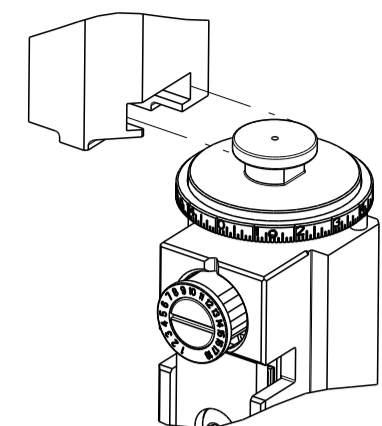


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150398-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150398-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150398-7	A	CRIMP TOOLING KIT	-

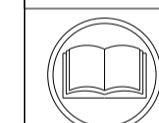
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, FLAG, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.15 mm [.173-.203 IN]		∅2.79-4.06 mm [.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION	REFERENCE 114-2079	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742999-1	1742999-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.78+/-0.05 [.070+/-0.002]	6.1
16 AWG	1.55+/-0.05 [.061+/-0.002]	8.5
18 AWG	1.40+/-0.05 [.055+/-0.002]	10.5



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

**\*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.

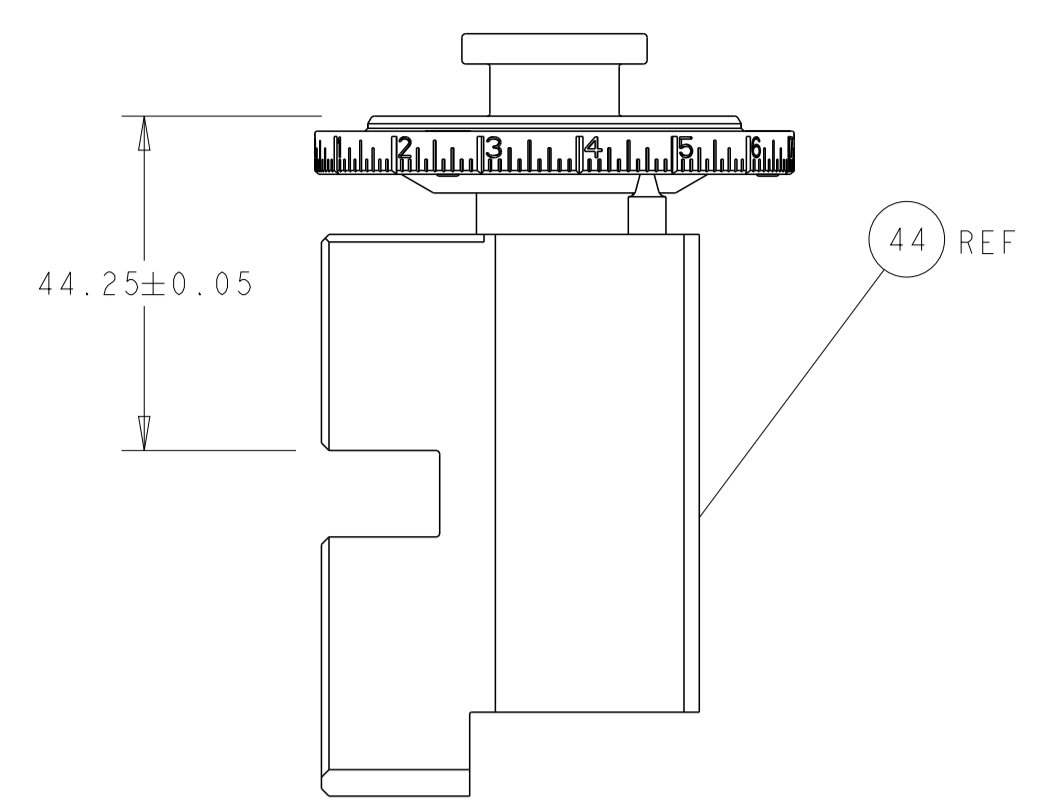
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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				ECR-19-016320	19OCT2019	TB	RK
				ECR-19-017751	14NOV2019	TB	RK

