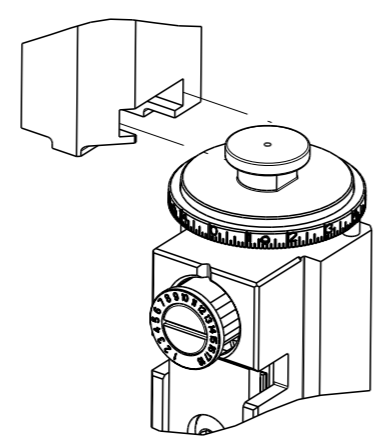


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150057-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150057-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150057-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: "250" SERIES POSITIVE LOCK-EX RECEPTACLE			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-5119 (B)114-5146	(C)114-5195	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 175022-1 (A) 175022-3 (A) 2232958-1	TE TERMINAL (A) 2-175022-1 (A) 2232553-1	TE TERMINAL (B) 175164-1	TE TERMINAL (C) 179974-1 (C) 179974-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.82+/-0.05 [.072+/-0.002]	5.9
(2)0.75mm2	1.82+/-0.05 [.072+/-0.002]	5.9
1.25mm2	1.62+/-0.05 [.064+/-0.002]	7.9
1.00mm2	1.55+/-0.05 [.061+/-0.002]	8.6
(2)0.5mm2	1.55+/-0.05 [.061+/-0.002]	8.6
0.75mm2	1.50+/-0.05 [.059+/-0.002]	9.1

- 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 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

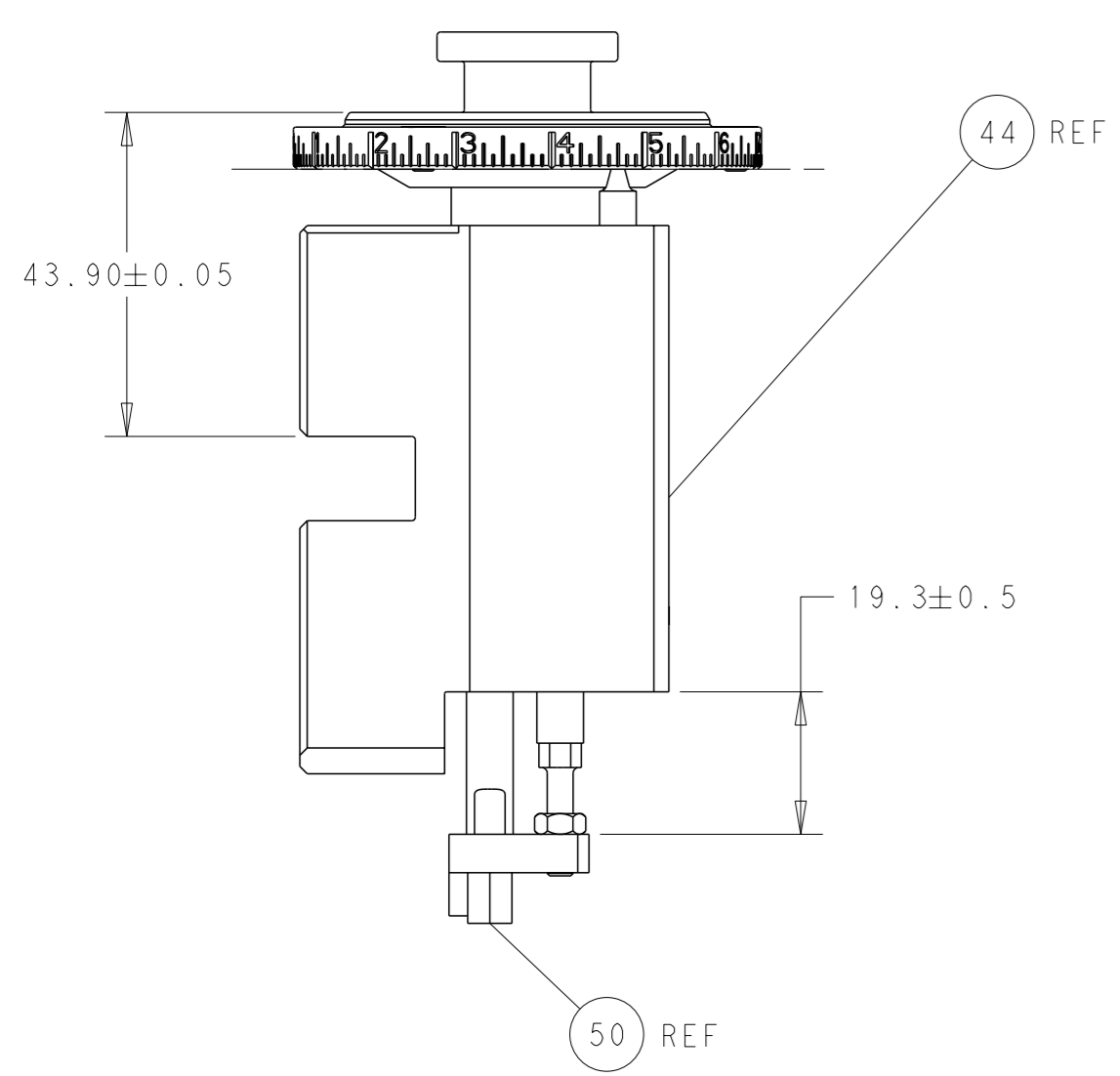
LOC	DIST	REVISIONS			
P	LYR	DESCRIPTION	DATE	OWN	APVD
C		ECR-18-015157	23SEP2018	TB	TE
C1		ECR-19-005255	02APR2019	MZ	GB
D		ECR-19-008437	31MAY2019	LG	TE
D1		ECR-20-008855	22JUN2020	FJ	TE

