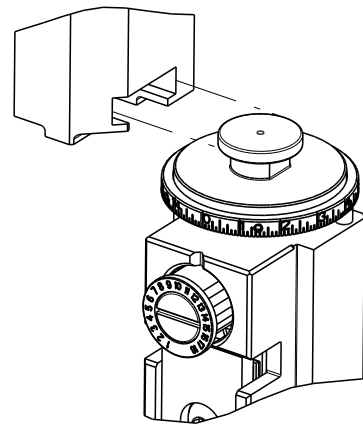


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150364-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150364-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150364-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150364-7	A	CRIMP TOOLING KIT	-



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION 		114-2036	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42743-1	42743-2	61404-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁴
18 AWG		1.42+/-0.05 [1.056+/-0.002]		9.4
20 AWG		1.30+/-0.05 [1.051+/-0.002]		10.7
22 AWG		1.24+/-0.05 [1.049+/-0.002]		11.4



- 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 50.
 - 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.

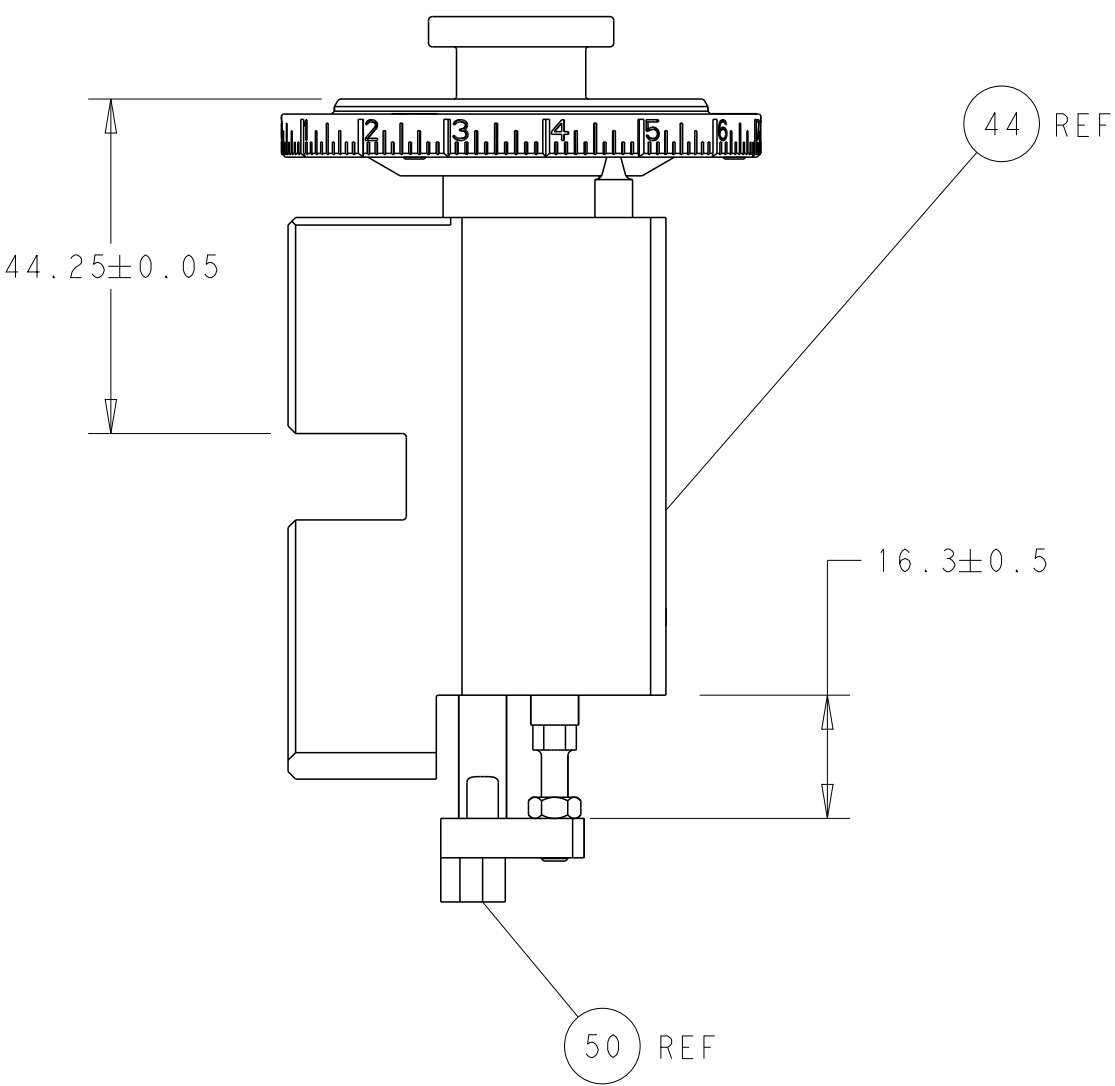
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1			
LOC	DIST	REVISIONS					
A	66						
		P	LTR	DESCRIPTION	DATE	OWN	APPROV
			A	RELEASED	27SEP2013	BH	GB
			B	ECR-16-005525	15APR2016	XZ	GB
			C	ECR-17-003991	20MAR2017	TB	GB
			D	ECR-18-015351	26SEP2018	TB	TE

