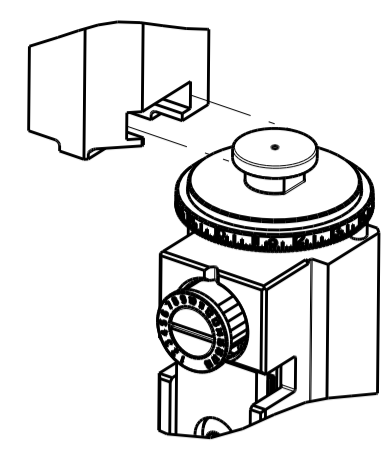


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150064-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150064-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150064-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150064-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150064-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE 250 SERIES FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.85-5.61 mm [.191-.221 IN]		∅2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170096-1	170096-2	170183-1	170183-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.42 +/- 0.05 [.056 +/- .002]	5.6
0.50mm2	1.30 +/- 0.05 [.051 +/- .002]	7.0
0.30mm2	1.24 +/- 0.05 [.049 +/- .002]	7.6

- △ 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.
- 5. 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.

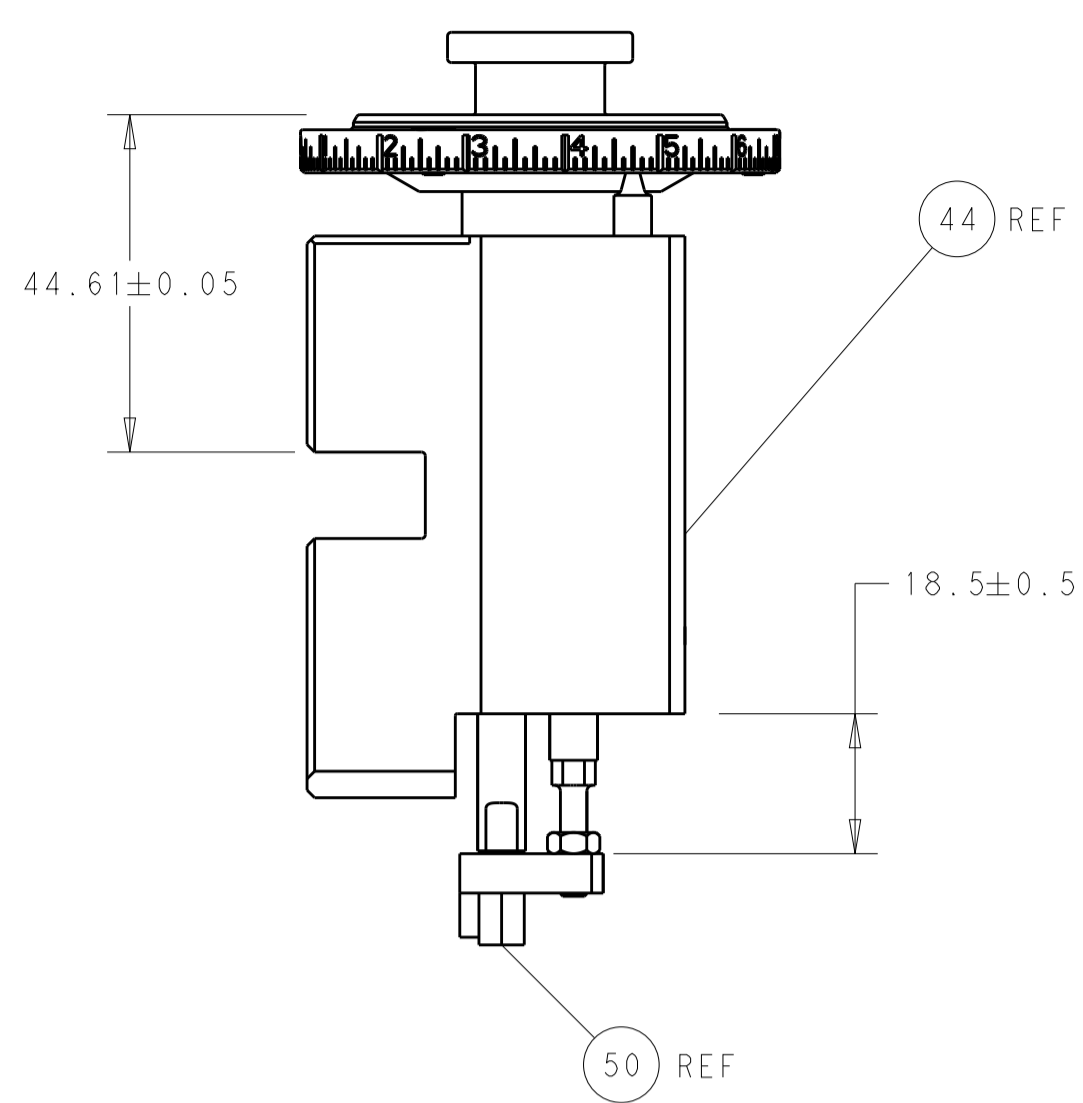
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		2		REVISED	25APR2013	XZ	LZ
		3		REVISED	15JUL2014	BH	BH
		A		RELEASED	14AUG2014	YY	UG
		B		ECR-19-011837	26JUL2019	TB	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	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	-	2844940-4	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	455888-5	SPACER, CRIMPER	82	
-	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2063961-2	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752354-2	STANDOFF,HOLD-DOWN	50	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	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	
-	8	8	8	8	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	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240641-5	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
△	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
△	1	1	1	1	2-690482-9	PLATE, FRONT SHEAR	9	
△	1	2	2	1	1	7-1633384-0	ANVIL, COMBINATION	8
△	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
△	1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
△	1	2	2	1	1	2-456406-0	CRIMPER, WIRE PREMIUM	1
					-77-72-71-2-1	PART NO	DESCRIPTION	ITEM NO