-	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	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	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	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	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	1-1752354-2	STANDOFF,HOLD-DOWN	50	
-	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	1-1752371-7	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	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240833-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-4	PLATE, FRONT SHEAR	9	
-	1	2	1	4-1333219-0	ANVIL, COMBINATION	8
-	1	1	1	1-2217206-0	BLADE, SLUG	7
-	1	1	1	7-240641-2	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	1	1-456422-5	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

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

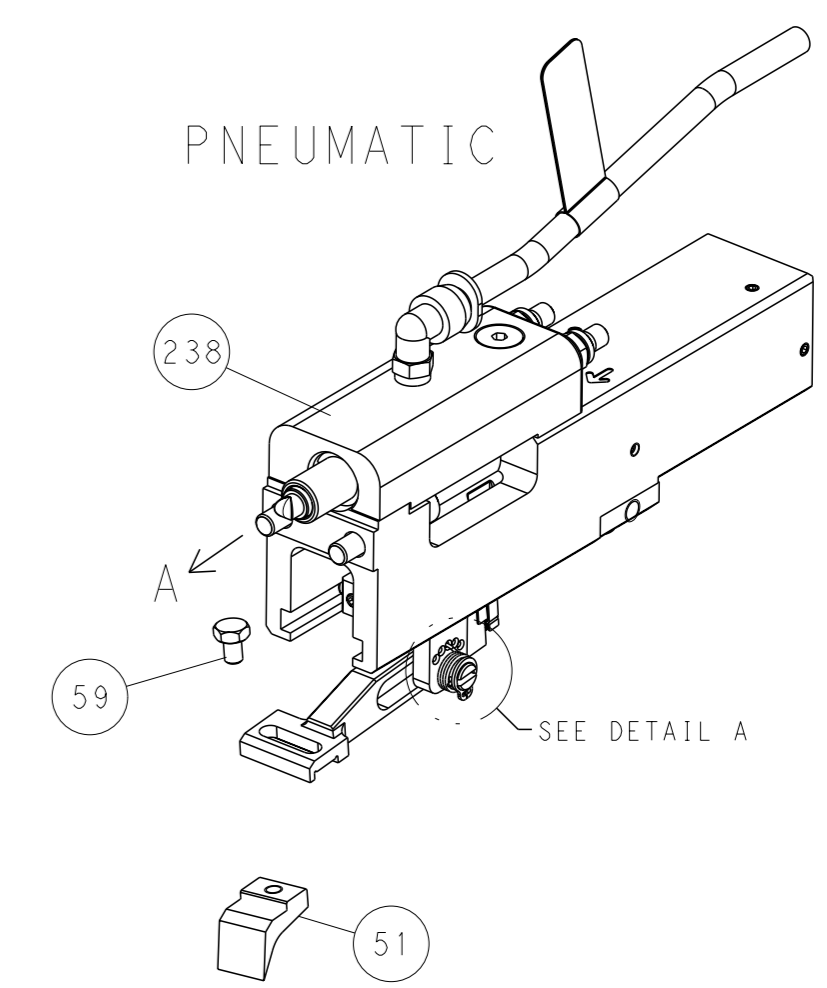
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0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ±		±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SCALE 1:1 SHEET 1 OF 4 REV D1	
-		-		-		Customer Accessible Production Drawing	