	-	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	
3	-	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	6-9931111-6	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	177	
	-	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	
5	-	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	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	
	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
	-	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	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	
3	-	1	-	1	-	2119792-2	PAWL, EF, AIR	51	
	-	1	1	1	1	1752354-8	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	240825-1	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	2-240641-9	SPACER	16	
1	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
	-	-	-	-	-	-	-	10	
1	-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	5-1333217-9	ANVIL, EF .090	8	
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	2-240641-8	SPACER	5	
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1	
	-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

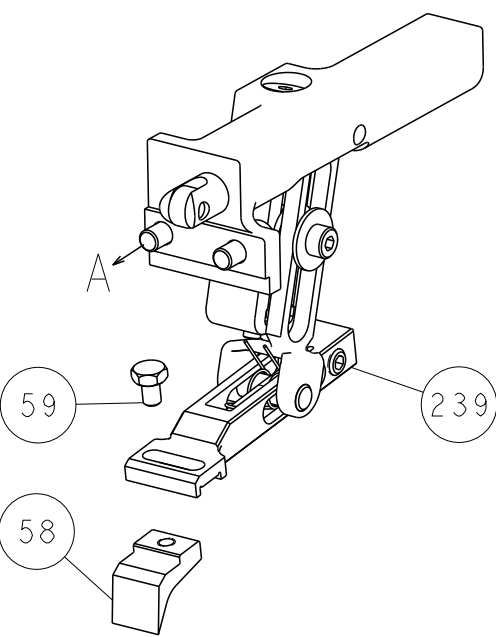
[illegible]

