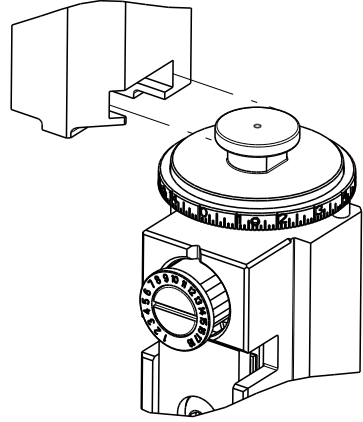
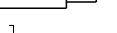


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150240-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150240-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150240-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.81 mm [.150]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POSITIVE LOCK MARK II RECEP			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.50-6.50 mm [.217-.256 IN]			Ø3.00-5.10 mm [.118-.201 IN]
TERMINAL APPLICATION SPECIFICATION		114-5042	
		-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170329-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.58+/-0.05 [.102+/- .002]	1.4
3.00mm2	2.20+/-0.05 [.087+/- .002]	5.1
2.00mm2	1.83+/-0.05 [.072+/- .002]	9.5
1.3+0.5+0.5mm2	1.83+/-0.05 [.072+/- .002]	9.5
1.25+0.5mm2	1.79+/-0.05 [.070+/- .002]	9.9



- 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 50.
- 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 WIRE STRIP LENGTH 5.80-6.80 mm [.228-.268 IN]
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL DESIGN IS NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

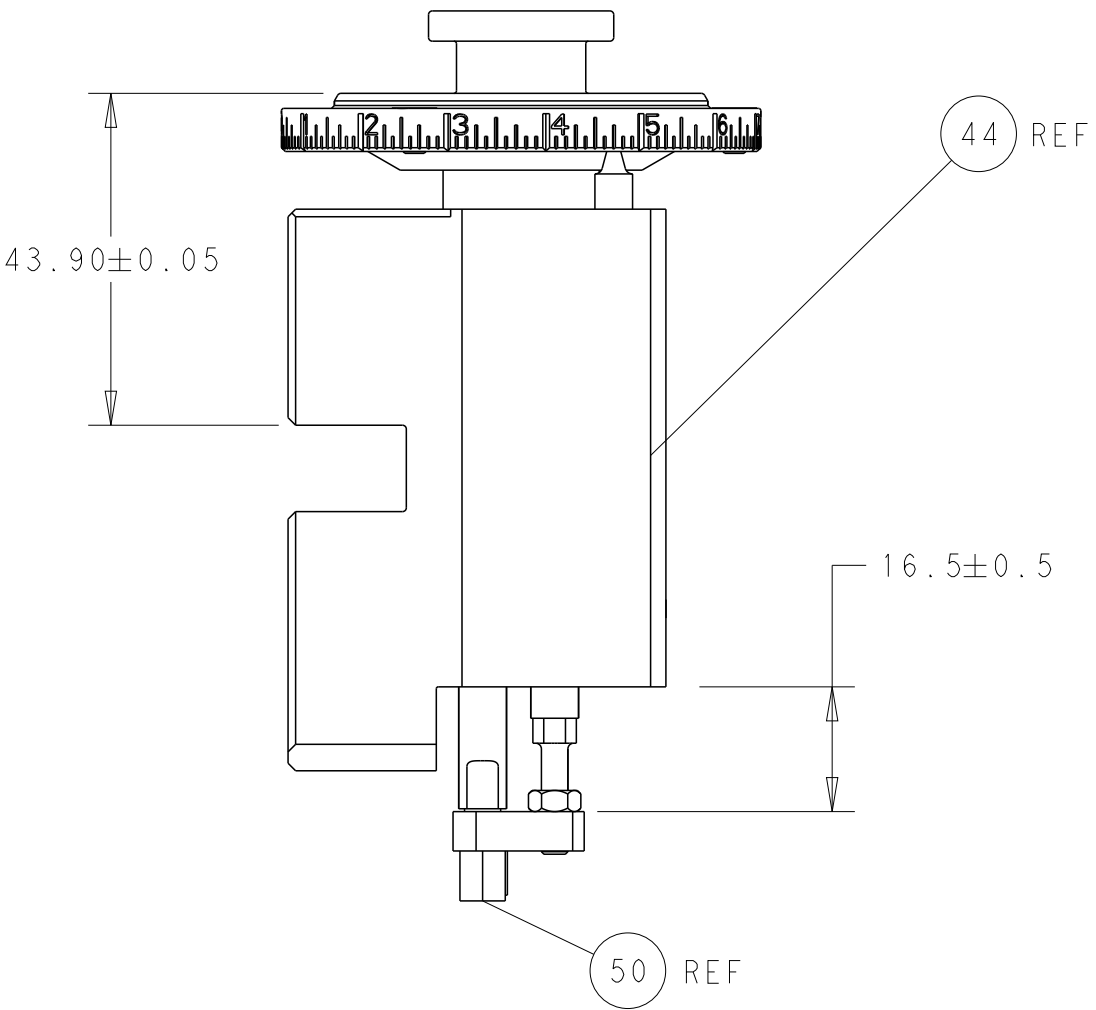
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISIONS			
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					A	RELEASED	01JUN2012
					B	ECR-18-014354	10SEP2018

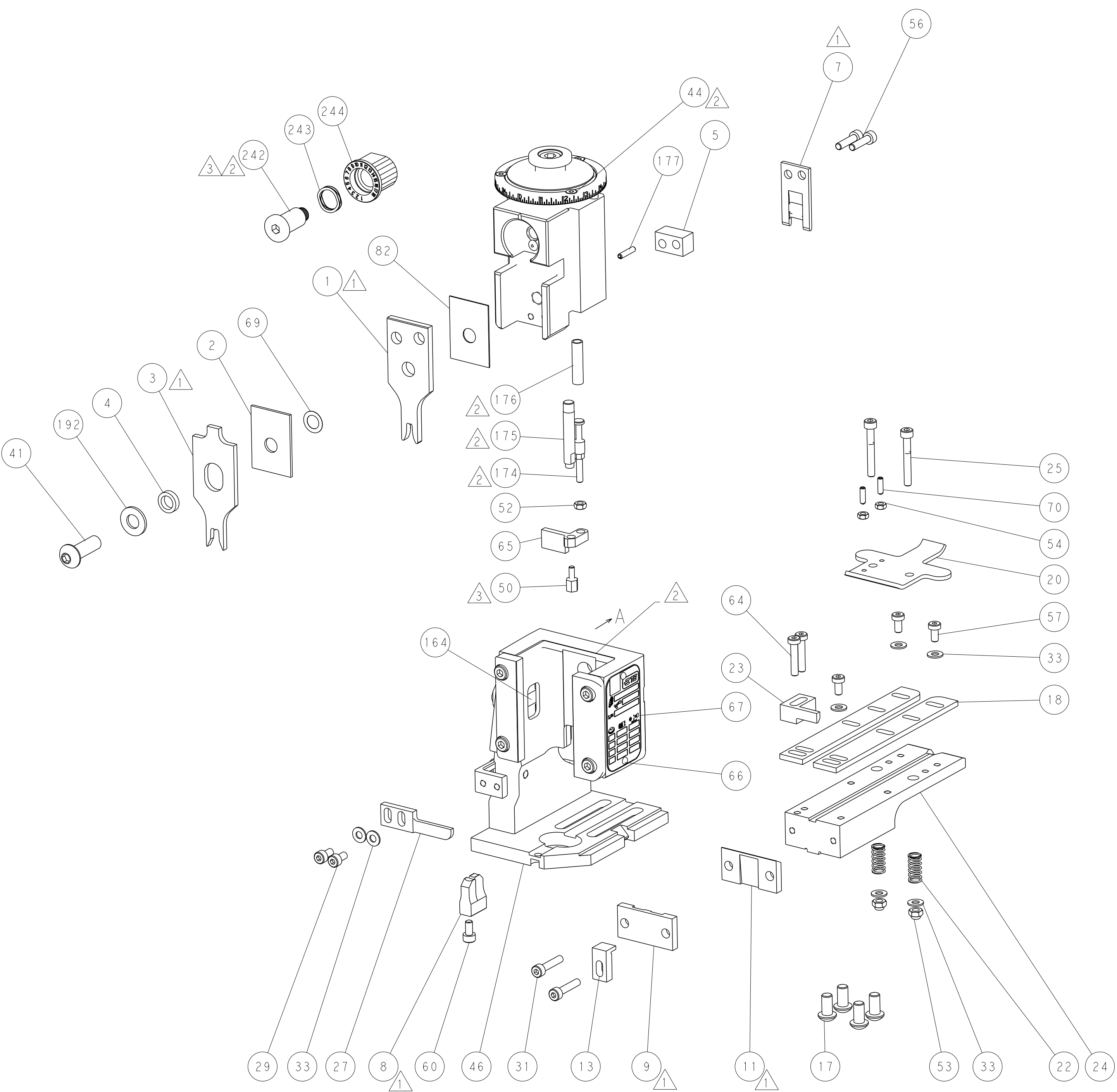
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2063440-2	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-9931111-6	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
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-2	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	1976052-1	HOLDDOWN,TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1	2031314-1	FEED FINGER SUBASSEMBLY	51
-	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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
-	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	1-1752371-7	PLATE, STRIP GUIDE	24
-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240833-7	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	6-690482-3	PLATE, FRONT SHEAR	9
1	2	1	1633386-6	ANVIL, COMBINATION	8
-	1	1	1-690474-7	BLADE, SLUG	7
-	1	1	5-240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	1-1633962-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	2	1	6-163305-3	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS THE USER'S RESPONSIBILITY TO CONTACT THE ISSUING ORGANIZATION FOR THE LATEST EDITION.		OWN R.KNEPPER CHK T.ELBIN APVD M.CLIFFORD	02APR2012 02APR2012 02APR2012	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	
MATERIAL -		WEIGHT -		SIZE A	CAGE CODE 00779
				DRAWING NO C=2150240	RESTRICTED TO B
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				SCALE 1:1	SHEET 1 OF 4

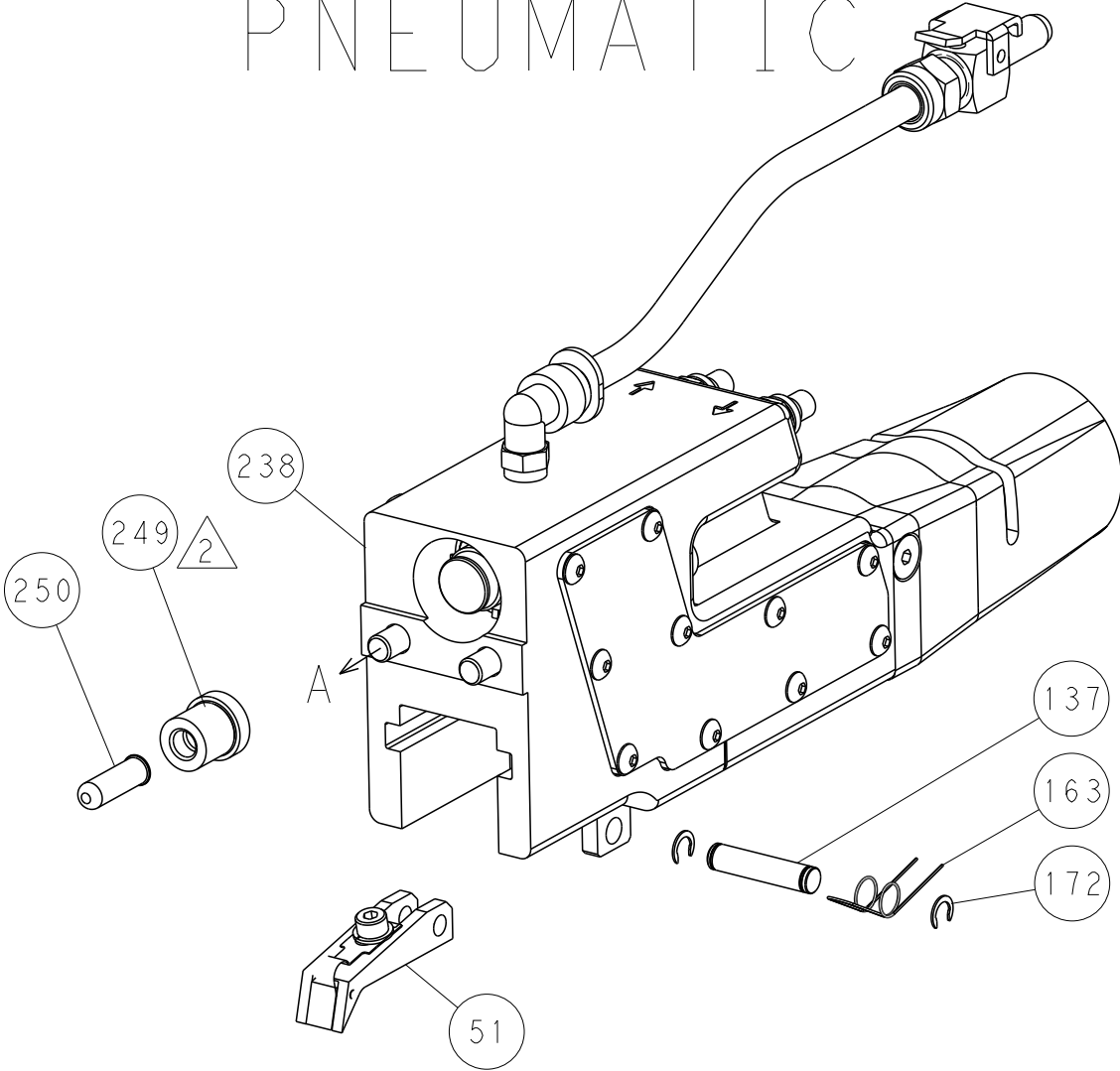
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-



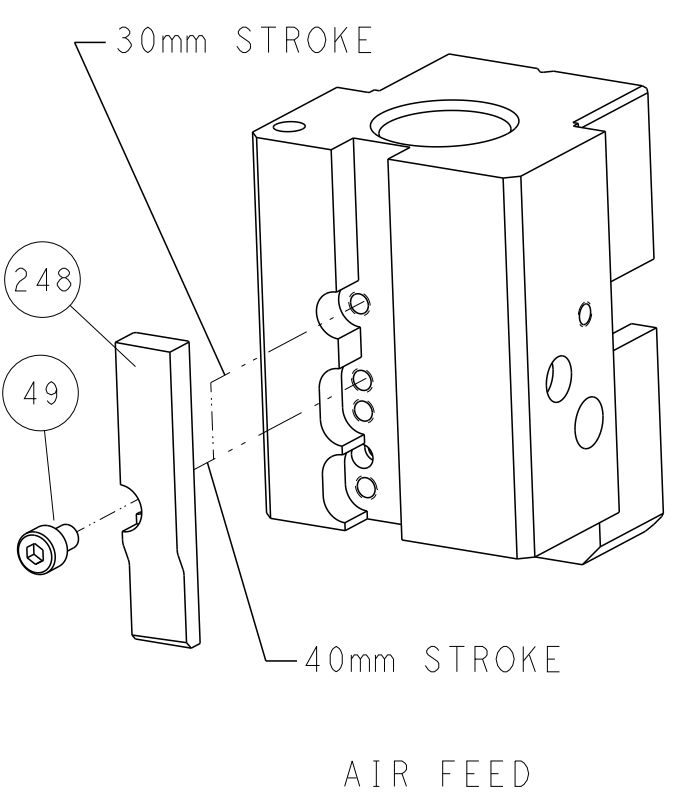
RAM AND HOLDDOWN SET-UP



FEED TYPE
PNEUMATIC



CAM POSITIONS

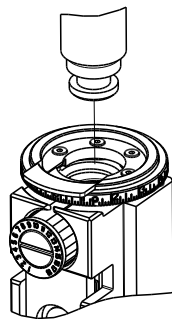


AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY REVISIONS TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. KNEPPER 02APR2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 02APR2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH		APVD M. CLIFFORD 02APR2012	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
		APPLICATION SPEC -	DRAWING NO C=2150240	
		WEIGHT -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
		SCALE 1:1	SHEET 2 OF 4	
			REV B	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.81 mm [.150]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POSITIVE LOCK MARK II RECEPTOR			
WIRE STRIP LENGTH   5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE  $\varnothing$ 3.00-5.10 mm [.118-.201 IN]	
TERMINAL APPLICATION 			
SPECIFICATION		SPECIFICATION	
TERMINALS APPLIED 			
TE TERMINAL 170329-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5.00mm2		2.58+/-0.05 [1.02+/- .002]		1.4
3.00mm2		2.20+/-0.05 [1.087+/- .002]		5.1
2.00mm2		1.83+/-0.05 [1.072+/- .002]		9.5
 1.3+0.5+0.5mm2		1.83+/-0.05 [1.072+/- .002]		9.5
 1.25+0.5mm2		1.79+/-0.05 [1.070+/- .002]		9.6



- 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 50.
- 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 WIRE STRIP LENGTH 5.80-6.80 mm [.228-.268 IN]
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⑦ TERMINAL DESIGN IS NOT COMPATIBLE WITH MECHANICAL FEED.

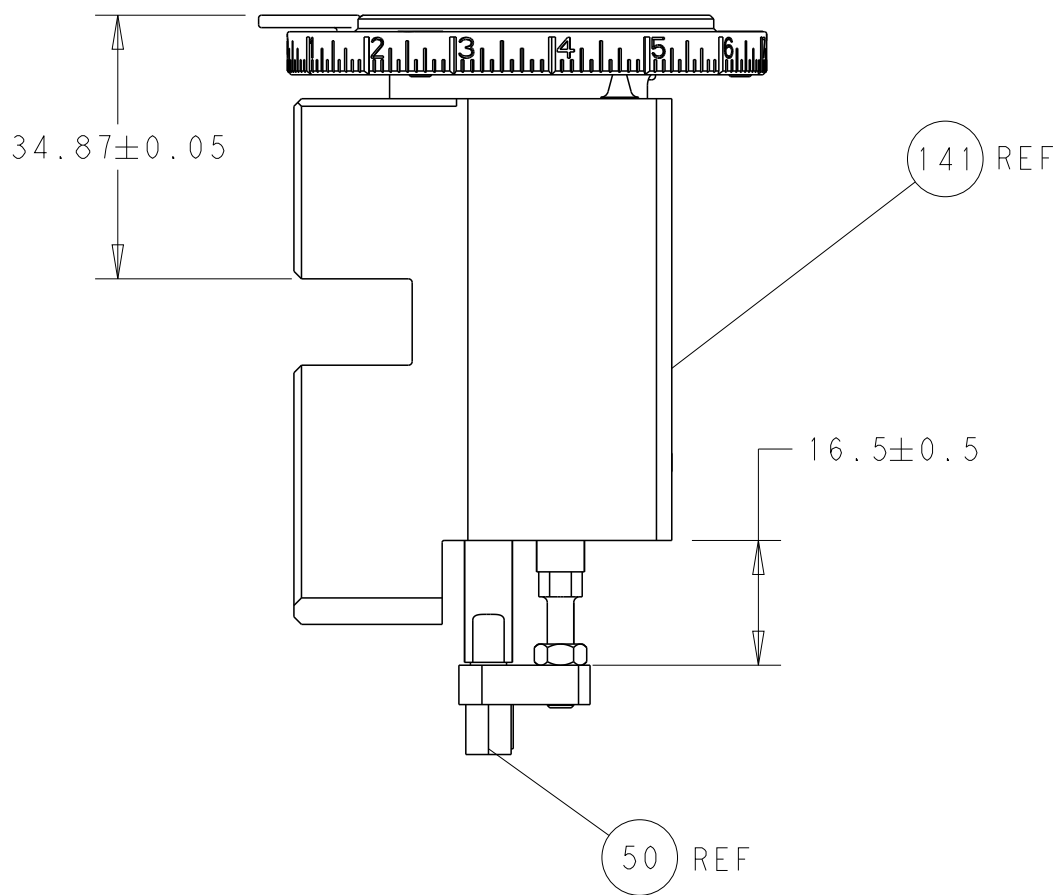
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

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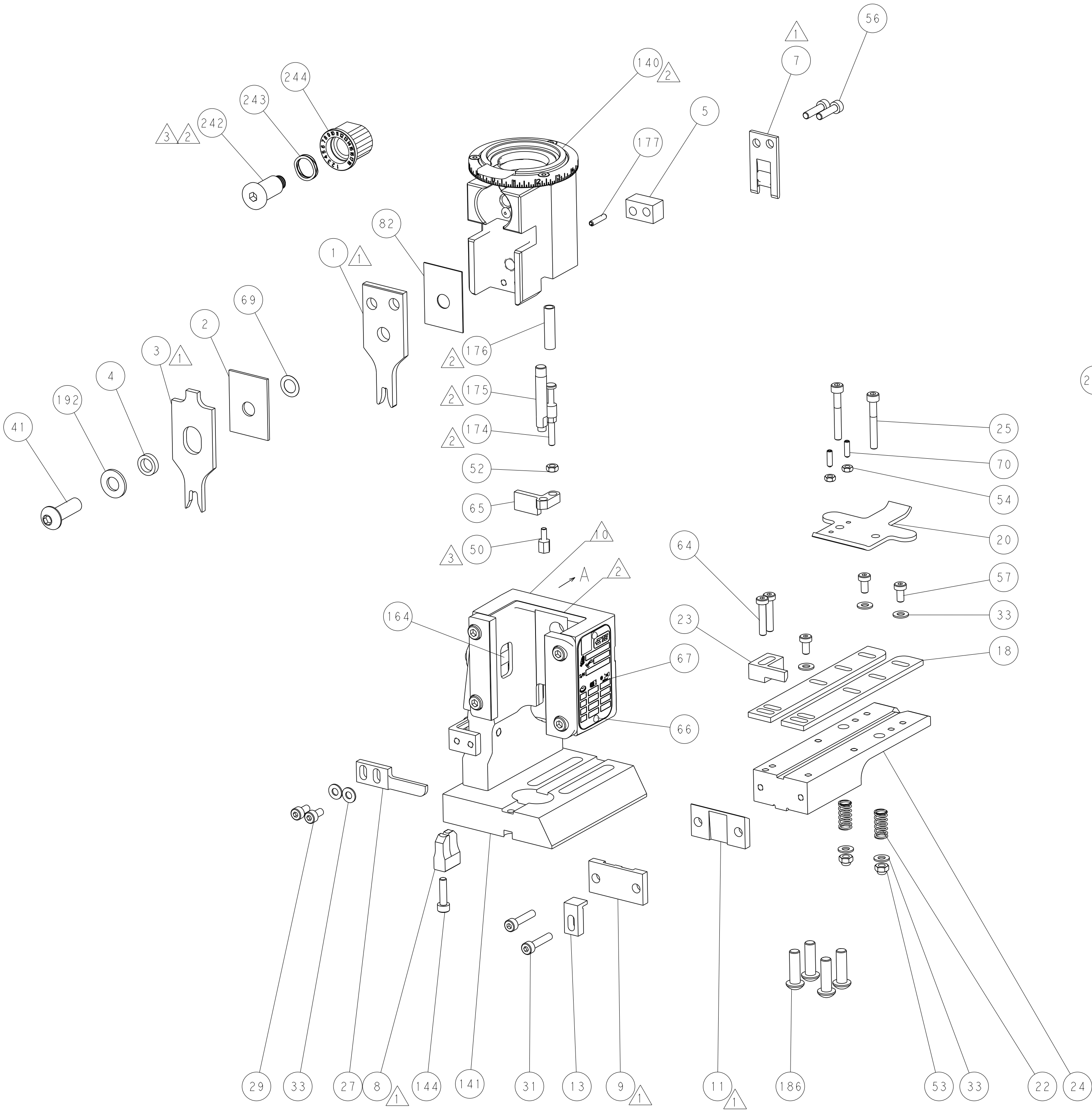
3	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2063440-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN,HOLDDOWN	177
	-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	2119641-2	FEED CAM, AIR FEED	152
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	455888-5	SPACER, CRIMPER	82
	-	1	1803607-2	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	1976052-1	HOLDDOWN, TERMINAL	65
	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2031314-1	FEED FINGER SUBASSEMBLY	51	
3	-	1	1-1752354-1	STANDOFF,HOLD-DOWN	50
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	7	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	1-1752371-7	PLATE, STRIP GUIDE	24
	-	1	240825-2	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
1	-	1	1803292-1	DRAG	20
	-	2	1901259-6	GUIDE, LOWER STRIP	18
	-	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240833-7	PLATE, REAR SHEAR	11
	-	-	-	-	10
	-	1	6-690482-3	PLATE, FRONT SHEAR	9
	1	1	1633386-6	ANVIL, COMBINATION	8
	-	1	1-690474-7	BLADE, SLUG	7
	-	1	5-240641-3	SPACER	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1-1633962-4	CRIMPER, INSULATION F PREMIUM	3
1	-	1	1-455888-4	SPACER, CRIMPER	2
	1	1	6-1633305-3	CRIMPER, WIRE PREMIUM	1

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. ANGLES ±. FINISH		Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 00779 C=2150240	
MATERIAL -		WEIGHT -		RESTRICTED TO	
CUSTOMER ACCESSIBLE DRAWING		SCALE 1:1		SHEET 3 OF 4 REV B	

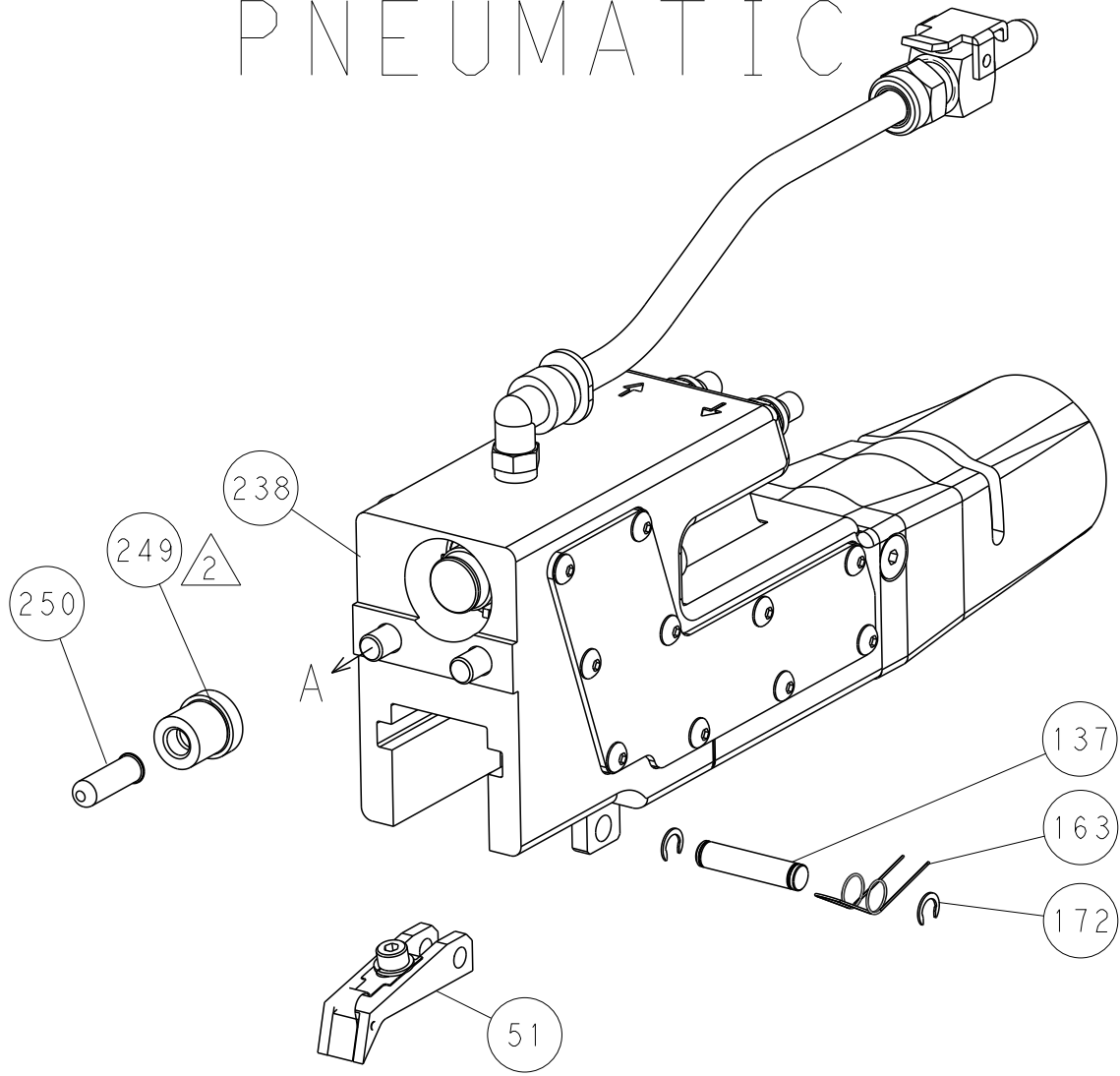
LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



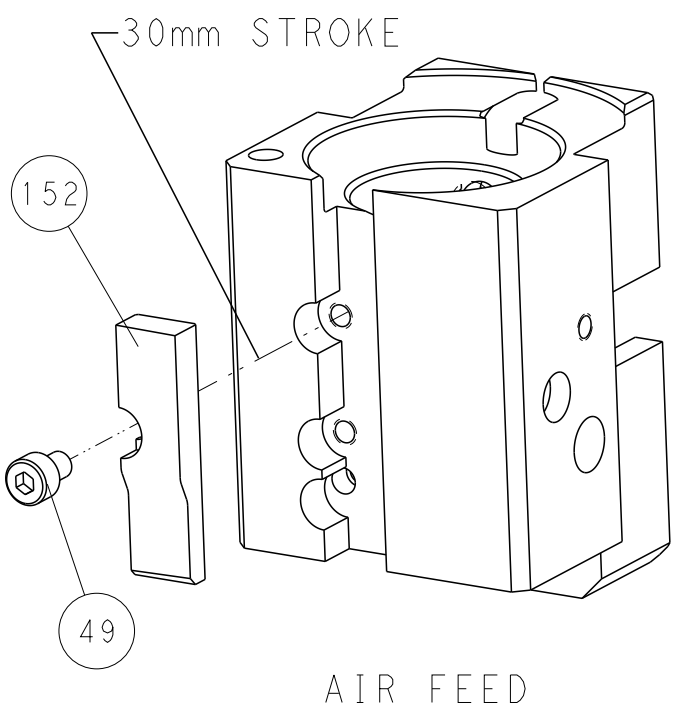
RAM AND HOLDDOWN SET-UP



FEED TYPE
PNEUMATIC



CAM POSITIONS



AIR FEED

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				CHK T. ELBIN 02APR2012			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH				APVD M. CLIFFORD 02APR2012	NAME Ocean End Feed Applicator		
MATERIAL -				PRODUCT SPEC -	SIZE A1		
				APPLICATION SPEC -	CAGE CODE 00779		
				WEIGHT -	DRAWING NO C=2150240		
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:1		
					SHEET 4		
					OF 4		
					REV B		