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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150030-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150030-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150030-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150030-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150030-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160389-3	42510-2	63609-3	140760-3
160389-4	42510-5	63609-4	140760-4
41772	63127-1	63693-1	140760-5
41772-1	63609-1	140760-1	2238027-3
42510-1	63609-2	140760-2	2238027-4
2238143-1			

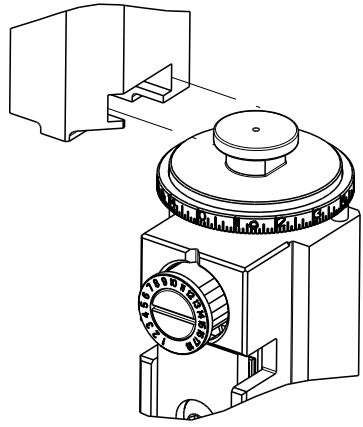
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG or 0.75mm ²		1.42+/-0.05 [.056+/- .002]		6.0
22 AWG x 2		1.37+/-0.05 [.054+/- .002]		6.5
20 AWG or 0.50mm ²		1.30+/-0.05 [.051+/- .002]		7.3
0.40mm ²		1.27+/-0.05 [.050+/- .002]		7.6
22 AWG or 0.30mm ²		1.24+/-0.05 [.049+/- .002]		8.0



- 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 ITEM 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- WHEN RUNNING TERMINAL 160389,POSITION ITEM 261 IN PLACE OF ITEM 16.
- LUBRICANT IS RECOMMENDED.

A

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPERIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20023	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280000-6	280000-7	41771	41771-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.80mm ²		1.30+/-0.03 [.051+/- .001]		7.8
0.75mm ²		1.30+/-0.03 [.051+/- .001]		7.8
0.65mm ²		1.27+/-0.03 [.050+/- .001]		7.6
0.50mm ²		1.22+/-0.03 [.048+/- .001]		7.8
0.30mm ²		1.14+/-0.03 [.045+/- .001]		8.4

*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.

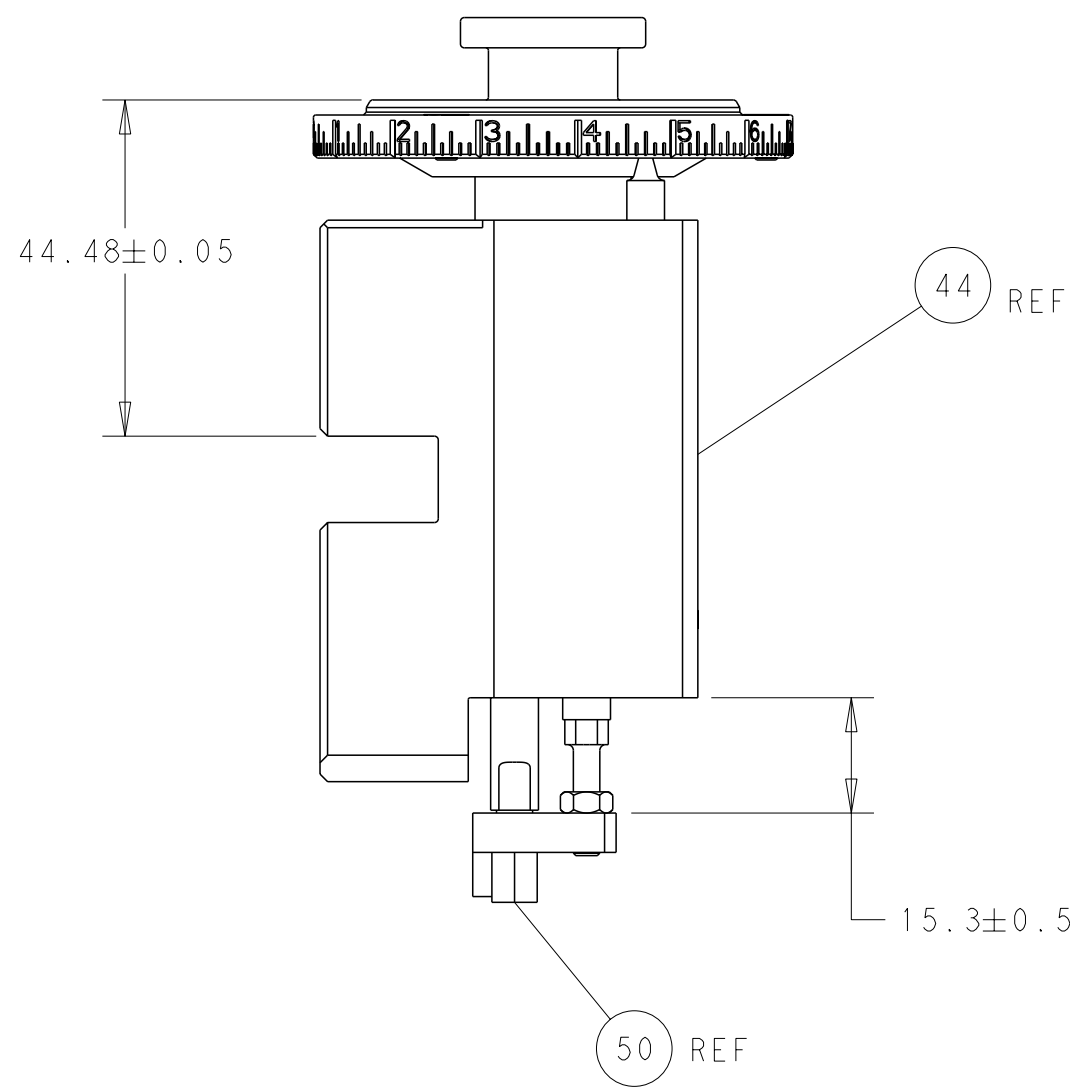
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		F		ECR-18-005228			17APR2018	YY	JDG
		G		ECR-18-014234			10SEP2018	FL	TE
		H		ECR-18-015593			01OCT2018	JAH	TE
		H1		ECR-19-016791			29OCT2019	FJ	TE

