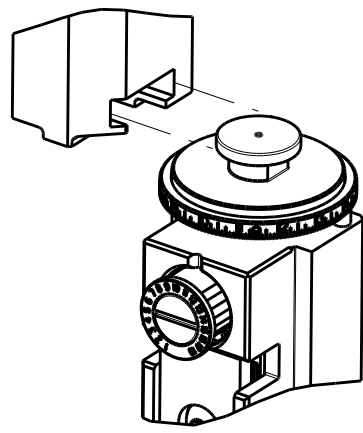


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150135-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150135-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150135-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT POSITIVE LOCK .250 SERIES			
WIRE STRIP LENGTH 4.39-5.17 mm [.173-.204 IN]			INSULATION DIAMETER RANGE Ø2.29-3.94 mm [.090-.155 IN]
TERMINAL APPLICATION SPECIFICATION 	114-2074	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63097-1	63097-4	63442-1	2238155-1
63097-2	63809-1		2238155-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/- .002]	5.4
16 AWG	1.65+/-0.05 [.065+/- .002]	7.7
18 AWG	1.47+/-0.05 [.058+/- .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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT POSITIVE LOCK .250 SERIES			
WIRE STRIP LENGTH 4.39-.5.17 mm [.173-.204 IN]		INSULATION DIAMETER RANGE Ø2.29-3.94 mm [.090-.155 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-2074 - -	
TERMINALS APPLIED  			
TE TERMINAL 2238104-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.00+/-0.05 [.079+/- .002]	4.1
16 AWG	1.83+/-0.05 [.072+/- .002]	8.2

*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.

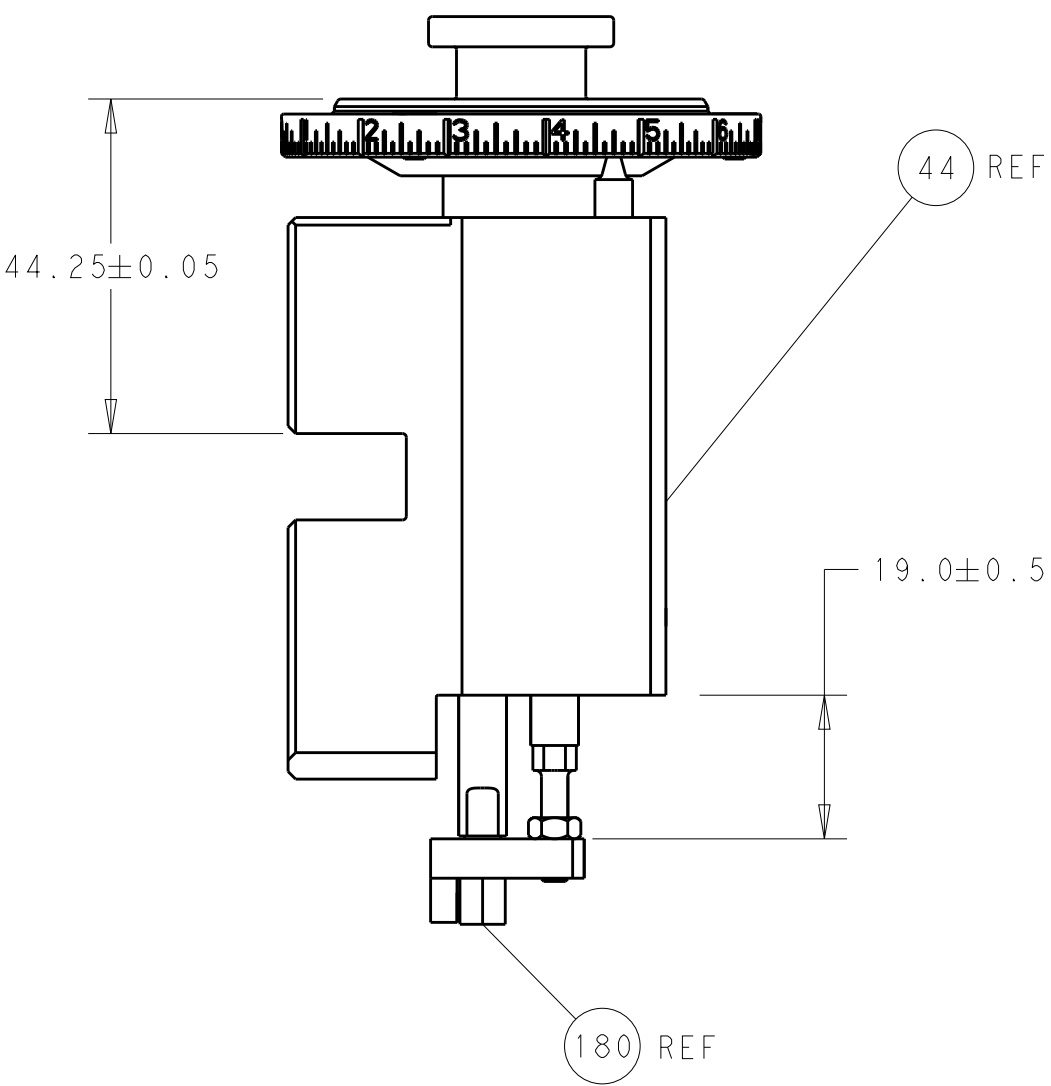
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISIONS			
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					H	ECR-18-020071	27DEC2018
					J	ECR-19-005662	08APR2019
					K	ECR-19-009342	13JUN2019
					L	ECR-19-012523	08AUG2019
							OWN
							APVD

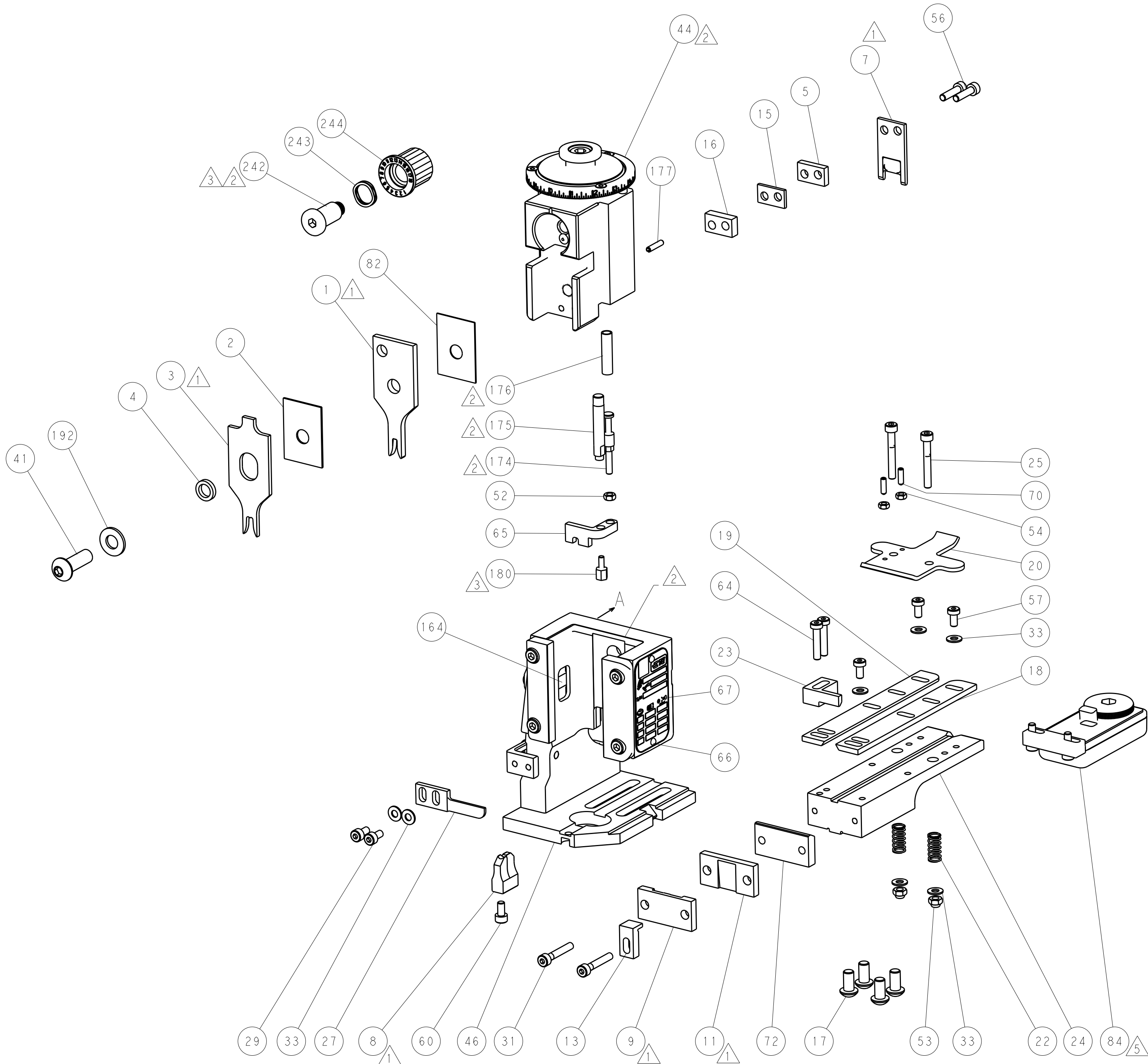
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1752354-9	STANDOFF,HOLD-DOWN	180
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	72
-	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	2-1901681-7	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	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	2063961-1	FEED FINGER	51
-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-3	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1803152-1	STRIP GUIDE, REAR	19
-	1	1	1803151-1	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1-240641-8	SPACER	16
-	1	1	1-240641-1	SPACER	15
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	-	1	4-690482-6	PLATE, FRONT SHEAR	9
	1	2	1-1803000-9	ANVIL, COMBINATION, END FEED	8
	-	1	1-2217206-6	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	6-240641-9	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	4-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
	1	2	456408-6	CRIMPER, WIRE PREMIUM	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

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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 Applicator	
MATERIAL -		WEIGHT -		SIZE A1	CAGE CODE 00779
				DRAWING NO C=2150135	RESTRICTED TO -
				Customer Accessible Production Drawing	SCALE 1:1
				SHEET 1	OF 4
				REV L	

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

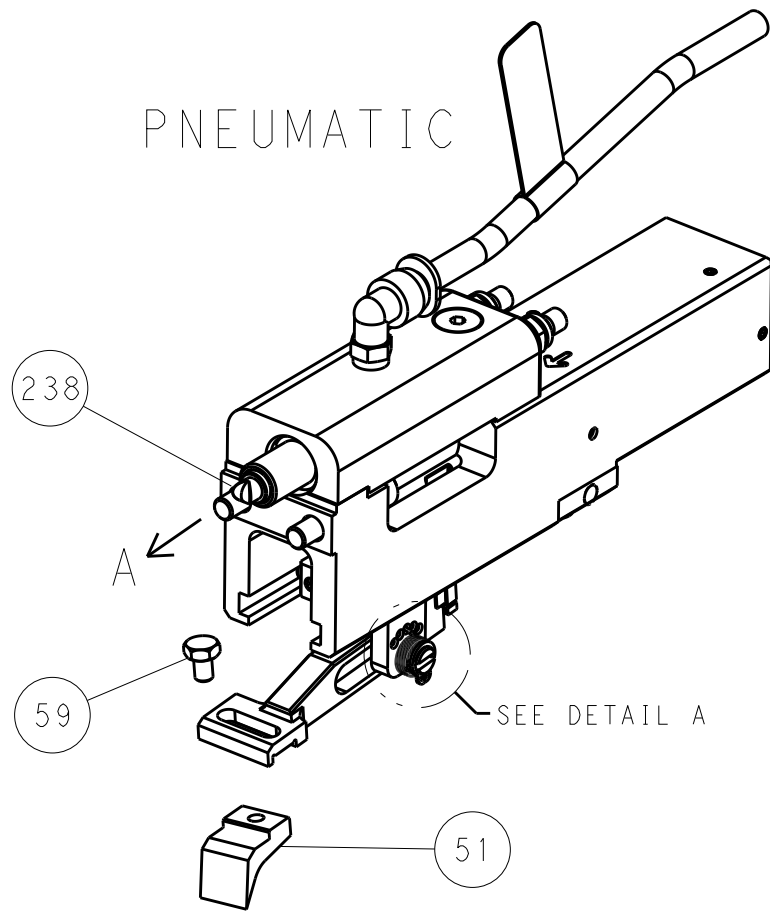


RAM AND HOLDDOWN SET-UP

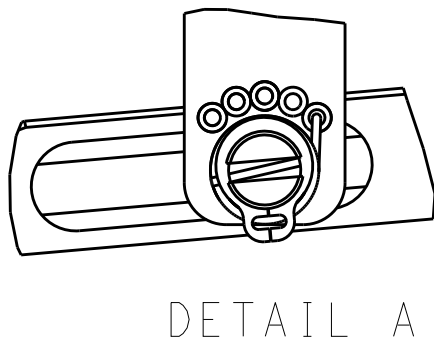


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

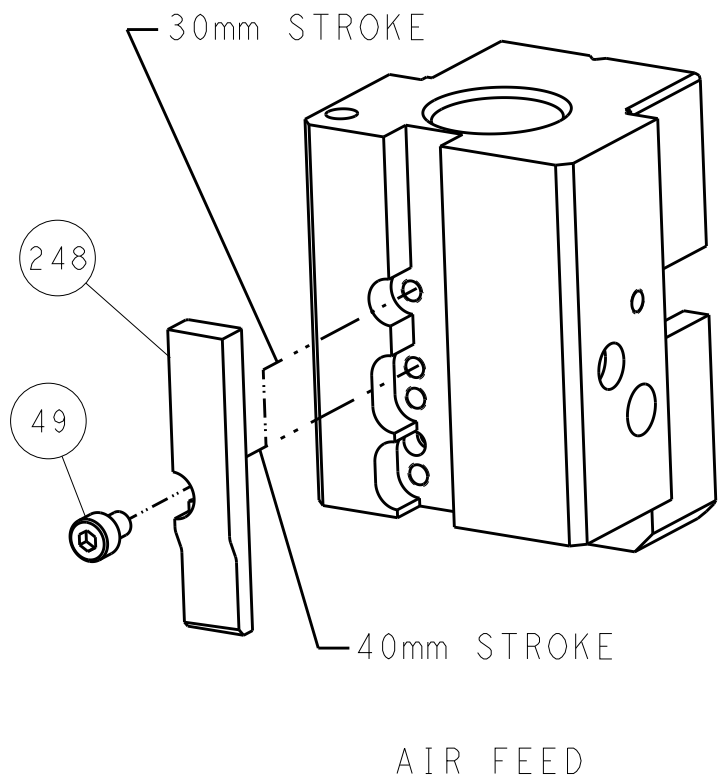
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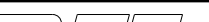
FEED SPRING
SETTING POSITION



CAM POSITION



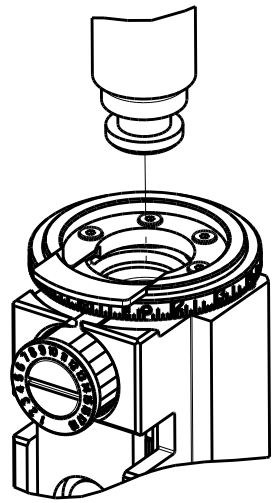
AIR FEED

1ST PUBLISHED BY: COMPANY LOGO FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND NOT BE USED FOR REPRODUCTION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION		DWN Y. YIN	05MAY2015	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK G. BAILEY	05MAY2015		
		APVD J. GUO	05MAY2015		
		PRODUCT SPEC			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
0 PLC		±			
1 PLC		±			
2 PLC		±			
3 PLC		±		SIZE A1	
4 PLC		±			
ANGLES		±			
FINISH		-			
MATERIAL		-		CAGE CODE	
				DRAWING NO	
				RESTRICTED TO	
				00779	
				©=2150135	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 2 OF 4	
				REV L	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150135-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150135-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT POSITIVE LOCK .250 SERIES			
WIRE STRIP LENGTH 4.39-5.17 mm [.173-.204 IN]			INSULATION DIAMETER RANGE Ø2.29-3.94 mm [.090-.155 IN]
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63097-1	63097-4	63442-1	2238155-1
63097-2	63809-1		2238155-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT POSITIVE LOCK .250 SERIES			
WIRE STRIP LENGTH 4.39-5.17 mm [.173-.204 IN]		INSULATION DIAMETER RANGE Ø2.29-3.94 mm [.090-.155 IN]	
TERMINAL APPLICATION SPECIFICATION			
114-2074			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238104-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/- .002]	5.4
16 AWG	1.65+/-0.05 [.065+/- .002]	7.7
18 AWG	1.47+/-0.05 [.058+/- .002]	9.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.00+/-0.05 [.079+/- .002]	4.1
16 AWG	1.83+/-0.05 [.072+/- .002]	8.2



- 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 180.
- 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH 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.

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

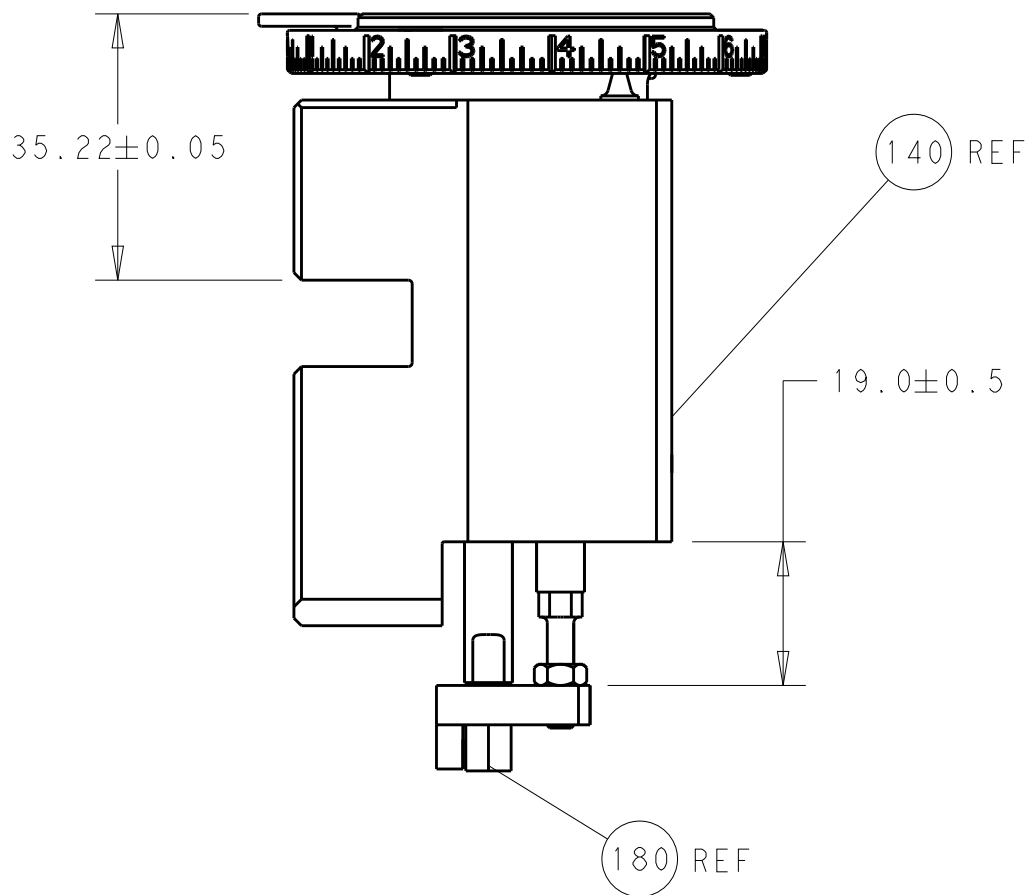
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
						SEE SHEET 1	

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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
-	1	1752354-9	STANDOFF,HOLD-DOWN	180
-	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	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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
-	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	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	72
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	2-1901681-7	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	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	2063961-1	FEED FINGER	51
-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-3	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1803152-1	STRIP GUIDE, REAR	19
-	1	1803151-1	STRIP GUIDE, FRONT	18
-	1	1-240641-8	SPACER	16
-	1	1-240641-1	SPACER	15
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	4-690482-6	PLATE, FRONT SHEAR	9
1	1	7-1803000-9	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-6	BLADE, SLUG	7
-	-	-	-	6
-	1	6-240641-9	SPACER	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	4-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
1	1	456408-6	CRIMPER, WIRE PREMIUM	1
-77-22	PART NO		DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4	
				REV L	

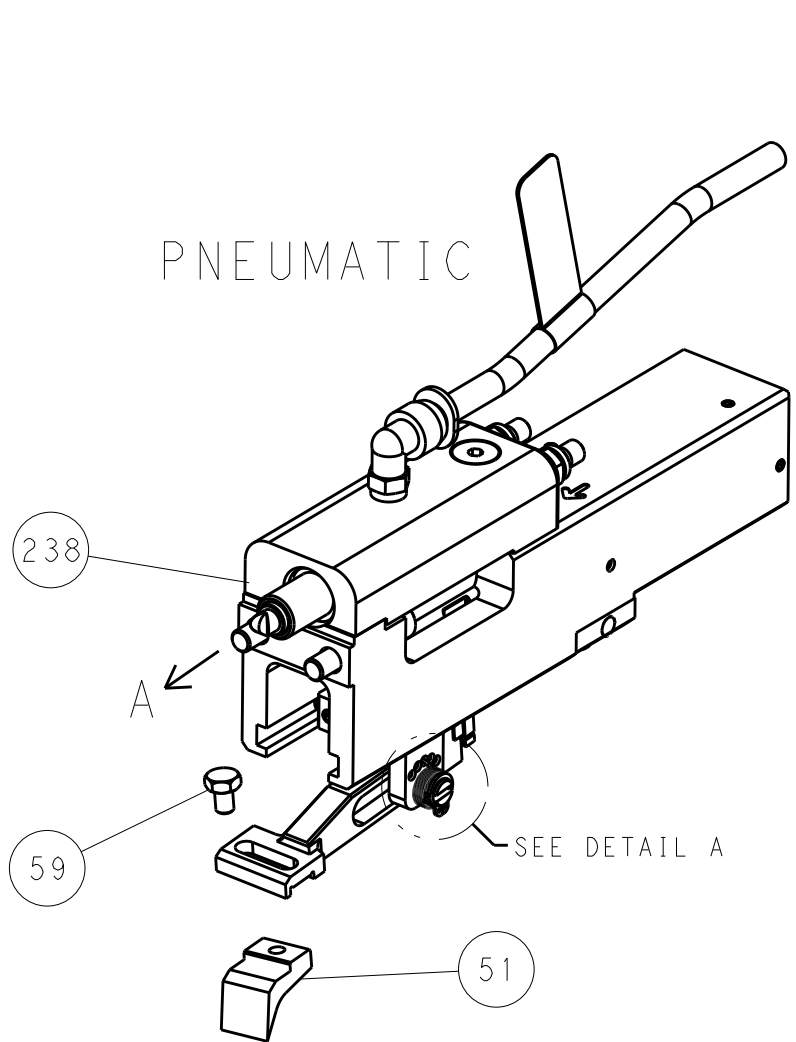
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

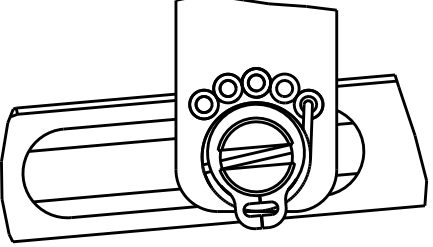


RAM AND HOLDDOWN SET-UP

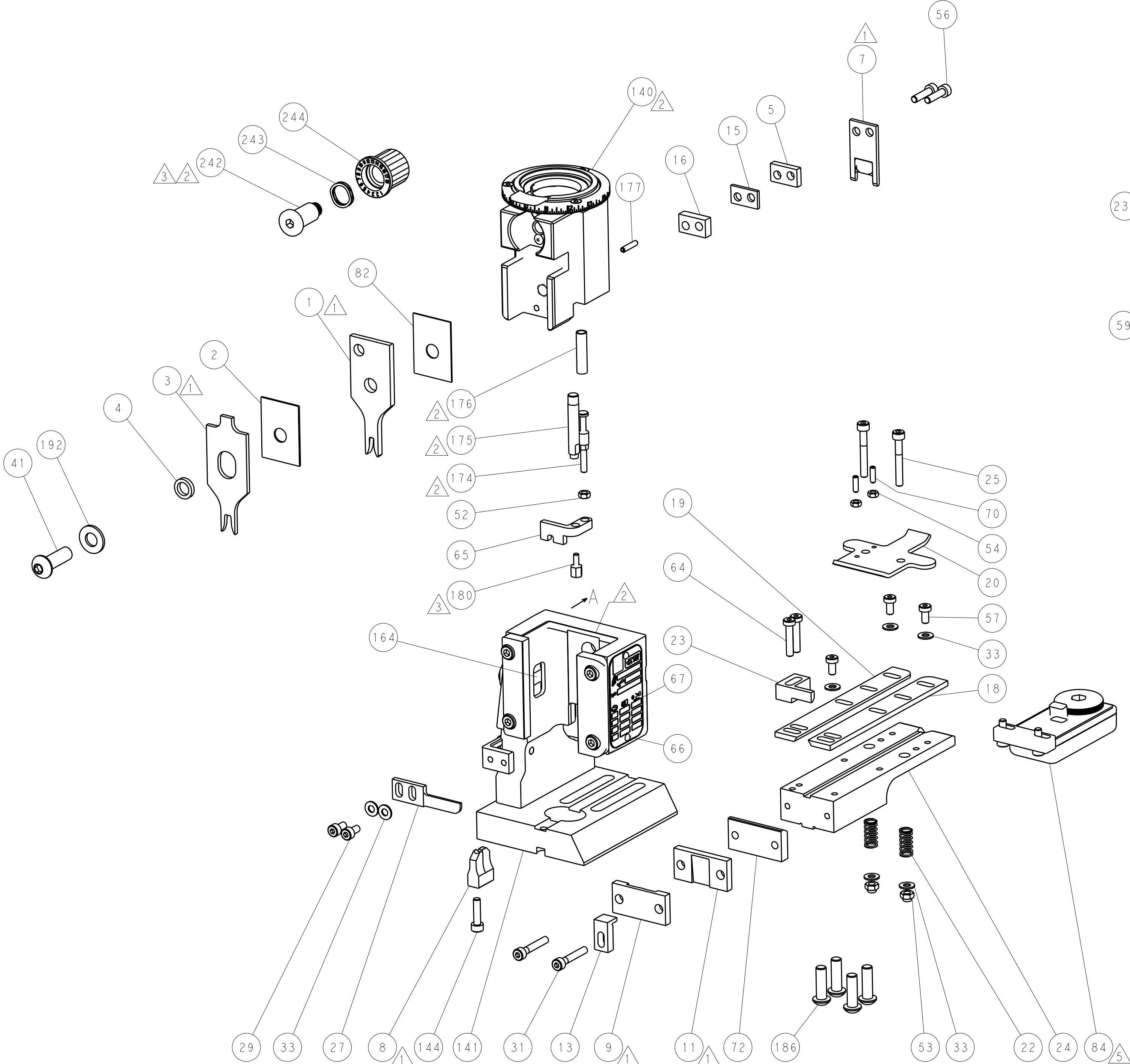
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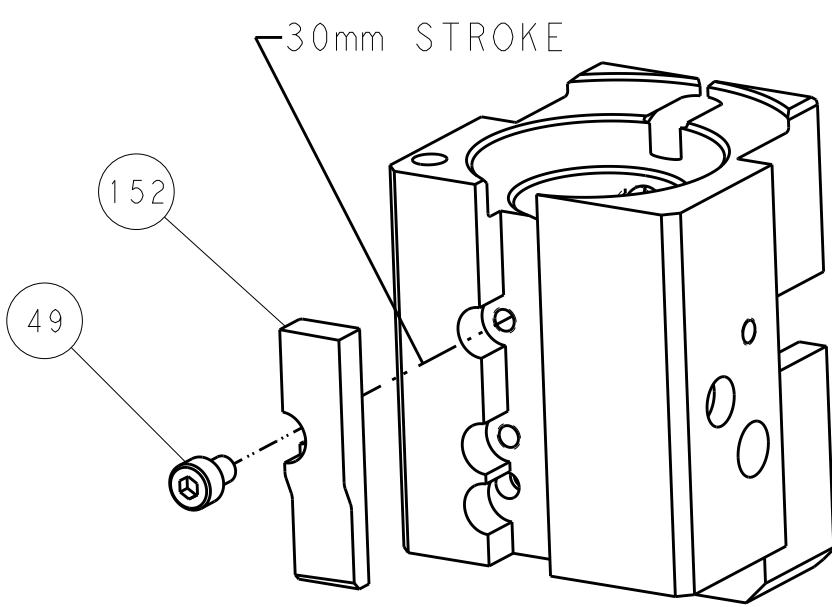
FEED SPRING SETTING POSITION



DETAIL A

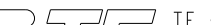
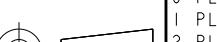


CAM POSITION



AIR FEED

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

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										CHK		G. BAILEY		05MAY2015											
										APVD		J. GUO		05MAY2015		NAME									
DIMENSIONS: mm 										TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean End Feed Applicator		SIZE				CASE CODE		DRAWING NO		RESTRICTED TO	
										APPLICATION SPEC		WEIGHT													
MATERIAL														A1		00779		©=2150135							
										Customer Accessible Production Drawing				SCALE		1:1		SHEET		4		OF 4		REV L	