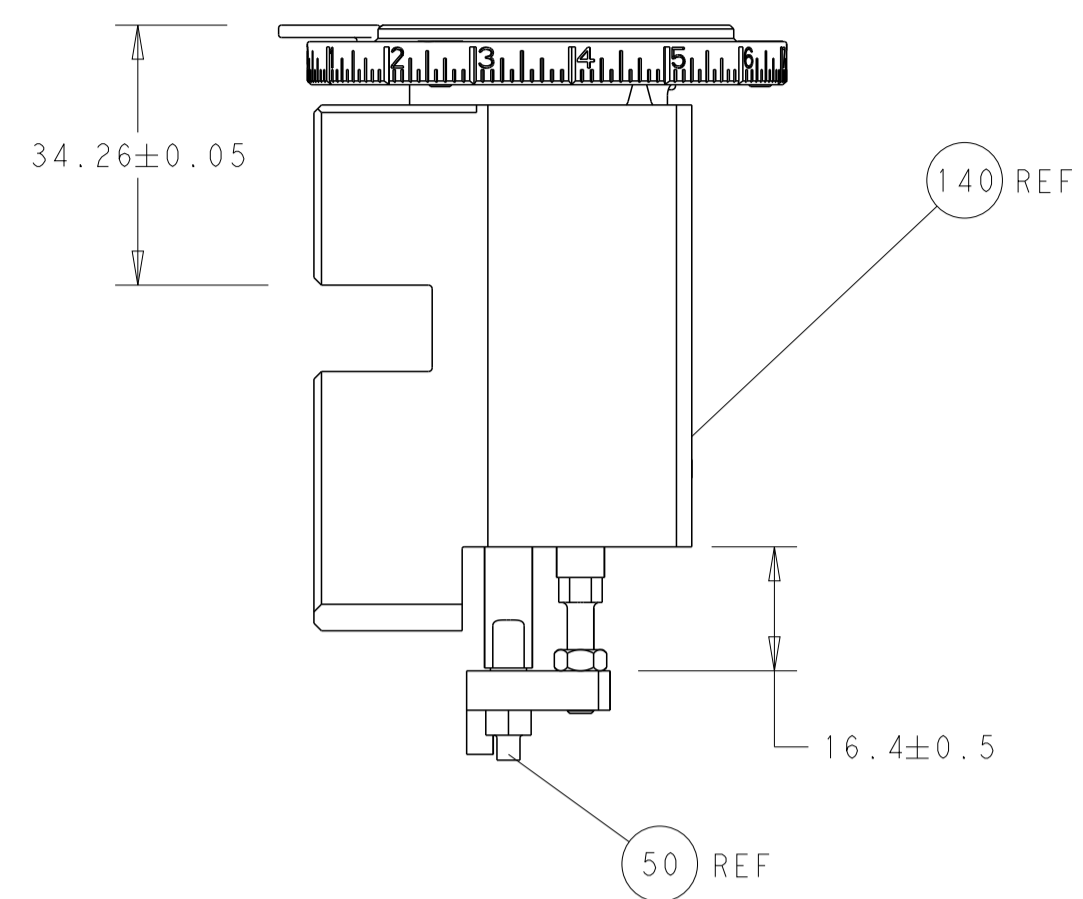
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	2119791-9	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	2168400-5	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	1-1976055-1	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	240825-4	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	240833-3	PLATE, REAR SHEAR	11	
△	-	1	1	2-690495-6	PLATE, FRONT SHEAR	9
△	1	1	1	1633383-7	ANVIL, COMBINATION	8
△	-	1	1	2-690474-8	BLADE, SLUG	7
-	1	1	1-240641-8	SPACER	5	
-	1	1	1-238011-2	BLOCK, CRIMPER SPACER	4	
△	1	1	1	3-1633961-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-4	SPACER, CRIMPER	2
△	1	1	1	456415-6	CRIMPER, WIRE .155 F PREMIUM	1
-	77	22	21	PART NO	ITEM NO	