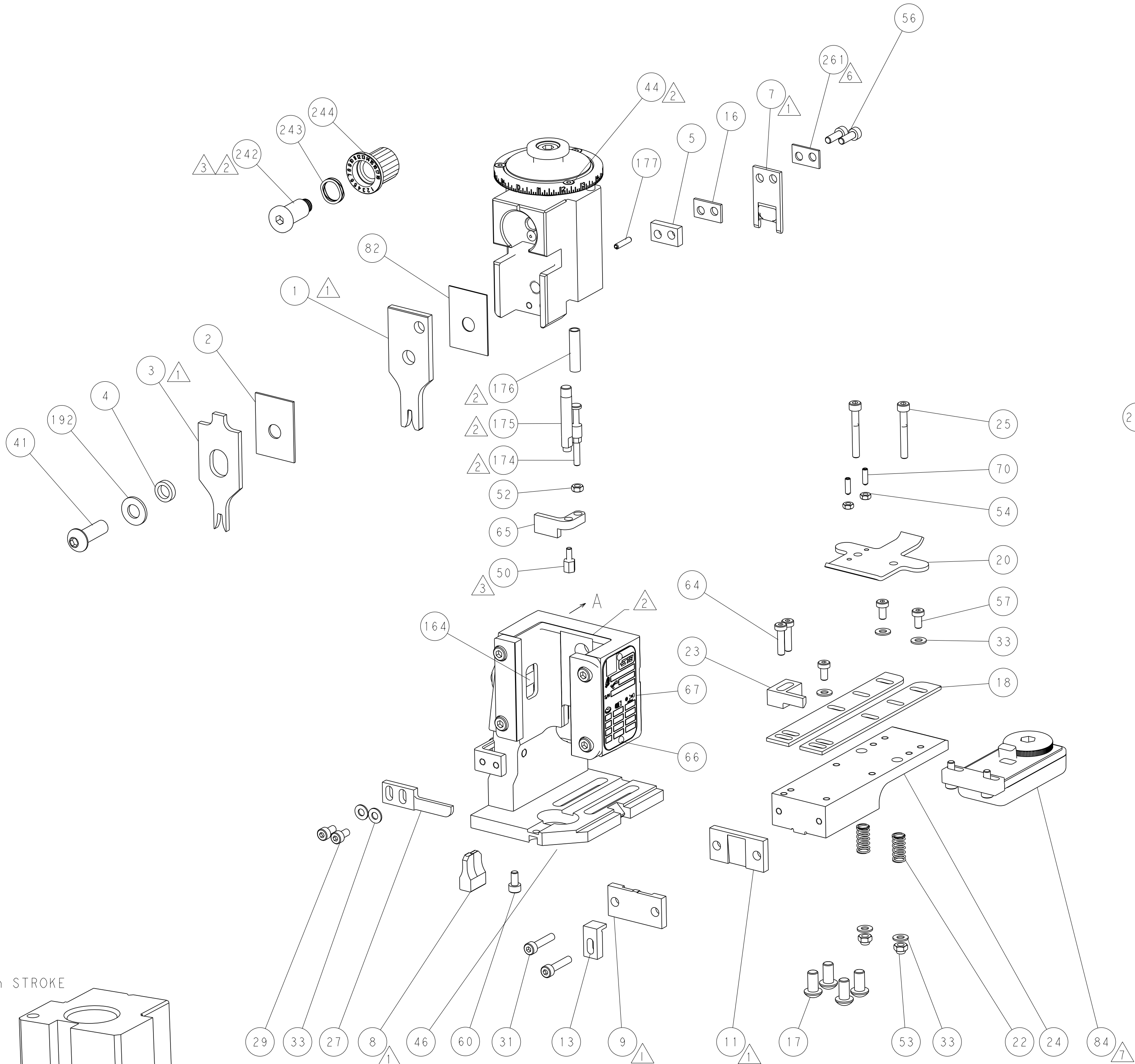
	-	1	1	1	1	3-240641-4	SPACER	261
	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	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
	-	1	1	1	1	6-993111-6	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2119792-2	PAWL, EF, AIR	51
	-	1	1	1	1	1-1752354-1	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	1752371-5	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	1901259-4	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	3-240641-3	SPACER	16
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
	-	1	1	1	1	690495-4	PLATE, FRONT SHEAR	9
	1	2	2	1	1	1338673-1	ANVIL, COMBINATION	8
	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	1	1	1	1	240641-3	SPACER	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
	1	2	2	1	1	1-456406-2	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 ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN B. WEAVER CHK G. HOFENER APVD G. RAILLY	09DEC2011 09DEC2011 09DEC2011	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 ANGLES	± ± ± ± ± ±	PRODUCT SPEC	
MATERIAL		FINISH		APPLICATION SPEC	
-		-		-	
-		-		WEIGHT	
-		-		A1 00779 ©=2150030	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 of 4	
				REV H1	

