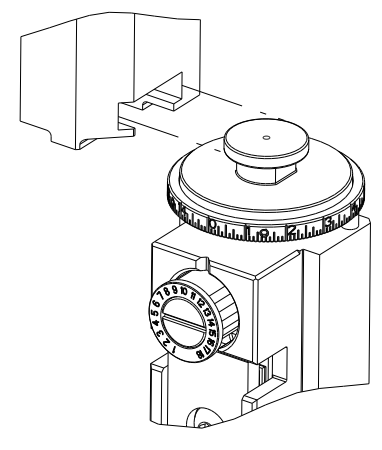


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150237-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150237-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150237-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150237-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150237-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	5.33 mm [.210]	O

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.30-5.70 mm [.209-.224 IN]	Ø3.81-5.08 mm [.150-.200 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42437-2	41450-1	61095-4	63435-2
42437-5	41450-2	63365-1	1742399-1
42437-6	41450-3	63365-2	41450
41449-1	1-41450-1	63412-1	
41449-3	61095-1	63435-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.92 +/- 0.05 [.115 +/- .002]	2.8
4.00mm2	2.59 +/- 0.05 [.102 +/- .002]	6.6
3.50mm2	2.46 +/- 0.05 [.097 +/- .002]	8.3
12 AWG	2.41 +/- 0.05 [.095 +/- .002]	8.1
3.00mm2	2.34 +/- 0.05 [.092 +/- .002]	9.1
2.50mm2	2.21 +/- 0.05 [.087 +/- .002]	10.1
2.25mm2	2.16 +/- 0.05 [.085 +/- .002]	10.9
14 AWG	2.11 +/- 0.05 [.083 +/- .002]	11.7

- 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.
- 10 AWG WIRE TO BE 9600 CMA MAX.
- 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.

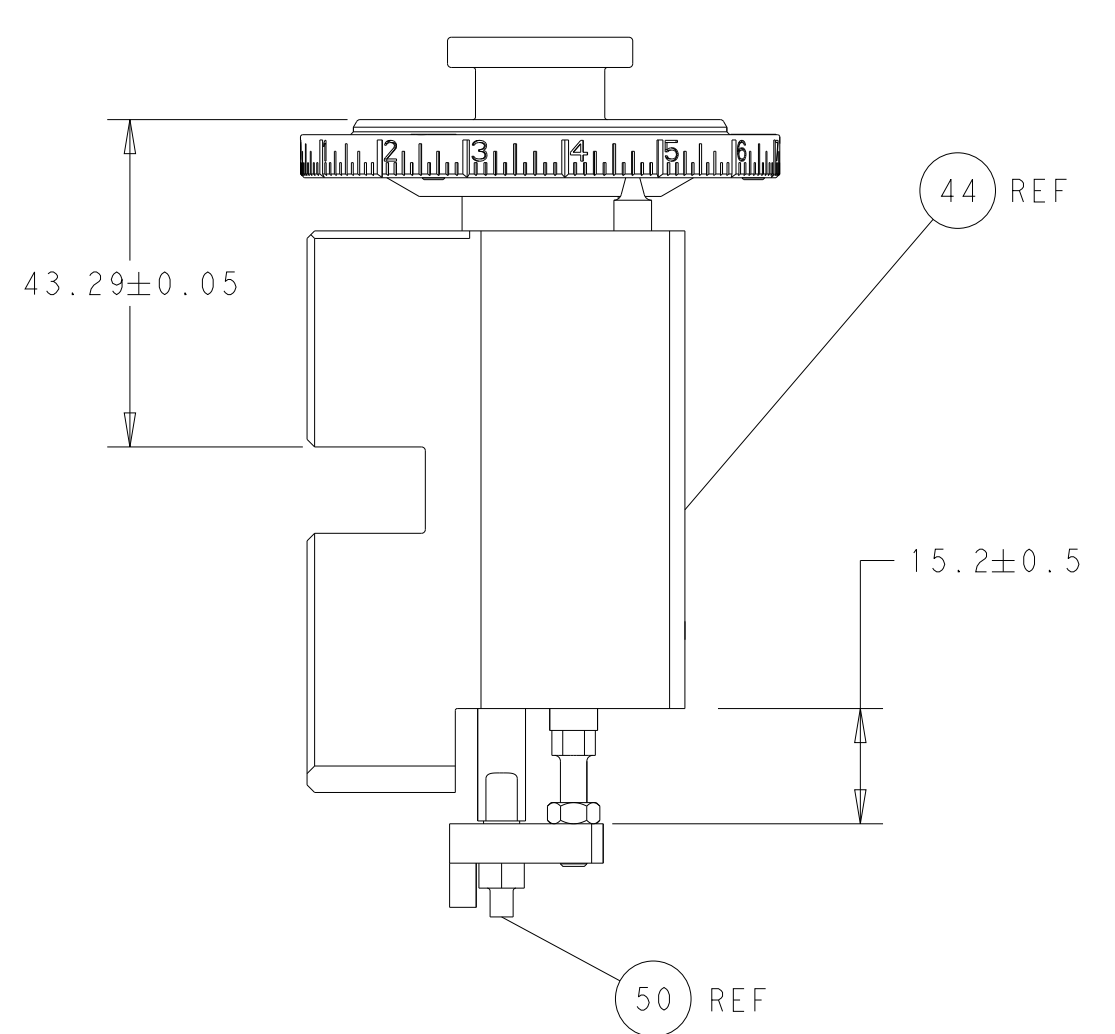
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-14-007760	23MAY2014	JH	TE
		D		ECR-18-014675	16SEP2018	TB	TE
		E		ECR-19-008970	06JUN2019	LG	TE
		E1		ECR-21-002987	09MAR2021	FZ	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	-	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	2119791-6	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	2119943-1	WASHER, SPACER	69
-	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	1	1	1	1-1976055-3	STANDOFF, HOLD-DOWN	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	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	1901259-6	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	690482-6	PLATE, FRONT SHEAR	9
-	1	2	2	1	1-1333221-7	ANVIL, EF .130	8
-	1	1	1	1	2217206-5	BLADE, SLUG	7
-	1	1	1	1	7-240641-1	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	2	2	1	456410-4	CRIMPER, WIRE PREMIUM	1

