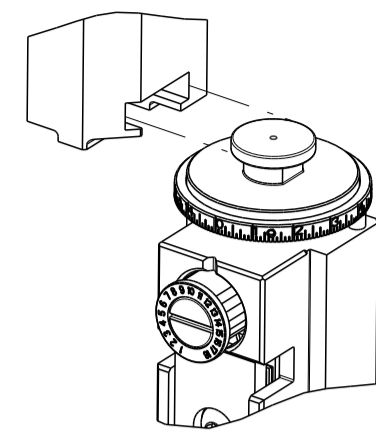


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150016-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150016-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150016-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150016-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150016-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .250 SERIES			
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]	INSULATION DIAMETER RANGE Ø3.05-4.31 mm [.120-.170 IN]		
TERMINAL APPLICATION SPECIFICATION 114-2036			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63306-1	60713-1	42660-1	1217393-1
63306-2	60713-2	42660-2	63985-1
42400-1	350981-2	60650-1	63674-1
42400-2	42219-1	60650-2	1742948-1
42400-3	42219-2	60650-3	1742971-4
1742198-1	154692-1	1217272-1	2238196-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [.073+/-0.002]	7.5
(1)18 & (1)16	1.85+/-0.05 [.073+/-0.002]	7.5
(2)18	1.73+/-0.05 [.068+/-0.002]	9.0
16 OR (1)20 & (1)18	1.63+/-0.05 [.064+/-0.002]	10.0
18 AWG	1.47+/-0.05 [.058+/-0.002]	11.7

- 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 LUBRICANT IS RECOMMENDED.
- 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.

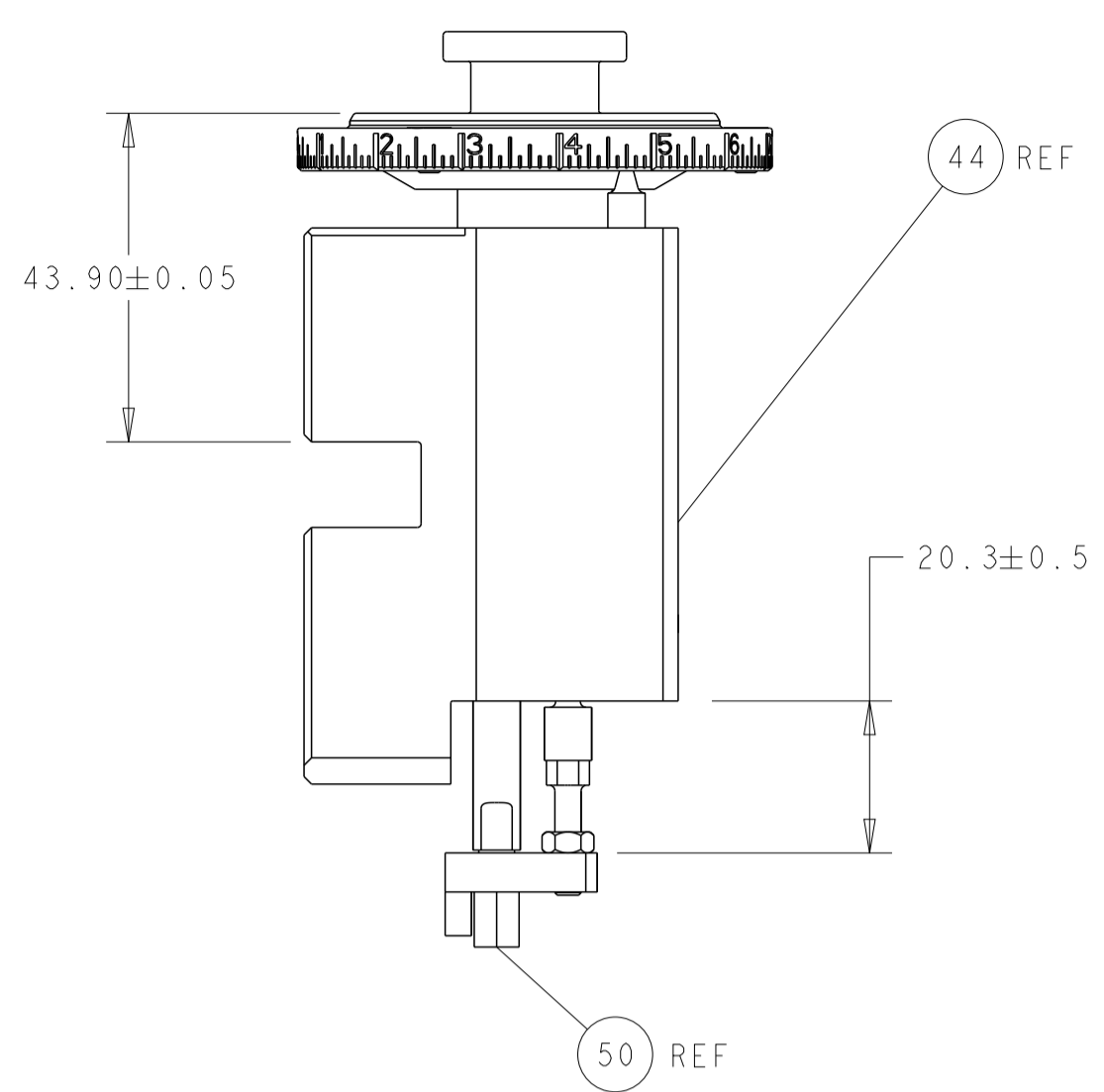
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		K1		ECR-17-00027	05JAN2017	YY	JDG
		K2		ECR-17-002694	23FEB2017	TB	CT
		K3		ECR-18-004151	26MAR2018	FL	GB
		L		ECR-18-015547	29SEP2018	TB	TE

