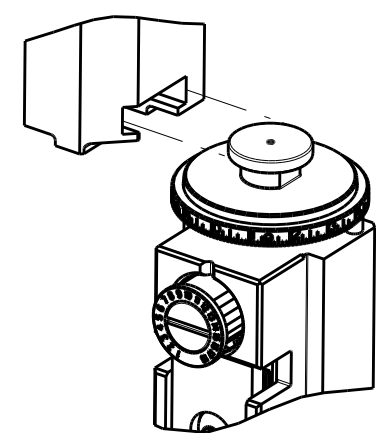


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150459-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150459-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150459-7	A	CRIMP TOOLING KIT	-

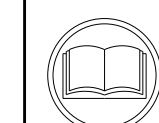
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTIN-ON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.72-6.48 mm [.225-.255 IN]		∅3.43-5.08 mm [1.35-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180352-1	1-180352-2	280080-1	280080-5
180352-2		280080-2	280080-4
180352-6			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.34 +/- 0.05 [.092 +/- .002]	4.4
5.00mm2	2.16 +/- 0.05 [.085 +/- .002]	6.3
4.00mm2	1.96 +/- 0.05 [.077 +/- .002]	8.5
1.5+1.5mm2	1.83 +/- 0.05 [.072 +/- .002]	9.7



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

**\*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.

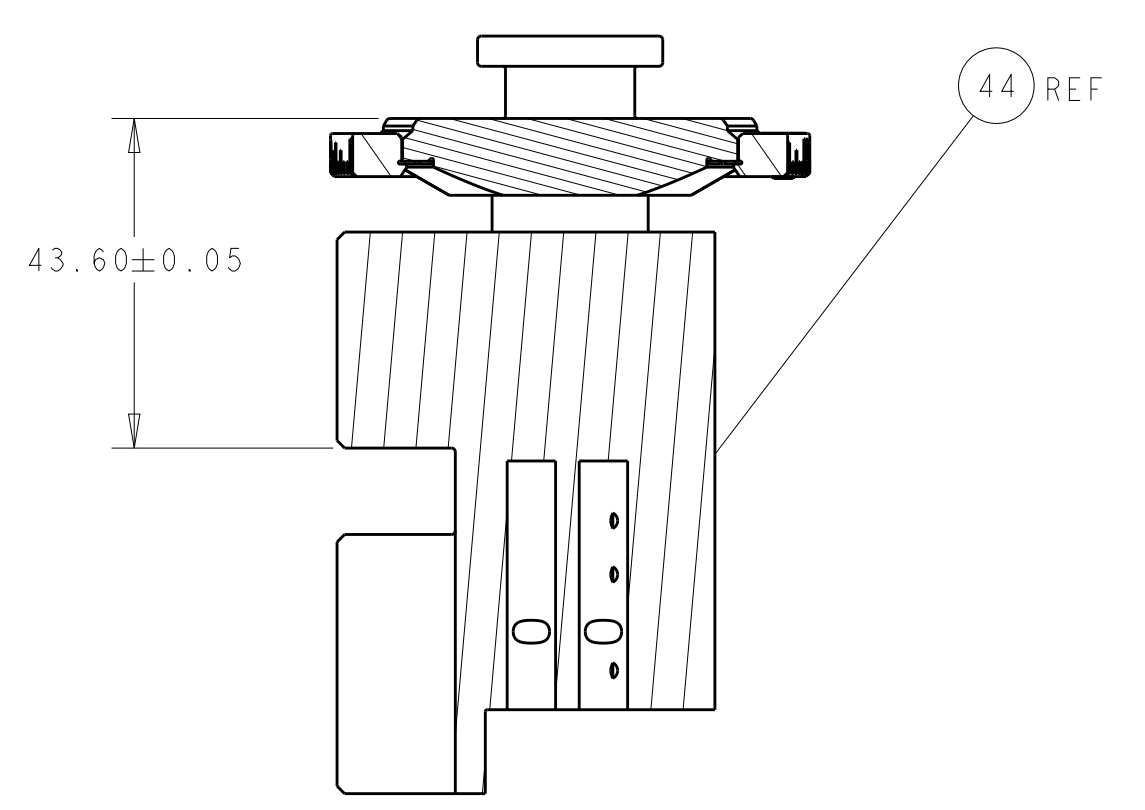
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		A	RELEASED	17OCT2014	RW GB
		A1	ECR-19-010615	08JUL2019	FZ GB
		B	ECR-19-019908	23DEC2019	FZ TE

