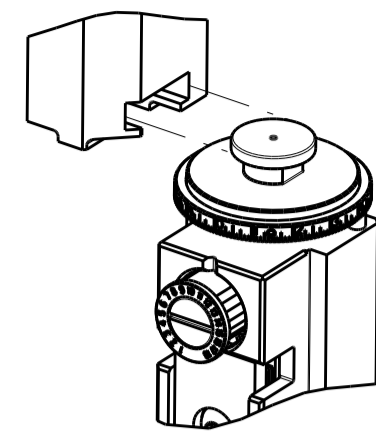


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150331-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150331-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150331-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150331-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150331-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.79 mm [.110]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SER. FASTIN-ON REC.		
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]	INSULATION DIAMETER RANGE Ø1.19-2.41 mm [.047-.095 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	
TERMINALS APPLIED		
TE TERMINAL 338052-4	TE TERMINAL 160844-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	8.7
1.00mm2	1.52 +/- 0.05 [.060 +/- .002]	9.1
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	9.7
0.50mm2	1.42 +/- 0.05 [.056 +/- .002]	10.1

- 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. 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)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		A	RELEASED	28FEB2014	LG TE
		B	ECR-18-018141	20NOV2018	FZ KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-2	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	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	1	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	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	3	3	3	3	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	-	2119792-2	PAWL, EF, AIR	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	
-	7	7	7	7	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	1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-4	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	2-690482-9	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	4-1333217-1	ANVIL, EF .090	8
-	1	1	1	1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	6-240641-5	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	4-456406-5	CRIMPER, WIRE PREMIUM	1
-	77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

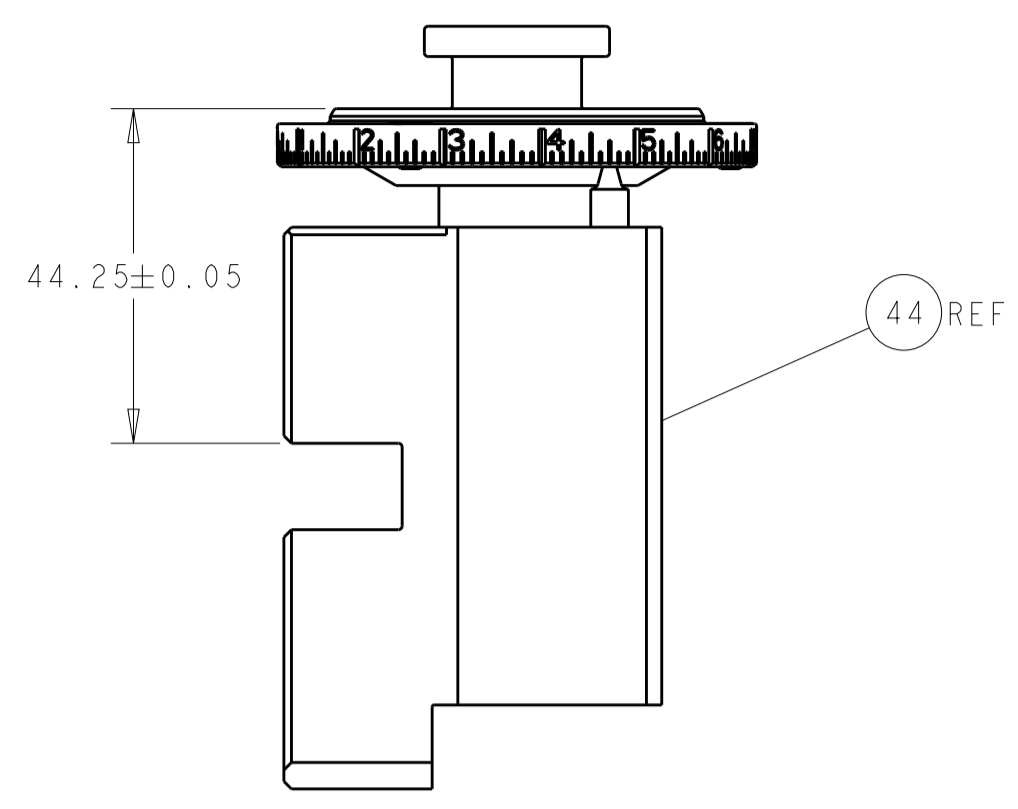
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV

STE TE Connectivity
Harrisburg, PA 17105-3608

Customer Accessible Production Drawing

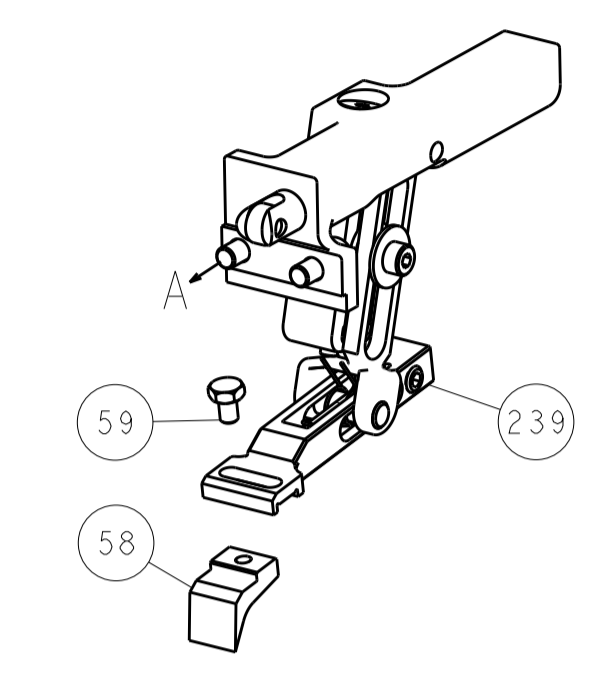
SCALE: 1:1 SHEET 1 OF 4 REV B

