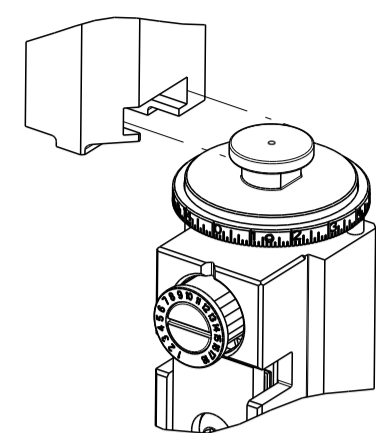


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150550-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150550-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150550-7	B	CRIMP TOOLING KIT	-

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		INSULATION DIAMETER RANGE	
6.02-6.78 mm [.237-.267 IN]		∅5.33-6.73 mm [.210-.265 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
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.
- 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.

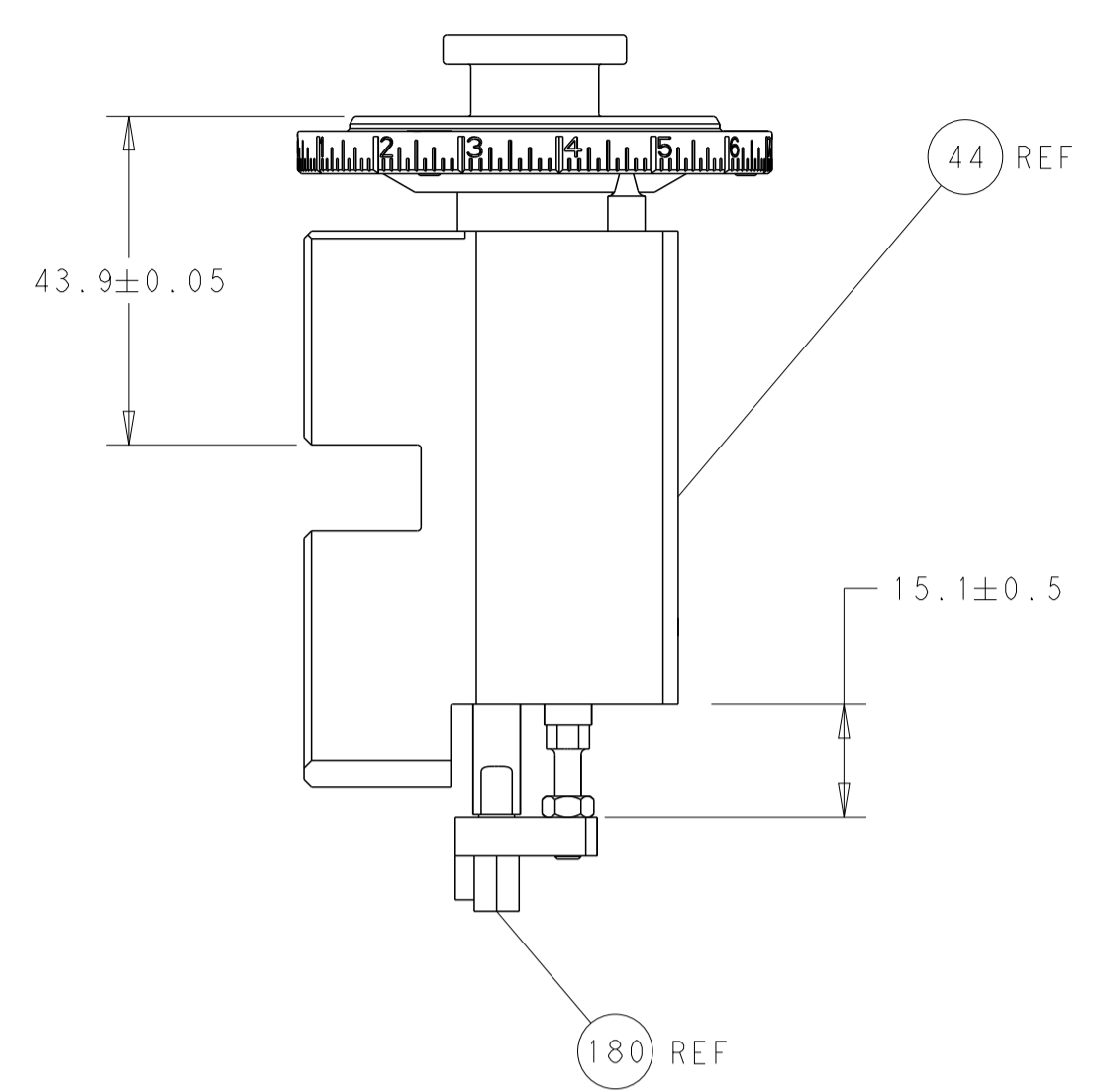
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-15-018629	23DEC2015	MR	GB
		C		ECR-18-015272	25SEP2018	TB	TE
		D		ECR-20-010768	29JUL2020	JWC	GB
		E		ECR-20-014811	19OCT2020	TB	RK

-	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	
	-	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	1-1752354-4	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-6	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	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	2063961-9	FEED FINGER	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	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	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	-	1	690482-3	PLATE, FRONT SHEAR	9	
	1	2	1	3-1803059-5	ANVIL, COMBINATION, END FEED	8
	-	1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	1-240641-4	SPACER	5
-	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	2	1	2-1803187-7	CRIMPER, INSULATION F	3
-	1	1	1	1-455888-5	SPACER, CRIMPER	2
	1	2	1	456411-3	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

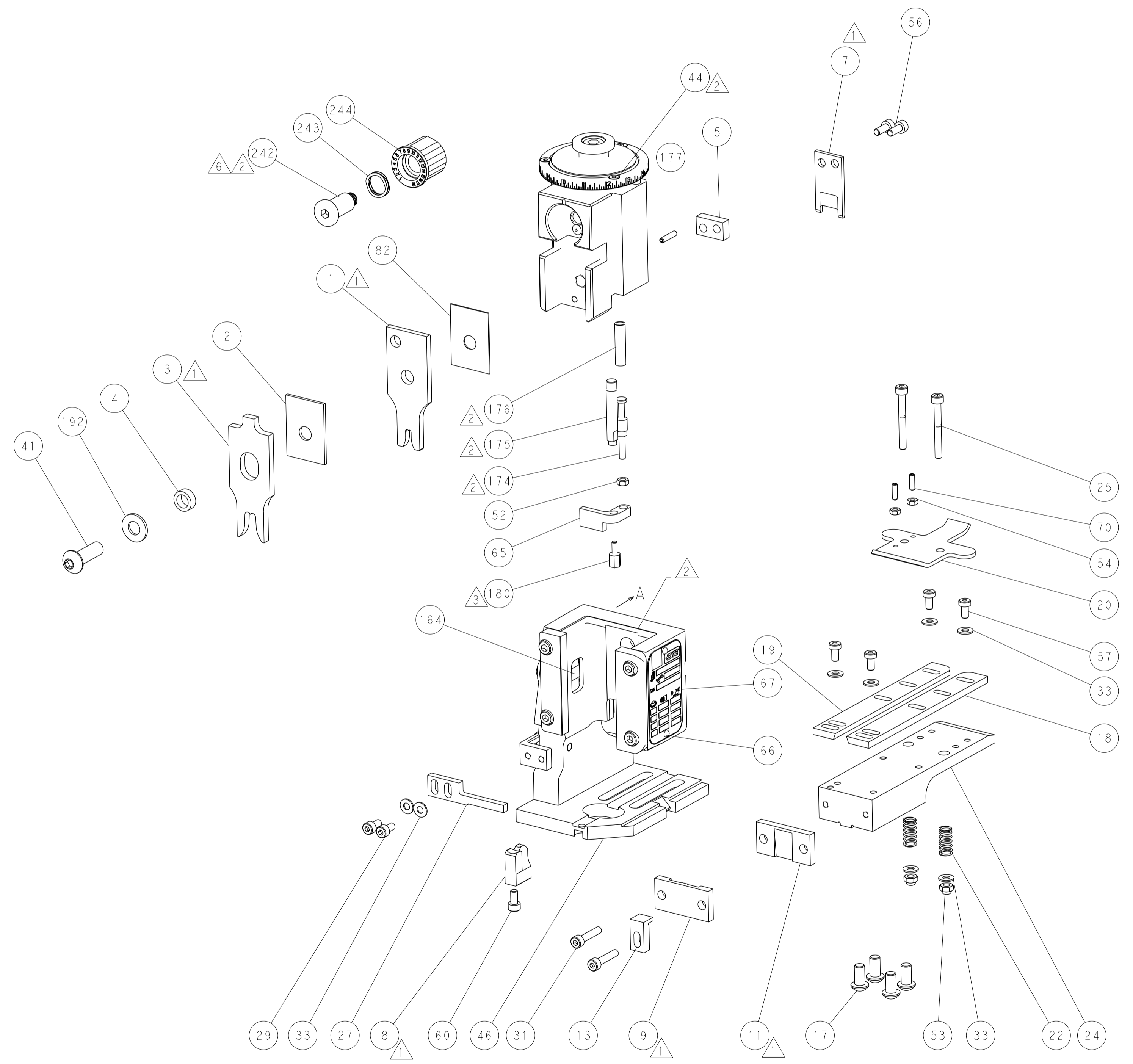
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	12JUN2015	DWN
	3 PLC ±	4 PLC ±	ANGLES ±	12JUN2015	CHK
MATERIAL	FINISH	WEIGHT	SCALE	1:1	SHEET 1 OF 4
Customer Accessible Production Drawing				REV	E

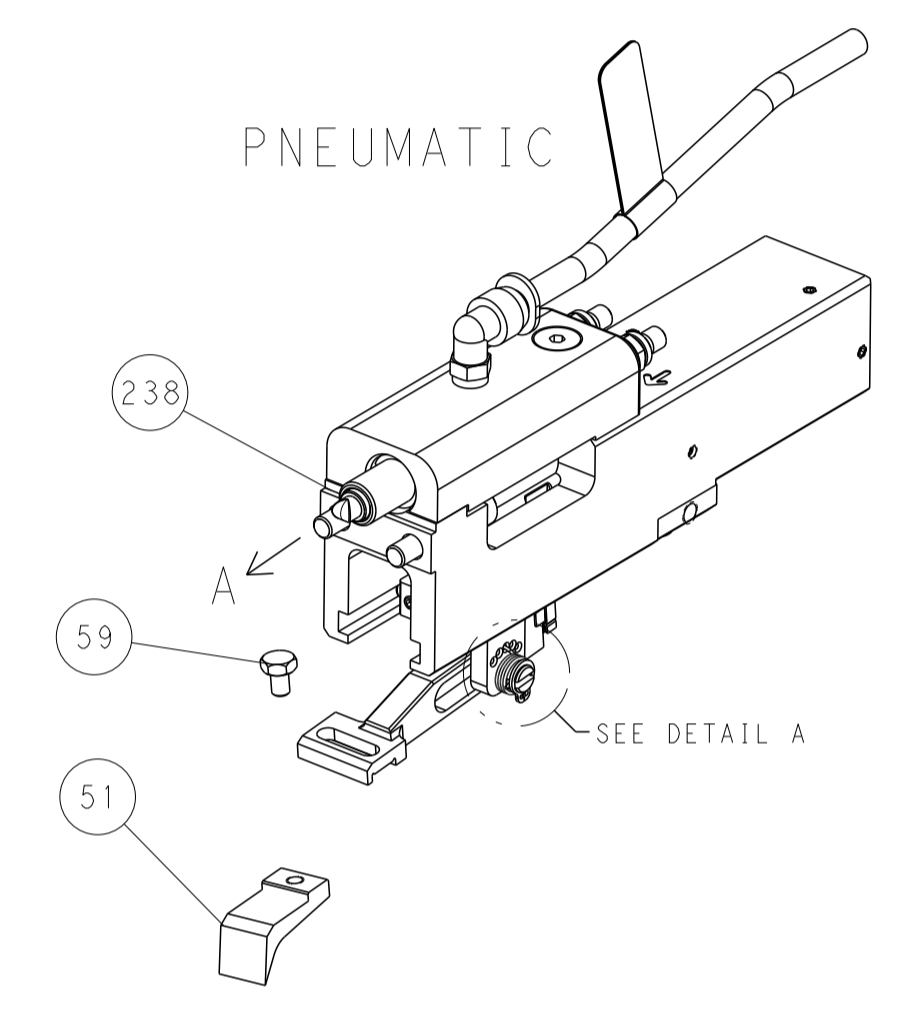
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



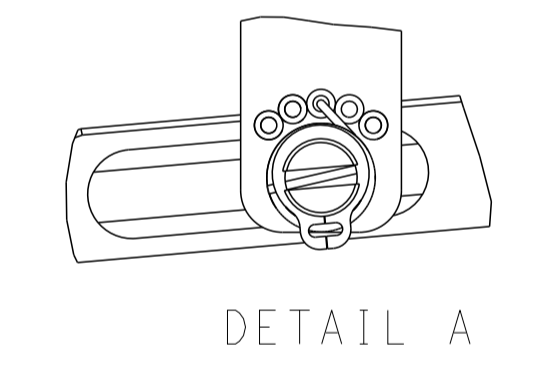
RAM AND HOLDDOWN SET-UP



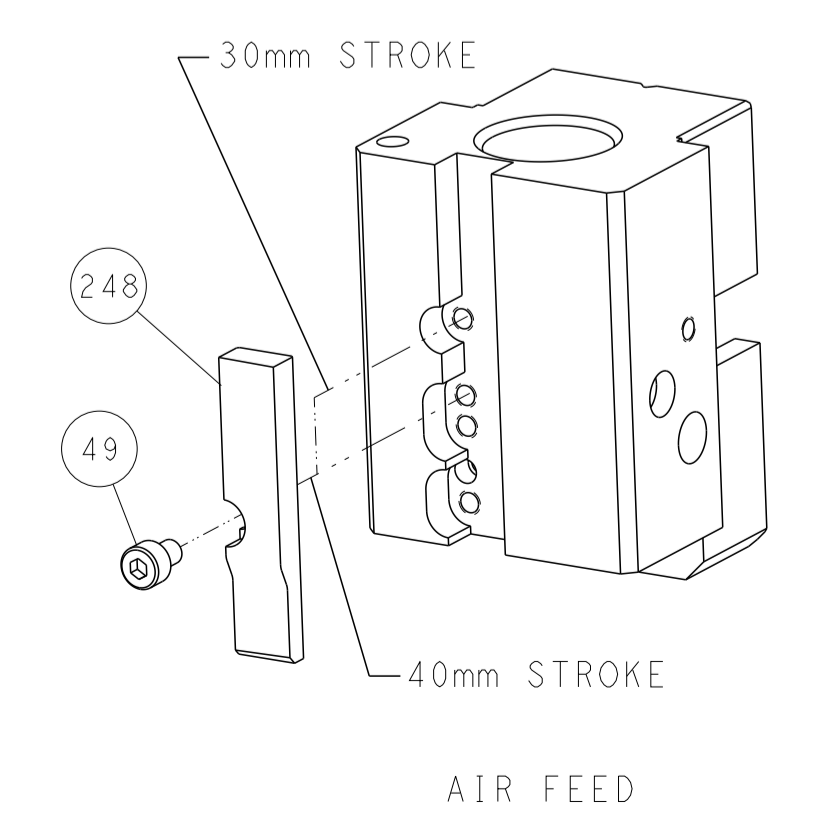
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

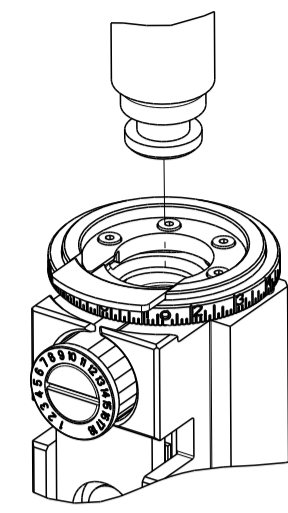


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN J. HOU 12JUN2015 CHK L. ZHANG 12JUN2015 APVD H. GUO 12JUN2015		NAME Ocean End Feed Applier	
MATERIAL:		WEIGHT:		SIZE CAGE CODE DRAWING NO A1 00779 C=2150550		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150550-2	E	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		INSULATION DIAMETER RANGE	
6.02-6.78 mm [.237-.267 IN]		∅5.33-6.73 mm [.210-.265 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
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.
- 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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

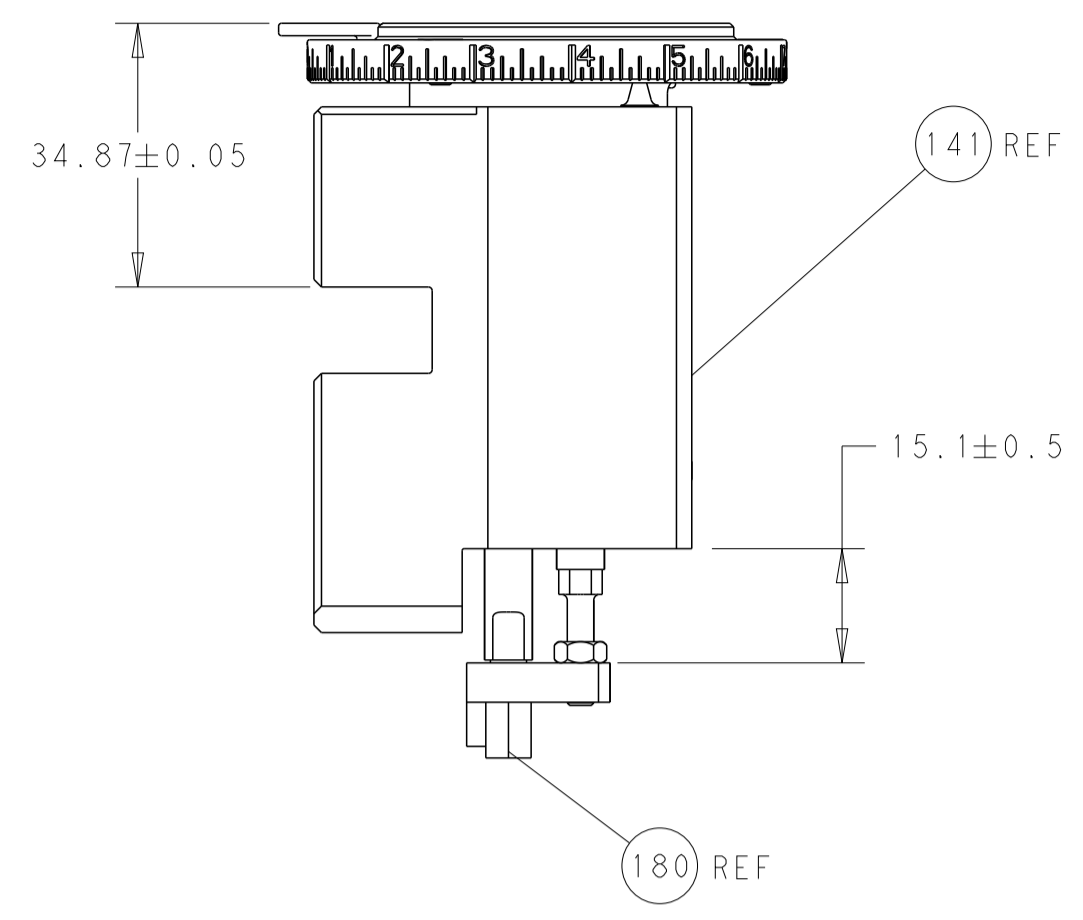
-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1-1752354-4	STANDOFF, HOLD-DOWN	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	
-	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	455888-6	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	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	2063961-9	FEED FINGER	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	1:1	SHEET 3 OF 4
APPLICATOR SPEC		APPLICATION SPEC		CAGE CODE		DRAWING NO		RESTRICTED TO		REV E	
APPLICATOR SPEC		APPLICATION SPEC		CAGE CODE		DRAWING NO		RESTRICTED TO		REV E	



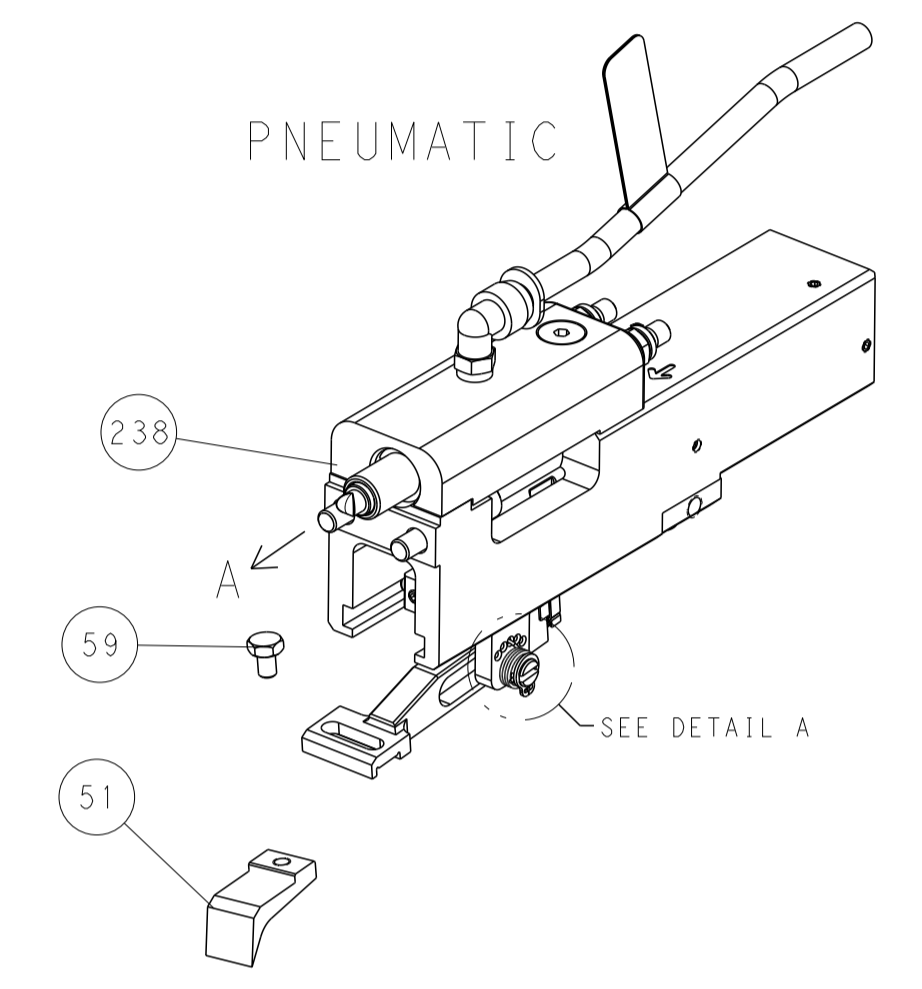
Ocean End Feed
Applicator

LOC		DIST		REVISIONS				
P	LTN	DATE	OWN	APVD	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

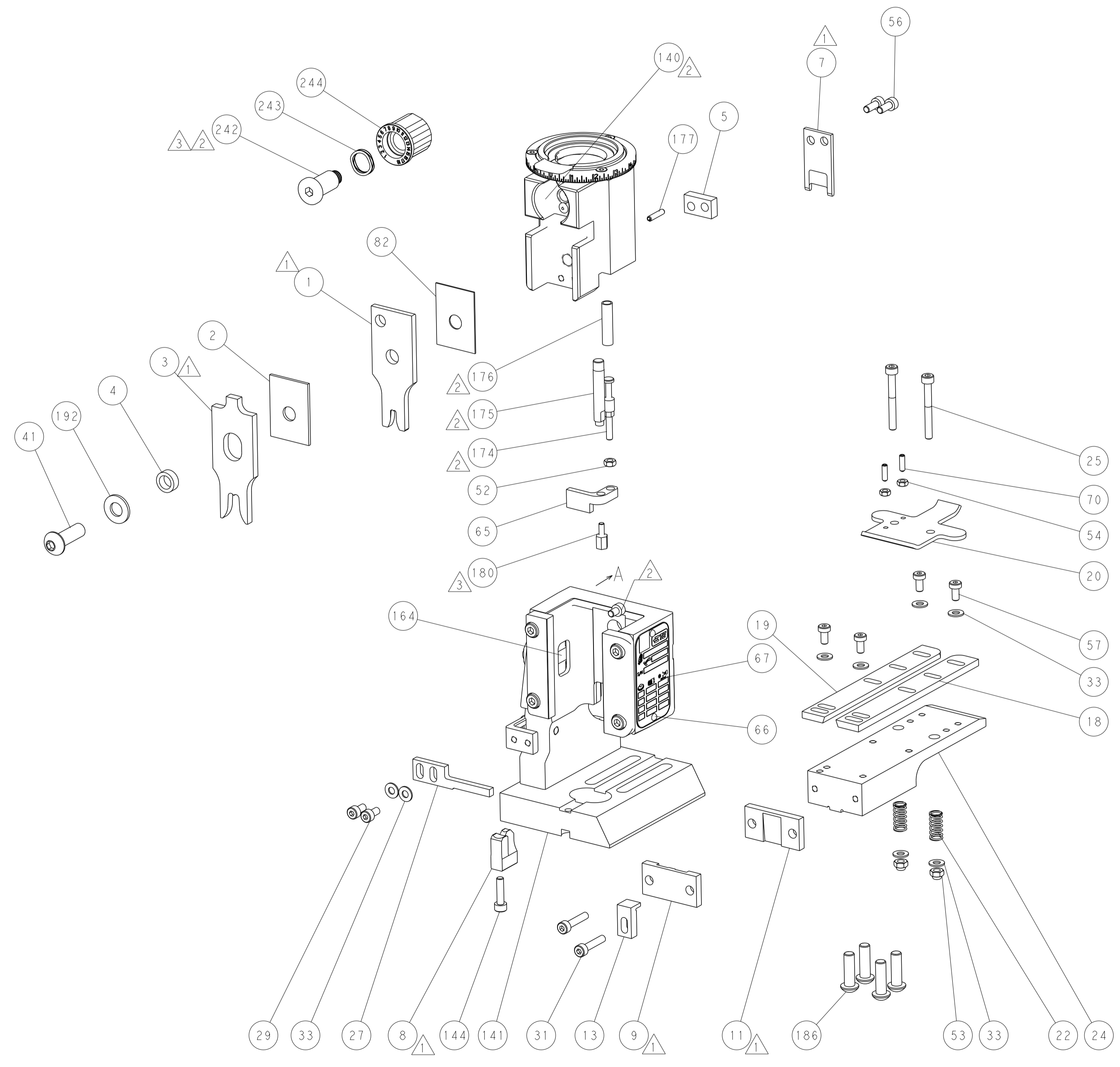
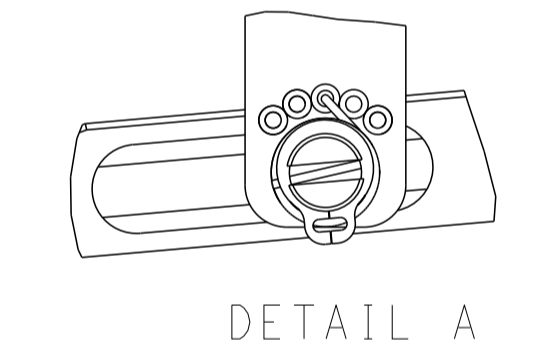


RAM AND HOLDDOWN SET-UP

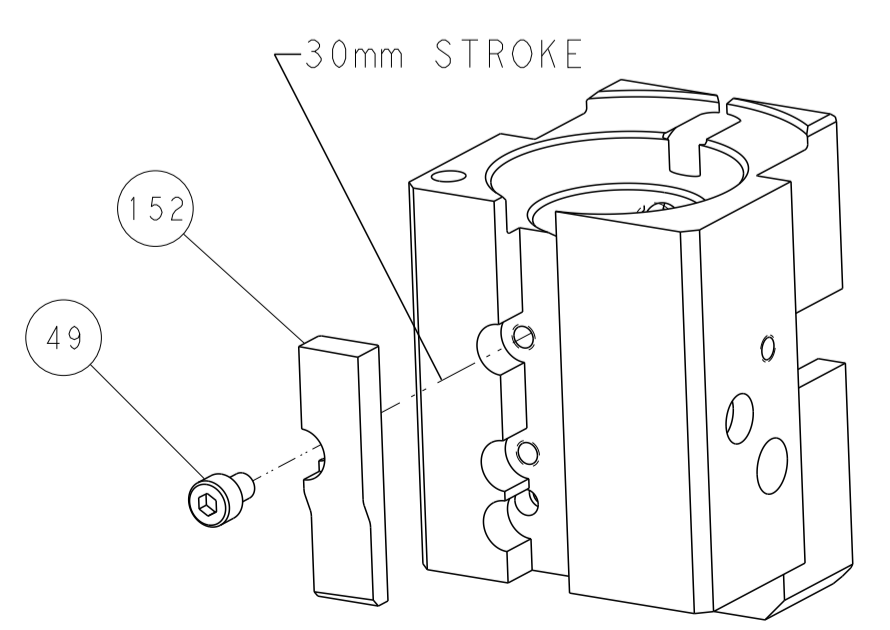
FEED TYPE



FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J. HOU CHK: L. ZHANG APVD: H. GUO	12JUN2015 12JUN2015 12JUN2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applier APPLICATION SPEC: - PRODUCT SPEC: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150550 SCALE: 1:1 SHEET: 4 OF 4 REV: E	RESTRICTED TO: -
AMP 4805 REV 31MAR2000		Customer Accessible Production Drawing		