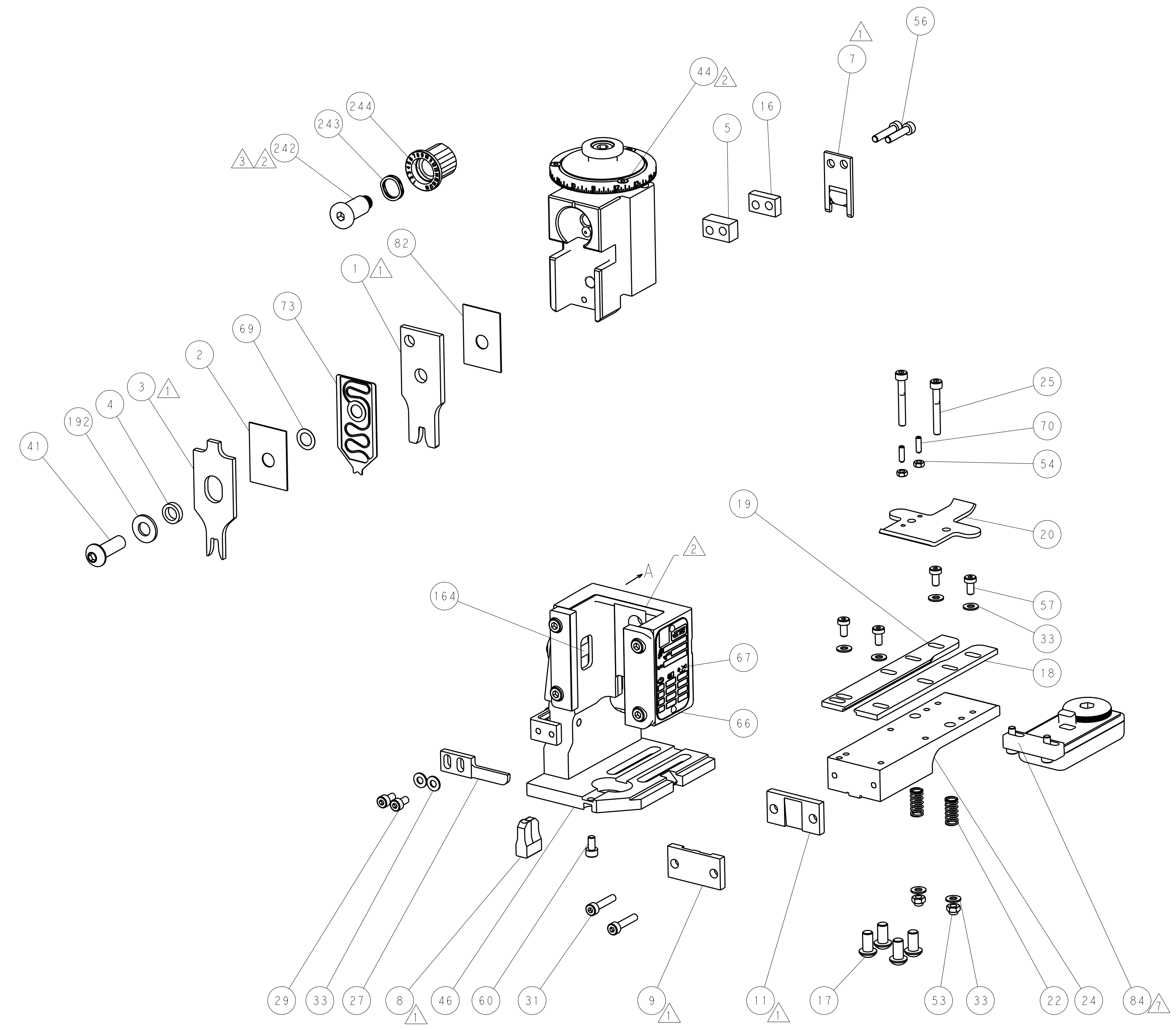
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	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	
-	-	-	2063961-1	FEED FINGER	58	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2063961-1	FEED FINGER	51	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	-	2119653-1	FEED CAM, POST FEED	47	
-	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	
-	8	8	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	1-1752371-6	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1901696-4	STRIP GUIDE, REAR	19	
-	1	1	1901695-4	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1-240641-4	SPACER	16	
	1	1	1-240644-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	5-690482-0	PLATE, FRONT SHEAR	9	
	1	2	1	5-1803001-8	ANVIL, COMBINATION, END FEED	8
	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	5-240641-1	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	1	1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-5	SPACER, CRIMPER	2
	1	2	1	456414-9	CRIMPER, WIRE	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
THE DRAWING IS CONTROLLED THROUGH THE QUALITY CONTROL AND TESTING ORGANIZATION. IT IS THE DUTY OF THE USER TO CONTACT THE QUALITY CONTROL ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: R. O. WILSON 01AUG2014 CHK: K. J. STARKEM 04AUG2014 APVD: T. L. ELBIN 05AUG2014		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150459 RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:1 SHEET: 1 OF 4 REV: B	