-	1	1	1	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	261					
-	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					
-	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					
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84					
-	1	1	1	1	455888-4	SPACER, CRIMPER	82					
-	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					
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65					
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52					
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51					
-	1	1	1	1	1-1752354-4	STANDOFF,HOLD-DOWN	50					
-	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					
-	1	1	1	1	2168400-5	SHCS, LOW HEAD, 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	1752371-1	PLATE, STRIP GUIDE	24					
-	1	1	1	1	240825-1	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	1901259-6	GUIDE, LOWER STRIP	18					
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17					
-	1	1	1	1	240641-1	SPACER	16					
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13					
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11					
-	-	-	-	-	-	-	10					
-	1	1	1	1	690495-4	PLATE, FRONT SHEAR	9					
-	1	2	2	1	1	3-1803000-1	ANVIL, COMBINATION, END FEED	8				
-	1	1	1	1	1	1-2217206-4	BLADE, SLUG	7				
-	1	1	1	1	1	1-240641-6	SPACER	5				
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4				
-	1	2	2	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3				
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2				
-	1	2	2	1	1	1-1633730-9	CRIMPER, WIRE	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

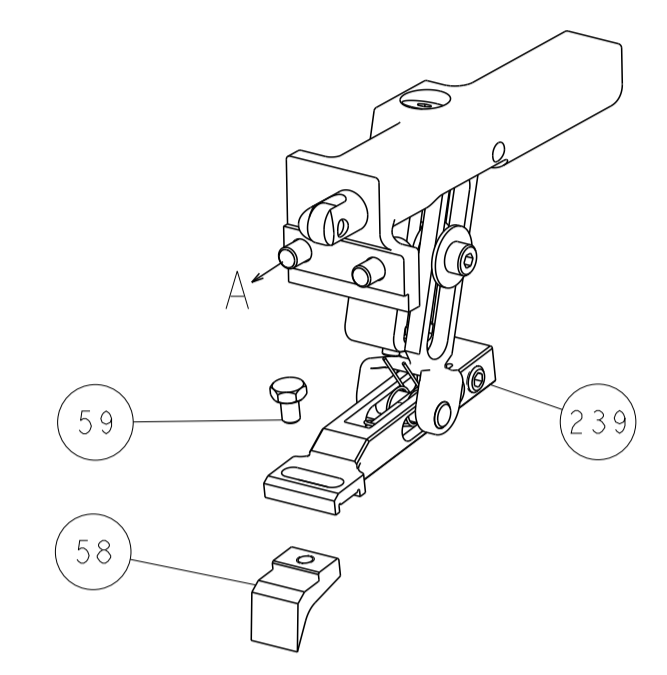
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC	±													
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													