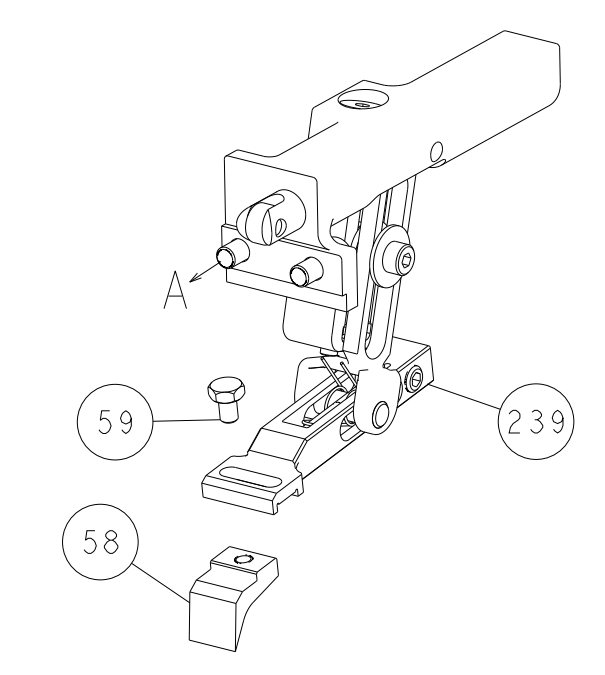
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				

