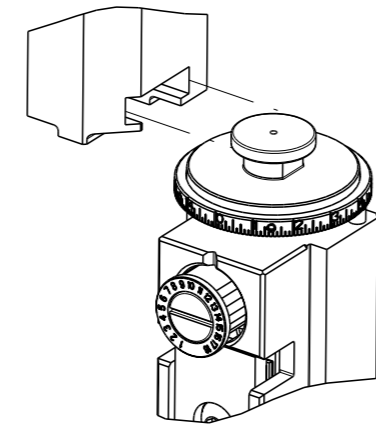


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150003-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150003-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150003-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.00-6.80 mm [.236-.268 IN]		Ø.32-3.05 mm [.120-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-2036 (B)114-35000	(D)114-5084	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 63537-1	(A) 63537-2	(A) 41202-1	(A) 41274-1
(A) 41274-2	(A) 41274-3	(A) 63655-1	(A) 153377-1
(A) 153377-2	(A) 1217917-2	(A) 63993-1	(B) 61107-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø3.05-4.30 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20023		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 100570-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.91+/-0.05 [.075+/- .002]	3.6
16 AWG OR 1.25mm2	1.68+/-0.05 [.066+/- .002]	6.0
18 AWG OR 0.75mm2	1.55+/-0.05 [.061+/- .002]	7.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.5 mm2	2.03+/-0.03 [.080+/- .001]	2.6
2.0 mm2	1.95+/-0.03 [.077+/- .001]	3.2
1.5 mm2	1.85+/-0.03 [.073+/- .001]	4.0
1.0 mm2	1.67+/-0.03 [.066+/- .001]	6.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

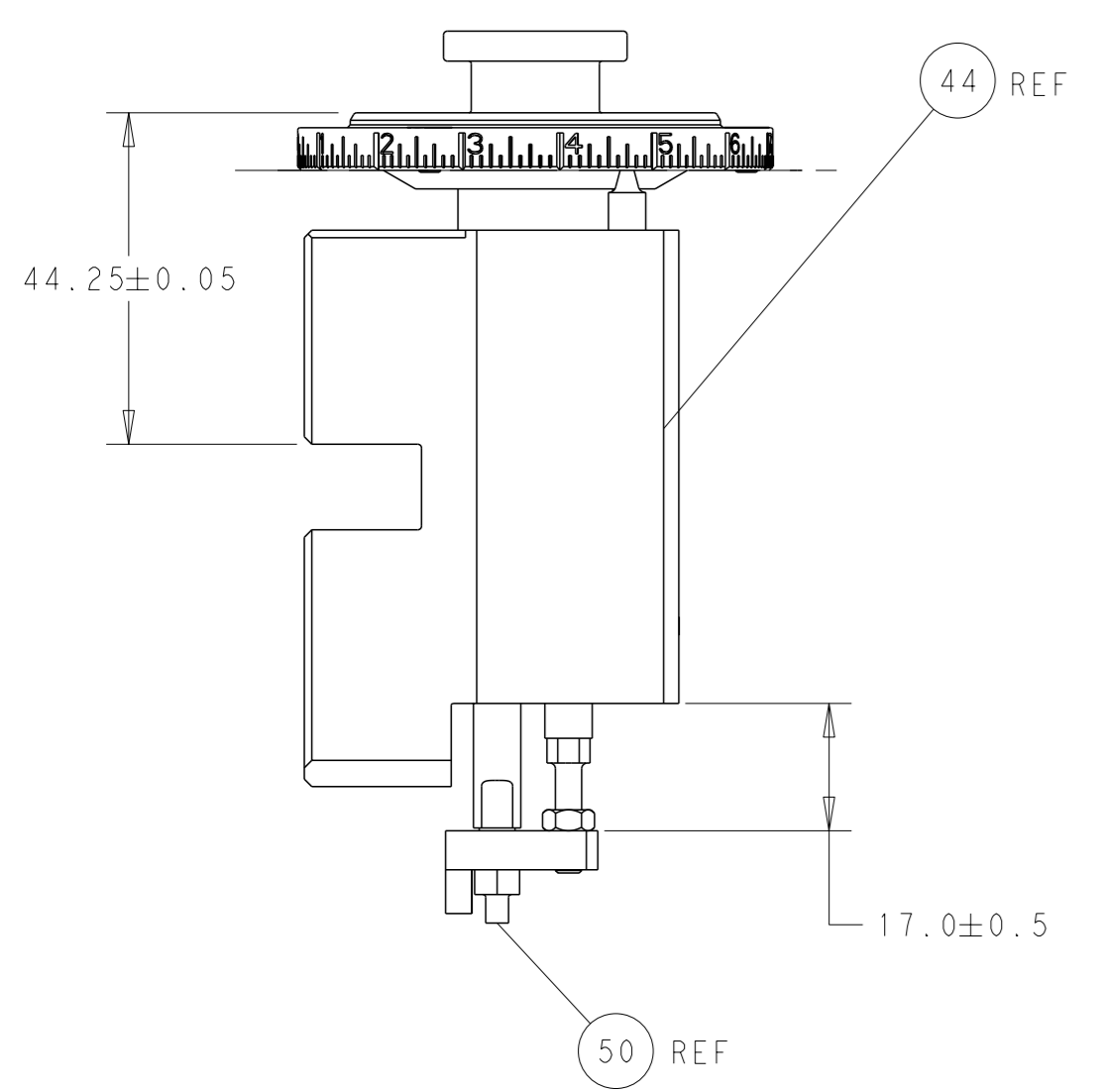
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		D		ECR-17-012763	31AUG2017	KH	TE
		E		ECR-18-012849	13AUG2018	JAH	CT
		F		ECR-18-014025	04SEP2018	TB	CT
		G		ECR-19-008437	24MAY2019	LG	TE

