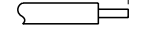


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150347-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150347-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150347-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

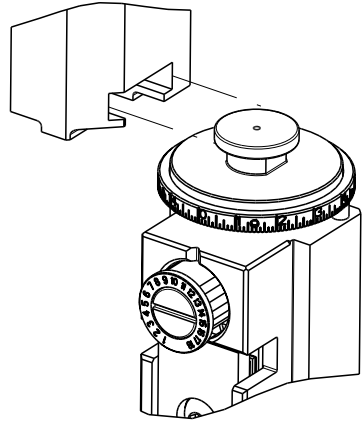
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON TAB, AMPLIVAR			
WIRE STRIP LENGTH 6.05-6.65 mm [.238-.262 IN]		 INSULATION DIAMETER RANGE Ø2.20-3.30 mm [.087-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-2070 - -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928890-1	928890-2	1-928890-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
MAG Ø1.60		1.81+/-0.05 [1.071+/- .002]		4.7
MAG Ø1.40		1.66+/-0.05 [1.065+/- .002]		6.3
MAG Ø0.95		1.45+/-0.05 [1.057+/- .002]		8.2
MAG Ø0.90		1.38+/-0.05 [1.054+/- .002]		9.0



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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



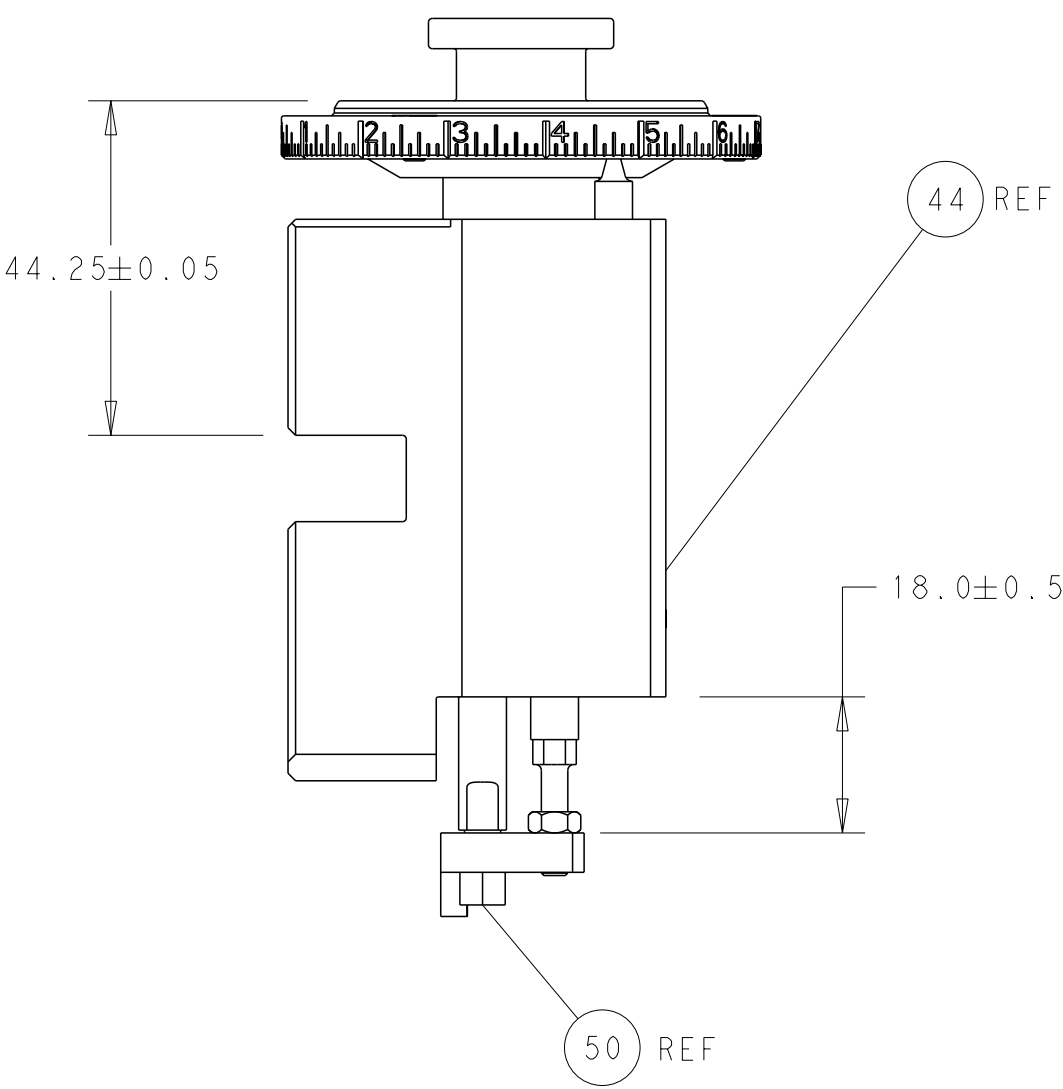
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1					
LOC	DIST	REVISIONS							
A	66	P	LYR	DESCRIPTION			DATE	DWN	APVD
			A1	ECR-15-004157			16MAR2015	JH	JT
			B	ECR-19-012338			05AUG2019	TB	RK
			B1	ECR-19-014823			23SEP2019	MZ	YY
			B3	ECR-22-151035			31AUG2022	FZ	JAH