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

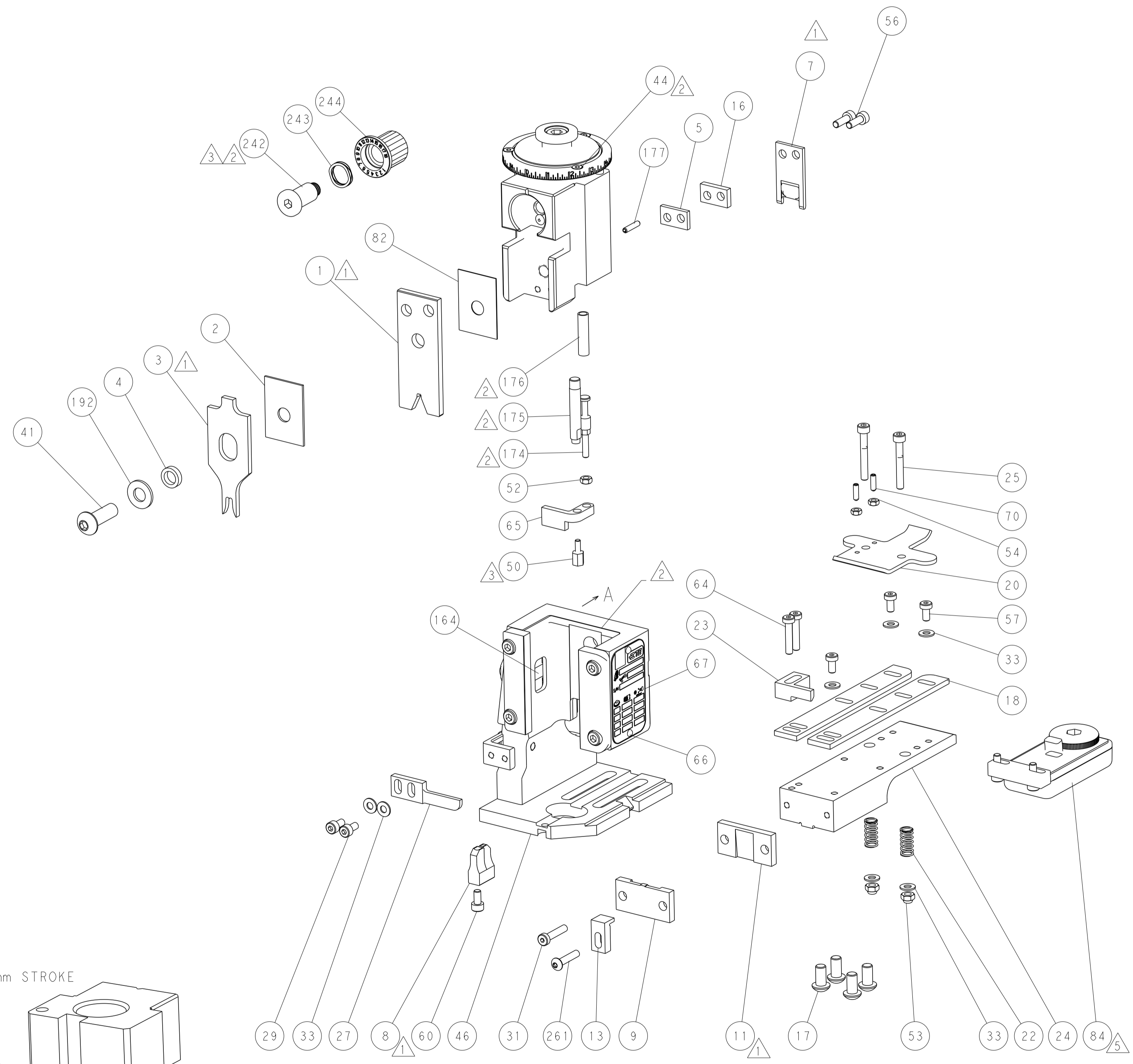
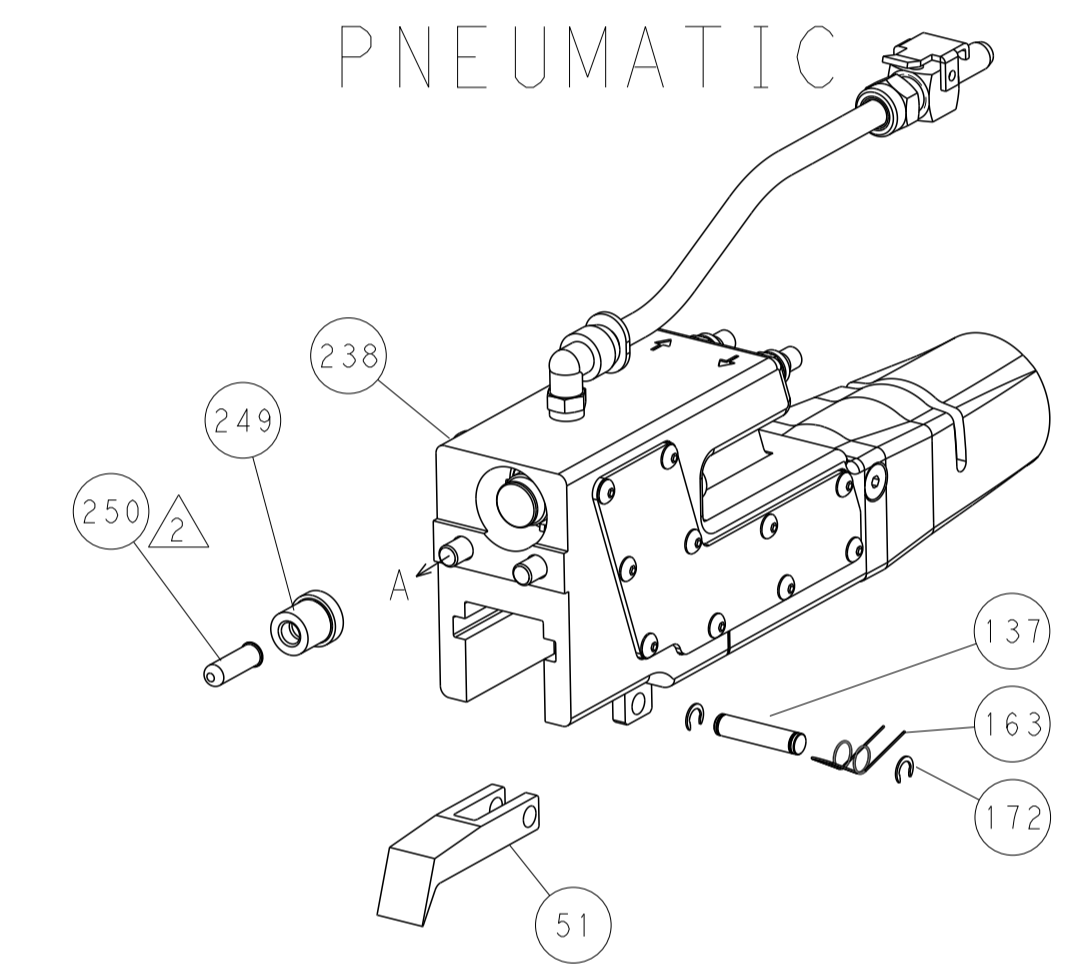


RAM AND HOLDDOWN SET-UP

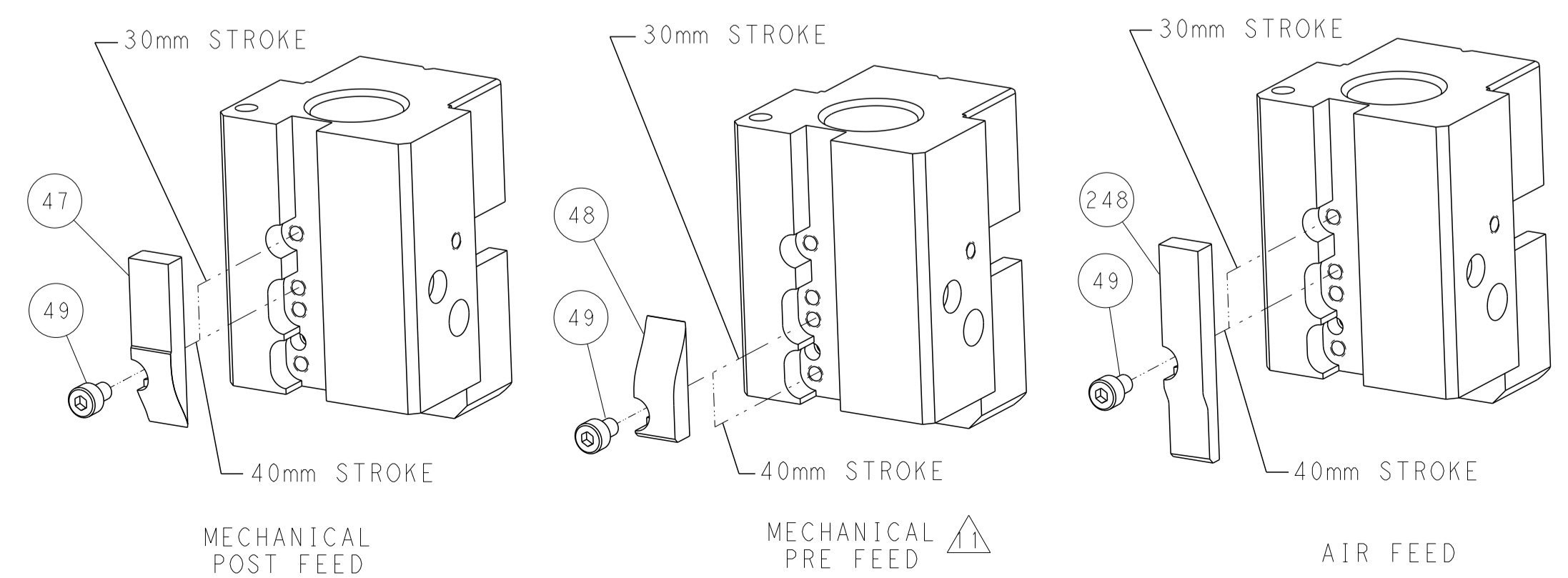
FEED TYPE  
MECHANICAL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 29NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. HOFFNER 29NOV2011		NAME: Ocean End Feed Applicator	
				APVD: T. ELBIN 29NOV2011		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2150016	
				WEIGHT:		SCALE: 1:1	
				Customer Accessible Production Drawing		SHEET 2 OF 4	
						REV L	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150016-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150016-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150016-7	H	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .250 SERIES			
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]		INSULATION DIAMETER RANGE Ø3.05-4.31 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63306-1	60713-1	42660-1	1217393-1
63306-2	60713-2	42660-2	63985-1
42400-1	350981-2	60650-1	63674-1
42400-2	42219-1	60650-2	1742948-1
42400-3	42219-2	60650-3	1742971-4
1742198-1	154692-1	1217272-1	2238196-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85 +/- 0.05 [.073 +/- .002]	7.5
(1)18 & (1)16	1.85 +/- 0.05 [.073 +/- .002]	7.5
(2)18	1.73 +/- 0.05 [.068 +/- .002]	9.0
16 OR (1)20 & (1)18	1.63 +/- 0.05 [.064 +/- .002]	10.0
18 AWG	1.47 +/- 0.05 [.058 +/- .002]	11.7



- 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 LUBRICANT IS RECOMMENDED.
- 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.

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

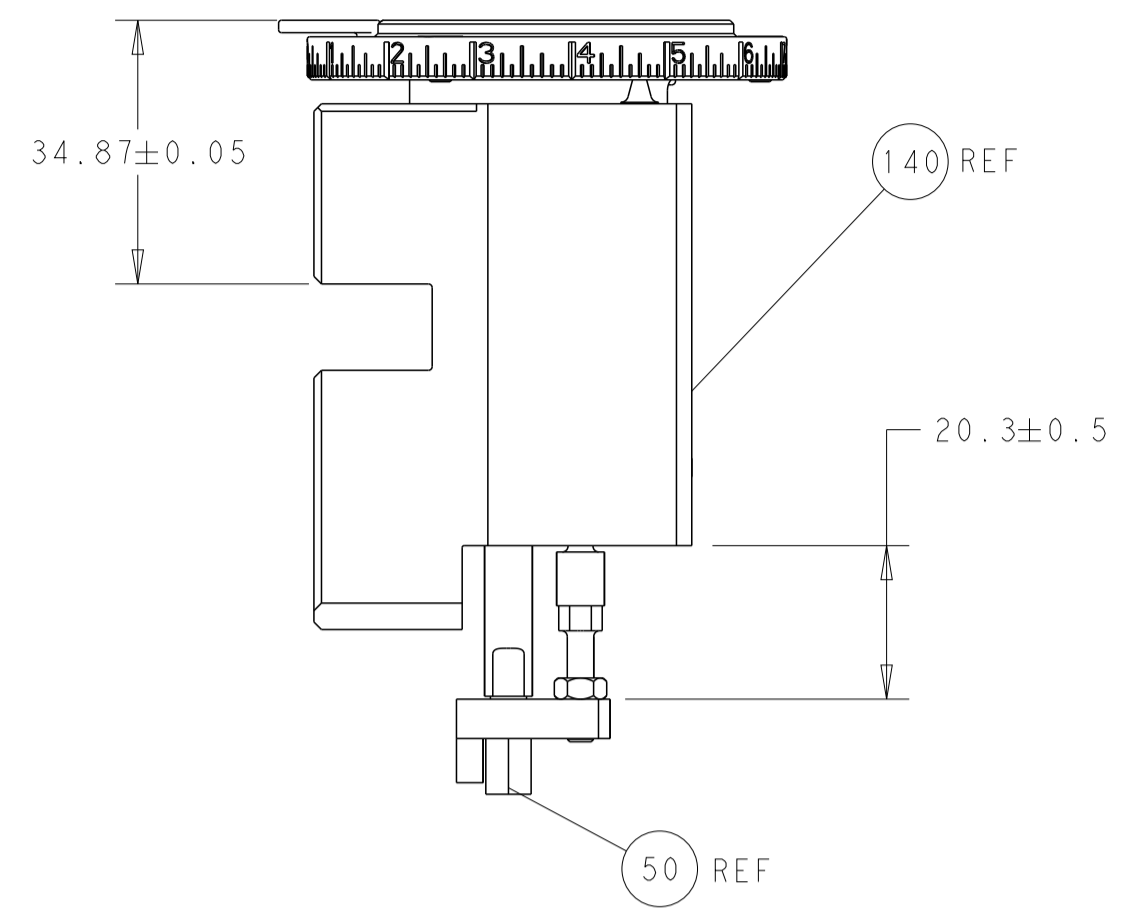
-	1	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	261
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL 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
-	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
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REFREF	-	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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	SPACER, CRIMPER	82
-	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
-	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	2119792-2	PAWL, EF, AIR	51
3	-	1	1-1752354-4	STANDOFF, HOLD-DOWN	50
-	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
-	1	1	2168400-5	SHCS, LOW HEAD, 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
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	240641-1	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690495-4	PLATE, FRONT SHEAR	9
1	1	1	3-1803000-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-4	BLADE, SLUG	7
-	1	1	1-240641-6	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1-1633730-9	CRIMPER, WIRE	1

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:		MATERIAL:		FINISH:	
mm	0 PLC	±					
	1 PLC	±					
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH						

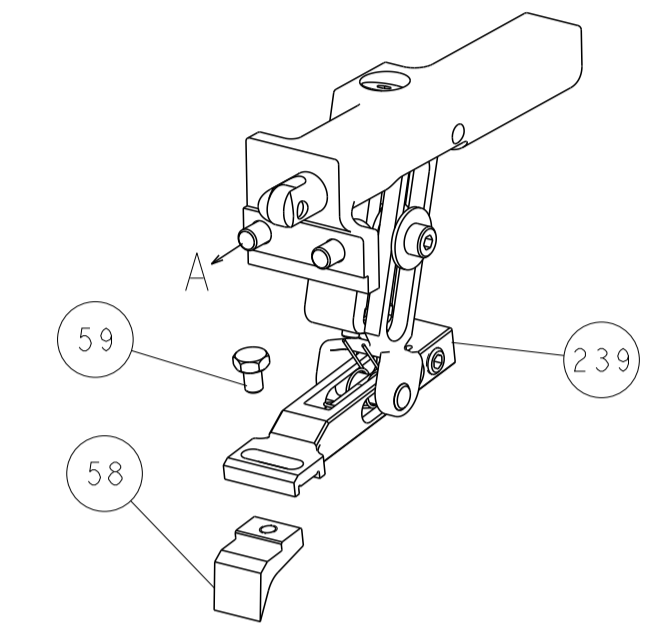
CHK	B. WEAVER	29NOV2011	NAME	TE Connectivity
CHK	G. HOFENER	29NOV2011	NAME	Harrisburg, PA 17105-3608
APVD	T. ELBIN	29NOV2011	NAME	Ocean End Feed
			PRODUCT SPEC	Applicator
			APPLICATION SPEC	
			SIZE	CAGE CODE
