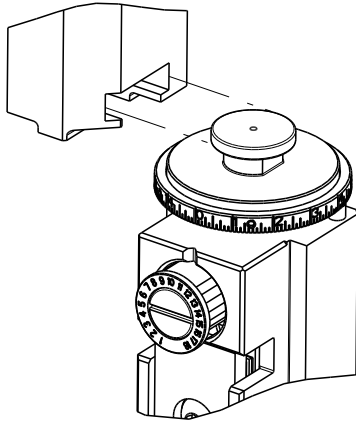


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150323-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150323-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150323-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150323-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150323-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.50 mm [.138]	F
INSUL	4.50 mm [.177]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON CONNECTOR, .250 SERIES			
WIRE STRIP LENGTH 5.84-6.60 mm [.230-.260 IN]			INSULATION DIAMETER RANGE Ø3.80-5.10 mm [.150-.201 IN]
TERMINAL APPLICATION SPECIFICATION	114-20023	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-160301-6	1-160301-8	1-160301-9	2-160301-8
2-160301-9			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm2		2.51+/-0.03 [.099+/-0.001]		9.8



- 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.
- 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.
- 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)

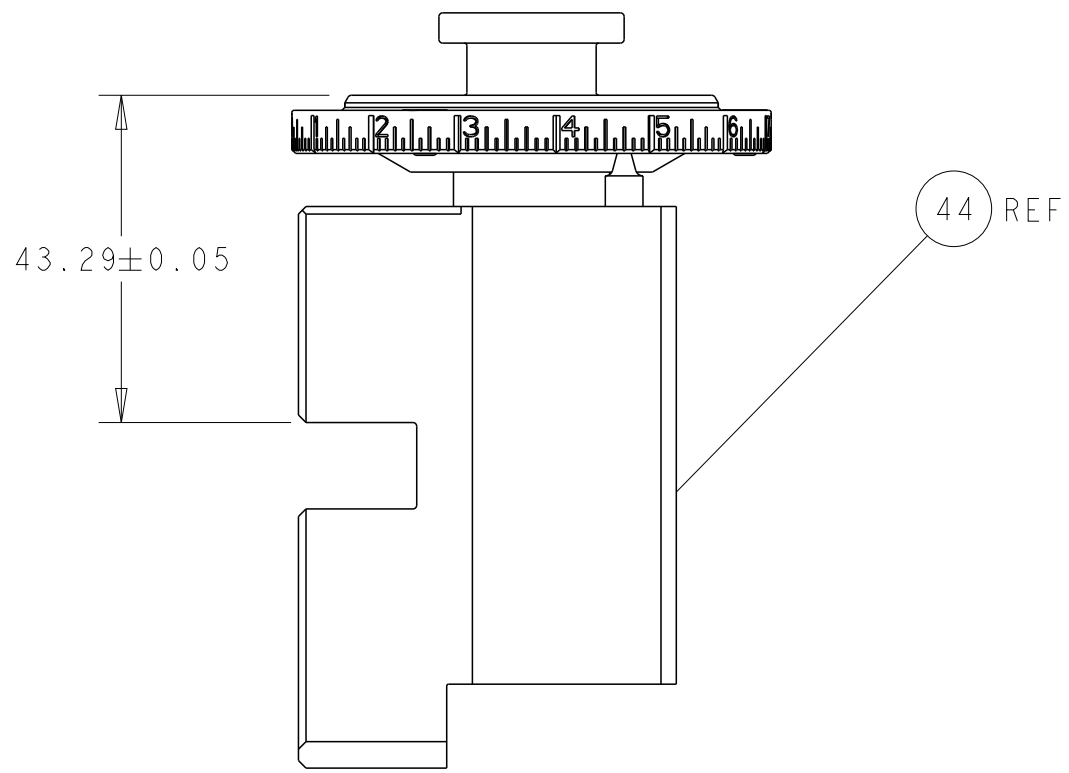
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LOC	DIST	REVISIONS							
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		B		ECR-17-014130			25SEP2017	KH	CT
		C		ECR-18-017485			06NOV2018	TB	CT

-	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
-	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
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	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
-	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	-	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	1-1752371-6	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-2	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	1901259-7	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	4-690495-3	PLATE, FRONT SHEAR	9
-	1	2	2	1	1803074-5	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-5	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-2	SPACER	5
-	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	4-1633962-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	8-1633609-3	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN L. GROSS CHK G. BAILEY APVD M. CLIFFORD	08OCT2013 08OCT2013 08OCT2013	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=2150323	RESTRICTED TO -
				Customer Accessible Production Drawing	
				SCALE 1:1	SHEET 1 OF 4
				REV C	

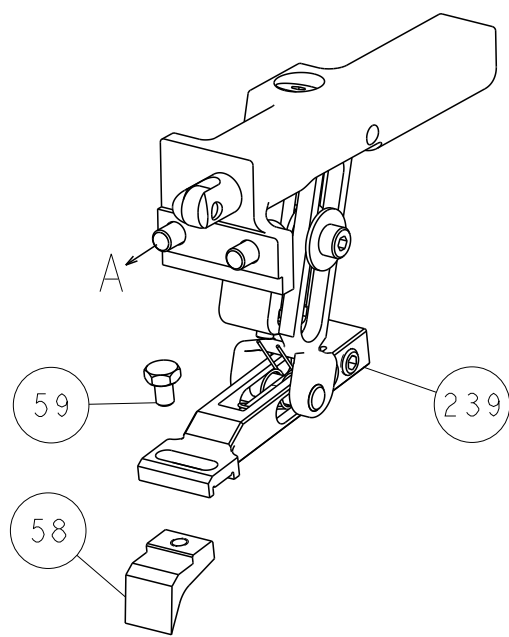
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

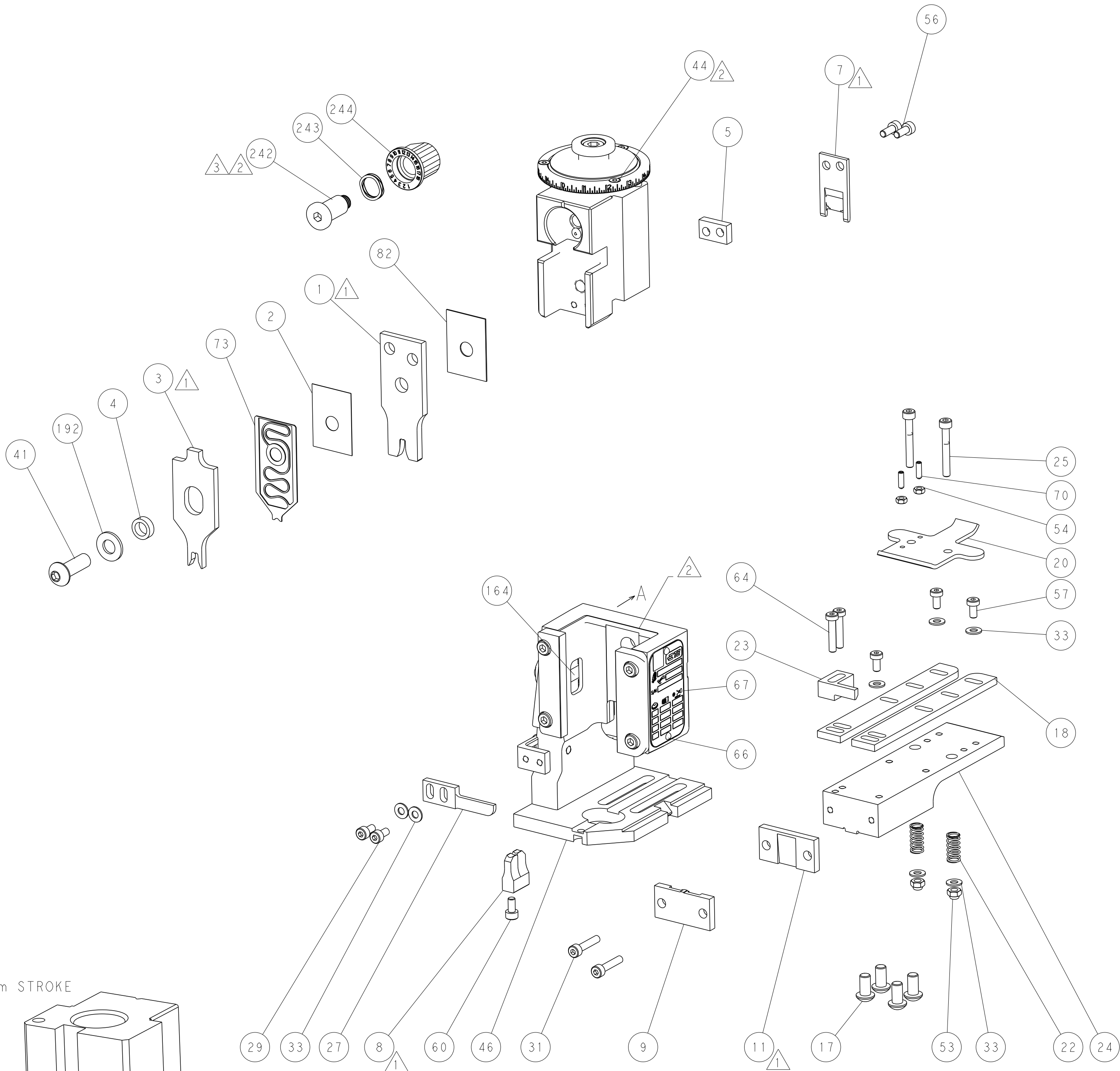
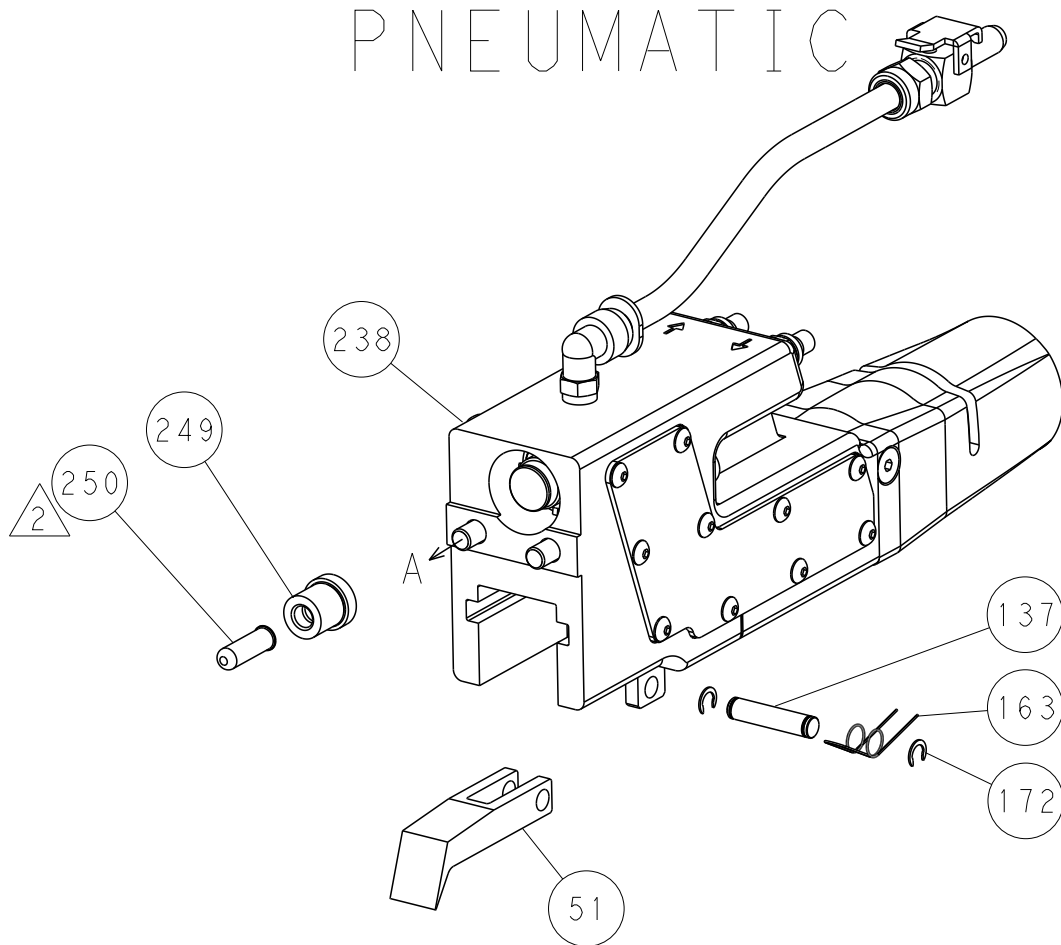


RAM SET-UP

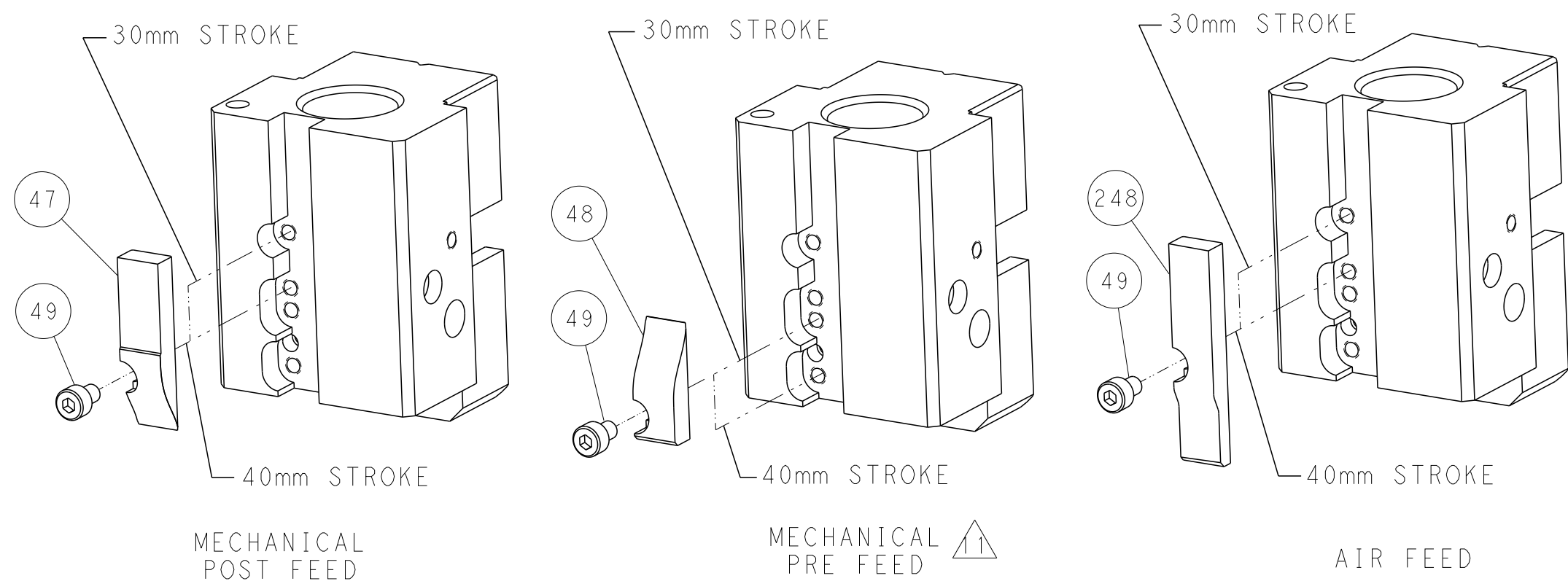
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

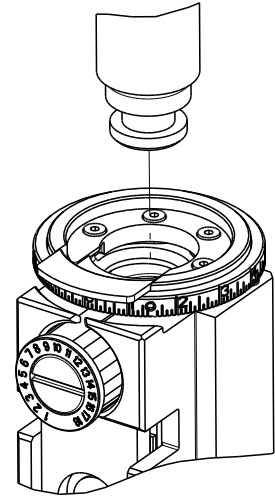


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHK: G. BAILEY 08OCT2013		Harrisburg, PA 17105-3608	
				APVD: M. CLIFFORD 08OCT2013		NAME: Ocean End Feed Applicator	
				PRODUCT SPEC:		SIZE: A1	
				APPLICATION SPEC:		CAGE CODE: 00779	
				WEIGHT:		DRAWING NO: C-2150323	
				Customer Accessible Production Drawing		RESTRICTED TO: -	
				SCALE: 1:1		SHEET 2 OF 4	
						REV C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150323-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150323-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150323-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.50 mm [.138]	F
INSUL	4.50 mm [.177]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON CONNECTOR, .250 SERIES			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.84-6.60 mm [.230-.260 IN]			Ø3.80-5.10 mm [.150-.201 IN]
TERMINAL APPLICATION SPECIFICATION		114-20023	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-160301-6	1-160301-8	1-160301-9	2-160301-8
2-160301-9			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm2		2.51+/-0.03 [.099+/- .001]		9.8



- 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.
- 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)

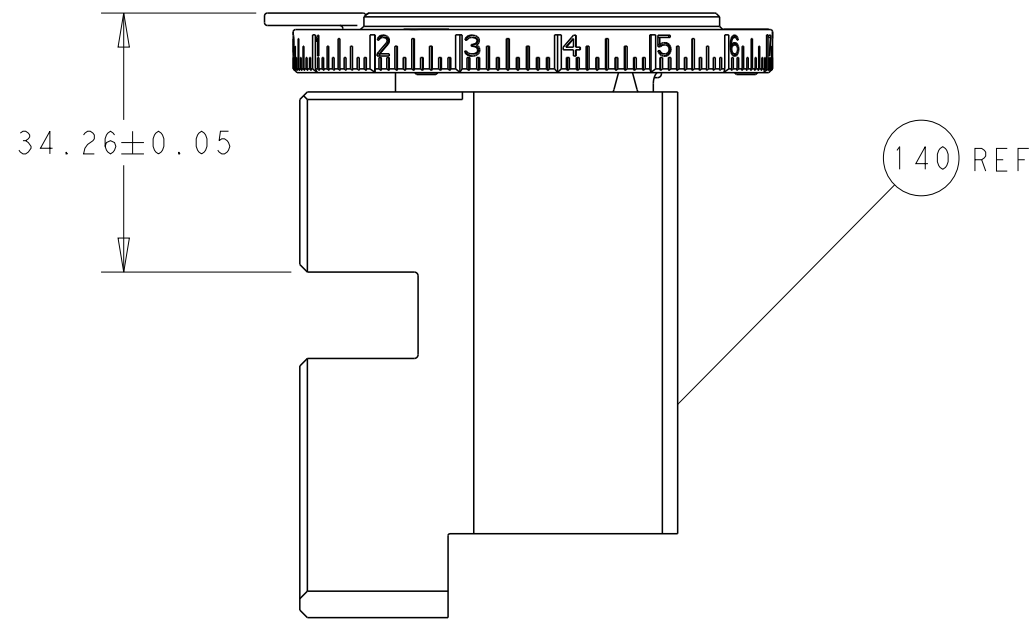
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

3	-	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	
	-	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	455888-5	SPACER, CRIMPER	82	
	-	1	1	2119791-5	DEPRESSOR, WIRE	73	
	-	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
1	-	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	
	-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	-	2119792-2	PAWL, EF, AIR	51	
	-	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	1-1752371-6	PLATE, STRIP GUIDE	24	
	-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
1	-	2	2	2-22281-3	SPRING, COMPRESSION	22	
	-	1	1	1803292-4	DRAG	20	
	-	2	2	1901259-7	GUIDE, LOWER STRIP	18	
	-	1	1	240644-5	PLATE, REAR SHEAR	11	
	-	-	-	-	-	10	
	-	1	1	4-690495-3	PLATE, FRONT SHEAR	9	
	-	1	1	1803074-5	ANVIL, COMBINATION, END FEED	8	
	-	1	1	2217206-5	BLADE, SLUG	7	
	-	-	-	-	-	6	
	-	1	1	1-240641-2	SPACER	5	
	-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
	-	1	1	4-1633962-4	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	455888-1	SPACER, CRIMPER	2	
	-	1	1	8-1633609-3	CRIMPER, WIRE	1	
	-	77	22	21	PART NO	DESCRIPTION	ITEM NO

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CHK		G.BAILEY	08OCT2013	NAME		Ocean End Feed Applicator	
APVD		M.CLIFFORD	08OCT2013	PRODUCT SPEC		SIZE	
APPLICATION SPEC		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL		WEIGHT		A1		00779	
Customer Accessible Production Drawing		SCALE		1:1		SHEET 3 OF 4	
						REV C	

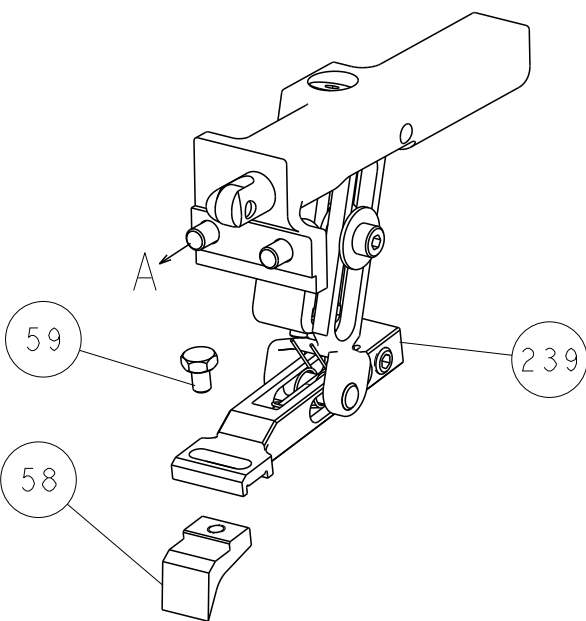
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

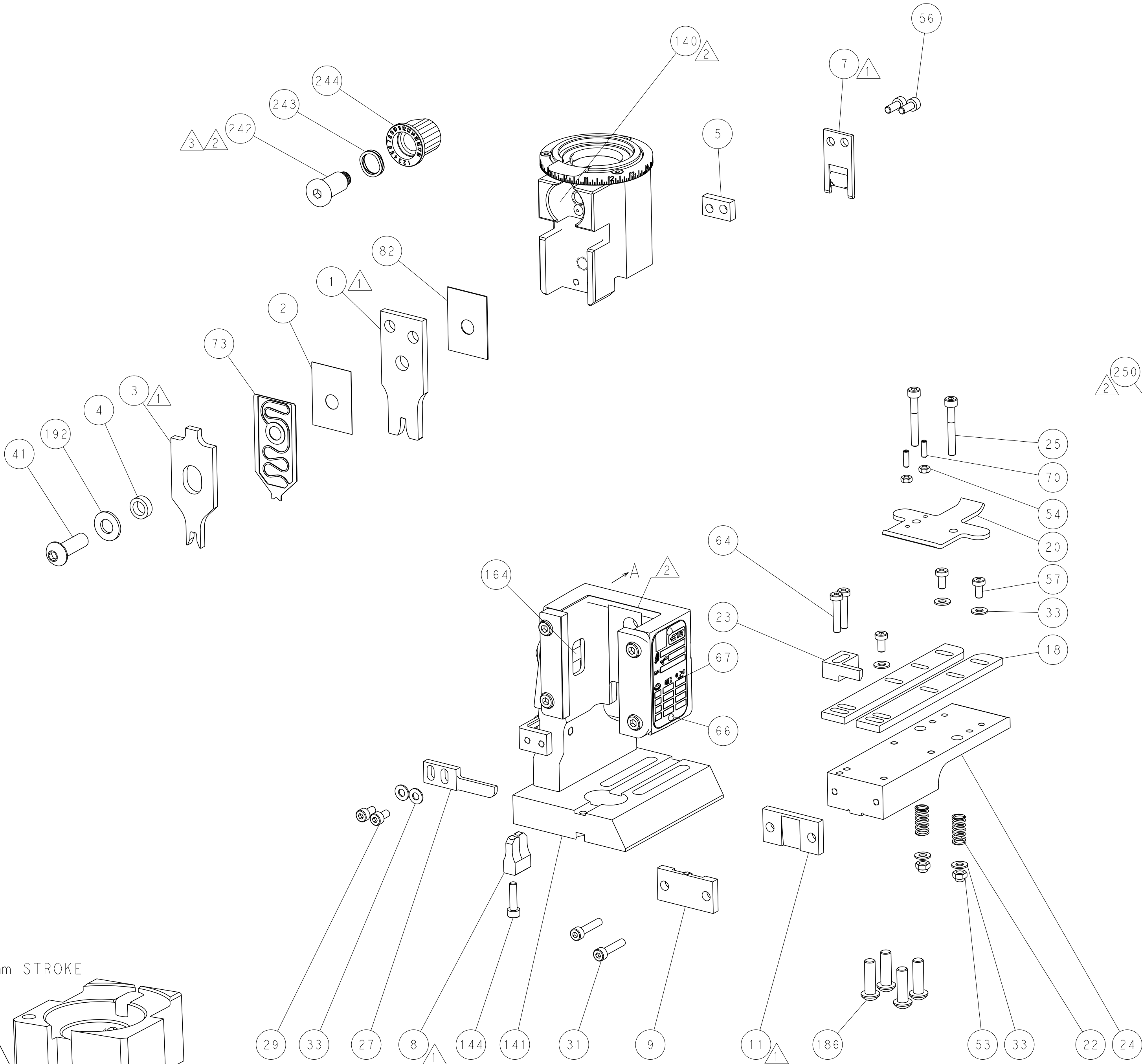
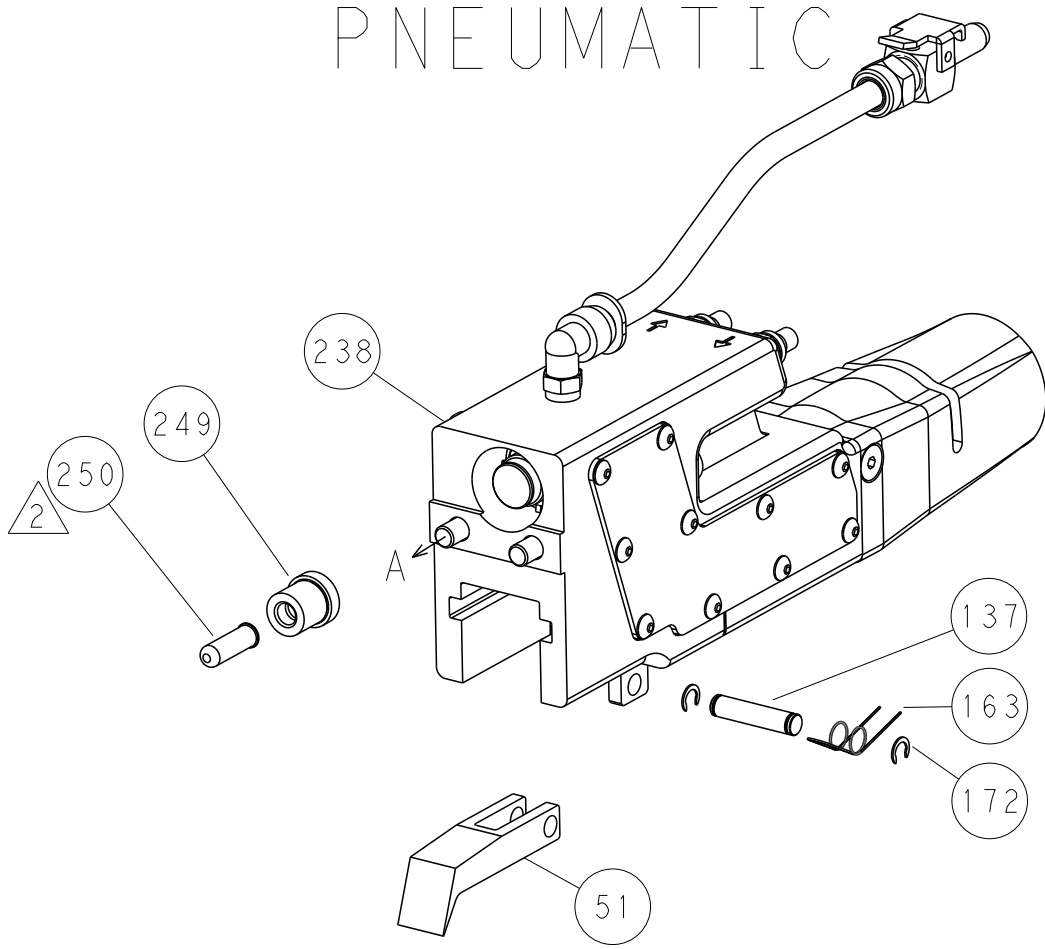


RAM SET-UP

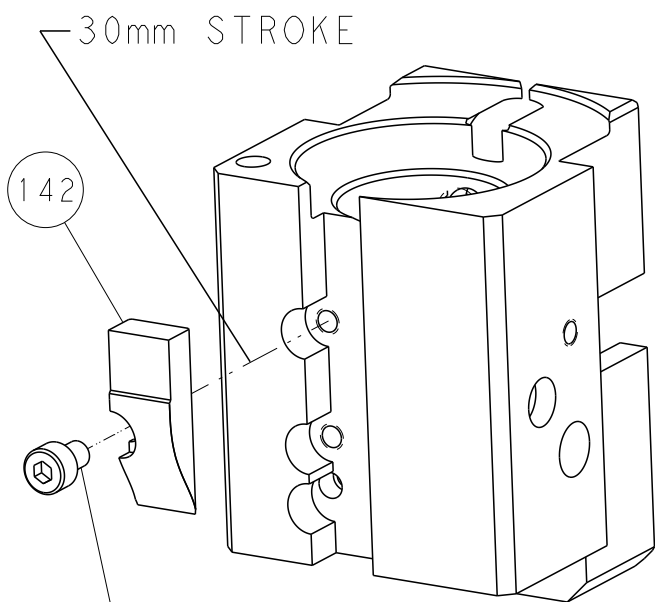
FEED TYPE
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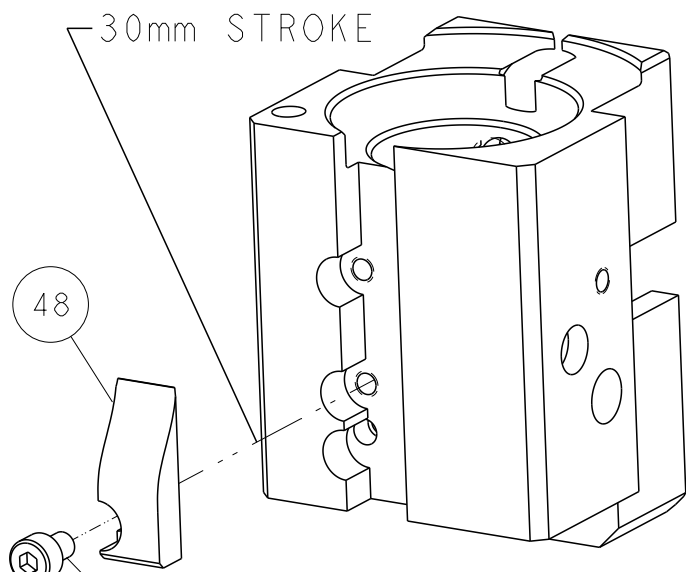
PNEUMATIC



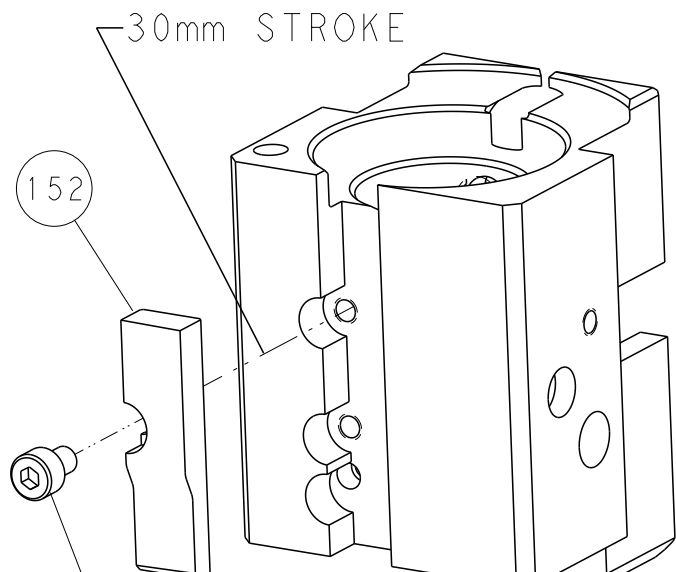
CAM POSITIONS



MECHANICAL
POST FEED

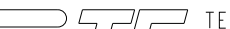


MECHANICAL
PRE FEED



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	08OCT2013									
				APVD	M. CLIFFORD	08OCT2013	NAME								
				PRODUCT SPEC				Ocean End Feed Applicator							
				APPLICATION SPEC											
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO								
				A1	00779	C=2150323	-								
				Customer Accessible Production Drawing				SCALE	1:1	SHEET	4	OF	4	REV	C