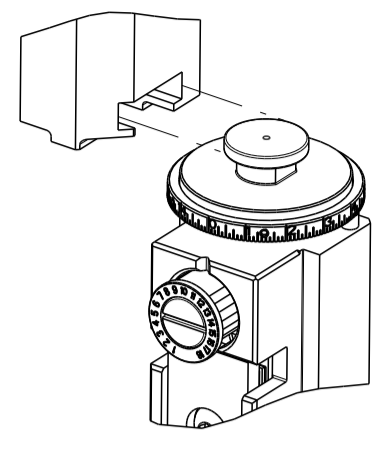


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150401-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150401-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150401-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150401-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150401-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F

APPL INSTRUCTIONS  
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 (6.3) SERIES FLAG POS. LOCK			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø2.20-3.30 mm [.087-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-20083	-	-
	(B) 114-20080	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 926820-1	(A) 926820-4	(A) 926820-7	
(A) 926820-2	(A) 926820-5	(A) 926820-8	
(A) 926820-3	(A) 926820-6	(B) 282349-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.60 +/- 0.03 [.063 +/- .001]	5.7
1.00mm2	1.45 +/- 0.03 [.057 +/- .001]	7.3
0.75mm2	1.35 +/- 0.03 [.053 +/- .001]	9.0
0.50mm2	1.27 +/- 0.03 [.050 +/- .001]	10.3



- 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.
- 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 WIRE RANGE 0.5mm2 IS NOT CAPABLE FOR FORE MONITORING. IF CRIMP FORCE MONITORING IS ESSENTIAL, 0.5mm2 IS NOT ALLOWED FOR THIS TERMINAL. THIS WAS TAKEN FROM TERMINAL DRAWING.

**\*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.

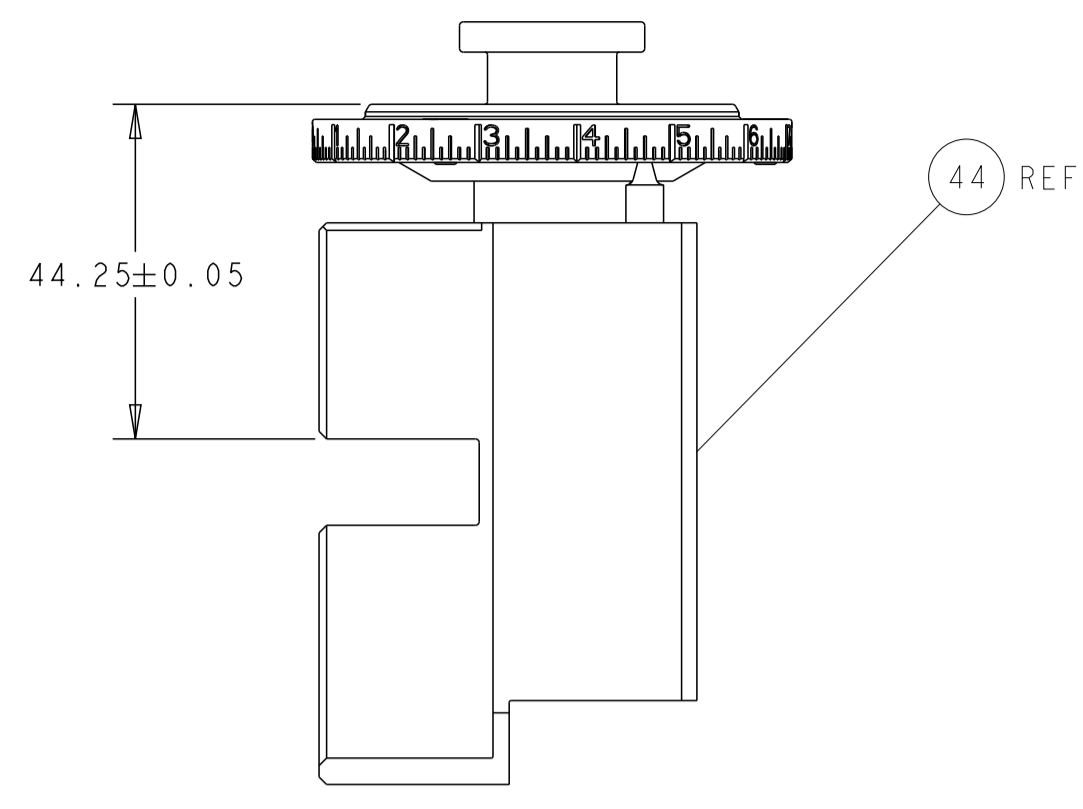
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		C		ECR-18-015787	04OCT2018	MEH	GB
		D		ECR-18-018351	23NOV2018	FL	CT
		E		ECR-19-000479	11JAN2019	FL	CT
		F		ECR-21-006510	27JUN2021	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	109	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	105	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	104	
-	2	2	2	2	1-2079383-6	SCR, BHSC, RoHS (M4 X 10)	93	
-	2	2	2	2	2168083-4	SCR, SKT HD CAP, RoHS, M5 X 10.0	89	
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	86	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85	
-	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	83	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 25	80	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	-	224716-6	PAWL, FEED	58	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	1	-	1	-	224716-6	PAWL, FEED	51	
-	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	1-2119655-9	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	1	1	2217981-1	BLOCK, BASE	32	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	28	
-	1	1	1	1	690455-9	STRIPPER, FRONT CASTING	27	
-	1	1	1	1	2217982-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	240792-1	DRAG, TERMINAL	20	
-	1	1	1	1	662657-1	STRIP, GUIDE, REAR	19	
-	1	1	1	1	690438-1	FRONT STRIP GUIDE	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	455888-3	SPACER, CRIMPER	14	
-	1	1	1	1	2217983-1	PLATE, SHEAR	13	
-	1	1	1	1	6-22279-4	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-6	STOP, SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	662631-1	SHEAR, FLOATING	9	
-	1	2	2	1	2217984-1	ANVIL	8	
-	1	1	1	1	662630-1	BLADE, FRONT SLUG	7	
-	1	1	1	1	662632-2	DEPRESSOR, SHEAR	6	
-	1	1	1	1	662630-2	BLADE, FRONT SLUG	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	456407-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	-2	-1	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)

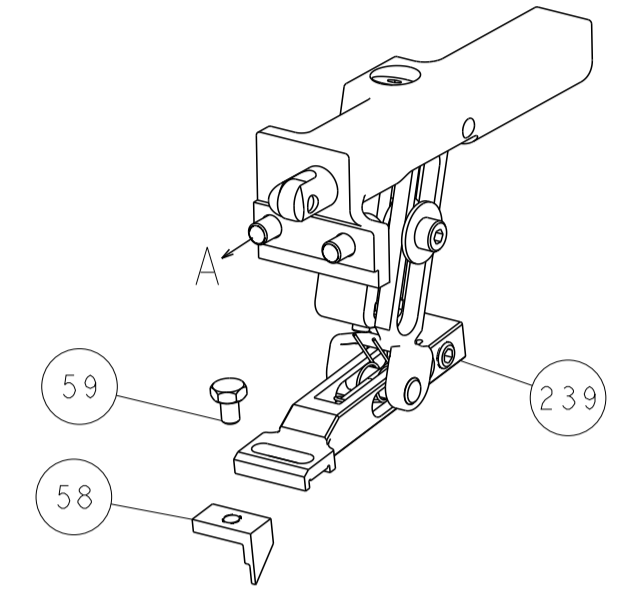
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APVD: G. BAILEY		APVD: T. ELRLIN		APVD: T. ELRLIN		APVD: T. ELRLIN	
DATE: 20JAN2014		DATE: 20JAN2014		DATE: 20JAN2014		DATE: 20JAN2014	
NAME: G. BAILEY		NAME: T. ELRLIN		NAME: T. ELRLIN		NAME: T. ELRLIN	
PRODUCT SPEC		APPLICATION SPEC		WEIGHT		SCALE	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: C=2150401		SHEET 1 OF 4	
RESTRICTED TO		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1		REV F	