			A1	00779
			DRAWING NO	2150016
			RESTRICTED TO	
			WEIGHT	
			SCALE	1:1
			SHEET	3 OF 4
			REV	L

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

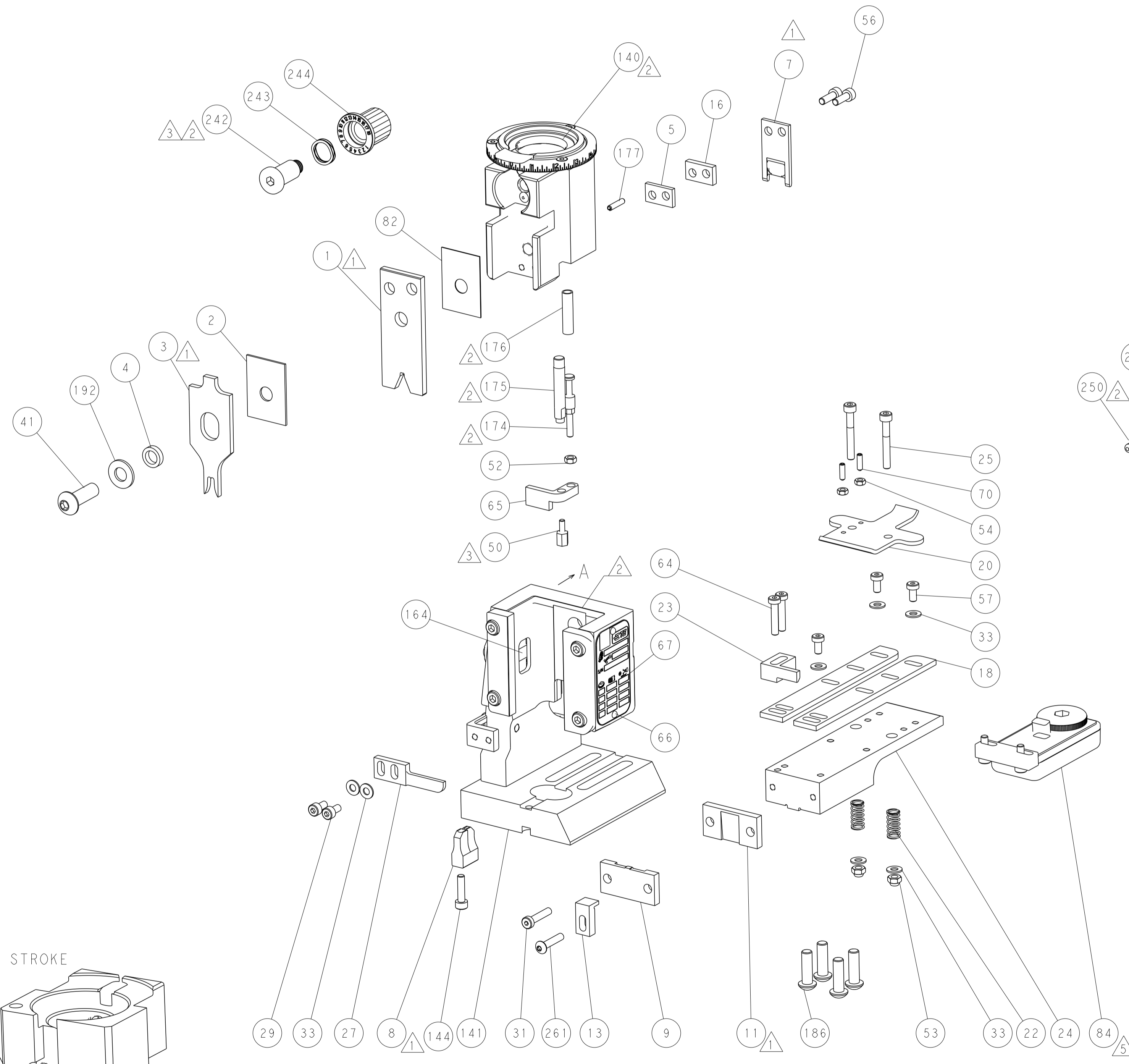
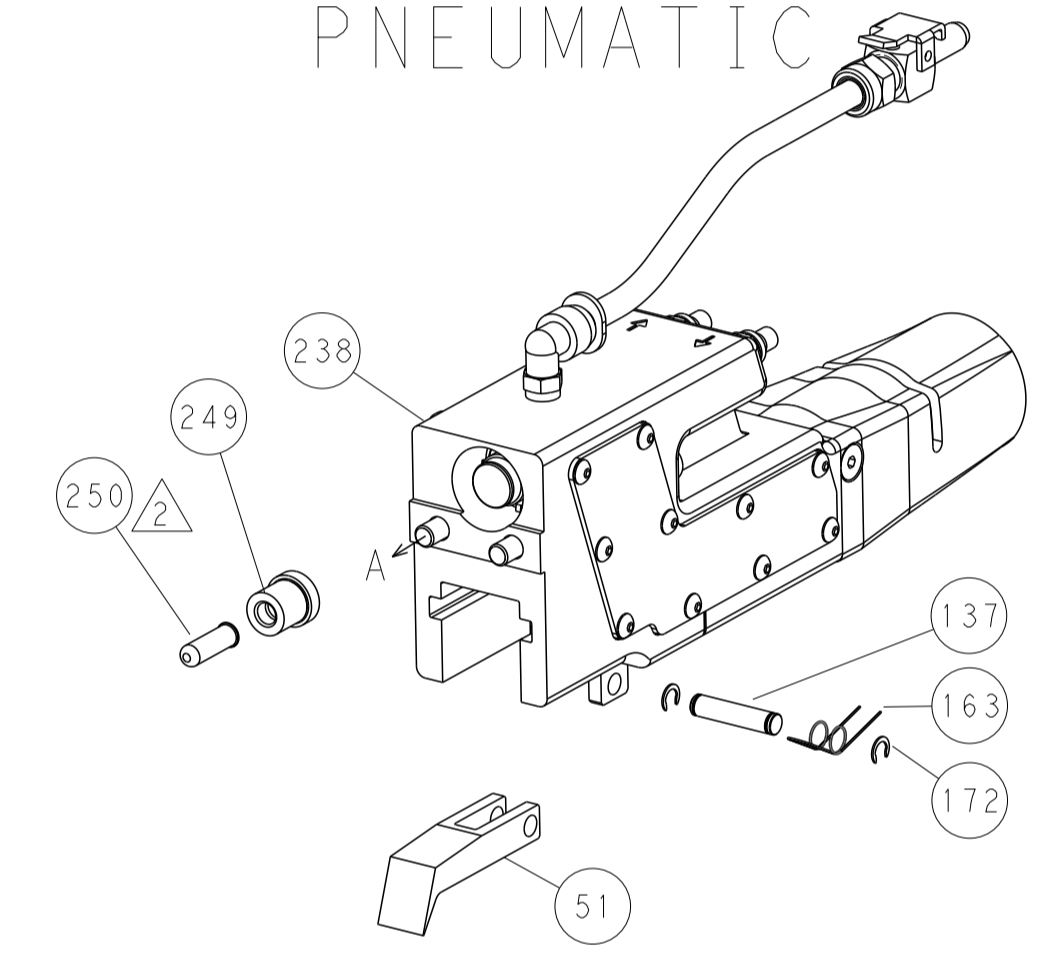


RAM AND HOLDDOWN SET-UP

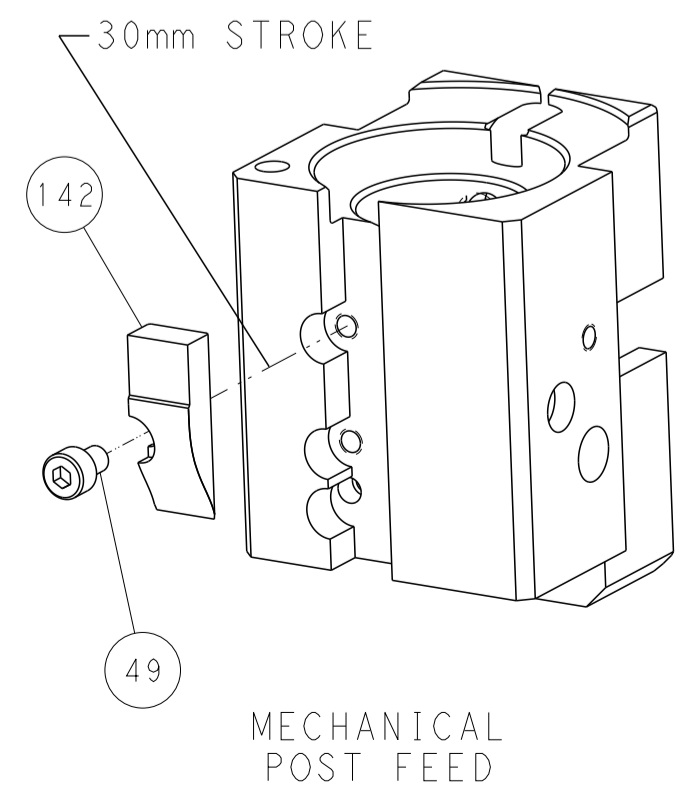
FEED TYPE  
MECHANICAL



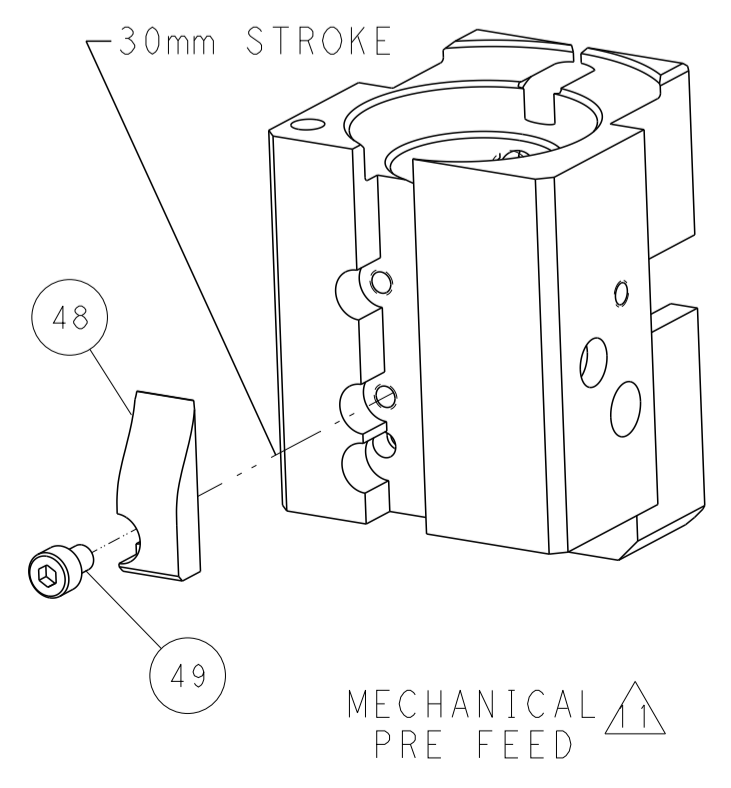
PNEUMATIC



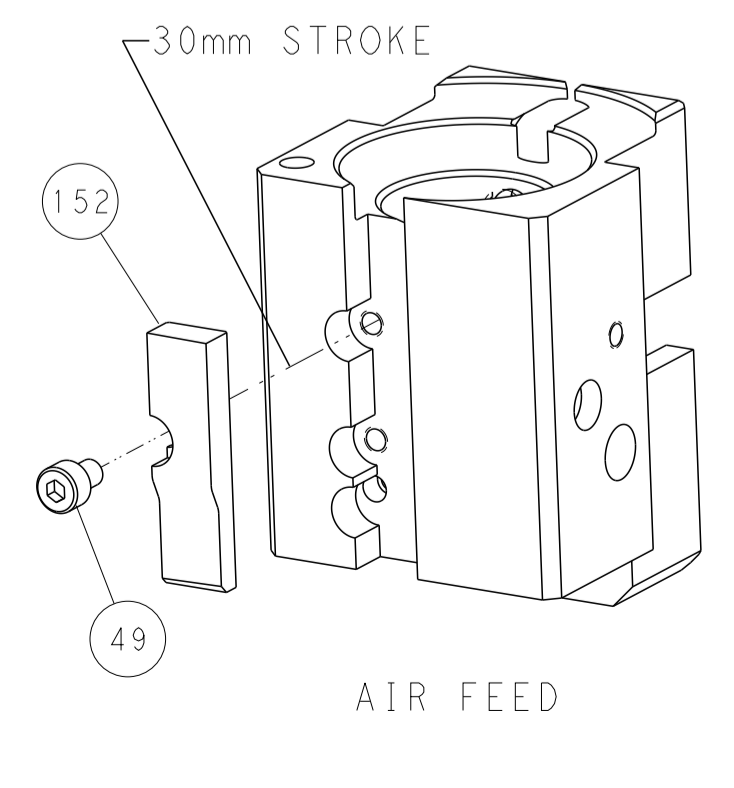
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER 29NOV2011		TE Connectivity	
mm	0 PLC	±		CHK: G. HOFFNER 29NOV2011	NAME: Ocean End Feed Applier		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELRLIN 29NOV2011	SIZE: A1		CAGE CODE: 00779
	2 PLC	±			DRAWING NO: C=2150016		RESTRICTED TO
	3 PLC	±			SCALE: 1:1		SHEET 4 OF 4
	4 PLC	±			REV: L		
	ANGLES	±			Customer Accessible Production Drawing		
	FINISH						