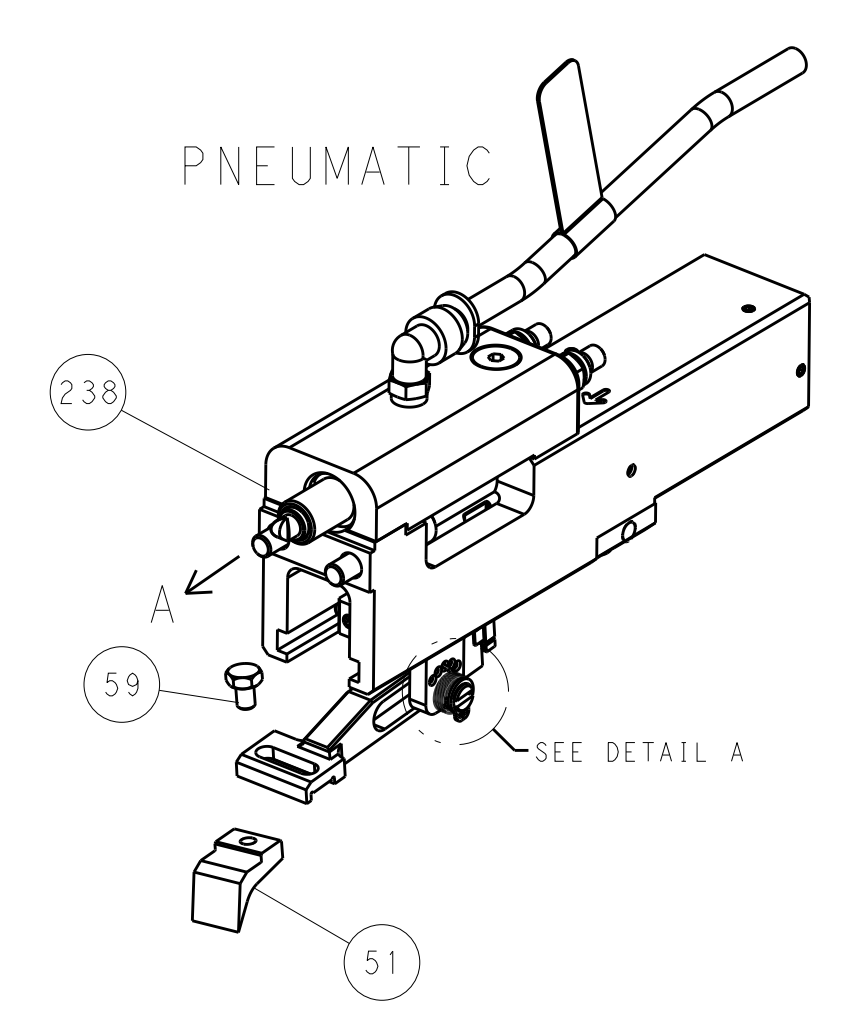
LOC	DIST	REV	DATE	BY	APPV
A	66				



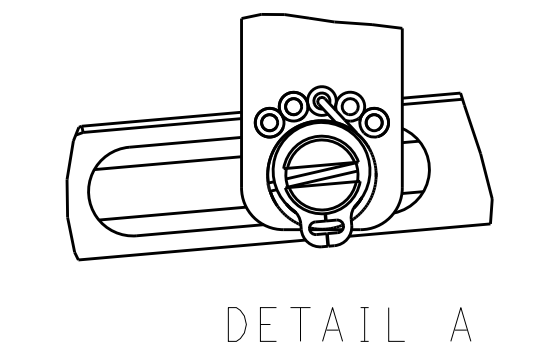
RAM SET-UP



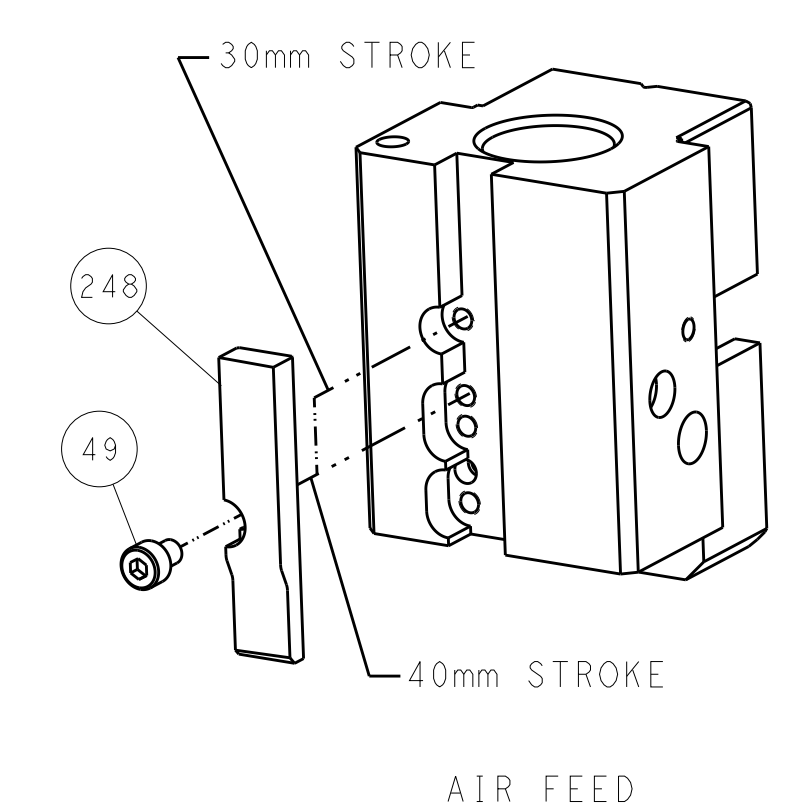
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

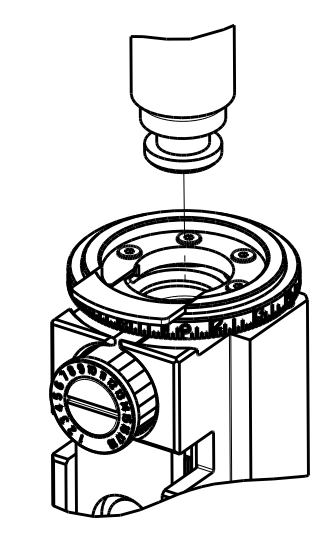


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		DWN: R. O. WILSON 01AUG2014 CHK: K. J. STAKEM 04AUG2014 APVD: T. L. ELBIN 05AUG2014 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150459 SHEET 2 OF 4 REV B	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150459-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150459-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [ .160 ]	F
INSUL	5.33 mm [ .210 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FAST-IN-ON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.72-6.48 mm [ .225-.255 IN ]		∅3.43-5.08 mm [ 1.135-.200 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-20021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180352-1	1-180352-2	280080-1	280080-5
180352-2		280080-2	280080-4
180352-6			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.34 +/- 0.05 [ .092 +/- .002 ]	4.4
5.00mm2	2.16 +/- 0.05 [ .085 +/- .002 ]	6.3
4.00mm2	1.96 +/- 0.05 [ .077 +/- .002 ]	8.5
1.5+1.5mm2	1.83 +/- 0.05 [ .072 +/- .002 ]	9.7