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

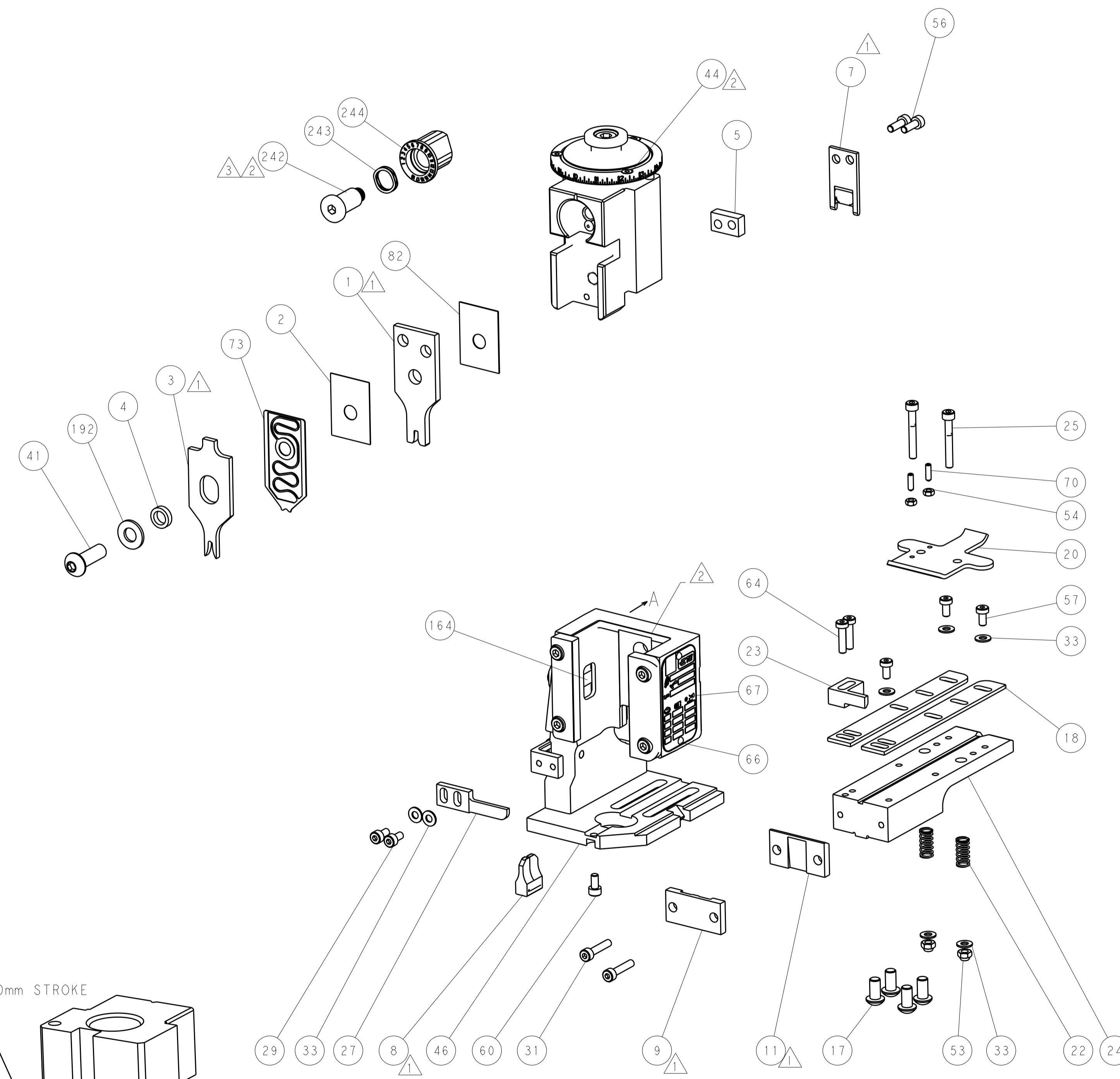
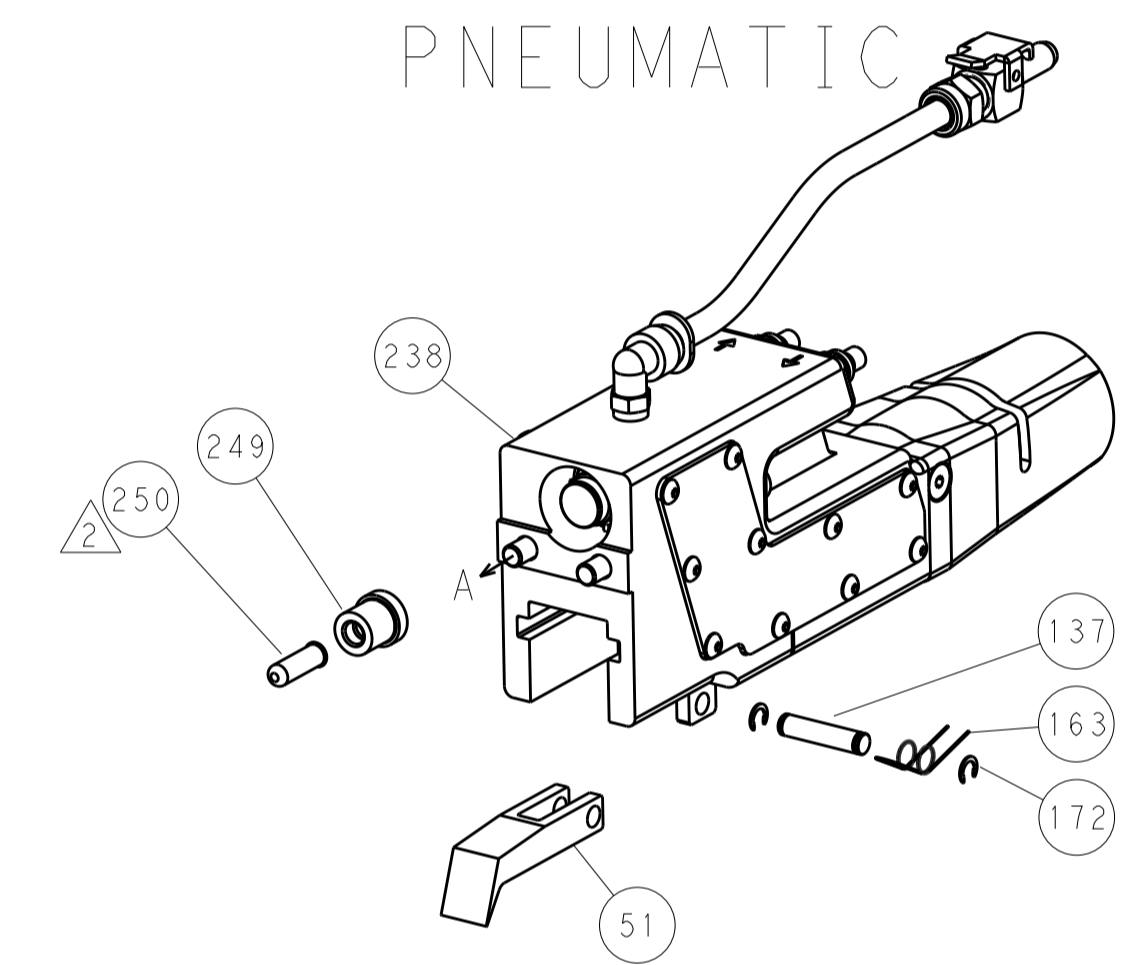