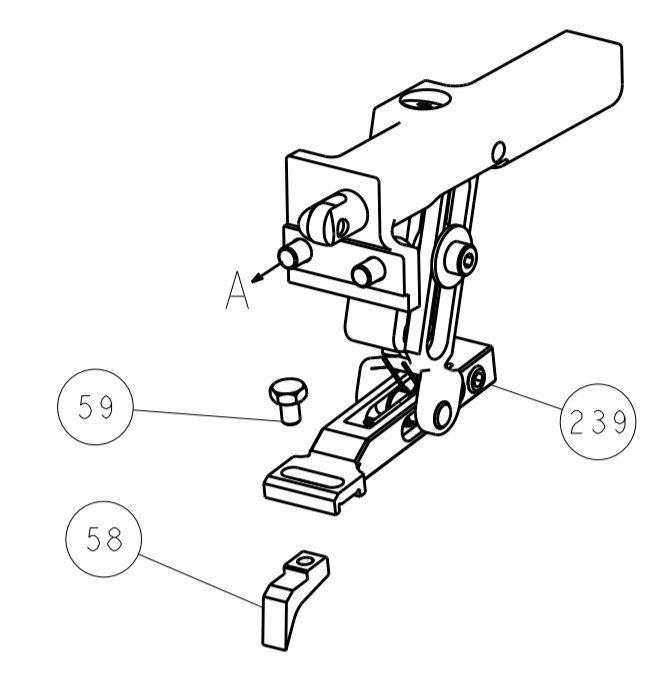
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
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		1 PLC ±		13FEB2012		13FEB2012		13FEB2012		Harrisburg, PA 17105-3608	
		2 PLC ±								Ocean End Feed	
		3 PLC ±								Applicator	
		4 PLC ±								-	
		ANGLES ±								SIZE	
		FINISH								CAGE CODE	
										DRAWING NO	
										RESTRICTED TO	
										WEIGHT	
										A1 00779	
										SCALE	
										1:1	
										SHEET	
										1 OF 4	
										REV	
										B	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