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

**\*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.

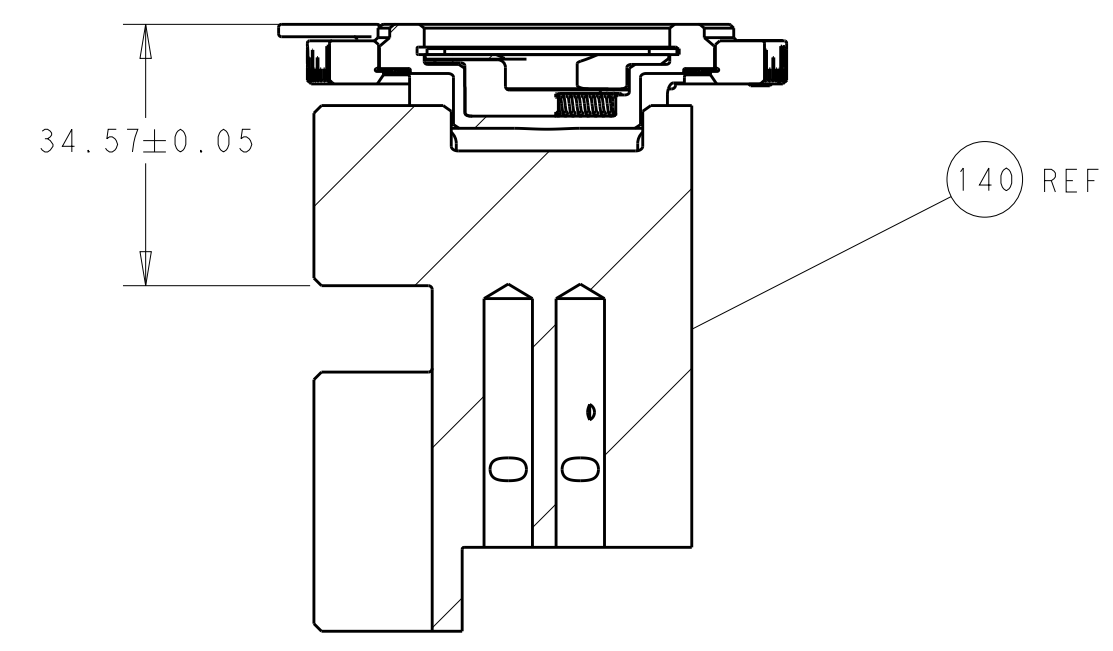
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

QTY	REV	PART NO	DESCRIPTION	ITEM NO
-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	2844940-4	AIR FEED MODULE	238
-	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	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	2119653-2	FEED CAM, POST FEED	142
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	2063961-1	FEED FINGER	58
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	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	1-1752371-6	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1901696-4	STRIP GUIDE, REAR	19
-	1	1901695-4	STRIP GUIDE, FRONT	18
-	1	1-240641-4	SPACER	16
-	1	1-240644-7	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	5-690482-0	PLATE, FRONT SHEAR	9
-	1	5-1803001-8	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6
-	1	5-240641-1	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
-	1	456414-9	CRIMPER, WIRE	1

