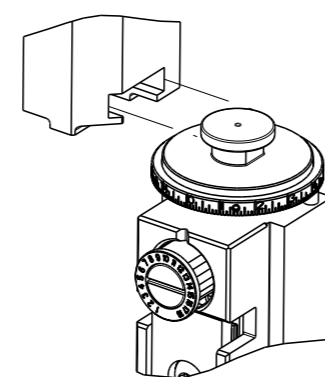


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150252-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150252-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150252-7 | A | CRIMP TOOLING KIT | - |

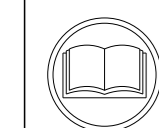
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



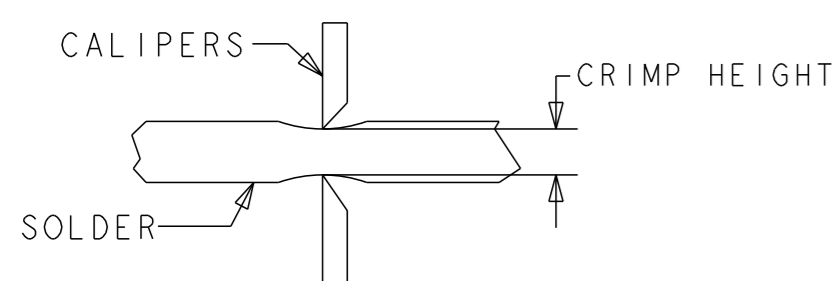
| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.11 mm [.201] | D |
| INSUL | - | - |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|----------------------------|-------------|
| TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .250 SERIES | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 7.51-8.33 mm [.296-.328 IN] | | ∅ 4.19mm MAX [.165 IN MAX] | |
| TERMINAL APPLICATION SPECIFICATION | 114-2123 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2-520128-2 | 2-521164-2 | 9-521164-2 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING | ∅ SOLDER |
|--------------|----------------------------|--------------------------------|-----------------|
| 18 OR (2) 22 | 1.79+/-0.05 [.070+/-0.002] | 5.7 | .19 in [4.83mm] |
| 22 OR 20 | 1.65+/-0.05 [.065+/-0.002] | 7.0 | .19 in [4.83mm] |



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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.

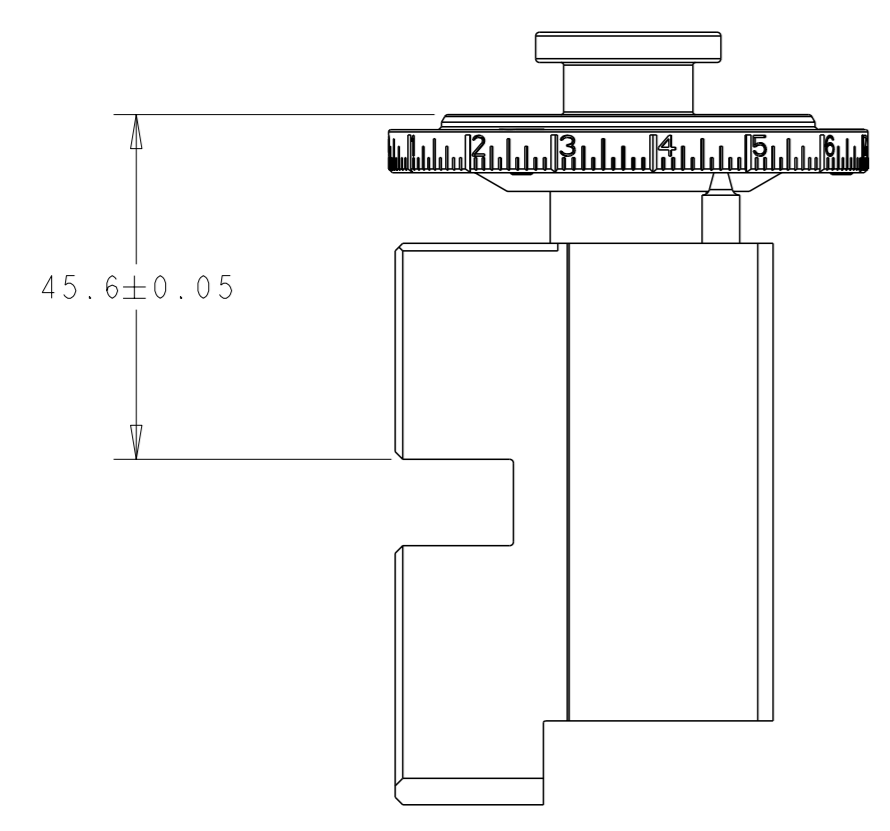
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-------------|-----|------|
| | | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | 1 | | ORIGINAL | 11APRIL2012 | GH | TE |
| | | A | | RELEASED | 18JAN2013 | GH | TE |
| | | B | | ECR-18-014348 | 10SEP2018 | JAH | TE |
| | | C | | ECR-19-008826 | 04JUN2019 | LG | TE |