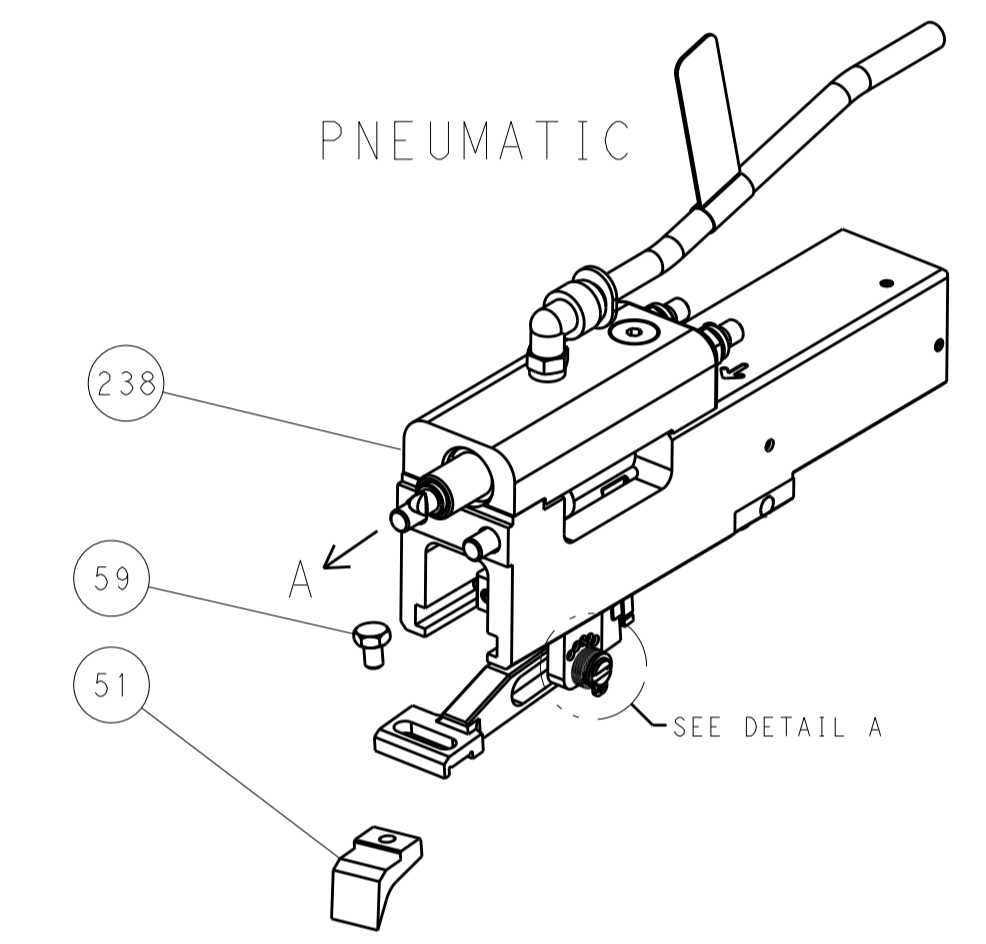


RAM AND HOLDDOWN SET-UP

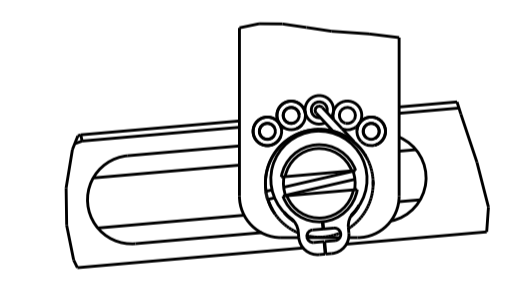
FEED TYPE
MECHANICAL



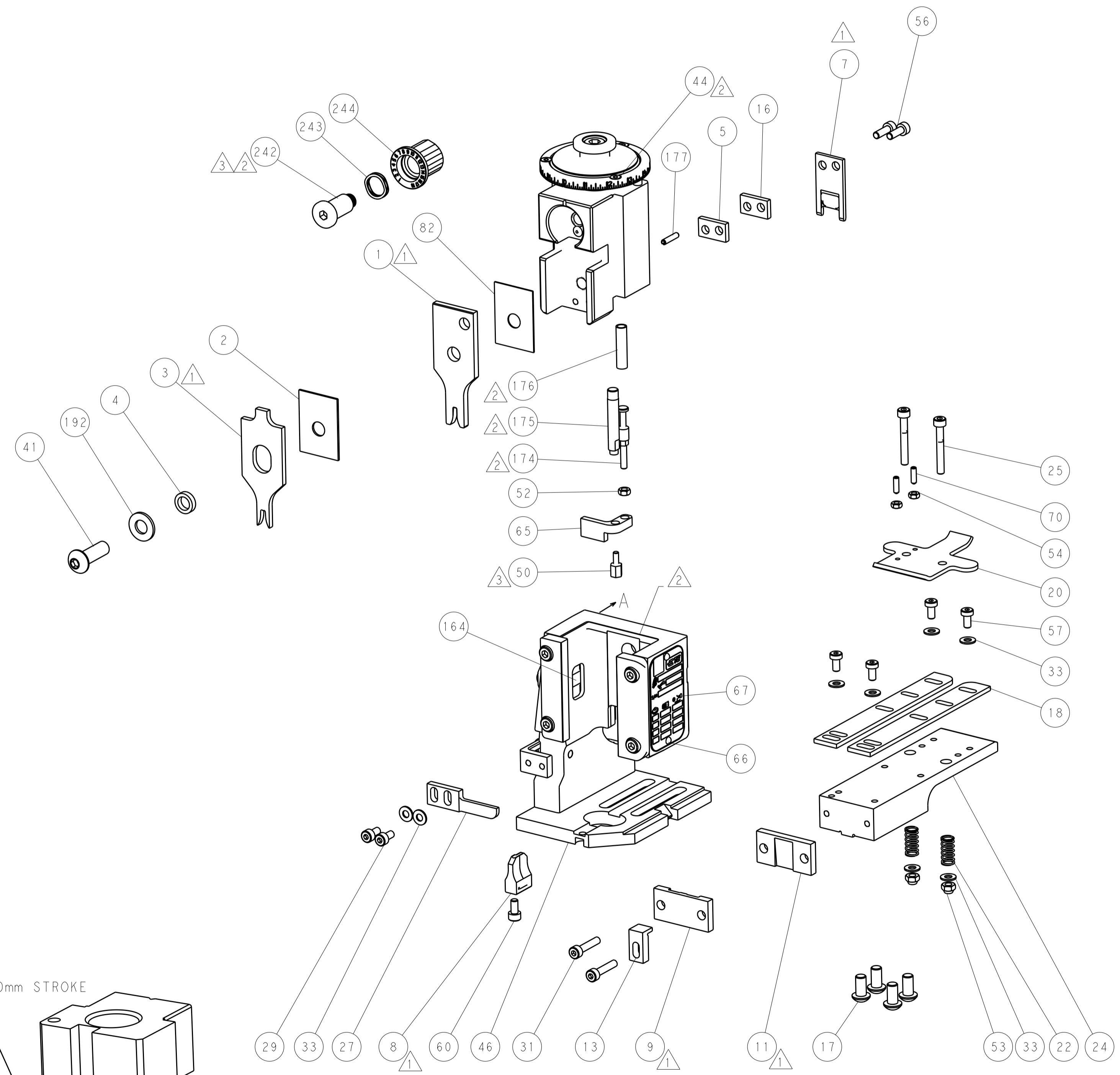
PNEUMATIC



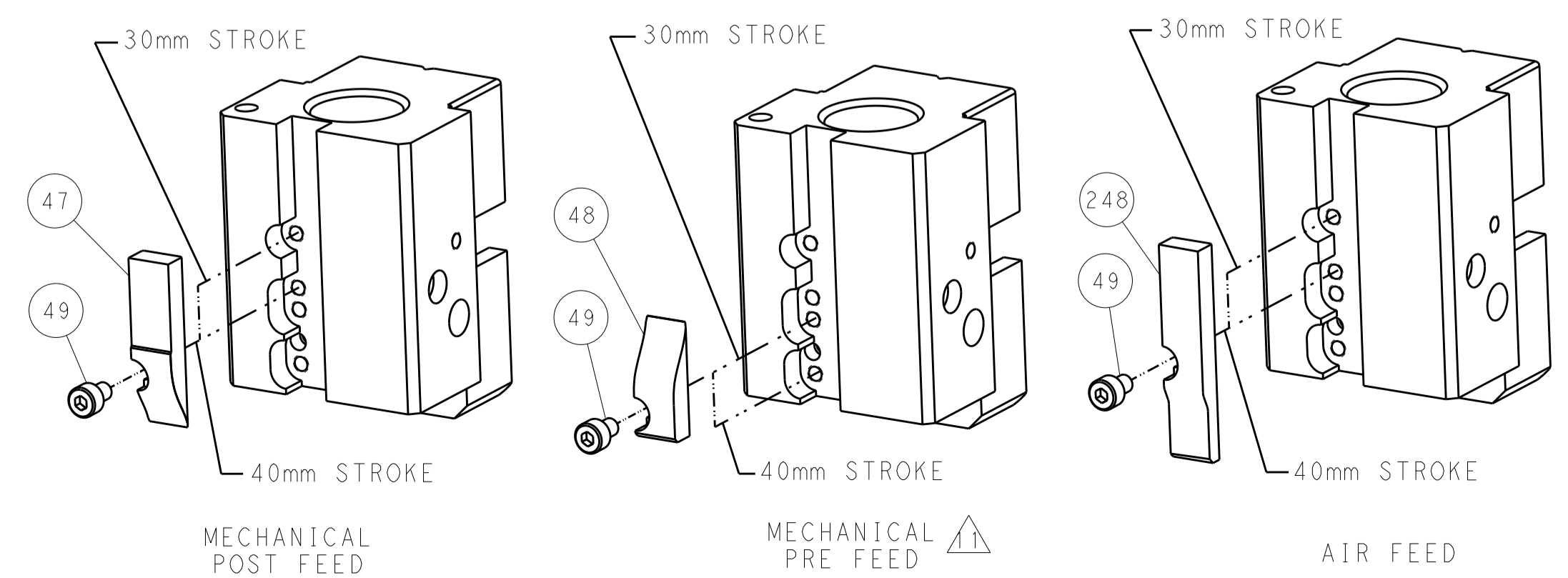
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS

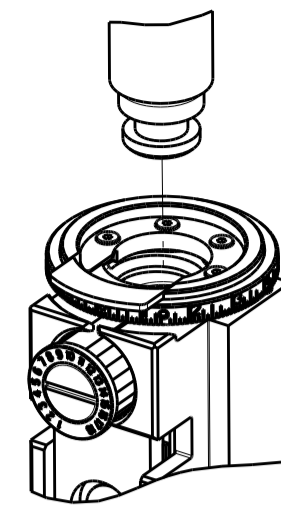


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		TE Connectivity	
mm		0 PLC ±		Y. YIN		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		13FEB2012		NAME	
H		2 PLC ±		G. BAILEY		Ocean End Feed	
A		3 PLC ±		13FEB2012		Applicator	
B		4 PLC ±		S. XI		SIZE	
C		5 PLC ±		13FEB2012		CAGE CODE	
D		6 PLC ±		13FEB2012		DRAWING NO	
E		7 PLC ±		13FEB2012		RESTRICTED TO	
F		8 PLC ±		13FEB2012		A1 00779	
G		9 PLC ±		13FEB2012		©=2150064	
H		10 PLC ±		13FEB2012		SCALE	
I		11 PLC ±		13FEB2012		1:1	
J		12 PLC ±		13FEB2012		SHEET	
K		13 PLC ±		13FEB2012		2 of 4	
L		14 PLC ±		13FEB2012		REV	
M		15 PLC ±		13FEB2012		B	
N		16 PLC ±		13FEB2012		Customer Accessible Production Drawing	
O		17 PLC ±		13FEB2012		Customer Accessible Production Drawing	
P		18 PLC ±		13FEB2012		Customer Accessible Production Drawing	
Q		19 PLC ±		13FEB2012		Customer Accessible Production Drawing	
R		20 PLC ±		13FEB2012		Customer Accessible Production Drawing	