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

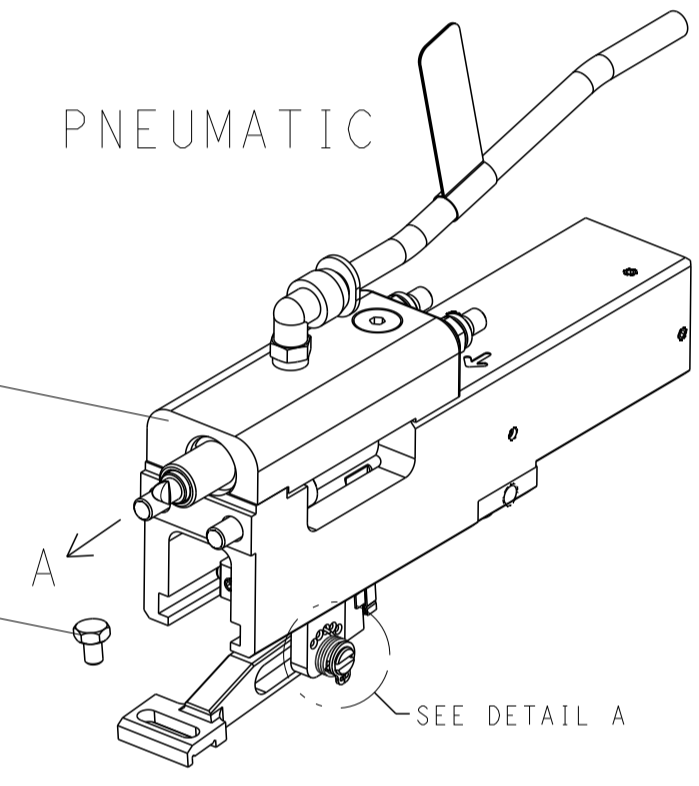
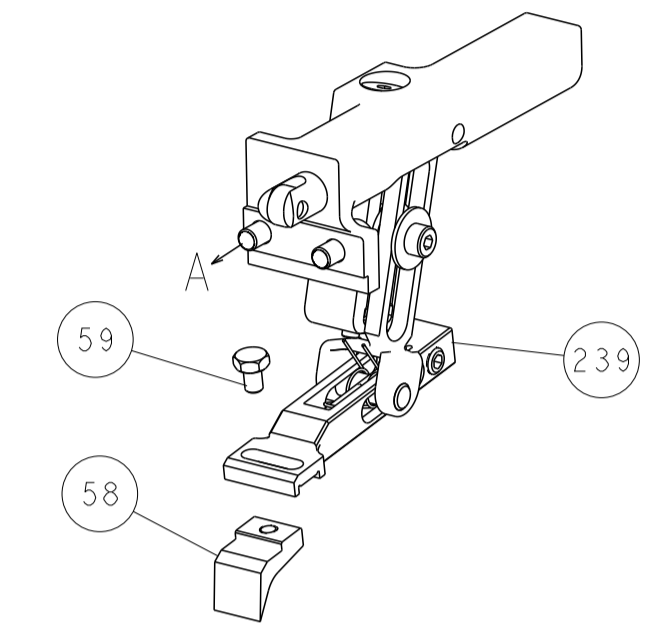
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20		DWG L. ZHANG 19MAR2012		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 19MAR2012		NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 19MAR2012		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
0 PLC ±		PRODUCT SPEC		A1 00779 C=2150251	
1 PLC ±		APPLICATION SPEC		WEIGHT	
2 PLC ±		SCALE 1:1		SHEET 3 OF 4	
3 PLC ±		CUSTOMER DRAWING		REV C	
4 PLC ±					
ANGLES FINISH					

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

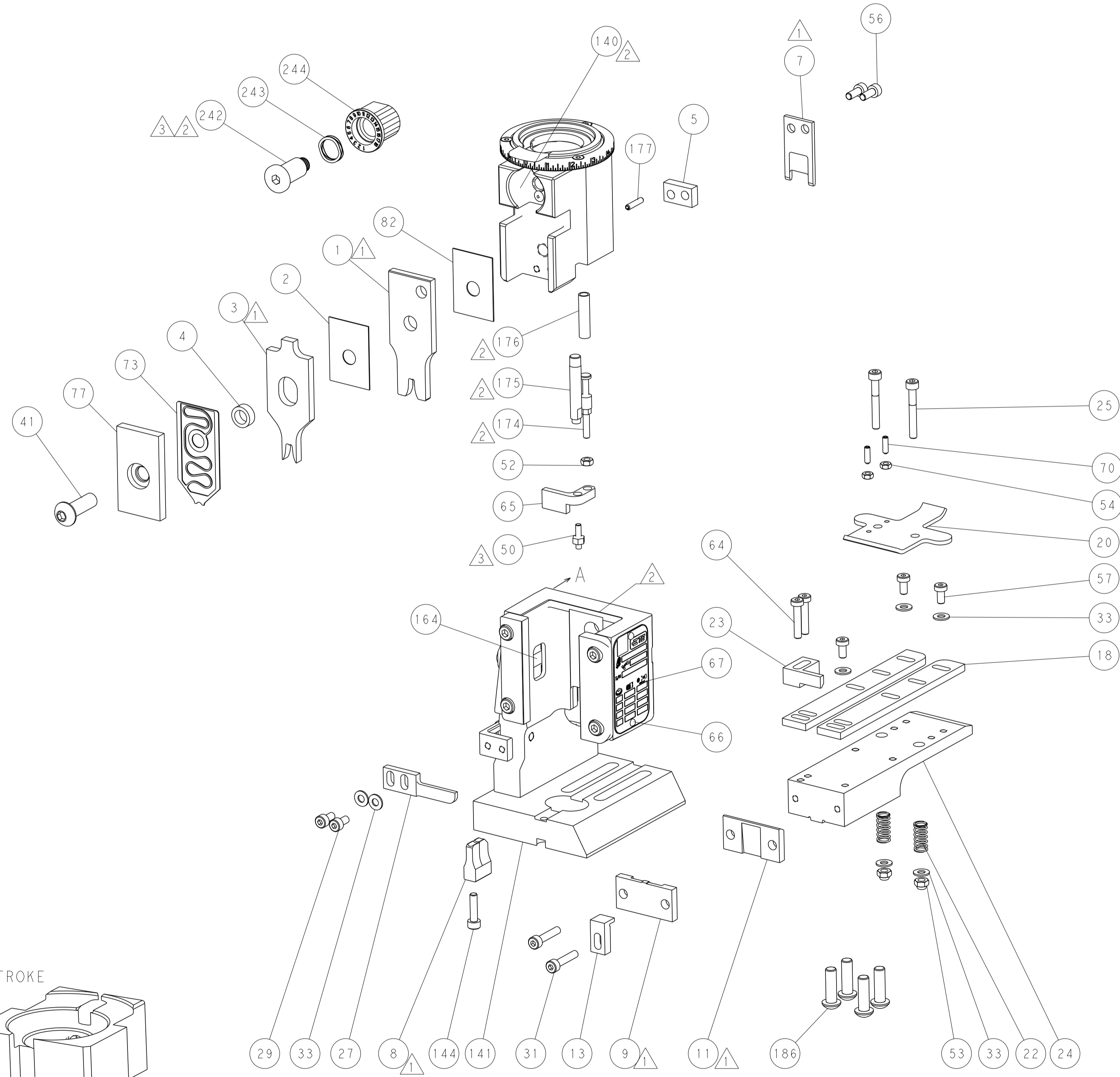
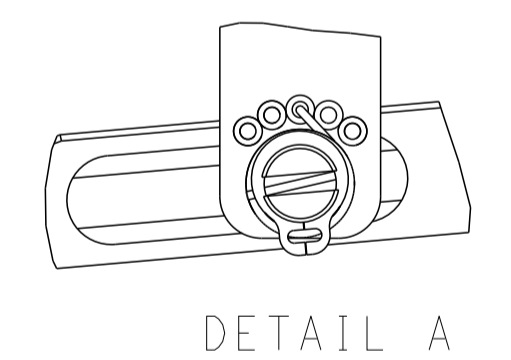


