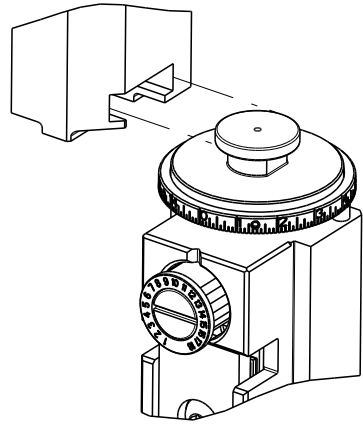


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150035-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150035-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150035-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTIN FASTON TAB CONNECTOR			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]		INSULATION DIAMETER RANGE Ø 2.30mm MAX [.091 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-20119	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
293041-1	293041-2	1-293041-1	1-293041-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.40+/-0.03 [.055+/- .001]		5.4
0.75mm2		1.35+/-0.03 [.053+/- .001]		5.8
0.50mm2		1.30+/-0.03 [.051+/- .001]		6.3
0.35mm2		1.25+/-0.03 [.049+/- .001]		6.8



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

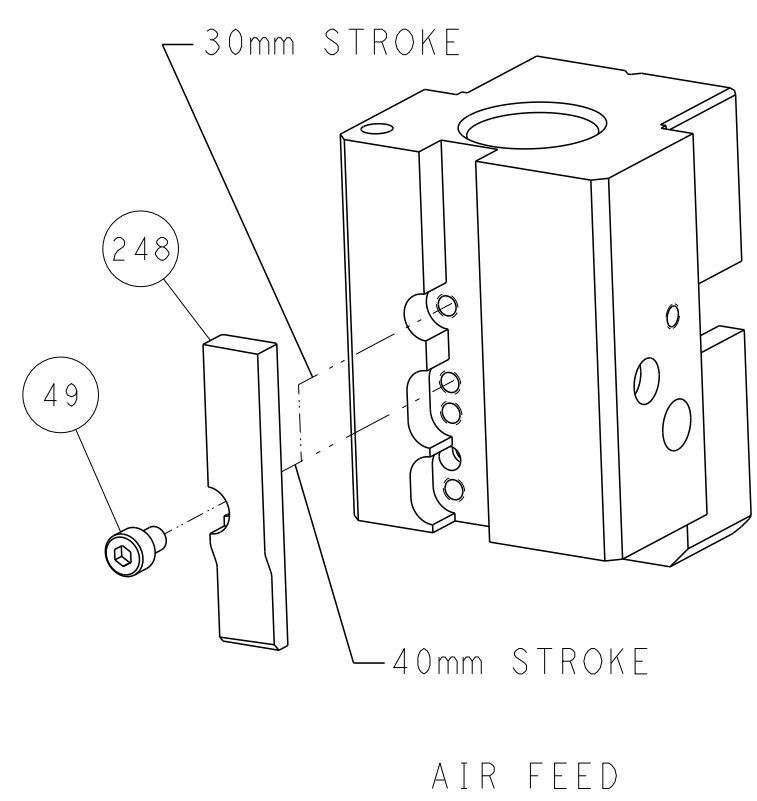
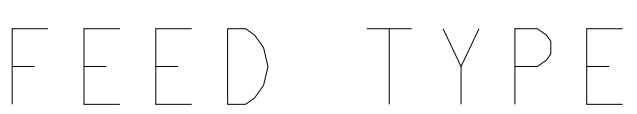
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

2		1	
SET UP GAUGE	LOC	DIST	REVISIONS
2119599-2	A	66	
P	LTR	DESCRIPTION	DATE
	A	RELEASED	08FEB2013
	B	ECR-18-016633	21OCT2018

	-	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	2119082-9	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
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	190
	-	1	1	811242-5	BUMPER, HOLD DOWN	189
	-	1	1	690753-2	SPACER, TONKER	188
	-	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	455888-4	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	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	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	240639-1	STRIPPER (MACHINING)	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	1-1901696-2	STRIP GUIDE, REAR	19
	-	1	1	1-1901695-2	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	6-240641-3	SPACER	16
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-6	PLATE, FRONT SHEAR	9
1	1	2	1	1333216-8	ANVIL, COMBINATION	8
1	-	1	1	2217206-4	BLADE, SLUG	7
	-	1	1	5-240641-0	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	1	2-456405-5	CRIMPER, WIRE PREMIUM	1
	-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