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

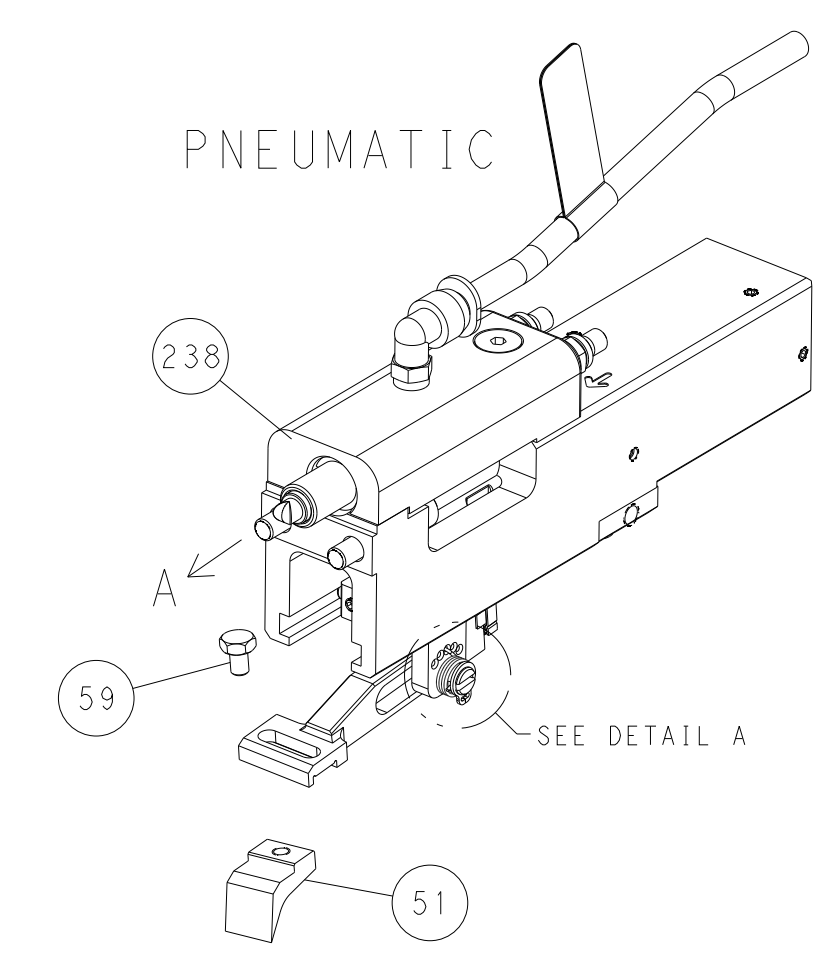


RAM AND HOLDDOWN SET-UP

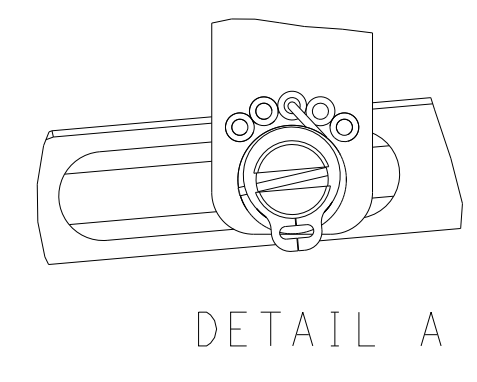
FEED TYPE  
MECHANICAL



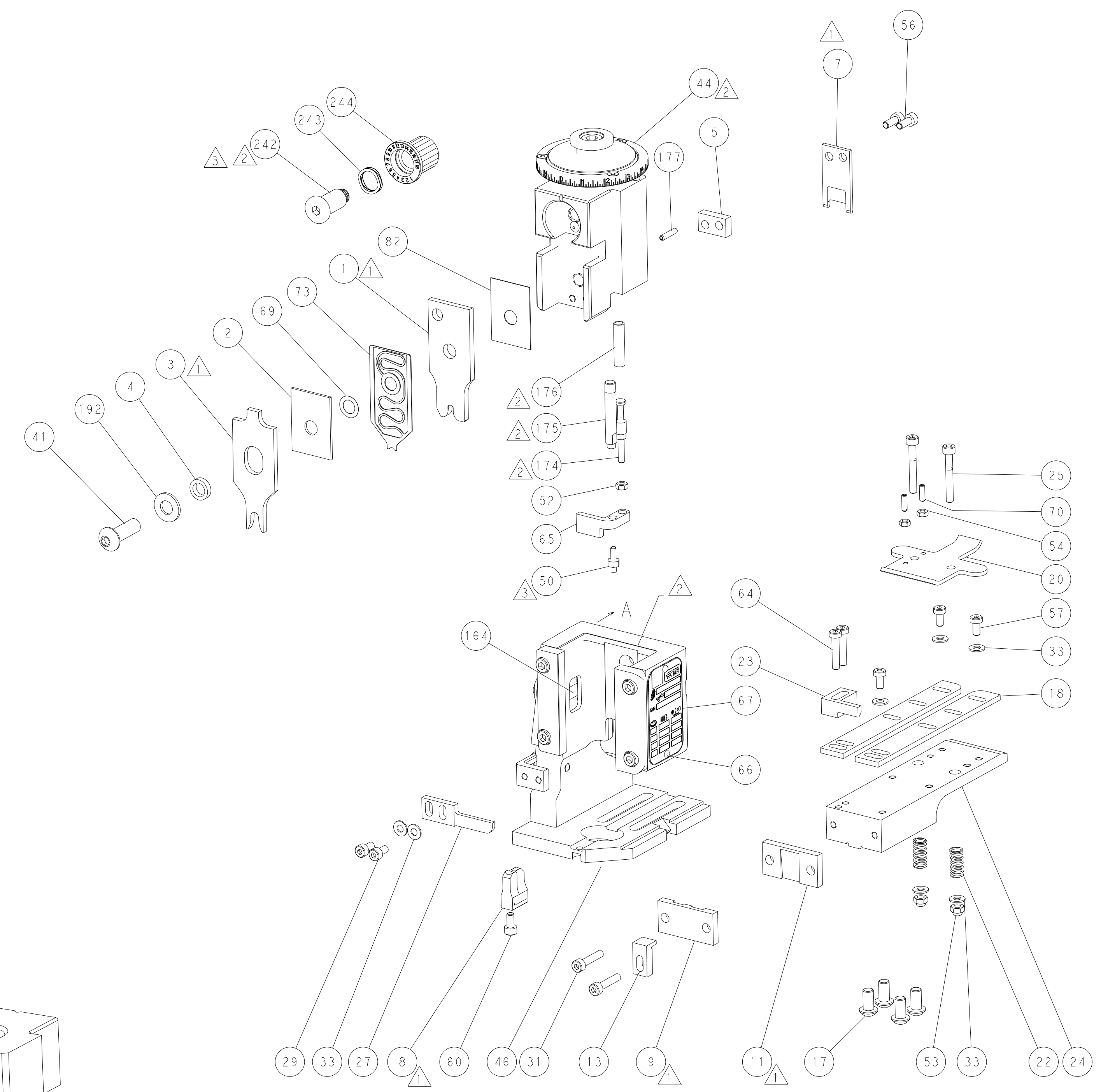
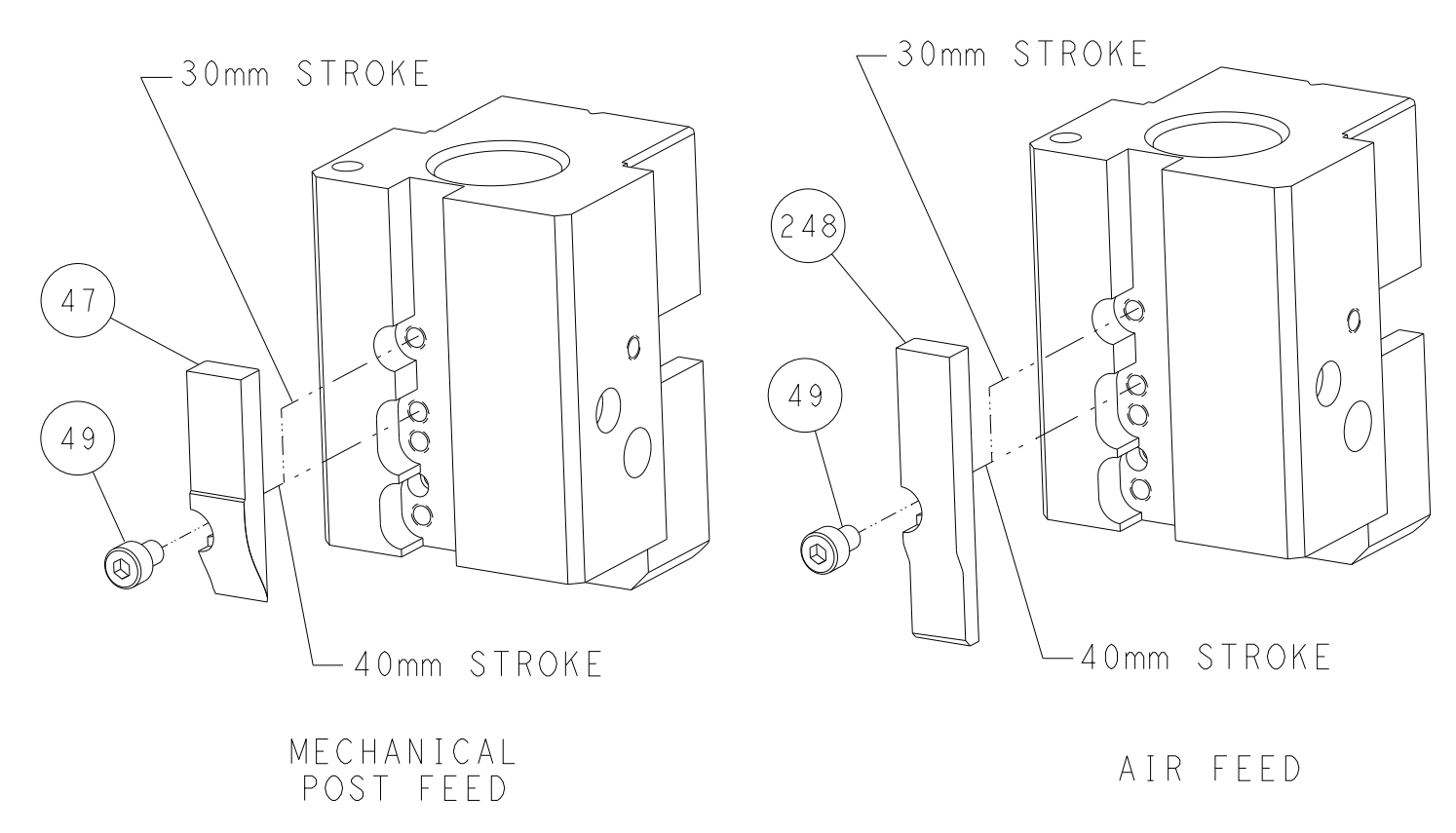
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

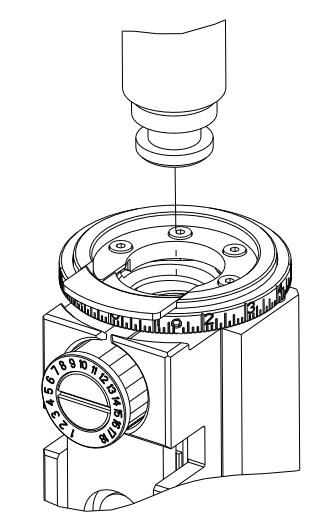


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN B. WEAVER 23NOV2011 CHK C. MOYER 23NOV2011 APVD G. BAILEY 23NOV2011		NAME OCEAN END FEED APPLICATOR	
MATERIAL:		WEIGHT:		SIZE CAGE CODE DRAWING NO A1 00779 C=2150237		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 OF 4 REV E1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150237-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150237-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150237-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [ .130 ]	F
INSUL	5.33 mm [ .210 ]	Ø