-	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	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	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	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	1901681-5	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	2063961-1	FEED FINGER	51	
-	1	1	1-1976055-3	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	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	6-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690495-6	PLATE, FRONT SHEAR	9	
-	1	2	1	1338673-2	ANVIL, COMBINATION	8
-	1	1	1	5-690474-3	BLADE, SLUG	7
-	1	1	1	3-240641-0	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1	3-456409-6	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

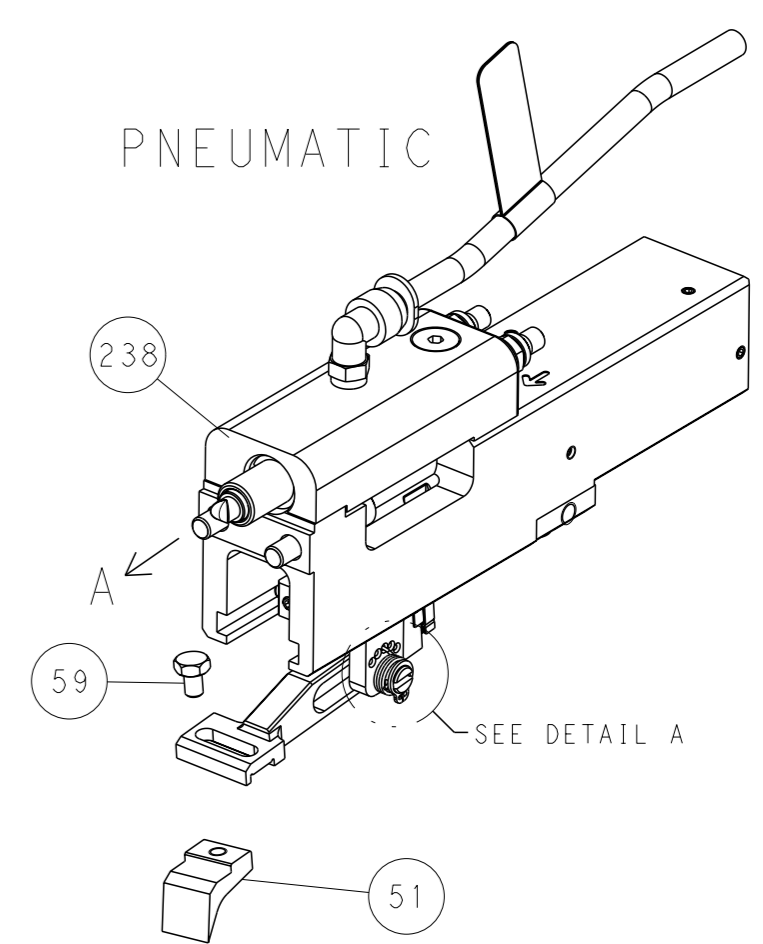
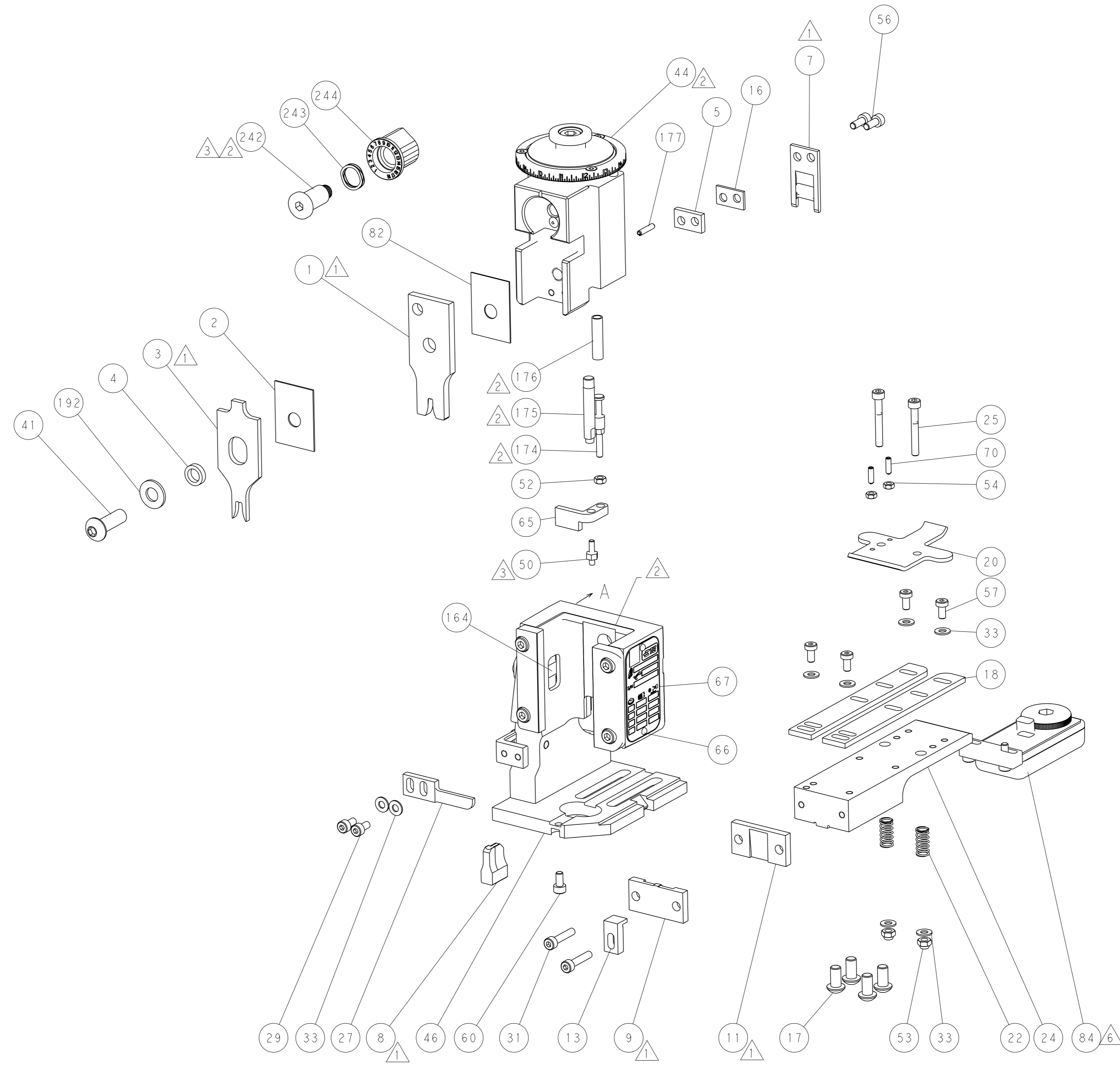
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	FINISH	FINISH	FINISH	FINISH	FINISH	APVD	NAME
MATERIAL	FINISH	FINISH	FINISH	FINISH	FINISH	APVD	NAME
Customer Accessible Production Drawing		SCALE	1:1	SHEET	1	OF	4
REV		G		REV		G	

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

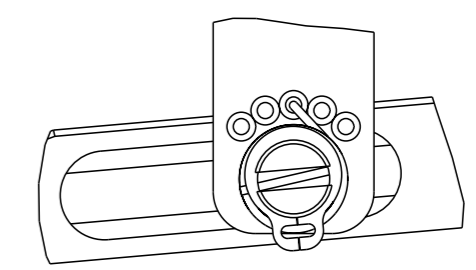


RAM AND HOLDDOWN SET-UP

FEED TYPE

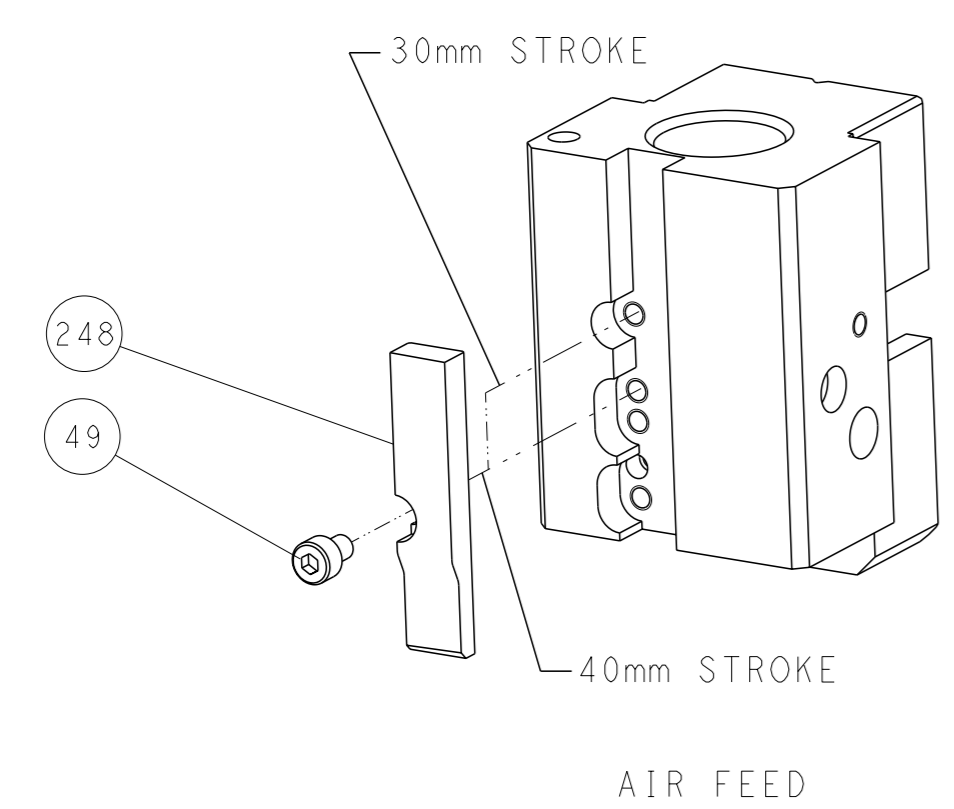


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



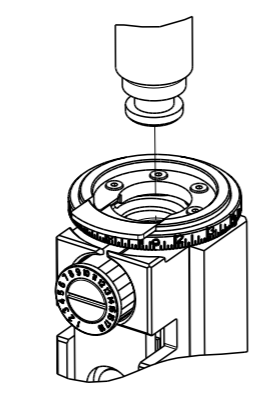
AIR FEED

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS AND EXTENTING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN C.CHEN 05JUL2012 CHK S.XI 05JUL2012 APVD J.CRUZ 05JUL2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2150003 WEIGHT - Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV G

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150003-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150003-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.00-6.80 mm [.236-.268 IN]		Ø4.32-3.05 mm [.170-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-2036 (B)114-35000	(D)114-5084	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 63537-1	(A) 63537-2	(A) 41202-1	(A) 41274-1