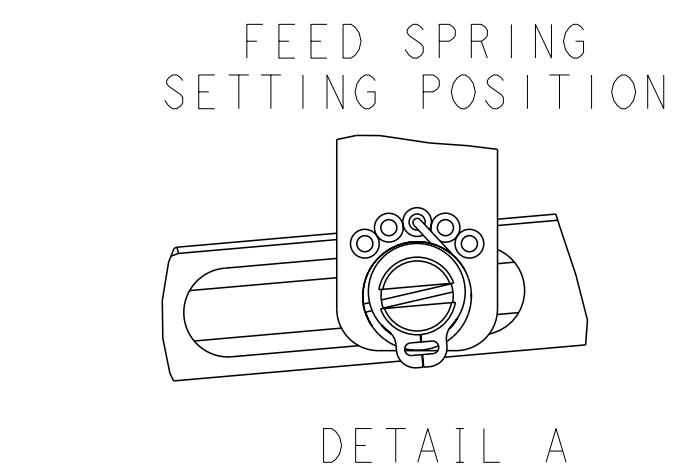
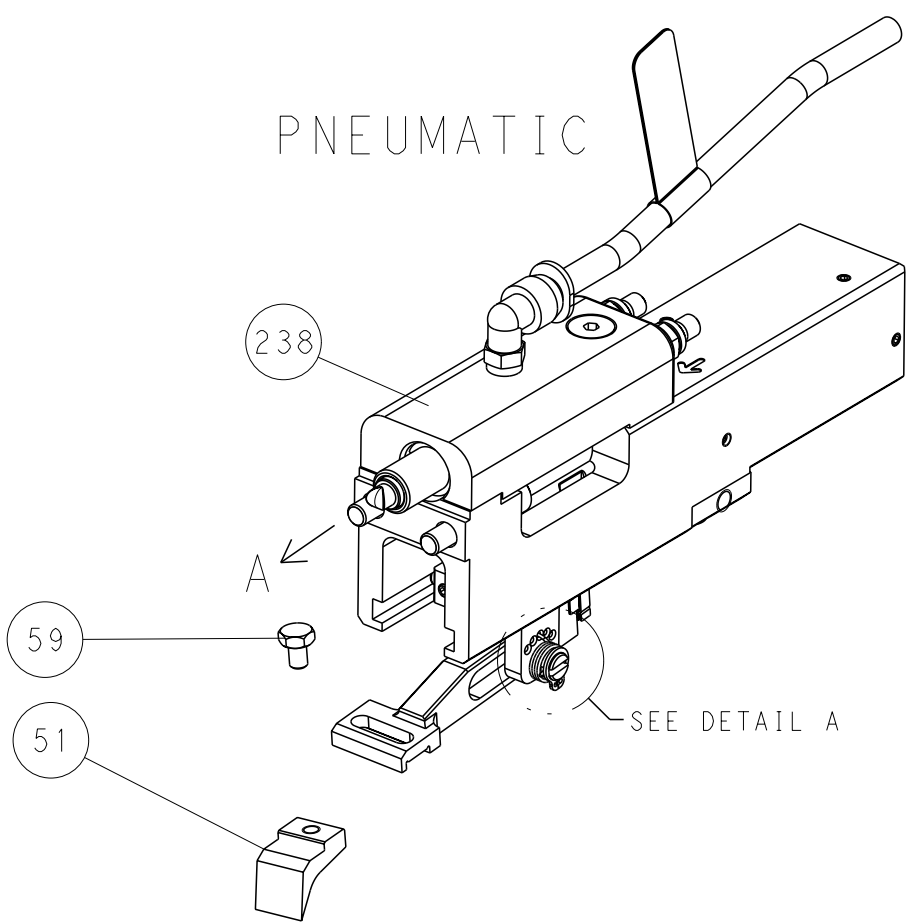
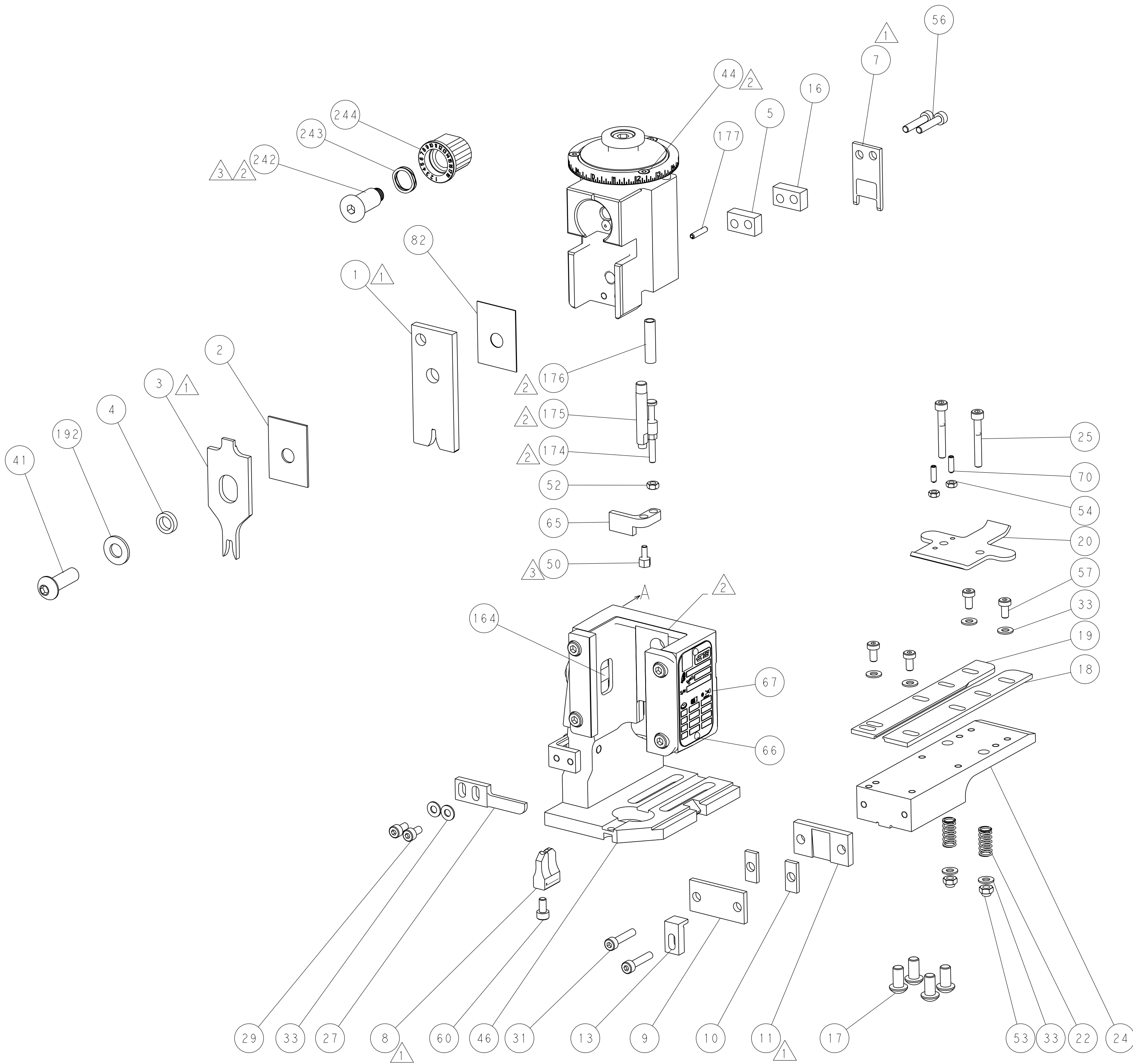
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-4	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	6-993111-6	PIN, 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
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1803607-4	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
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	2063961-1	FEED FINGER	51
3	-	1	1	1752354-2	STANDOFF,HOLD-DOWN	50
	-	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	1-1752371-2	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1901696-5	STRIP GUIDE, REAR	19
	-	1	1	1901695-5	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1-240641-5	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
1	-	2	2	1-240645-1	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	1803064-4	ANVIL, COMBINATION	8
1	-	1	1	8-240651-2	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	2-240641-2	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	1	1-462808-8	CRIMPER, BLUNT F	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFC ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING CONTROLLING ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	Y. YIN	01AUG2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	G. BAILEY	01AUG2013				
				APVD	J. GUO	01AUG2013				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		Ocean End Feed Applicator		
mm		0 PLC ±		APPLICATION SPEC		SIZE				
		1 PLC ±		FINISH		CAGE CODE				
		2 PLC ±		MATERIAL		DRAWING NO		RESTRICTED TO		
		3 PLC ±				A1 00779				
		4 PLC ±				©=2150347				
		ANGLES				Customer Accessible Production Drawing		SCALE 1:1		
		FINISH						SHEET 1 of 4		
								REV B3		