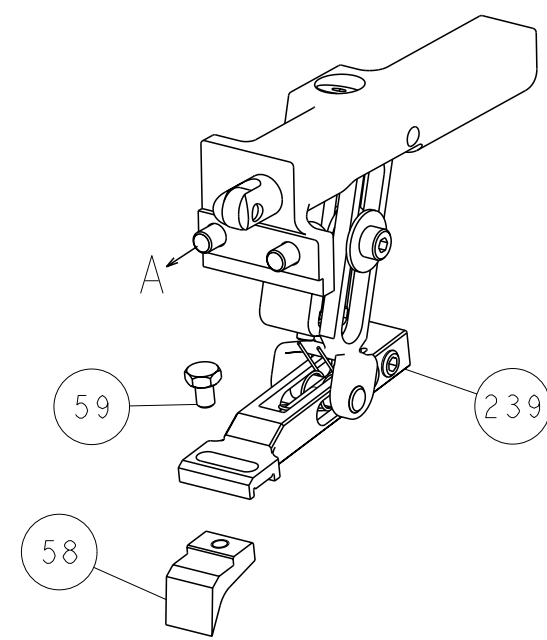
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



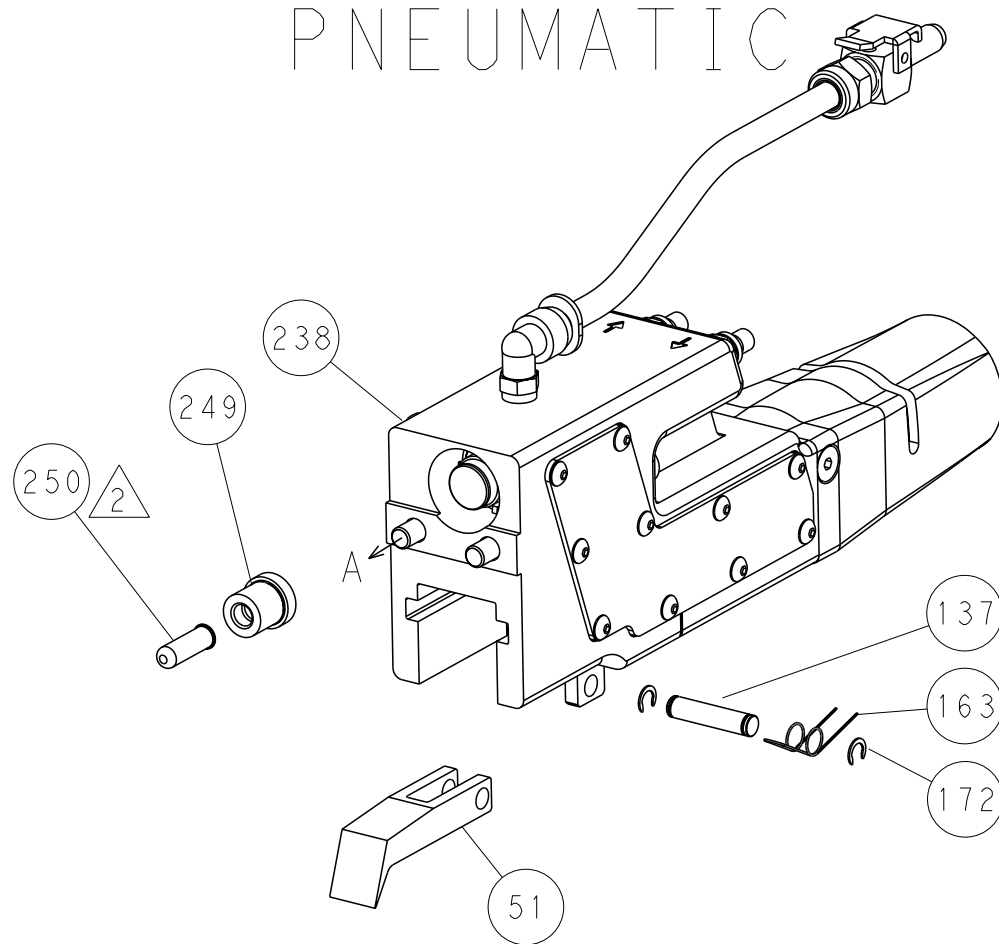
