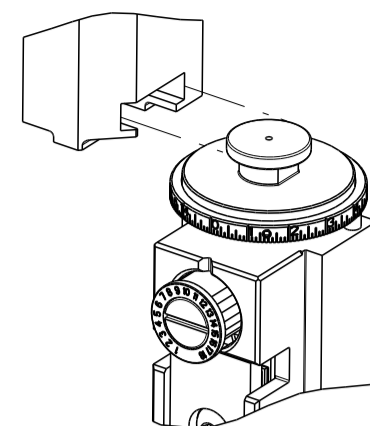


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150163-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150163-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150163-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	5.84 mm [.230]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES TAB ECONOSEAL 3 HC			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.00-5.50 mm [.197-.217 IN]		∅ 1.50-2.40mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3036		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
344069-1			347707-1	1.6-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [.071+/-0.002]	7.0
1.00mm2	1.60+/-0.05 [.063+/-0.002]	9.6
0.75mm2	1.50+/-0.05 [.059+/-0.002]	10.5
0.50mm2	1.37+/-0.05 [.054+/-0.002]	11.9



- 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.

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

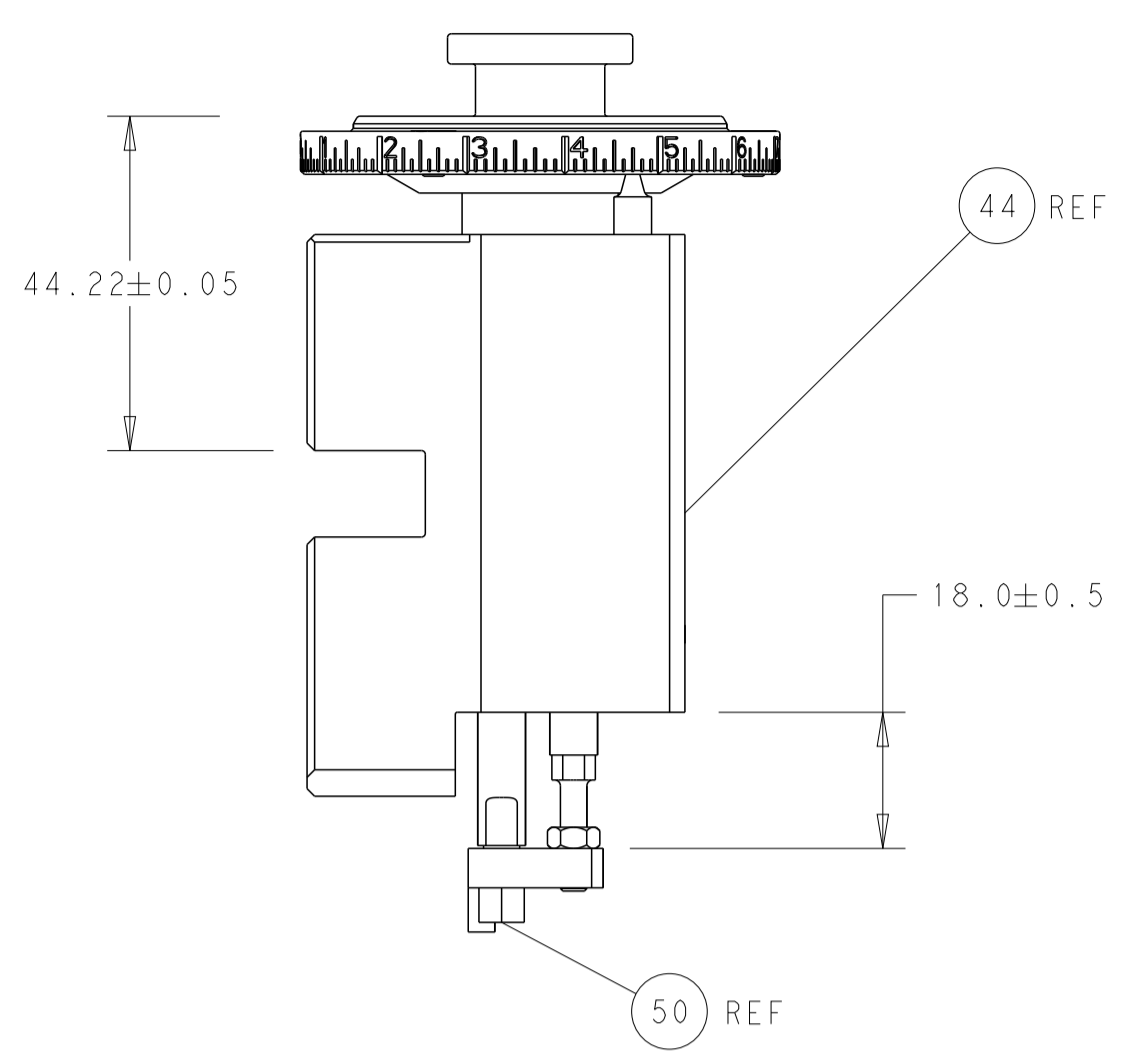
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		A		RELEASED	14JUN2012	CC	SX
		B		ECR-19-015226	28SEP2019	TB	TE