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.30-5.70 mm [ .209-.224 IN ]	Ø3.81-5.08 mm [ .150-.200 IN ]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42437-2	41450-1	61095-4	63435-2
42437-5	41450-2	63365-1	1742399-1
42437-6	41450-3	63365-2	41450
41449-1	1-41450-1	63412-1	
41449-3	61095-1	63435-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.92 +/- 0.05 [ .115 +/- .002 ]	2.8
4.00mm2	2.59 +/- 0.05 [ .102 +/- .002 ]	6.6
3.50mm2	2.46 +/- 0.05 [ .097 +/- .002 ]	8.3
12 AWG	2.41 +/- 0.05 [ .095 +/- .002 ]	8.1
3.00mm2	2.34 +/- 0.05 [ .092 +/- .002 ]	9.1
2.50mm2	2.21 +/- 0.05 [ .087 +/- .002 ]	10.1
2.25mm2	2.16 +/- 0.05 [ .085 +/- .002 ]	10.9
14 AWG	2.11 +/- 0.05 [ .083 +/- .002 ]	11.7

- 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.
- 10 AWG WIRE TO BE 9600 CMA MAX.
- 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.

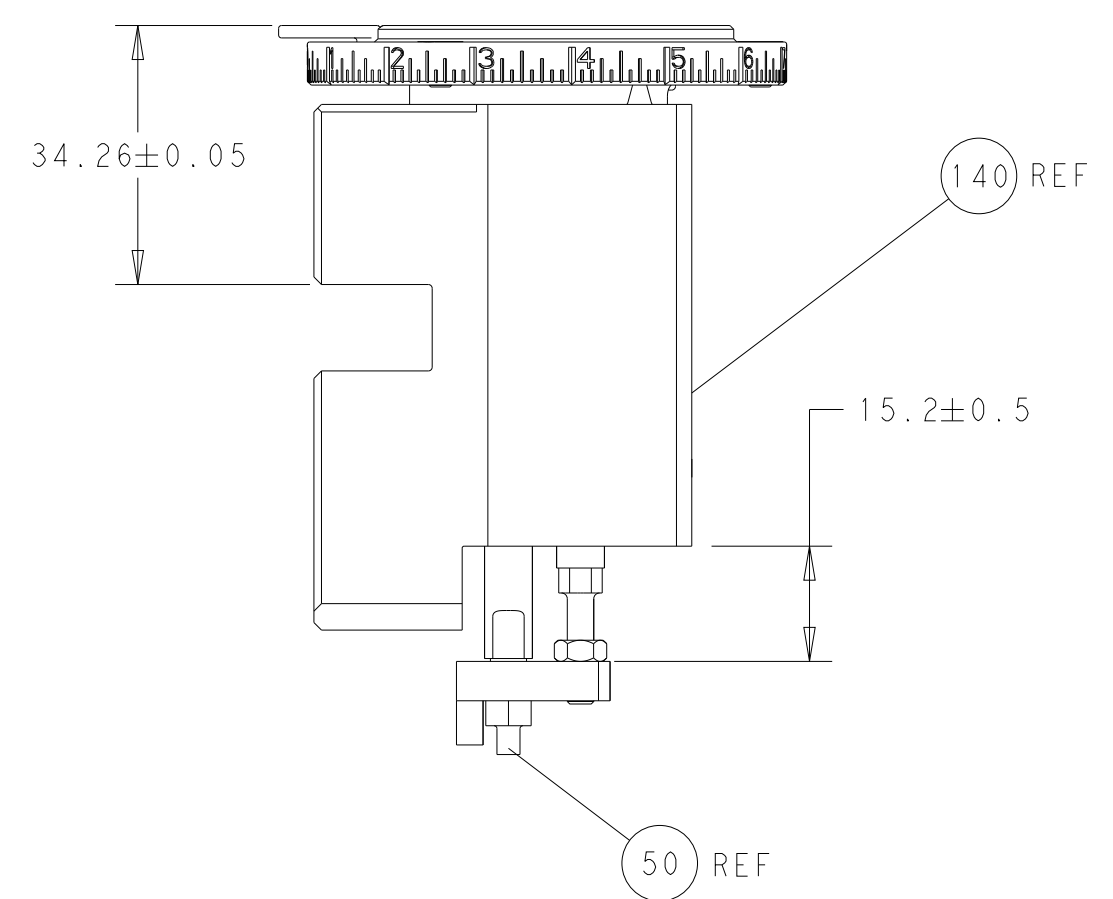
LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPD
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-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	-	2119580-1			239
-	1	2844940-3			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	-	2119653-2			142
-	1	2119655-6			141
-	1	1803518-1			140
-	1	455888-4			82
-	1	2119791-6			73
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119943-1			69
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-5			65
-	2	2168400-5			64
-	1	5-18022-5			59
-	-	2063961-1			58
-	3	2168400-4			57
-	2	1-2168083-0			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-1			51
-	1	1-1976055-3			50
-	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	1752371-5			24
-	1	240825-2			23
-	2	2-22281-3			22
-	1	1803292-4			20
-	2	1901259-6			18
-	1	1752360-1			13
-	1	240644-9			11
-	-	-			10
-	1	690482-6			9
1	1	1-1333221-7			8
-	1	2217206-5			7
-	1	7-240641-1			5
-	1	238011-2			4
1	1	1-2119784-7			3
-	1	1-455888-2			2
1	1	456410-4			1
-	77-22-21	PART NO			ITEM NO
		DESCRIPTION			