RAM AND HOLDDOWN SET-UP



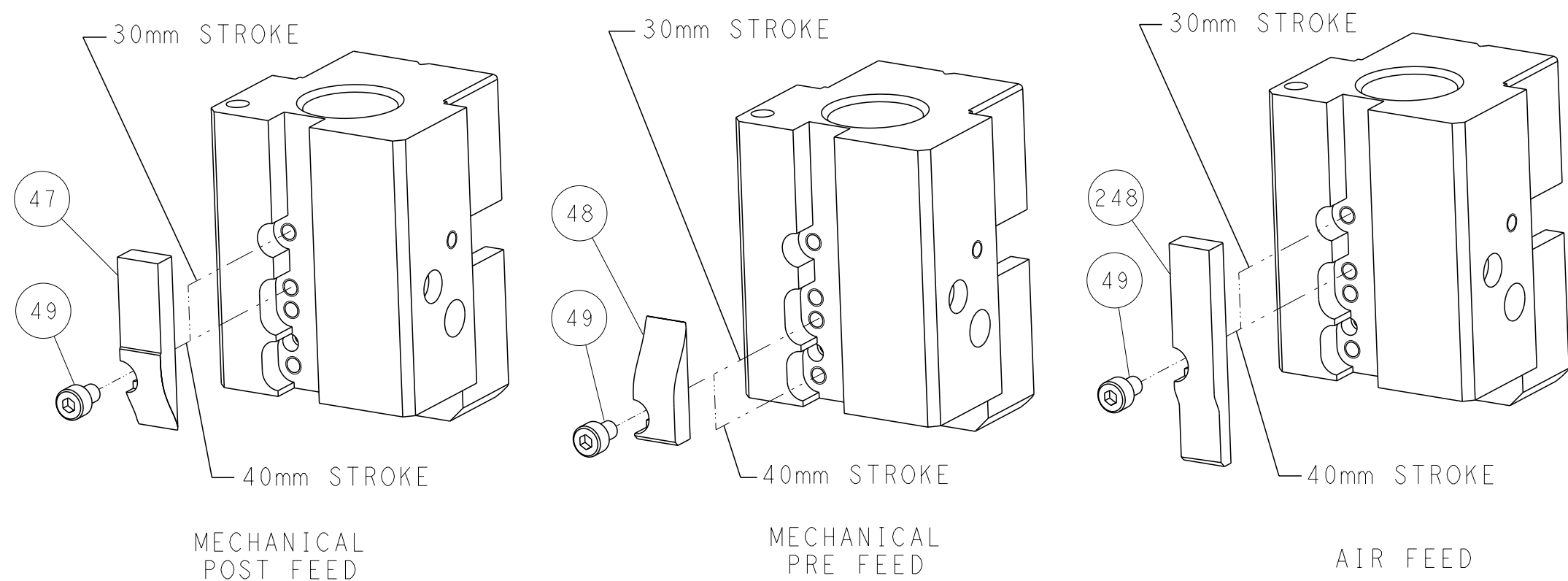
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

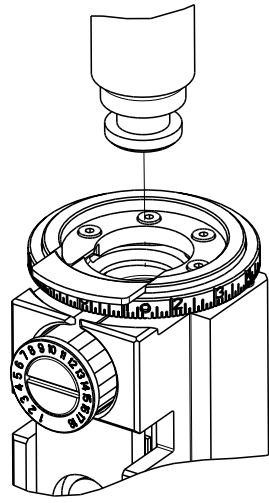


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHK G. HOFFNER 09DEC2011		
				APVD G. BAILEY 09DEC2011	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE 1:1	SHEET 2 of 4	
				REV H1		

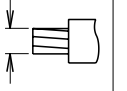
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150030-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150030-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150030-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [1.30]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [1.173-.252 IN]			INSULATION DIAMETER RANGE Ø2.30-3.30 mm [1.091-.130 IN]
TERMINAL APPLICATION SPECIFICATION		114-2036	- -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
 160389-3	42510-2	63609-3	140760-3
 160389-4	42510-5	63609-4	140760-4
41772	63127-1	63693-1	140760-5
41772-1	63609-1	140760-1	2238027-3
42510-1	63609-2	140760-2	2238027-4
2238143-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
18 AWG or 0.75mm ²		1.42+/-0.05 [1.056+/-0.002]		6.0
22 AWG x 2		1.37+/-0.05 [1.054+/-0.002]		6.5
20 AWG or 0.50mm ²		1.30+/-0.05 [1.051+/-0.002]		7.3
0.40mm ²		1.27+/-0.05 [1.050+/-0.002]		7.6
22 AWG or 0.30mm ²		1.24+/-0.05 [1.049+/-0.002]		8.0

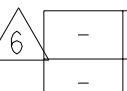
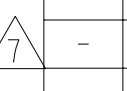
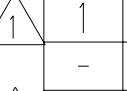


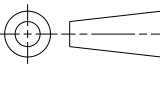
-  1. RECOMMENDED SPARE PARTS
-  2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING 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.
-  6. WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.
-  7. LUBRICANT IS RECOMMENDED.

*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)

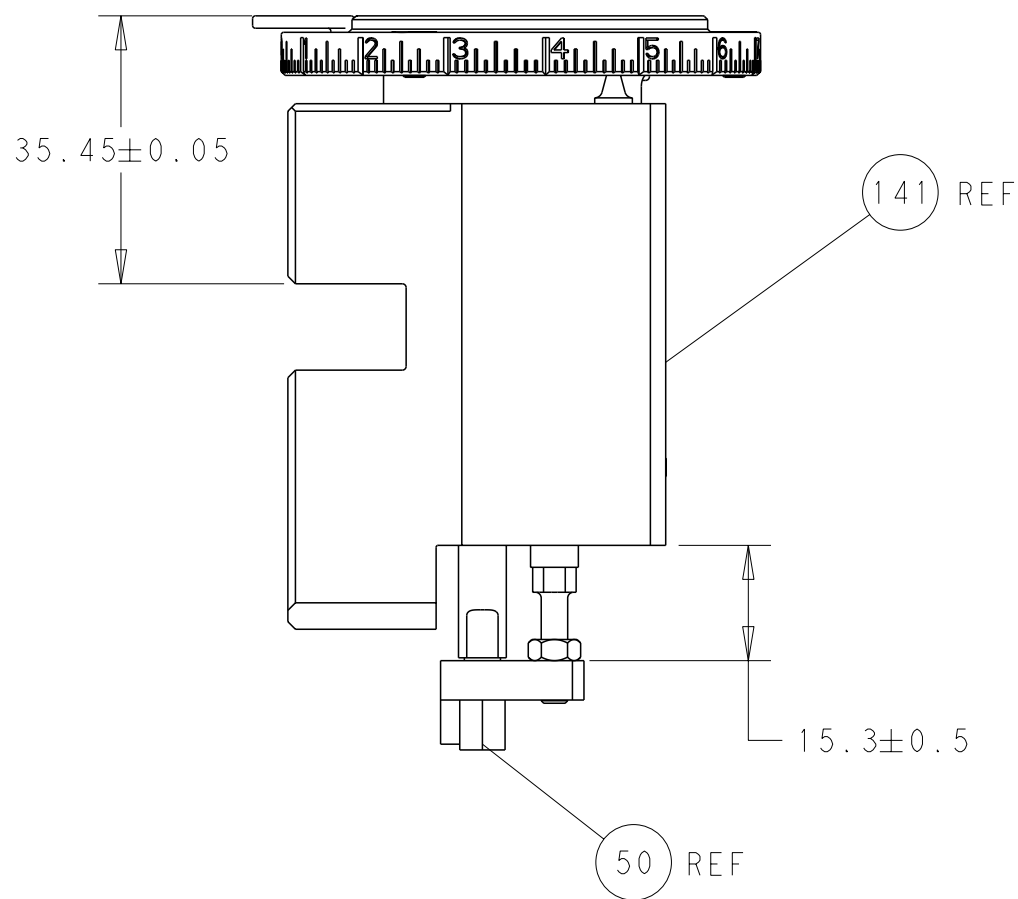
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

	-	1	1	3-240641-4	SPACER	261
-	1	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	240638-1	SPRING, FEED FINGER	163
-	1	-	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	1	2063961-1	FEED FINGER	58
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	-	2119792-2	PAWL, EF, AIR	51
	-	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	50
-	1	2	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1803292-4	DRAG	20
-	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	1	3-240641-3	SPACER	16
-	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
	-	1	1	690495-4	PLATE, FRONT SHEAR	9
	1	1	1	1338673-1	ANVIL, COMBINATION	8
	-	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	240641-3	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
-	77-22-21	PART NO			DESCRIPTION	ITEM NO

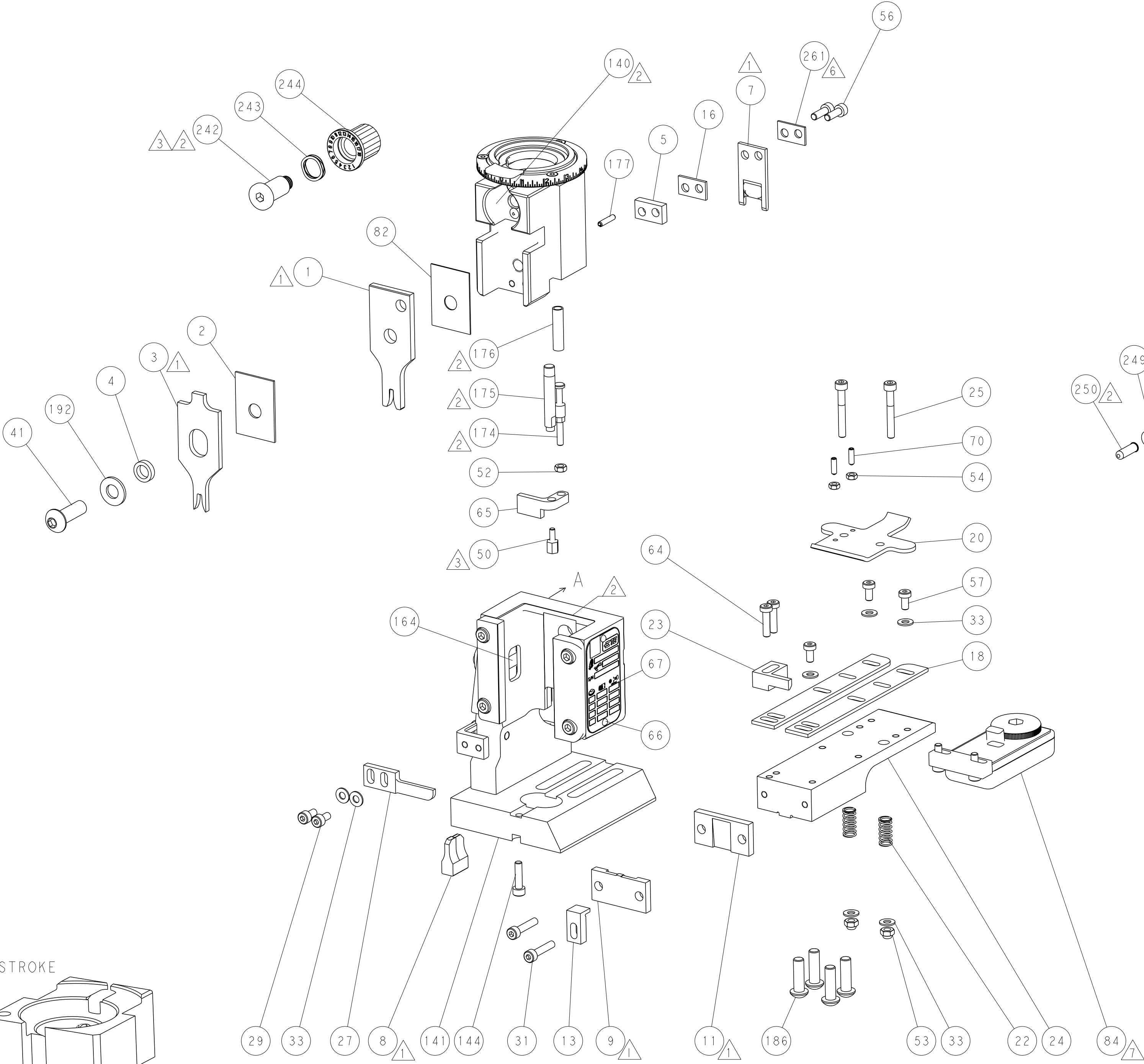
THIS DRAWING IS CONTROLLED. FOR CONTROLLED DRAWINGS, THE LATEST REVISION SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN B. WEAVER CHK G. HOFENER APVD G. RILEY	09DEC2011 09DEC2011 09DEC2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE A1	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2150030	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3	
				OF 4	
				REV H1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

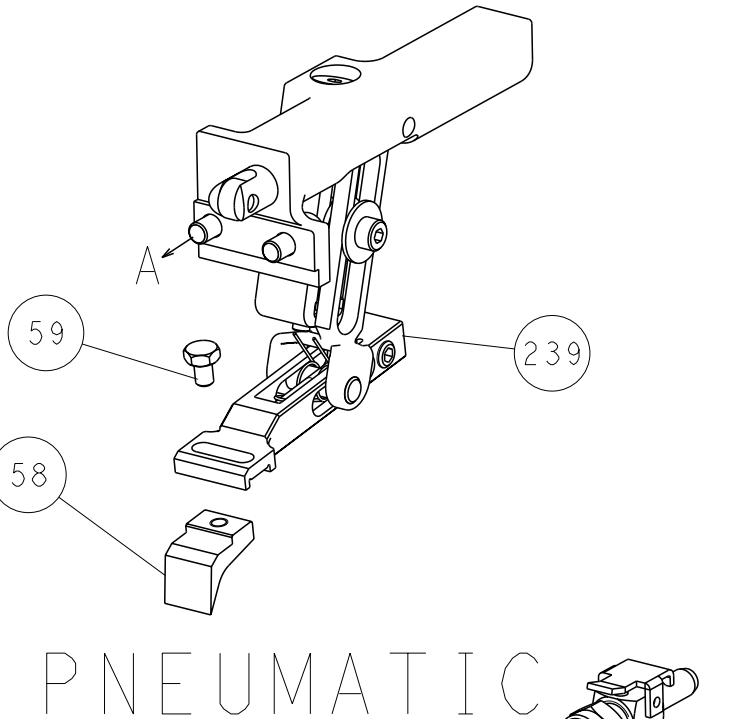
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



