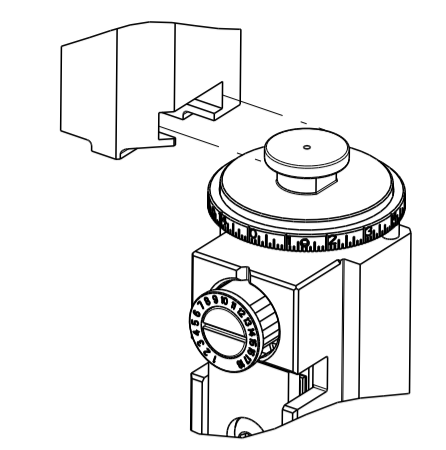


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150945-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150945-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150945-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150945-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150945-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.84 mm [.230]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES REC ECONOSEAL 3 HIGH CURRENT			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
5.00-5.50 mm [.197-.217 IN]	Ø4.10-5.50 mm [.161-.217 IN]		
TERMINAL APPLICATION SPECIFICATION	114-3036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
344009-1			347713-1
			347707-1
			CABLE DIAMETER
			2.6-3.4
			2.2 MIN

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.03+/-0.05 [.080+/-0.002]	7.8
2.50mm2	1.85+/-0.05 [.073+/-0.002]	9.5
2.00mm2	1.70+/-0.05 [.067+/-0.002]	11.1

- △ 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. PLY 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HEAD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.

**\*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.

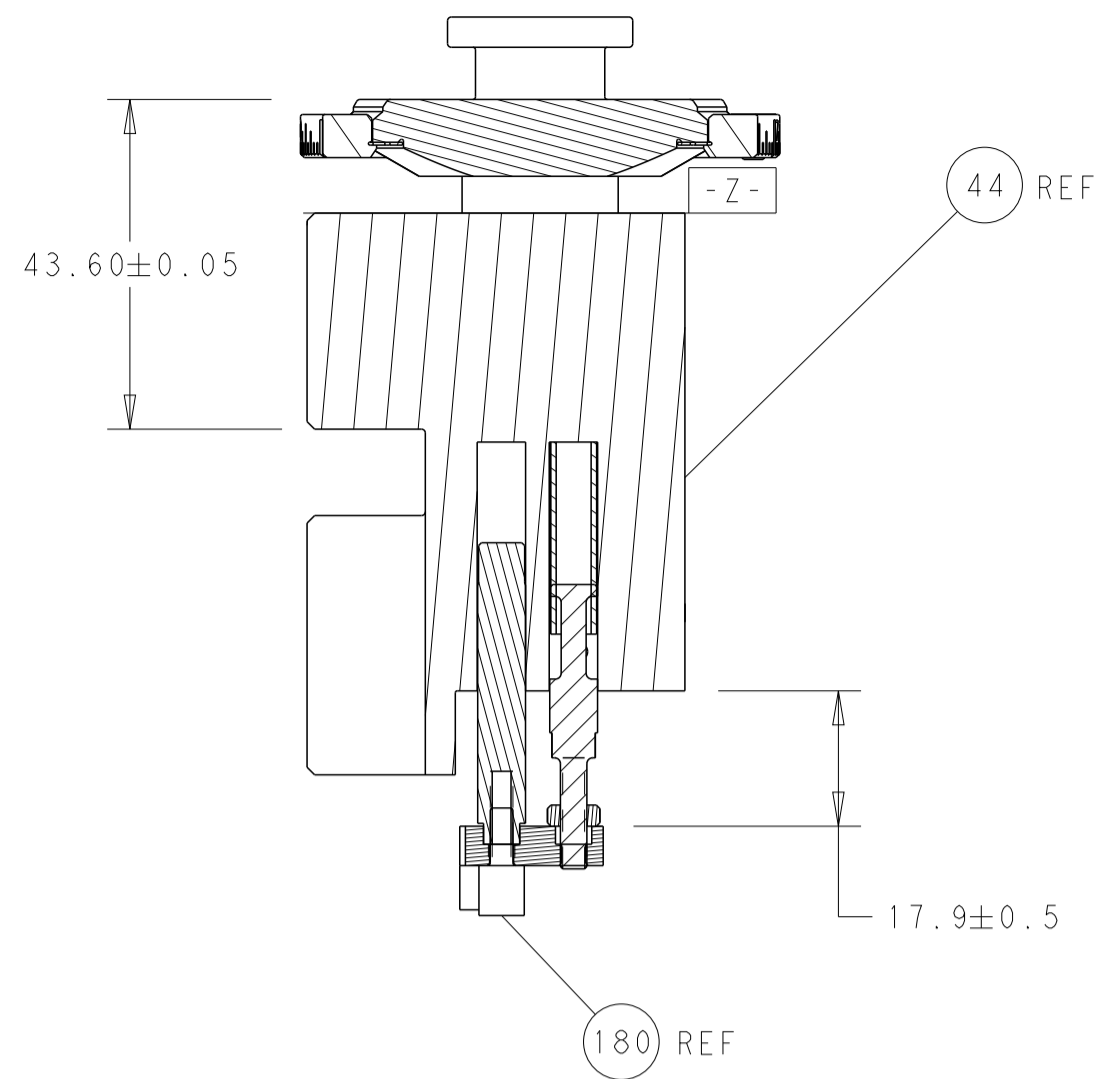
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
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		B		ECR-20-016625	22NOV2020	TB	RK

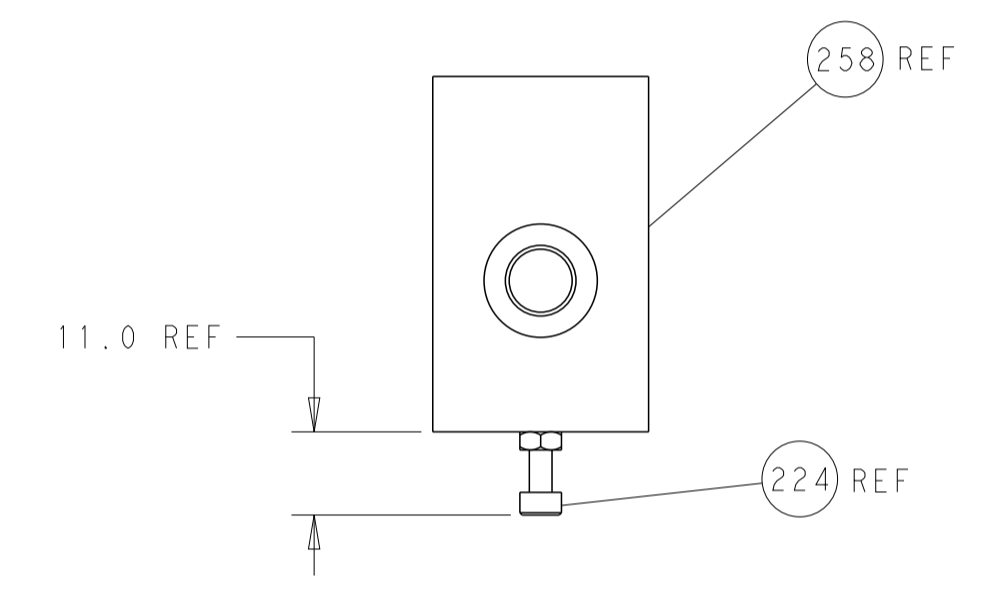
-	1	1	1	1	1803203-3	BLOCK, FRONT DEPRESSOR	258
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
7	-	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	224
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	223
-	1	1	1	1	455888-4	SPACER, CRIMPER	185
3	-	1	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	180
-	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
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-4	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
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	-	1	2063961-1	FEED FINGER	58
-	4	4	4	4	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	-	2063961-1	FEED FINGER	51
-	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
-	8	8	8	8	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	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	1	1	1	1	1803152-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1803151-2	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	-	1	1	1	3-690482-4	PLATE, FRONT SHEAR	9
1	2	2	1	1	1333295-3	ANVIL, COMBINATION, SPECIAL	8
1	-	1	1	1	2217206-5	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-4	SPACER	5
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1-1803018-4	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	2	1	456408-2	CRIMPER, WIRE PREMIUM	1
-	77	7271	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	T. ELBIN
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	1:1
						SHEET	1 OF 4
						REV	B

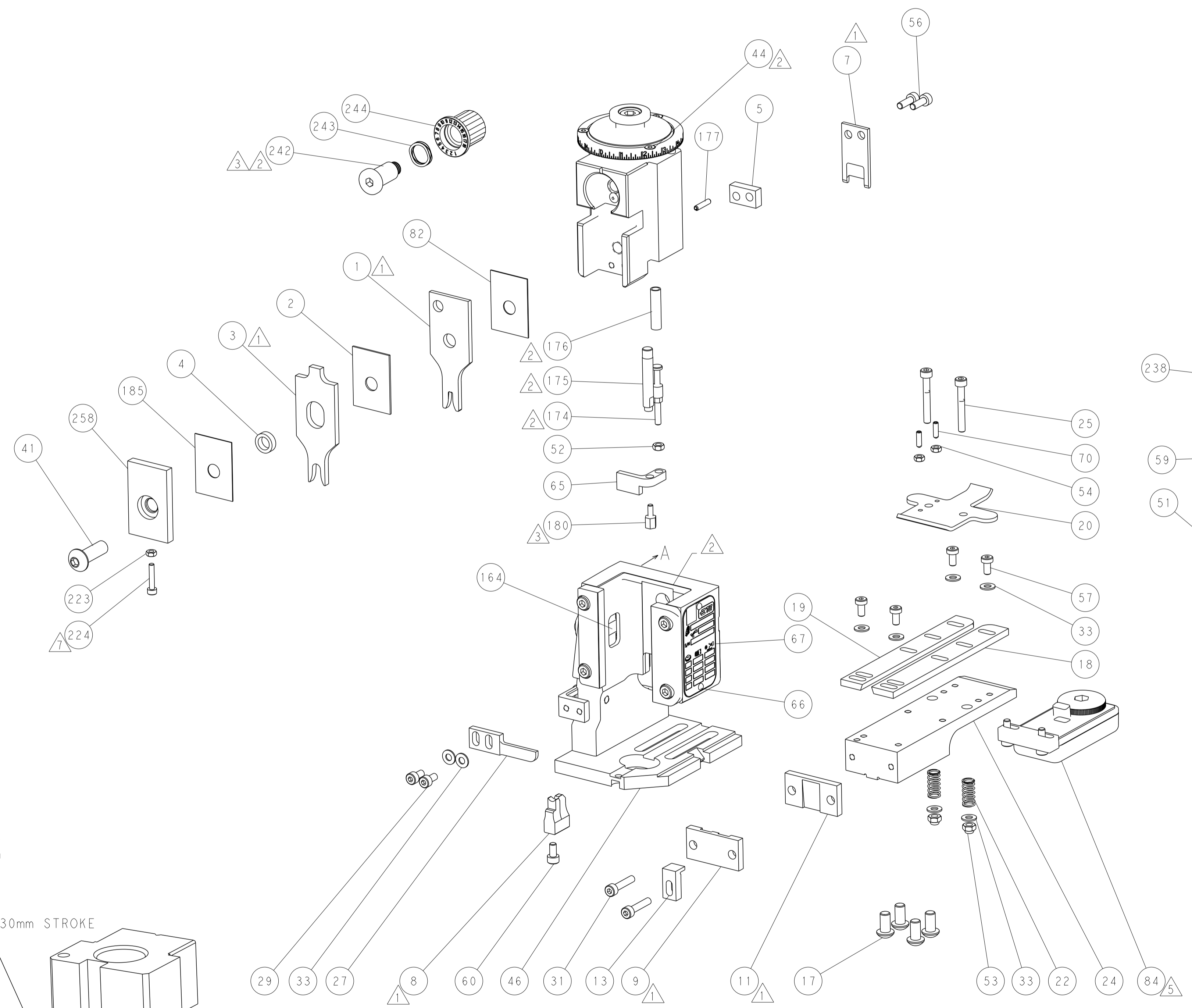
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



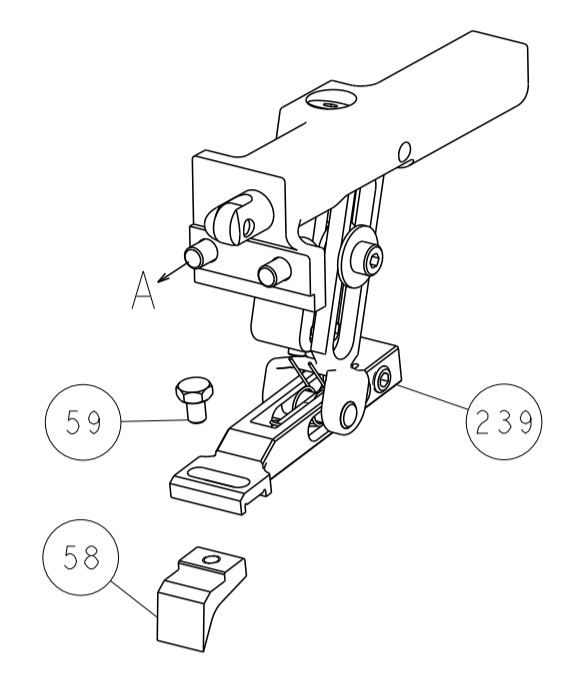
RAM AND HOLDDOWN SET-UP



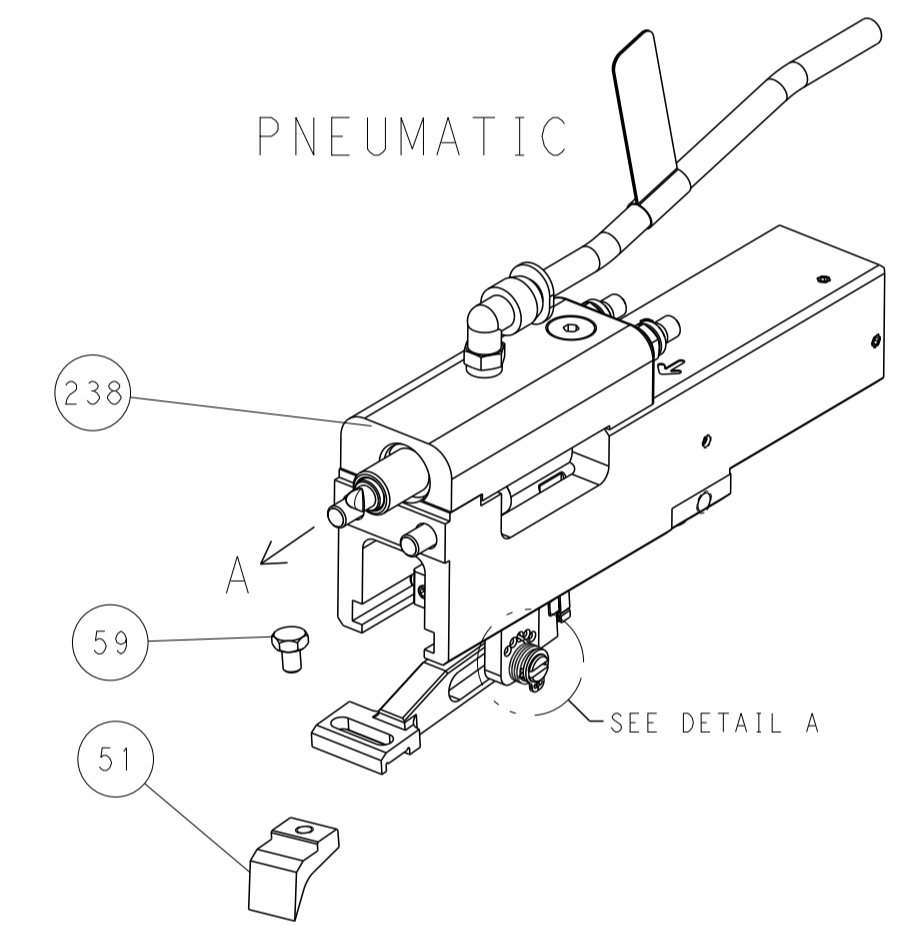
SEAL SCREW SET-UP



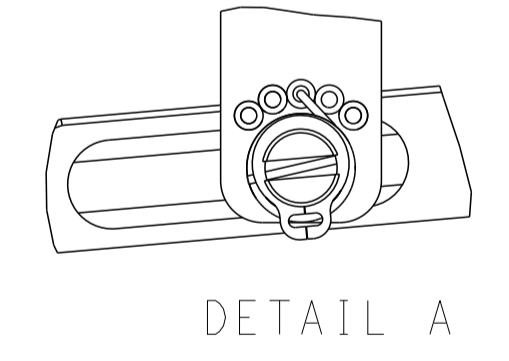
FEED TYPE  
MECHANICAL



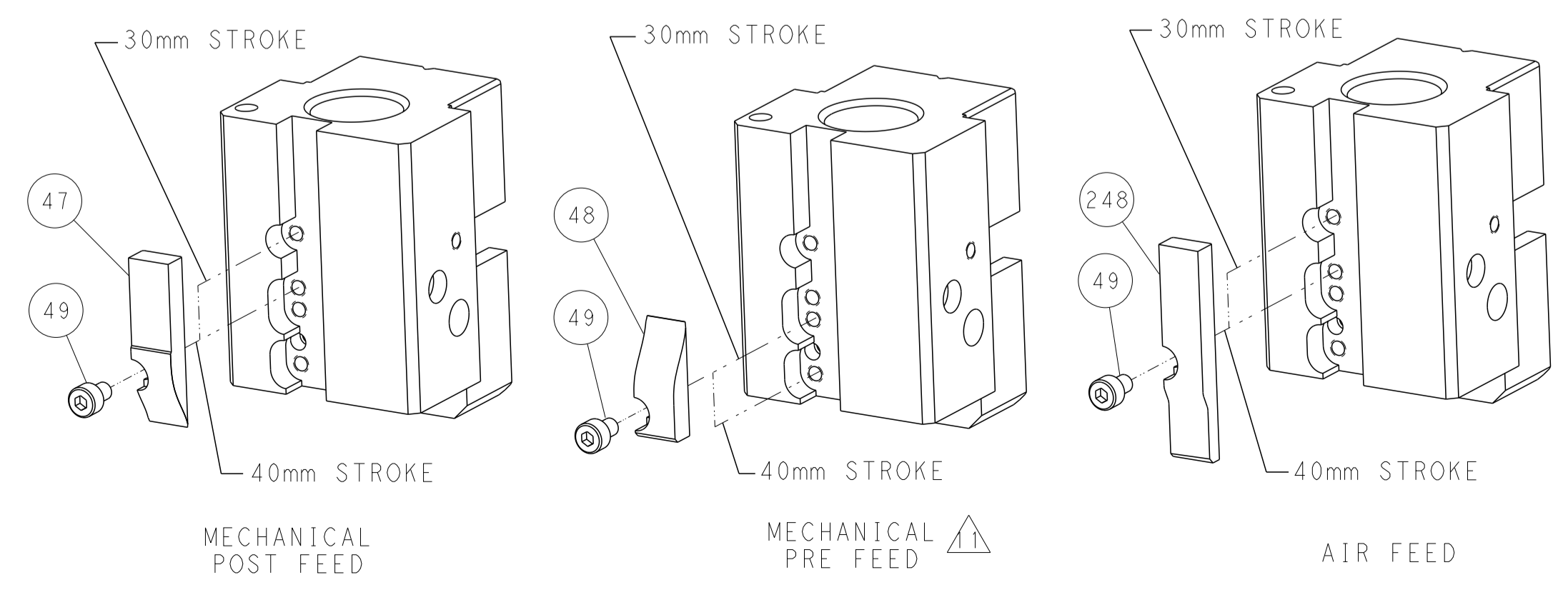
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

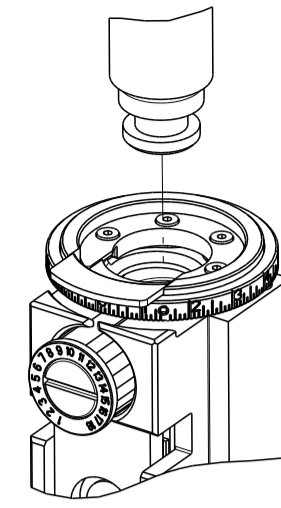


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKENS 07AUG2018 CHK M. HERR 07AUG2018 APVD T. ELBIN 07AUG2018 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		TE Connectivity Harrisburg, PA 17105-3608 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150945 RESTRICTED TO SHEET 2 OF 4 REV B	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150945-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150945-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150945-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER

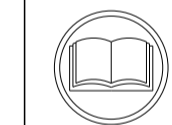


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	5.84 mm [2.30]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES REC ECONOSEAL 3 HIGH CURRENT			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.00-5.50 mm [1.97-.217 IN]		4.10-5.50 mm [1.61-.217 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3036		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
344009-1			347713-1	2.6-3.4
			347707-1	2.2 MIN

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.03 +/- 0.05 [1.080 +/- .002]	7.8
2.50mm2	1.85 +/- 0.05 [1.073 +/- .002]	9.5
2.00mm2	1.70 +/- 0.05 [1.067 +/- .002]	11.1



- 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. PLY 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HEAD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.

**\*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.

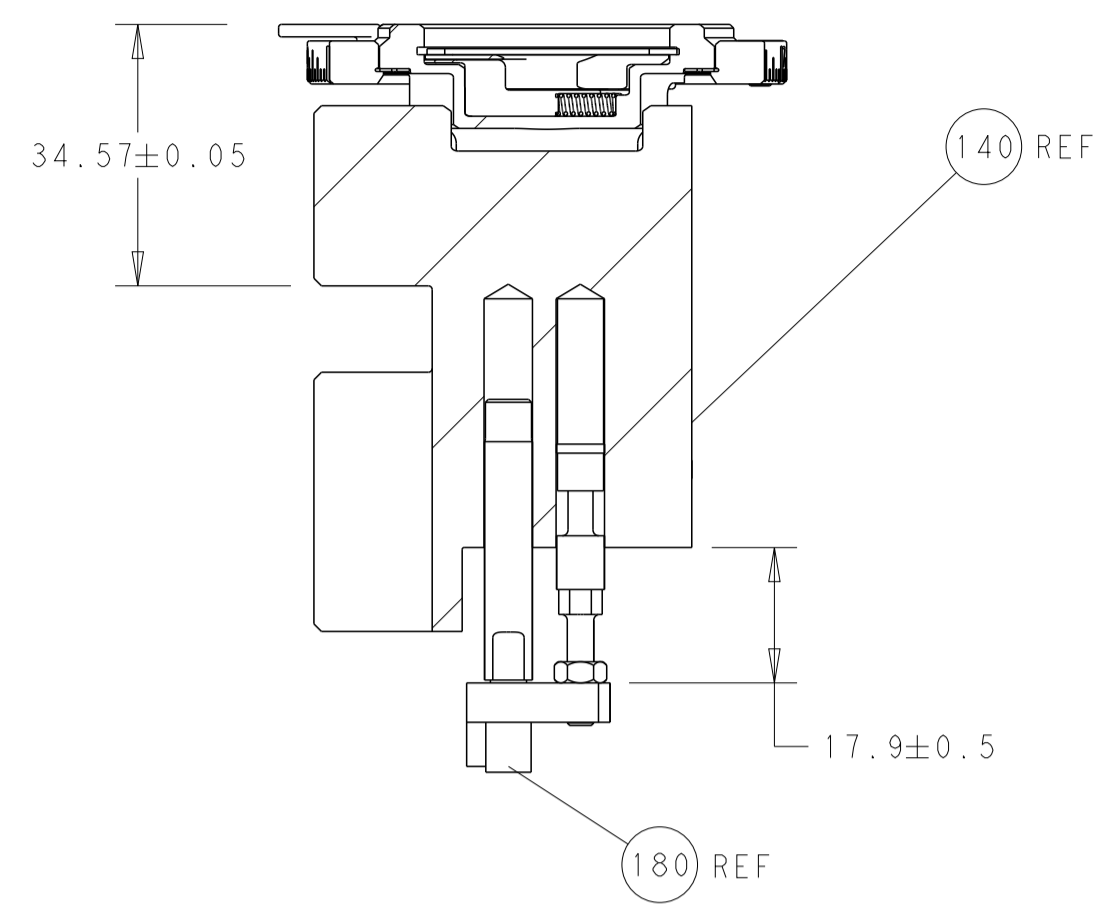
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	1803203-3	BLOCK, FRONT DEPRESSOR	258
-	1	1	2119082-3	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
7	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	224
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	223
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	455888-4	SPACER, CRIMPER	185
3	1	1	1-1752354-1	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
5	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	FEED FINGER	51
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	1803152-2	STRIP GUIDE, REAR	19
-	1	1	1803151-2	STRIP GUIDE, FRONT	18
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	3-690482-4	PLATE, FRONT SHEAR	9
1	1	1	1333295-3	ANVIL, COMBINATION, SPECIAL	8
1	1	1	2217206-5	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-240641-4	SPACER	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803018-4	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	456408-2	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO

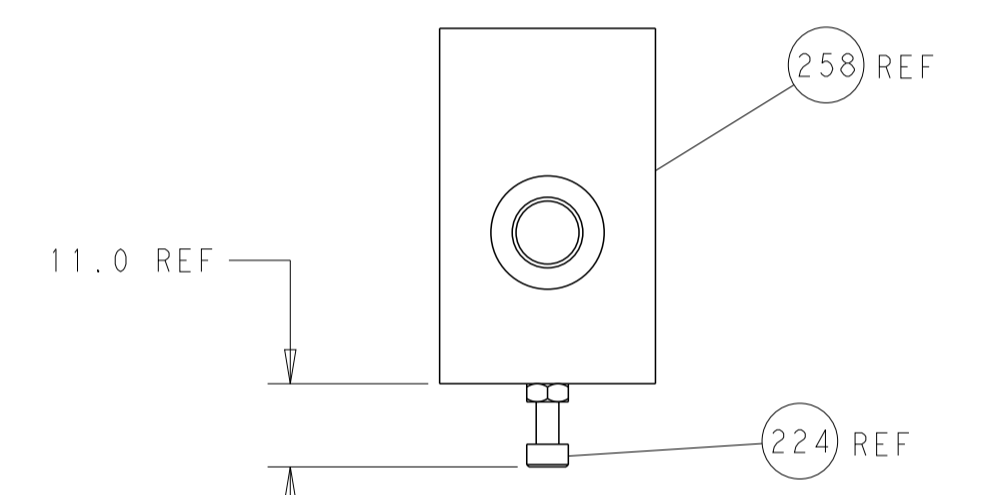
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 07AUG2018		CHK M. HERR 07AUG2018		APVD T. ELBIN 07AUG2018		NAME	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
ANGLES		FINISH		WEIGHT		SCALE		SHEET 3 OF 4		REV B	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET 3 OF 4		REV B	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4		REV B		Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV B	

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

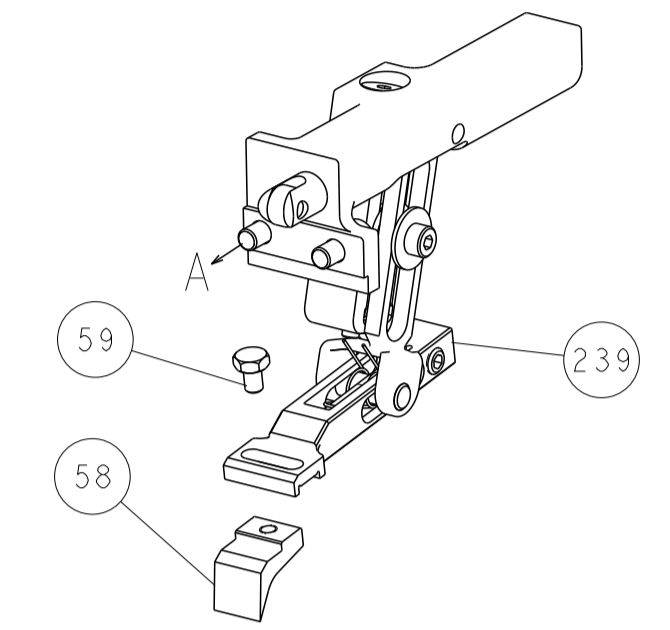


RAM AND HOLDDOWN SET-UP

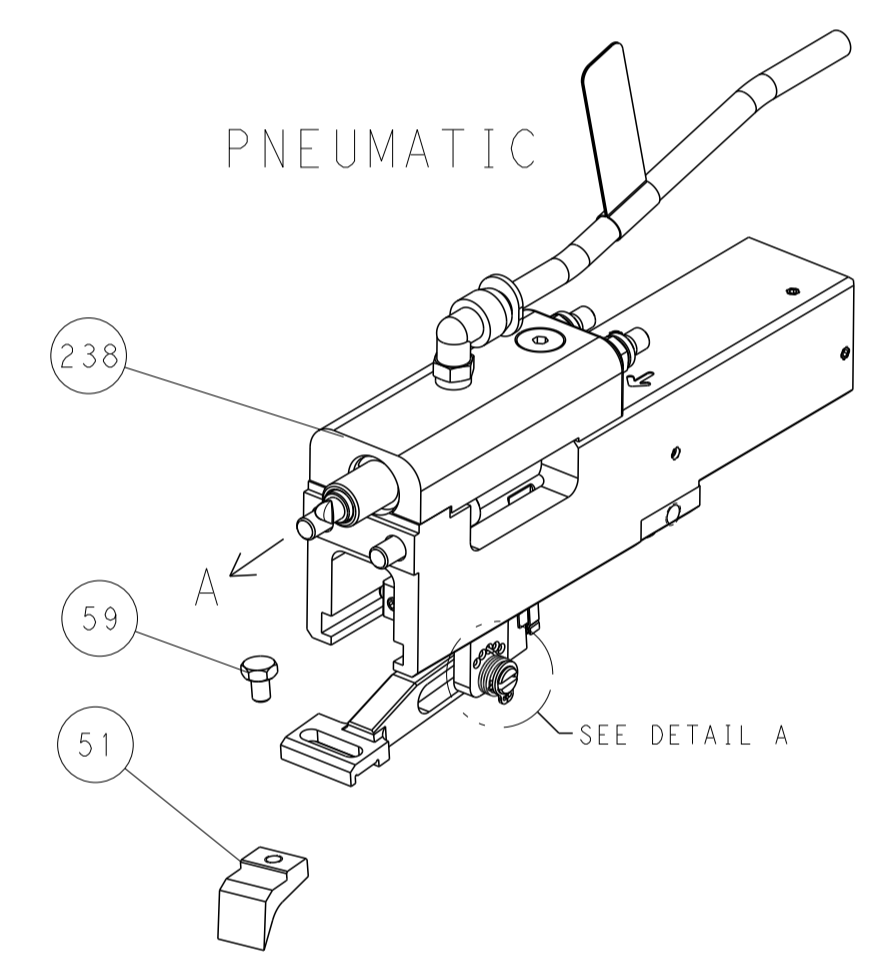


SEAL SCREW SET-UP

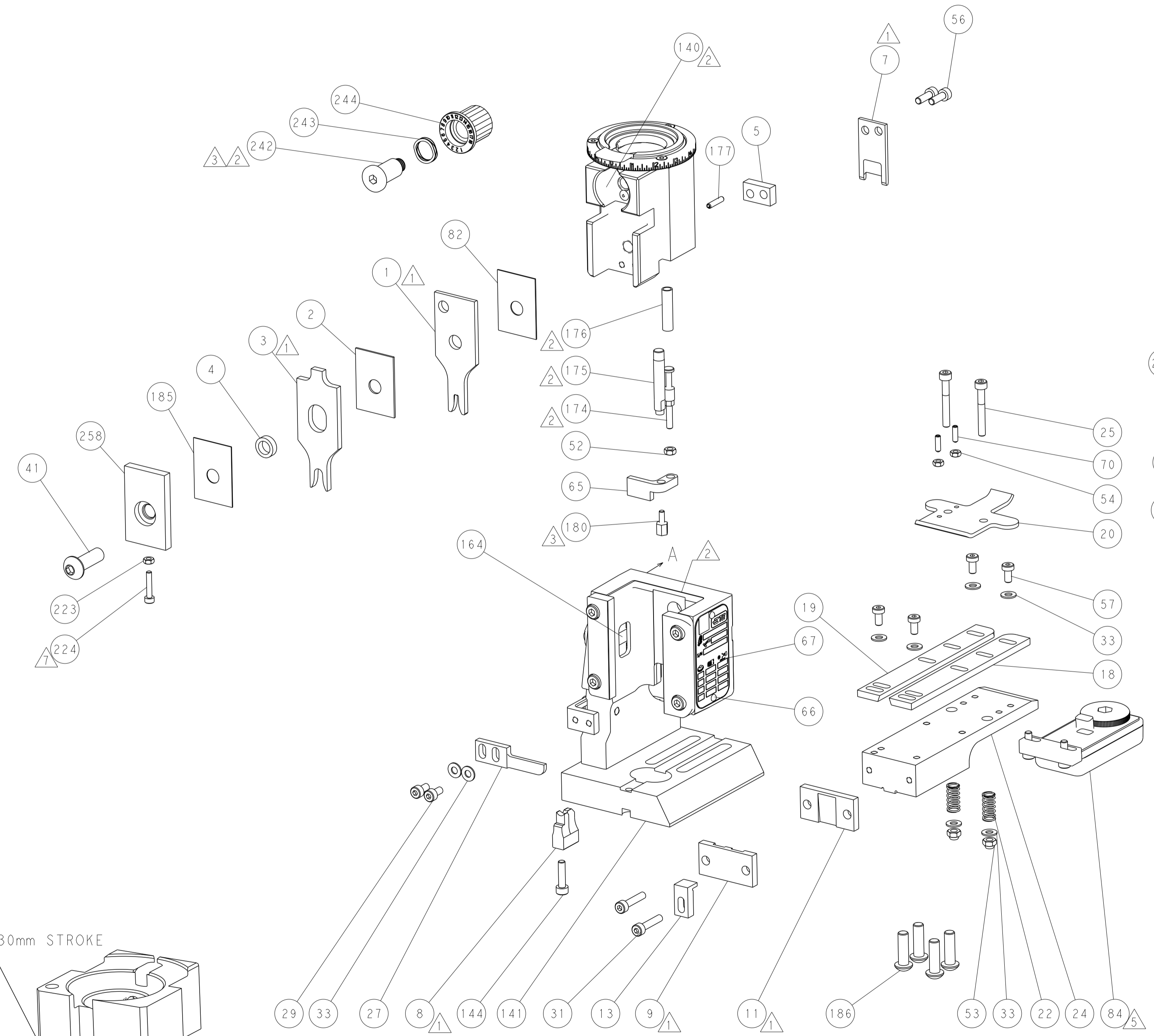
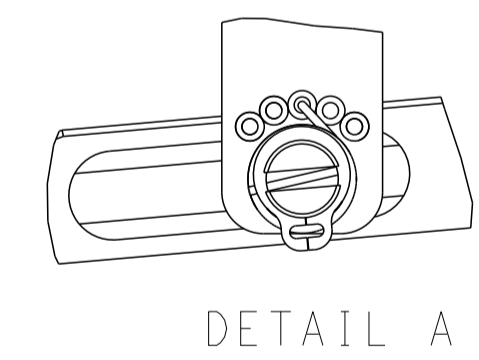
FEED TYPE  
MECHANICAL



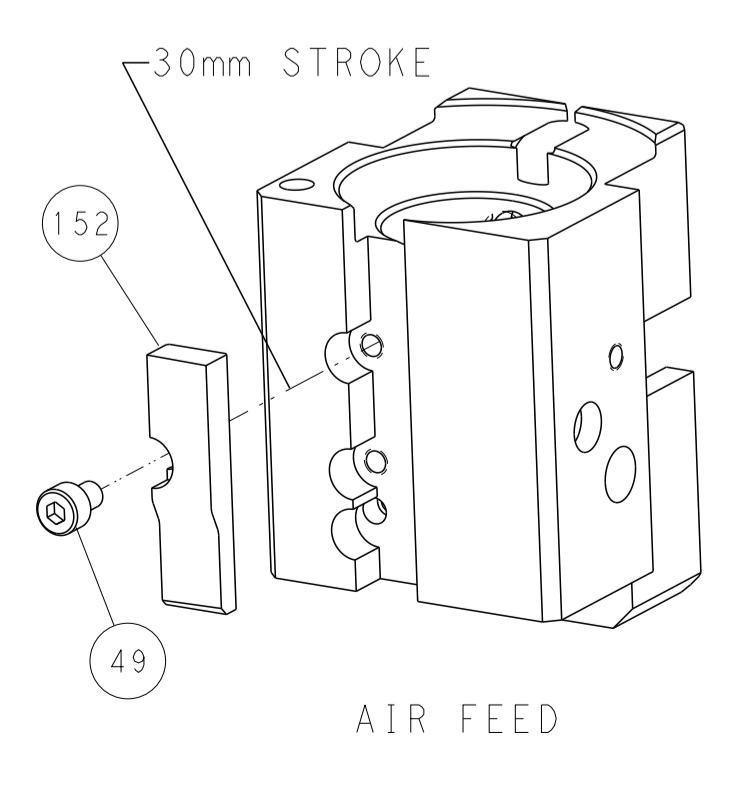
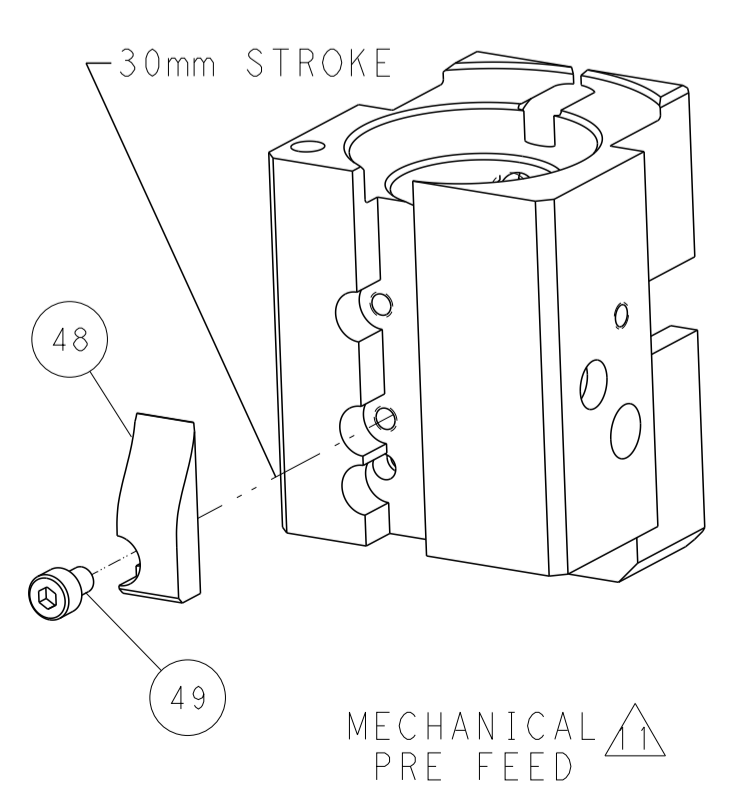
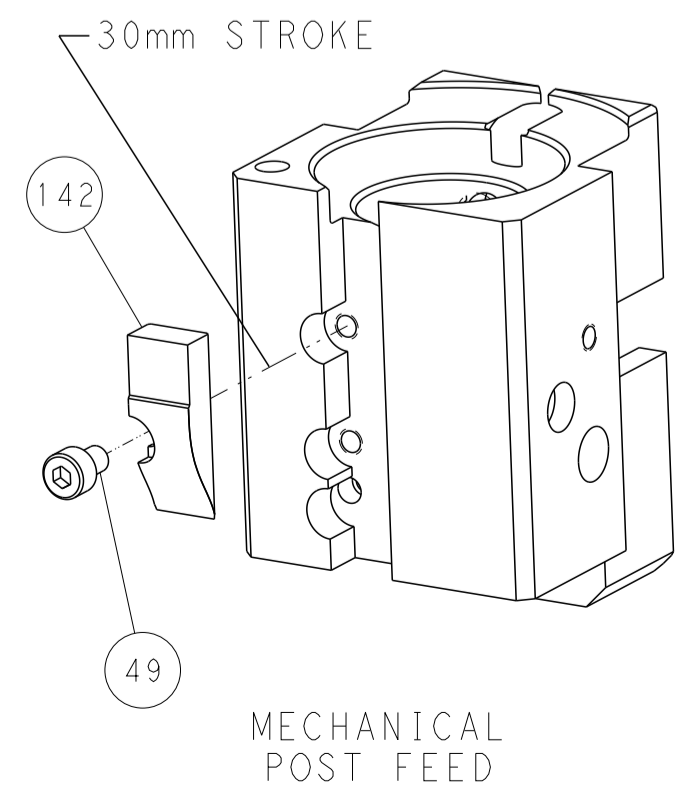
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 07AUG2018		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD M. HERR 07AUG2018	NAME
	ANGLES ±	FINISH ±				T. ELBIN 07AUG2018	PRODUCT SPEC
MATERIAL							APPLICATION SPEC
							SIZE CAGE CODE DRAWING NO
							RESTRICTED TO
							Customer Accessible Production Drawing
							SCALE 1:1 SHEET 4 OF 4 REV B