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

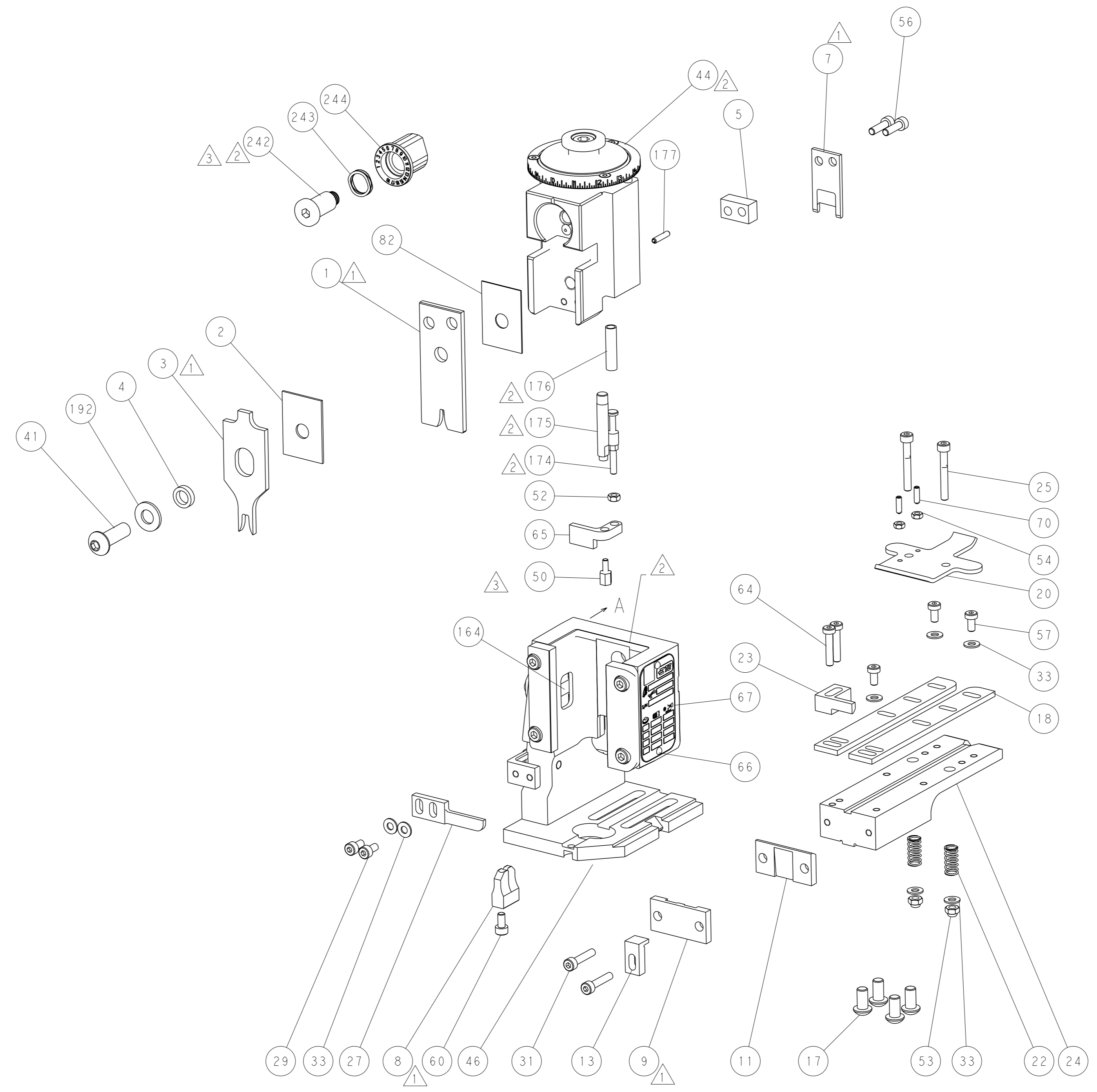
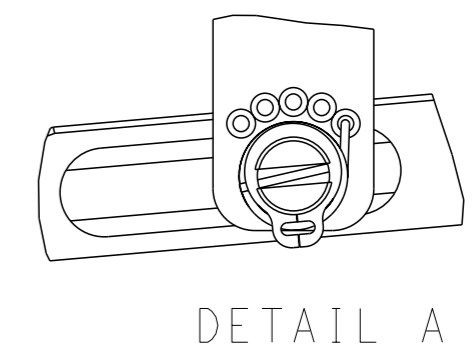


RAM AND HOLDDOWN SET-UP

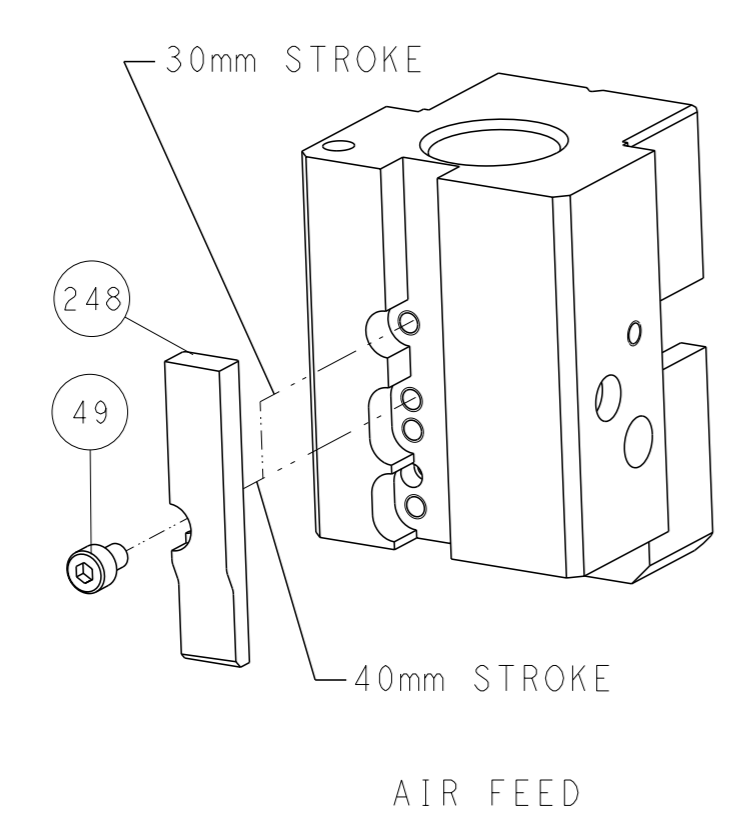
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

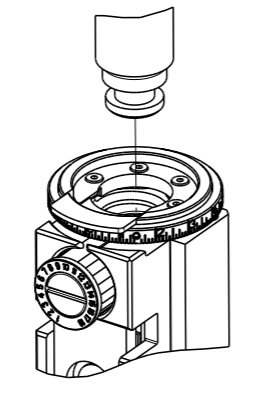


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: X_ZHAO 02FEB2012 CHK: T_ELFIN 02FEB2012 APVD: S_XI 02FEB2012	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150057	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D1	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150057-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150057-7	B	CRIMP TOOLING KIT	-

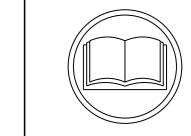
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: "250" SERIES POSITIVE LOCK-EX RECEPTACLE			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5119 (B)114-5146	(C)114-5195	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 175022-1	(A) 2-175022-1	(B) 175164-1	(C) 179974-1
(A) 175022-3	(A) 2232553-1	(C) 179974-6	
(A) 2232958-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.82 +/- 0.05 [.072 +/- .002]	5.9
(2)0.75mm2	1.82 +/- 0.05 [.072 +/- .002]	5.9
1.25mm2	1.62 +/- 0.05 [.064 +/- .002]	7.9
1.00mm2	1.55 +/- 0.05 [.061 +/- .002]	8.6
(2)0.5mm2	1.55 +/- 0.05 [.061 +/- .002]	8.6
0.75mm2	1.50 +/- 0.05 [.059 +/- .002]	9.1



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

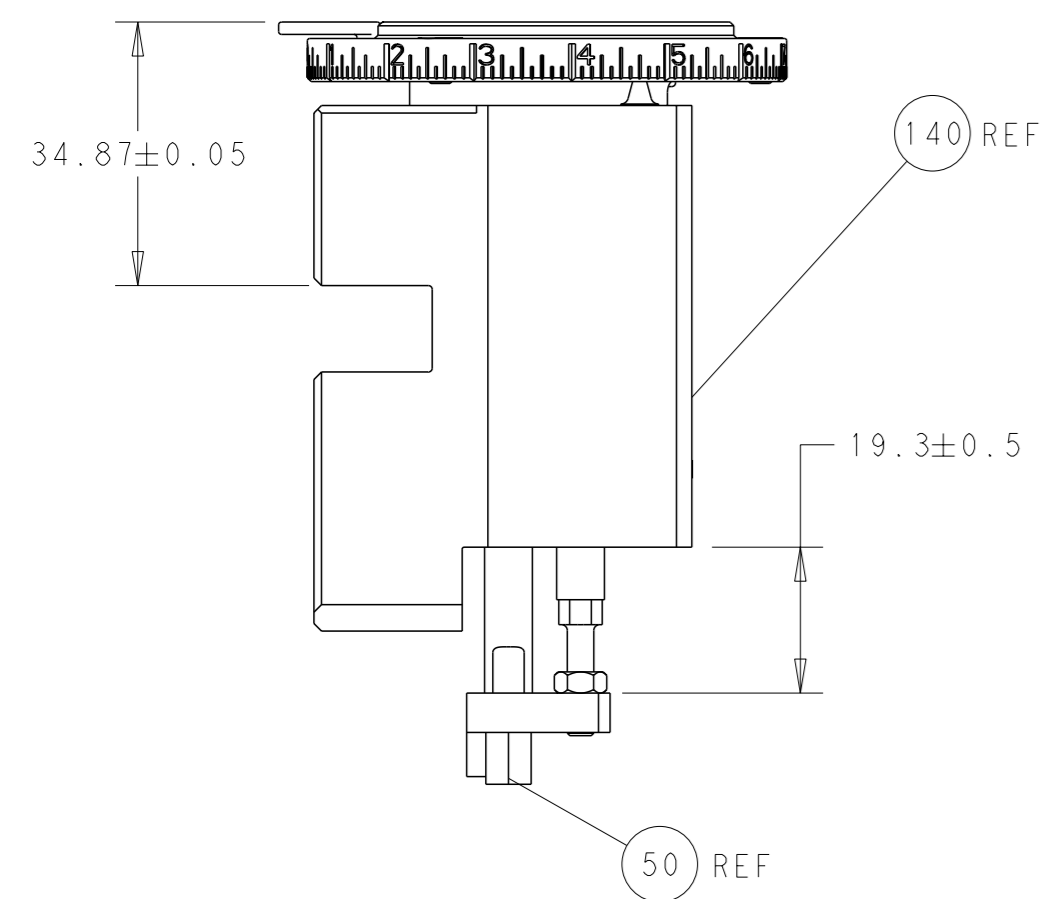
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1		-	-

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-3	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-1	FEED FINGER	51
-	1	1-1752354-2	STANDOFF,HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1-1752371-7	PLATE, STRIP GUIDE	24
-	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-4	PLATE, FRONT SHEAR	9
-	1	4-1333219-0	ANVIL, COMBINATION	8
-	1	1-2217206-0	BLADE, SLUG	7
-	1	7-240641-2	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
-	1	1-456422-5	CRIMPER, WIRE PREMIUM	1
-	77-22	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)