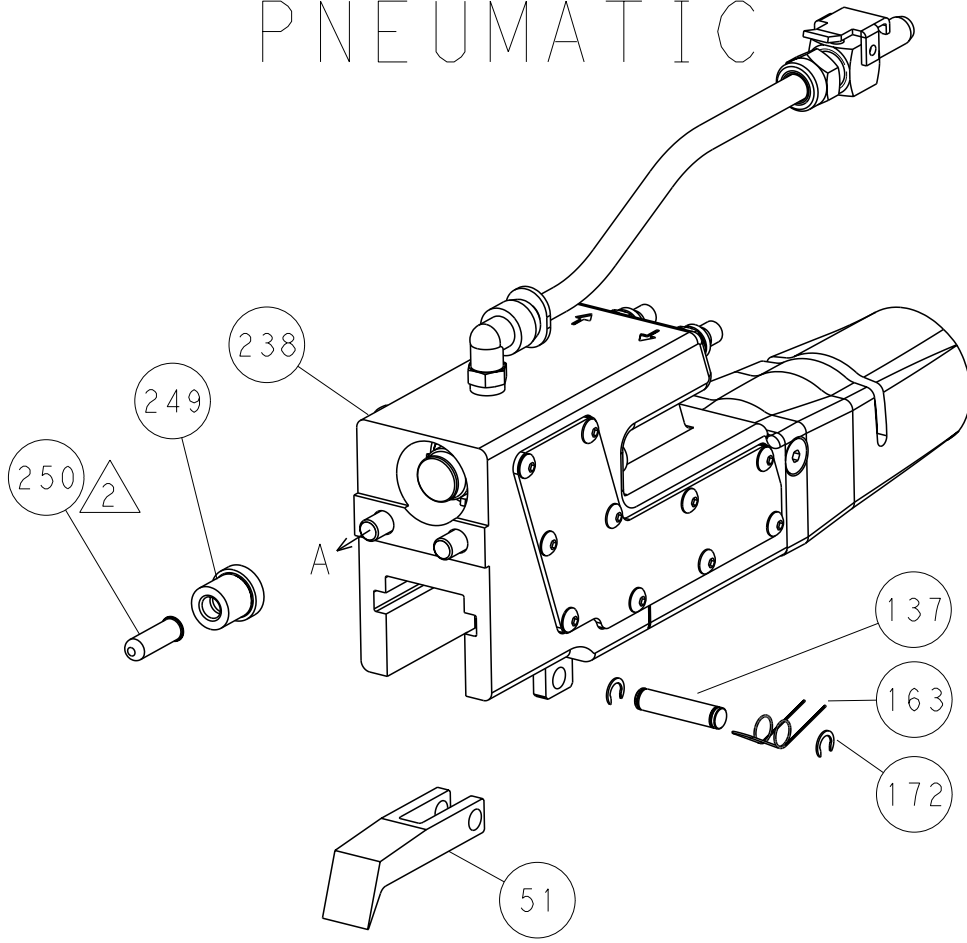
RAM AND HOLDDOWN SET-UP



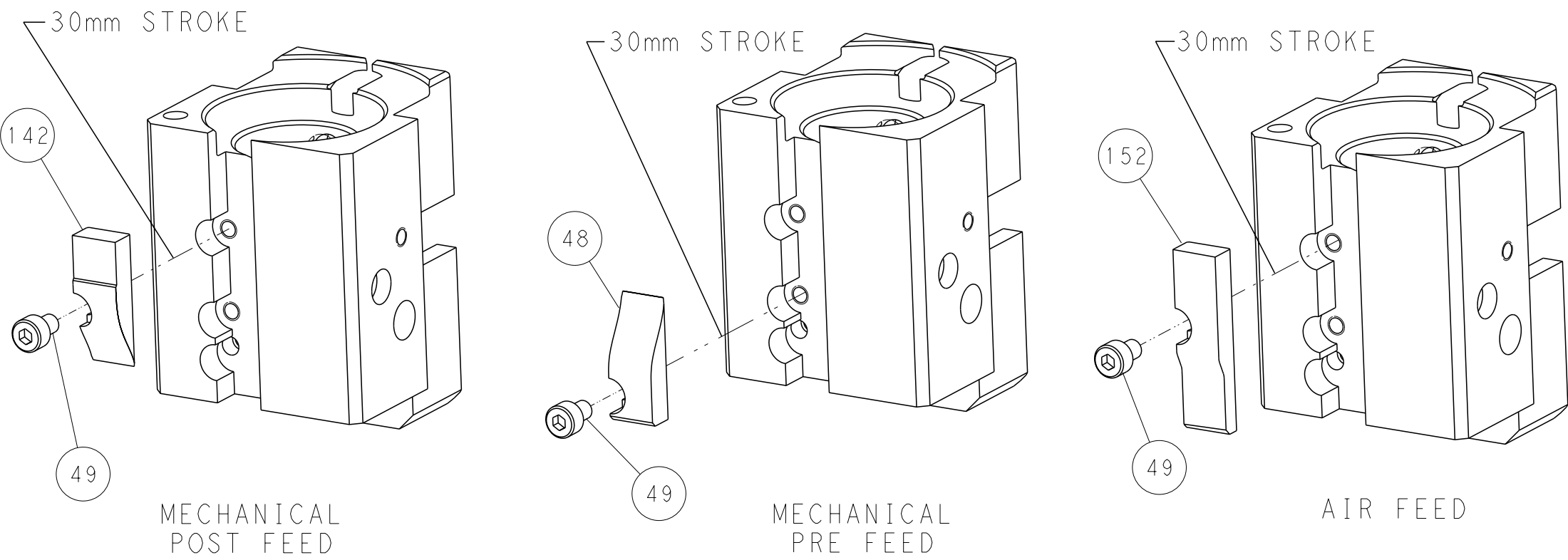
FEED TYPE
MECHANICAL



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 BE CONTROLLED BY THE ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN B. WEAVER 09DEC2011	STE TE Connectivity Harrisburg, PA 17105-3608		
CHK G. HOFFNER 09DEC2011				NAME	Ocean End Feed Applicator		
APVD G. BAILEY 09DEC2011				PRODUCT SPEC	-		
APPLICATION SPEC				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL				WEIGHT	A1	00779 C=2150030	-
Customer Accessible Production Drawing				SCALE	1:1	SHEET 4 OF 4	REV H1