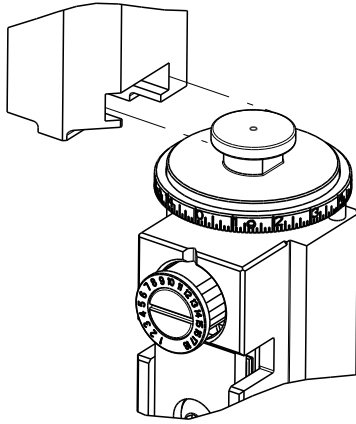


8		7	
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2014		2014	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150451-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150451-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150451-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150451-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150451-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES			
WIRE STRIP LENGTH .237-.267 IN [6.02-6.78 mm]		INSULATION DIAMETER RANGE Ø.120-.170 IN [3.05-4.32 mm]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
114-2036		-	
-		-	
TERMINALS APPLIED 5			
TE TERMINAL 41774	TE TERMINAL 41832	TE TERMINAL 62500-1	TE TERMINAL 62500-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		1.91+/-0.05 [0.075+/-0.002]		4.7
(2) 18		1.80+/-0.05 [0.071+/-0.002]		5.6
16 AWG		1.68+/-0.05 [0.066+/-0.002]		7.2
18 AWG		1.55+/-0.05 [0.061+/-0.002]		8.6



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.
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.

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

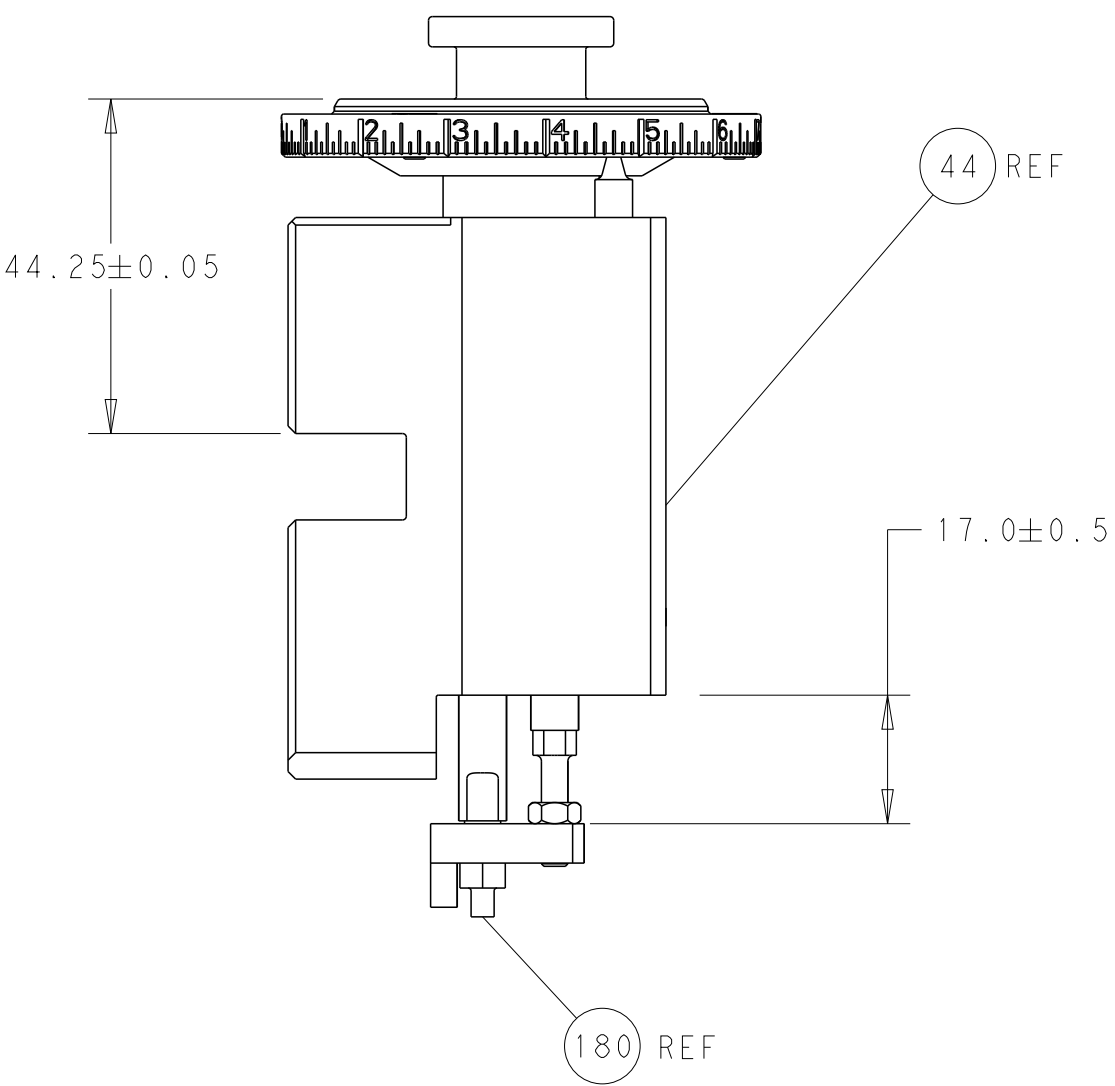
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LOC	DIST	REVISIONS					
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			A1	ECR-16-004765	01APR2016	JH	TE
			B	ECR-19-001916	05FEB2019	TB	TE