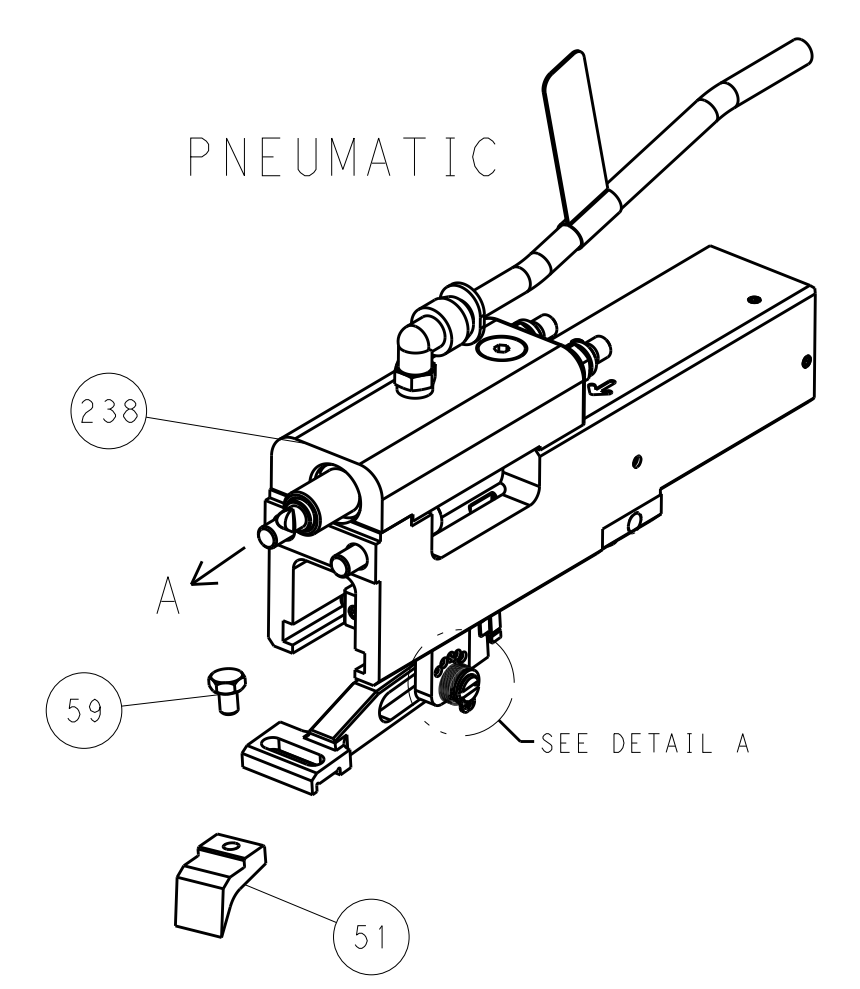
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN R. O. WILSON 01AUG2014 CHK K. J. STARKEM 04AUG2014 APVD T. L. ELBIN 05AUG2014		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150459		RESTRICTED TO: - SCALE: 1:1 SHEET: 3 OF 4 REV: B	
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

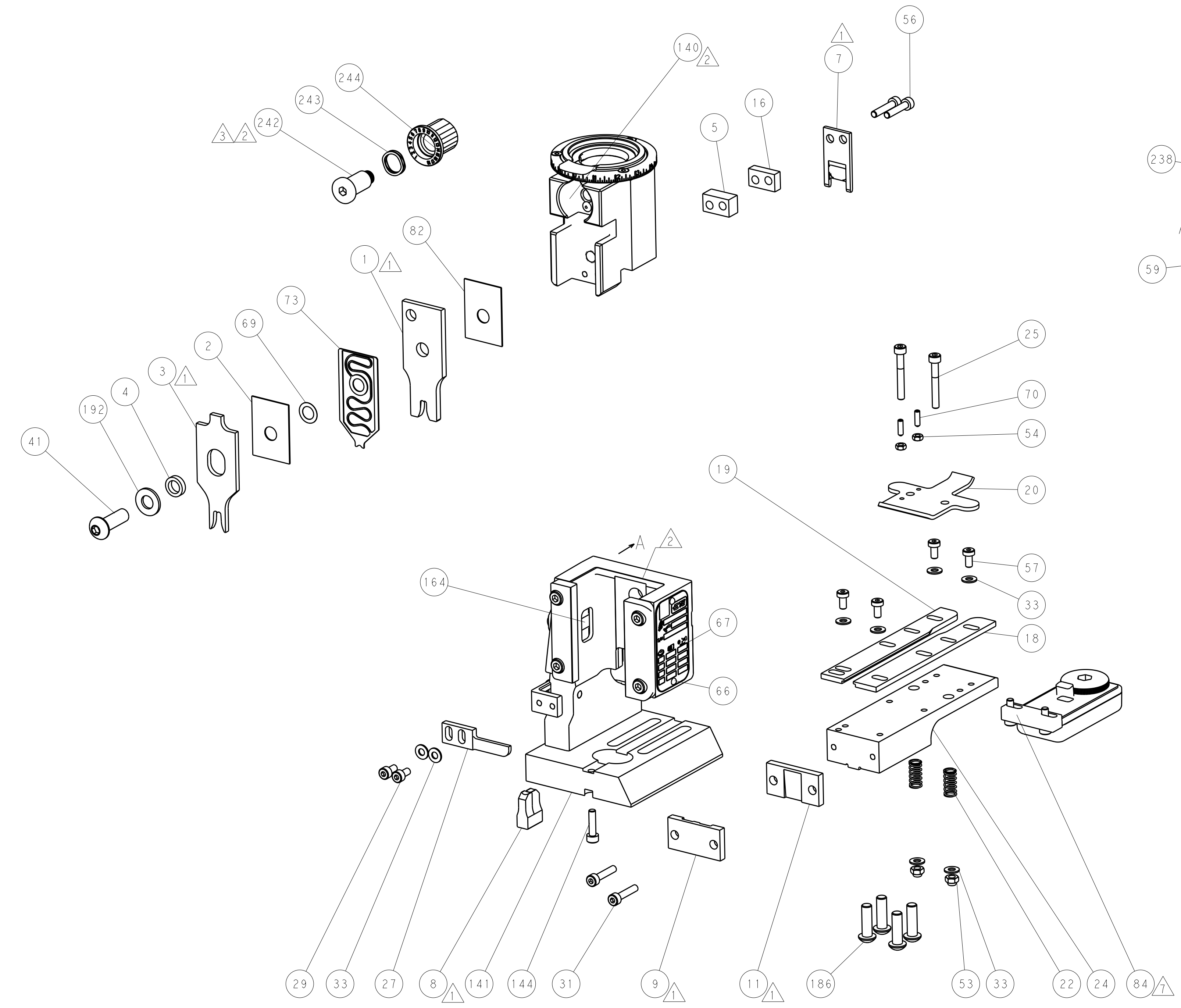
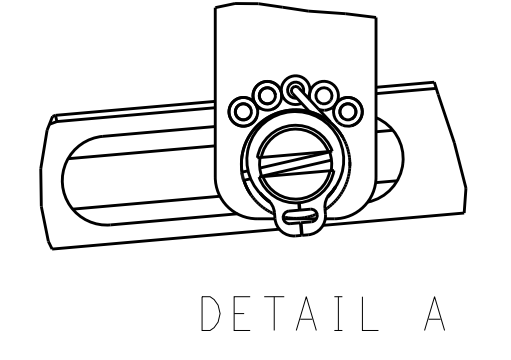


