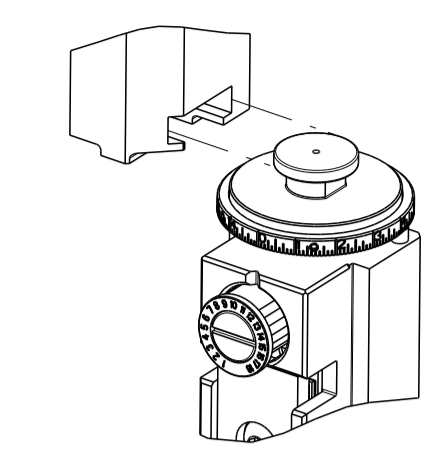


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150378-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150378-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150378-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150378-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150378-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES AUTOMOTIVE POS LOCK RECEP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.20 mm [.165-.205 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5060	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170454-1	170454-2	85069-2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES AUTOMOTIVE POS LOCK RECEP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.20 mm [.165-.205 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5060	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170454-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.86+/-0.05 [.073+/-0.002]	4.5
16 AWG OR 1.25mm2	1.62+/-0.05 [.064+/-0.002]	6.9
18 AWG OR 0.85mm2	1.50+/-0.05 [.059+/-0.002]	8.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.54+/-0.05 [.061+/-0.002]	7.7

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. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
6. THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
7. 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.

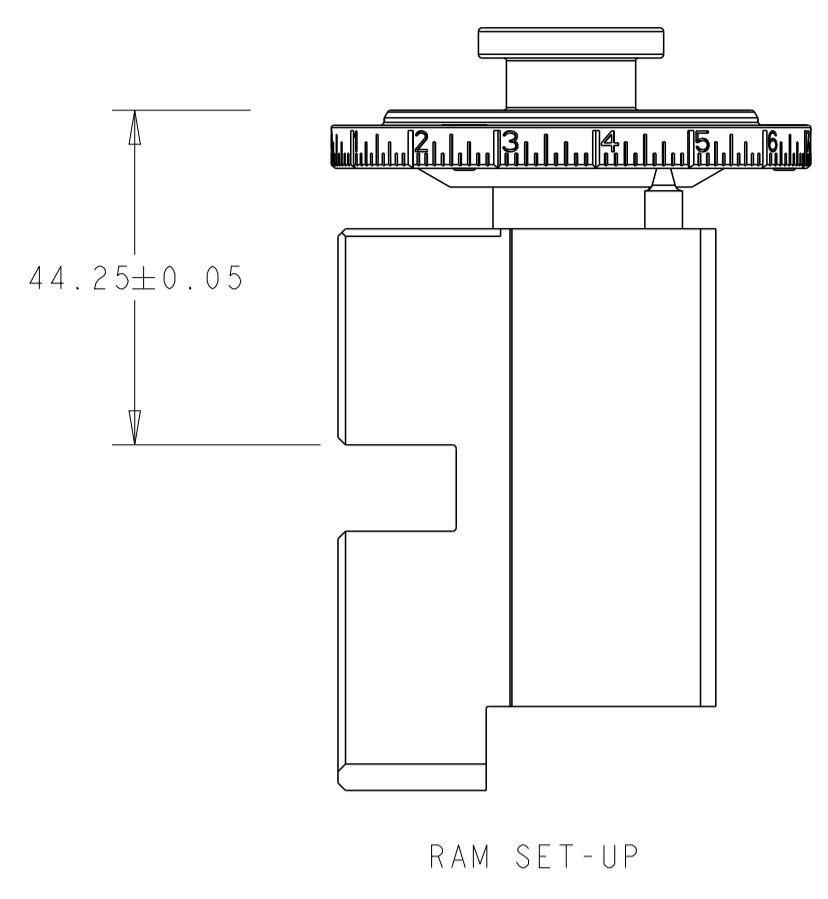
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		B1		ECR-17-001723	23FEB2017	MZ	KZ
		C		ECR-18-014745	17SEP2018	JAH	TE
		D		ECR-19-011044	13JUL2019	TB	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-4	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	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	-	2063961-9	FEED FINGER	51	
-	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	
-	7	7	7	7	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	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	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	4-240641-5	SPACER	16	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1-1333219-4	ANVIL, COMBINATION	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-6	SPACER	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	4-2119582-9	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	2	1	456408-2	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

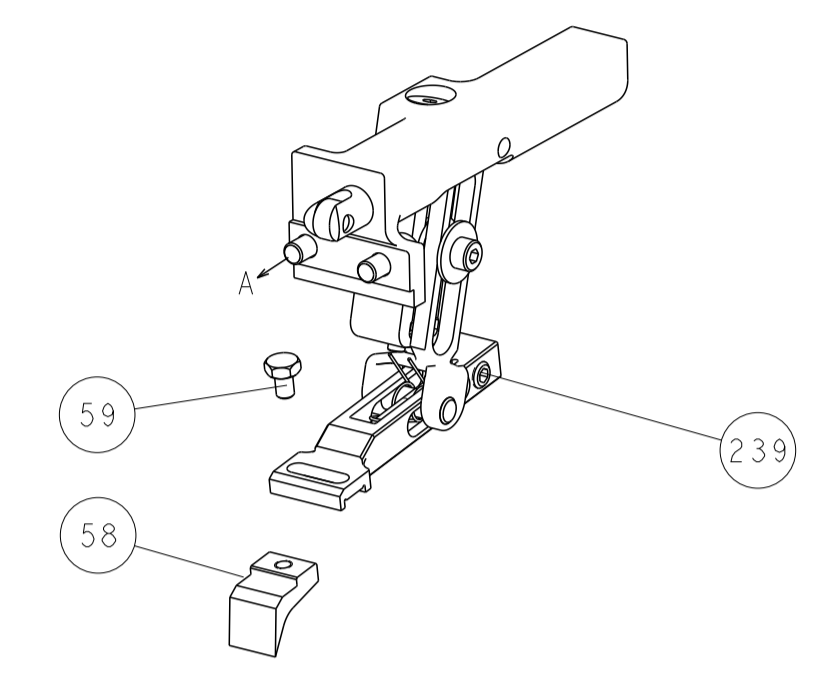
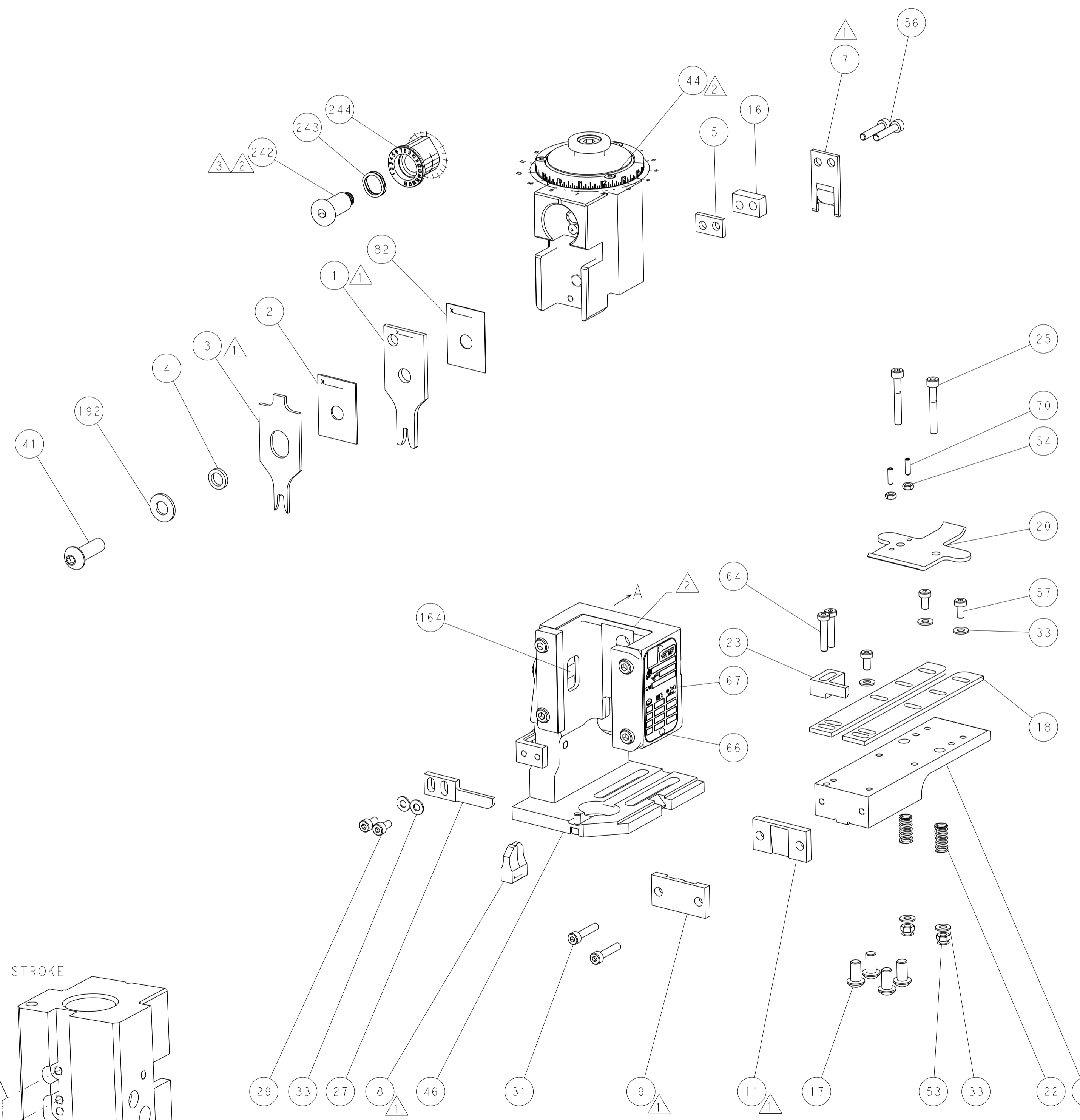
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 1 OF 4		REV D	

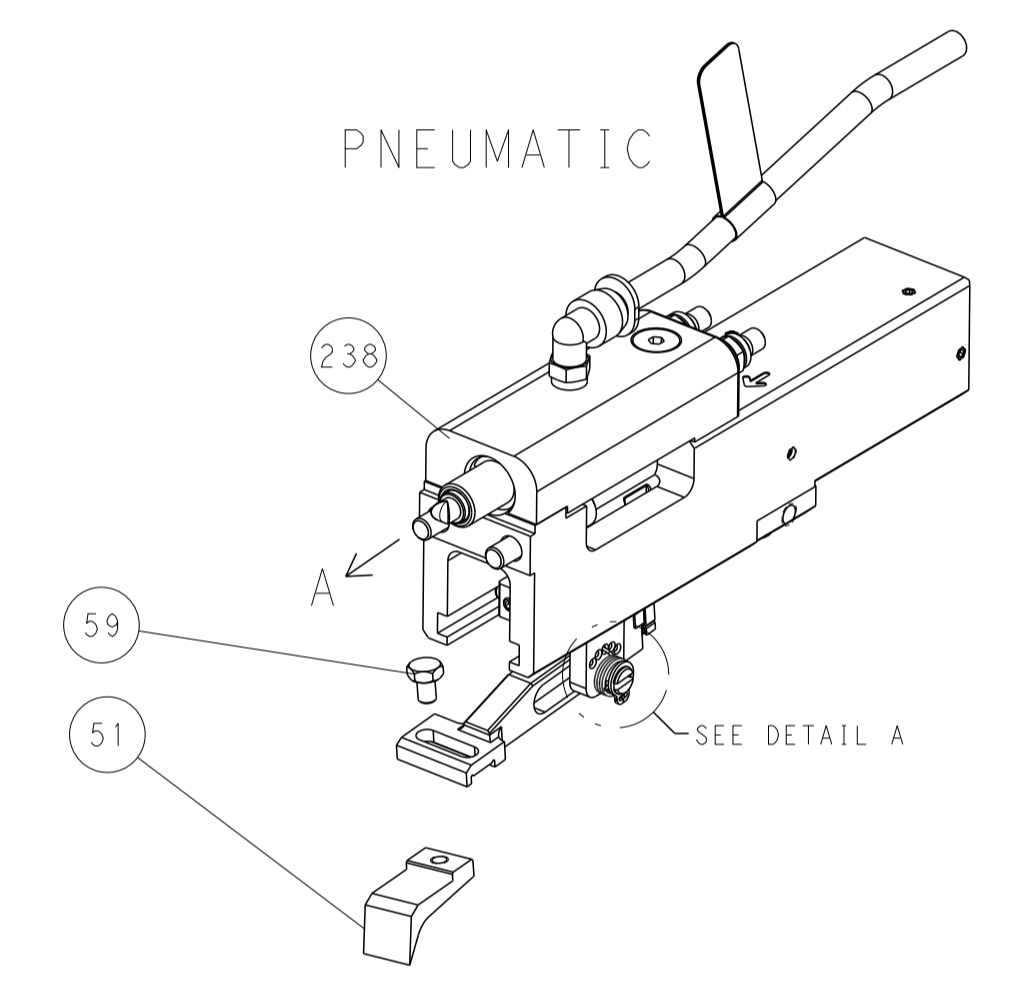
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A	66				
		REVISIONS			
P LTR		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			



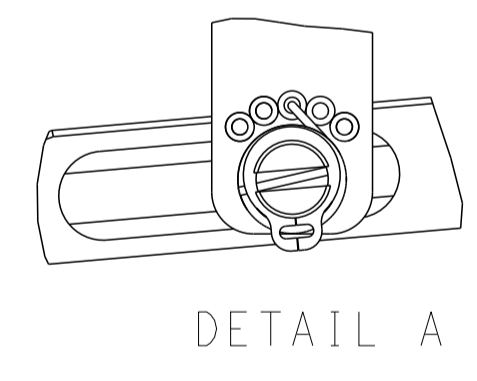
FEED TYPE MECHANICAL



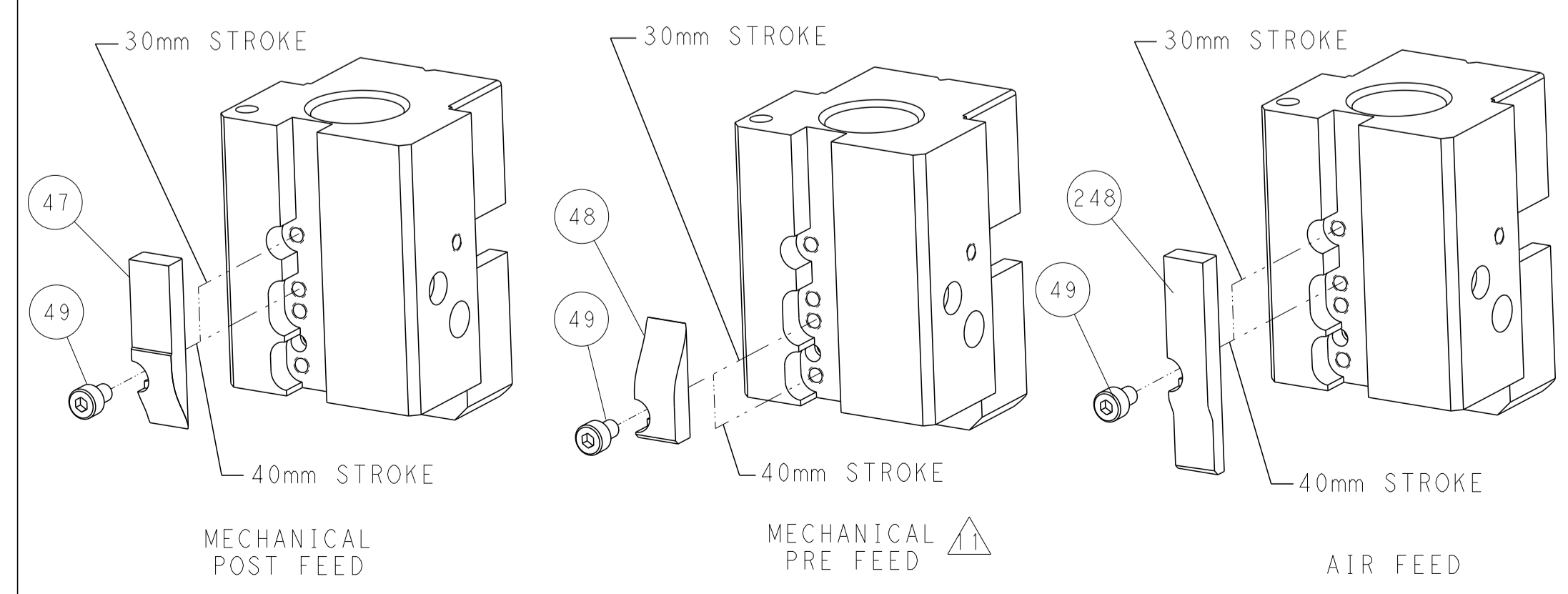
PNEUMATIC



FEED SPRING SETTING POSITION



CAM POSITIONS

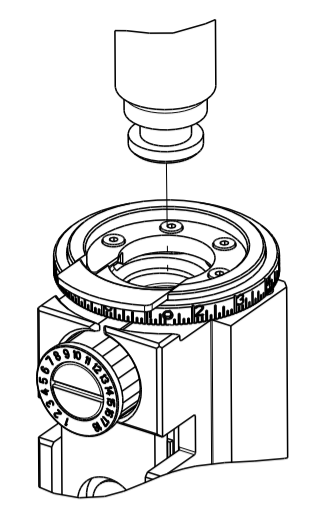


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 03OCT2013 CHK: TELBIN 03OCT2013 APVD: TELBIN 03OCT2013	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 APPLICATION SPEC: PRODUCT SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150378	RESTRICTED TO: SCALE: 1:1 SHEET: 2 of 4 REV: D
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150378-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150378-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150378-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES AUTOMOTIVE POS LOCK RECEPTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.20 mm [.165-.205 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5060	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170454-1	170454-2	85069-2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES AUTOMOTIVE POS LOCK RECEPTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.20 mm [.165-.205 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5060	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170454-1	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.86+/-0.05 [.073+/-0.002]	4.5
16 AWG OR 1.25mm2	1.62+/-0.05 [.064+/-0.002]	6.9
18 AWG OR 0.85mm2	1.50+/-0.05 [.059+/-0.002]	8.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.54+/-0.05 [.061+/-0.002]	7.7

- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
 - 6 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
7. 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.

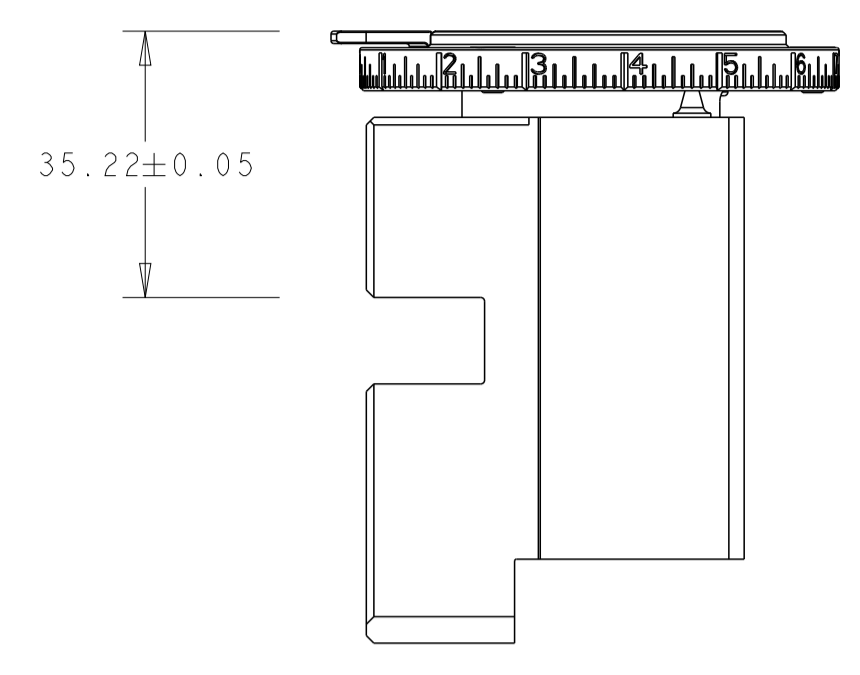
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-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	455888-4	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	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	3	3	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	-	2063961-9	FEED FINGER	51	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	2119653-1	FEED CAM, POST FEED	47	
-	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	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	1	1	4-240641-5	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	1	1-1333219-4	ANVIL, COMBINATION	8	
-	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-6	SPACER	5	
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	4-2119582-9	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-9	SPACER, CRIMPER	2	
-	1	1	456408-2	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)

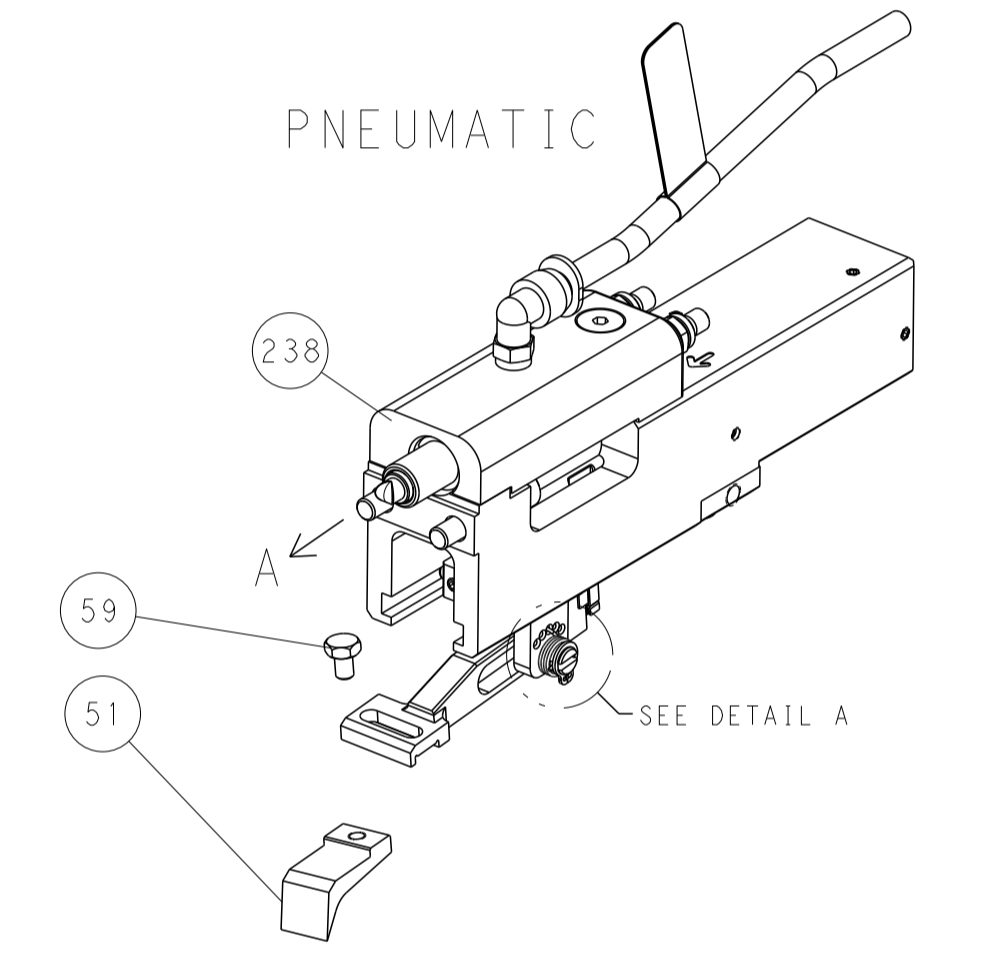
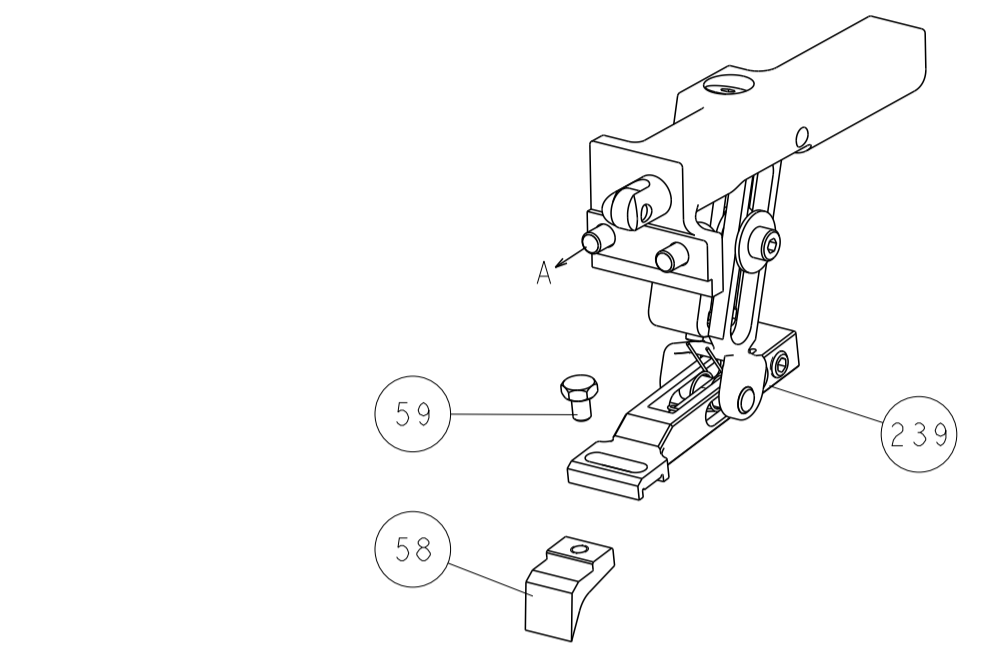
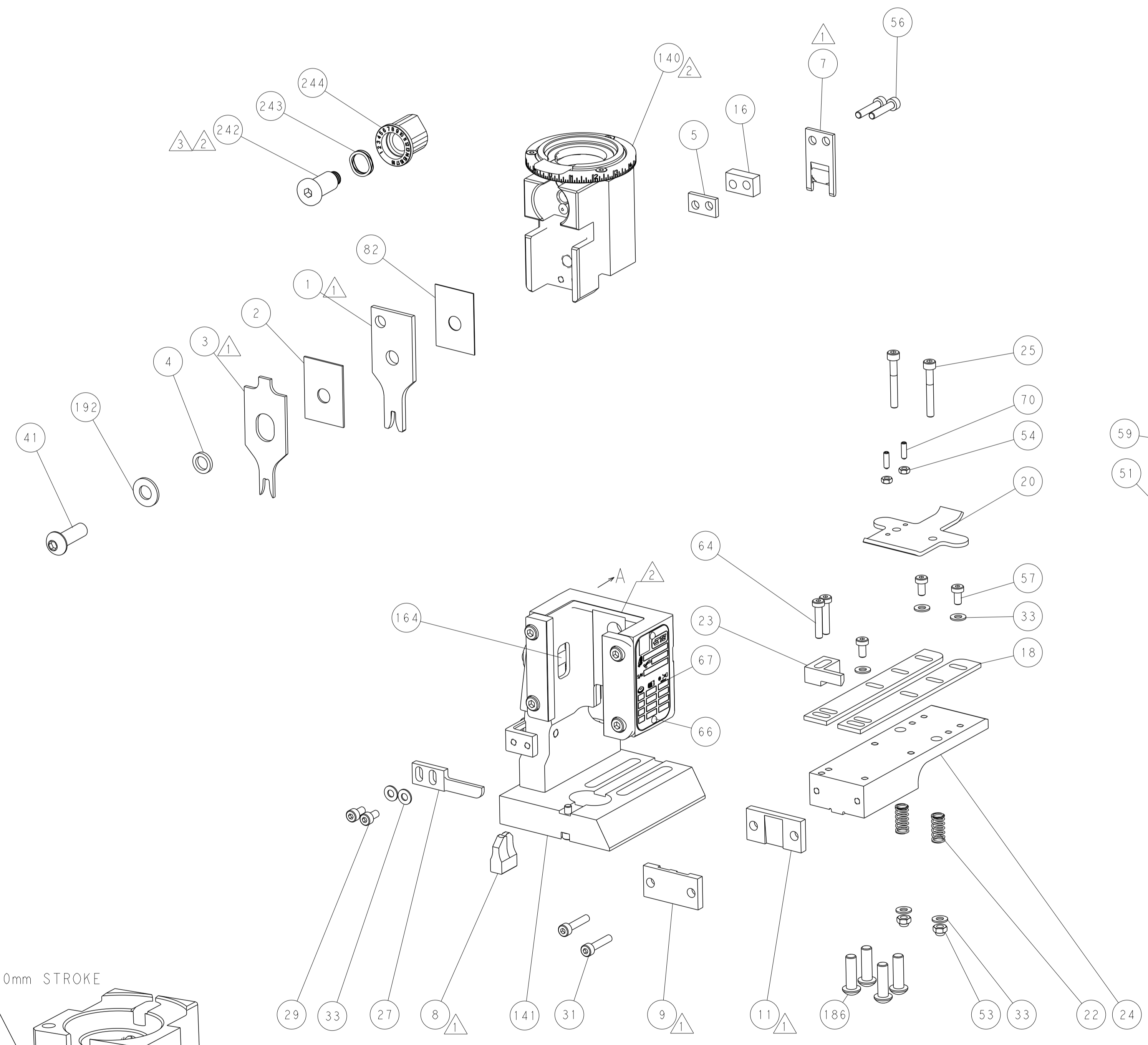
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					
Customer Accessible Production Drawing		SCALE	1:1	SHEET	3 OF 4

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

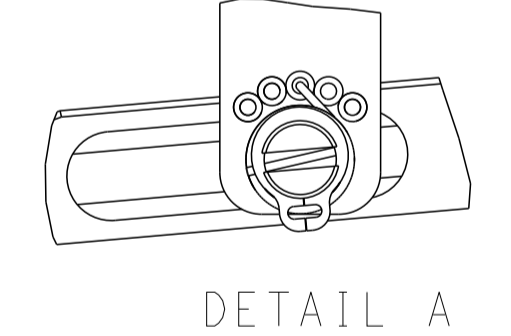


RAM SET-UP

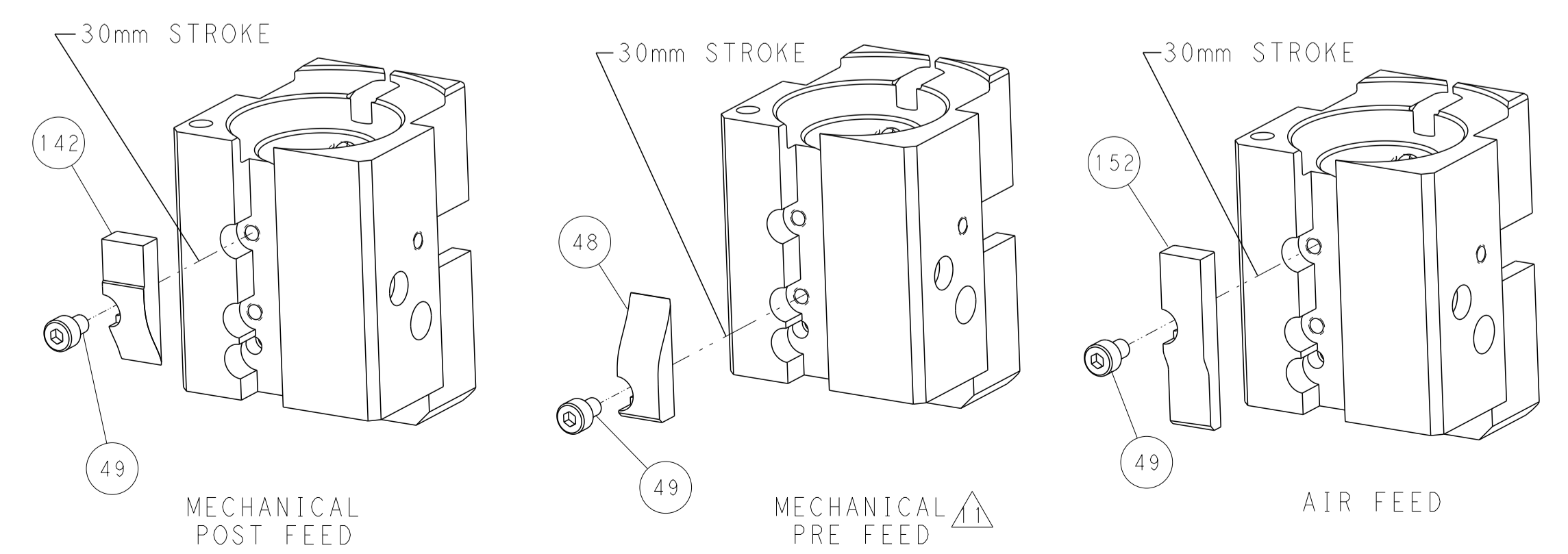
FEED TYPE MECHANICAL



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applier APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150378 SHEET 4 OF 4 REV D
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	