| | | | | | | |
|---|-----|-----|-------------|----------------------------------|-------------------------------|---------|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 2844940-3 | AIR FEED MODULE | 238 | |
| - | 1 | 1 | 467281-1 | RETAINER, SHEAR, FLOATING | 207 | |
| - | 1 | 1 | 2161936-1 | HOLDER, SHEAR, FLOATING | 206 | |
| - | 1 | 1 | 467500-1 | SHEAR, FLOATING | 205 | |
| - | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 | |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 2161937-1 | STABILIZER | 154 | |
| - | 1 | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 3-18032-3 | SCR, SET, FLT PNT, M3 X 20.0 | 70 | |
| - | 1 | 1 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 69 | |
| - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 | |
| - | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 | |
| - | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 60 | |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 | |
| - | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | |
| - | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 1 | 1 | 2352966-1 | FEED FINGER | 51 | |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 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 | |
| - | 2 | 2 | 5-22278-1 | SPRING, COMPRESSION | 36 | |
| - | 8 | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 31 | |
| - | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 29 | |
| - | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 | |
| - | 2 | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 | |
| - | 1 | 1 | 2161941-1 | PLATE, GUIDE, STRIP | 24 | |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 2161948-1 | DRAG | 20 | |
| - | 1 | 1 | 683736-1 | GUIDE, STRIP, REAR | 19 | |
| - | 1 | 1 | 683737-1 | FRONT STRIP GUIDE | 18 | |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 4-22280-7 | SPRING, COMPRESSION | 13 | |
| | 1 | 2 | 1 | 2161935-1 | ANVIL, RIGHT HAND | 8 |
| - | 1 | 1 | 1 | 2161957-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 2161331-1 | SPACER, WIRE FUNNEL DEPRESSOR | 2 |
| | 1 | 2 | 1 | 467342-1 | CRIMPER, RIGHT HAND | 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)