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

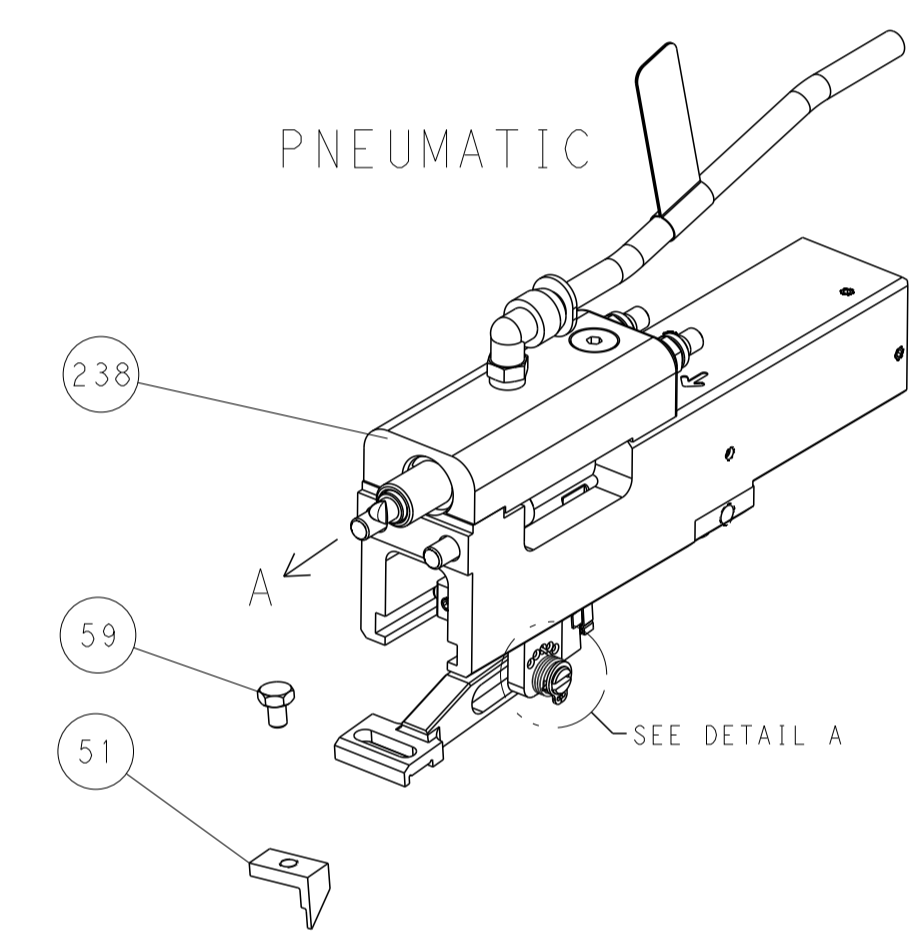


RAM SET-UP

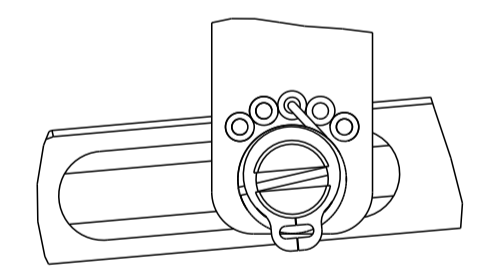
FEED TYPE  
MECHANICAL



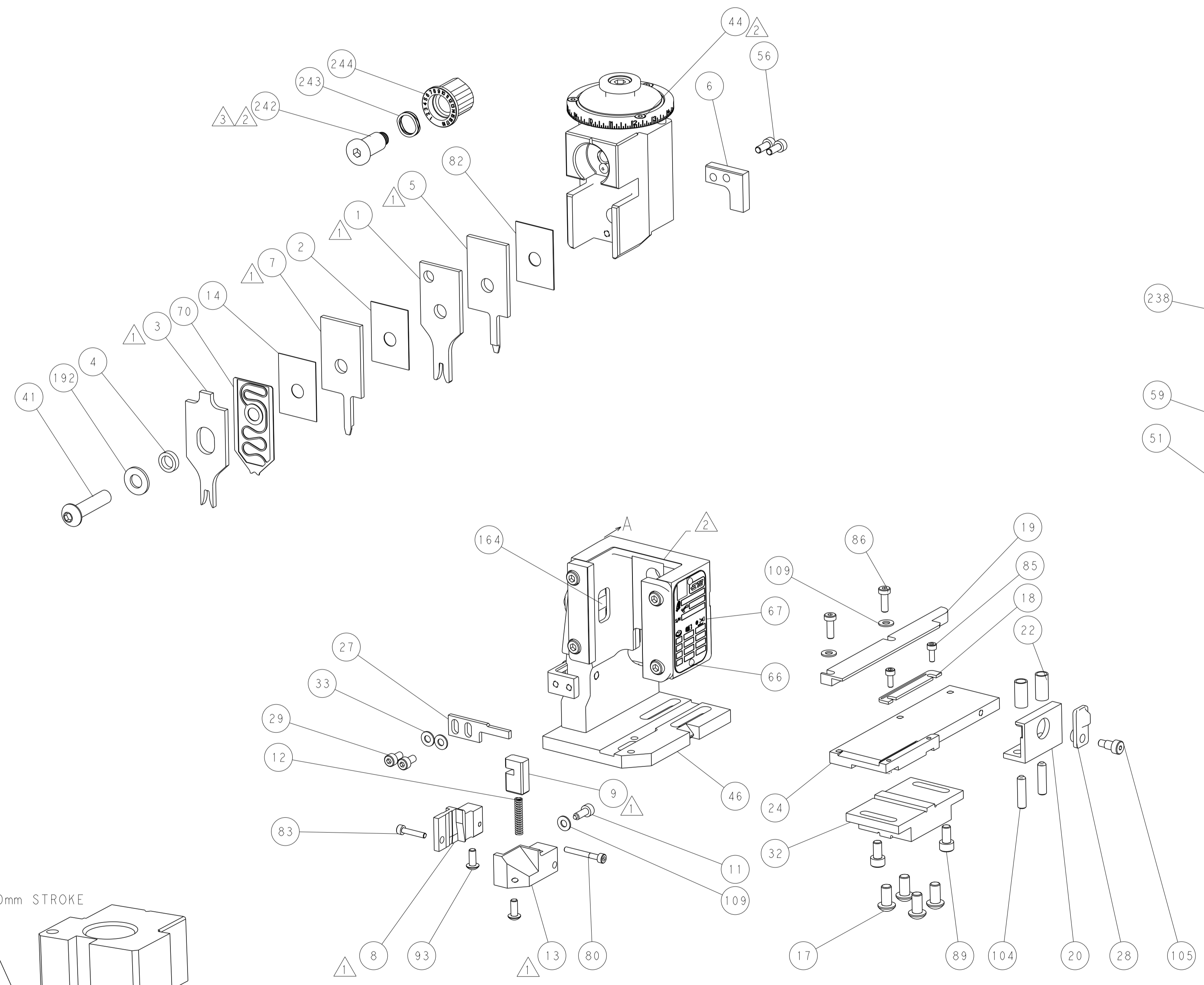
PNEUMATIC



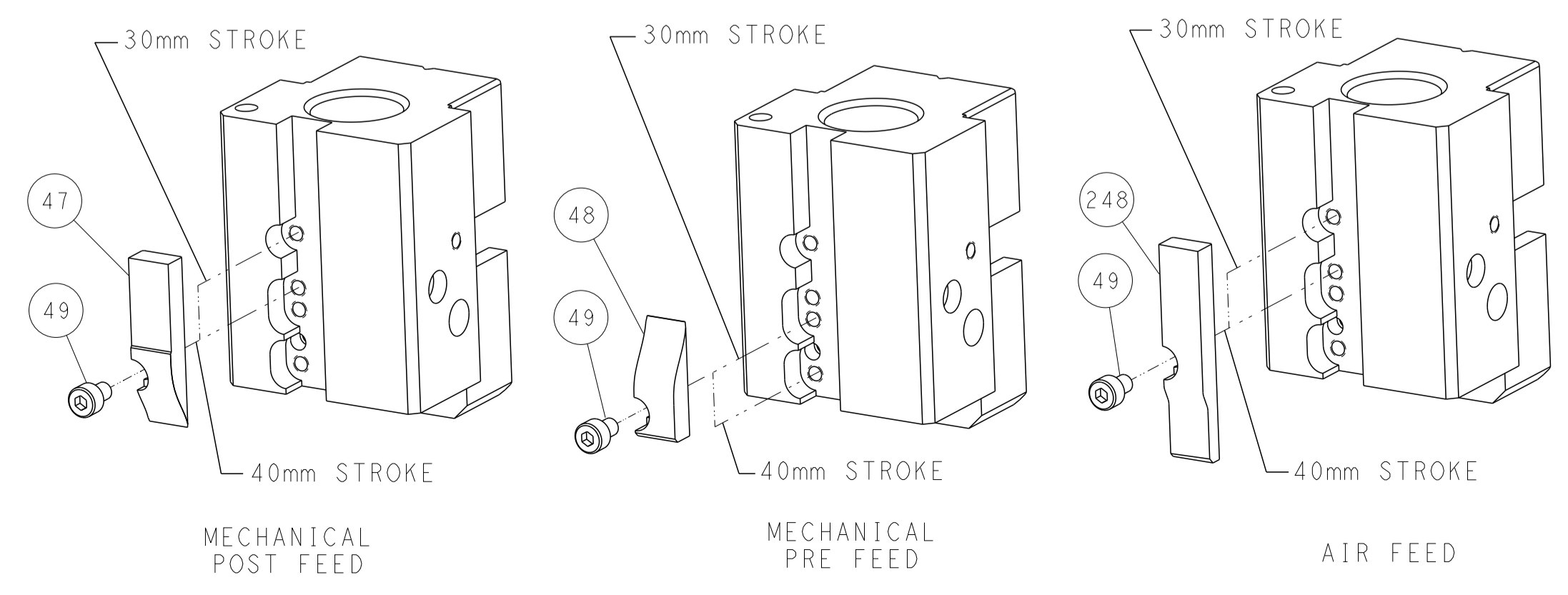
FEED SPRING  
SETTING POSITION



DETAIL A



CAM POSITIONS

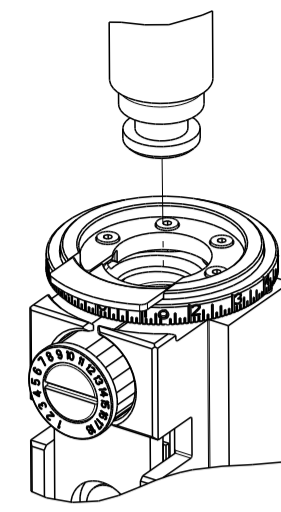


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: K. STAKEM 20JAN2014		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 20JAN2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T. ELRLIN 20JAN2014		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC:		SIZE: A1	
L		3 PLC ±		APPLICATION SPEC:		CAGE CODE: 00779	
R		4 PLC ±		WEIGHT:		DRAWING NO: 2150401	
ANGLES		FINISH:		MATERIAL:		RESTRICTED TO:	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150401-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150401-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150401-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.138]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: .250 (6.3) SERIES FLAG POS. LOCK							
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]				INSULATION DIAMETER RANGE Ø2.20-3.30 mm [.087-.130 IN]			
TERMINAL APPLICATION SPECIFICATION (A) 114-20083		-		-		-	
TERMINALS APPLIED (B) 114-20080		-		-		-	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 926820-1	(A) 926820-4	(A) 926820-7					
(A) 926820-2	(A) 926820-5	(A) 926820-8					
(A) 926820-3	(A) 926820-6	(B) 282349-1					

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.60 +/- 0.03 [0.063 +/- 0.001]	5.7
1.00mm2	1.45 +/- 0.03 [0.057 +/- 0.001]	7.3
0.75mm2	1.35 +/- 0.03 [0.053 +/- 0.001]	9.0
0.50mm2	1.27 +/- 0.03 [0.050 +/- 0.001]	10.3

- 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.
- 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 WIRE RANGE 0.5mm2 IS NOT CAPABLE FOR FORE MONITORING. IF CRIMP FORCE MONITORING IS ESSENTIAL, 0.5mm2 IS NOT ALLOWED FOR THIS TERMINAL. THIS WAS TAKEN FROM TERMINAL DRAWING.

