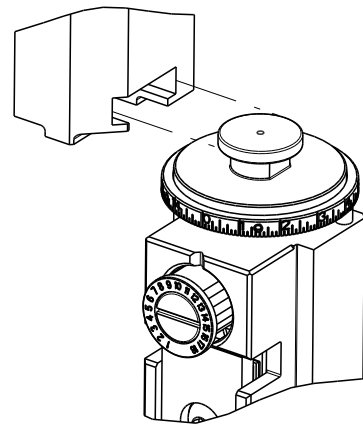


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
2015		2015	
(C) COPYRIGHT 2015		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150533-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150533-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150533-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150533-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150533-7	E	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, .250 FF RECEPTACLE W/O LATCH			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø 2.90-3.80 mm [.114-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5052	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170258-1	170089-1	170089-4	
170258-2	170089-2		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
3.00mm ²			1.78+/-0.05 [0.070+/-0.002]		5.5
2.00mm ²			1.47+/-0.05 [0.058+/-0.002]		8.8



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION

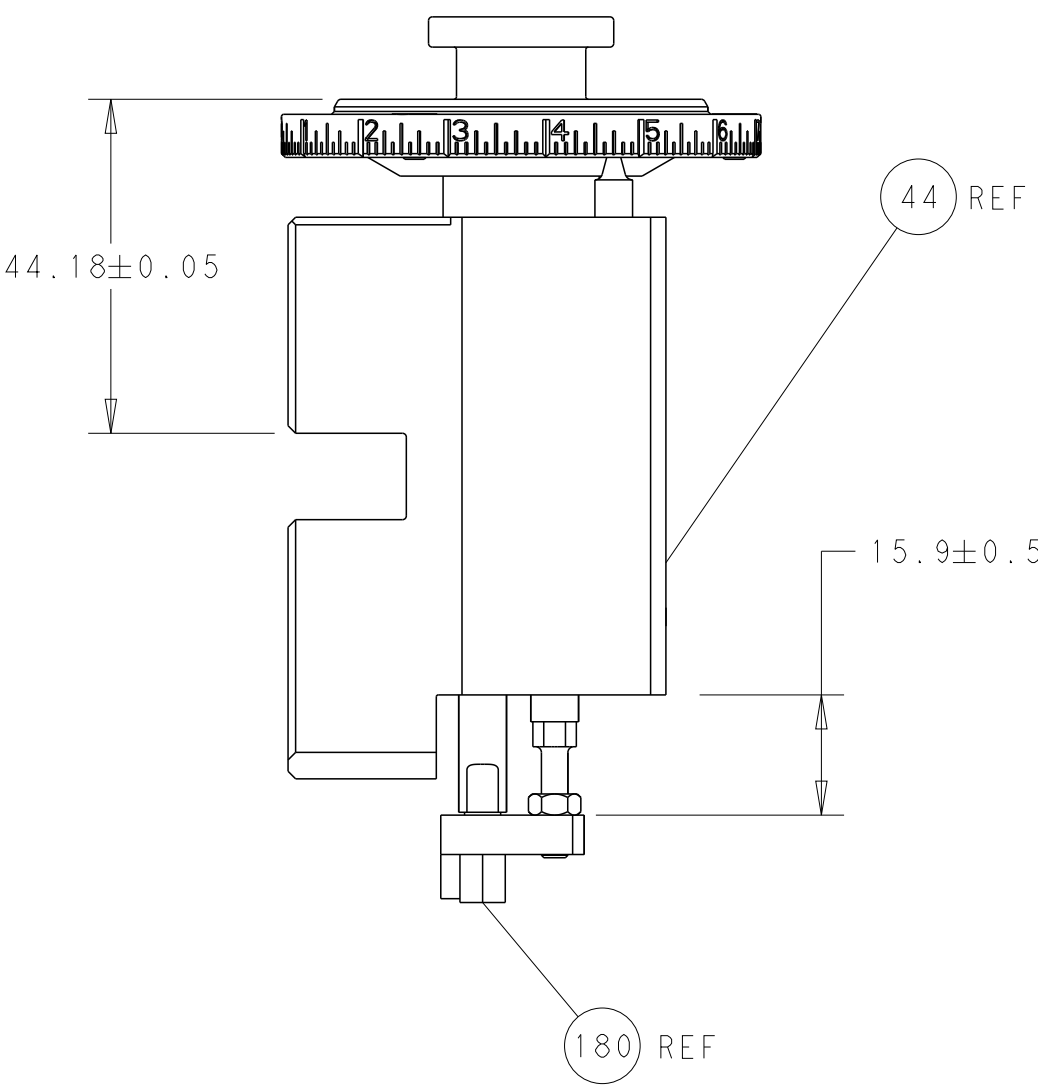
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DRN	APVD
			C	ECR-17-005784	21APR2017	TB	TE
			D	ECR-18-016632	21OCT2018	TB	TE
			E	ECR-19-003104	26FEB2019	MZ	YY
			F	ECR-19-006077	15APR2019	RK	TE

[illegible]

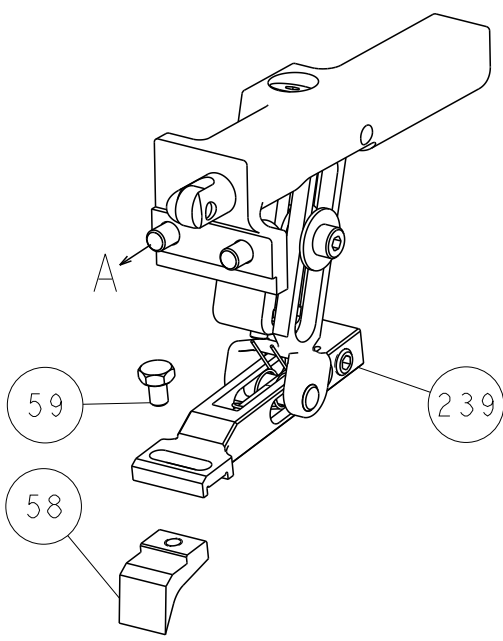
THIS DRAWING IS A COMPUTER GENERATED FILE. ALL DIMENSIONS AND TOLERANCES ARE BASED ON THE DIMENSIONS AND TOLERANCES SPECIFIED ON THE DRAWING. THE USER SHALL BE RESPONSIBLE FOR THE ACCURACY OF THE DIMENSIONS AND TOLERANCES SPECIFIED ON THE DRAWING.		DWN WEAVER 25FEB2015		 TE Connectivity Harrisburg, PA 17105-3608	
THIS DRAWING IS A COMPUTER GENERATED FILE. ALL DIMENSIONS AND TOLERANCES ARE BASED ON THE DIMENSIONS AND TOLERANCES SPECIFIED ON THE DRAWING. THE USER SHALL BE RESPONSIBLE FOR THE ACCURACY OF THE DIMENSIONS AND TOLERANCES SPECIFIED ON THE DRAWING.		CHK ELBIN 25FEB2015			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm$ 1 PLC $\pm$ 3 PLC $\pm$ 4 PLC $\pm$ ANGLES $\pm$ FINISH		NAME Ocean End Feed Applicator -	
		APPR ELBIN 25FEB2015 PRODUCT SPEC		RESTRICTED TO	
MATERIAL -		APPLICATION SPEC -		SIZE A 00779 C=2150533	
WEIGHT -		DRAWING NO A 00779 C=2150533		SCALE 1:1	
Customer Accessible Drawing		SCALE 1:1		SHEET 1 OF 4	
REV F		REV F		REV F	

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

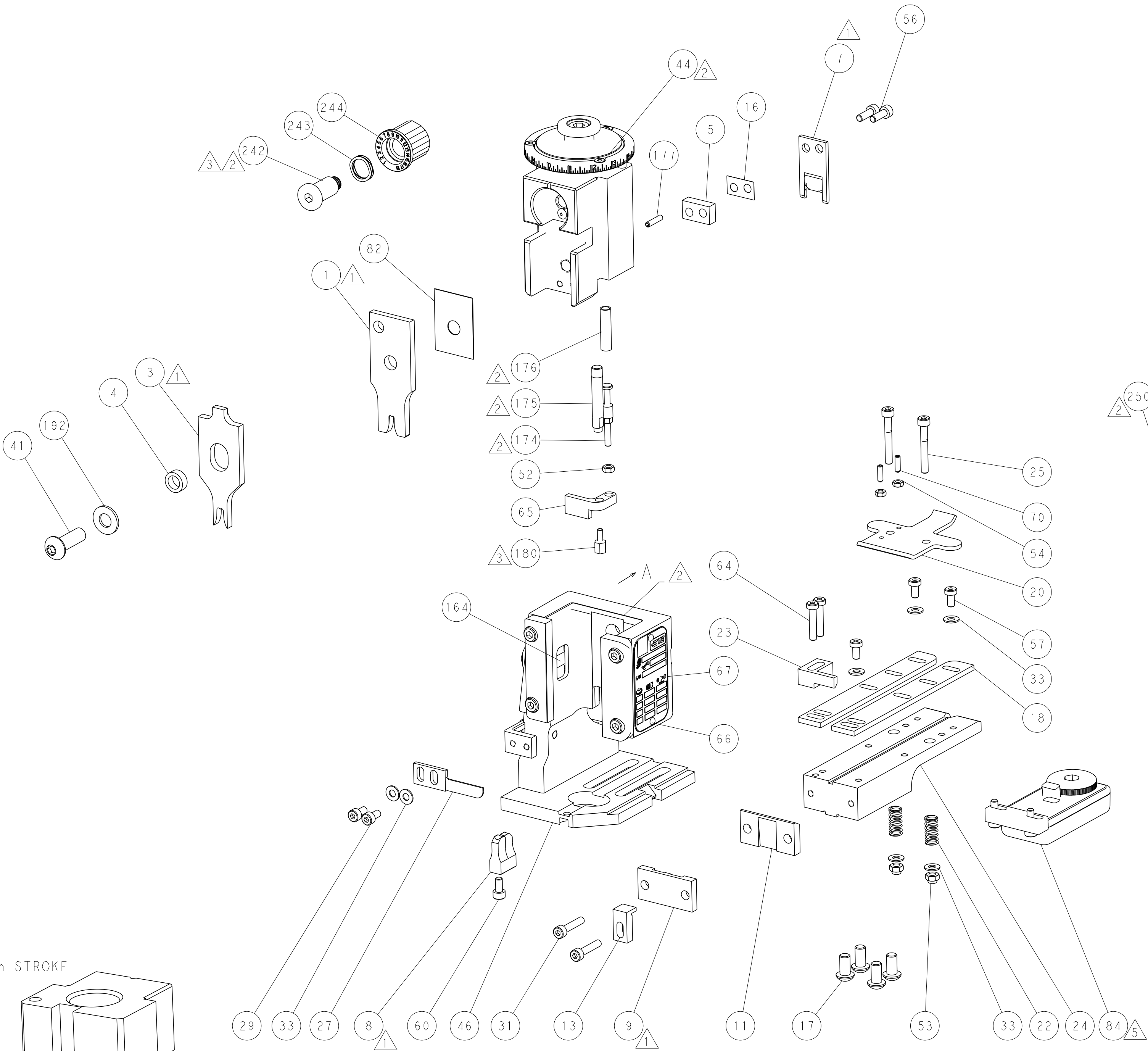
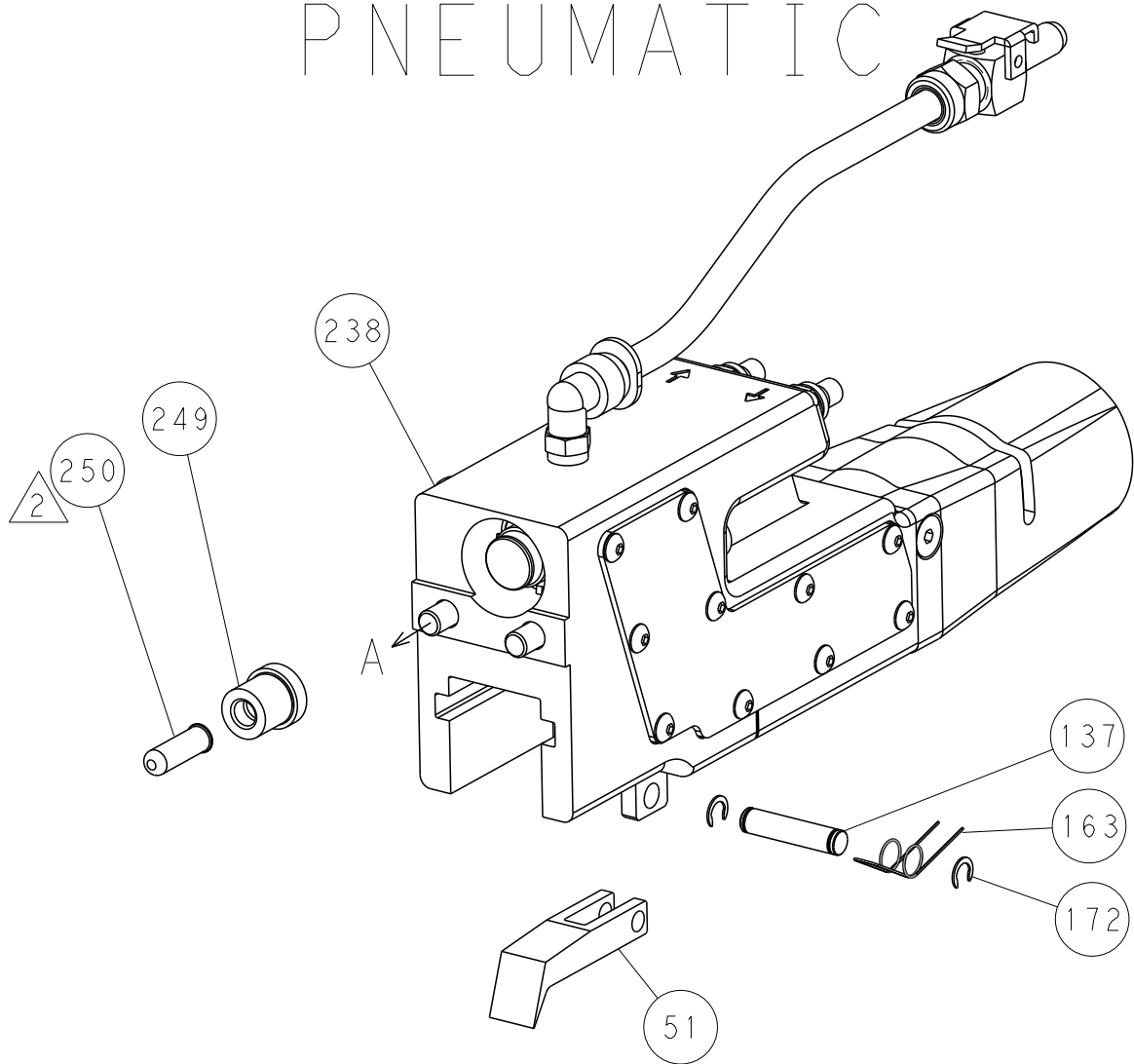


RAM AND HOLDDOWN SET-UP

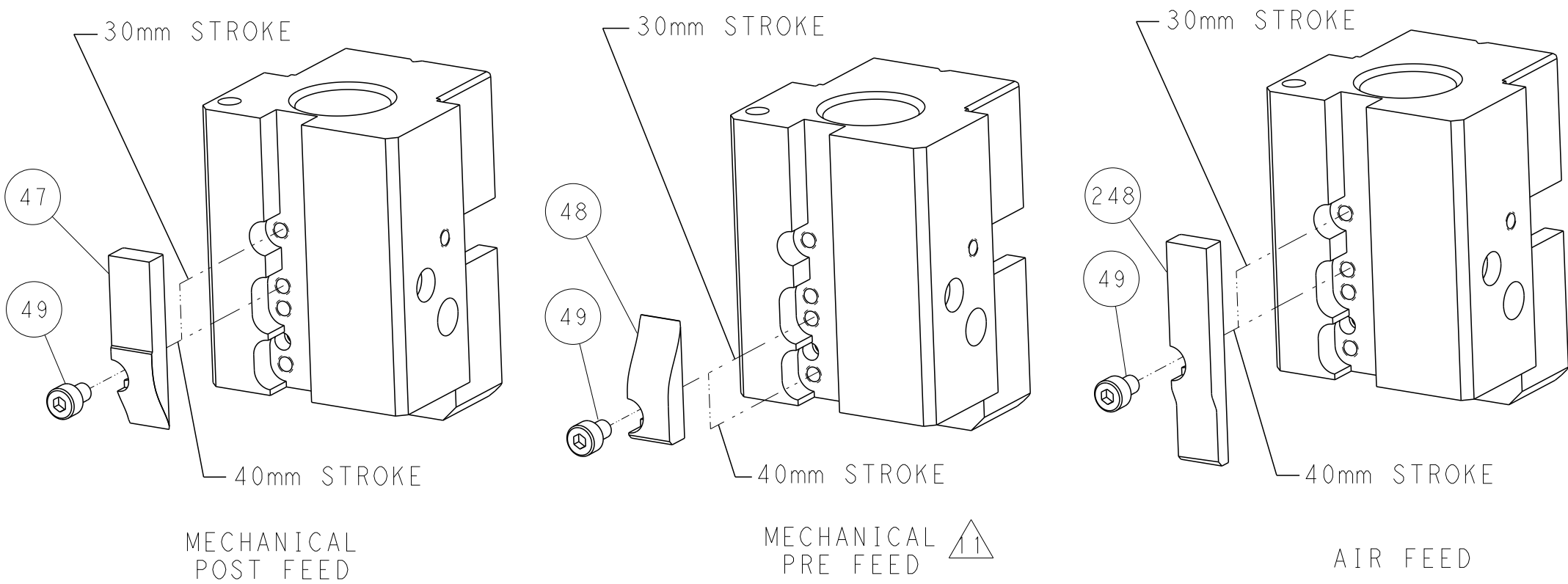
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

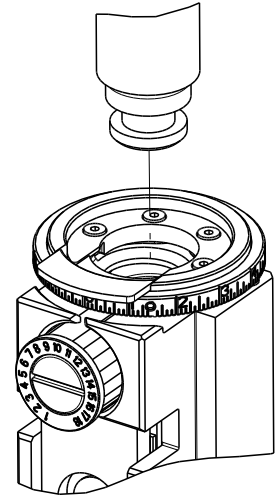


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION.				DWN B. WEAVER 25FEB2015		TE Connectivity Harrisburg, PA 17105-3608	
CHK T. ELBIN 25FEB2015				APVD T. ELBIN 25FEB2015		NAME Ocean End Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH				± ± ± ± ± ± ±		CAGE CODE 00779	
MATERIAL -				WEIGHT -		DRAWING NO C=2150533	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 of 4	
						REV F	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
2015		2015	
© COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150533-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150533-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150533-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, .250 FF RECEPTACLE W/O LATCH			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		 INSULATION DIAMETER RANGE Ø 2.90-3.80 mm [.114-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-5052	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170258-1	170089-1	170089-4	
170258-2	170089-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
3.00mm2		1.78+/-0.05 [.070+/- .002]		5.5
2.00mm2		1.47+/-0.05 [.058+/- .002]		8.8



- 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. 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.

*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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			-	SEE SHEET 1	-	-	-	

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	1	1-1752354-0	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
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REFREF		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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	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	2168400-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2119792-2	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	240639-2	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1-1752371-4	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
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	4-240641-9	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1-240833-3	PLATE, REAR SHEAR	11
1	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	8-1803074-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	6-240641-5	SPACER	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	7-1633961-2	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
1	1	1	3-456410-0	CRIMPER, WIRE PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.		DWN B. WEAVER 25FEB2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 25FEB2015	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD T. ELBIN 25FEB2015	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -	A1 00779 ©=2150533 Customer Accessible Production Drawing	
		SCALE 1:1	SHEET 3 OF 4 REV F	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TPO ELECTRONICS CORPORATION IT IS BORNE OUT BY THE TPO ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 25FEB2015 CRK W. WEAVER 25FEB2015 T. ELBIN 25FEB2015 T. ELBIN 25FEB2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C-2150533		RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 of 4	
REV F					