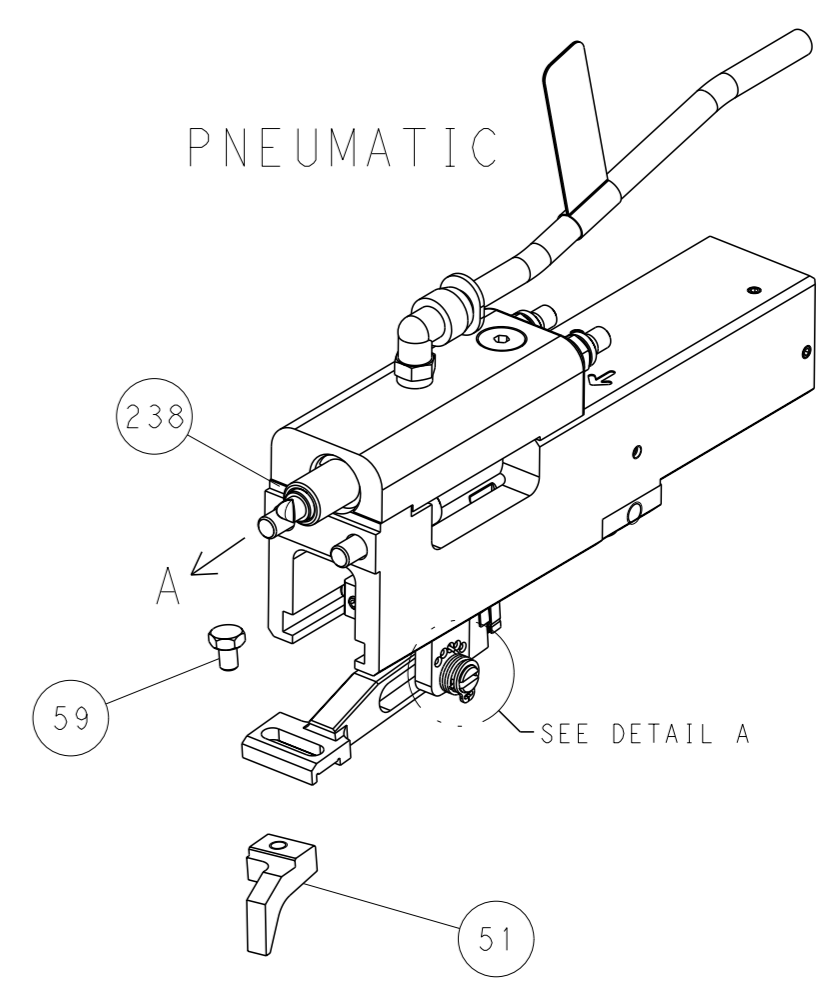
| | | | | | | | |
|--|--|--|--|----------------------------|--|---------------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN: HOFFNER 11APRIL2012 | | TE Connectivity | |
| mm | | 0 PLC ± | | CHK: 12APRIL2012 | | Harrisburg, PA 17105-3608 | |
| | | 1 PLC ± | | APVD: T. ELBIN 12APRIL2012 | | NAME: Ocean End Feed Applicator | |
| | | 2 PLC ± | | PRODUCT SPEC | | SIZE: A1 | |
| | | 3 PLC ± | | APPLICATION SPEC | | CAGE CODE: 00779 | |
| | | 4 PLC ± | | WEIGHT: - | | DRAWING NO: 2150252 | |
| MATERIAL: - | | FINISH: - | | SCALE: 1:1 | | SHEET 1 OF 4 | |
| Customer Accessible Production Drawing | | | | REV C | | | |

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

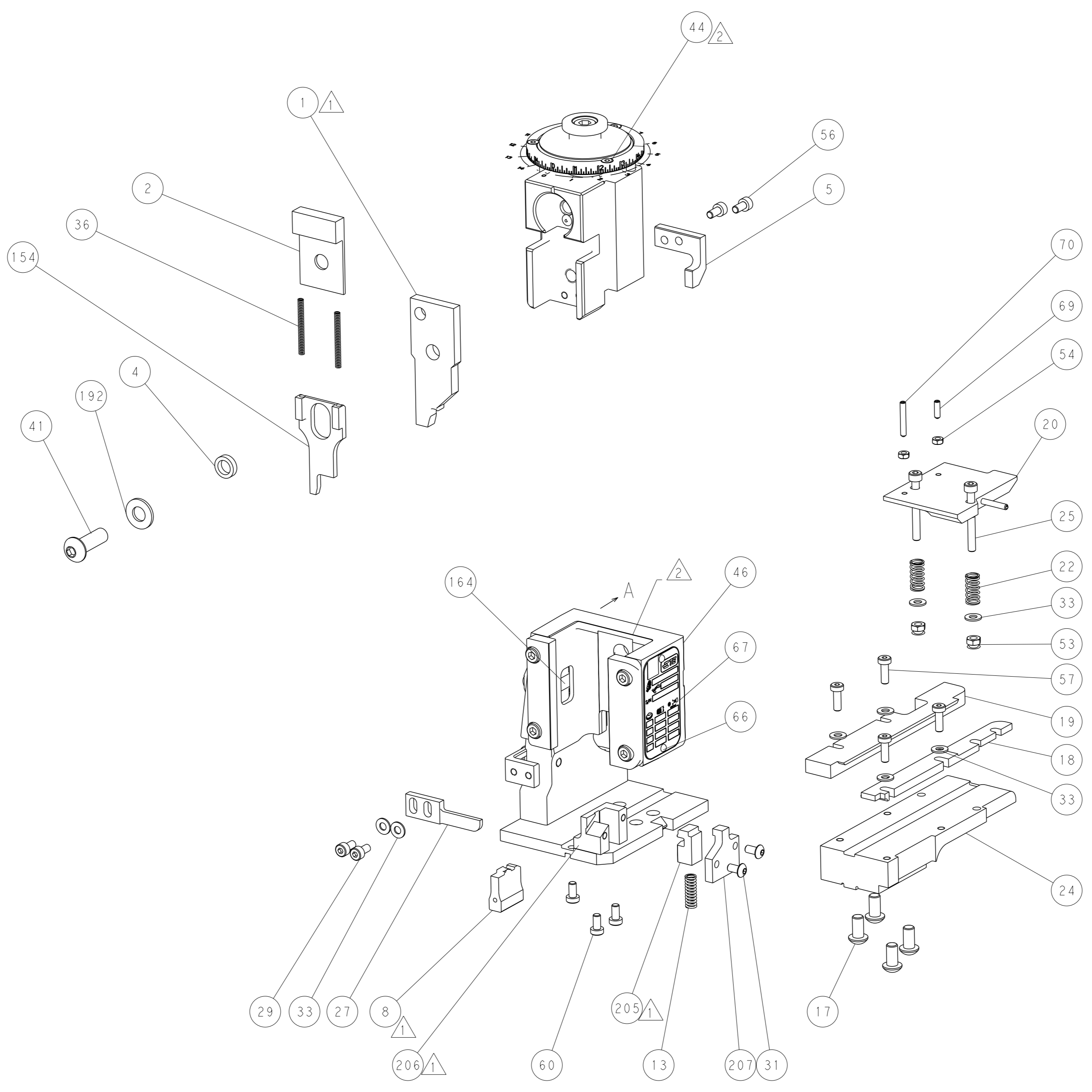
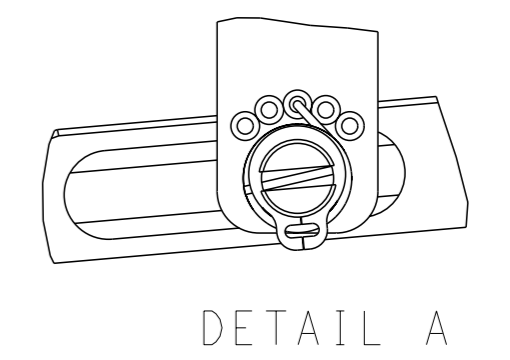