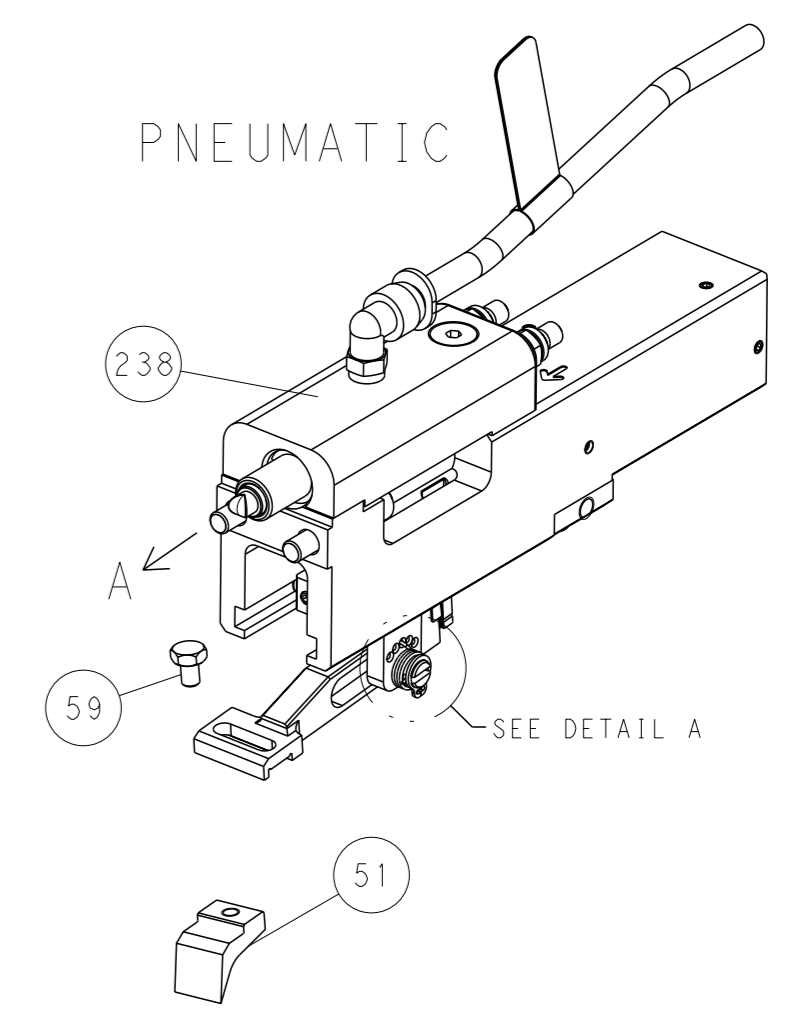
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1 PLC ±		2 PLC ±		APVD S.YI 02FEB2012		NAME	
3 PLC ±		4 PLC ±		PRODUCT SPEC		Ocean End Feed	
ANGLES		FINISH		APPLICATION SPEC		Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
-		-		A1 00779 ©=2150057		-	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 of 4 REV D1	

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



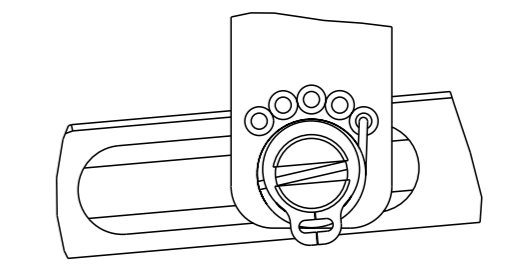
RAM AND HOLDDOWN SET-UP

FEED TYPE

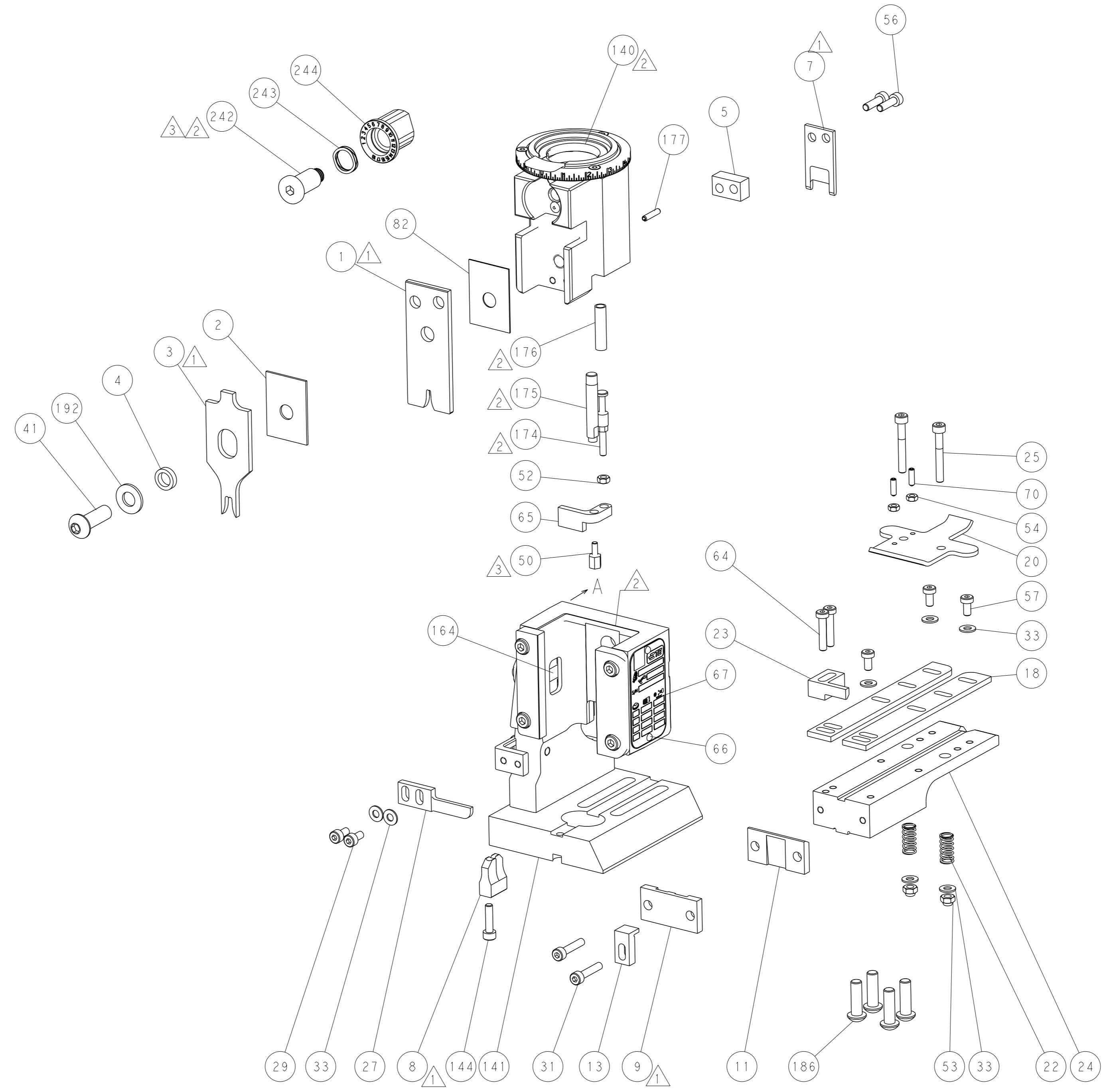


PNEUMATIC

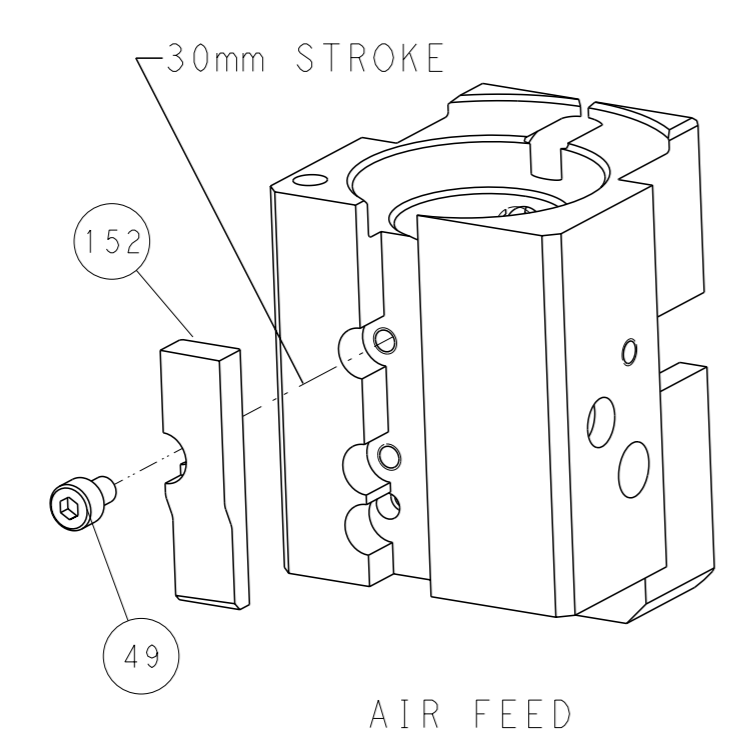
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION



AIR FEED

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: X_ZHAO 02FEB2012 CHK: T_ELBIN 02FEB2012 APVD: S_XI 02FEB2012	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150057 RESTRICTED TO:	SCALE: 1:1 SHEET: 4 of 4 REV: D1
MATERIAL:		WEIGHT:	
Customer Accessible Production Drawing			