RAM SET-UP

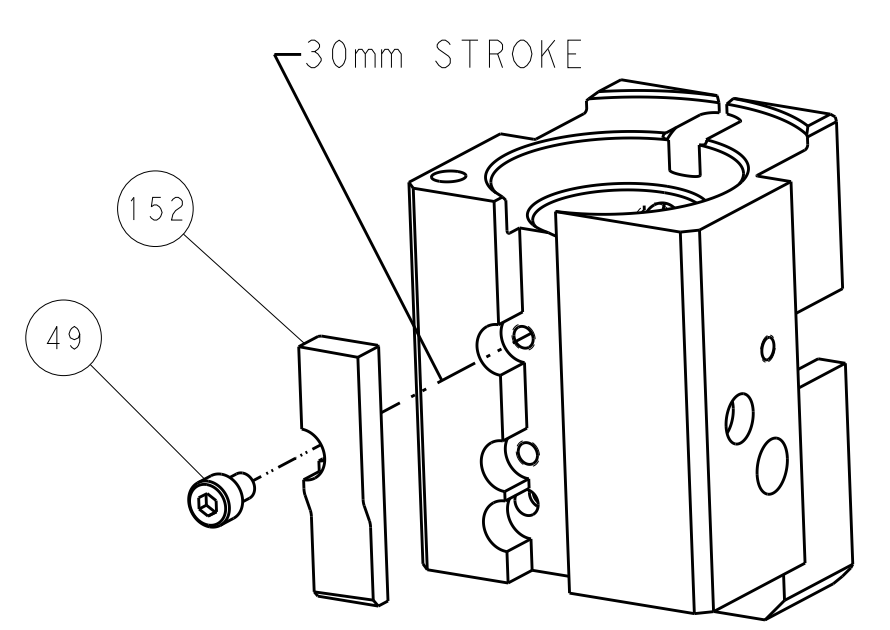
FEED TYPE



FEED SPRING SETTING POSITION



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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. Q. WILSON 01AUG2014 CHK: K. J. STAKEM 04AUG2014 APVD: T. L. ELBIN 05AUG2014	NAME: Ocean End Feed Applicator SIZE: A CAGE CODE: 00779 DRAWING NO: 2150459 SCALE: 1:1 SHEET: 4 OF 4 REV: B
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: RESTRICTED TO:	STE TE Connectivity Harrisburg, PA 17105-3608	CUSTOMER ACCESSIBLE PRODUCTION DRAWING