-	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	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
5	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-2063961-4	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	240639-4	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	2161922-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	464452-6	DRAG, STOCK	20	
-	1	1	1803086-4	GUIDE, REAR STRIP	19	
-	1	1	5-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	8-240645-4	SPACER, SHEAR PLATE	10	
1	-	1	1	455961-5	PLATE, FRONT SHEAR	9
1	1	2	1	1803074-6	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1803109-3	BLADE, SLUG	7
-	-	-	-	-	6	
-	-	-	-	-	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	1	1-1633989-3	CRIMPER, INSULATION, SPECIAL	3
-	1	1	2-455888-0	SPACER, CRIMPER	2	
1	1	2	1	1803015-6	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

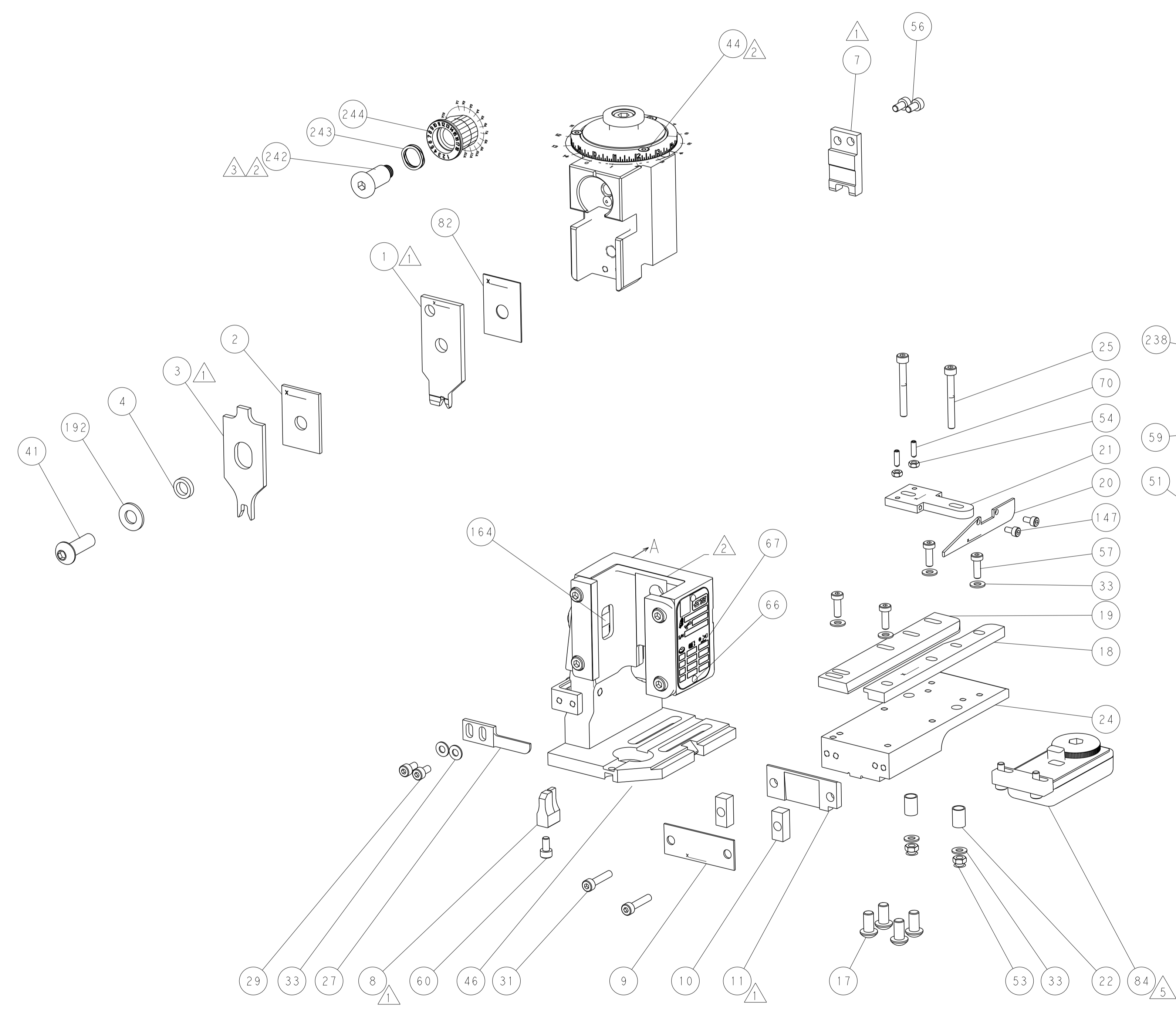
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 09-Jan-14		CHK: G. BAILEY 09-Jan-14		APVD: M. CLIFFORD 09-Jan-14		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150398	RESTRICTED TO: -
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 1 of 4		REV: C	

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTH	DESCRIPTION		
-	-	SEE SHEET 1	-	-

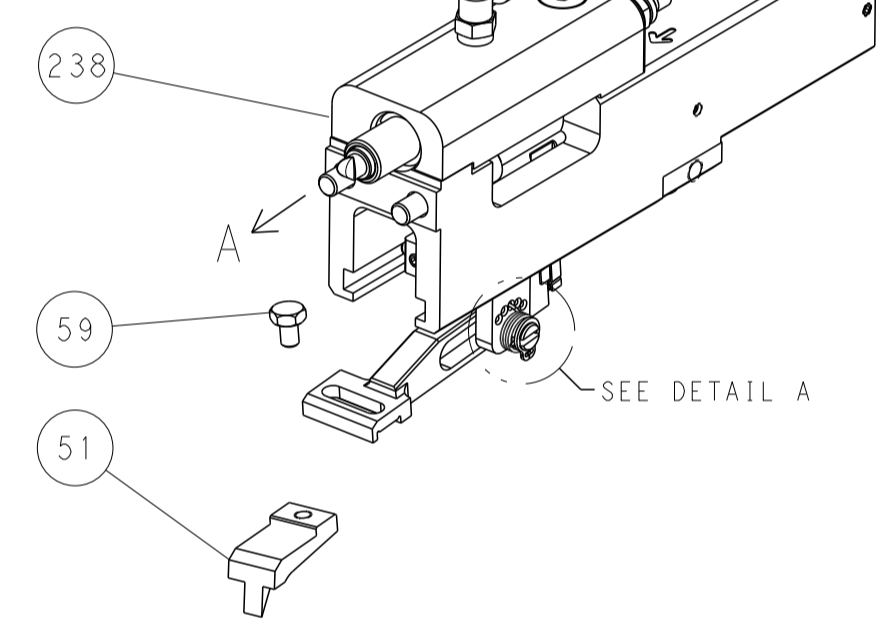


RAM SET-UP

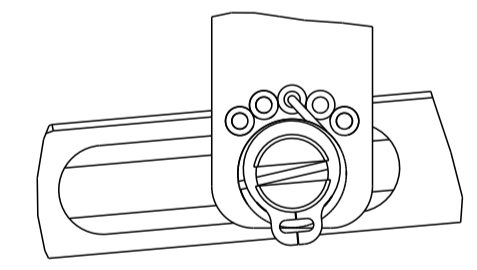


FEED TYPE

PNEUMATIC

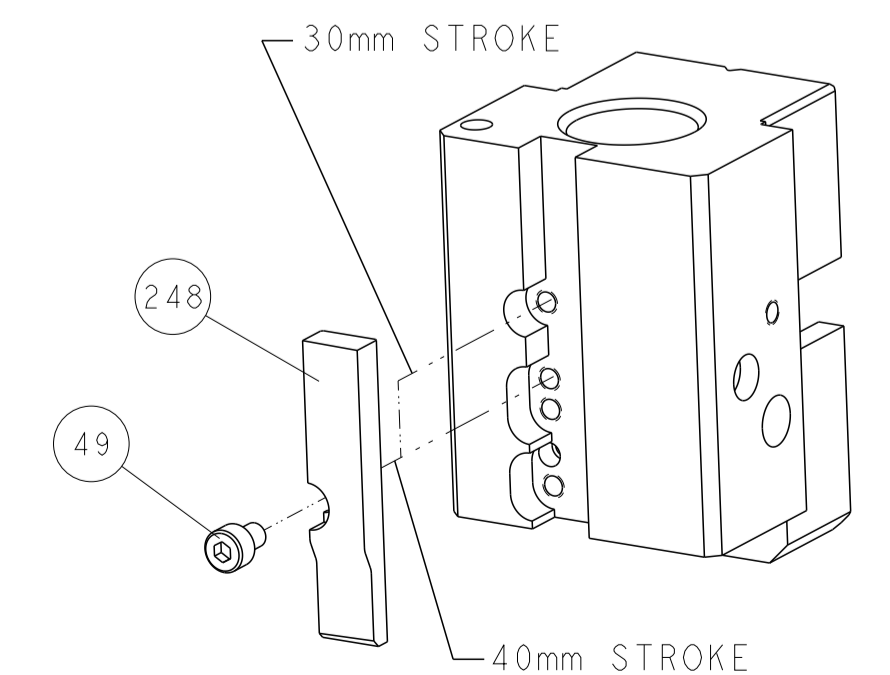


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



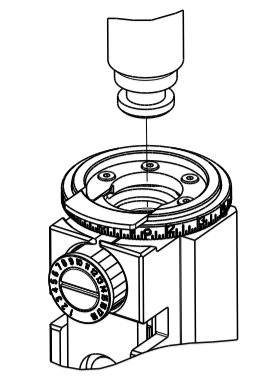
AIR FEED

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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN R. KNEPPER 09-Jan-14 CHK G. BAILEY 09-Jan-14 APVD M. CLIFFORD 09-Jan-14	NAME Ocean End Feed Applicator
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT	SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150398
MATERIAL		Customer Accessible Production Drawing	SCALE 1:1 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150398-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150398-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm (.100)	F
INSUL	4.57 mm (.180)	Ø

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON, FLAG, .250 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.39-5.15 mm (.173-.203 IN)	Ø2.79-4.06 mm (.110-.160 IN)

TERMINAL APPLICATION REFERENCE 114-2079

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742999-1	1742999-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.78 +/- 0.05 [.070 +/- .002]	6.1
16 AWG	1.55 +/- 0.05 [.061 +/- .002]	8.5
18 AWG	1.40 +/- 0.05 [.055 +/- .002]	10.5

- 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.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-3			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	REF	994970-2			164
-	1	2119641-2			152
-	2	1-2168083-1			147
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	2119955-2			84
-	1	455888-6			82
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	-	2063961-1			58
-	4	2168400-1			57
-	2	2168083-2			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-2063961-4			51
-	1	18023-9			49
-	1	1803602-1			41
-	8	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	240639-4			27
-	2	1-2168083-6			25
-	1	2161922-1			24
-	2	22281-6			22
-	1	1633168-2			21
-	1	464452-6			20
-	1	1803086-4			19
-	1	5-1901695-9			18
-	1	461160-3			11
-	2	8-240645-4			10
-	1	455961-5			9
1	1	1803074-6			8
-	1	1803109-3			7
-	-	-			6
-	-	-			5
-	1	238011-2			4
1	1	1-1633989-3			3
-	1	2-455888-0			2
1	1	1803015-6			1

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		DWG: R. KNEPPER 09-Jan-14 CHK: G. BAILEY 09-Jan-14 APVD: M. CLIFFORD 09-Jan-14 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150398 SHEET 3 OF 4	
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