RAM SET-UP

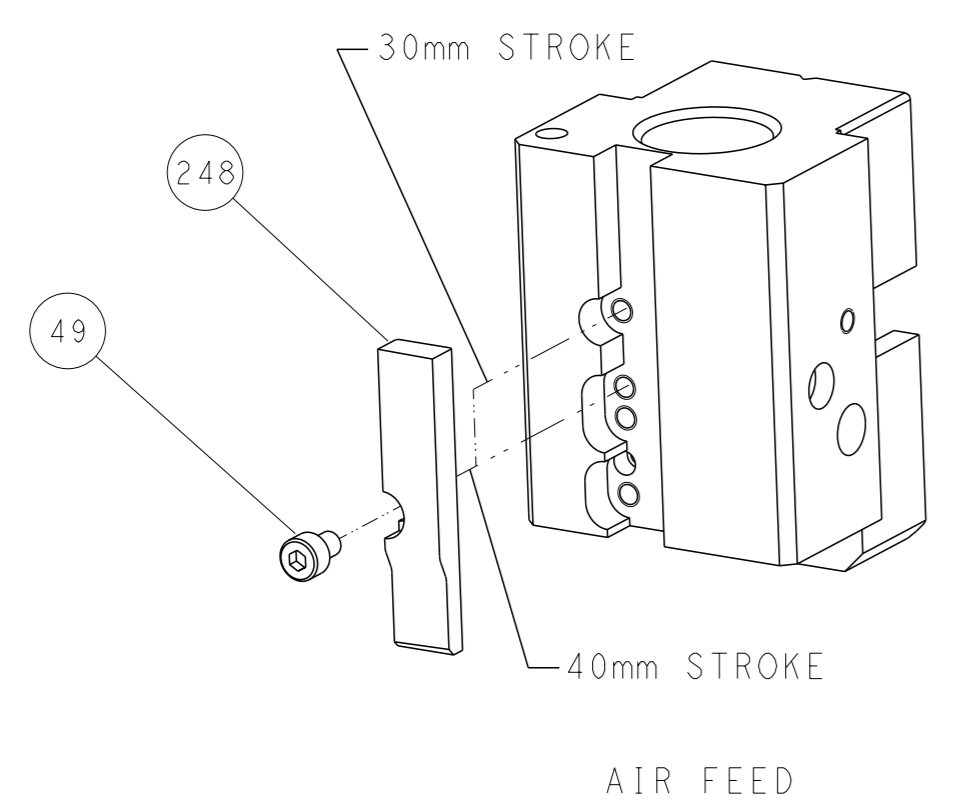
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



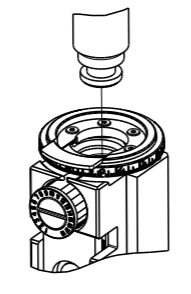
AIR FEED

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 CONTROL AND EXISTING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: HOFFNER 11APRIL2012 CHK: T. ELBIN 12APRIL2012 APVD: T. ELBIN 12APRIL2012 | 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=2150252 | RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: C |
| MATERIAL: - FINISH: - | | WEIGHT: - Customer Accessible Production Drawing | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2150252-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150252-7 | A | CRIMP TOOLING KIT | - |

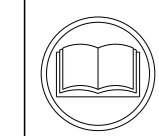
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



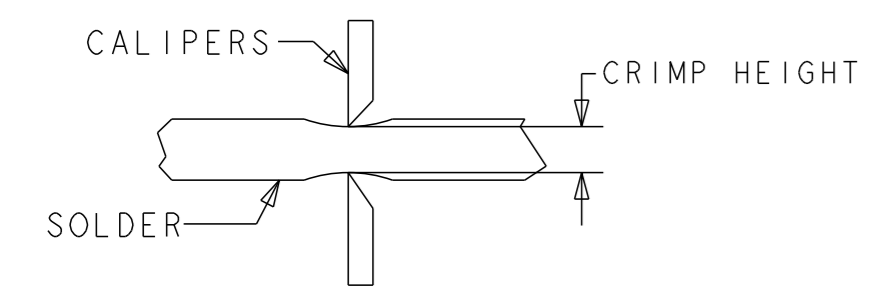
| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.11 mm [.201] | D |
| INSUL | - | - |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|---|-------------|
| TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .250 SERIES | | | |
| WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN] | | INSULATION DIAMETER RANGE ∅ 4.19mm MAX [.165 IN MAX] | |
| TERMINAL APPLICATION SPECIFICATION | 114-2123 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2-520128-2 | 2-521164-2 | 9-521164-2 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING | ∅ SOLDER |
|--------------|----------------------------|--------------------------------|-----------------|
| 18 OR (2) 22 | 1.79+/-0.05 [.070+/-0.002] | 5.7 | .19 in [4.83mm] |
| 22 OR 20 | 1.65+/-0.05 [.065+/-0.002] | 7.0 | .19 in [4.83mm] |



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

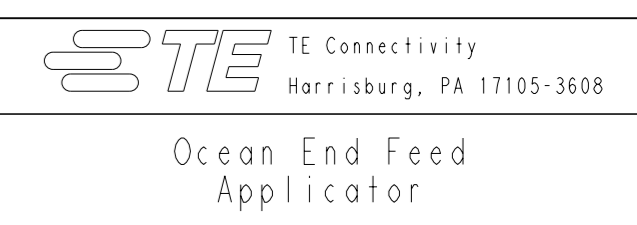
***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

| | | | | |
|---|-----|-------------|----------------------------------|-----|
| - | 1 | 2844940-3 | AIR FEED MODULE | 238 |
| - | 1 | 467281-1 | RETAINER, SHEAR, FLOATING | 207 |
| - | 1 | 2161936-1 | HOLDER, SHEAR, FLOATING | 206 |
| - | 1 | 467500-1 | SHEAR, FLOATING | 205 |
| - | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 |
| - | 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 |
| - | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 2161937-1 | STABILIZER | 154 |
| - | 1 | 2119641-2 | FEED CAM, AIR FEED | 152 |
| - | 1 | 1-2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | 141 |
| - | 1 | 1803518-1 | RAM ASSEMBLY, EF PACIFIC | 140 |
| - | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 3-18032-3 | SCR, SET, FLT PNT, M3 X 20.0 | 70 |
| - | 1 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 69 |
| - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 3 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 |
| - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 |
| - | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 |
| - | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 |
| - | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 |
| - | 1 | 2352966-1 | FEED FINGER | 51 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 2 | 5-22278-1 | SPRING, COMPRESSION | 36 |
| - | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 31 |
| - | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 29 |
| - | 1 | 240639-1 | STRIPPER (MACHINING) | 27 |
| - | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 |
| - | 1 | 2161941-1 | PLATE, GUIDE, STRIP | 24 |
| - | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 2161948-1 | DRAG | 20 |
| - | 1 | 683736-1 | GUIDE, STRIP, REAR | 19 |
| - | 1 | 683737-1 | FRONT STRIP GUIDE | 18 |
| - | 1 | 4-22280-7 | SPRING, COMPRESSION | 13 |
| 1 | 1 | 2161935-1 | ANVIL, RIGHT HAND | 8 |
| - | 1 | 2161957-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2161331-1 | SPACER, WIRE FUNNEL DEPRESSOR | 2 |
| 1 | 1 | 467342-1 | CRIMPER, RIGHT HAND | 1 |