RAM AND HOLDDOWN SET-UP

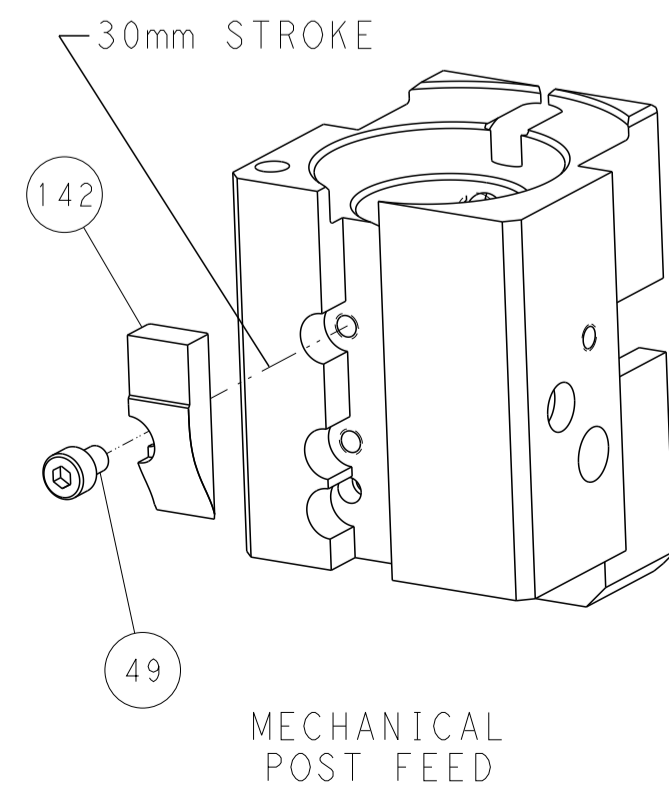
FEED TYPE
MECHANICAL



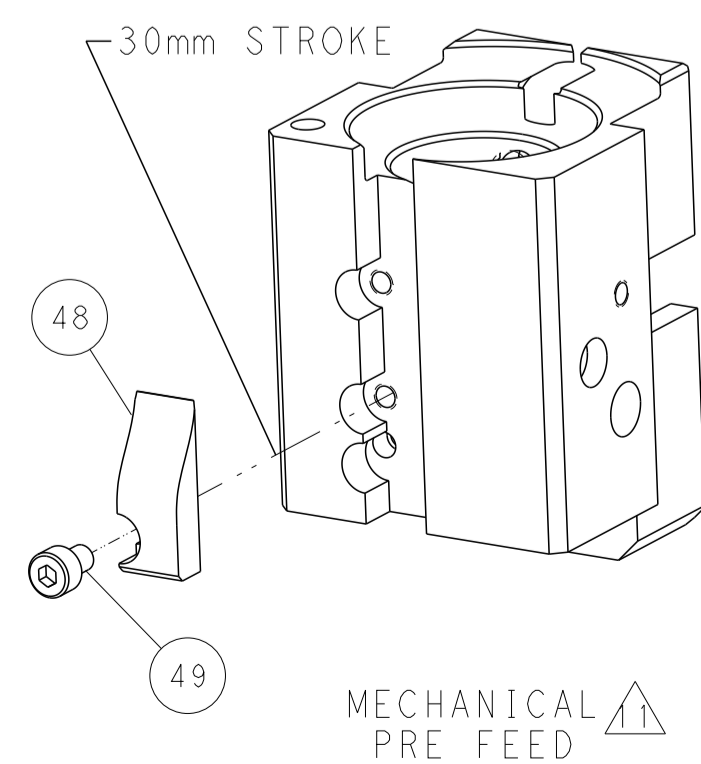
FEED SPRING
SETTING POSITION



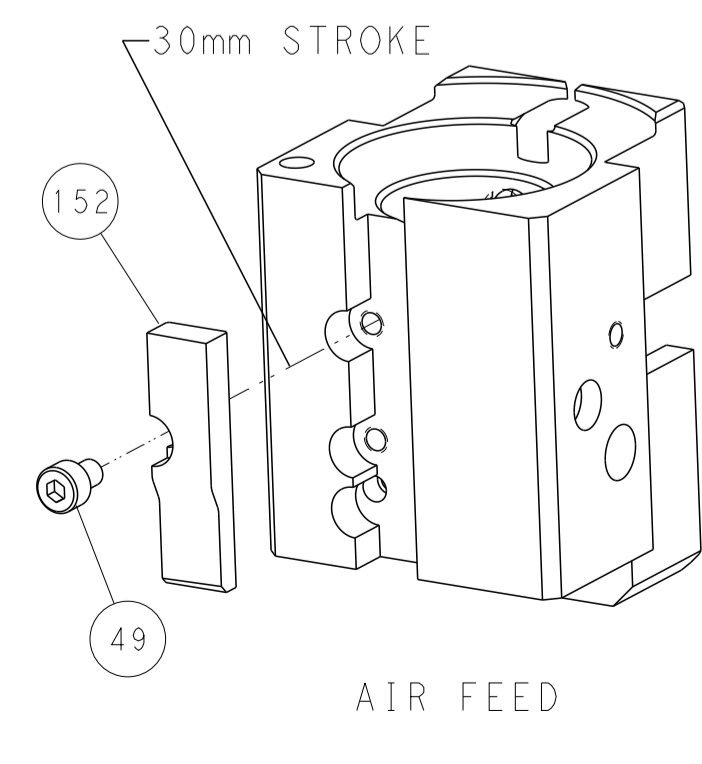
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 L. ZHANG 19MAR2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	CUSTOMER DRAWING:	SCALE:	SHEET:	OF:	REV:
				1:1	4	4	C