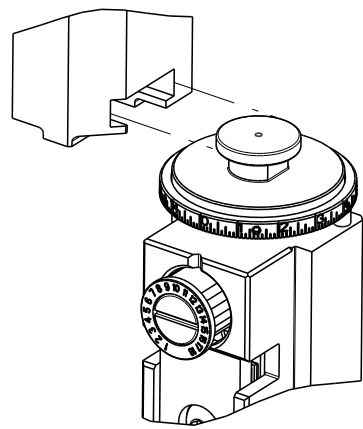


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150550-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150550-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150550-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACEL FASTON .250 SERIES			
WIRE STRIP LENGTH 6.02-6.78 mm [.237-.267 IN]		INSULATION DIAMETER RANGE Ø5.33-6.73 mm [.210-.265 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINALS APPLIED	
114-2036		-	
-		-	
-		-	
TE TERMINAL		TE TERMINAL	
42579-1		41727	
TE TERMINAL		TE TERMINAL	
41728		63831-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
12 AWG		2.03+/-0.05 [.080+/- .002]		6.4
14 AWG		1.78+/-0.05 [.070+/- .002]		9.4
(2) 18 AWG		1.68+/-0.05 [.066+/- .002]		10.4
16 AWG		1.63+/-0.05 [.064+/- .002]		11.6



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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)

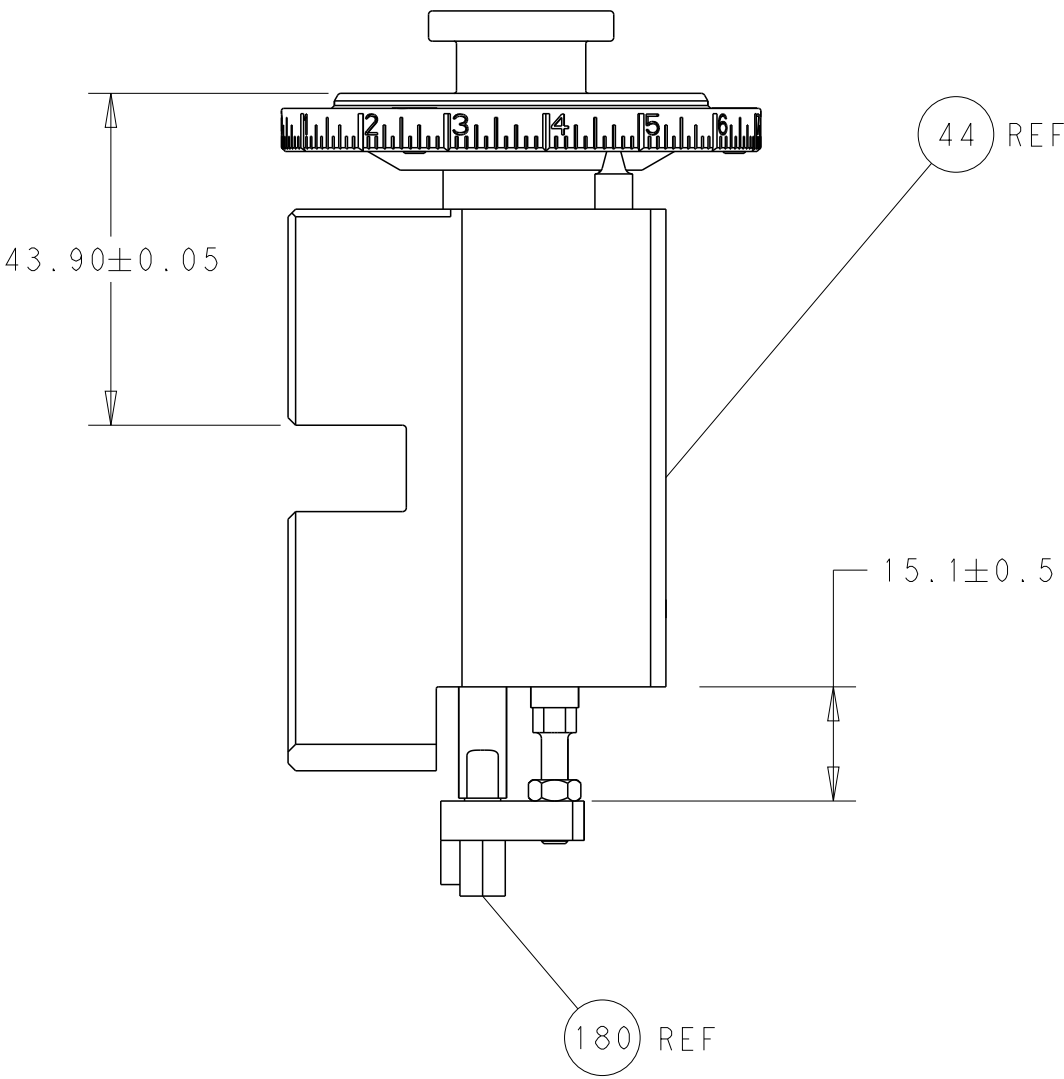
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
					B	ECR-15-018629	23DEC2015
					C	ECR-18-015272	25SEP2018