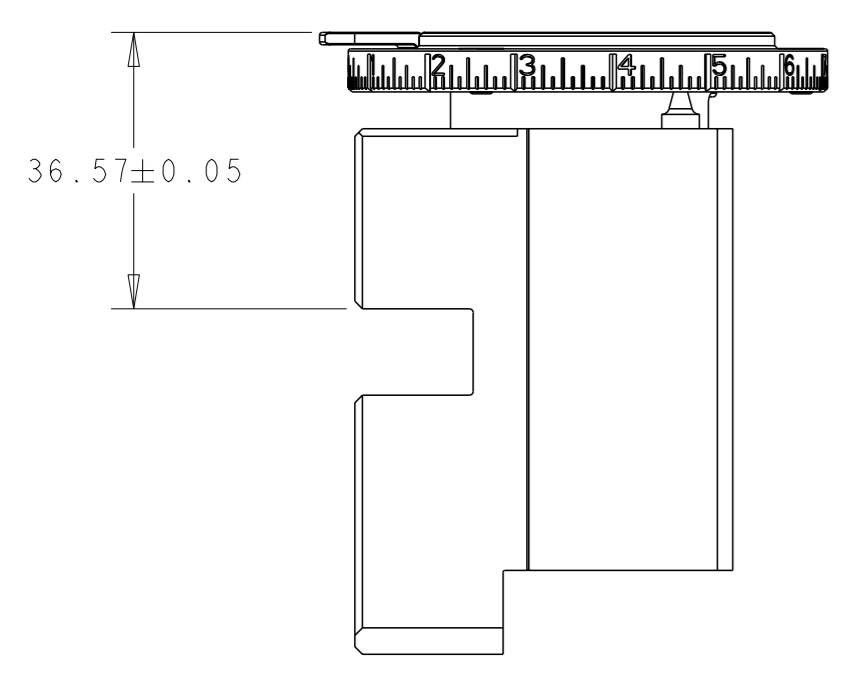
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|--|--------|--------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | | | SCALE | 1:1 |
| | | | | | | | | | | SHEET | 3 of 4 |



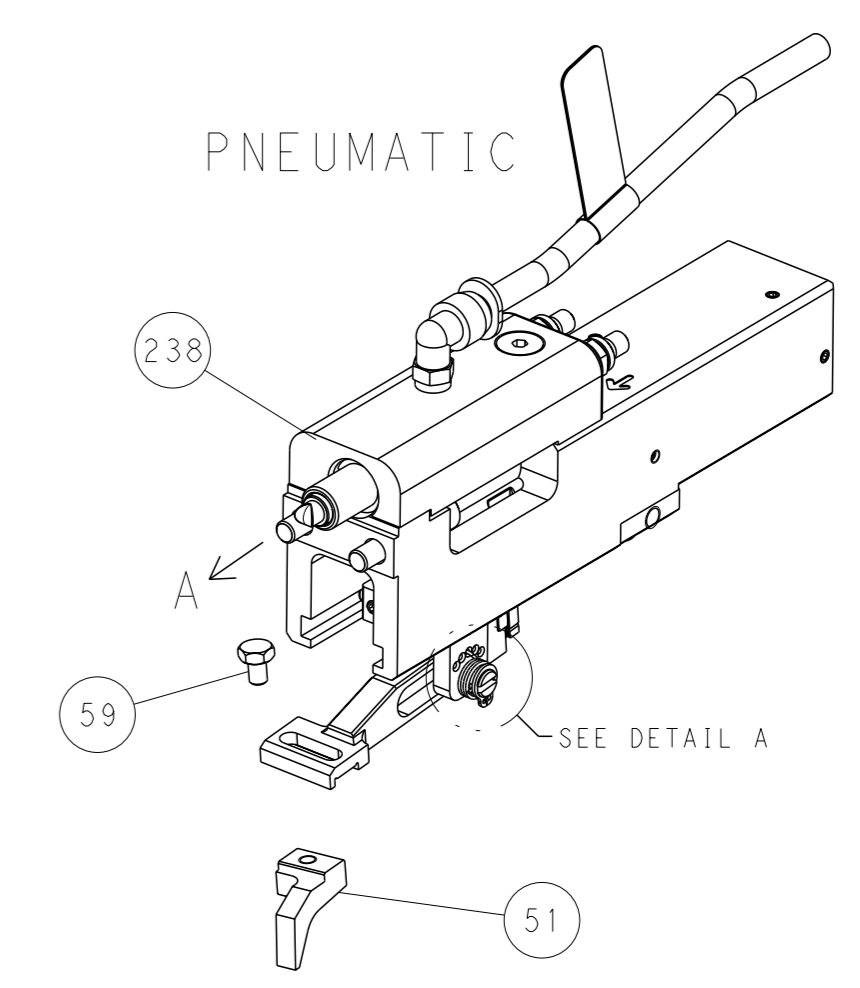
Customer Accessible Production Drawing
 SCALE 1:1 SHEET 3 of 4 REV C

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

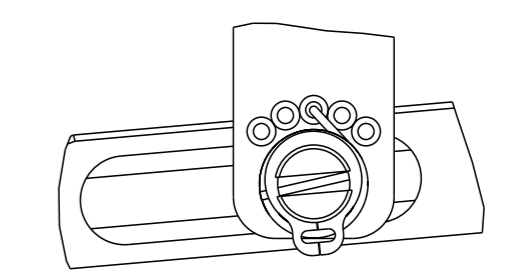


RAM SET-UP

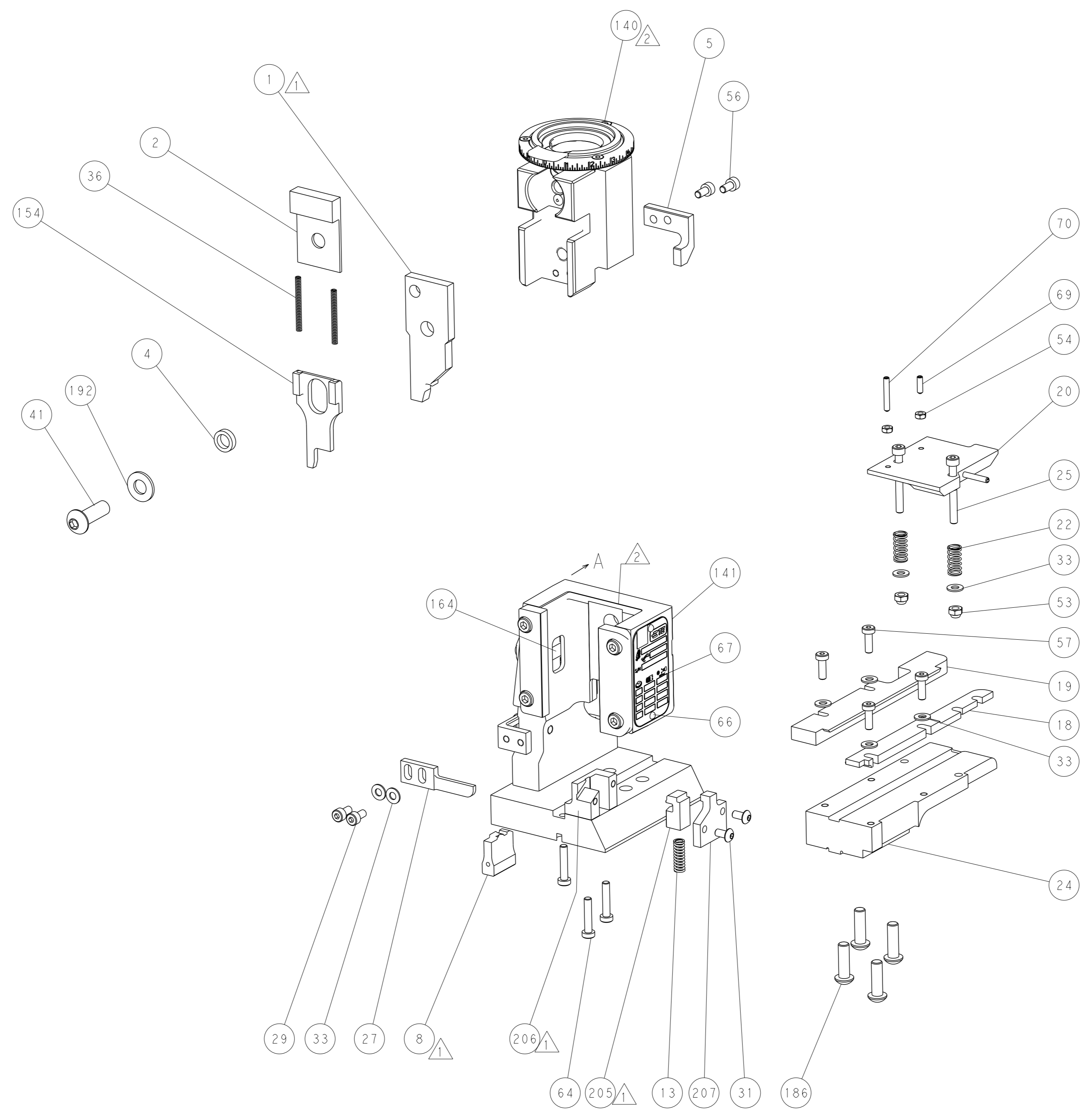
FEED TYPE



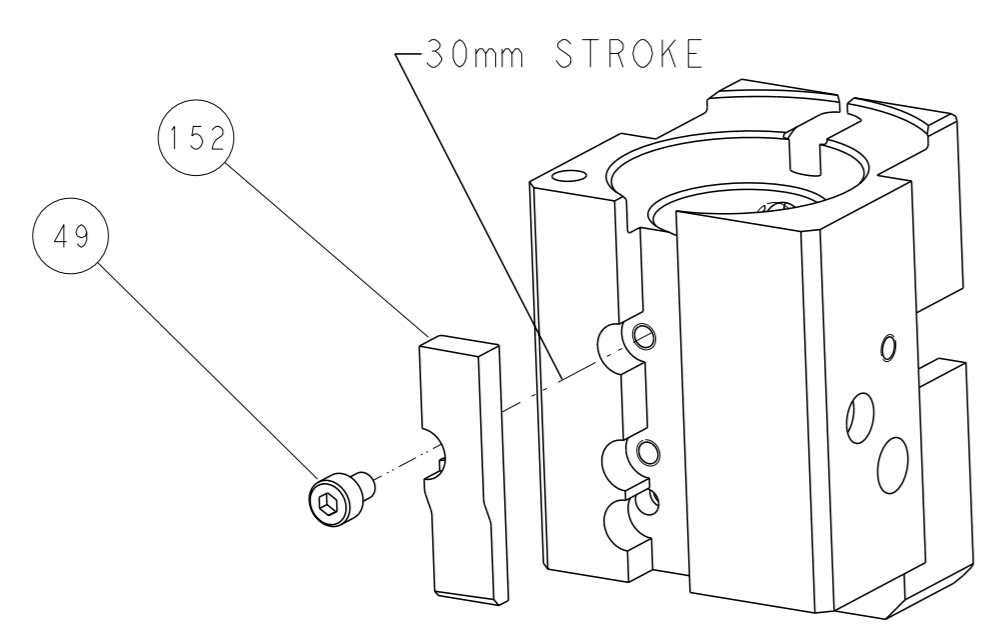
FEED SPRING SETTING POSITION



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 ITS CONTENTS ARE SUBJECT TO DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: HOFFNER 11APRIL2012 CHK: T. ELBIN 12APRIL2012 APVD: T. ELBIN 12APRIL2012 | 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=2150252 SCALE: 1:1 SHEET: 4 of 4 REV: C | RESTRICTED TO: |
| MATERIAL: | | WEIGHT: | Customer Accessible Production Drawing |