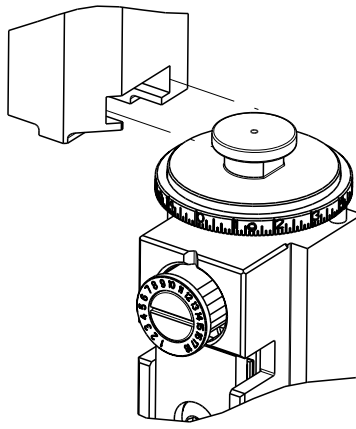


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150254-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150254-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150254-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150254-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150254-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.54 mm [.100]	Ø
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE,FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH 5.44-6.07 mm [.214-.239 IN]		INSULATION DIAMETER RANGE Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
114-2025		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL 60413-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22+/-0.05 [1.048+/- .002]	7.5
20 AWG	1.12+/-0.05 [1.044+/- .002]	9.4
22 AWG	1.07+/-0.05 [1.042+/- .002]	10.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50.
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. 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.

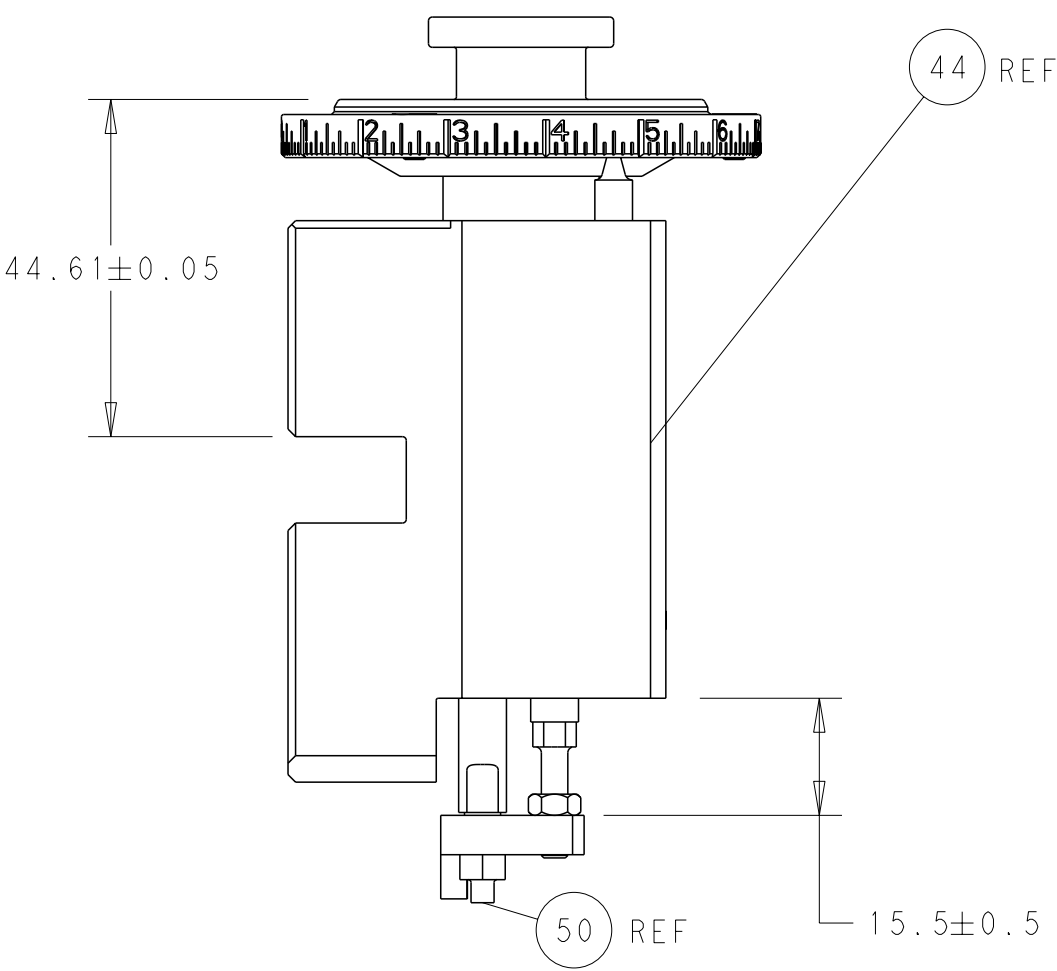
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	16MAY2012	XZ	SX
		B		ECR-18-014813	18SEP2018	JAH	TE
		B1		ECR-18-016520	17OCT2018	JAH	TE

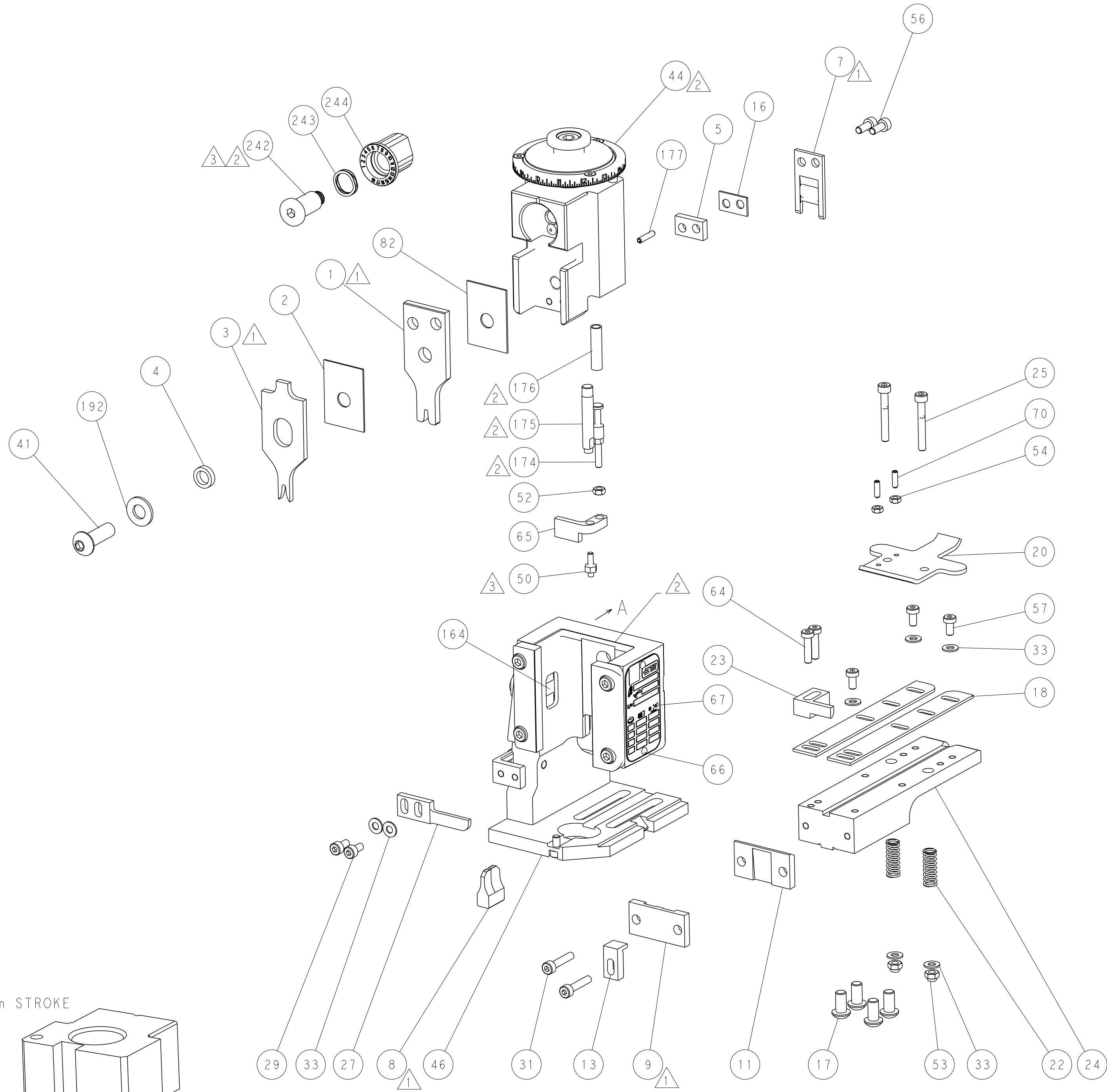
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	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
-	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	455888-8	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	-	2119792-1	PAWL, EF, AIR	51
3	-	1	1	1	1-1976055-0	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
-	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	1752371-6	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	4-22281-1	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-1	DRAG	20
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	6-240641-7	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	-	1	1	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	2	1	1-1803000-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	690474-3	BLADE, SLUG	7
-	1	1	1	1	2-240641-0	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	4-456406-5	CRIMPER, WIRE PREMIUM	1
-77-72-71-2-1		PART NO		DESCRIPTION		ITEM NO	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN X ZHAO CHK T.ELBIN APVD S X1	14MAR2012 14MAR2012 14MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		PRODUCT SPEC		SIZE	
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE	
-		-		WEIGHT		DRAWING NO	
-		-		RESTRICTED CUSTOMER		100779 ©=2150254	
						RESTRICTED TO	
						SCALE 1:1	
						SHEET 1 OF 4	
						REV B1	

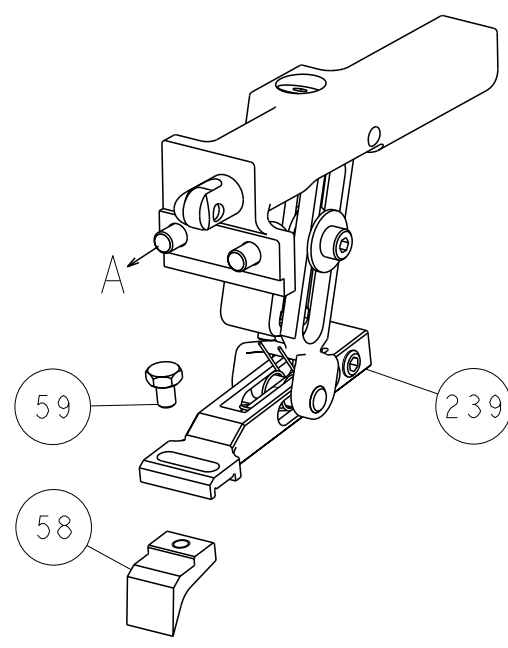
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



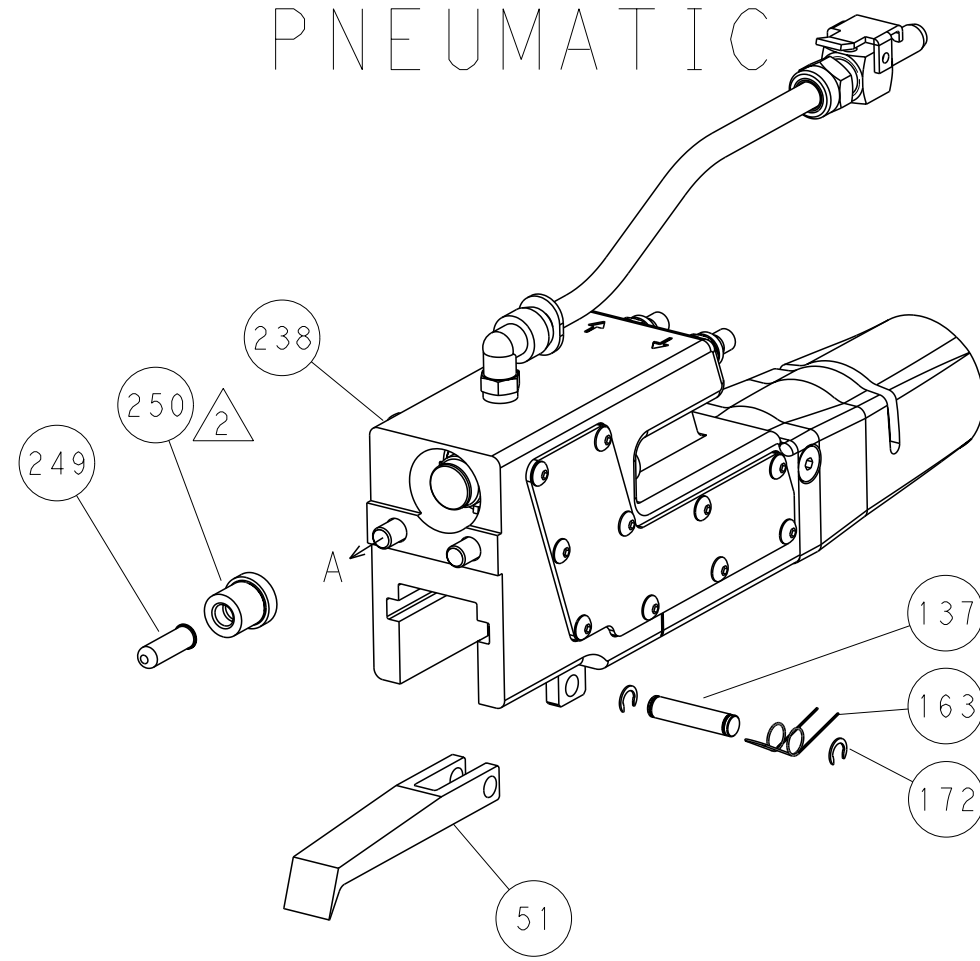
RAM AND HOLDDOWN SET-UP



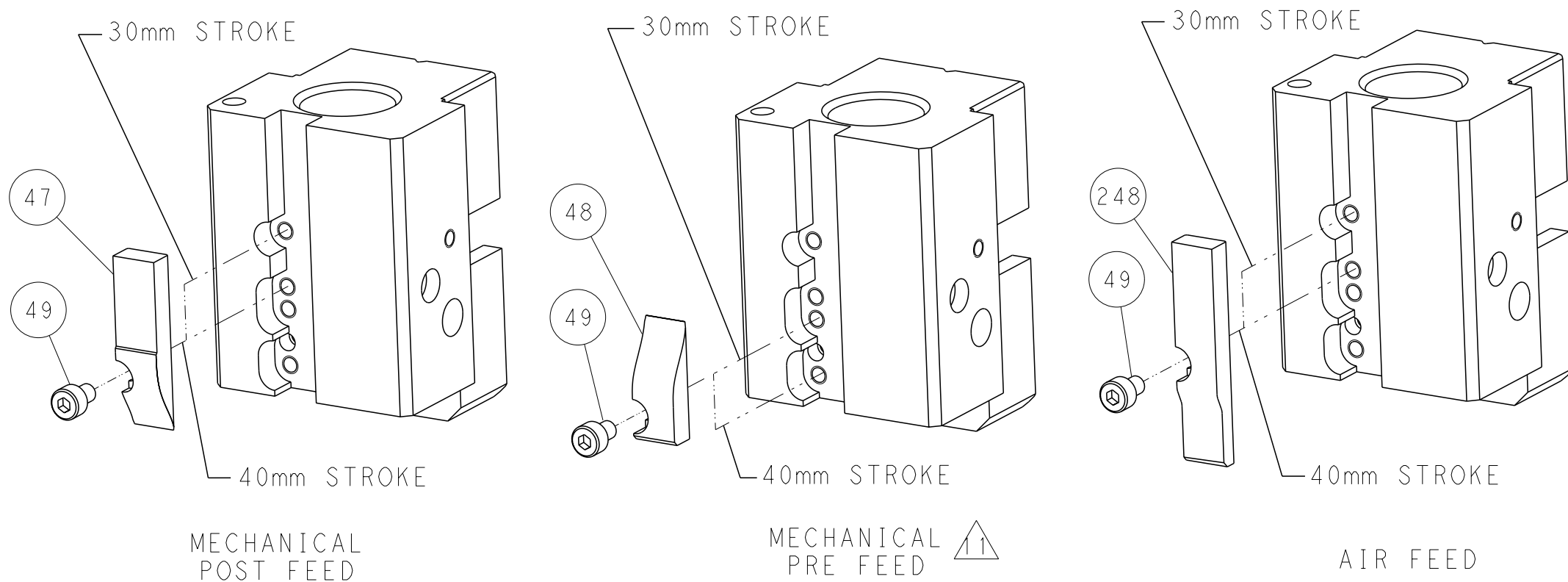
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

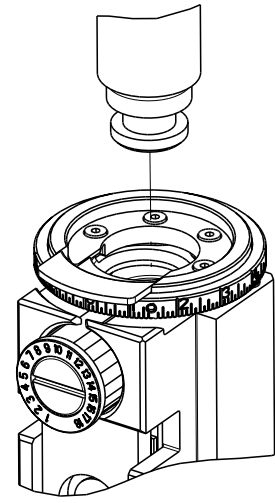


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN X. ZHAO 14MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
CMR T. ELBIN 14MAR2012				NAME	Ocean End Feed Applicator	
APVD S. XI 14MAR2012				PRODUCT SPEC	-	
APPLICATION SPEC				SIZE	A1	
MATERIAL				WEIGHT	00779	
RESTRICTED CUSTOMER				SCALE	1:1	
				SHEET	2 of 4	
				REV	B1	

8		7	
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20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150254-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150254-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150254-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE,FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH 5.44-6.07 mm [.214-.239 IN]		INSULATION DIAMETER RANGE Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
114-2025		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60413-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.22+/-0.05 [.048+/- .002]		7.5
20 AWG		1.12+/-0.05 [.044+/- .002]		9.4
22 AWG		1.07+/-0.05 [.042+/- .002]		10.0

-
- RECOMMENDED SPARE PARTS

REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

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.

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.

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)

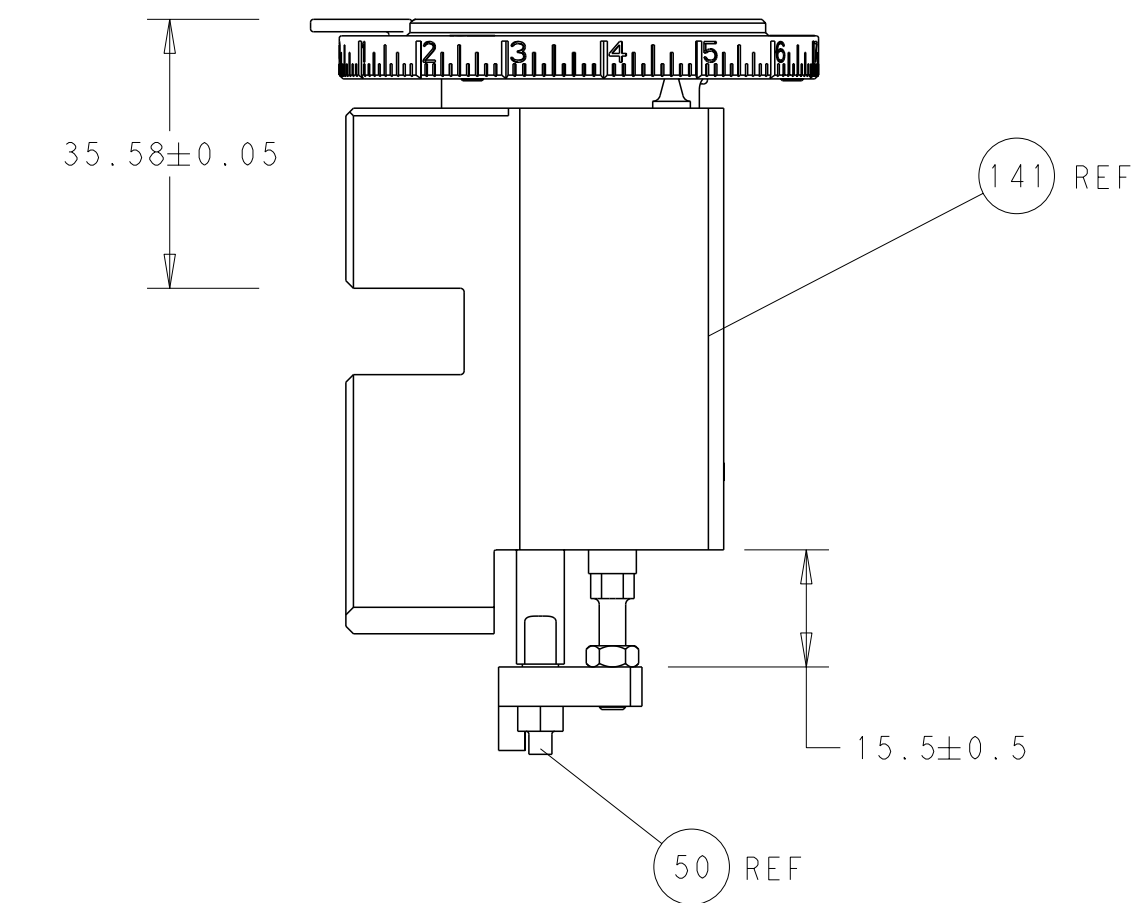
LOC	DIST	REVISIONS				
		#	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	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	-	2063440-1	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	6-9931111-6	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	-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-8	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	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2119792-1	PAWL, EF, AIR	51
-	1	1	1-1976055-0	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
-	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	1752371-6	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	6-240641-7	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1-1803000-3	ANVIL, COMBINATION, END FEED	8
-	1	1	690474-3	BLADE, SLUG	7
-	1	1	2-240641-0	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	4-456406-5	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO

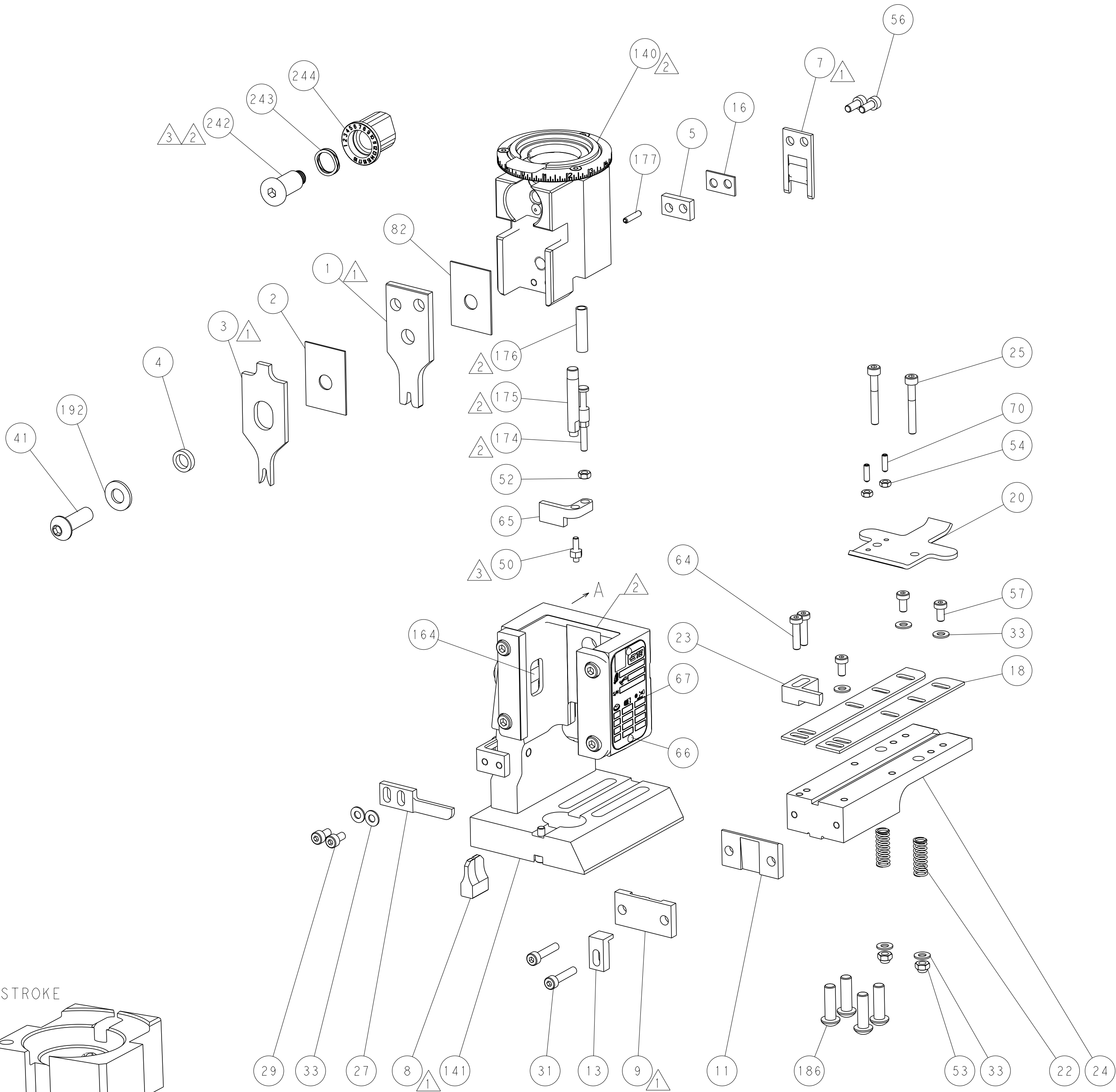
THIS DRAWING IS CONTROLLED FOR CONFORMANCE WITH THE REQUIREMENTS OF THE QUALITY MANAGEMENT SYSTEM. IT IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING DEPARTMENT SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN X ZHAO CHK T.ELBIN APVD S XI	14MAR2012 14MAR2012 14MAR2012	NAME Ocean End Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE CAGE CODE DRAWING NO	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		RESTRICTED TO	
MATERIAL :		FINISH :		WEIGHT :	
				RESTRICTED CUSTOMER	
				SCALE 1:1	
				SHEET 3 OF 4	
				REV B1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

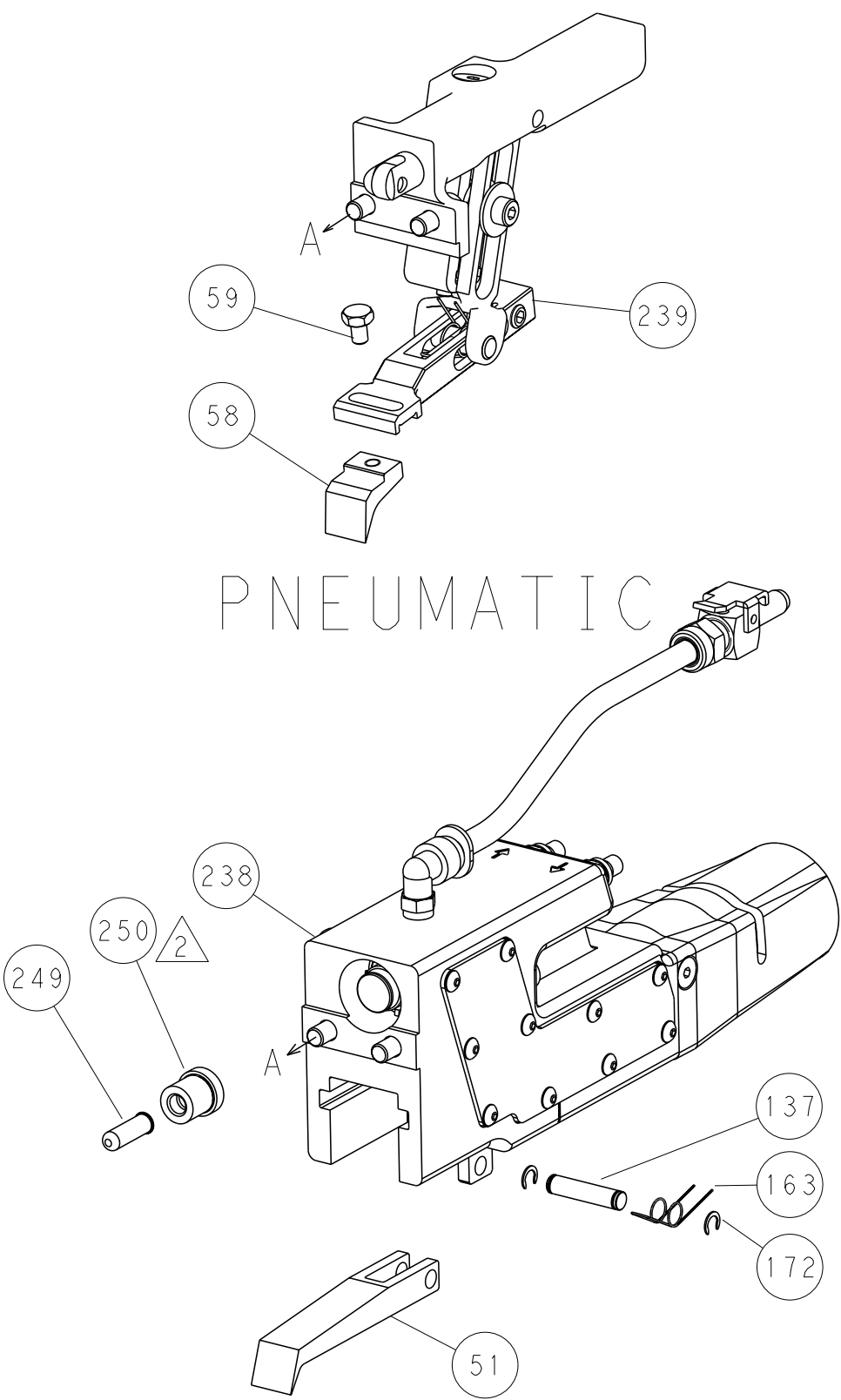
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP

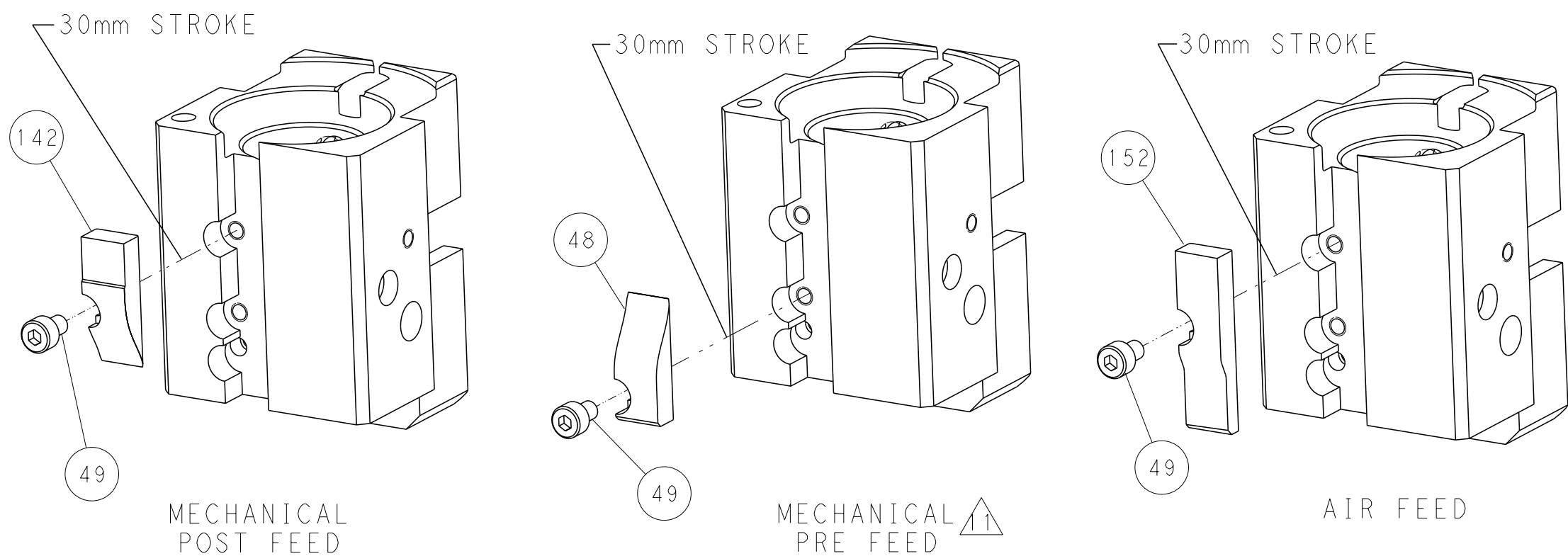


FEED TYPE
MECHANICAL



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN X. ZHAO 14MAR2012	TE Connectivity Harrisburg, PA 17105-3608		
				CHK T. ELBIN 14MAR2012			
				APVD S. YI 14MAR2012	NAME Ocean End Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				RESTRICTED CUSTOMER			
				SCALE 1:1	SHEET 4 of 4		
					REV B1		