-	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	2844940-4	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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	2119943-1	WASHER, SPACER	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1901681-9	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
-	1	1	1752354-3	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1803292-1	DRAG	20
-	2	2	1-1901259-0	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1-240641-0	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2-240645-4	SPACER, SHEAR PLATE	10
-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	2	1	1333295-2	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1-240651-9	BLADE, SLUG	7
-	1	1	6-240641-8	SPACER	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1-1803018-4	CRIMPER, INSULATION O	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	5-456405-0	CRIMPER, WIRE PREMIUM	1
-	77	-72	-2	PART NO	
				DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		FINISH		WEIGHT	
				RESTRICTED CUSTOMER	

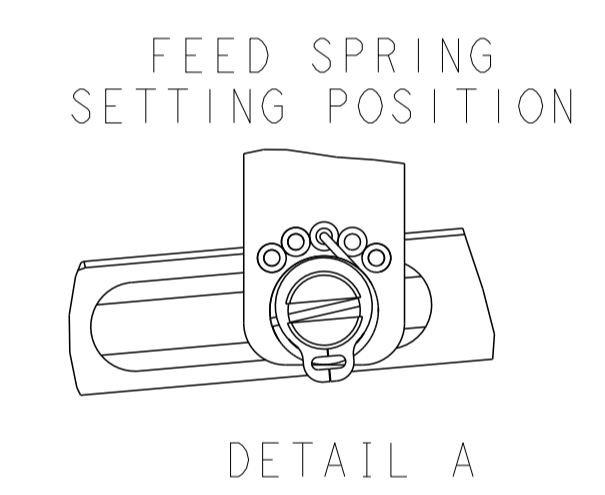
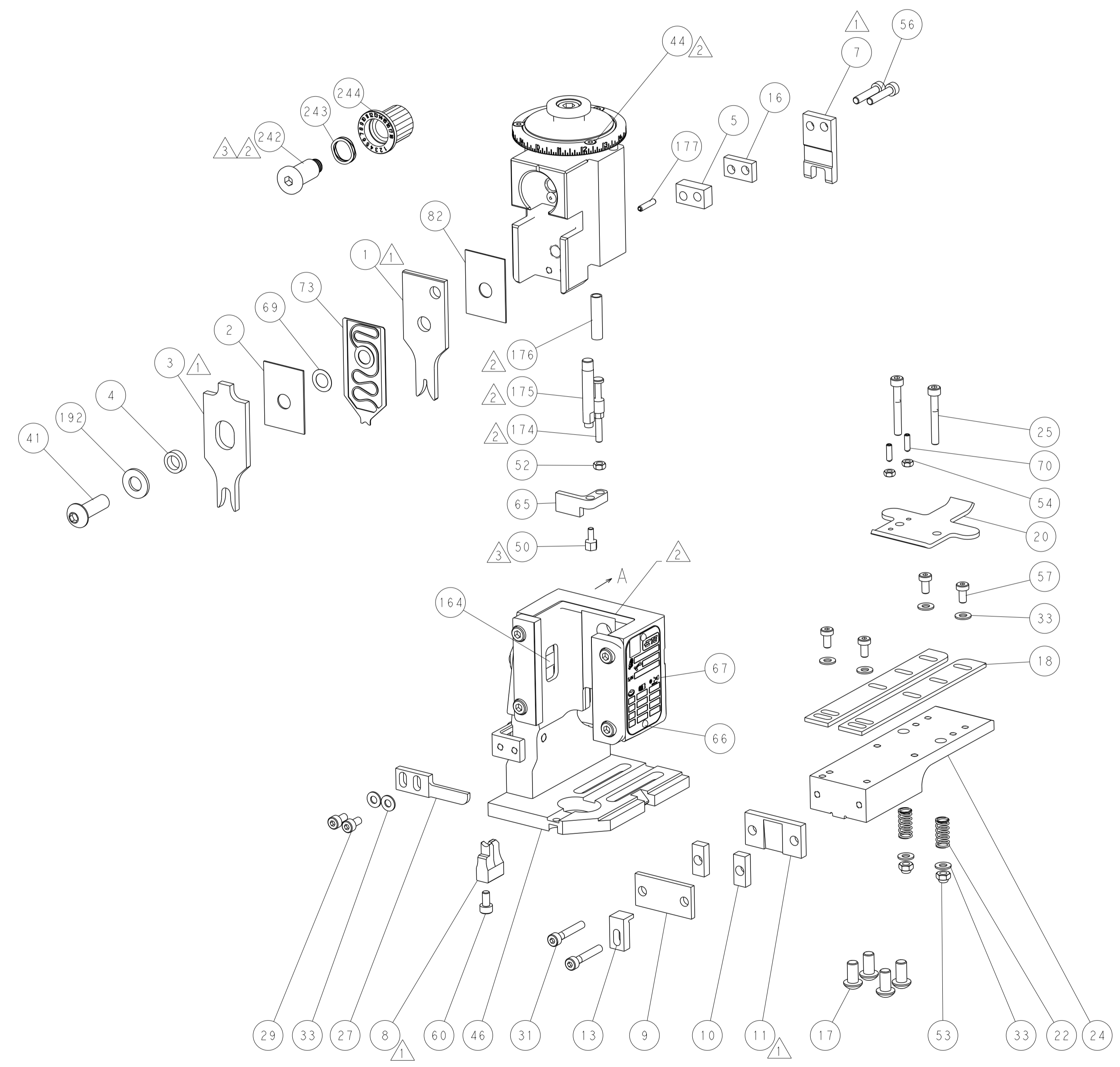
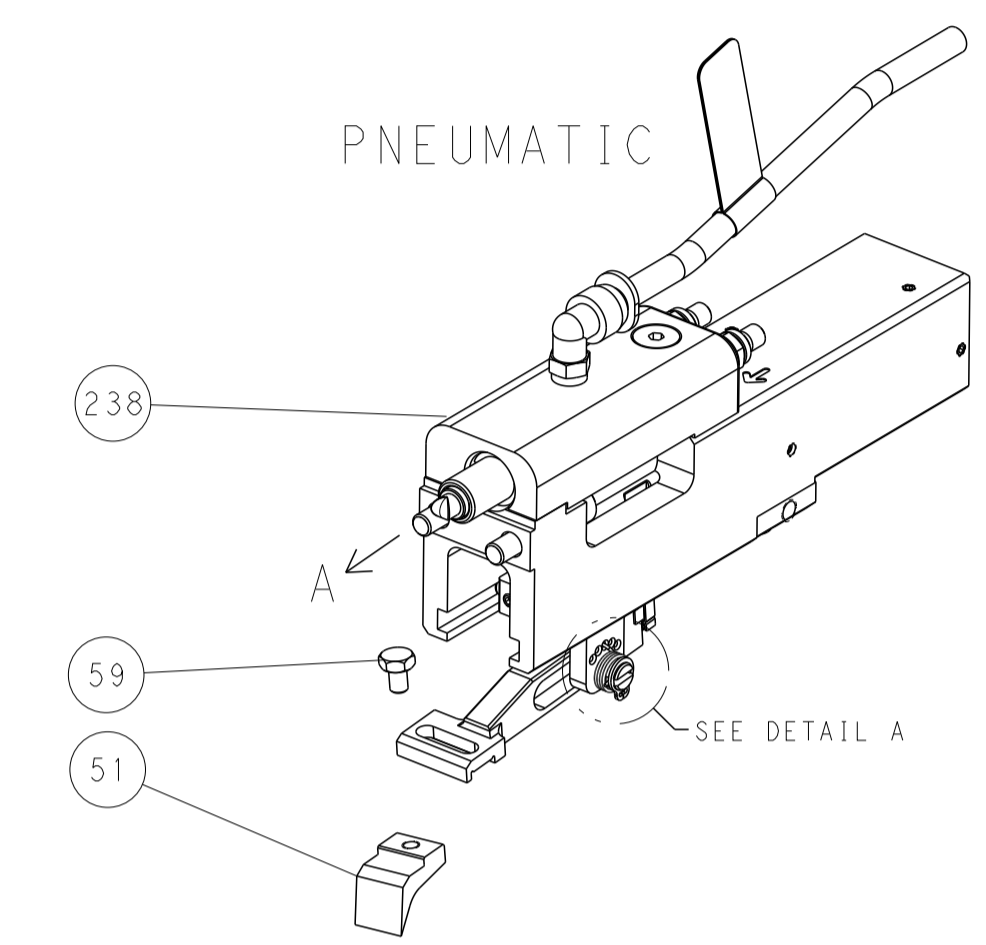
OWN	C. CHEN	23FEB2012		TE Connectivity
CHK	S. XI	23FEB2012		Harrisburg, PA 17105-3608
APVD	J. CRUZ	23FEB2012	NAME	
PRODUCT SPEC			Ocean End Feed	
APPLICATION SPEC			Applicator	
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
A1	00779	2150163		
SCALE			SHEET 1 OF 4	
REV B				

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

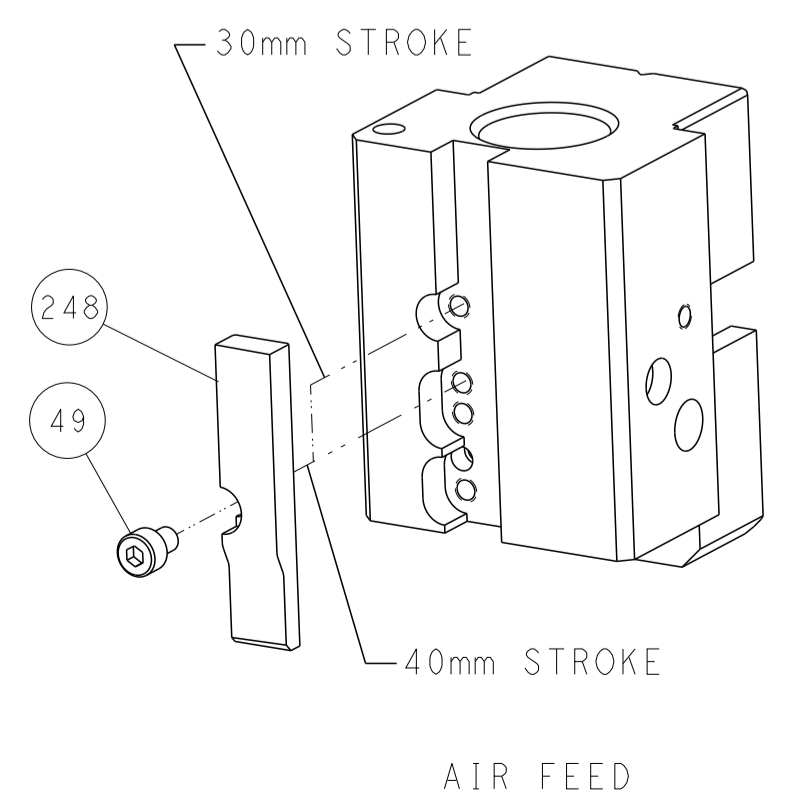


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION

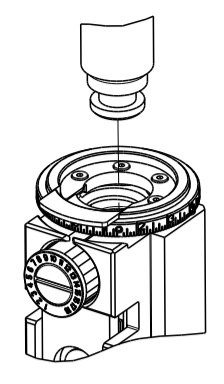


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN C. CHEN 23FEB2012 CHK S. XI 23FEB2012 APVD J. CRUZ 23FEB2012 PRODUCT SPEC APPLICATION SPEC WEIGHT RESTRICTED CUSTOMER		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150163 RESTRICTED TO		TE Connectivity Harrisburg, PA 17105-3608 SCALE 1:1 SHEET 2 OF 4 REV B	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150163-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150163-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	5.84 mm [.230]	O

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 250 SERIES TAB ECONOSEAL 3 HC

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	1.50-2.40mm [.059-.094 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
344069-1			347707-1	1.6-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [.071+/-0.002]	7.0
1.00mm2	1.60+/-0.05 [.063+/-0.002]	9.6
0.75mm2	1.50+/-0.05 [.059+/-0.002]	10.5