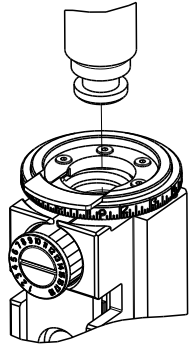
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		OWN	10JAN2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK		Y. YIN	10JAN2012	NAME	
G. BAILEY		S. XI	10JAN2012	Ocean End Feed Applicator	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE	
mm		0 PLC ±.005		CAGE CODE	
1 PLC ±.005		2 PLC ±.005		DRAWING NO	
3 PLC ±.005		4 PLC ±.005		RESTRICTED TO	
ANGLES		FINISH		SCALE	
MATERIAL		WEIGHT		SHEET	
-		-		1 OF 4	
Customer Accessible Production Drawing		SCALE		REV	
-		1:1		B	



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

[illegible]

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(C) COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150035-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150035-7	A	CRIMP TOOLING KIT	-



PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTIN FASTON TAB CONNECTOR			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]		INSULATION DIAMETER RANGE Ø 2.3mm MAX [.091 IN MAX]	
TERMINAL APPLICATION SPECIFICATION		114-20119	
TERMINALS APPLIED		△	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
293041-1	293041-2	1-293041-1	1-293041-2

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
1.00mm2			1.40+/-0.03 [0.055+/-0.01]		5.4	
0.75mm2			1.35+/-0.03 [0.053+/-0.01]		5.8	
0.50mm2			1.30+/-0.03 [0.051+/-0.01]		6.3	
0.35mm2			1.25+/-0.03 [0.049+/-0.01]		6.8	



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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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*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.
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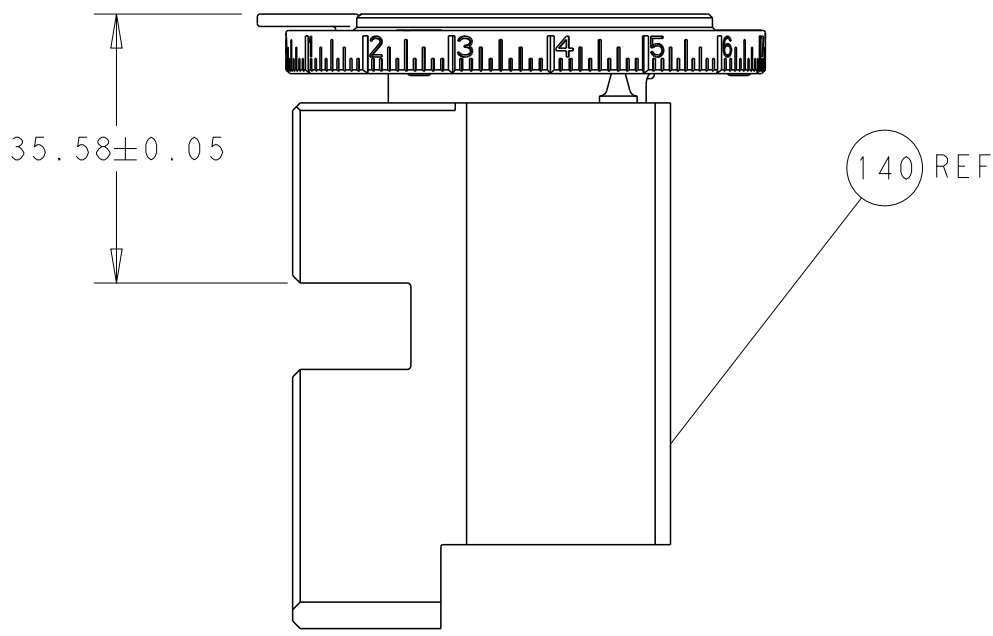
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

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SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISONS
P	LTR	DESCRIPTION	DATE
-	-	SEE SHEET 1	-

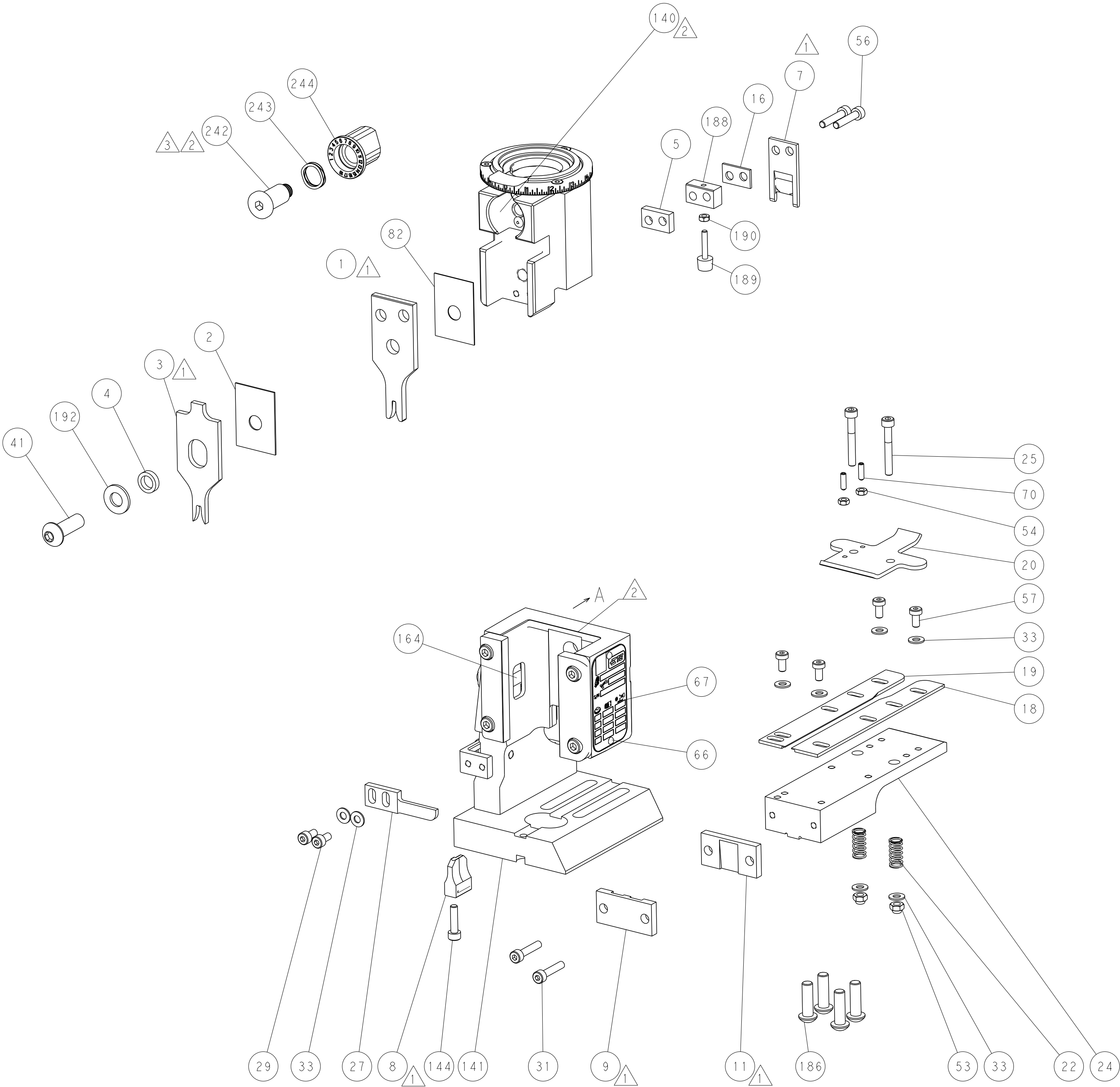
	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2063440-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	5018030-1	NUT, HEX, REG, RoHS, M3	190
	-	1	811242-5	BUMPER, HOLD DOWN	189
	-	1	690753-2	SPACER, TONKER	188
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	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	455888-4	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
	-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	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	240639-1	STRIPPER (MACHINING)	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	1-1901696-2	STRIP GUIDE, REAR	19
	-	1	1-1901695-2	STRIP GUIDE, FRONT	18
	-	1	6-240641-3	SPACER	16
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	690482-6	PLATE, FRONT SHEAR	9
1	1	1	1333216-8	ANVIL, COMBINATION	8
1	-	1	2217206-4	BLADE, SLUG	7
	-	1	5-240641-0	SPACER	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-6	SPACER, CRIMPER	2
1	1	1	2-456405-5	CRIMPER, WIRE PREMIUM	1
-77-22			PART NO	DESCRIPTION	ITEM NO

[illegible]

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

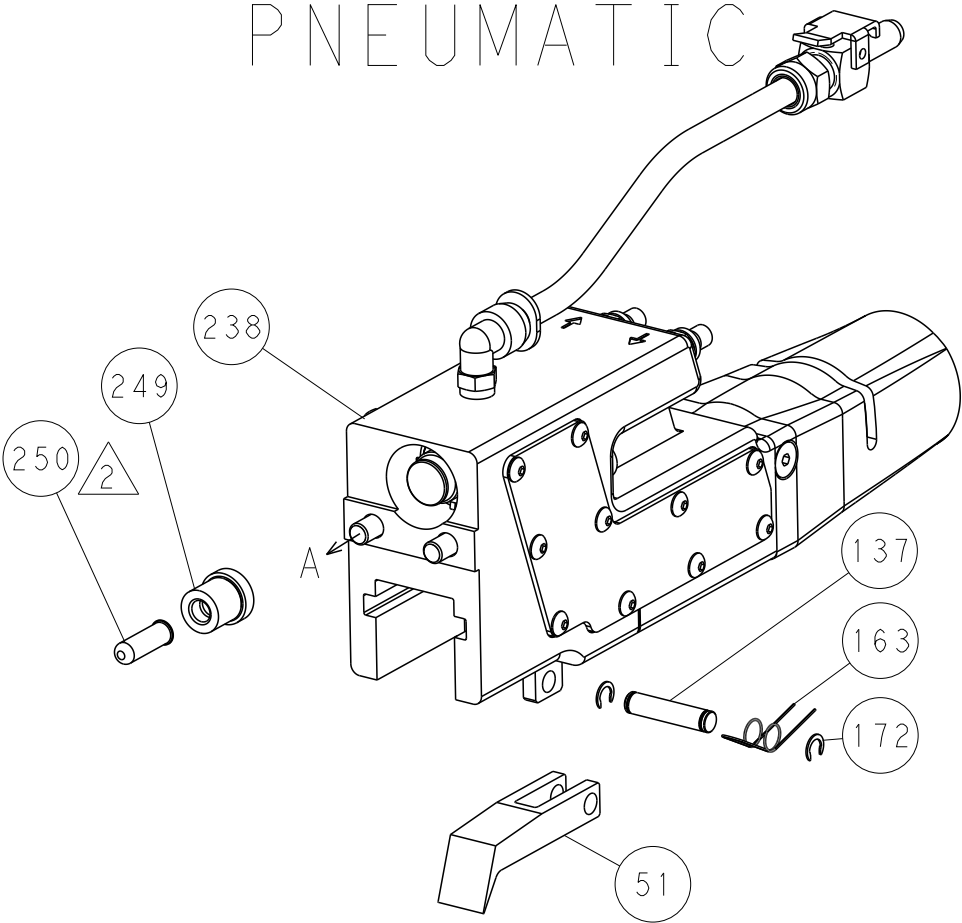


RAM SET-UP

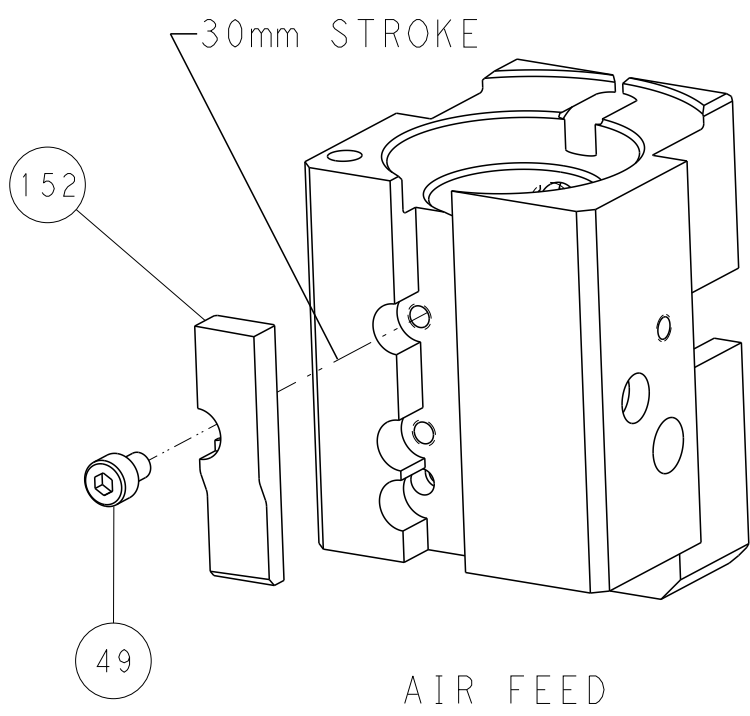


FEED TYPE

PNEUMATIC



CAM POSITION



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 10JAN2012							
										APVD S. XI 10JAN2012		NAME Ocean End Feed Applicator					
										PRODUCT SPEC -				RESTRICTED TO -			
										APPLICATION SPEC -							
										WEIGHT -				RESTRICTED TO -			
										Customer Accessible Production Drawing				SCALE 1:1			
										Customer Accessible Production Drawing				SHEET 4 of 4			
										Customer Accessible Production Drawing				REV B			