	-	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	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2063440-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1-1752354-4	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
	-	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	455888-6	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
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	4	4	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	1	2119792-2	PAWL, EF, AIR	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
	-	8	8	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1803152-2	STRIP GUIDE, REAR	19
	-	1	1	1803151-2	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	3-1803059-5	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-4	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	1-240641-4	SPACER	5
	-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	1	2-1803187-7	CRIMPER, INSULATION F	3
	-	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	2	1	456411-3	CRIMPER, WIRE PREMIUM	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

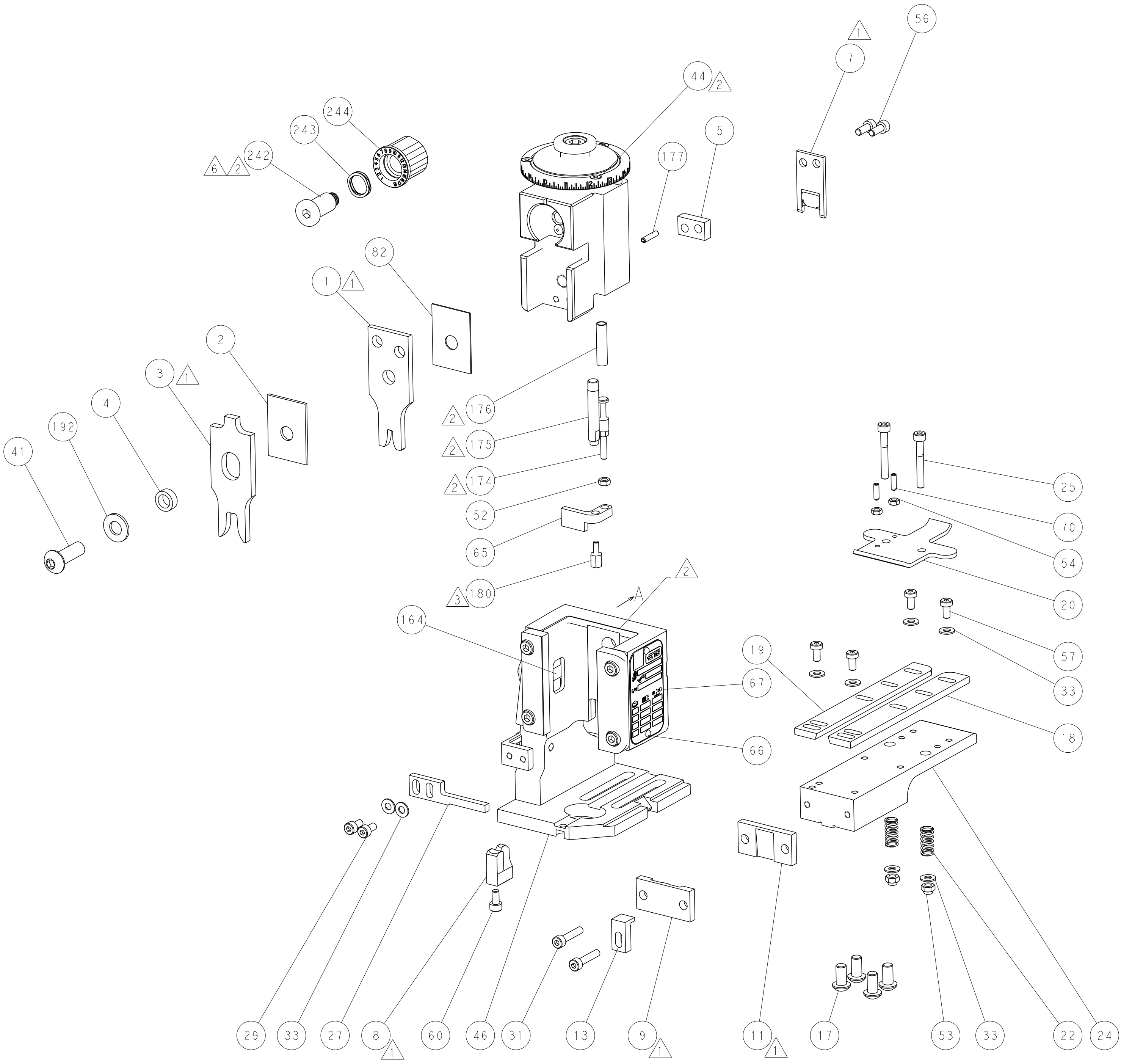
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN J. HOU 12JUN2015	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 12JUN2015		NAME	Ocean End Feed Applicator	
APVD J. GUO 12JUN2015		PRODUCT SPEC	-	
APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO
MATERIAL		WEIGHT	A1 00779 ©=2150550	
FINISH		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					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