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

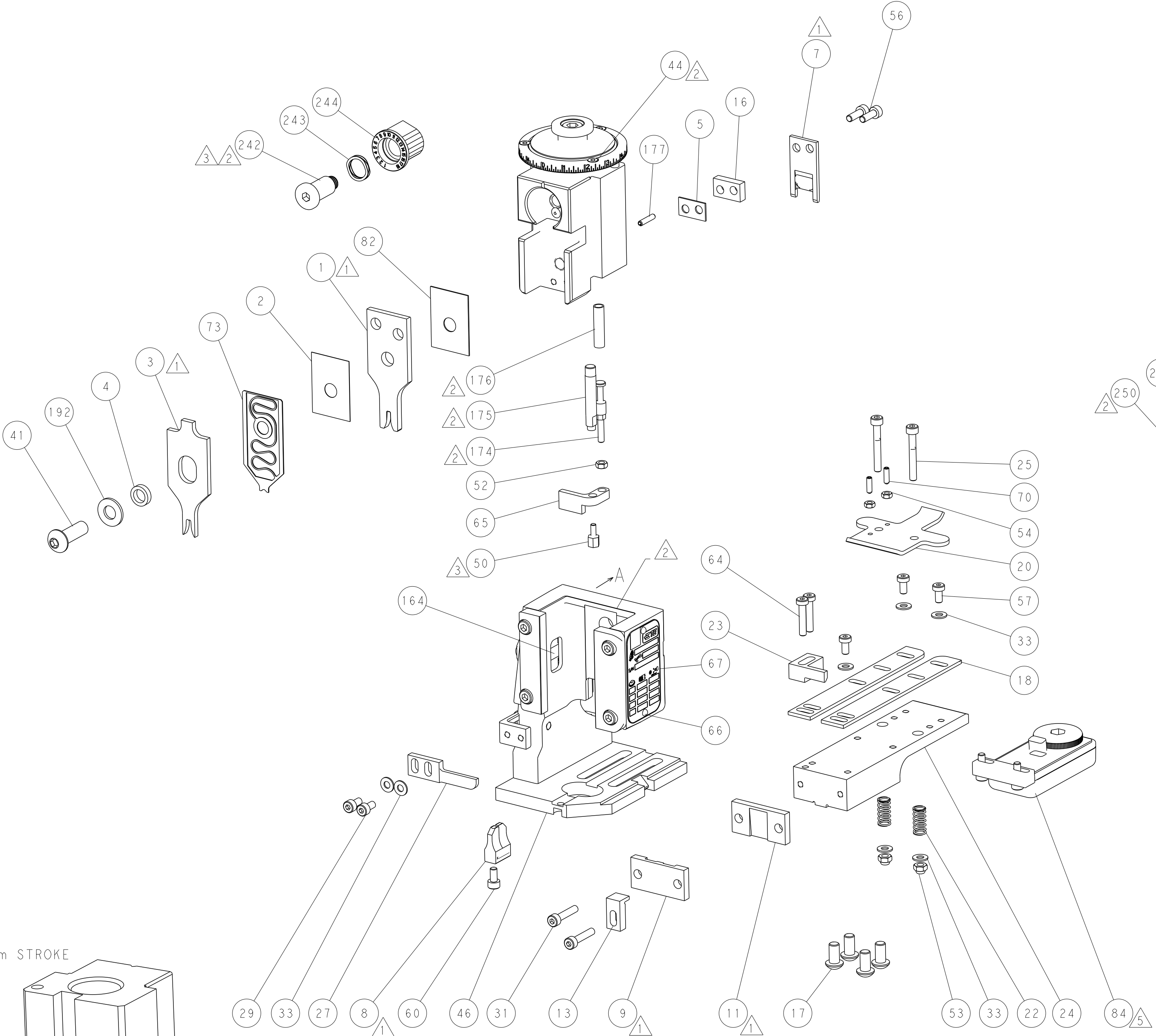
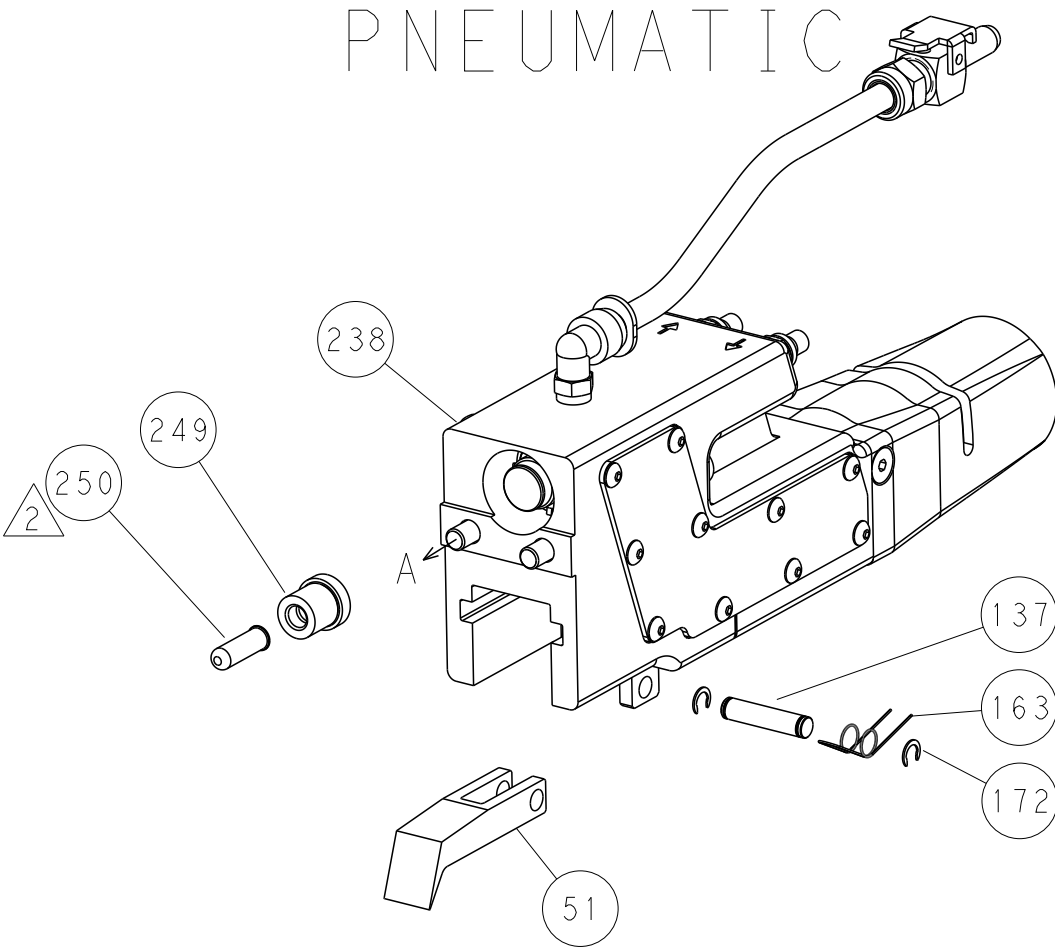