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

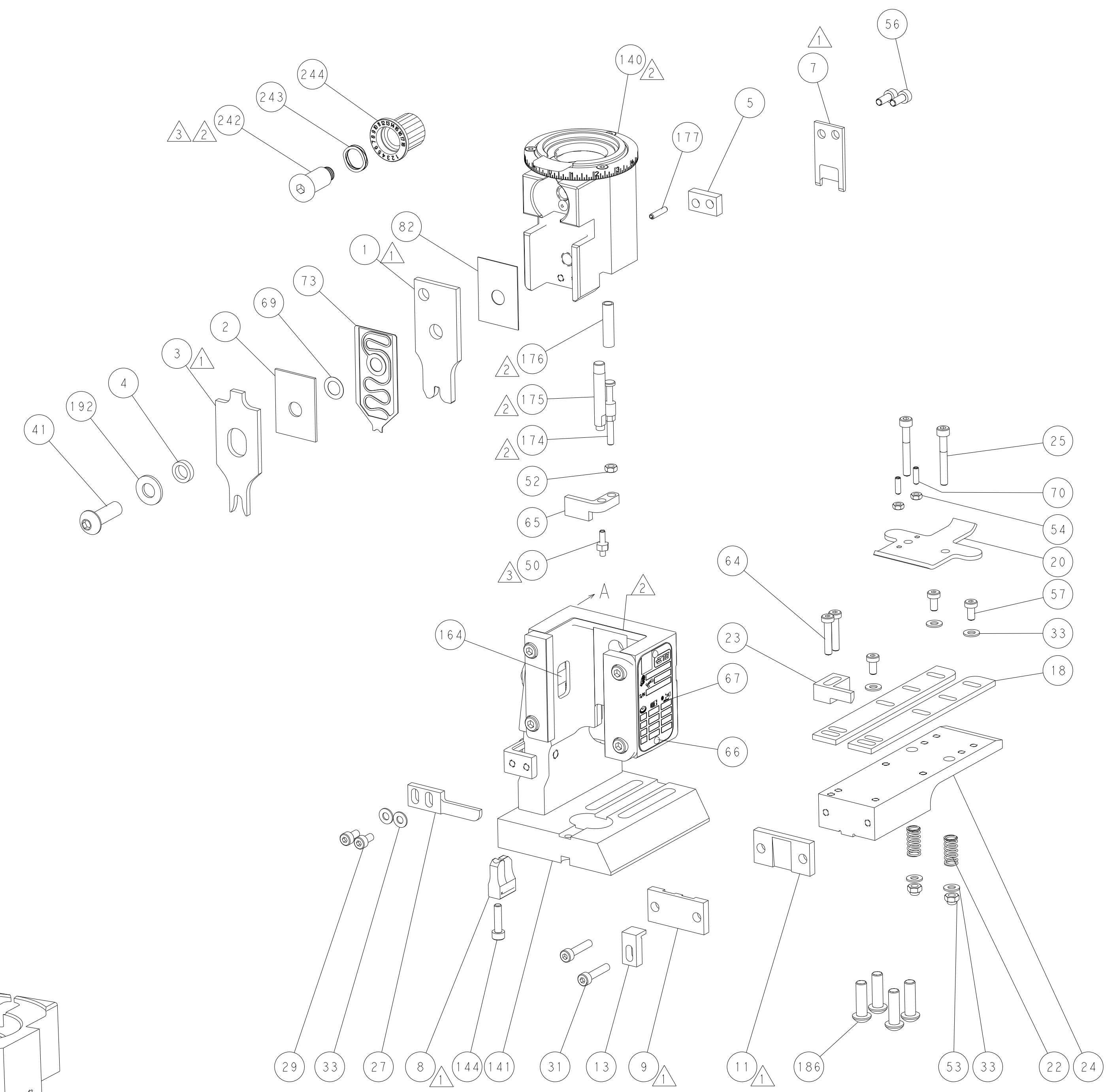
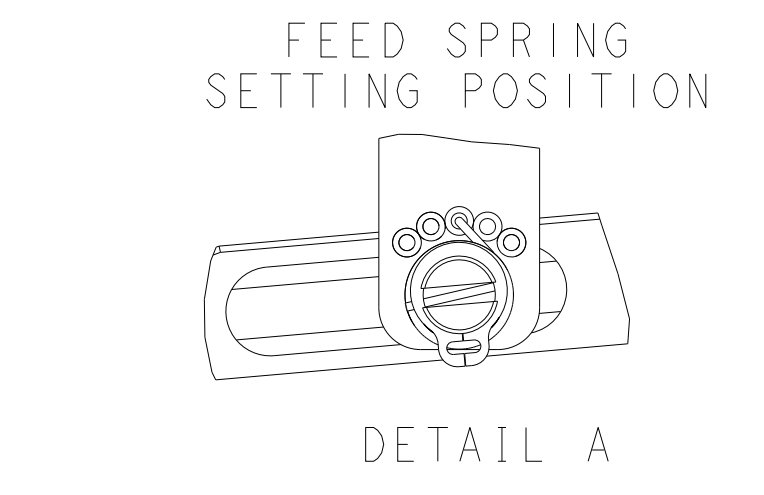
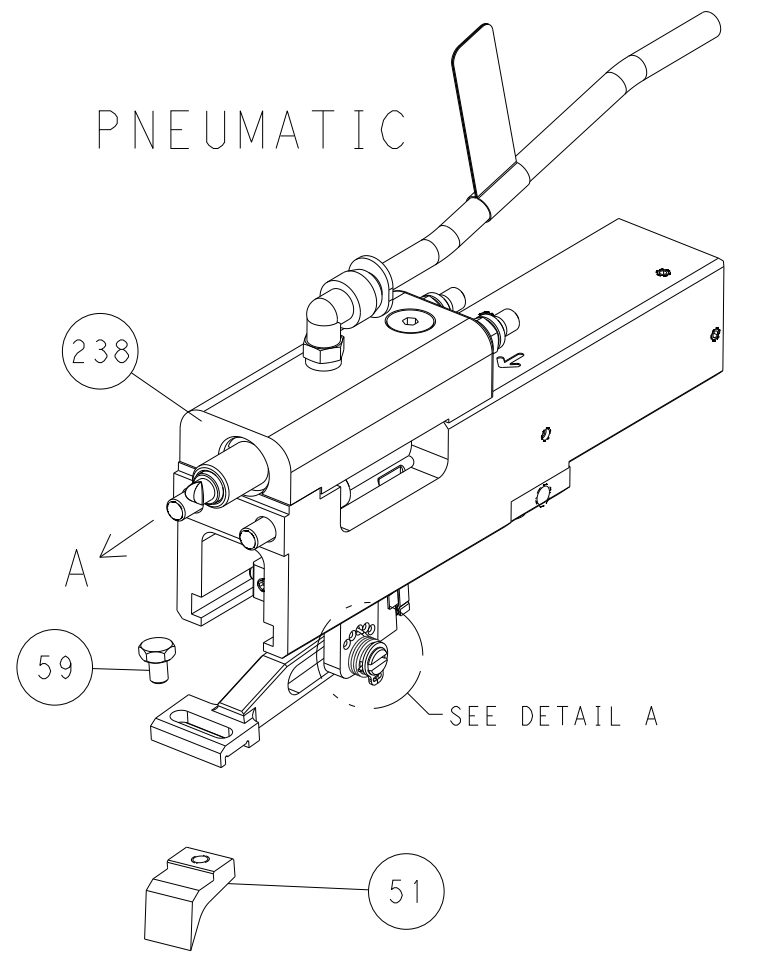
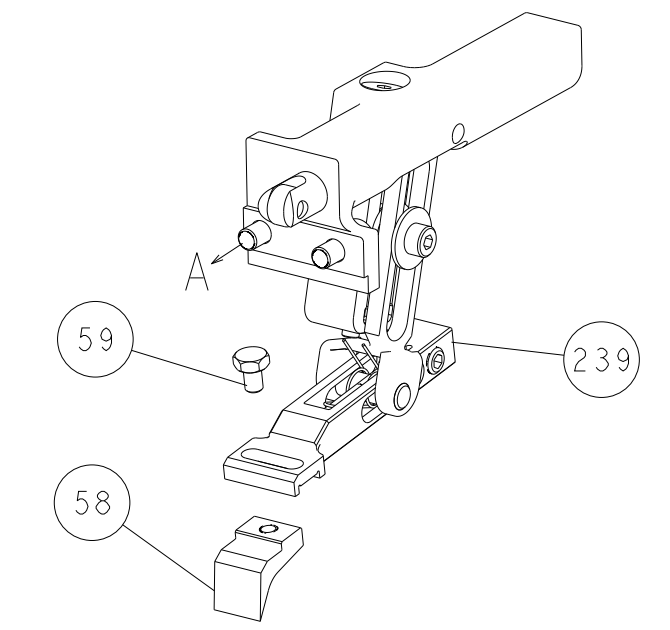
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: B. WEAVER 23NOV2011 CHK: C. MOYER 23NOV2011 APD: G. BAILEY 23NOV2011 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		NAME: OCEAN END FEED APPLICATOR SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150237 SCALE: 1:1 SHEET: 3 OF 4 REV: E1	
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