**\*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.

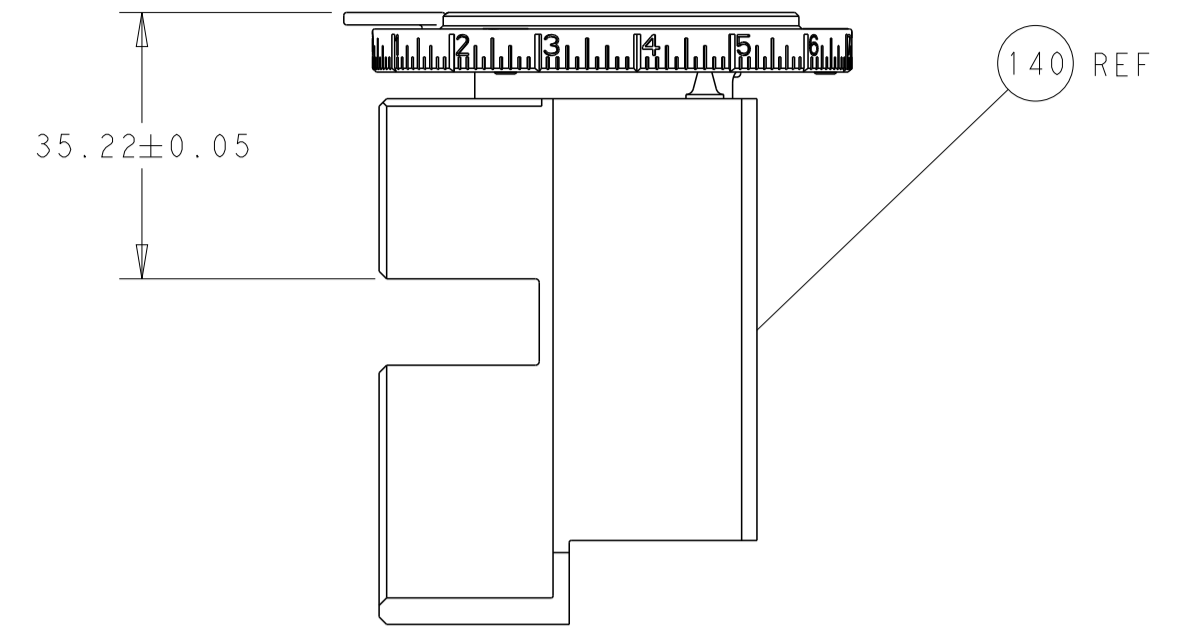
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-7	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2-2119655-0	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140	
-	3	3	1-18028-2	WASHER, FLAT, REG M4	109	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	105	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	104	
-	2	2	1-2079383-6	SCR, BHSC, RoHS (M4 X 10)	93	
-	2	2	2168083-4	SCR, SKT HD CAP, RoHS, M5 X 10.0	89	
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	86	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	83	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	2-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 25	80	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	224716-6	PAWL, FEED	58	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	1	-	224716-6	PAWL, FEED	51	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	2	2	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	2217981-1	BLOCK, BASE	32	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	356835-1	LEVER, DRAG RELEASE	28	
-	1	1	690455-9	STRIPPER, FRONT CASTING	27	
-	1	1	2217982-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	240792-1	DRAG, TERMINAL	20	
-	1	1	662657-1	STRIP, GUIDE, REAR	19	
-	1	1	690438-1	FRONT STRIP GUIDE	18	
-	1	1	455888-3	SPACER, CRIMPER	14	
-	1	1	2217983-1	PLATE, SHEAR	13	
-	1	1	6-22279-4	SPRING, COMPRESSION	12	
-	1	1	1-356885-6	STOP, SHEAR	11	
-	-	-	-	-	10	
-	1	1	662631-1	SHEAR, FLOATING	9	
-	1	1	2217984-1	ANVIL	8	
-	1	1	662630-1	BLADE, FRONT SLUG	7	
-	1	1	662632-2	DEPRESSOR, SHEAR	6	
-	1	1	662630-2	BLADE, FRONT SLUG	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-4	SPACER, CRIMPER	2	
-	1	1	456407-8	CRIMPER, WIRE 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)

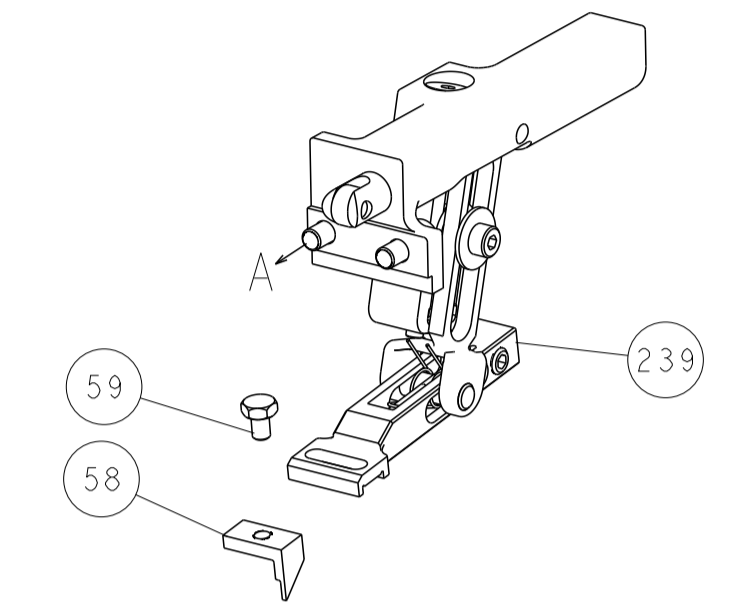
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	ANGLES ±	FINISH			
MATERIAL		FINISH		WEIGHT	
				SCALE	
				SHEET	
				REV	

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

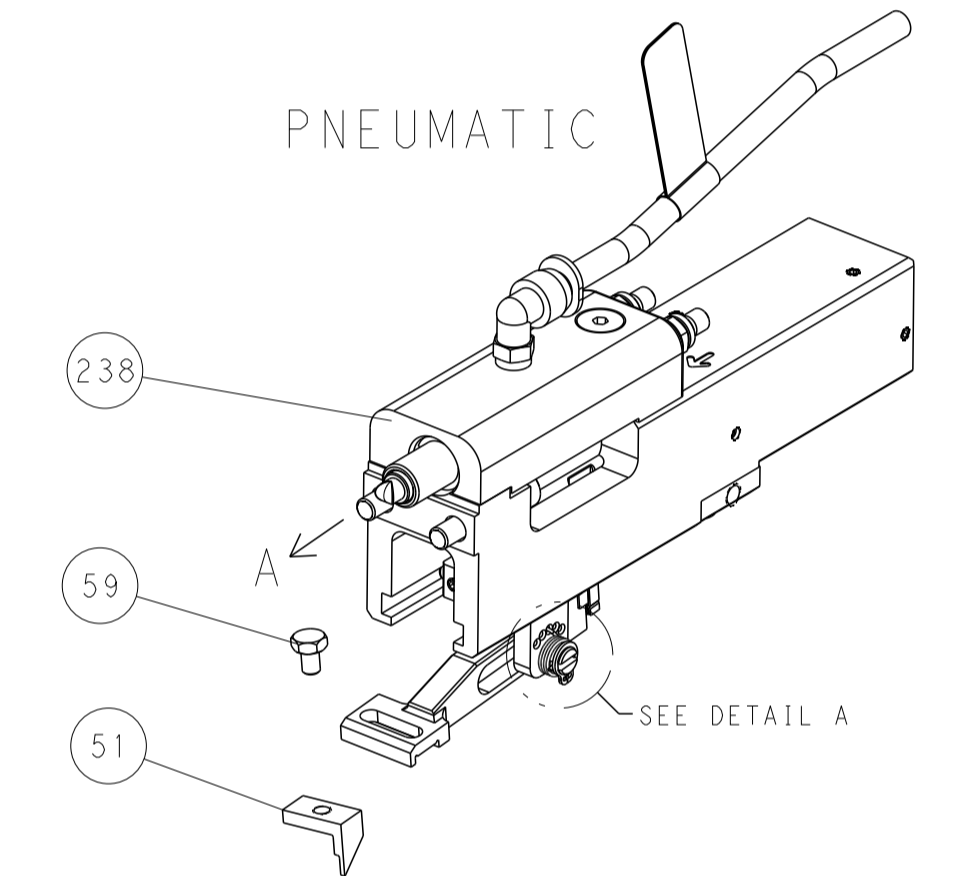


RAM SET-UP

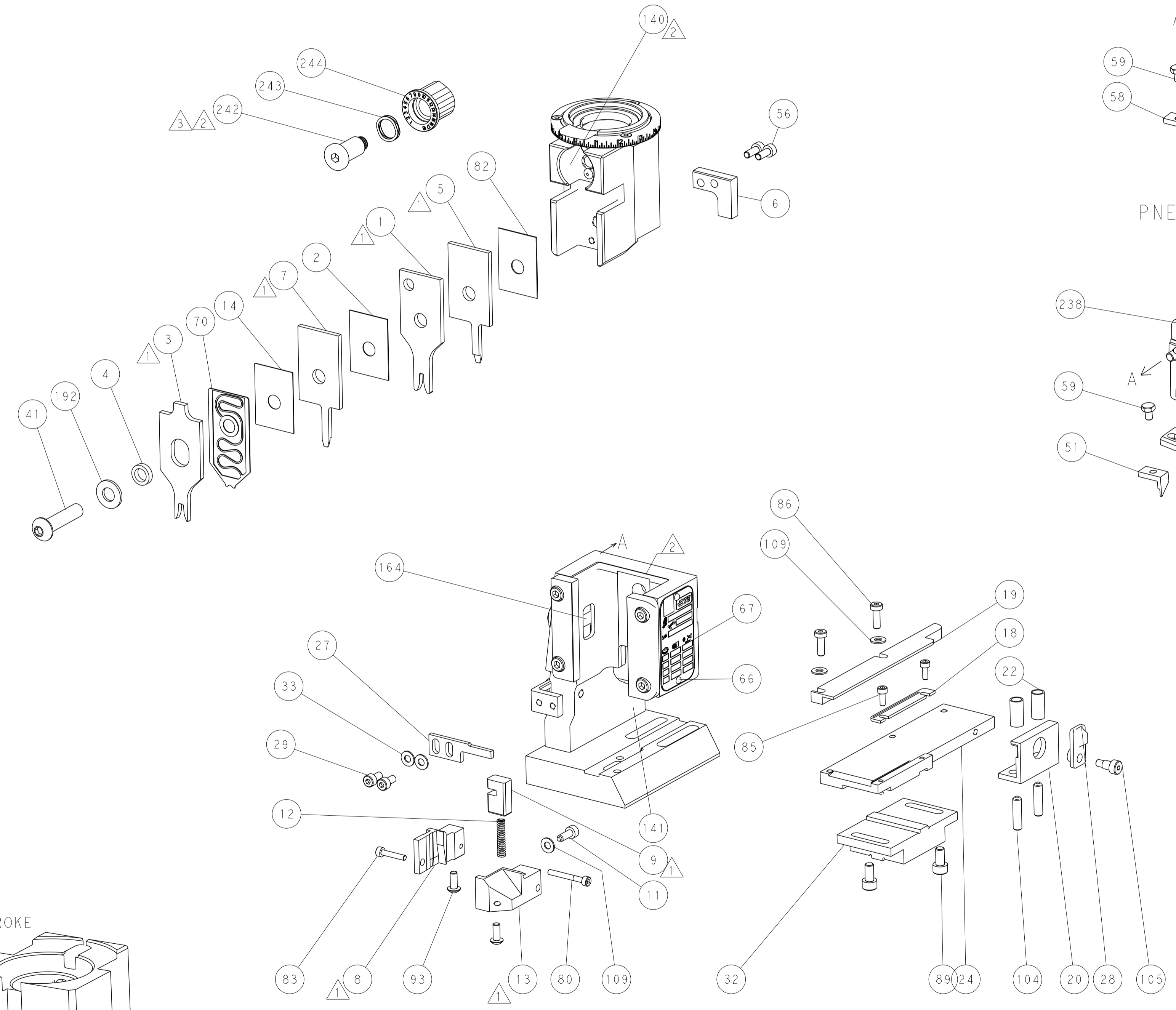
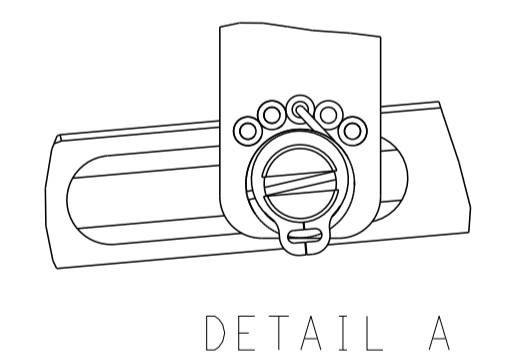
FEED TYPE  
MECHANICAL



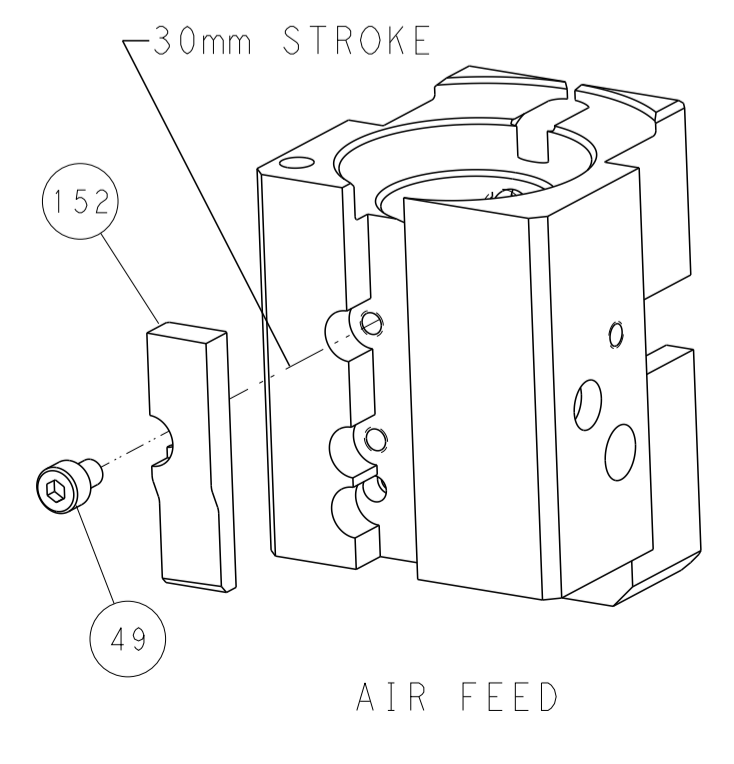
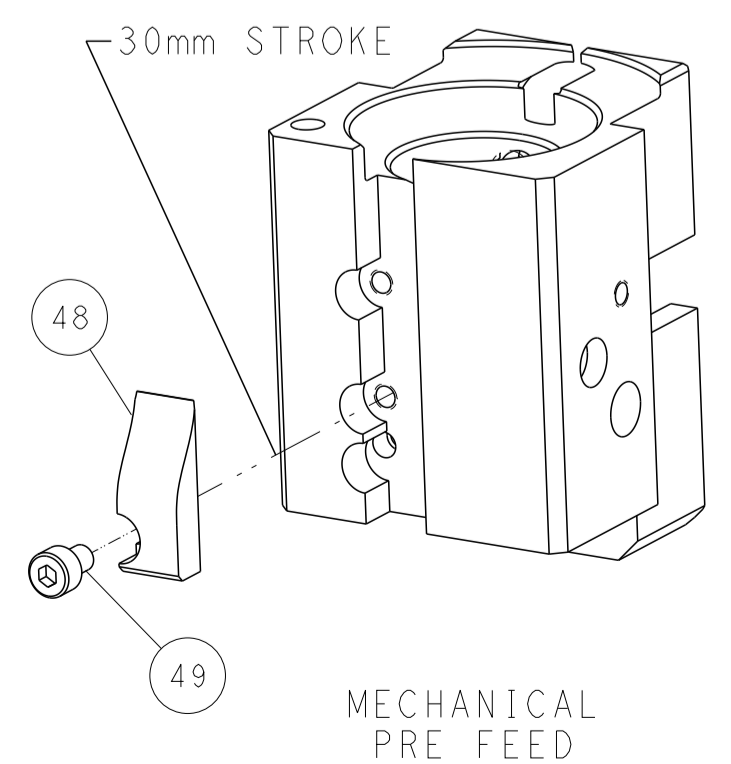
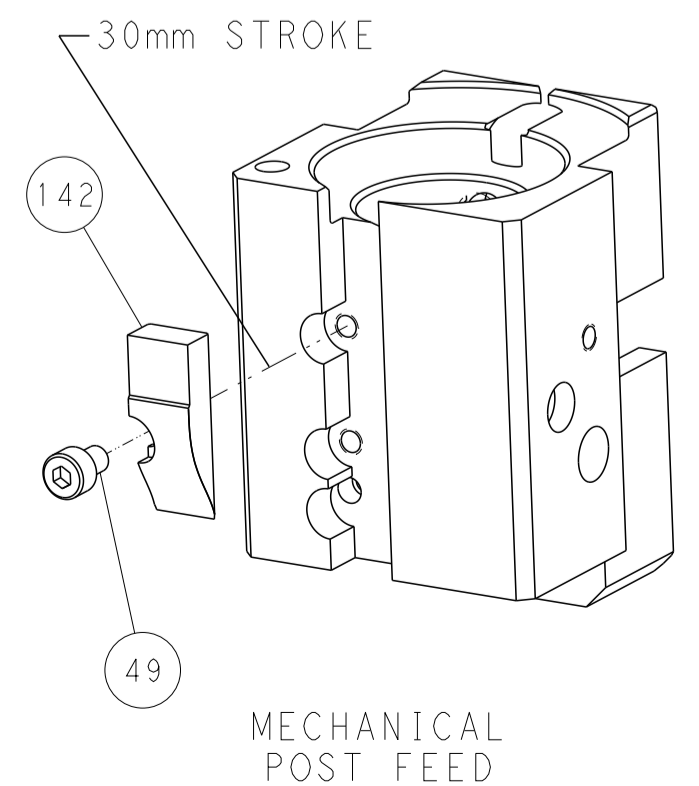
PNEUMATIC



FEED SPRING  
SETTING POSITION



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: K. STAKEM 20JAN2014 CHK: G. BAILEY 20JAN2014 APVD: T. ELRLIN 20JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean End Feed Applier	
	ANGLES ±	FINISH ±	WEIGHT		SIZE: A1 00779 C=2150401		RESTRICTED TO
MATERIAL				Customer Accessible Production Drawing		SCALE: 1:1	SHEET 4 OF 4 REV F