RAM AND HOLDDOWN SET-UP

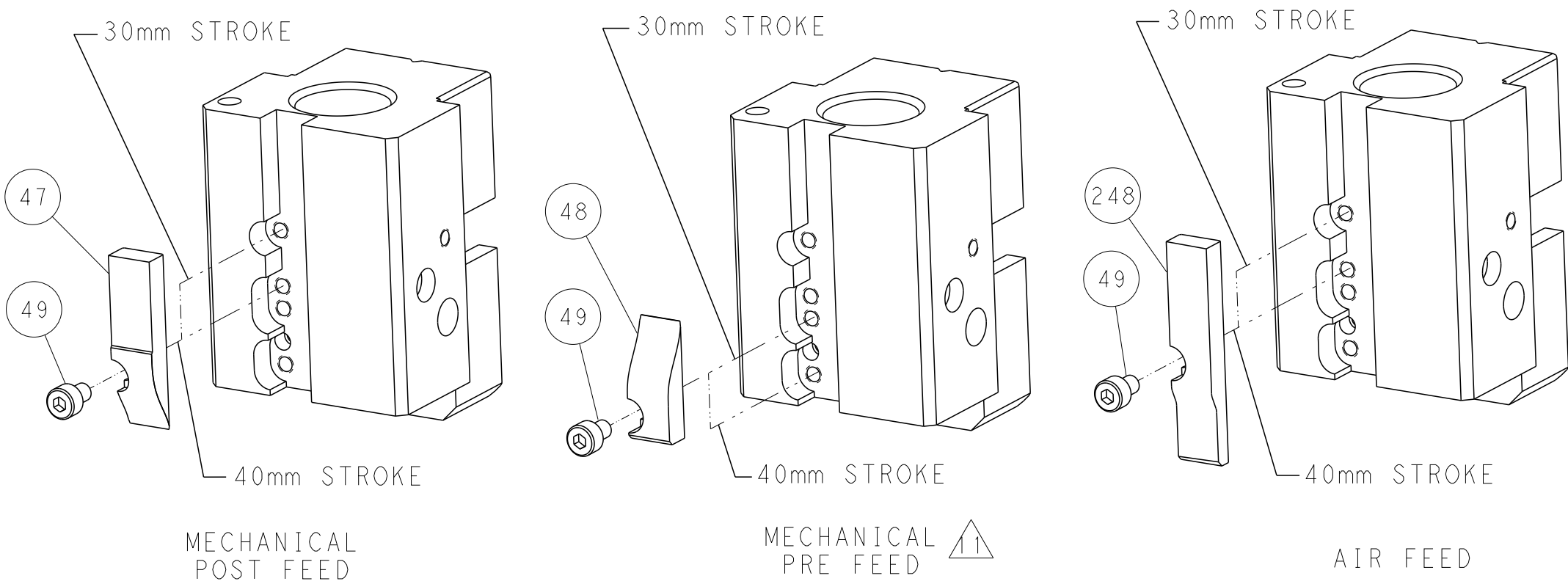
FEED TYPE
MECHANICAL



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 SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS. THE LATEST REVISION OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	Y. YIN	23AUG2013	TE Connectivity	
				CHK	G. BAILEY	23AUG2013	Harrisburg, PA 17105-3608	
				APVD	J. GUO	23AUG2013	NAME	
				PRODUCT SPEC			Ocean End Feed Applicator	
				APPLICATION SPEC			-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A1	00779	©=2150364	-	
				Customer Accessible Production Drawing			SCALE 1:1 SHEET 2 OF 4 REV D	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20
 COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150364-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150364-7	A	CRIMP TOOLING KIT	-

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION 		114-2036	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42743-1	42743-2	61404-1	

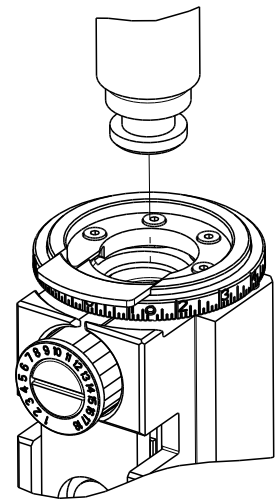
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.42+/-0.05 [0.056+/-0.002]		9.4
20 AWG		1.30+/-0.05 [0.051+/-0.002]		10.7
22 AWG		1.24+/-0.05 [0.049+/-0.002]		11.4



- 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 50.
- 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.

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



*WARNING

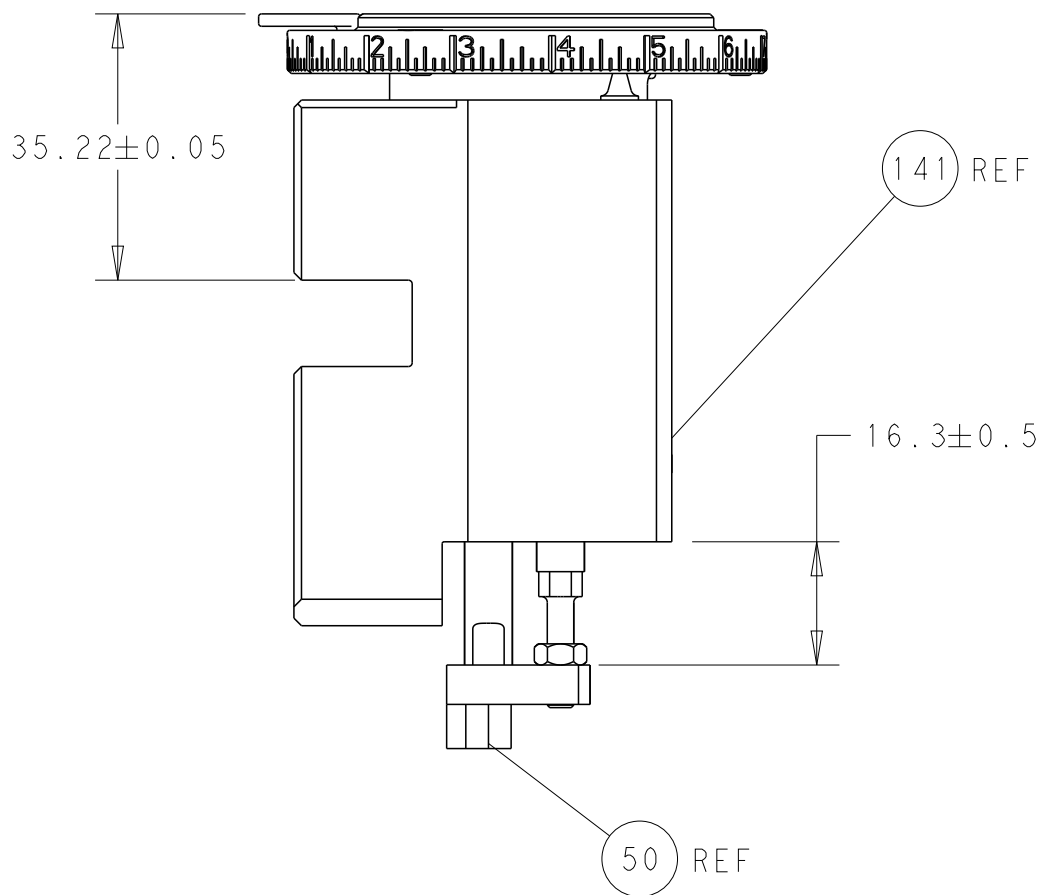
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE
SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE
SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO
THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR
PROPER SETUP AND ADJUSTMENTS.

PACIFIC VERSION

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

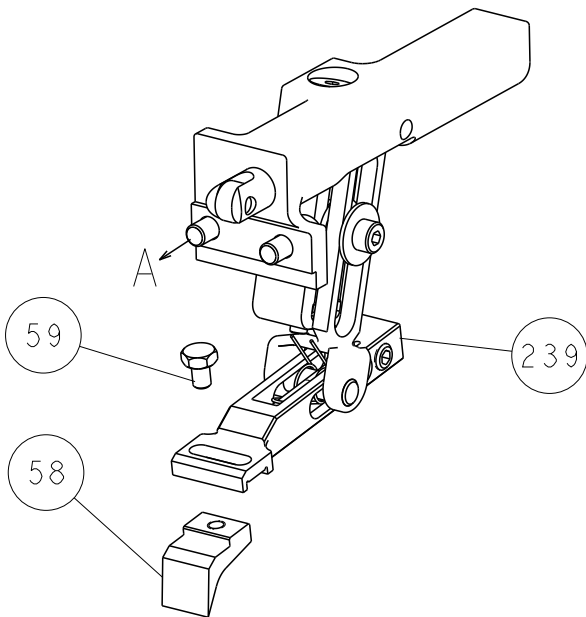
[illegible][illegible]

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

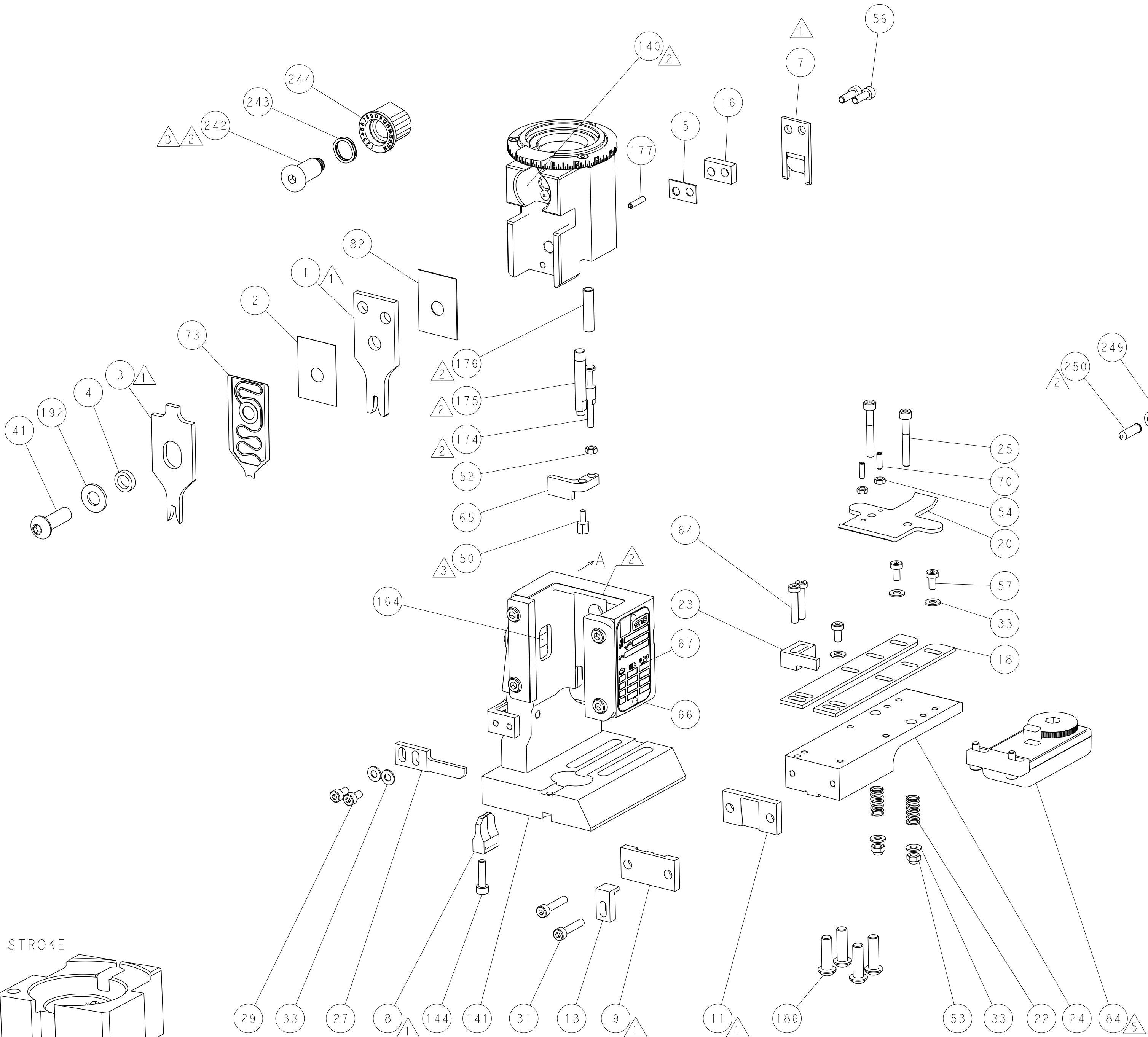
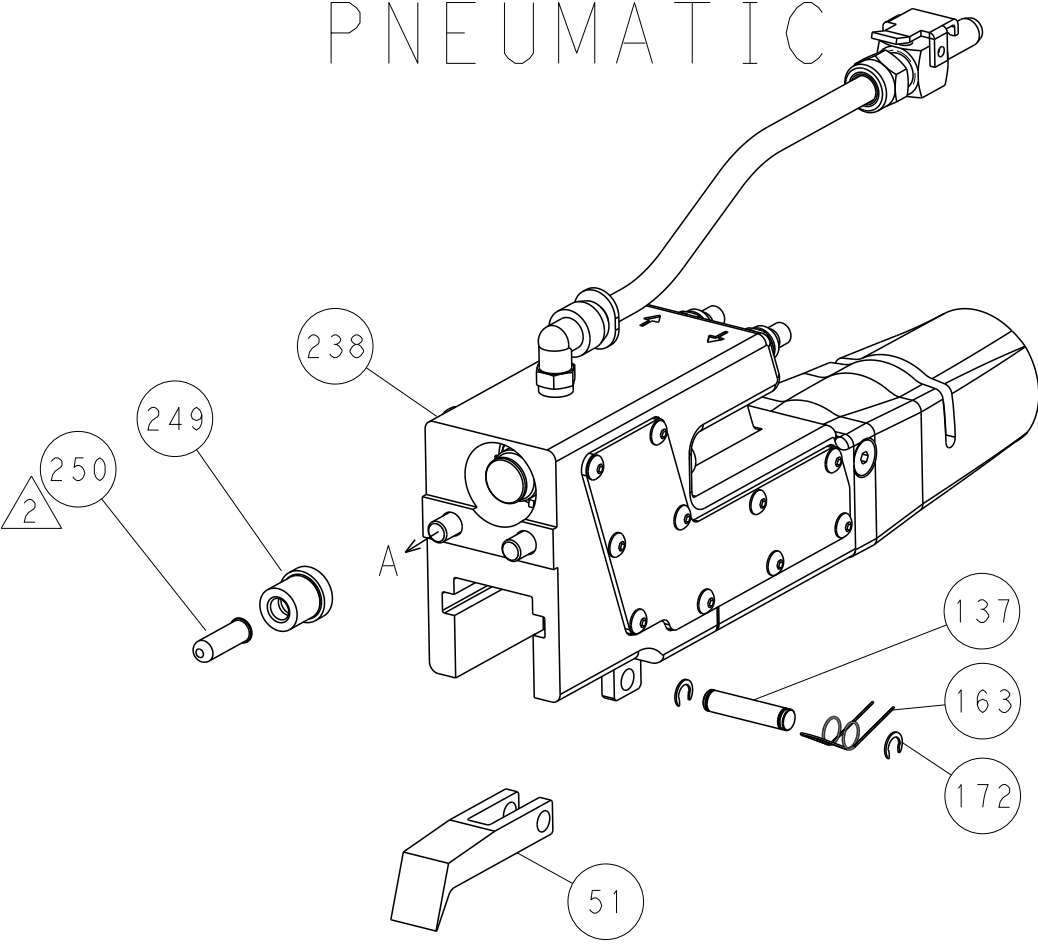


RAM AND HOLDDOWN SET-UP

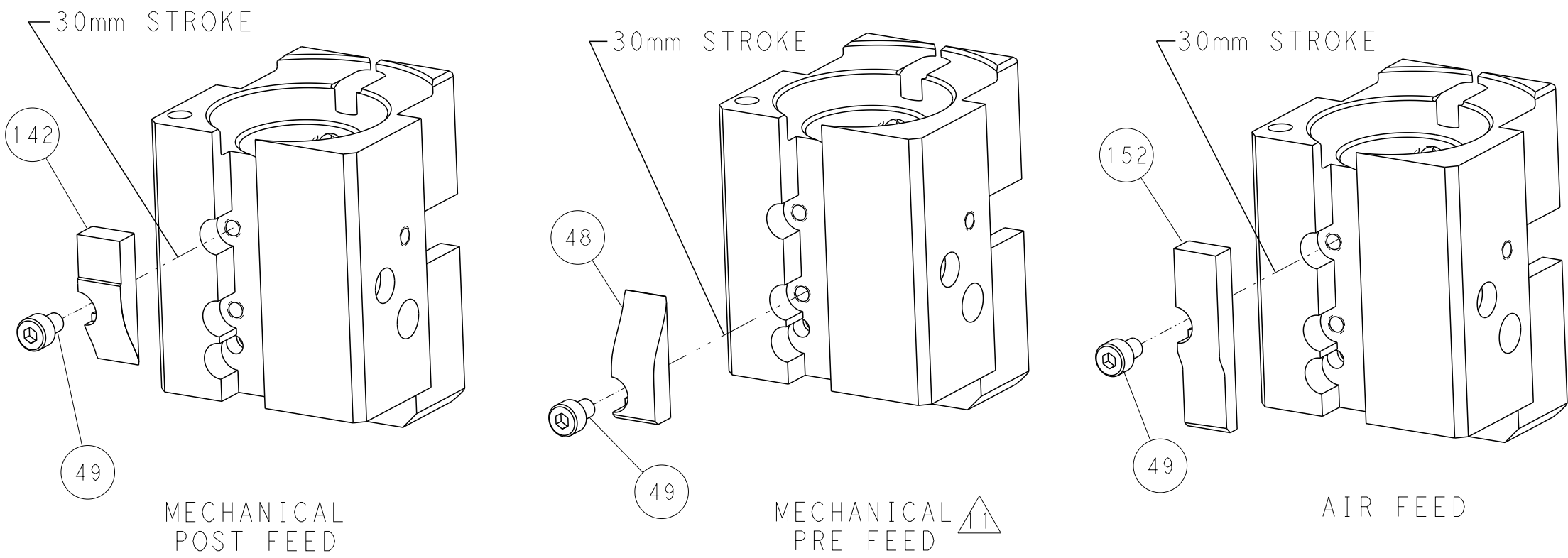
FEED TYPE
MECHANICAL



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.				DWN Y. YIN 23AUG2013				STE TE Connectivity Harrisburg, PA 17105-3608			
CHK G. BAILEY 23AUG2013				NAME				Ocean End Feed Applicator			
APVD J. GUO 23AUG2013				PRODUCT SPEC				SIZE CAGE CODE DRAWING NO			
				APPLICATION SPEC				RESTRICTED TO			
				WEIGHT				A 00779 C=2150364			
Customer Accessible Production Drawing				SCALE 1:1				SHEET 4 OF 4 REV D			