S		21 PLC ±		13FEB2012		Customer Accessible Production Drawing	
T		22 PLC ±		13FEB2012		Customer Accessible Production Drawing	
U		23 PLC ±		13FEB2012		Customer Accessible Production Drawing	
V		24 PLC ±		13FEB2012		Customer Accessible Production Drawing	
W		25 PLC ±		13FEB2012		Customer Accessible Production Drawing	
X		26 PLC ±		13FEB2012		Customer Accessible Production Drawing	
Y		27 PLC ±		13FEB2012		Customer Accessible Production Drawing	
Z		28 PLC ±		13FEB2012		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150064-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150064-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150064-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.30 mm (.130)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE 250 SERIES FASTON			
WIRE STRIP LENGTH 4.85-5.61 mm (.191-.221 IN)	INSULATION DIAMETER RANGE Ø2.30-3.30 mm (.091-.130 IN)		
TERMINAL APPLICATION SPECIFICATION 114-5084			
TERMINALS APPLIED			
TE TERMINAL 170096-1	TE TERMINAL 170096-2	TE TERMINAL 170183-1	TE TERMINAL 170183-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.42 +/- 0.05 [.056 +/- .002]	5.6
0.50mm2	1.30 +/- 0.05 [.051 +/- .002]	7.0
0.30mm2	1.24 +/- 0.05 [.049 +/- .002]	7.6

- 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.
- 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.

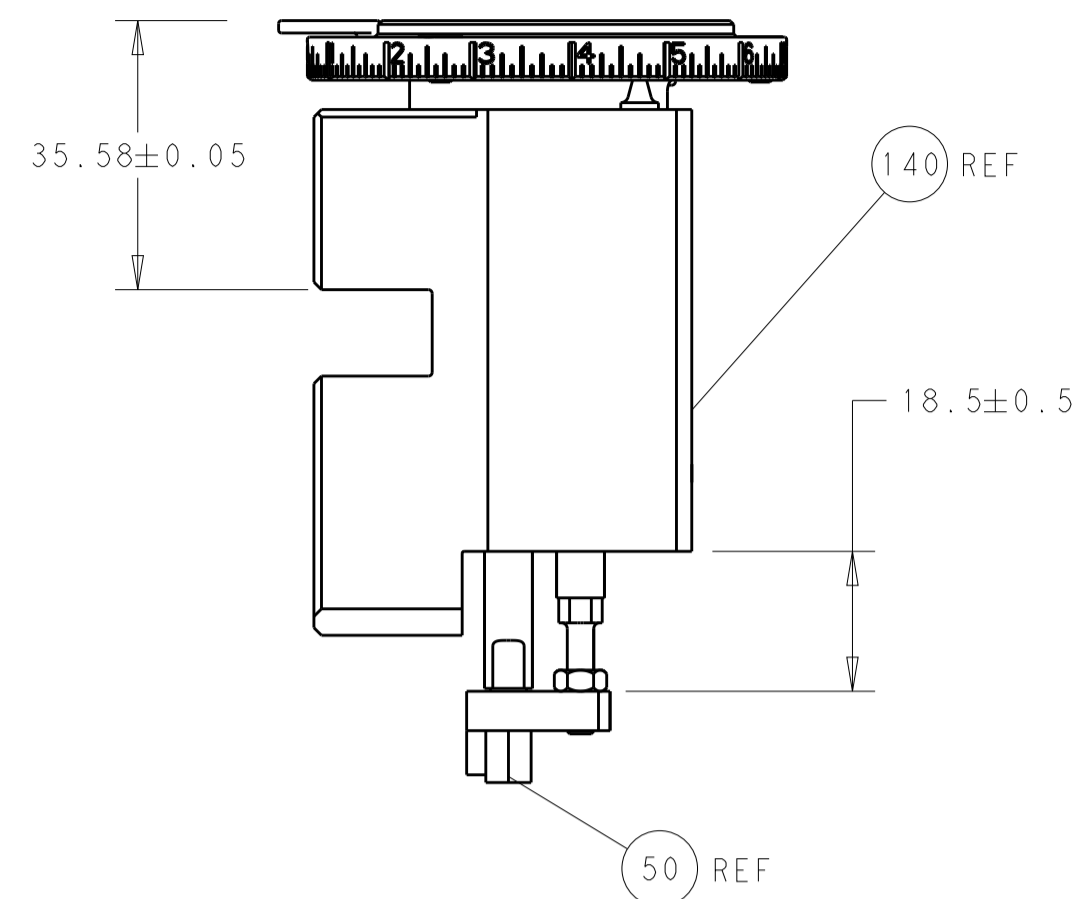
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	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
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-2	FEED FINGER	58
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	FEED FINGER	51
-	1	1	1-1752354-2	STANDOFF, HOLD-DOWN	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	240641-5	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	2-690482-9	PLATE, FRONT SHEAR	9
-	1	1	7-1633384-0	ANVIL, COMBINATION	8
-	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	240641-5	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	2-456406-0	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO

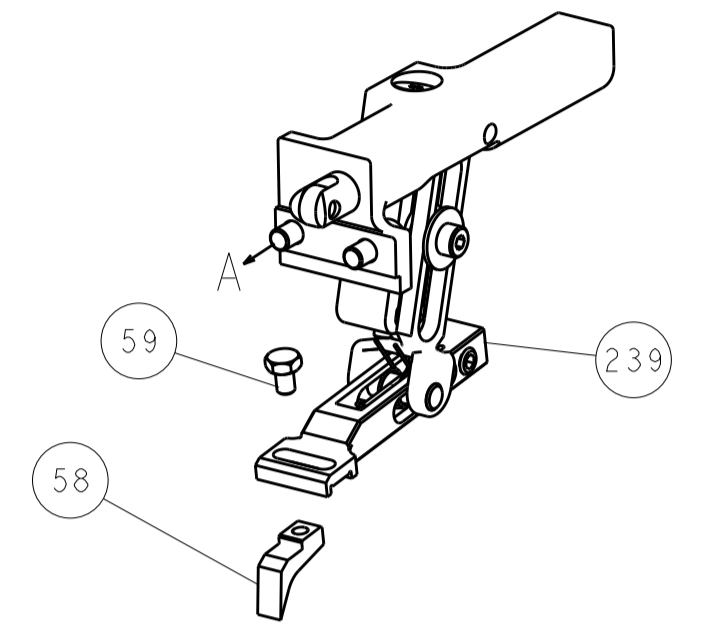
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 13FEB2012		CHK G. BAILEY 13FEB2012		APVD S. XI 13FEB2012		NAME	
0 PLC	±	1 PLC	±	TE Connectivity		Harrisburg, PA 17105-3608		PRODUCT SPEC		Ocean End Feed Applicator	
2 PLC	±	3 PLC	±	SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
4 PLC	±	ANGLES	±	A1		00779		©=2150064		-	
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing		SCALE		1:1		SHEET 3 OF 4 REV B	

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

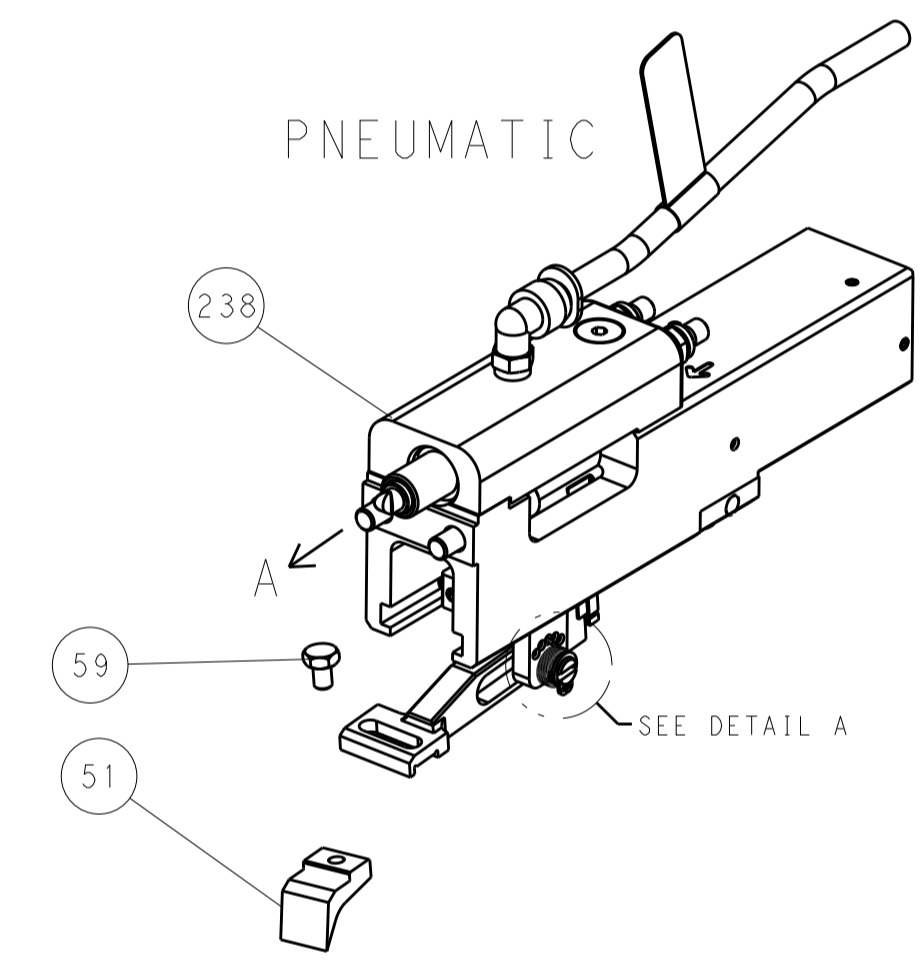


RAM AND HOLDDOWN SET-UP

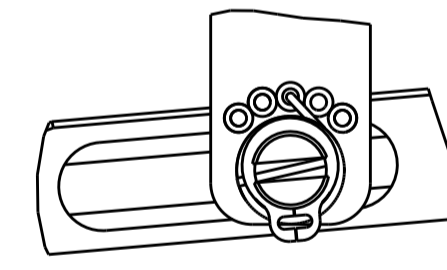
FEED TYPE
MECHANICAL



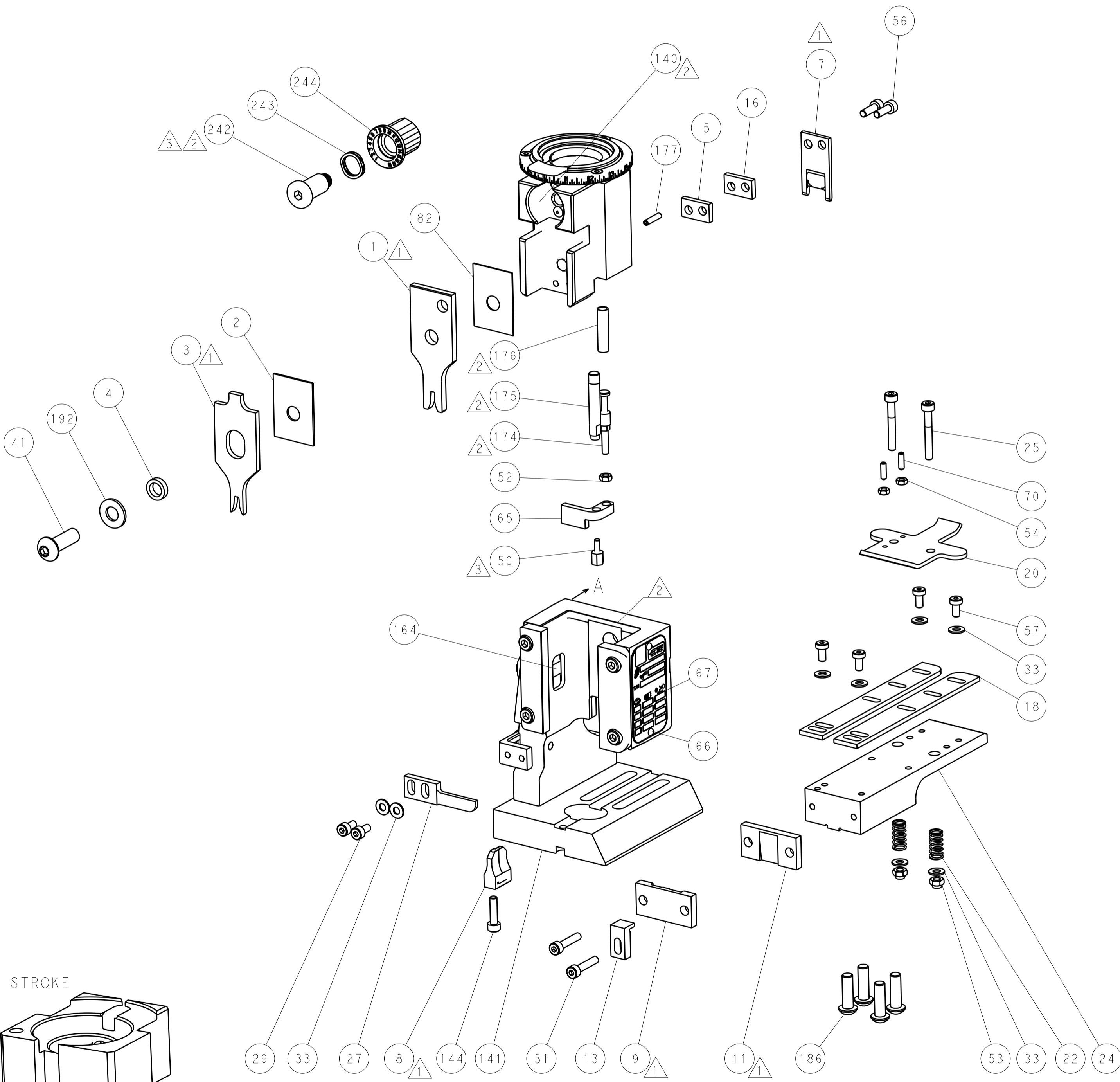
PNEUMATIC



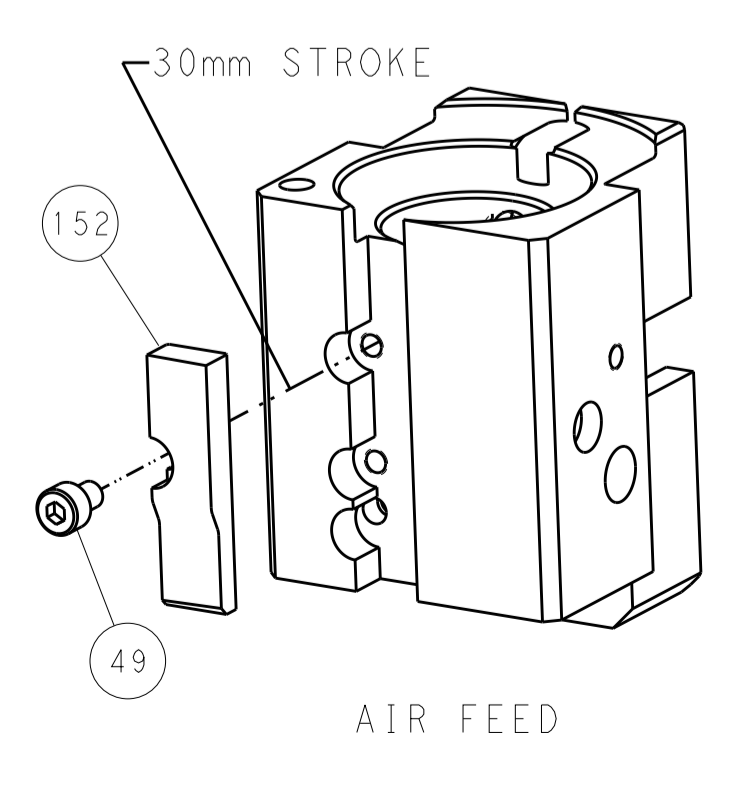
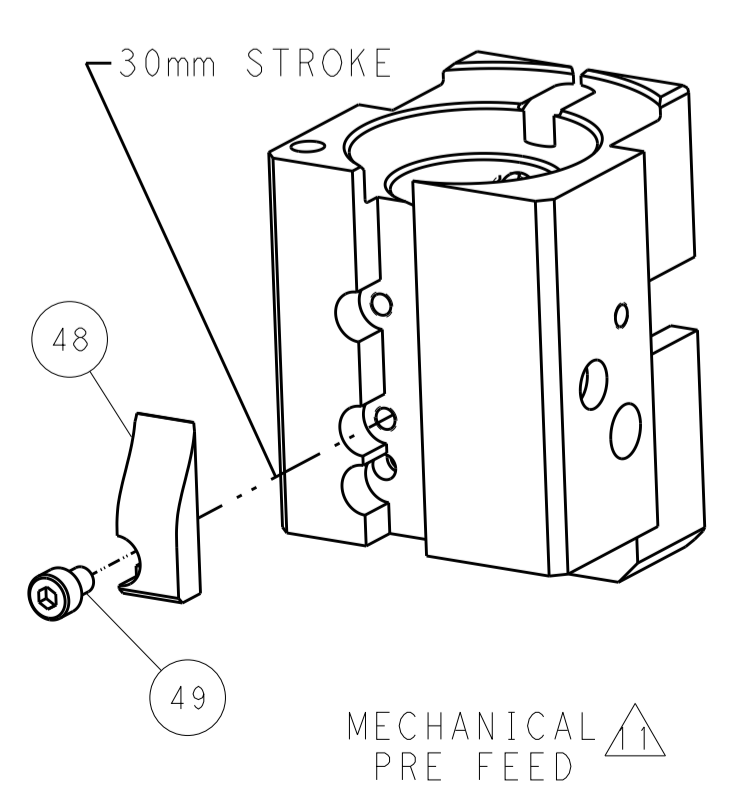
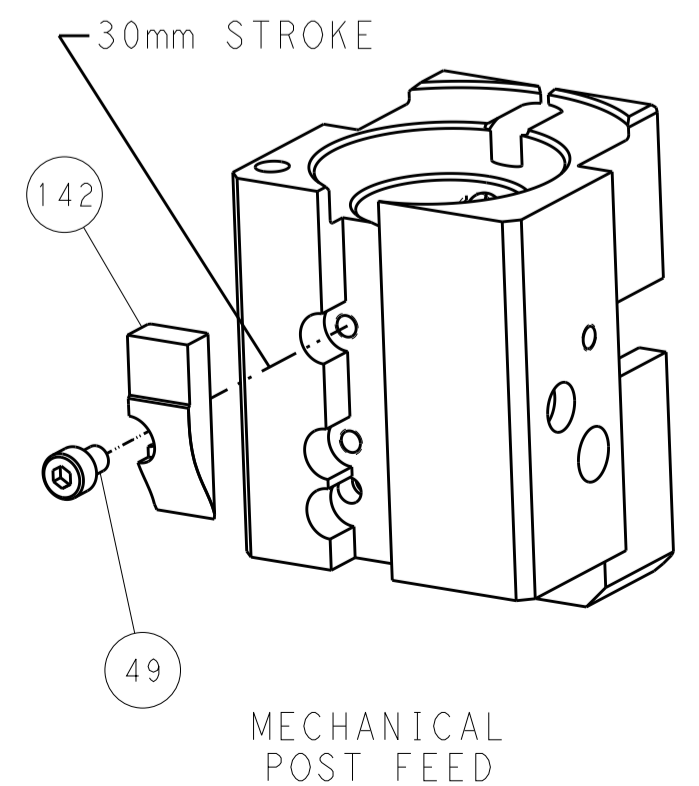
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A



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: Y. YIN 13FEB2012		 TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK: G. BAILEY 13FEB2012	NAME	
	1 PLC	±		APVD: S. XI 13FEB2012	PRODUCT SPEC	
	2 PLC	±			APPLICATION SPEC	
MATERIAL:		FINISH:		SIZE: A	CAGE CODE: 00779	DRAWING NO: C=2150064
				RESTRICTED TO:	SCALE: 1:1	SHEET 4 OF 4 REV B