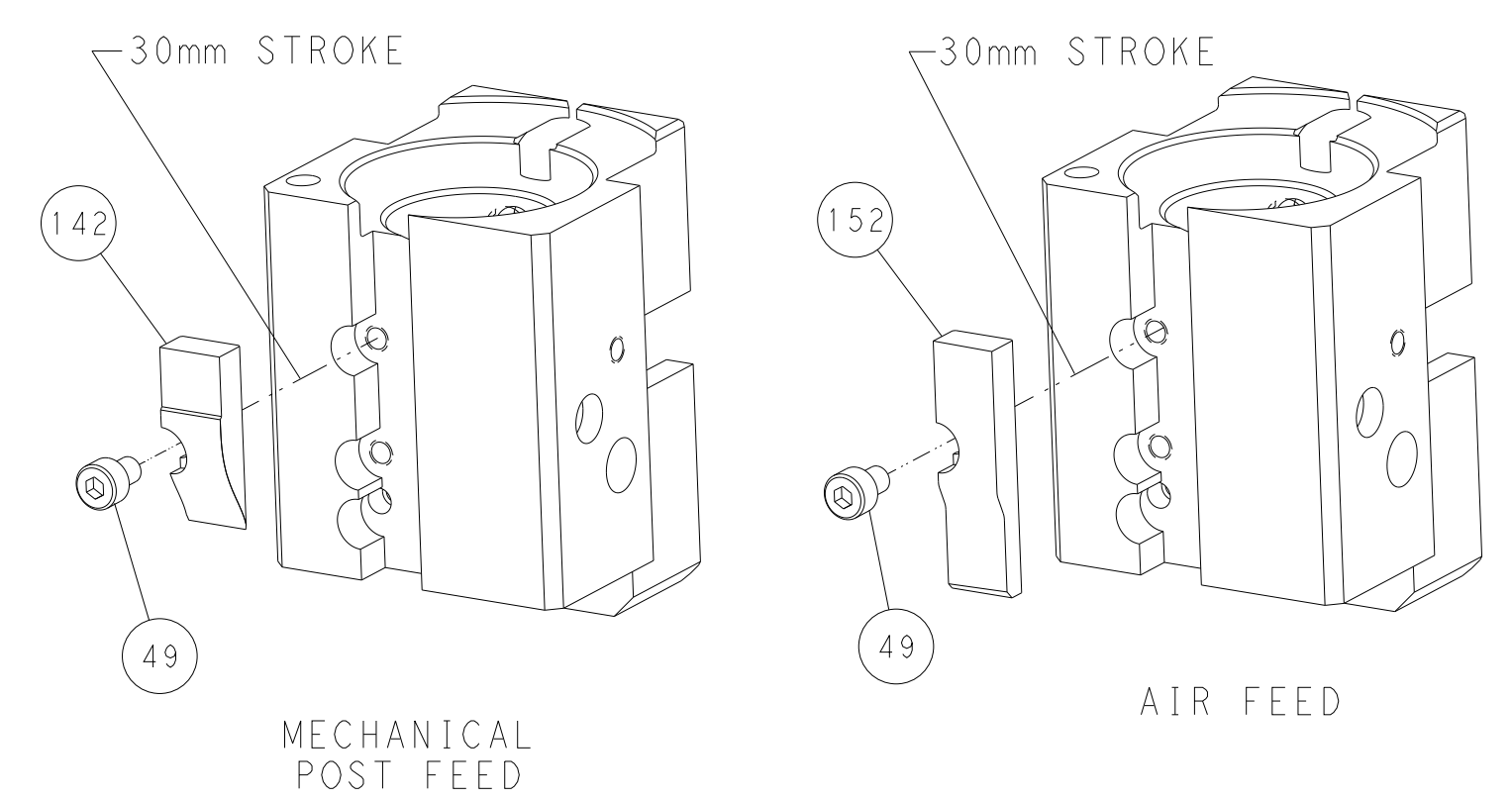


RAM AND HOLDDOWN SET-UP

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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: B. WEAVER 23NOV2011 CHK: C. MOYER 23NOV2011 APVD: G. BAILEY 23NOV2011	NAME: OCEAN END FEED APPLICATOR SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150237 SCALE: 1:1 SHEET: 4 OF 4 REV: E1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - MATERIAL: -	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING