

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150185-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150185-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150185-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150185-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150185-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.10 mm [.240]	F
APPLICATOR INSTRUCTIONS 408-35043		

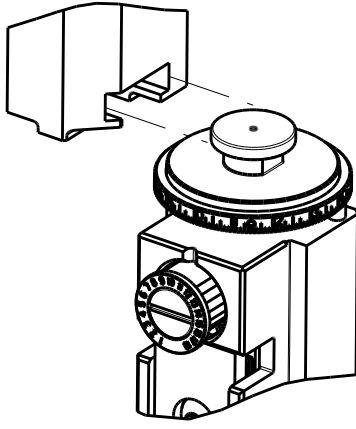
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE,POSITIVE-LOCK, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-6.20 mm [.173-.244 IN]		Ø3.05-4.31 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217095-1	1217095-2	1217092-1	1217092-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2)16AWG	1.78+/-0.05 [.070+/- .002]	6.3
1)16 AWG + (1)18 AWG	1.70+/-0.05 [.067+/- .002]	7.1
(2)18 AWG	1.60+/-0.05 [.063+/- .002]	8.1
16 AWG	1.50+/-0.05 [.059+/- .002]	9.1



- 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 ITEM 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



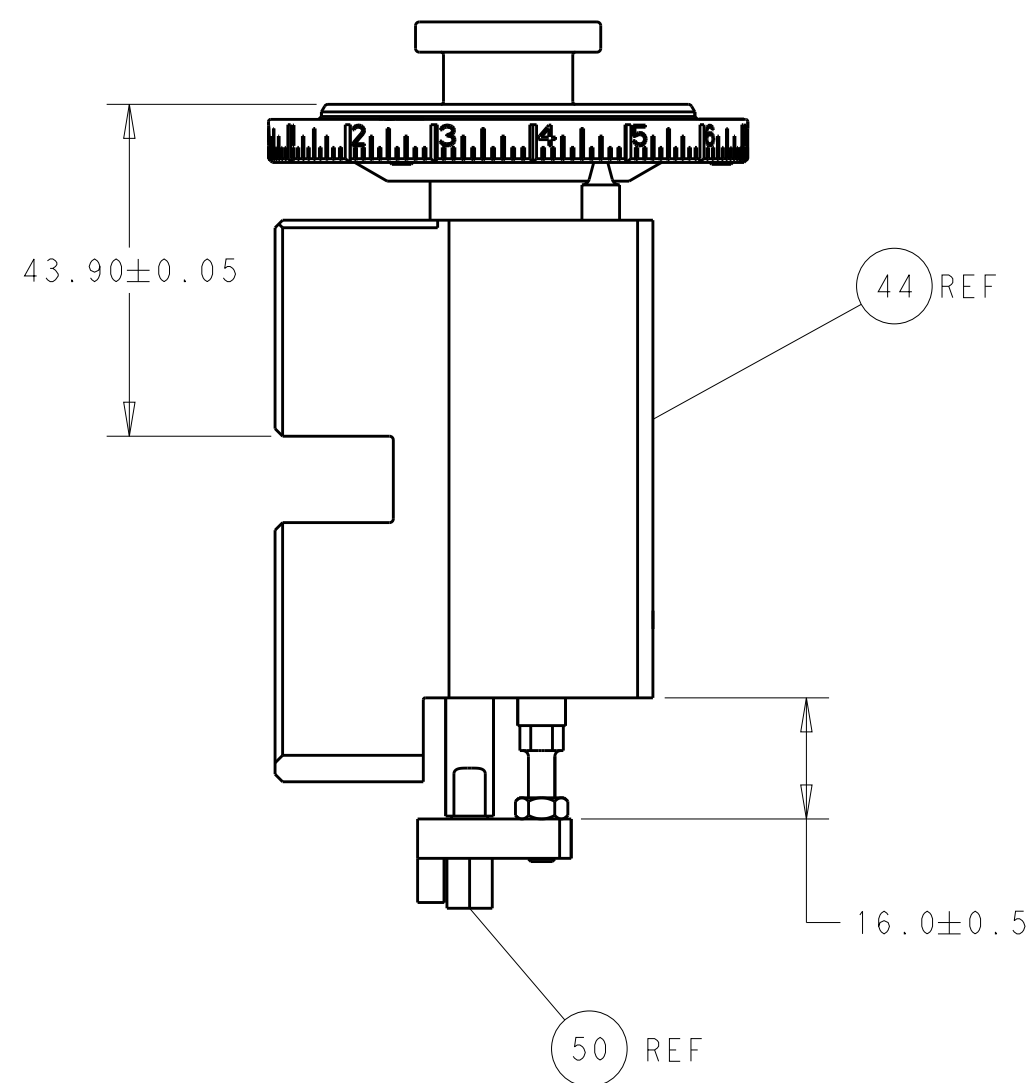
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

*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.

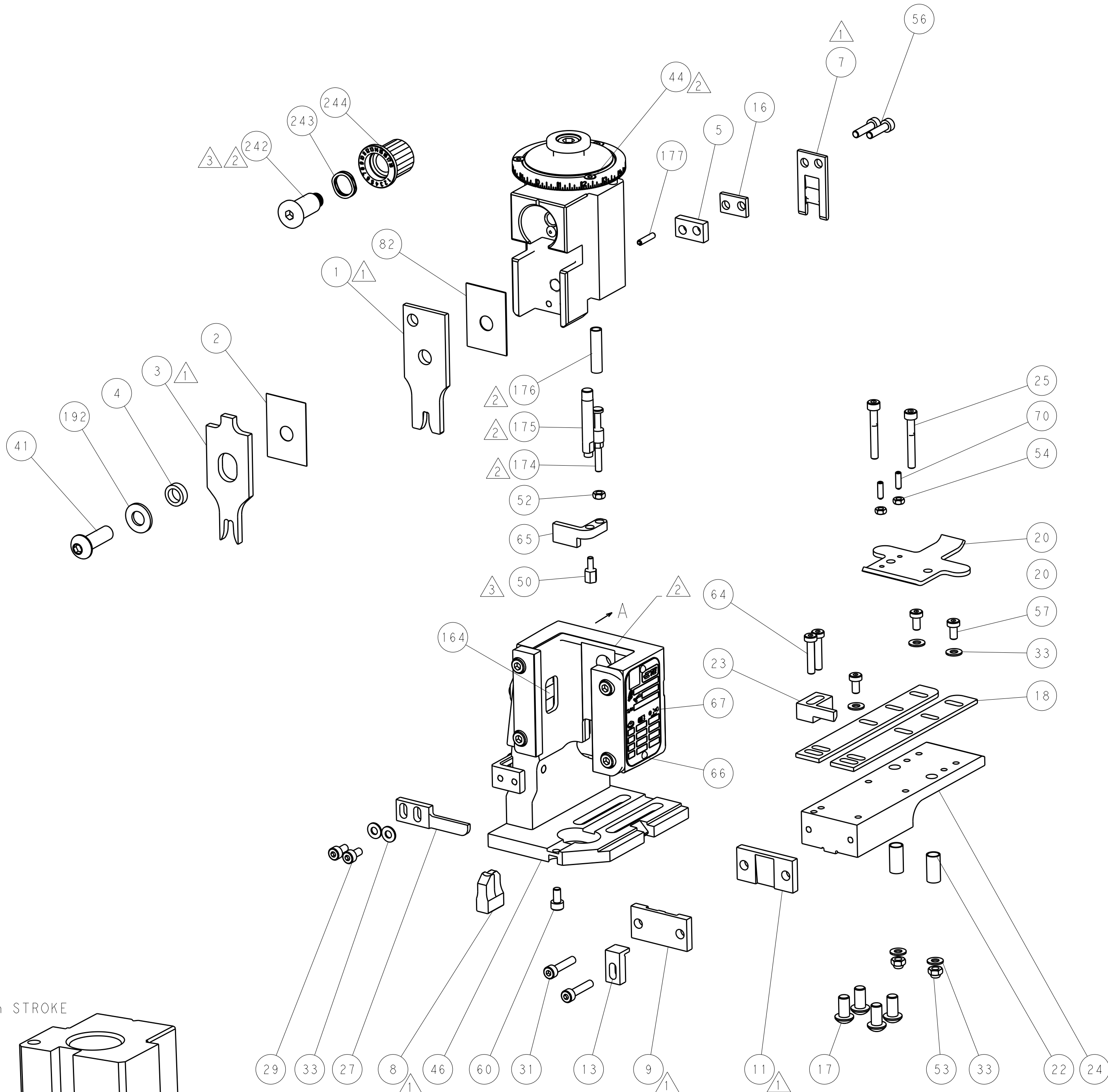
A	DIST	66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
			B		ECR-14-012840	27AUG2014	KH	TE
			B1		ECR-15-012692	02SEP2015	XZ	UG
			C		ECR-18-018078	19NOV2018	FZ	KZ
			D		ECR-18-019999	29DEC2018	MZ	YY
-		2119640-1			PUSH ROD, AIR FEED			250
-		1803259-1			BUSHING, FLANGED			249
		2119641-1			FEED CAM, AIR FEED			248
		2119082-9			CAM, SNAIL, INSULATION ADJUSTMENT			244
		2079764-1			WASHER, WAVE SPRING, CREST-TO-CREST			243
		2119083-1			RETAINER, INSULATION DIAL			242
		2119580-1			MECHANICAL FEED ASSEMBLY			239
-		2063440-1			AIR FEED MODULE			238
		1-18028-0			WASHER, FLAT, REG M8			192
		6-993111-6			PIN, SLOTTED SPRING 3.0 X 14.0			177
		8-22280-7			SPRING, COMPRESSION			176
		1752353-2			GUIDE PIN,HOLDDOWN			175
-		1901680-2			GUIDE PIN,HOLDDOWN			174
		21045-3			RING, RETAIN, EXTERN, 3/16 CRESCENT			172
F		994970-2			COUNTER, MAGNETIC			164
-		240638-1			SPRING, FEED FINGER			163
-		3-23627-7			PIN, RETAIN, GRVD, 3/16 X .854			137
-		455888-5			SPACER, CRIMPER			82
		1803607-2			DOCUMENTATION PACKAGE			71
2		2-18032-2			SCR, SET, FLT PNT, M3 X 10.0			70
		2119740-1			TAG,IDENTIFICATION			67
2		2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188			66
		1901681-5			HOLDDOWN, TERMINAL			65
2		2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20			64
		2168083-2			SCR, SKT HD CAP, RoHS, M4 X 8.0			60
		5-18022-5			SCR, HEX HD CAP, M4 X 6.0			59
		2063961-1			FEED FINGER			58
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
		1-5018030-0			NUT, HEX, REG, RoHS, M3.5			52
-		2119792-2			PAWL, EF, AIR			51
		1-1752354-1			STANDOFF,HOLD-DOWN			50
2		18023-9			SCR, SKT HD CAP M4 X 6.0			49
		2119652-1			FEED CAM, PRE FEED			48
		2119653-1			FEED CAM, POST FEED			47
		2119655-5			APPLICATOR BASIC ASSEMBLY, EF			46
		1803517-1			RAM ASSEMBLY, EF ATLANTIC			44
		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
		240639-1			STRIPPER (MACHINING)			27
2		1-2168083-5			SCR, SKT HD CAP, RoHS, M4 X 30			25
		1752371-1			PLATE, STRIP GUIDE			24
		240825-3			PLATE, STRIP HOLD DOWN			23
2		22281-9			SPRING, COMPRESSION			22
		1803292-1			DRAG			20
2		1-1901259-0			GUIDE, LOWER STRIP			18
4		1-2079383-1			SCR, BHSC, RoHS (M6 X 12)			17
		8-240641-6			SPACER			16
		1752360-1			SPACER,HOLD-DOWN			13
		240644-1			PLATE, REAR SHEAR			11
-		-			-			10
		690482-4			PLATE, FRONT SHEAR			9
		3-1633383-9			ANVIL, COMBINATION			8
		690474-4			BLADE, SLUG			7
		240641-3			SPACER			5
		238011-1			BLOCK, CRIMPER SPACER			4
		4-2119582-3			CRIMPER, INSULATION F PREMIUM			3
		455888-1			SPACER, CRIMPER			2
		1-456411-5			CRIMPER, WIRE PREMIUM			1
1		PART NO			DESCRIPTION			ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE TO THE USER.		DWN	X.ZHAO	28FEB2012	TE Connectivity Harrisburg, PA 17105-3608		
CHK		T.ELBIN		28FEB2012	NAME		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
mm		0 PLC ±.01		APPLICATION SPEC			
1 PLC ±.01		2 PLC ±.01		WEIGHT			
3 PLC ±.01		4 PLC ±.01		Customer Accessible Production Drawing		SCALE	
MATERIAL		FINISH		1:1		SHEET	
-		-		00779		OF	
				©=2150185		REV	
				D			

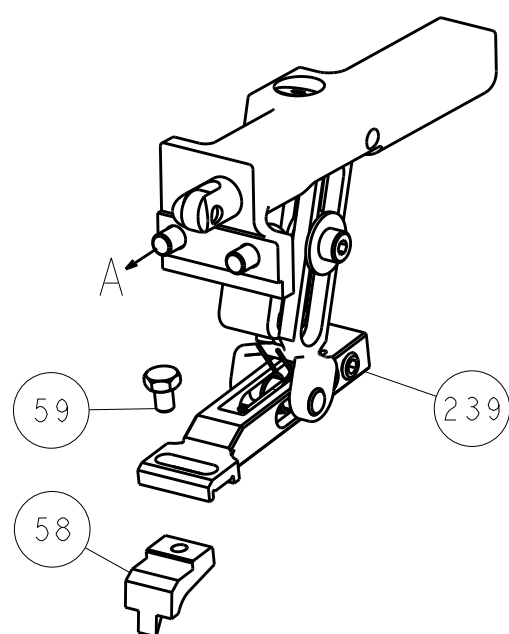
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



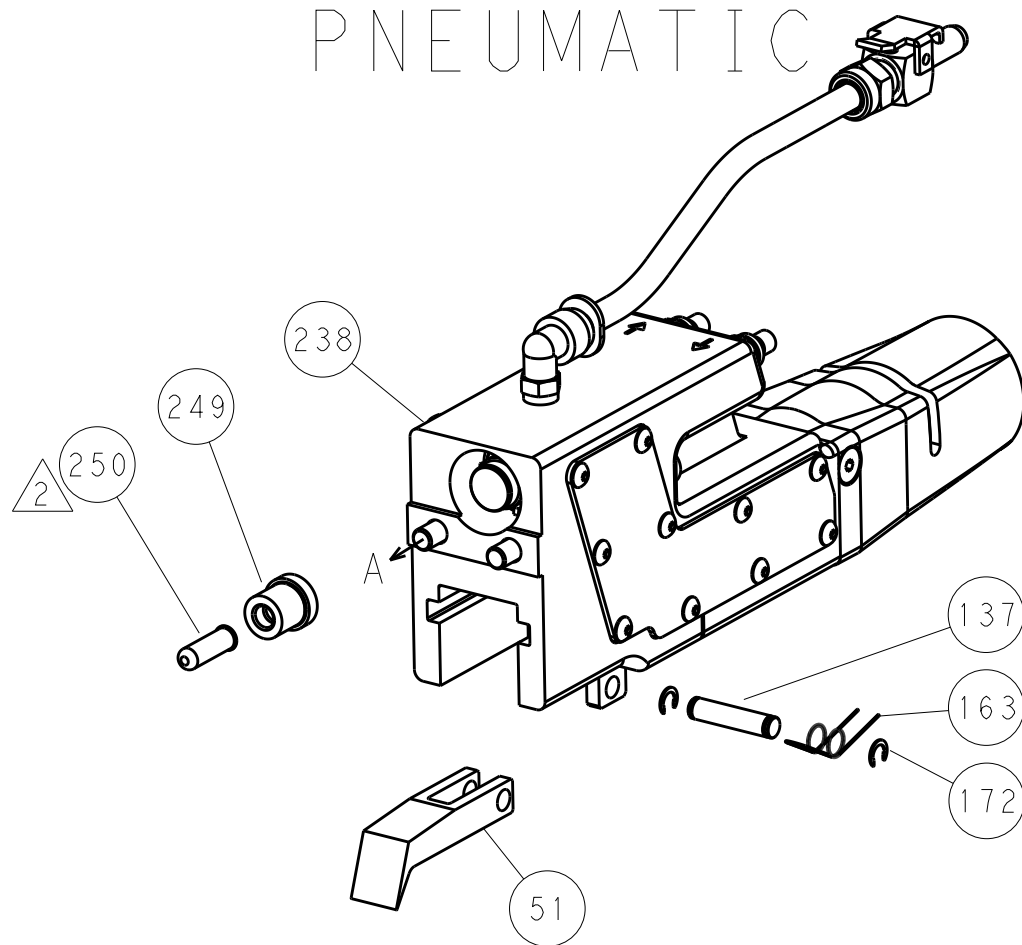
RAM AND HOLDDOWN SET-UP



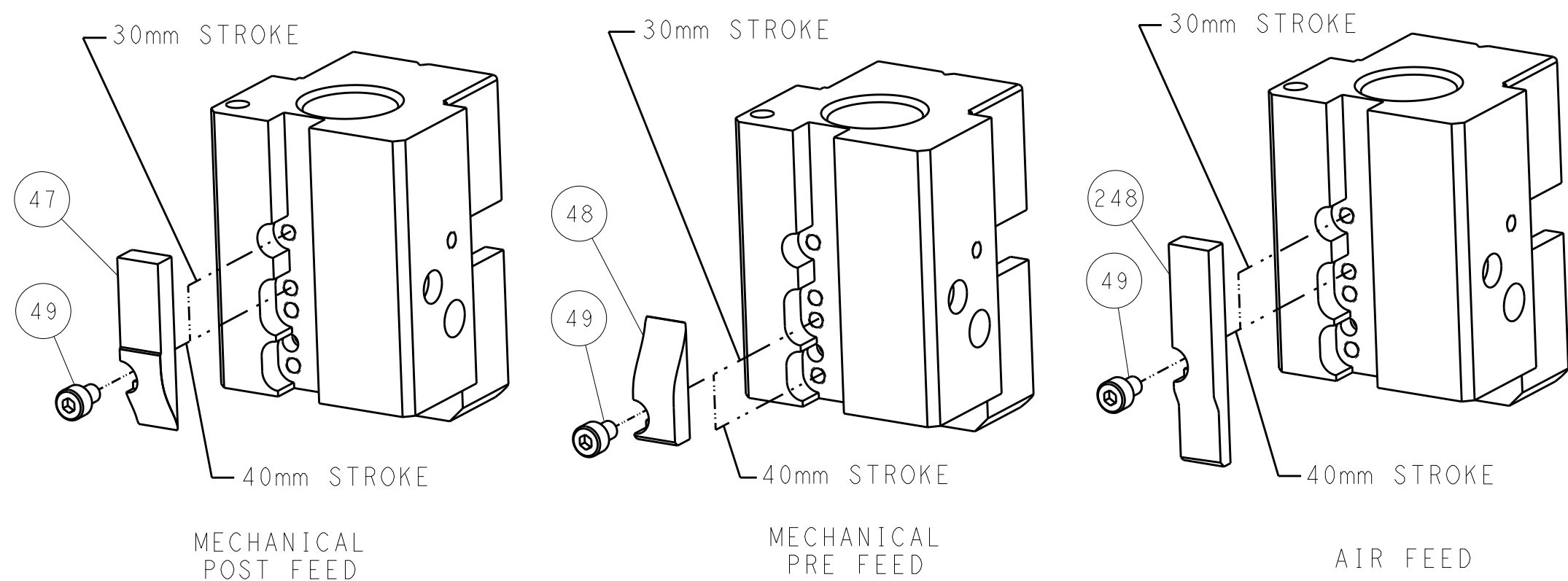
FEED TYPE
MECHANICAL



PNEUMATIC



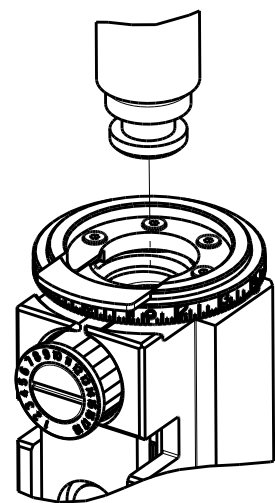
CAM POSITIONS



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

1ST PUBLISHED BY A COMPANY OF TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE BUYER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN X. ZHAO	28FEB2012	 TE Connectivity Harrisburg, PA 17105-3608							
				CHK T. ELBIN	28FEB2012								
				APVD S. XI	28FEB2012	NAME Ocean End Feed Applicator							
				PRODUCT SPEC									
				APPLICATION SPEC									
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.10 mm [.240]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES			
WIRE STRIP LENGTH 4.40-6.20 mm [.173-.244 IN]		INSULATION DIAMETER RANGE Ø3.05-4.31 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED		TERMINALS APPLIED	
TE TERMINAL 1217095-1	TE TERMINAL 1217095-2	TE TERMINAL 1217092-1	TE TERMINAL 1217092-2

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
(2)16AWG			1.78+/-0.05 [0.070+/- .002]		6.3
1)16 AWG + (1)18 AWG			1.70+/-0.05 [0.067+/- .002]		7.1
(2)18 AWG			1.60+/-0.05 [0.063+/- .002]		8.1
16 AWG			1.50+/-0.05 [0.059+/- .002]		9.1

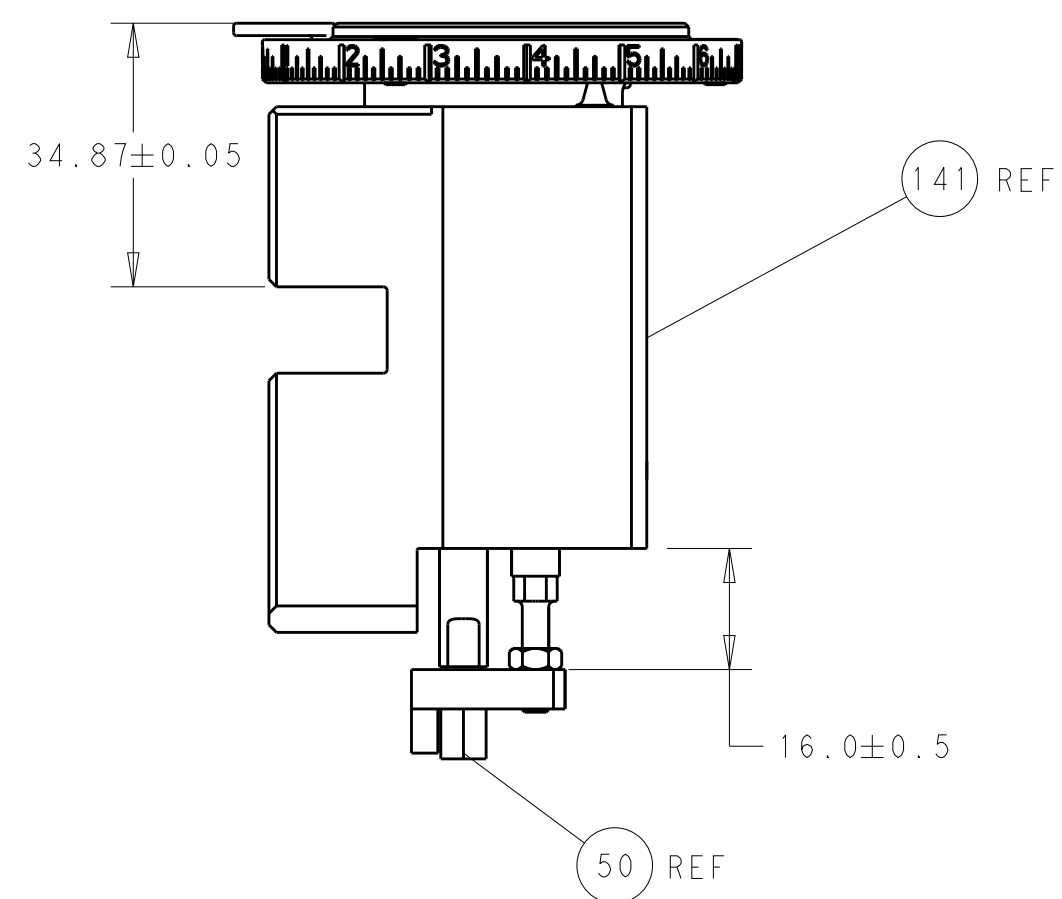


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

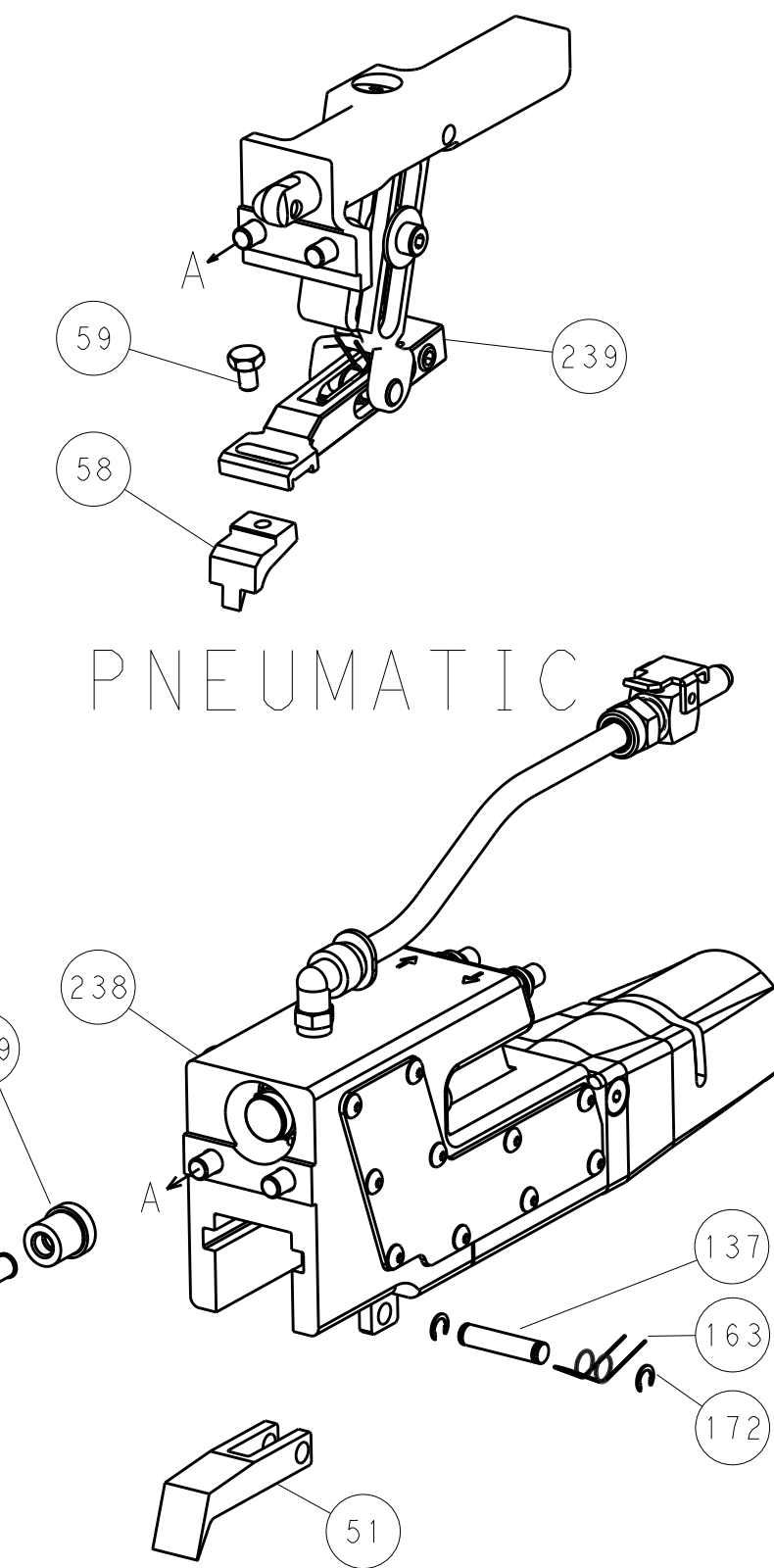
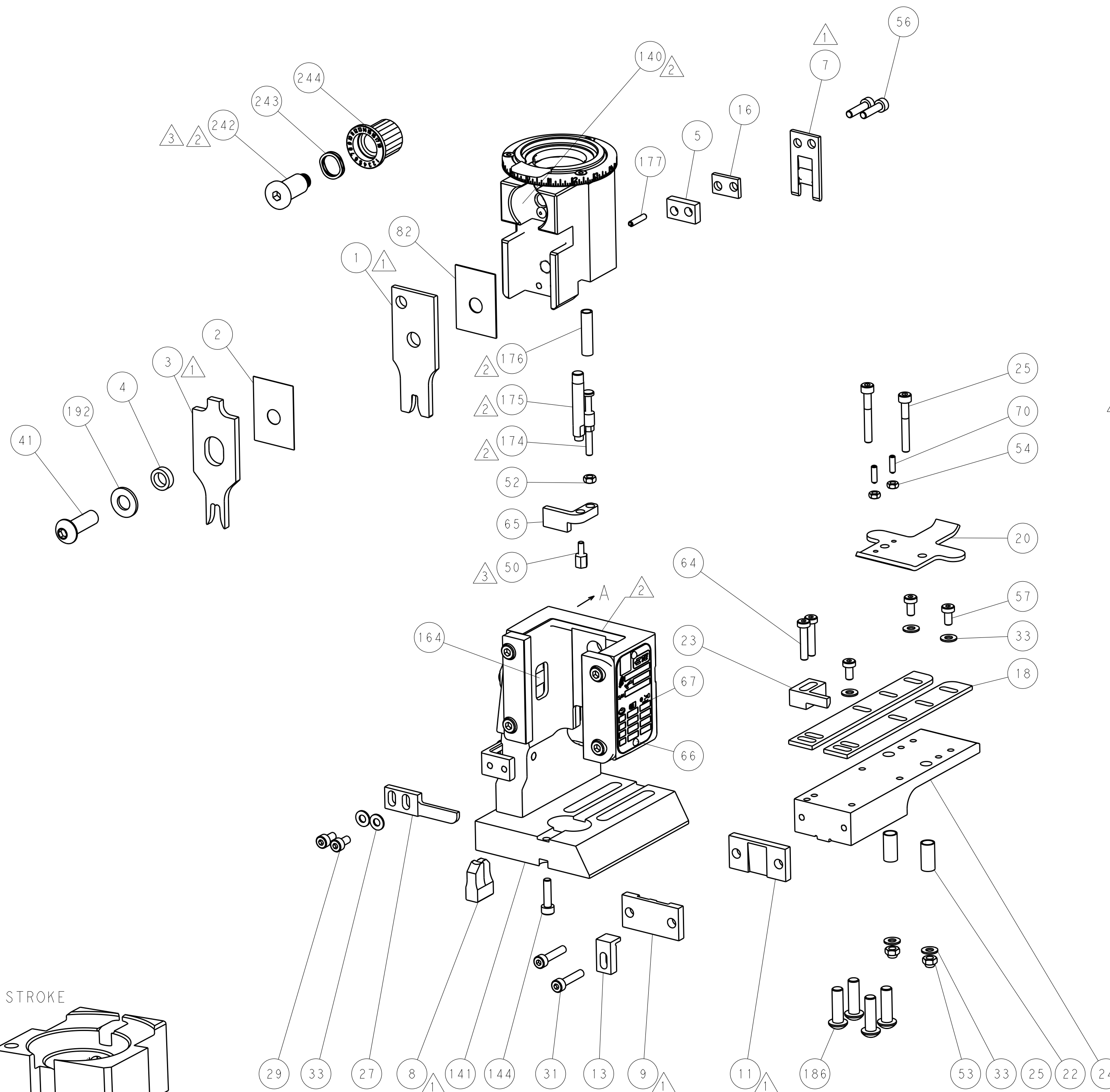
```
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING.
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.
```

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

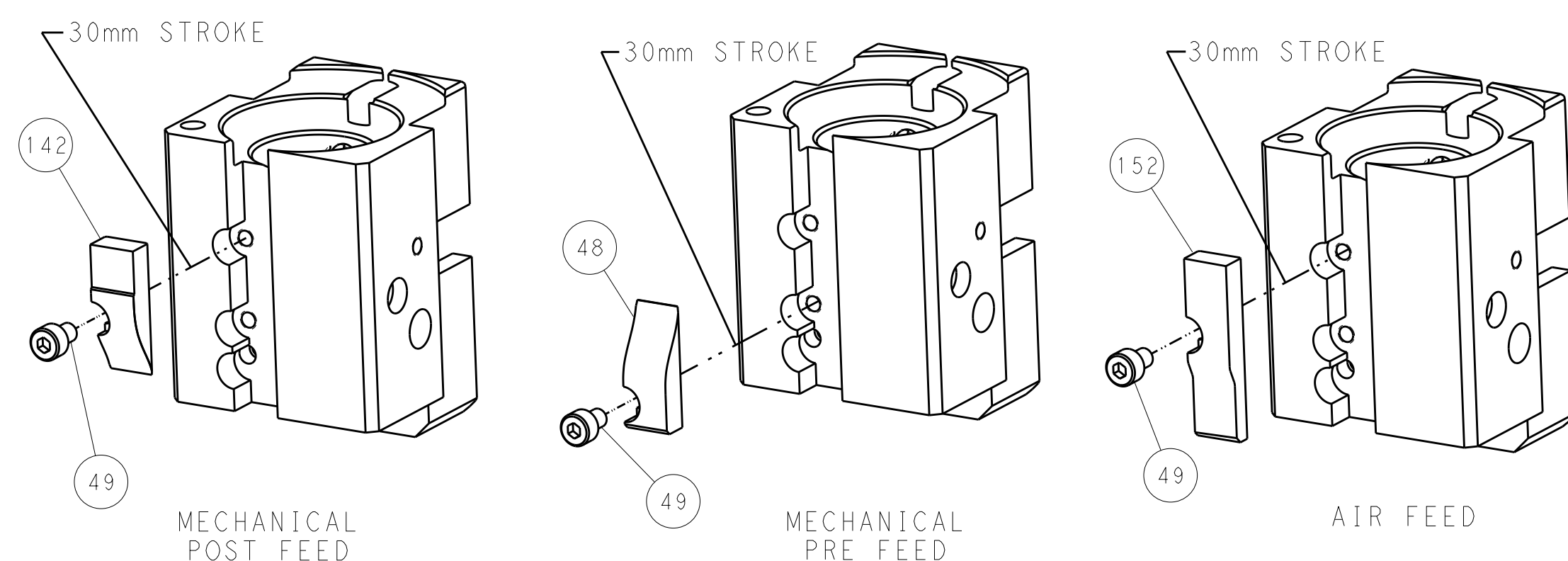
[illegible][illegible]



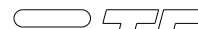
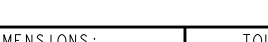
RAM AND HOLDDOWN SET-UP



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 CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION.		DWN X ZHAO 28FEB2012 CHK ELBIN 28FEB2012 APVD S.XI 28FEB2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A1 00779 C=2150185	
MATERIAL -		FINISH - WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET A OF A REV D	