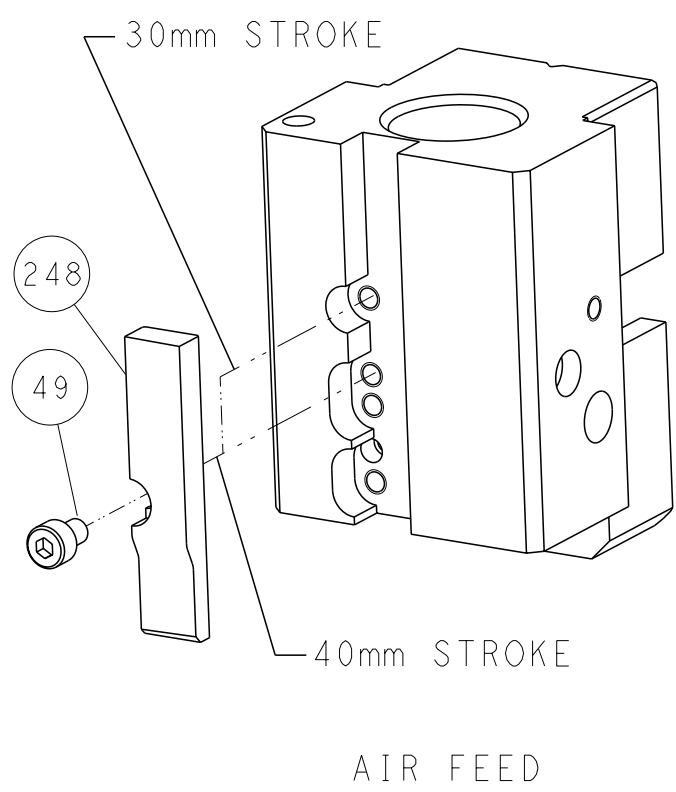
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



CAM POSITION

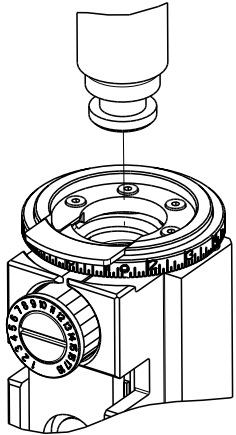


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1111 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN Y. YIN	01AUG2013	 TE Connectivity Harrisburg, PA 17105-3608		NAME Ocean End Feed Applicator					
				CHK G. BAILEY	01AUG2013								
				APVD U. GUO	01AUG2013								
				PRODUCT SPEC									
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC		SIZE A		CAGE CODE 00779		DRAWING NO C=2150347		RESTRICTED TO -	
mm				-									
				WEIGHT -									
MATERIAL -		FINISH -		Customer Accessible Production Drawing		SCALE 1:1		SHEET 2		OF 4		REV B3	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150347-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150347-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON TAB, AMPLIVAR			
WIRE STRIP LENGTH 6.05-6.65 mm [.238-.262 IN]		INSULATION DIAMETER RANGE Ø2.20-3.30 mm [.087-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2070	
TERMINALS APPLIED		5	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928890-1	928890-2	1-928890-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
MAG Ø1.60		1.81+/-0.05 [.071+/- .002]		4.7	
MAG Ø1.40		1.66+/-0.05 [.065+/- .002]		6.3	
MAG Ø0.95		1.45+/-0.05 [.057+/- .002]		8.2	
MAG Ø0.90		1.38+/-0.05 [.054+/- .002]		9.0	



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 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.

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

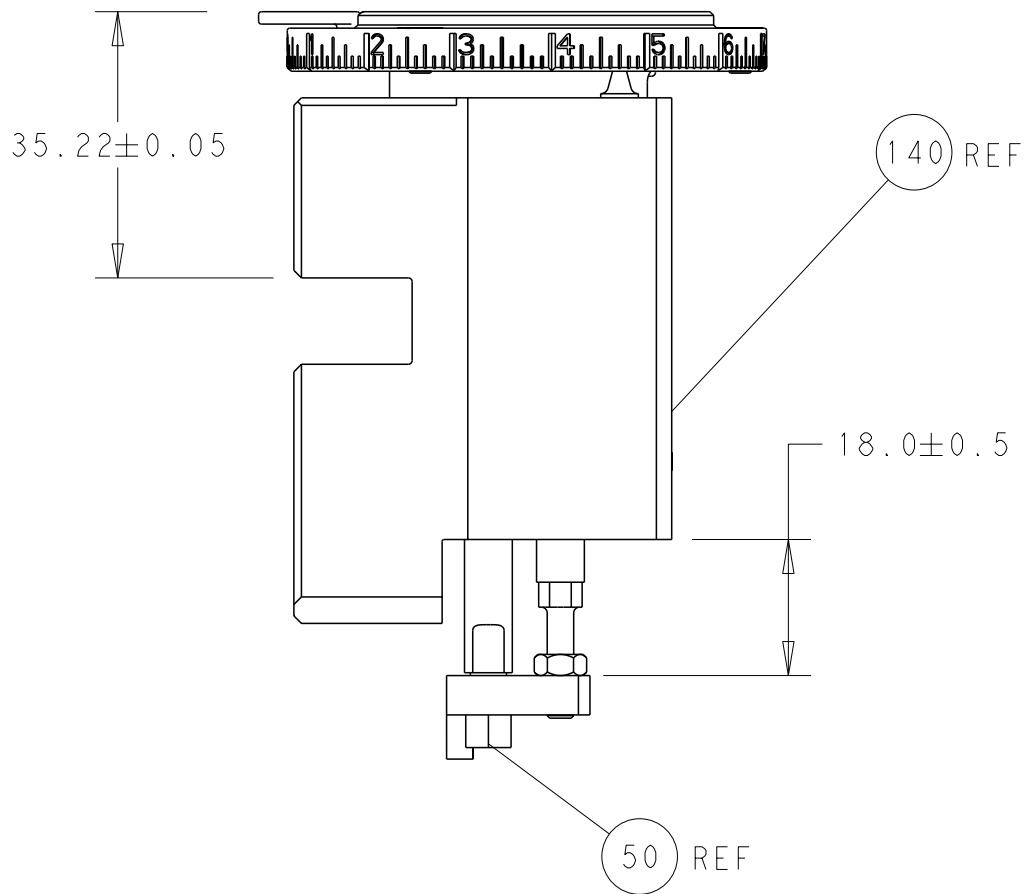
LOC	DIST	REVISIONS				
A	66	P	LYR	DESCRIPTION	DATE	OWN
		-		SEE SHEET 1	-	-

	-	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	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	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
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	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	455888-4	SPACER, CRIMPER	82
	-	1	1803607-4	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
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	2063961-1	FEED FINGER	51
3	-	1	1752354-2	STANDOFF,HOLD-DOWN	50
	-	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	1-1752371-2	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	1	1901696-5	STRIP GUIDE, REAR	19
	-	1	1901695-5	STRIP GUIDE, FRONT	18
	-	1	1-240641-5	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	2	1-240645-1	SPACER, SHEAR PLATE	10
1	-	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1803064-4	ANVIL, COMBINATION	8
1	-	1	8-240651-2	BLADE, SLUG	7
	-	-	-	-	6
	-	1	2-240641-2	SPACER	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-9	SPACER, CRIMPER	2
1	1	1	1-462808-8	CRIMPER, BLUNT F	1

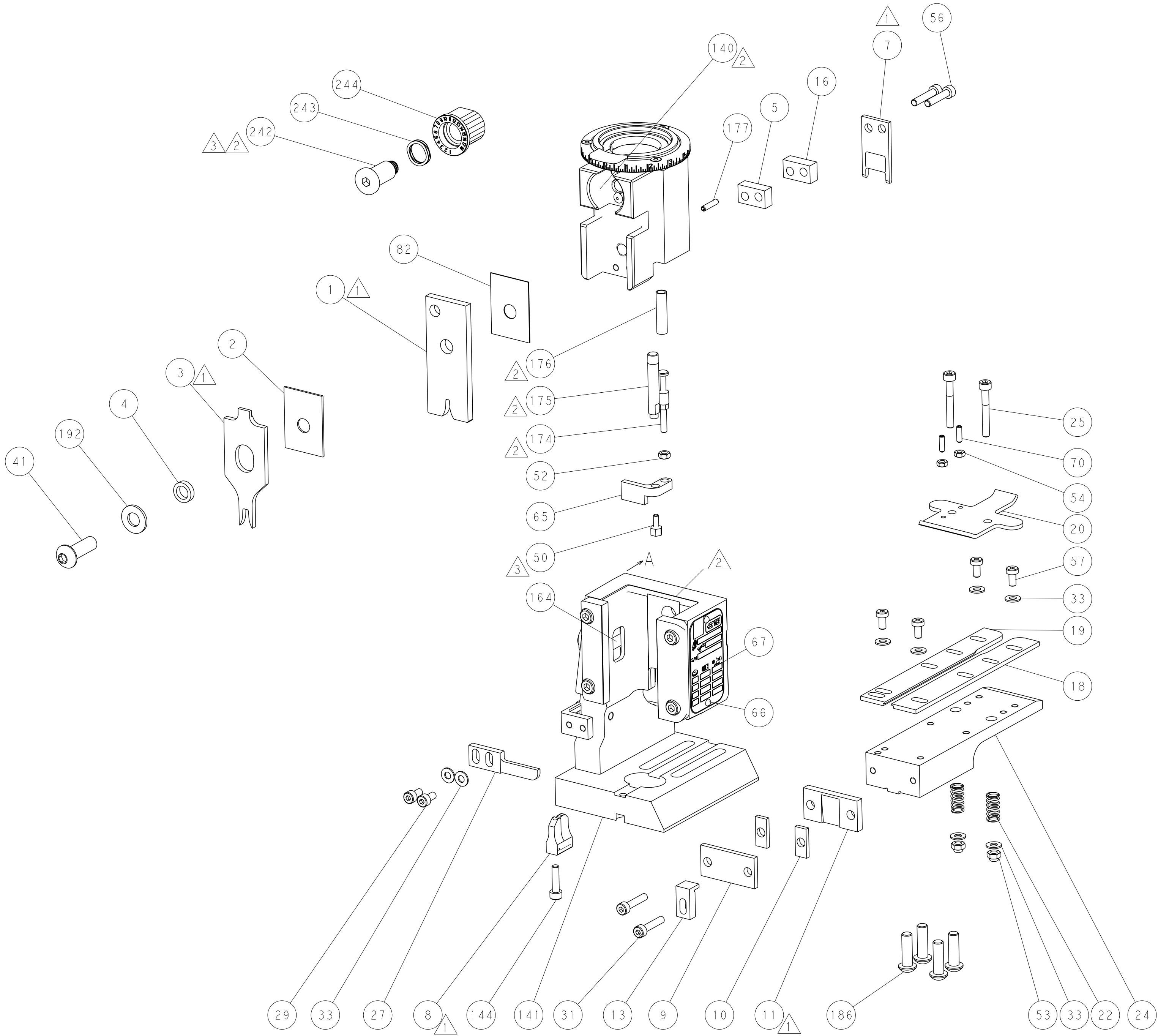
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN Y. YIN 01AUG2013		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK G. BAILEY 01AUG2013		NAME			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APVD U. GUO 01AUG2013		PRODUCT SPEC			
		ANGLES ±		APPLICATION SPEC		SIZE			
MATERIAL		FINISH		WEIGHT		CAGE CODE		DRAWING NO	
-		-		-		A 00779		C=2150347	
Customer Accessible Production Drawing						SCALE		1:1	
						SHEET		3 of 4	
						REV		B3	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

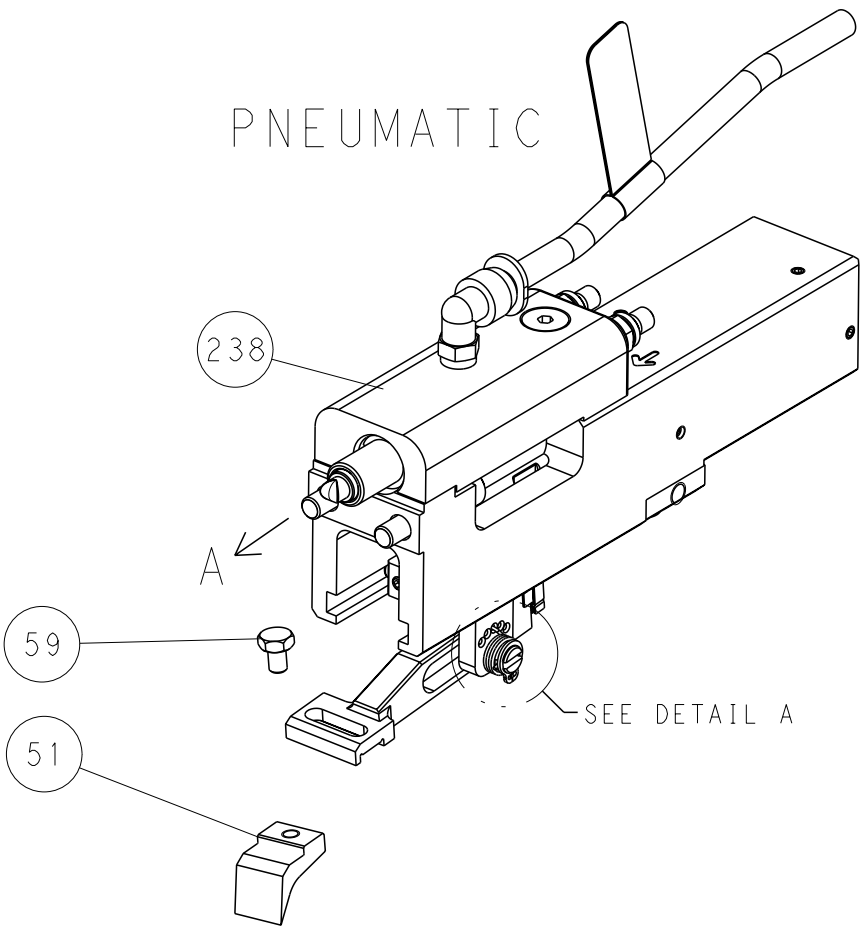
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



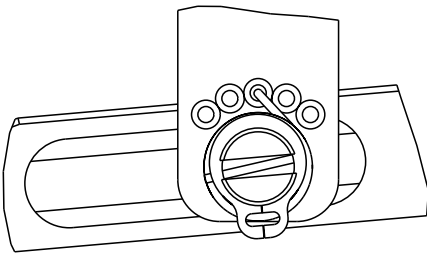
RAM AND HOLDDOWN SET-UP



FEED TYPE

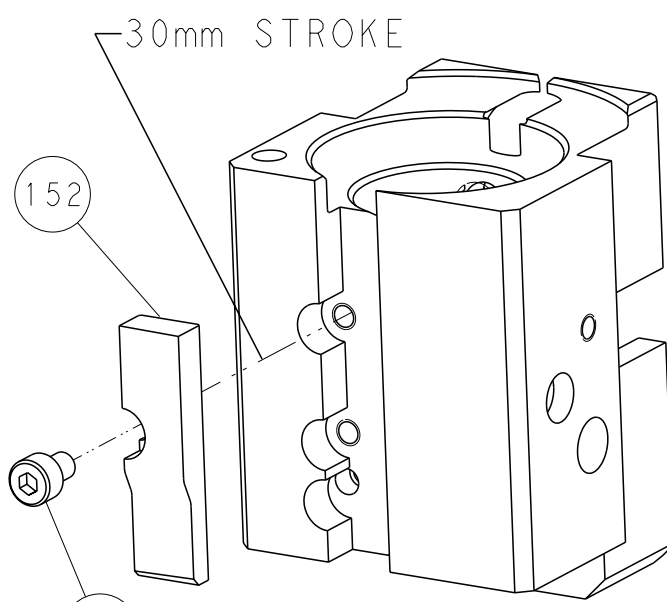


FEED SPRING SETTING POSITION



DETAIL A

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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN Y. YIN	01AUG2013	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK G. BAILEY	01AUG2013			
				APVD U. GUO	01AUG2013	NAME Ocean End Feed Applicator		
				PRODUCT SPEC				
				APPLICATION SPEC				
				WEIGHT				
				Customer Accessible Production Drawing				
				SCALE		1:1		
				SHEET		4 of 4		
				REV		B3		