0.50mm2	1.37+/-0.05 [.054+/-0.002]	11.9



- 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	REV	DATE	BY	APPD
A	66				

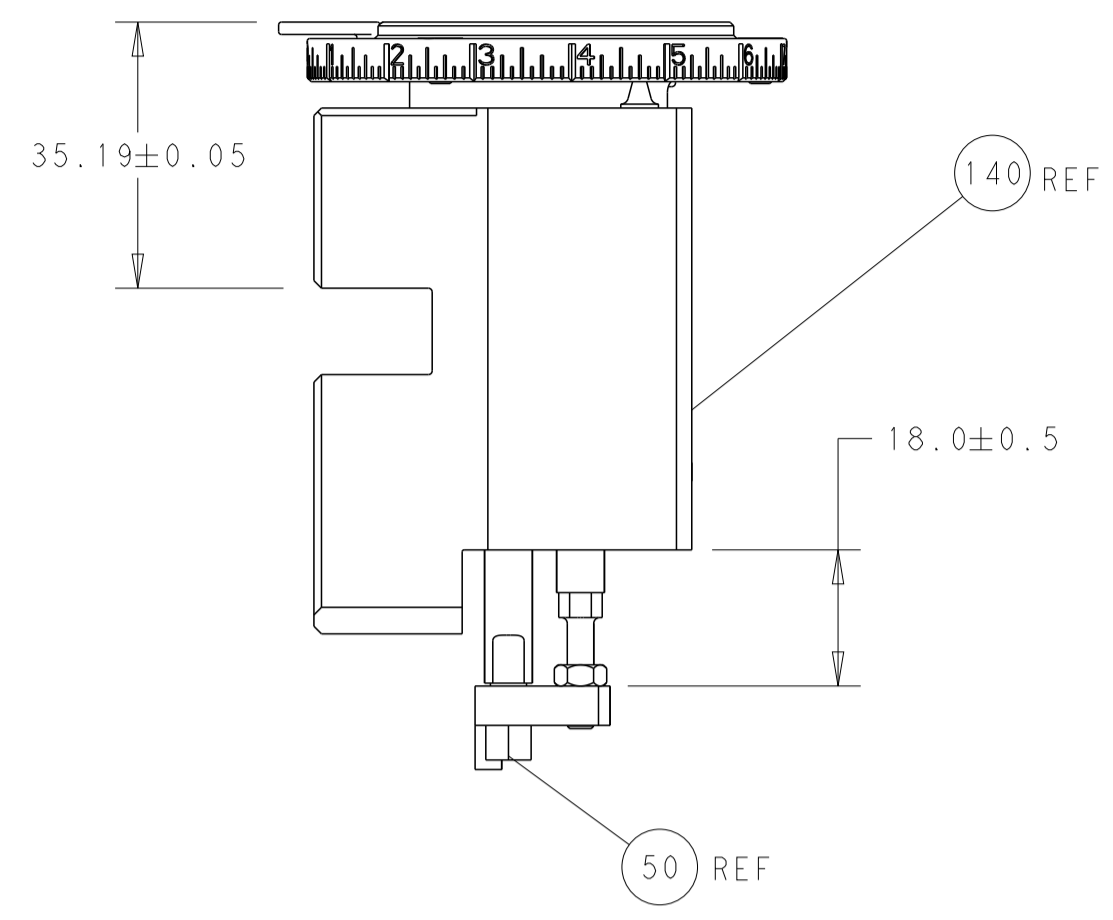
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-	1	2119083-1			
-	1	2844940-4			
-	1	1-18028-0			
-	4	2079383-9			
-	1	6-993111-6			
-	1	8-22280-7			
-	1	1752353-2			
-	1	1901680-2			
-	REF	994970-2			
-	1	2119641-2			
-	1	2168083-8			
-	1	2119655-6			
-	1	1803518-1			
-	1	455888-6			
-	1	2119791-5			
-	1	1803607-4			
-	2	2-18032-2			
-	1	2119943-1			
-	1	2119740-1			
-	2	2168078-1			
-	1	1901681-9			
-	1	5-18022-5			
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-	2	2168083-9			
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-	2	2168083-2			
-	1	240639-1			
-	2	1-2168083-5			
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-	2	2-22281-3			
-	1	1803292-1			
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-	1	240644-1			
-	2	2-240645-4			
-	1	240642-1			
1	1	1333295-2			
-	1	1-240651-9			
-	1	6-240641-8			
-	1	4-238011-5			
1	1	1-1803018-4			
-	1	455888-7			
1	1	5-456405-0			
-	77-22	PART NO			
		DESCRIPTION			
		ITEM NO			

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPD
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	23FEB2012	C. CHEN	S. XI
		23FEB2012	J. CRUZ	
MATERIAL		RESTRICTED TO	SCALE	SHEET 3 OF 4
		RESTRICTED CUSTOMER	1:1	REV B



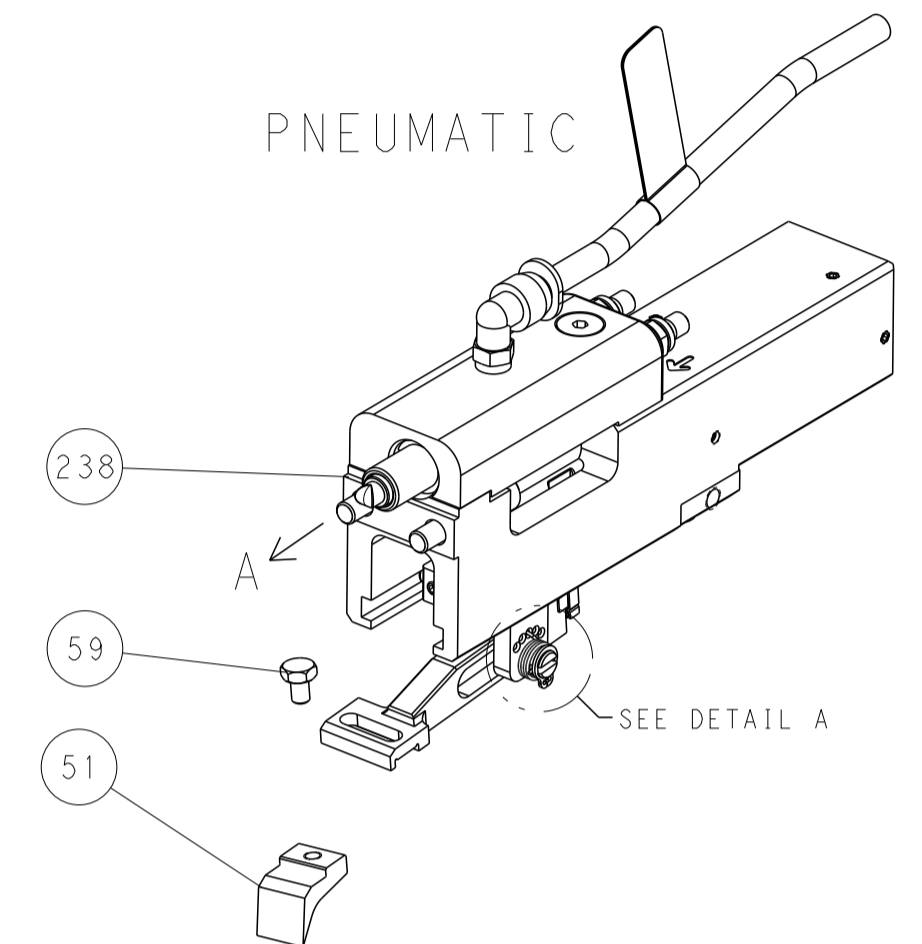
Ocean End Feed
 Applicator

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

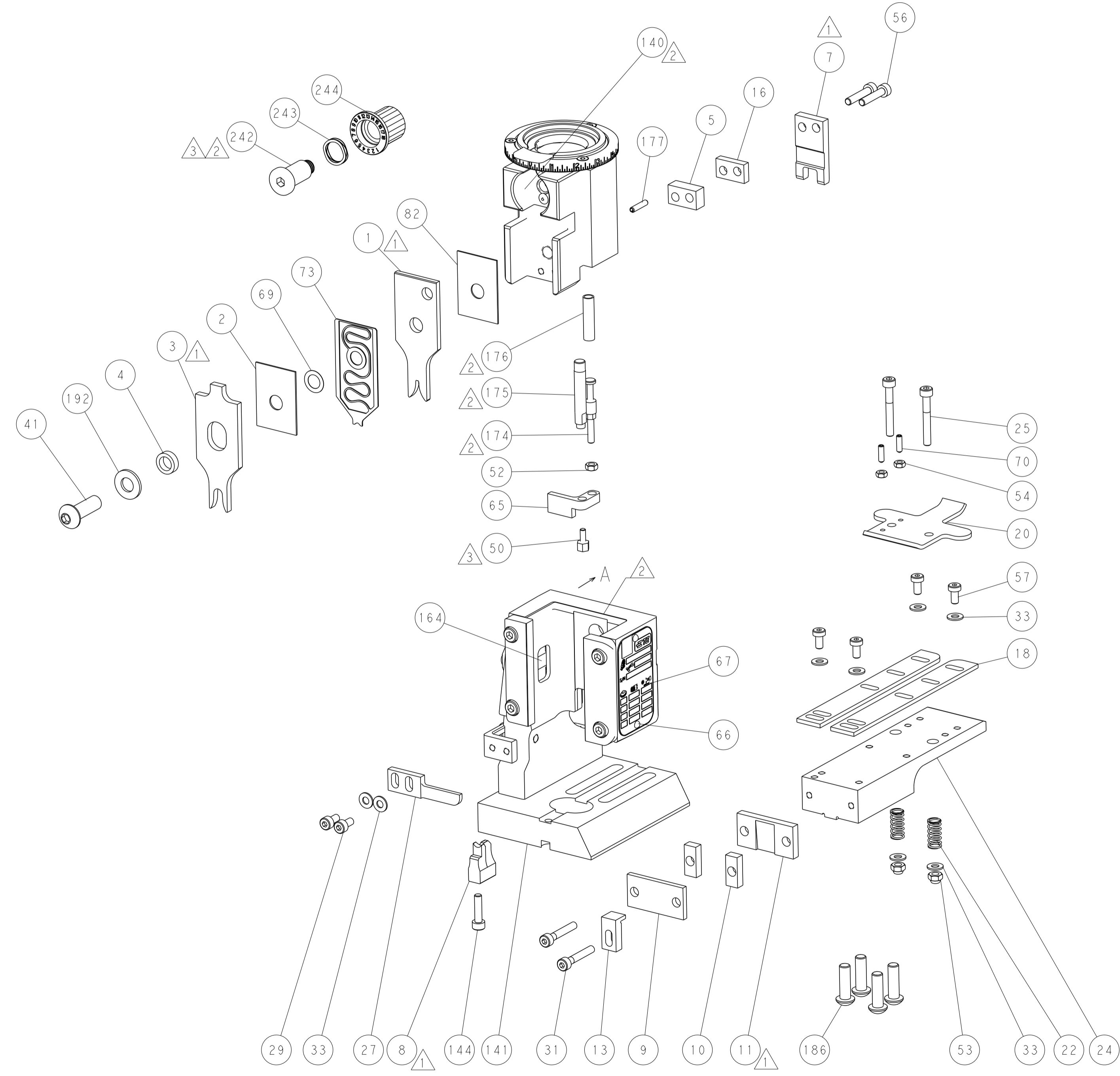
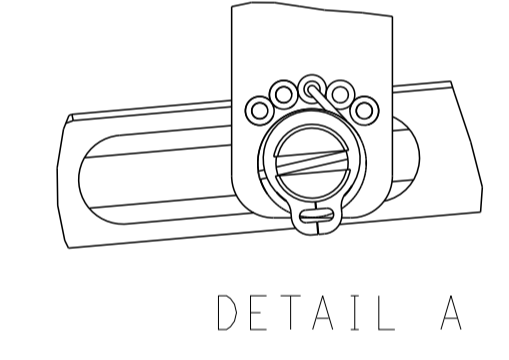


RAM AND HOLDDOWN SET-UP

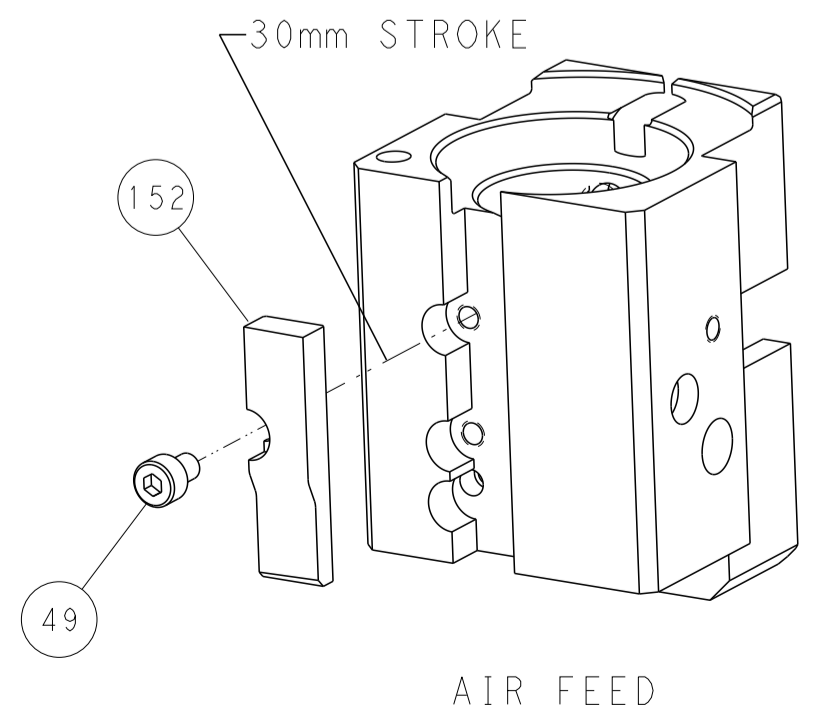
FEED TYPE



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN C. CHEN 23FEB2012 CHK S. XI 23FEB2012 APVD J. CRUZ 23FEB2012	NAME Ocean End Feed Applicator
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150163	RESTRICTED TO:
RESTRICTED CUSTOMER		SCALE: 1:1		SHEET: 4 OF 4	REV: B