(A) 41274-2	(A) 41274-3	(A) 63655-1	(A) 153377-1
(A) 153377-2	(A) 1217917-2	(A) 63993-1	(B) 61107-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø3.05-4.30 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20023		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 100570-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.91+/-0.05 [.075+/- .002]	3.6
16 AWG OR 1.25mm2	1.68+/-0.05 [.066+/- .002]	6.0
18 AWG OR 0.75mm2	1.55+/-0.05 [.061+/- .002]	7.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.5 mm2	2.03+/-0.03 [.080+/- .001]	2.6
2.0 mm2	1.95+/-0.03 [.077+/- .001]	3.2
1.5 mm2	1.85+/-0.03 [.073+/- .001]	4.0
1.0 mm2	1.67+/-0.03 [.066+/- .001]	6.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

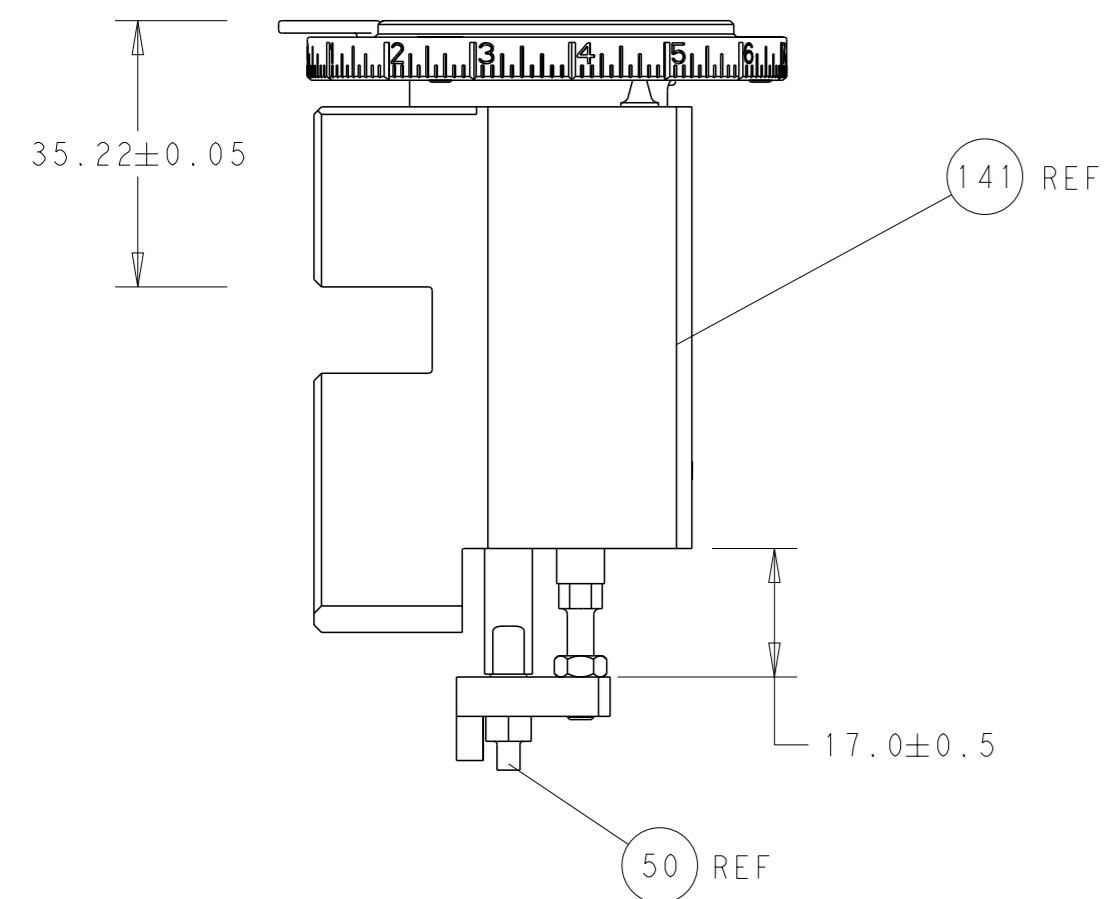
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

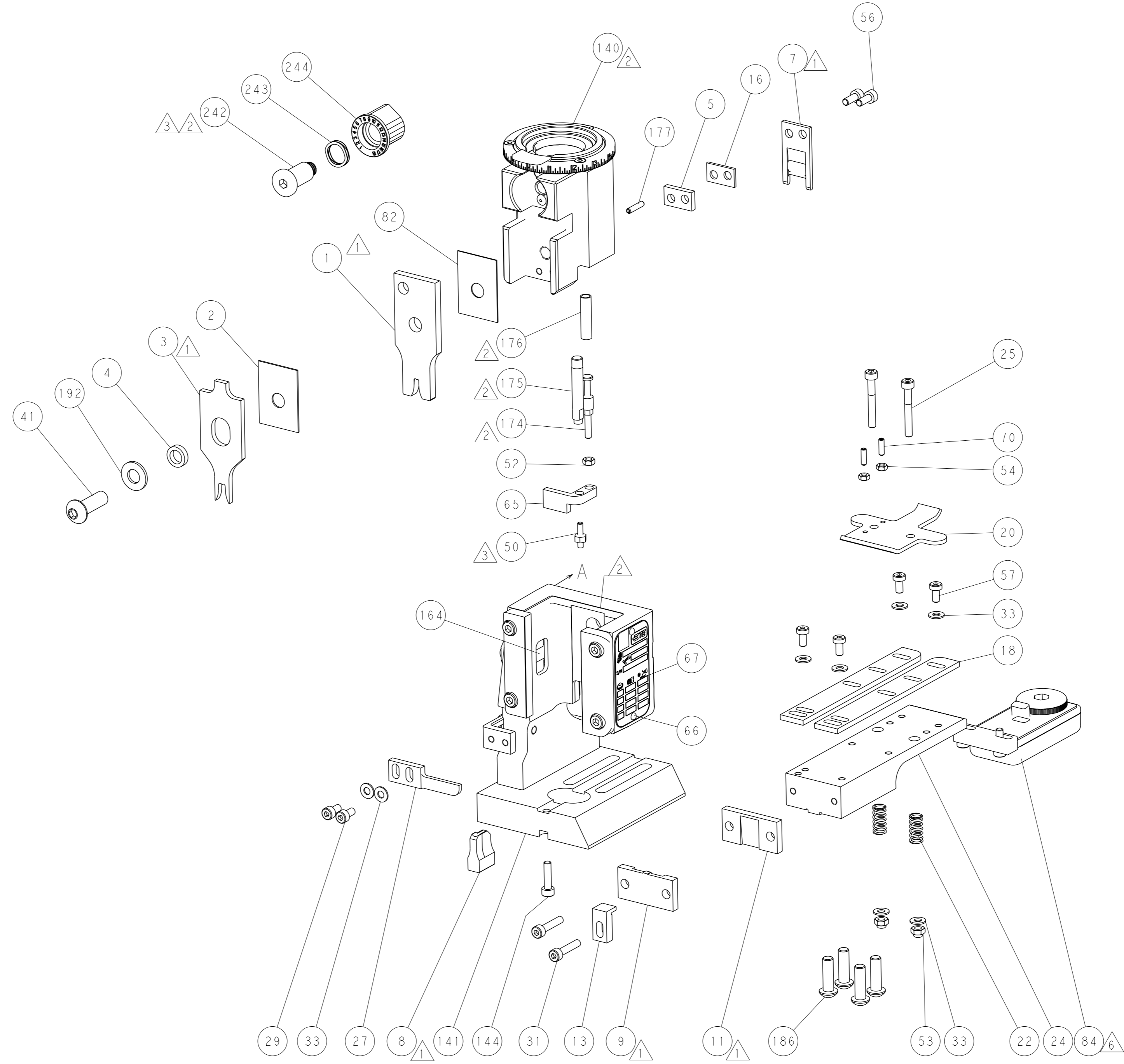
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-3	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	6-993111-6	PIN, SLOTTED SPRING 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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	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	1901681-5	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	2063961-1	FEED FINGER	51
-	1	1-1976055-3	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	6-240641-4	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690495-6	PLATE, FRONT SHEAR	9
-	1	1338673-2	ANVIL, COMBINATION	8
-	1	5-690474-3	BLADE, SLUG	7
-	1	3-240641-0	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
-	1	3-456409-6	CRIMPER, WIRE .120 "F" PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVALS:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SCALE	SHEET 3 OF 4
	ANGLES	FINISH		WEIGHT		SCALE	SHEET 3 OF 4

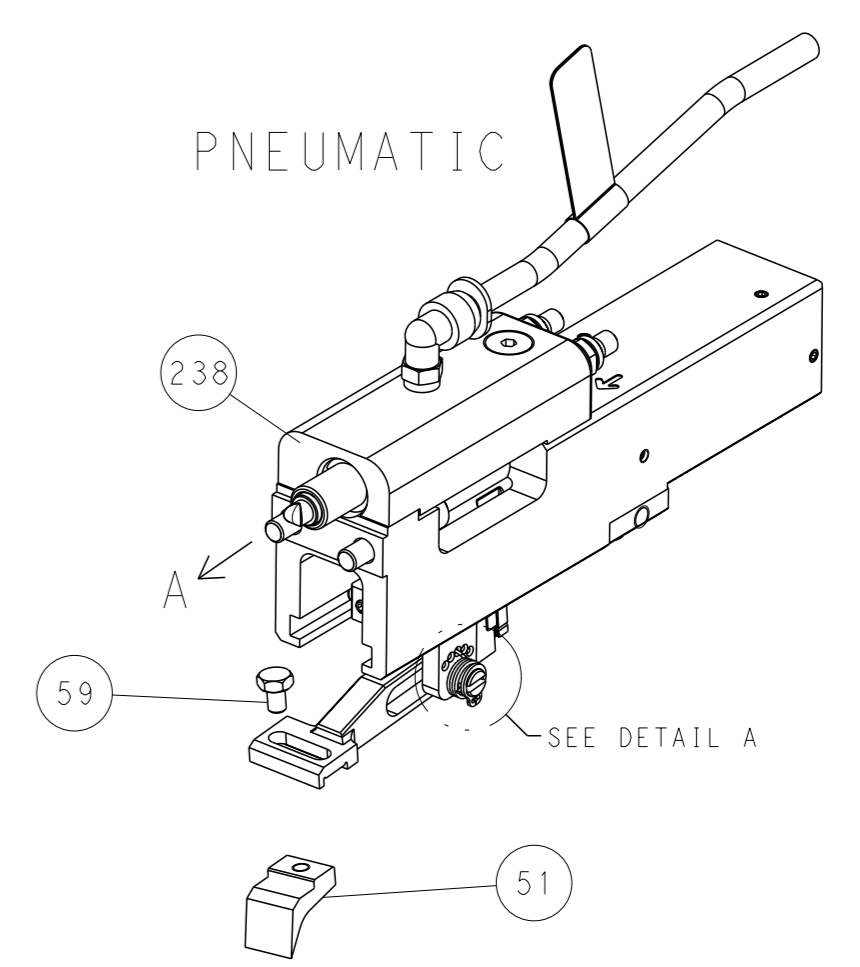
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-



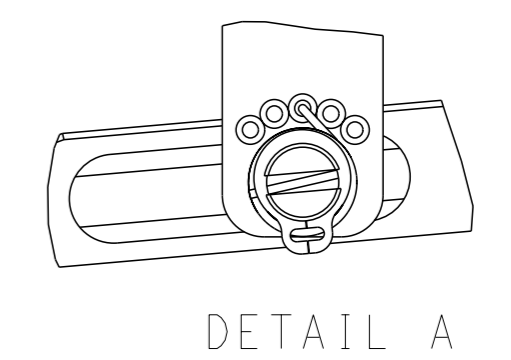
RAM AND HOLDDOWN SET-UP



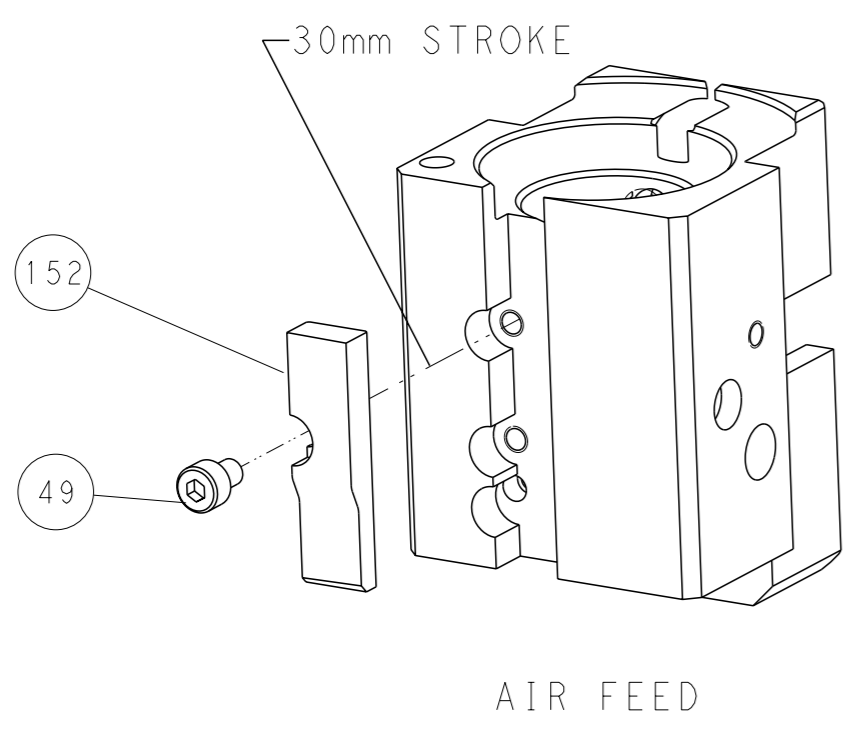
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: C. CHEN 05JUL2012 CHK: S. XI 05JUL2012 APVD: J. CRUZ 05JUL2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150003	RESTRICTED TO: - SCALE: 1:1 SHEET: 4 of 4 REV: G
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION