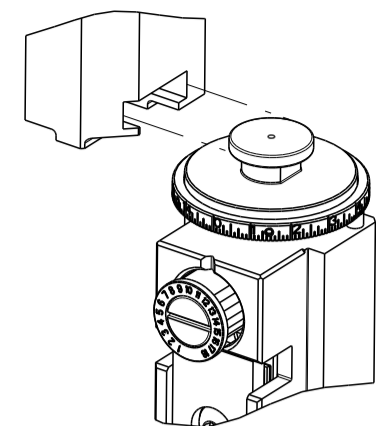


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150040-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150040-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150040-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 POSITIVE REC EX MK-2			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.50 mm [.217-.256 IN]		∅1.50-3.10 mm [.059-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5119	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
175020-1	175020-2	179973-1	179973-6
2232957-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm <sup>2</sup>	1.61+/-0.05 [.063+/-0.002]	5.3
20 AWG OR 0.50mm <sup>2</sup>	1.47+/-0.05 [.058+/-0.002]	6.8
22 AWG OR 0.30mm <sup>2</sup>	1.41+/-0.05 [.056+/-0.002]	7.5

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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
		B		ECR-18-003478	07MAR2018	FL	JD
		C		ECR-18-014381	11SEP2018	FL	KZ
		C1		ECR-19-008929	06JUN2019	FZ	TB
		D		ECR-19-012168	01AUG2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1-1752354-1	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	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	2119943-1	WASHER, SPACER	69
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	1	2063961-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	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	2-1752371-7	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	2-240641-9	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	-	1	690482-4	PLATE, FRONT SHEAR	9
	1	2	1333216-4	ANVIL, COMBINATION	8
	-	1	1-2217206-0	BLADE, SLUG	7
-	1	1	5-240641-2	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	1-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
	1	2	1-456405-5	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

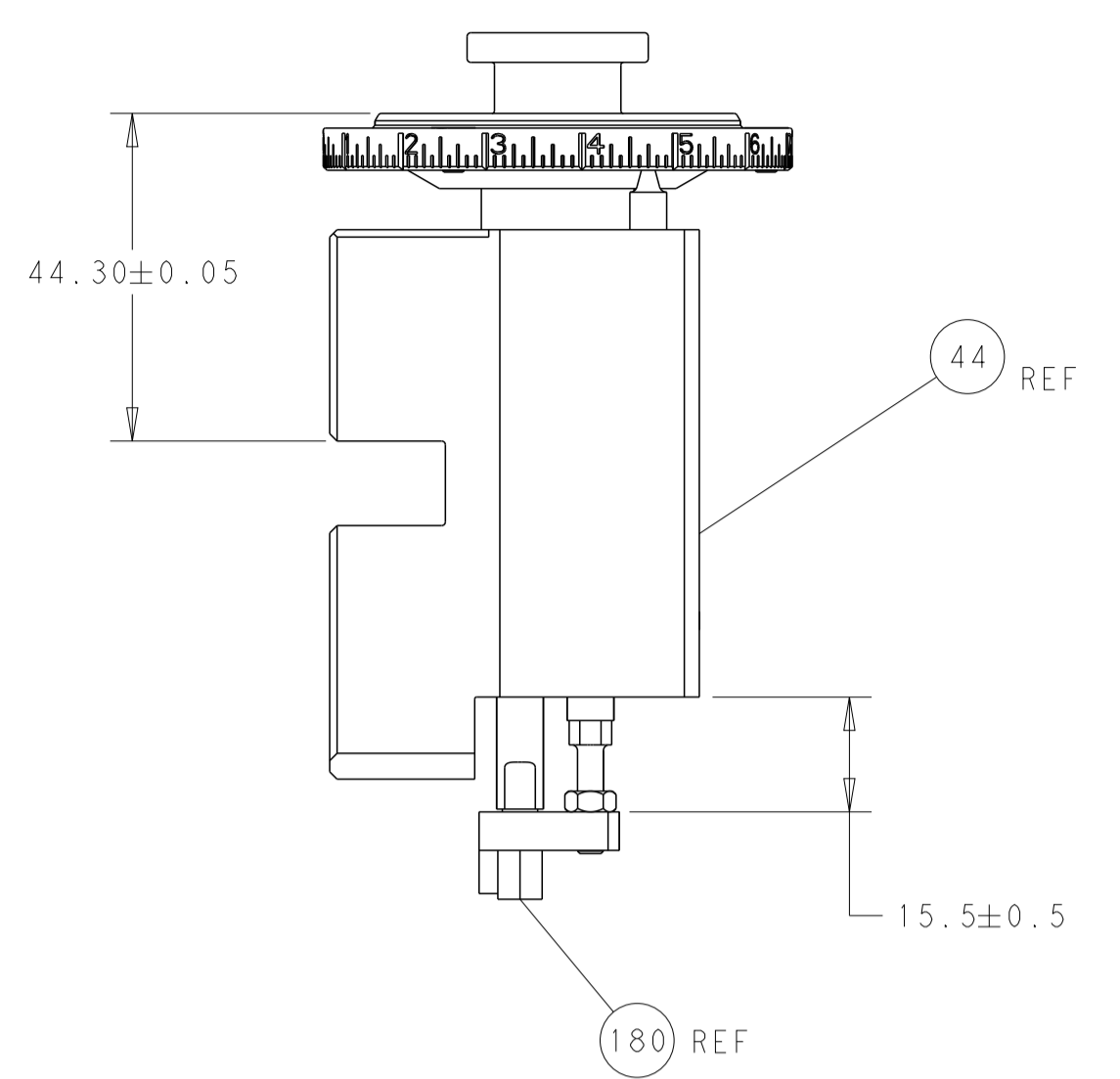
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL		WEIGHT		SCALE	1:1	SHEET	1 OF 4

**STE** TE Connectivity  
Harrisburg, PA 17105-3608

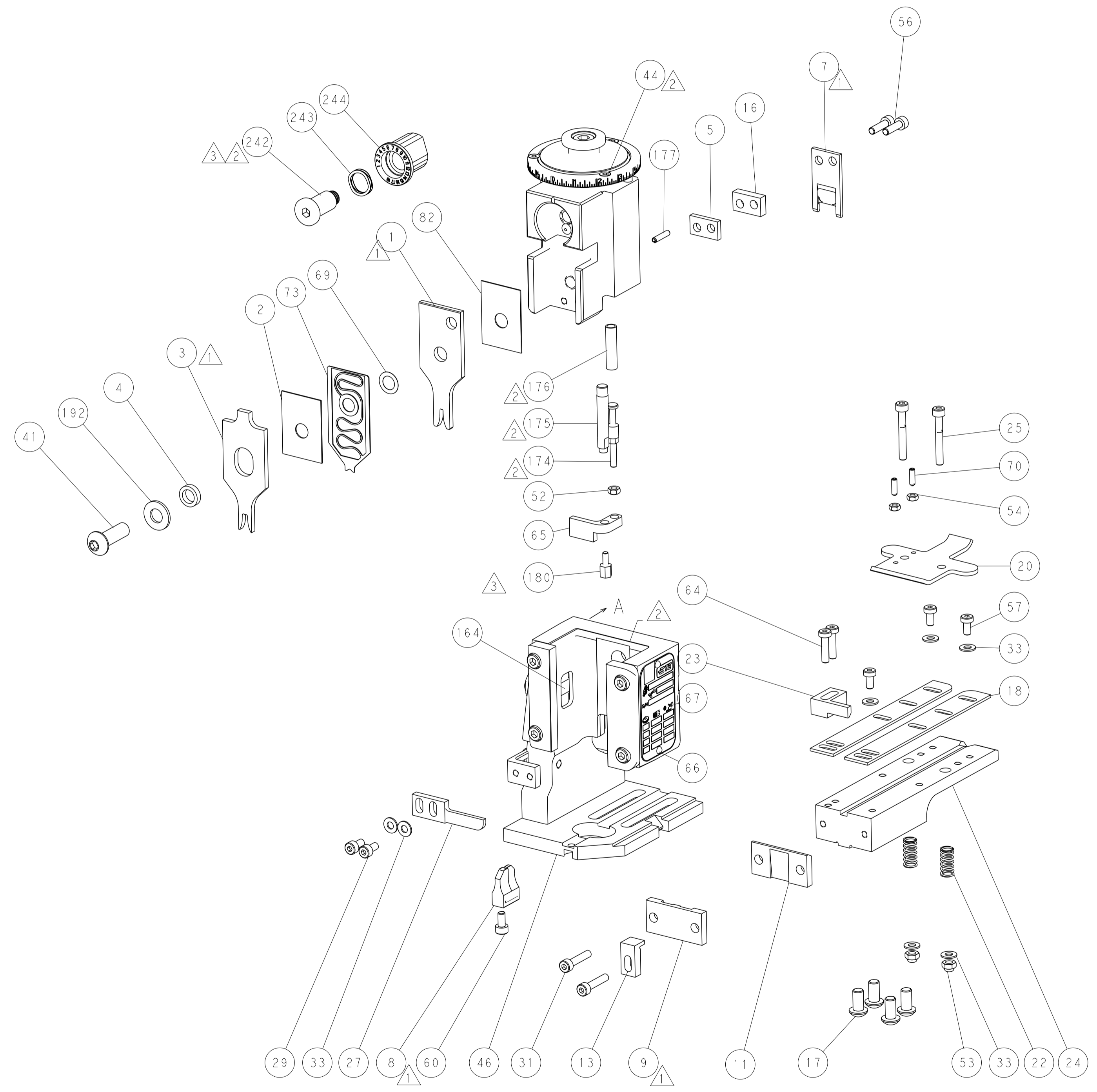
**Ocean End Feed Applicator**

Customer Accessible Production Drawing

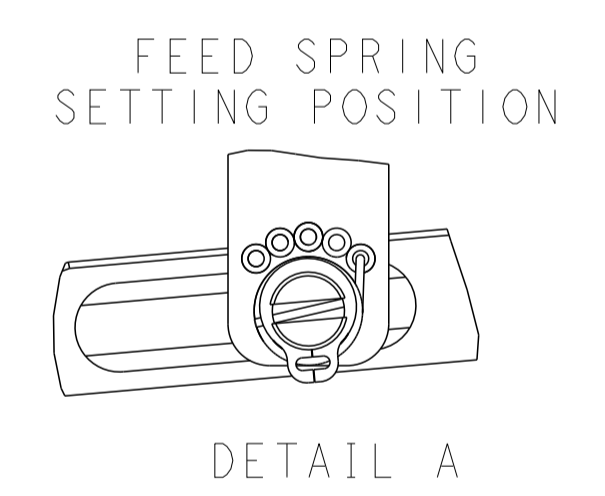
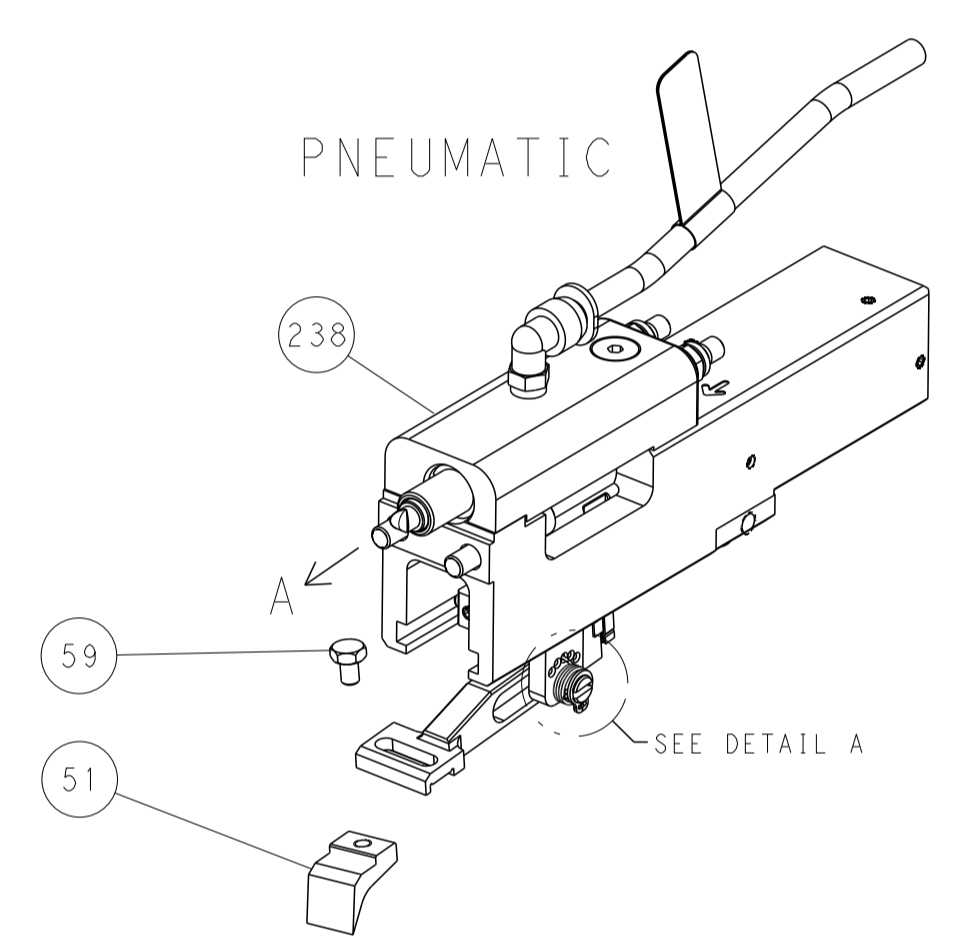
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-



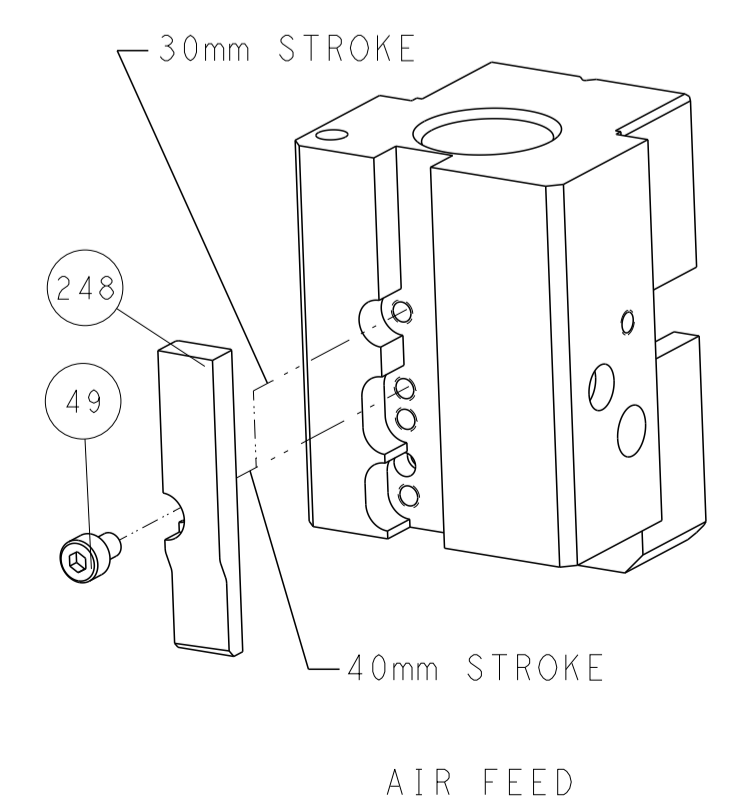
RAM AND HOLDDOWN SET-UP



FEED TYPE



CAM POSITIONS

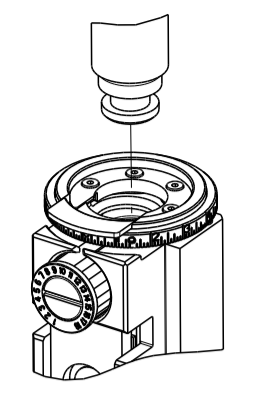


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DMN	11JAN2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	11JAN2012	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	11JAN2012	NAME
	MATERIAL	FINISH	WEIGHT	I. CRUZ PRODUCT SPEC APPLICATION SPEC		SIZE
				A1 00779 ©=2150040		CAGE CODE
				Customer Accessible Production Drawing		DRAWING NO
				SCALE 1:1		RESTRICTED TO
				SHEET 2 OF 4		REV D

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150040-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150040-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.56 mm (.140)	F

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 250 POSITIVE REC EX MK-2

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.50-6.50 mm (.217-.256 IN)	1.50-3.10 mm (.059-.122 IN)

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
175020-1	175020-2	179973-1	179973-6
2232957-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.61+/-0.05 [.063+/-0.002]	5.3
20 AWG OR 0.50mm2	1.47+/-0.05 [.058+/-0.002]	6.8
22 AWG OR 0.30mm2	1.41+/-0.05 [.056+/-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 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	REV	DATE	BY	APPV
A	66	-			

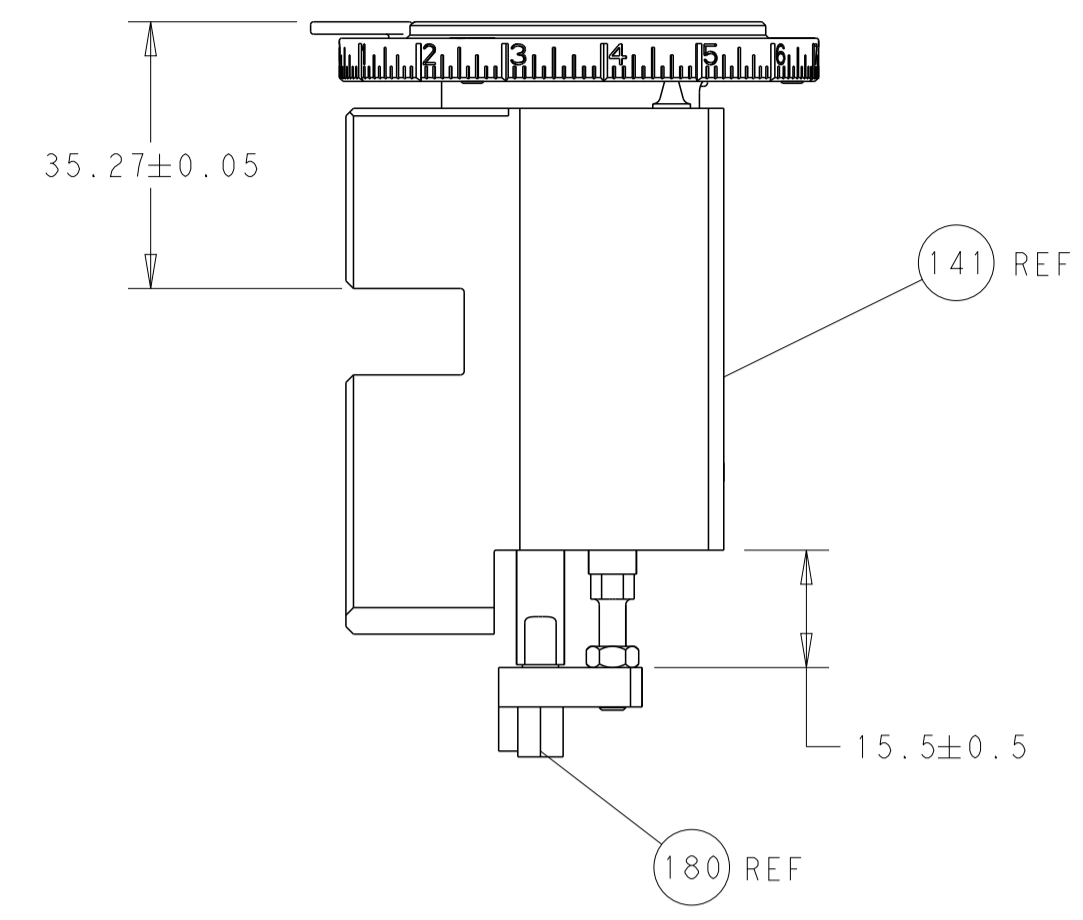
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-3			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	1-1752354-1			180
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	455888-5			82
-	1	2119791-5			73
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119943-1			69
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-1			65
-	2	2168400-8			64
-	1	5-18022-5			59
-	3	2168400-4			57
-	2	2-2168083-5			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-1			51
-	1	18023-9			49
-	1	1803602-1			41
-	7	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	240639-1			27
-	2	1-2168083-5			25
-	1	2-1752371-7			24
-	1	240825-1			23
-	2	2-22281-3			22
-	1	1803292-4			20
-	2	1901259-3			18
-	1	2-240641-9			16
-	1	1752360-1			13
-	1	240833-1			11
-	-	-			10
-	1	690482-4			9
1	1	1333216-4			8
-	1	1-2217206-0			7
-	1	5-240641-2			5
-	1	238011-2			4
1	1	2-1633961-3			3
-	1	455888-5			2
1	1	1-456405-5			1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	11JAN2012	R. HUANG	
		11JAN2012	S. XI	
		11JAN2012	J. CRUZ	

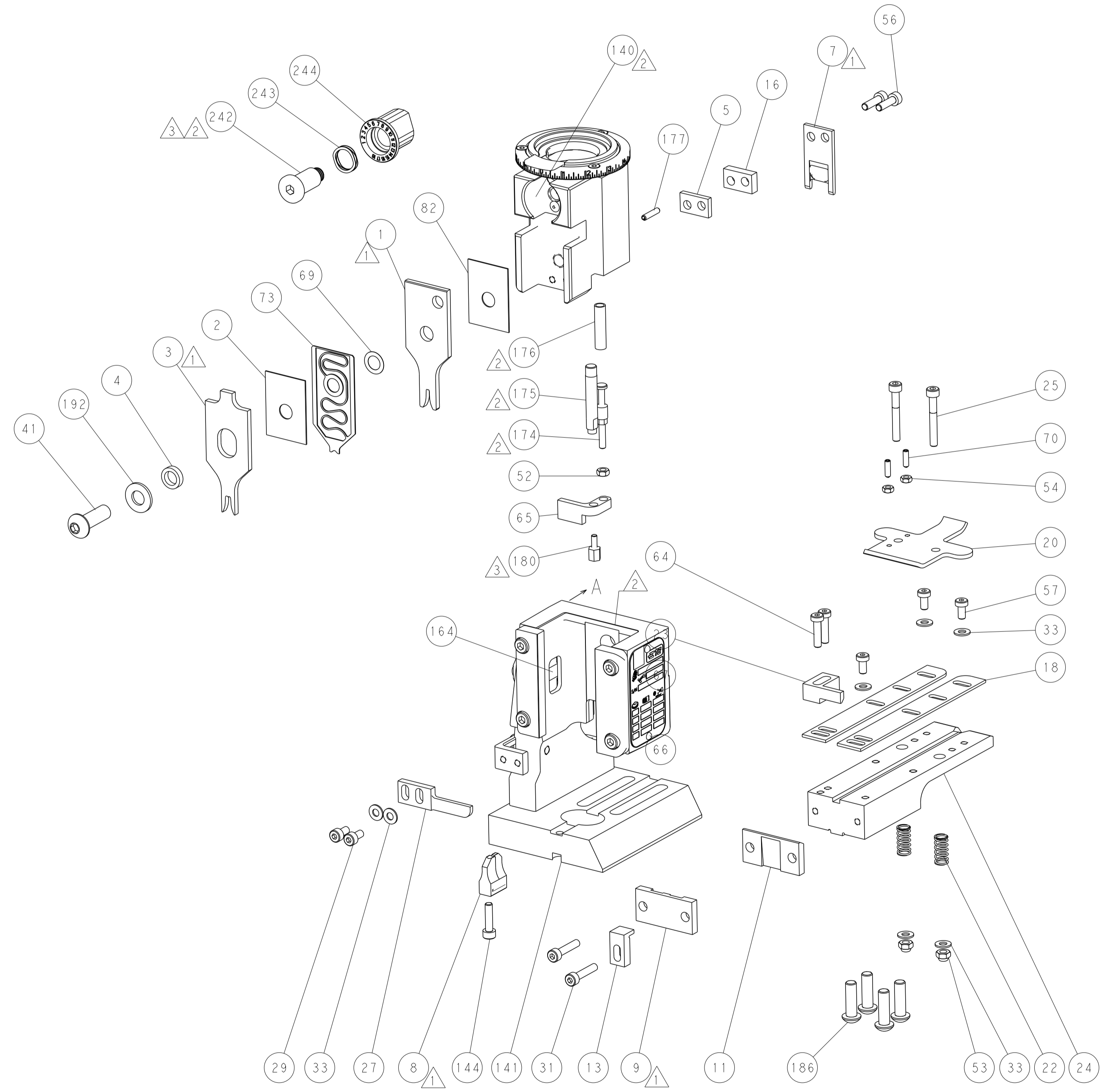
ITEM NO	PART NO	DESCRIPTION
-77-22		

Customer Accessible Production Drawing	SCALE 1:1	SHEET 3 OF 4	REV D
--	-----------	--------------	-------

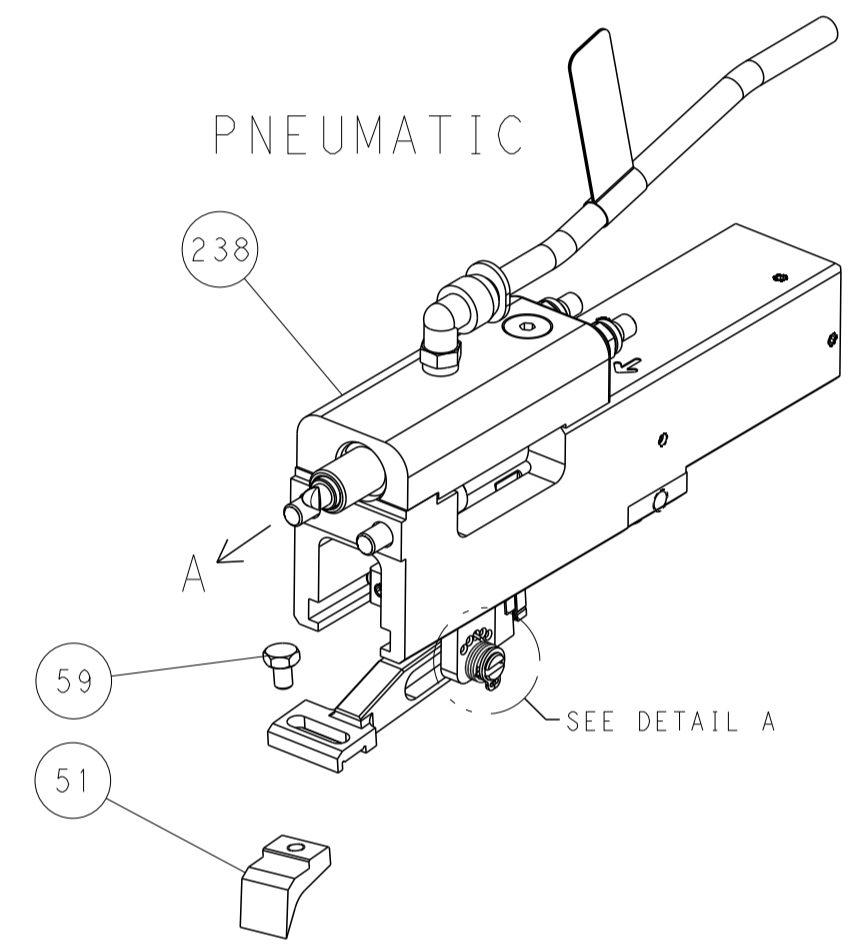
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



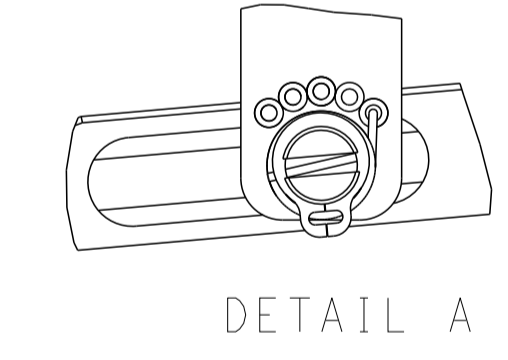
RAM AND HOLDDOWN SET-UP



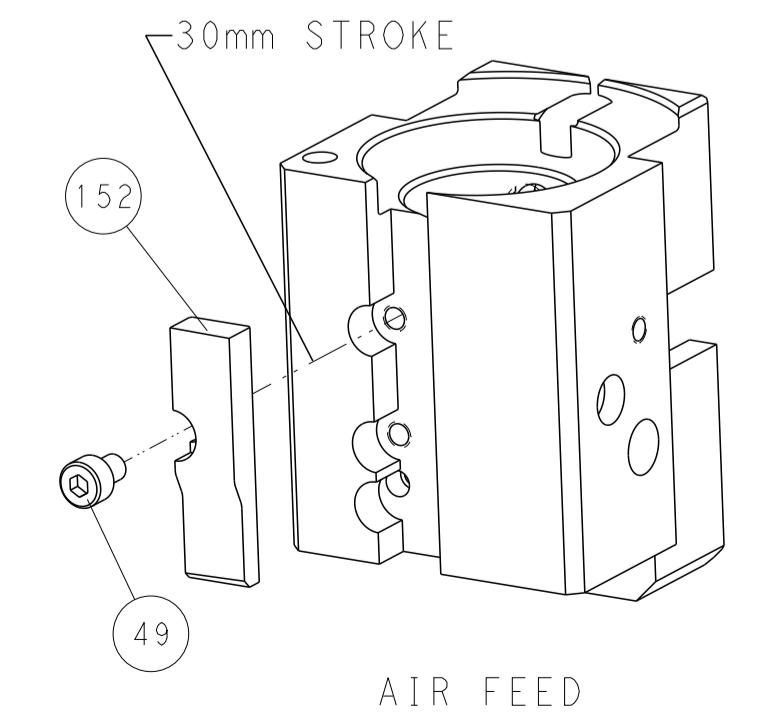
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 11JAN2012 CHK: S. XI 11JAN2012 APVD: J. CRUZ 11JAN2012	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 Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150040 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 4 OF 4 REV: D	Customer Accessible Production Drawing