3	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	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	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
3	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	1	1	1-1976055-3	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
5	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-2	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	1901681-5	HOLDDOWN, TERMINAL	65
	-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2119792-2	PAWL, EF, AIR	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	240825-8	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	6-240641-4	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	1	690495-6	PLATE, FRONT SHEAR	9
1	2	2	1	1	5-1803001-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	2	
1	2	2	1	1	3-456409-7	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77-72-71	-2	-1		PART NO	DESCRIPTION	ITEM NO	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				DWN B. WEAVER 16JUL2014	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK T. ELBIN 16JUL2014	NAME		
				APVD T. ELBIN 16JUL2014	PRODUCT SPEC		
					APPLICATION SPEC		
MATERIAL -					WEIGHT -		
					SIZE A		
					CAGE CODE 00779		
					DRAWING NO C=2150451		
					RESTRICTED TO -		
					Customer Accessible Production Drawing		
					SCALE 1:1		
					SHEET 1		
					OF 4		
					REV B		

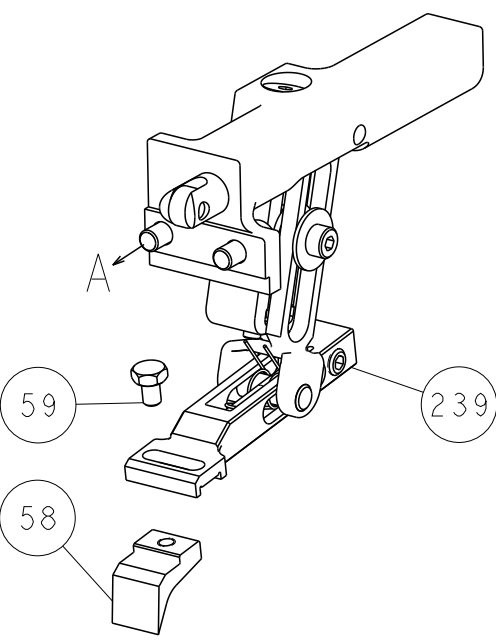
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

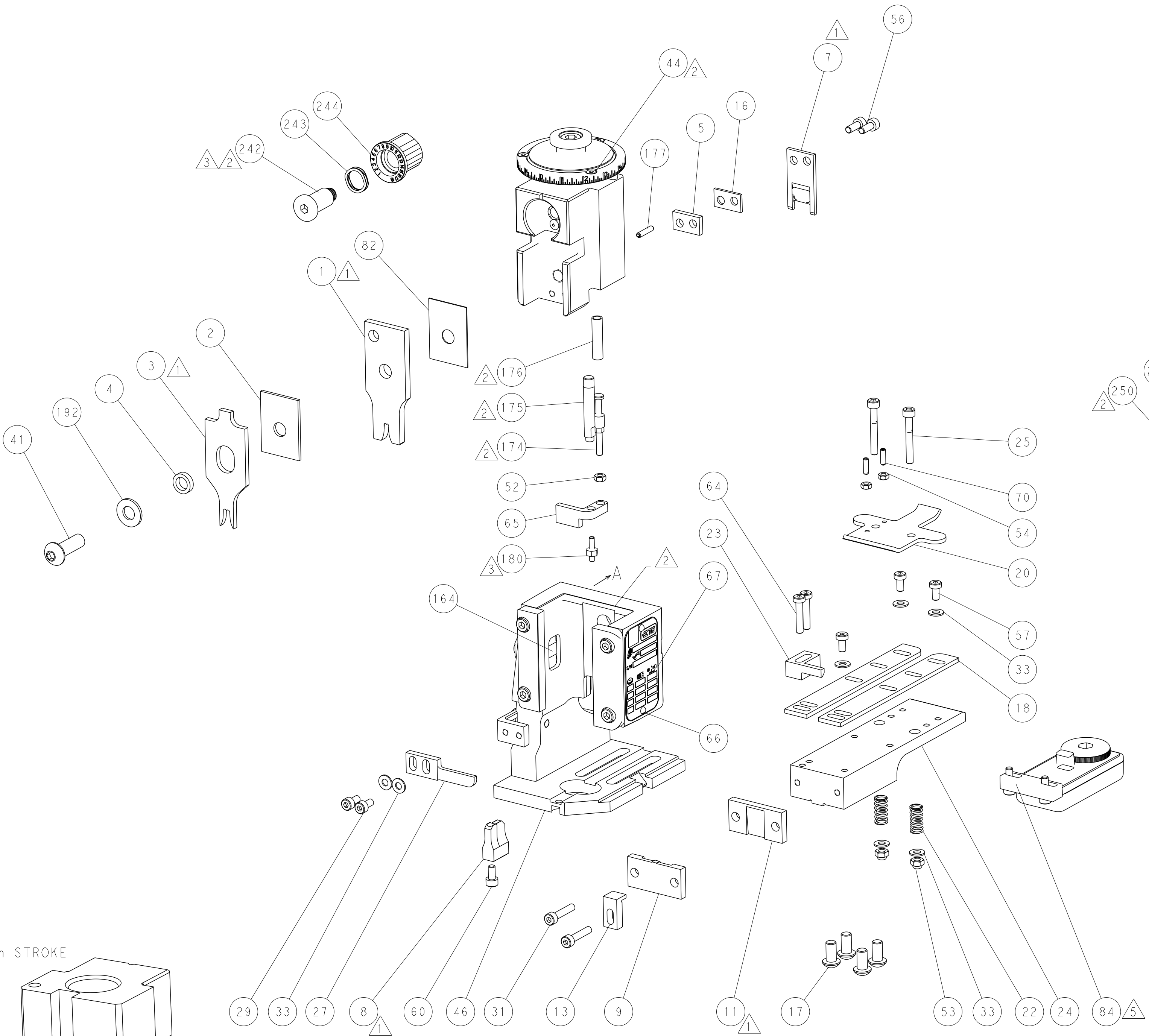
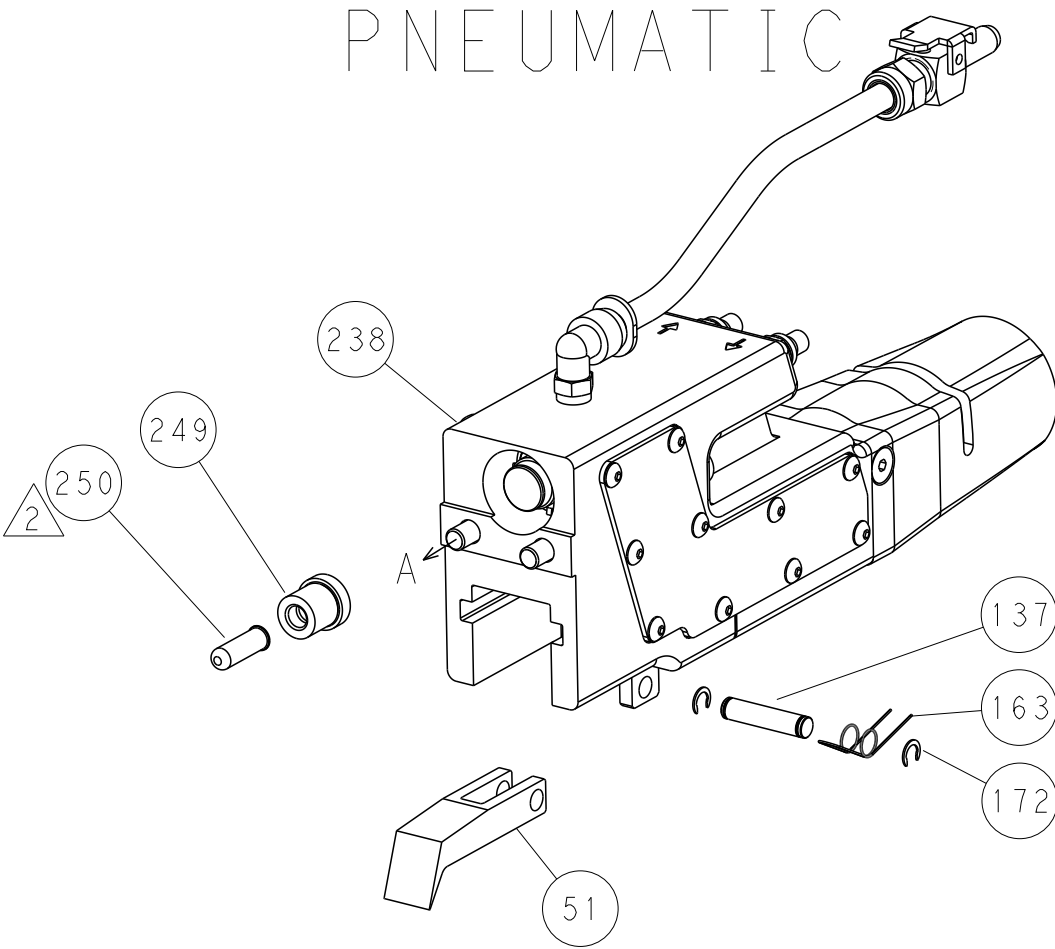


RAM AND HOLDDOWN SET-UP

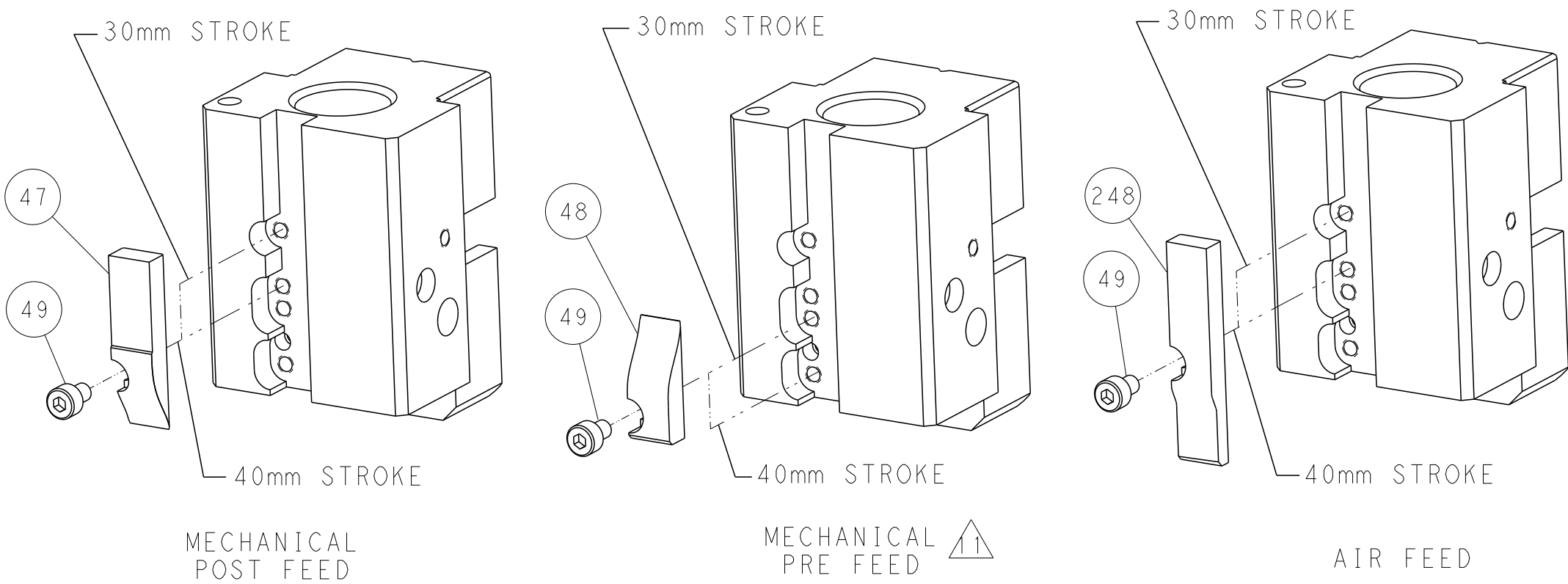
FEED TYPE
MECHANICAL



PNEUMATIC



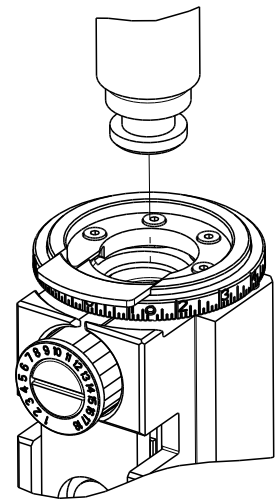
CAM POSITIONS



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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CHG T. ELBIN 16JUL2014		NAME	Ocean End Feed Applicator	
APVD T. ELBIN 16JUL2014		PRODUCT SPEC	SIZE A	
APPLICATION SPEC		WEIGHT	CAGE CODE 00779	
MATERIAL		FINISH	DRAWING NO C=2150451	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 2 of 4	
			REV B	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150451-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150451-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150451-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .250 SERIES			
WIRE STRIP LENGTH .237-.267 IN [6.02-6.78 mm]		INSULATION DIAMETER RANGE Ø.120-.170 IN [3.05-4.32 mm]	
TERMINAL APPLICATION 		114-2036	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL 41774	TE TERMINAL 41832	TE TERMINAL 62500-1	TE TERMINAL 62500-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		1.91+/-0.05 [0.075+/- .002]		4.7
(2) 18		1.80+/-0.05 [0.071+/- .002]		5.6
16 AWG		1.68+/-0.05 [0.066+/- .002]		7.2
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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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
 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.
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ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE
SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE
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PROPER SETUP AND ADJUSTMENTS.

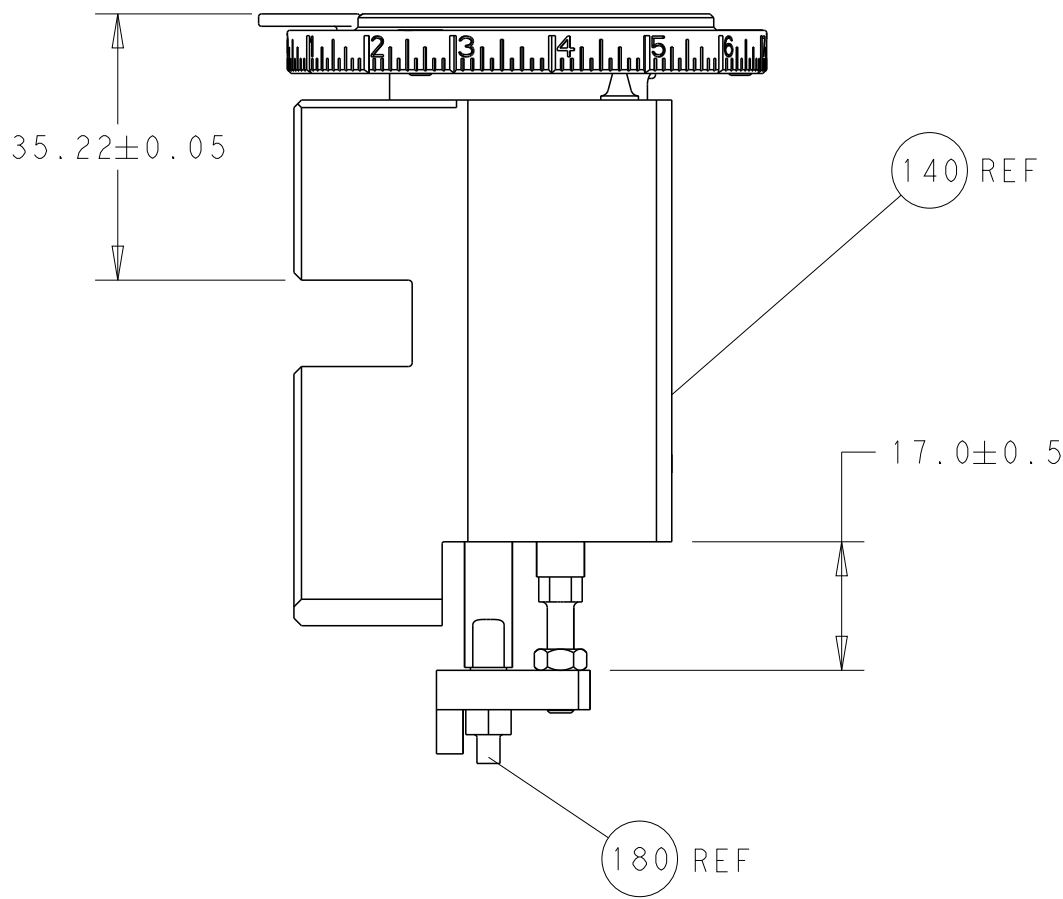
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SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

AMP 4805 REV 31MAR2000

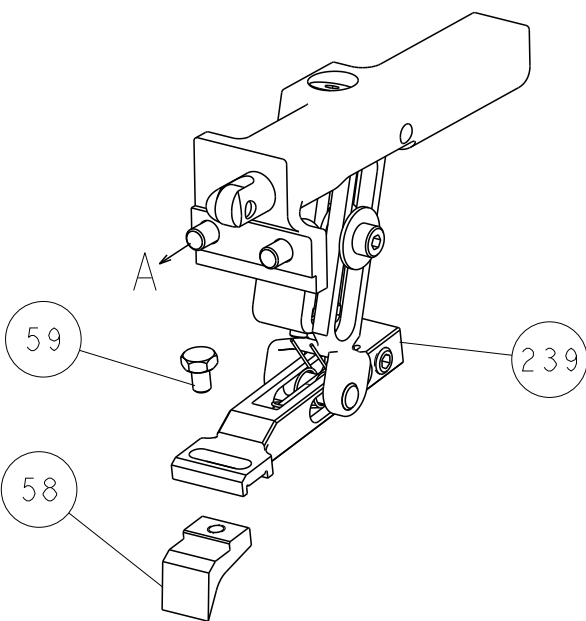
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

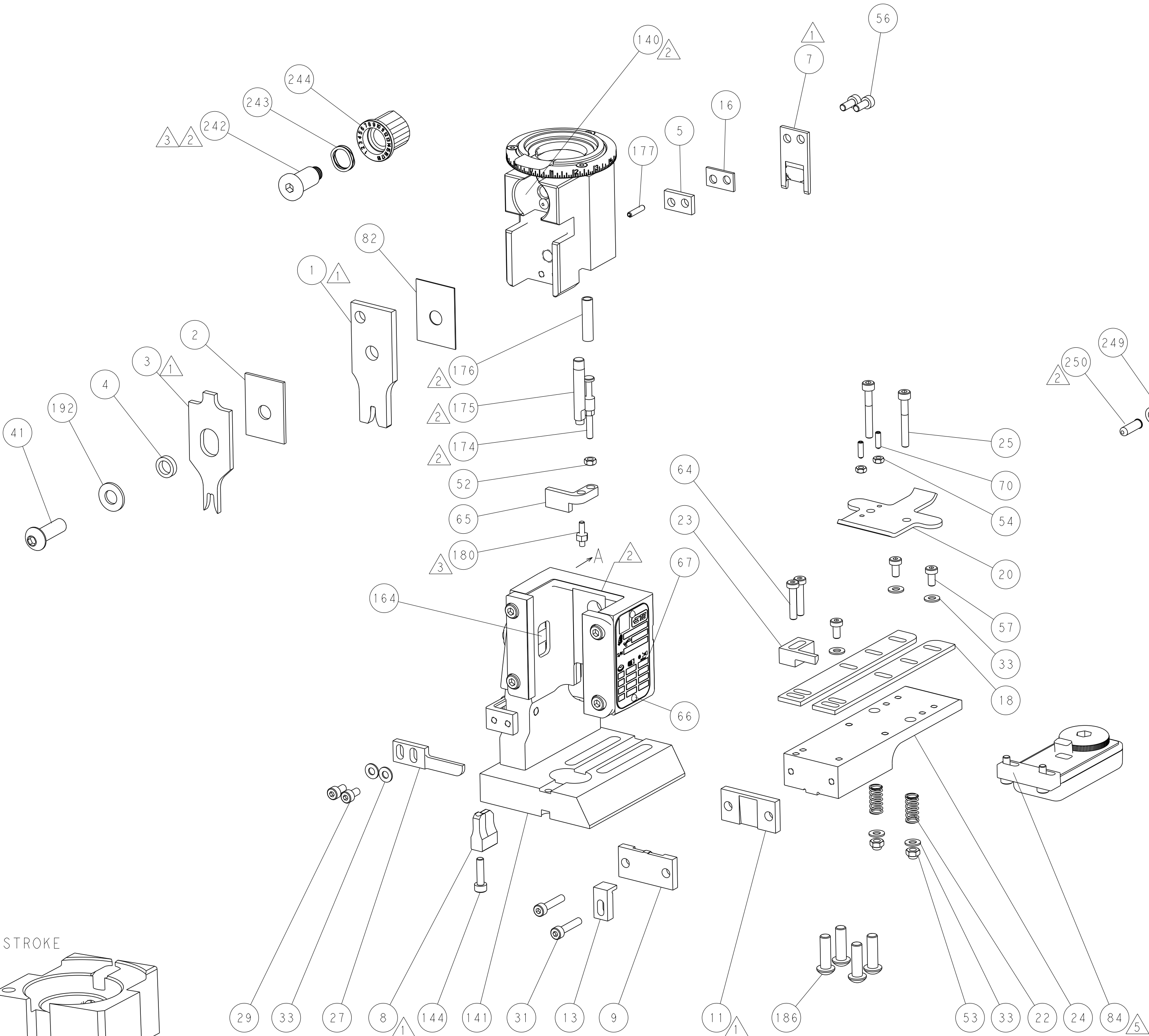
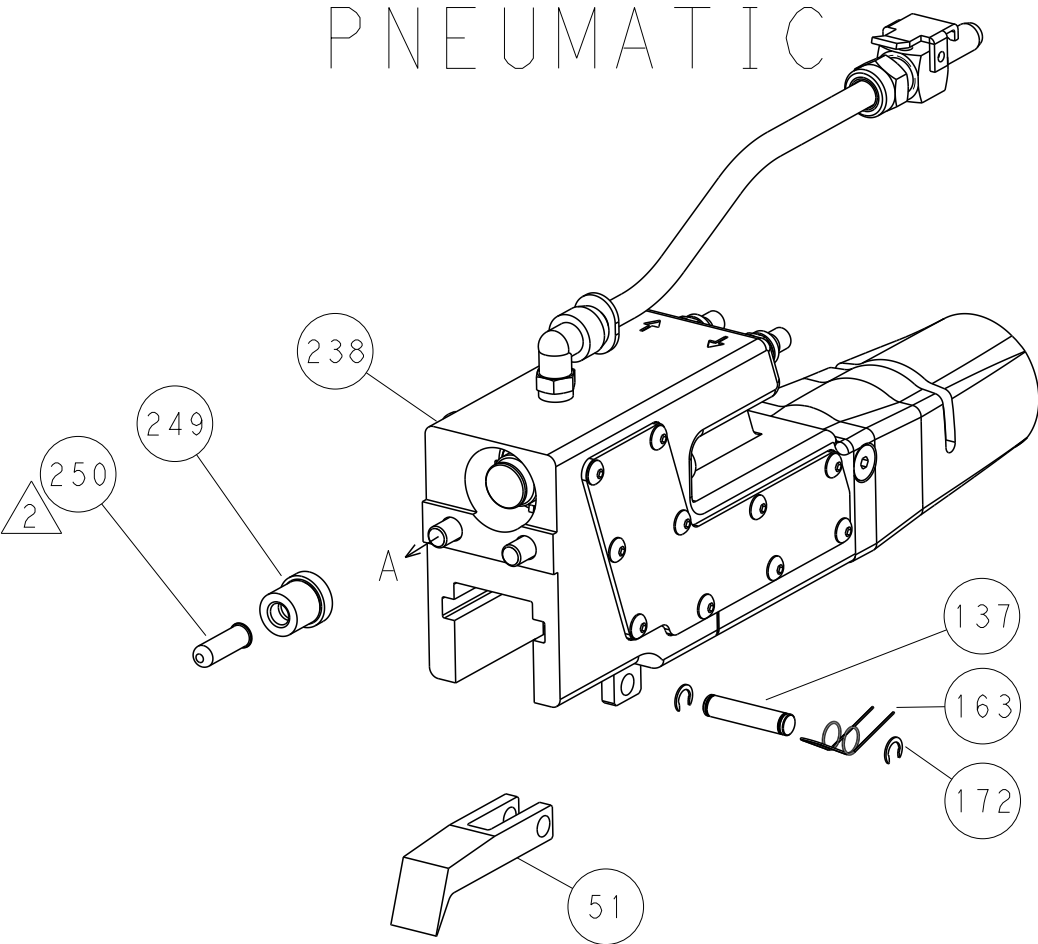


RAM AND HOLDDOWN SET-UP

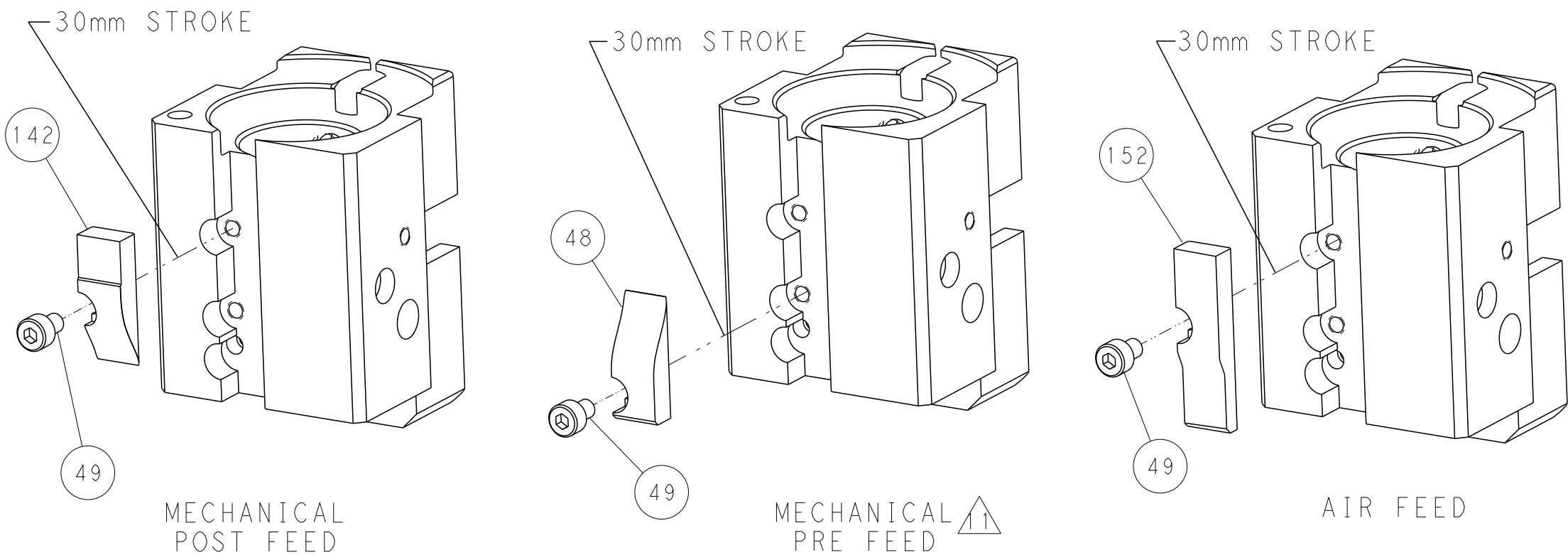
FEED TYPE
MECHANICAL



PNEUMATIC



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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CHK T. ELBIN 16JUL2014				NAME				Ocean End Feed Applicator			
APVD T. ELBIN 16JUL2014				PRODUCT SPEC				SIZE CAGE CODE DRAWING NO			
APPLICATION SPEC				RESTRICTED TO				-			
MATERIAL				WEIGHT				A 00779 C=2150451			
Customer Accessible Production Drawing				SCALE 1:1				SHEET 4 OF 4			
								REV B			