RAM SET-UP

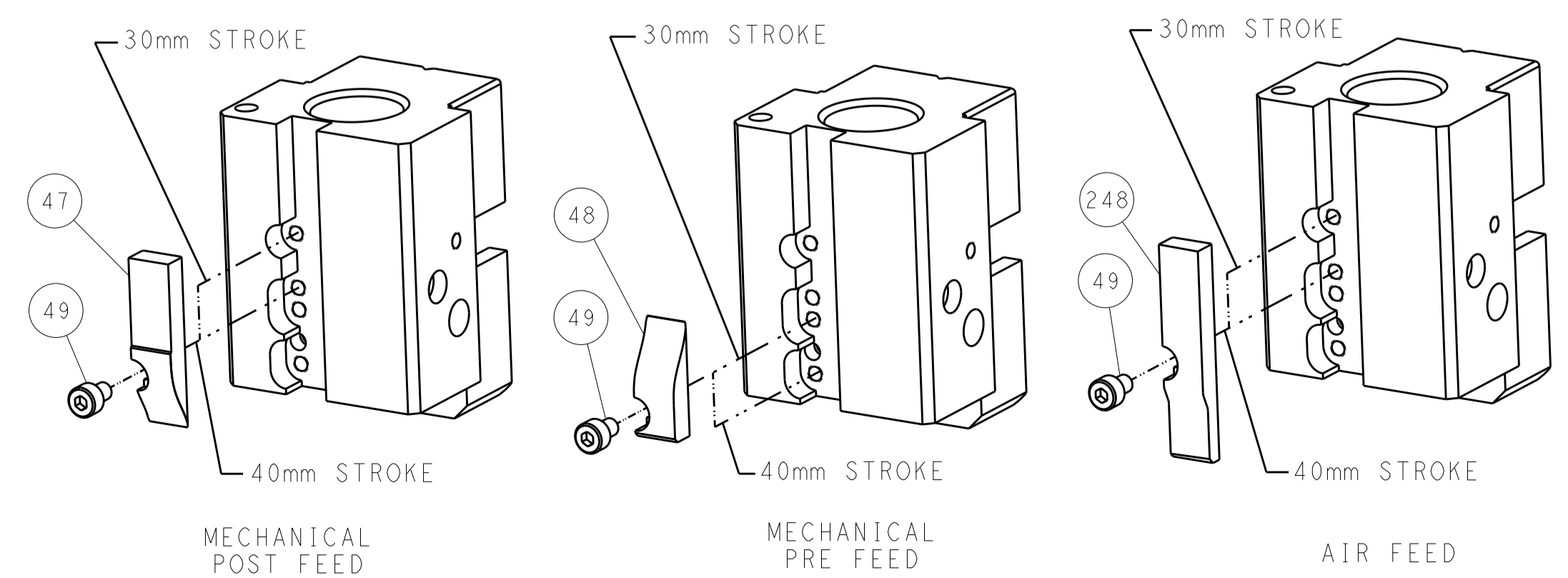
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

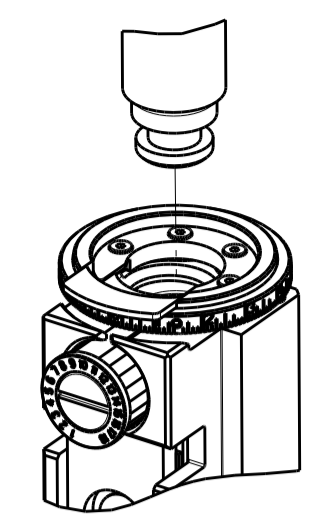


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: ALIERO 01JUN2011 CHK: P. BARLETTA 01JUN2011 APVD: C. LIMA 01JUN2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150331 SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150331-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150331-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150331-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	2.79 mm (.110)	OV

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SER. FASTIN-ON REC.

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.80-5.60 mm (.189-.220 IN)	∅1.19-2.41 mm (.047-.095 IN)

TERMINAL APPLICATION SPECIFICATION 114-3118

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
338052-4	160844-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	8.7
1.00mm2	1.52 +/- 0.05 [.060 +/- .002]	9.1
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	9.7
0.50mm2	1.42 +/- 0.05 [.056 +/- .002]	10.1

- 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.
- 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.
- 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.

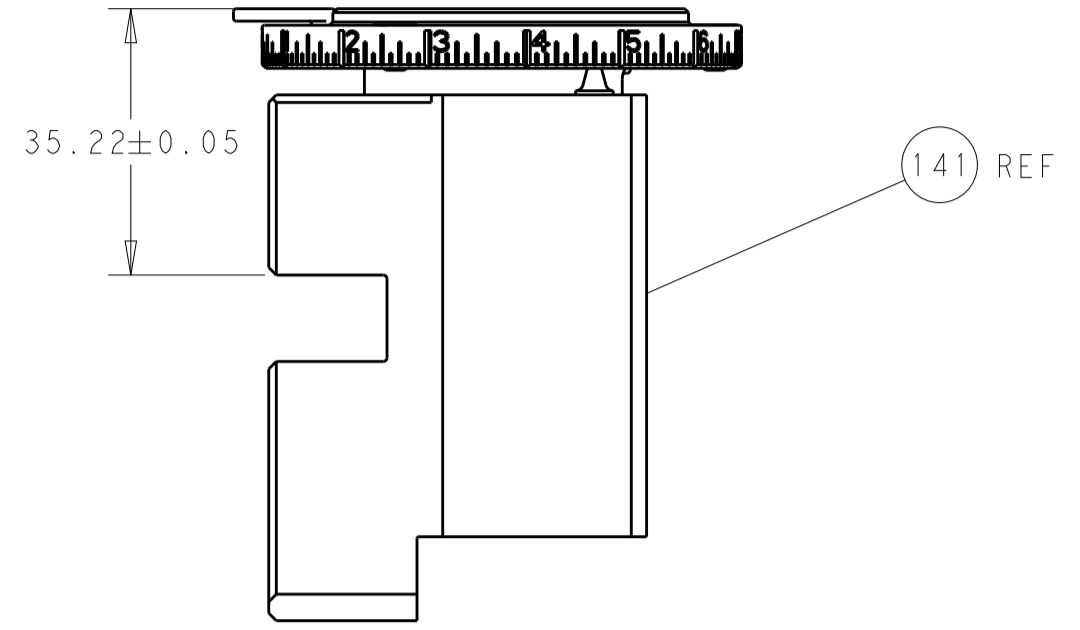
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	BY	APPD	DESCRIPTION	QTY
-	-	-	-	SEE SHEET 1	-
-	1	1		2119640-1 PUSH ROD, AIR FEED	250
-	1	1		1803259-1 BUSHING, FLANGED	249
-	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		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2063440-1 AIR FEED MODULE	238
-	1	1		1-18028-0 WASHER, FLAT, REG M8	192
-	4	4		2079383-9 SCR, BHSC, RoHS (M6 X 20)	186
-	2	2		21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF		994970-2 COUNTER, MAGNETIC	164
-	1	1		240638-1 SPRING, FEED FINGER	163
-	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
-	1	1		3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1		455888-4 SPACER, CRIMPER	82
-	1	1		2119791-9 DEPRESSOR, WIRE	73
-	1	1		1803607-2 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
-	2	2		2168400-8 SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1		5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	1		2063961-1 FEED FINGER	58
-	3	3		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	-		2119792-2 PAWL, EF, AIR	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
-	7	7		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		1752371-3 PLATE, STRIP GUIDE	24
-	1	1		240825-4 PLATE, STRIP HOLD DOWN	23
-	2	2		2-22281-3 SPRING, COMPRESSION	22
-	1	1		1803292-4 DRAG	20
-	2	2		1901259-4 GUIDE, LOWER STRIP	18
-	1	1		240833-2 PLATE, REAR SHEAR	11
-	-	-		-	10
-	1	1		2-690482-9 PLATE, FRONT SHEAR	9
-	1	1		4-1333217-1 ANVIL, EF .090	8
-	1	1		1-2217206-4 BLADE, SLUG	7
-	-	-		-	6
-	1	1		6-240641-5 SPACER	5
-	1	1		238011-2 BLOCK, CRIMPER SPACER	4
-	1	1		1633963-1 CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1		455888-2 SPACER, CRIMPER	2
-	1	1		4-456406-5 CRIMPER, WIRE PREMIUM	1
-	77-22-21			PART NO DESCRIPTION ITEM NO	

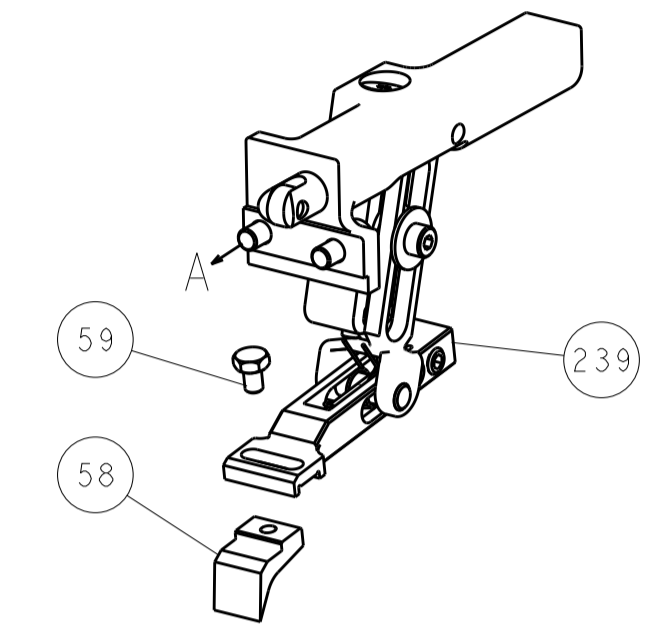
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0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO					
2 PLC	±	3 PLC	±	WEIGHT	A1	00779	SCALE	1:1	SHEET	3	OF	4
4 PLC	±	ANGLES	±	Customer Accessible Production Drawing		SCALE		1:1		SHEET 3 OF 4		REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

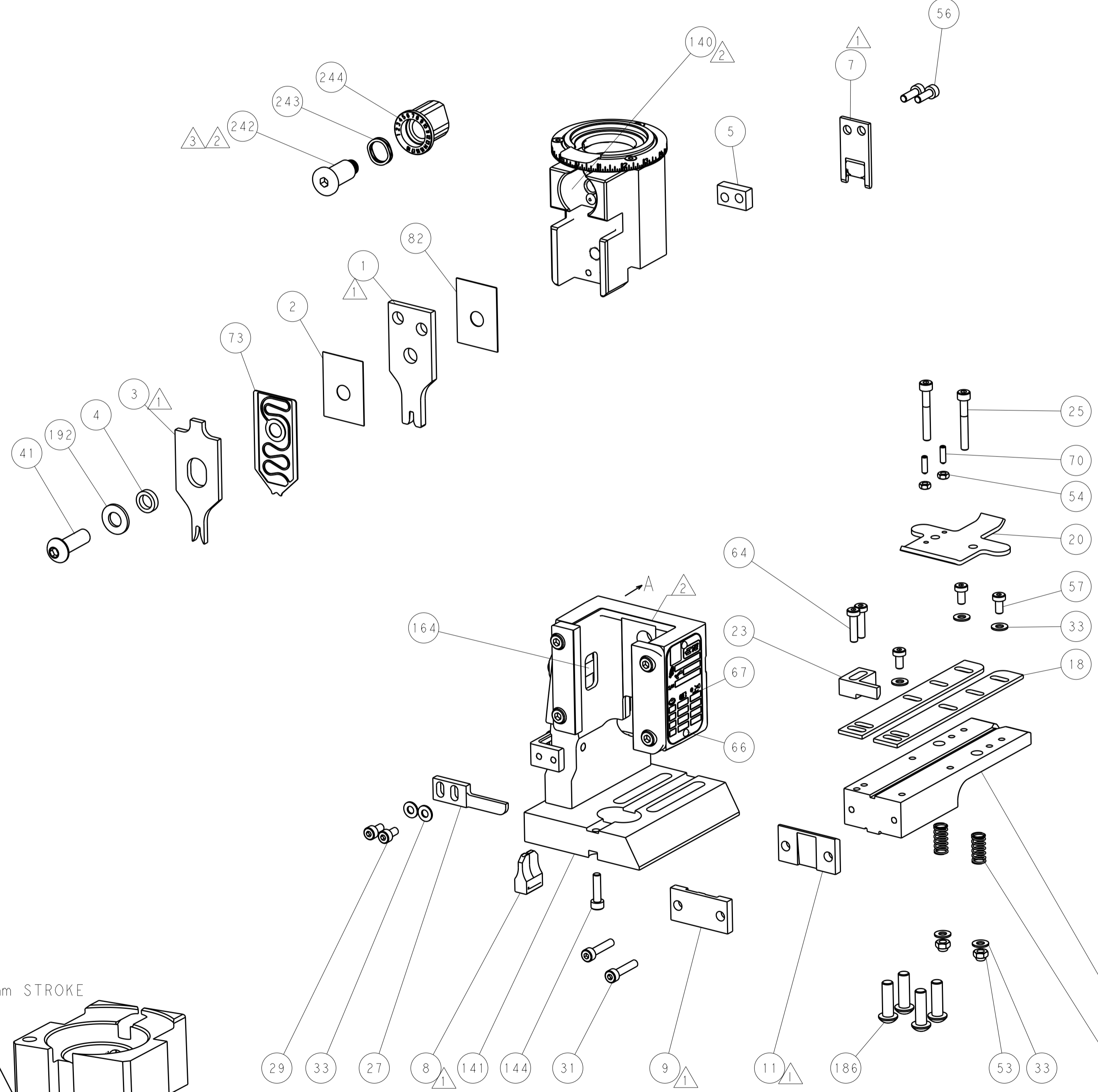
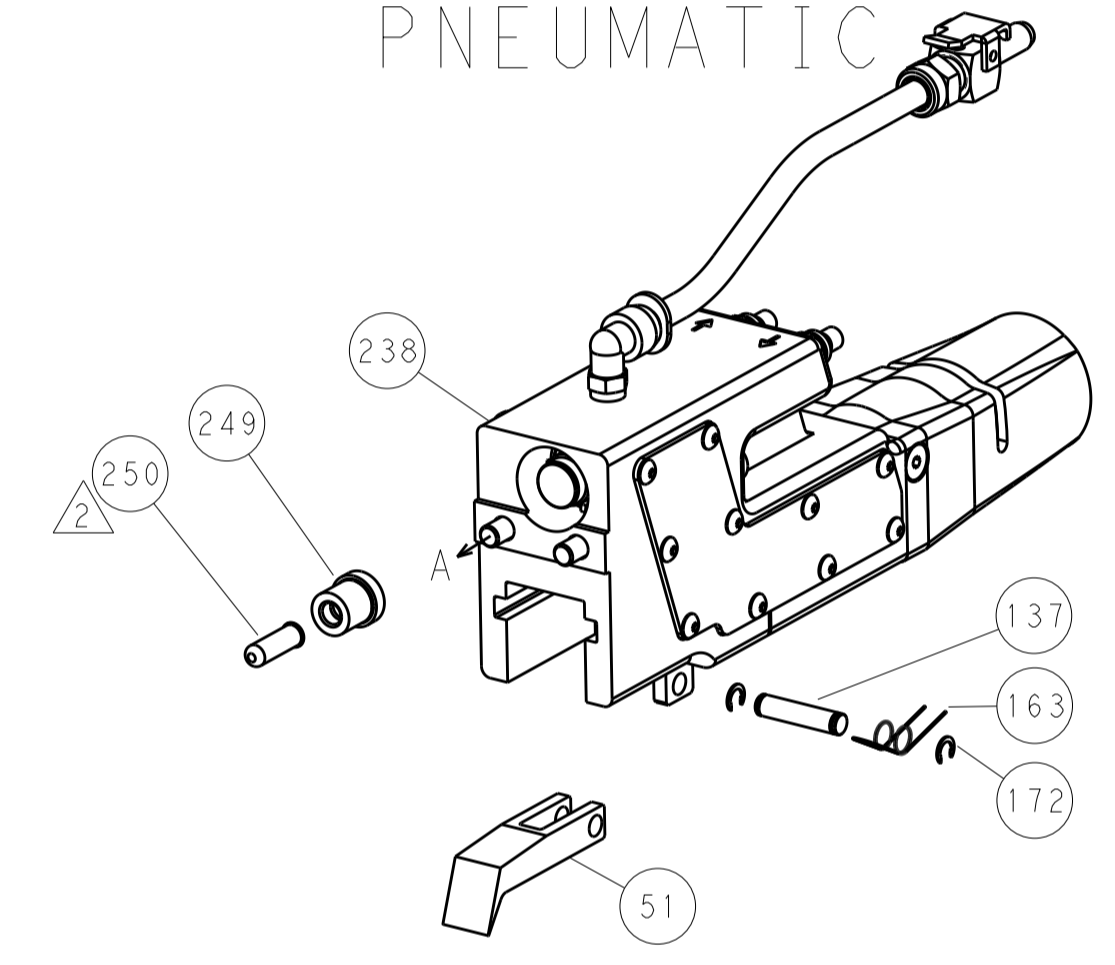


RAM SET-UP

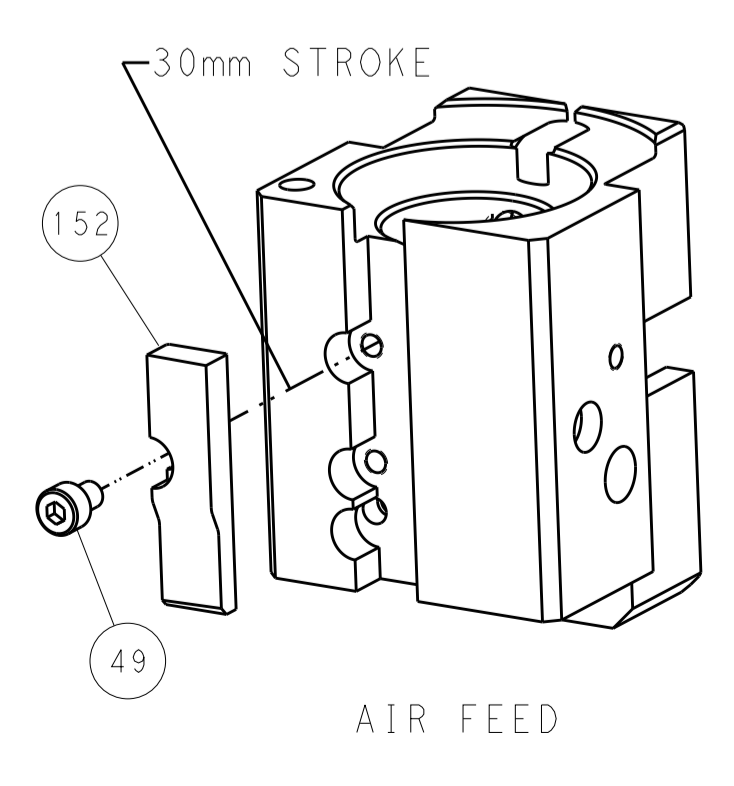
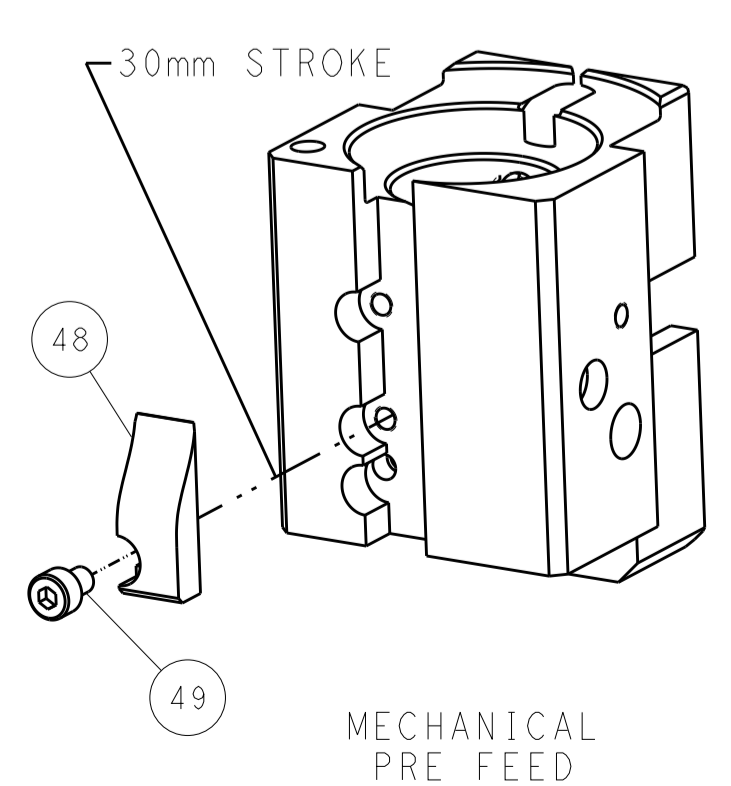
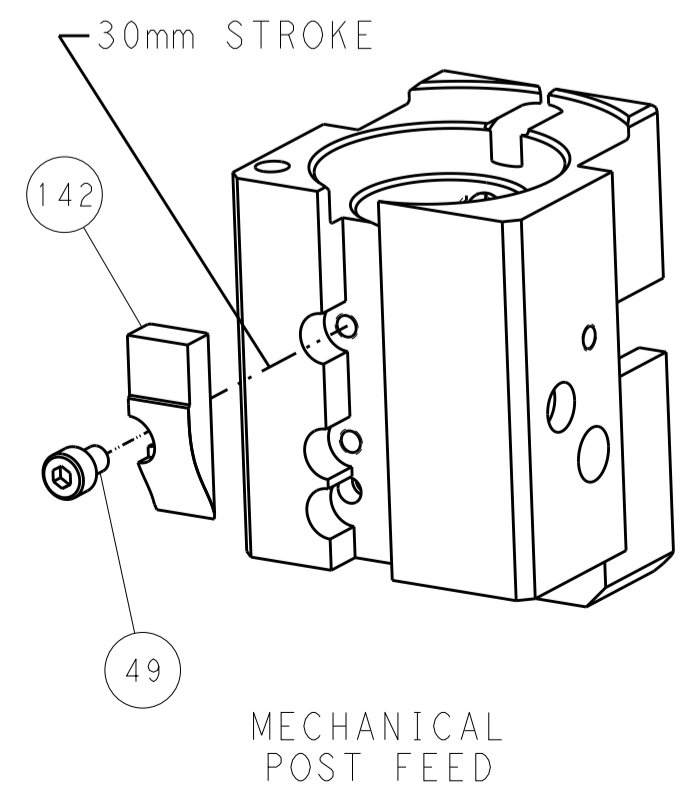
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC	NAME: Ocean End Feed Applicator SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150331 RESTRICTED TO: B
MATERIAL: FINISH:		WEIGHT: SCALE: 1:1 SHEET 4 OF 4 REV B	Customer Accessible Production Drawing