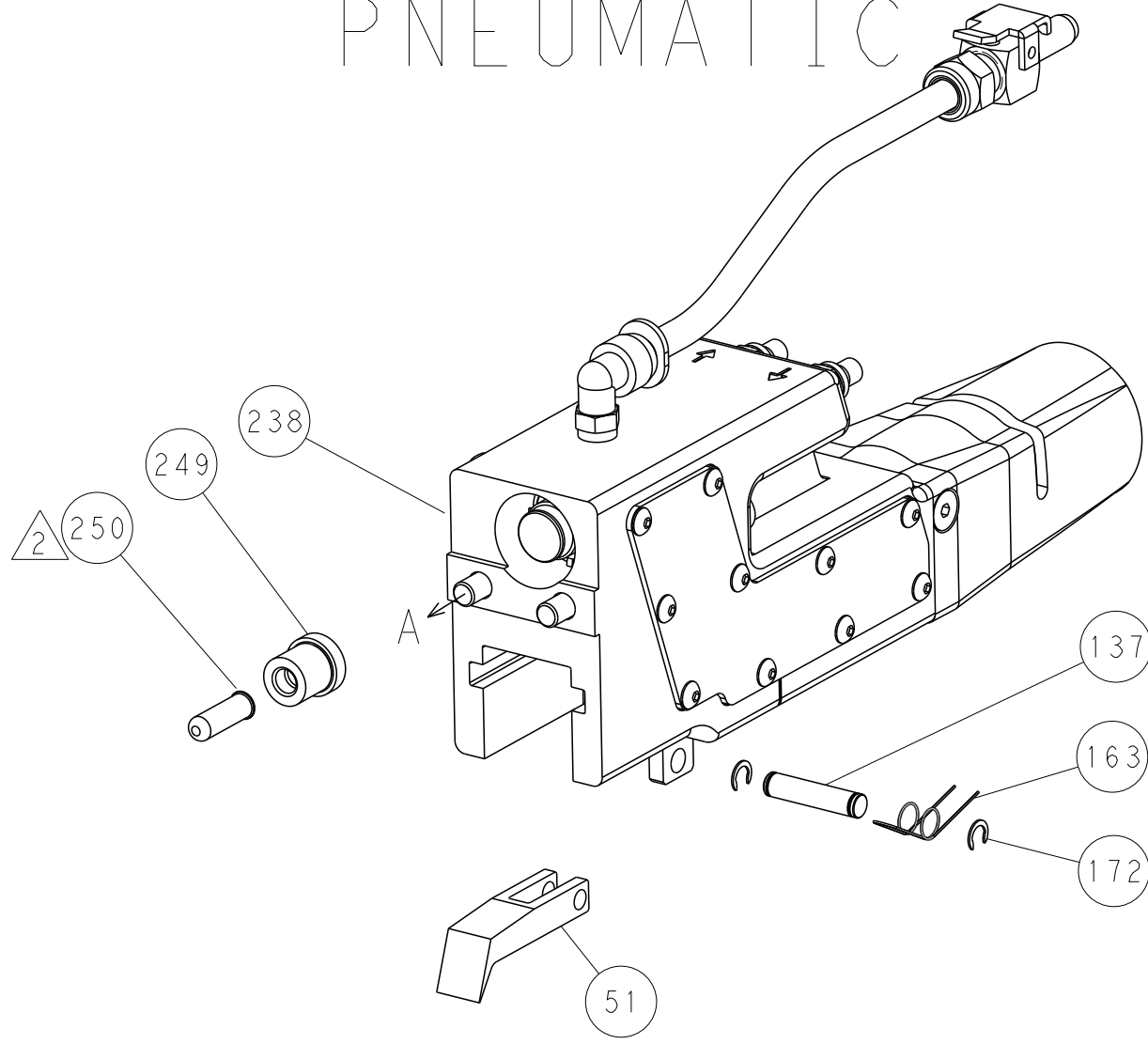


RAM AND HOLDDOWN SET-UP

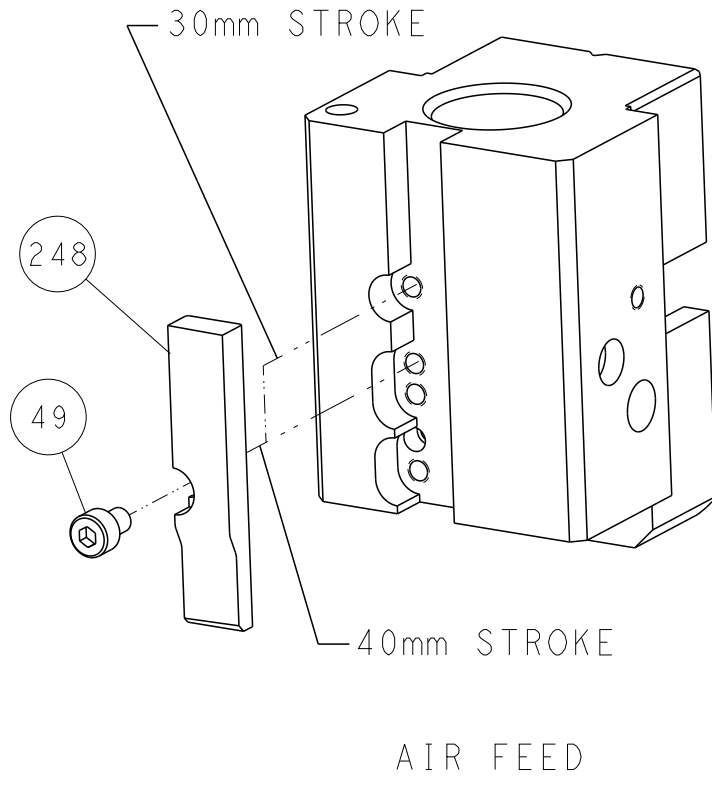


FEED TYPE

PNEUMATIC



CAM POSITION



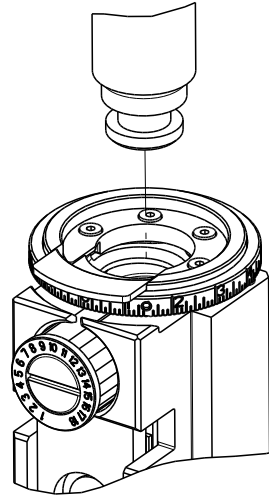
AIR FEED

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 WITHOUT NOTICE AND THE USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN J. HOU 12JUN2015	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 12JUN2015		NAME	Ocean End Feed Applicator	
APVD J. GUO 12JUN2015		PRODUCT SPEC	-	
APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO
MATERIAL		WEIGHT	A1	00779 C=2150550
Customer Accessible Production Drawing		SCALE	1:1	SHEET 2 OF 4 REV C

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
2-2150550-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150550-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACEL FASTON .250 SERIES			
WIRE STRIP LENGTH 6.02-6.78 mm [.237-.267 IN]		INSULATION DIAMETER RANGE Ø5.33-6.73 mm [.210-.265 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2036	
TERMINALS APPLIED		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42579-1	41727	41728	63831-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
12 AWG		2.03+/-0.05 [.080+/- .002]		6.4
14 AWG		1.78+/-0.05 [.070+/- .002]		9.4
(2) 18 AWG		1.68+/-0.05 [.066+/- .002]		10.4
16 AWG		1.63+/-0.05 [.064+/- .002]		11.6



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

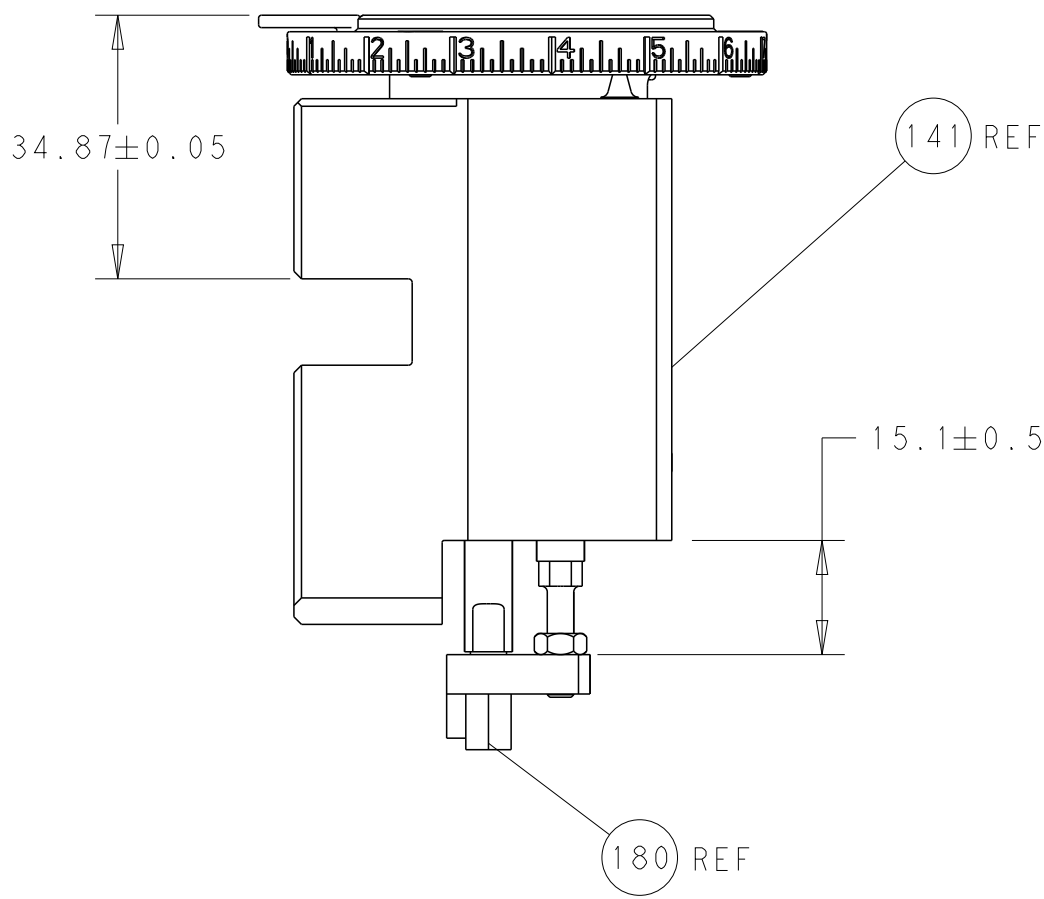
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-2	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1-1752354-4	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
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	455888-6	SPACER, CRIMPER	82
-	1	1803607-2	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	1901681-1	HOLDDOWN, TERMINAL	65
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2119792-2	PAWL, EF, AIR	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	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
-	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1803152-2	STRIP GUIDE, REAR	19
-	1	1803151-2	STRIP GUIDE, FRONT	18
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
-	1	3-1803059-5	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	6
-	1	1-240641-4	SPACER	5
-	1	238011-3	BLOCK, CRIMPER SPACER	4
-	1	2-1803187-7	CRIMPER, INSULATION F	3
-	1	1-455888-5	SPACER, CRIMPER	2
-	1	456411-3	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR PRO ELECTRONICS CORPORATION IT IS HEREBY REQUESTED THAT YOU CONTACT THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOU 12JUN2015		 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm 				CHK L. ZHAGN 12JUN2015				NAME
				APVD J. GUO 12JUN2015				
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		Ocean End Feed Appliator -		
0 PLC ±				-				
1 PLC ±				-				
2 PLC ±				-		SIZE		
3 PLC ±				APPLICATION SPEC				
4 PLC ±				-				
ANGLES				-		CAGE CODE		
FINISH				-				
-				-				
MATERIAL				WEIGHT		DRAWING NO		
-				-				
-				-				
Customer Accessible Production Drawing				A 00779		REV C		
SCALE				1:1				
SHEET				3 of 4				

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

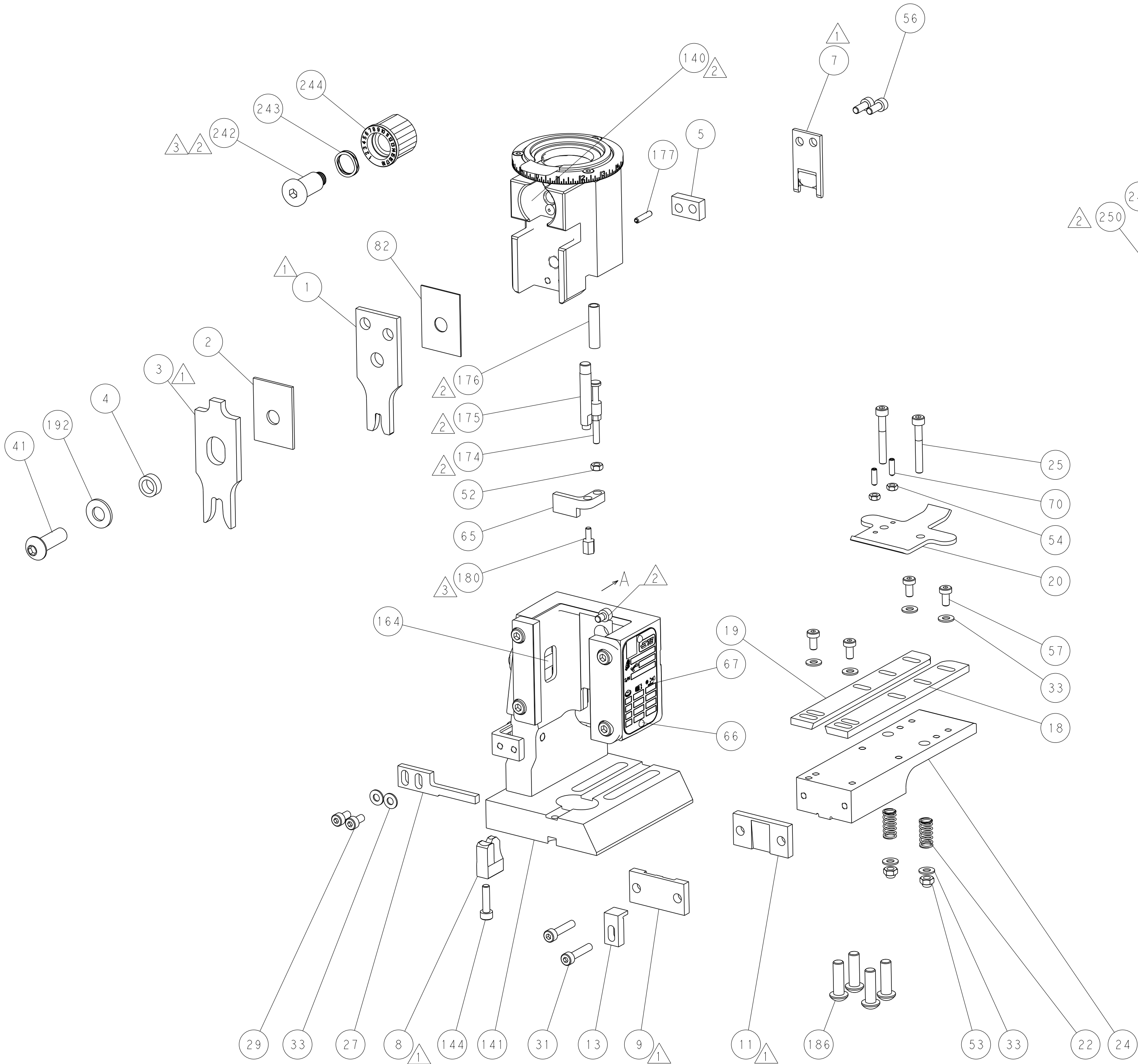
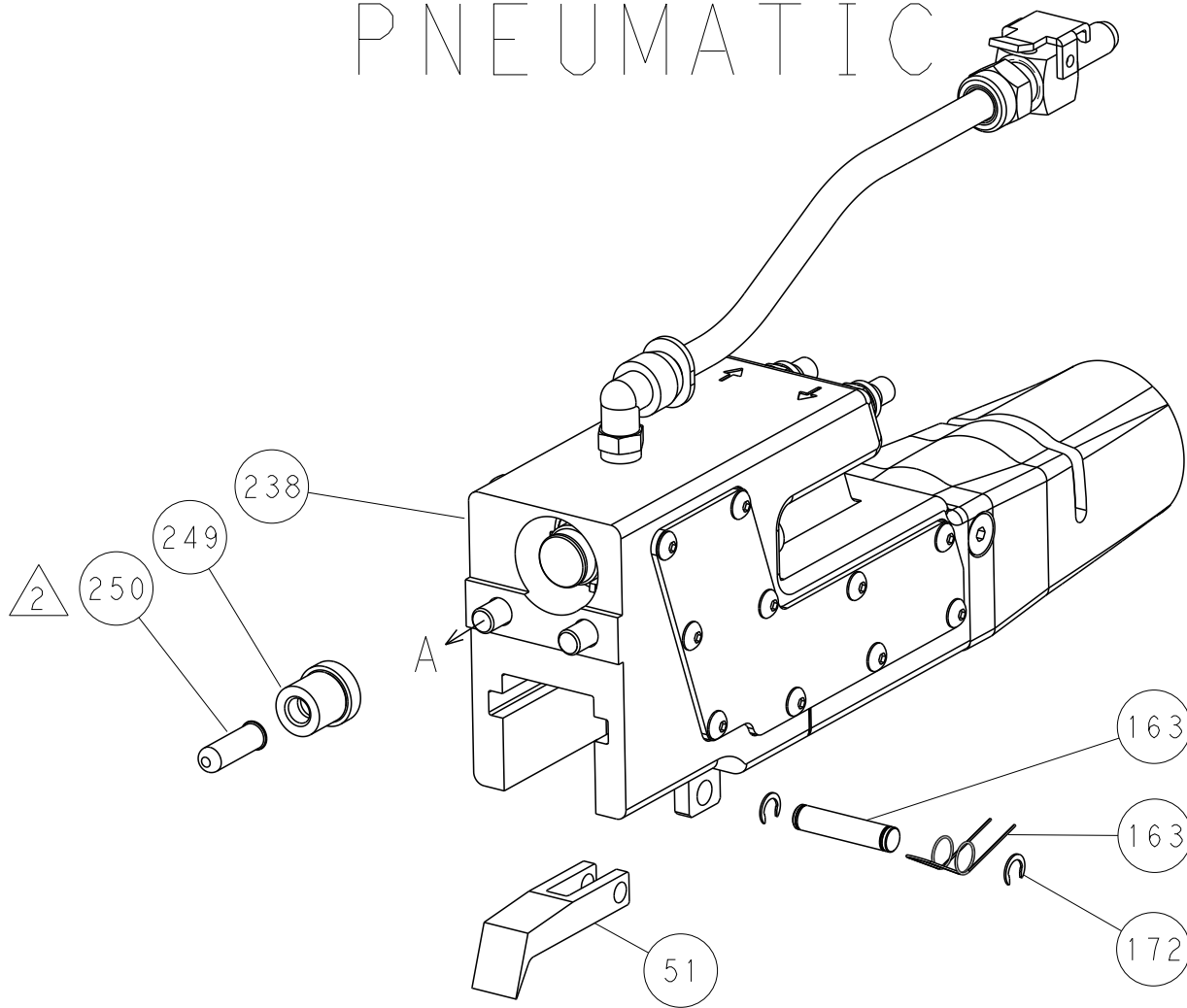
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP

FEED TYPE

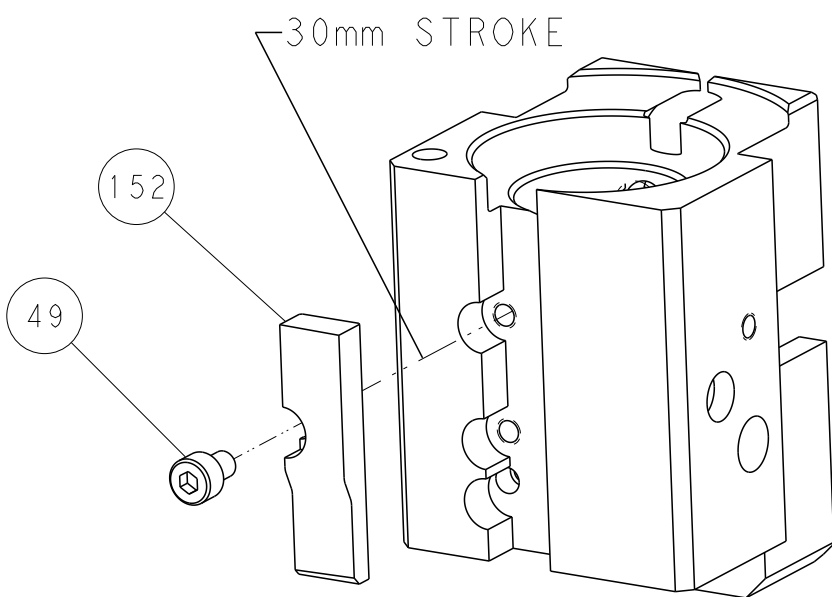
PNEUMATIC



PACIFIC VERSION

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

CAM POSITION



AIR FEED

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY POLICY AND ANY CHANGES TO THE LATEST EDITION SHOULD BE CONTACTED FOR THE LATEST EDITION.										DWN		J. HOU	12JUN2015	 TE Connectivity Harrisburg, PA 17105-3608																			
										CHK		L. ZHANG	12JUN2015																				
										APVD		J. GUO	12JUN2015	NAME																			
DIMENSIONS: mm  0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH										PRODUCT SPEC				Ocean End Feed Applicator																			
										APPLICATION SPEC																							
										SIZE		CASE CODE		DRAWING NO		RESTRICTED TO																	
MATERIAL										A1		00779		C=2150550																			
										WEIGHT				-																			
										Customer Accessible Production Drawing								SCALE		1:1		SHEET		4		OF		4		REV		C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION