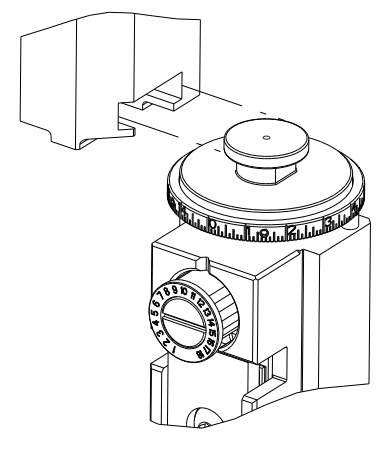


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150037-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150037-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150037-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm [.205-.235 IN]		Ø2.16-3.18 mm [.085-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-2025	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 60294-1	TE TERMINAL (A) 60294-2	TE TERMINAL (A) 62553-1	TE TERMINAL (A) 62553-3

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm [.205-.235 IN]		Ø2.16-3.18 mm [.085-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	(B) 114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL (B) 160691-1	TE TERMINAL (B) 160691-4	TE TERMINAL (B) 160691-7	
(B) 160691-2	(B) 160691-5	(B) 160645-1	
(B) 160691-3	(B) 160691-6	(B) 160645-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.35 +/- 0.05 [.053 +/- .002]	5.1
20 AWG	1.22 +/- 0.05 [.048 +/- .002]	6.7
22 AWG	1.17 +/- 0.05 [.046 +/- .002]	7.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32 +/- 0.05 [.052 +/- .002]	5.3
20 AWG	1.22 +/- 0.05 [.048 +/- .002]	6.7
22 AWG	1.14 +/- 0.05 [.045 +/- .002]	7.4

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- POSITION ITEM 51 TO FEED OFF THE INSULATION BARREL OF TERMINAL.
- 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.

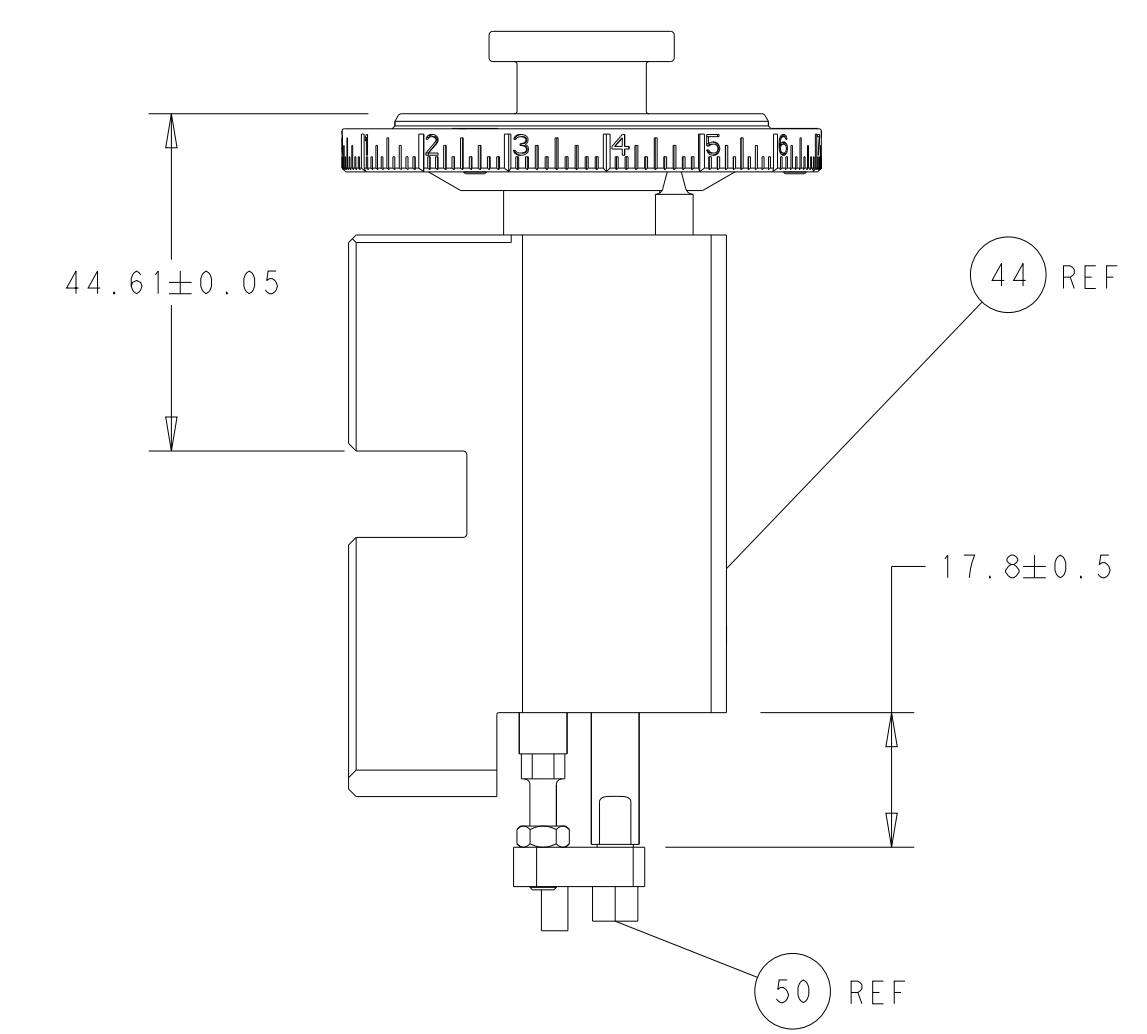
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66	C	26SEP2018	TB	TE
		D	10JUN2019	LG	TE
		E	10DEC2019	FJ	TE
		F	30MAR2022	FZ	TE

REV	DATE	DESCRIPTION	ITEM NO			
-	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	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	1976052-1	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	2063961-9	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	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	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	5-240641-8	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	2	1	1338673-6	ANVIL, COMBINATION	8
-	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	7-240641-4	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	2	1	1-456406-6	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO		
-				DESCRIPTION		
-				ITEM NO		

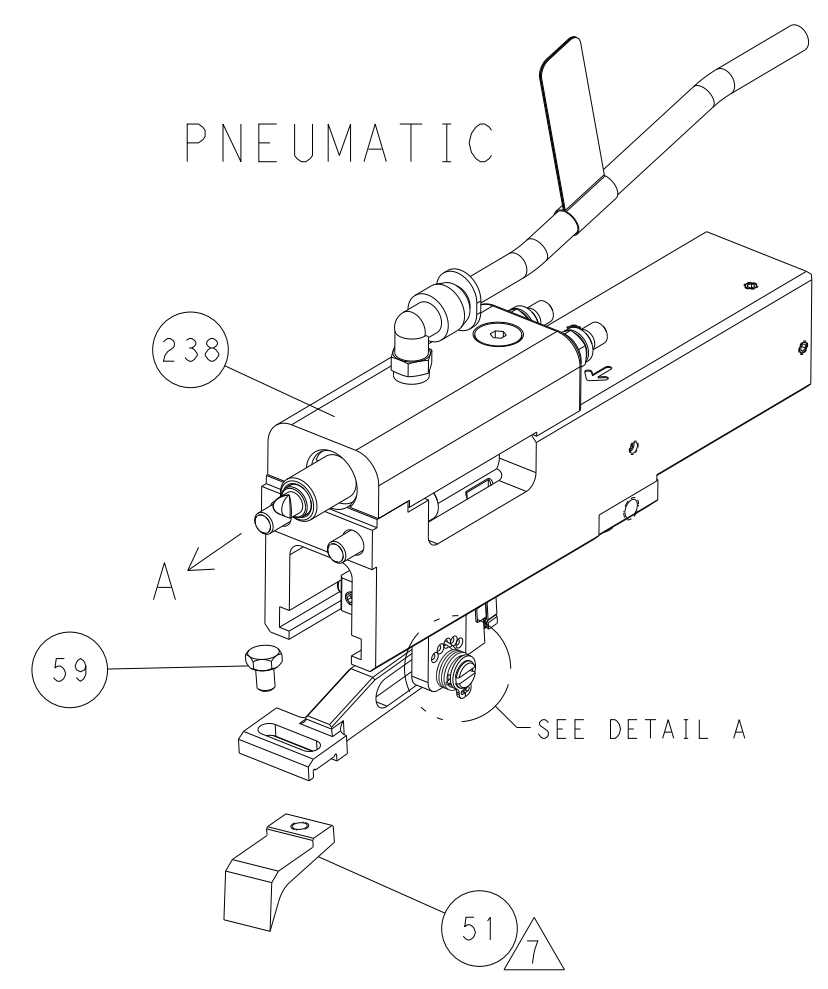
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APV		NAME				
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	ANGLES ±	FINISH ±				S. XI	12JAN2012			Ocean End Feed	Applicator			
MATERIAL										SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
										A1	00779	©=2150037		
										Customer Accessible Production Drawing	SCALE	1:1	SHEET 1 OF 4	REV F

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

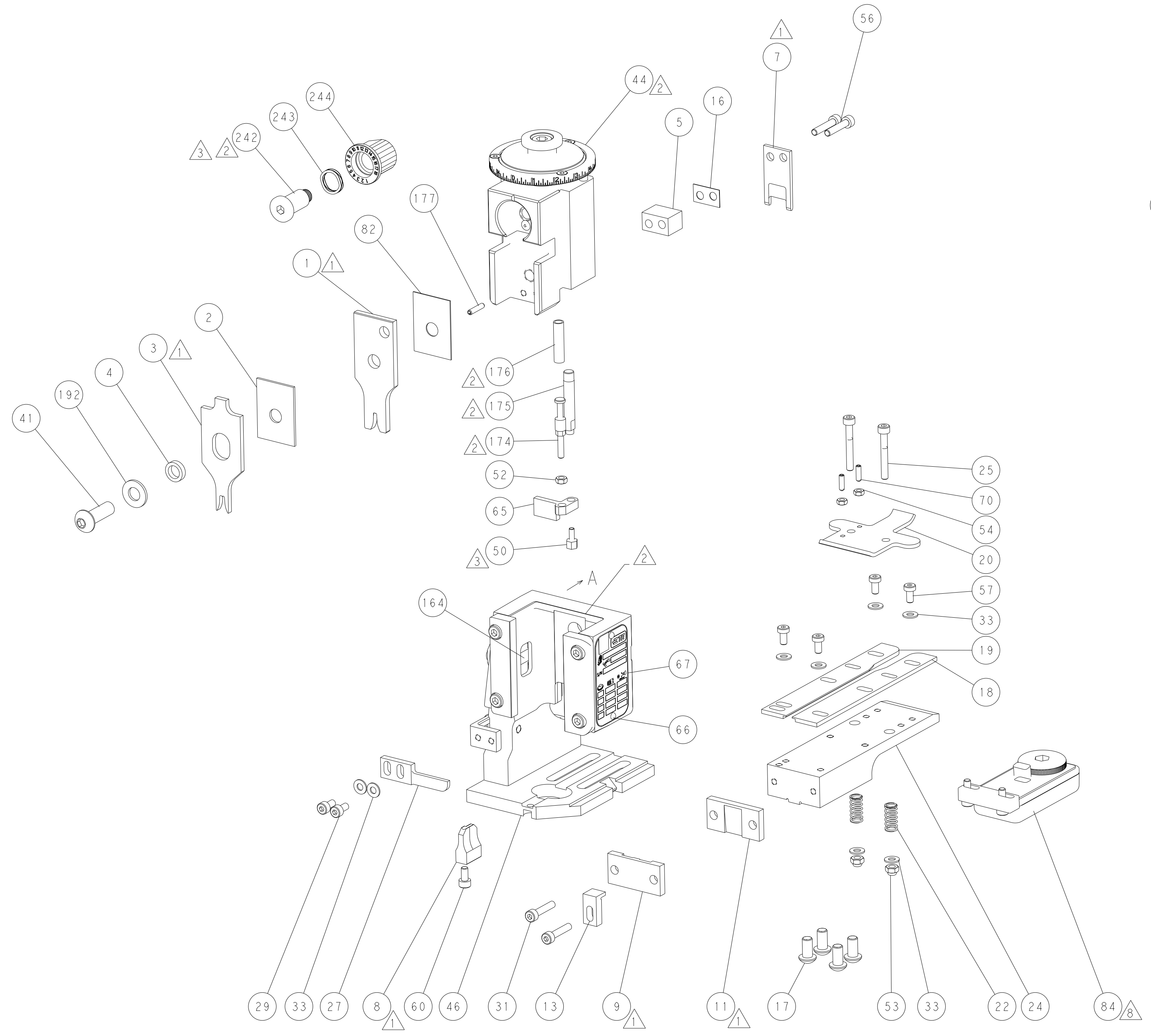
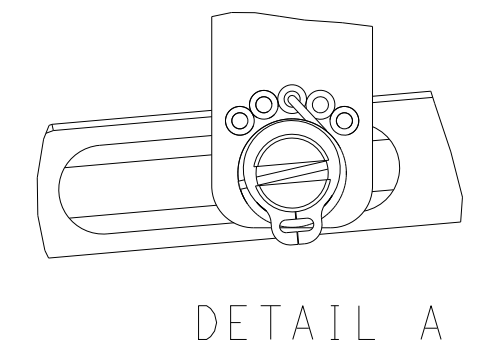


RAM AND HOLDDOWN SET-UP

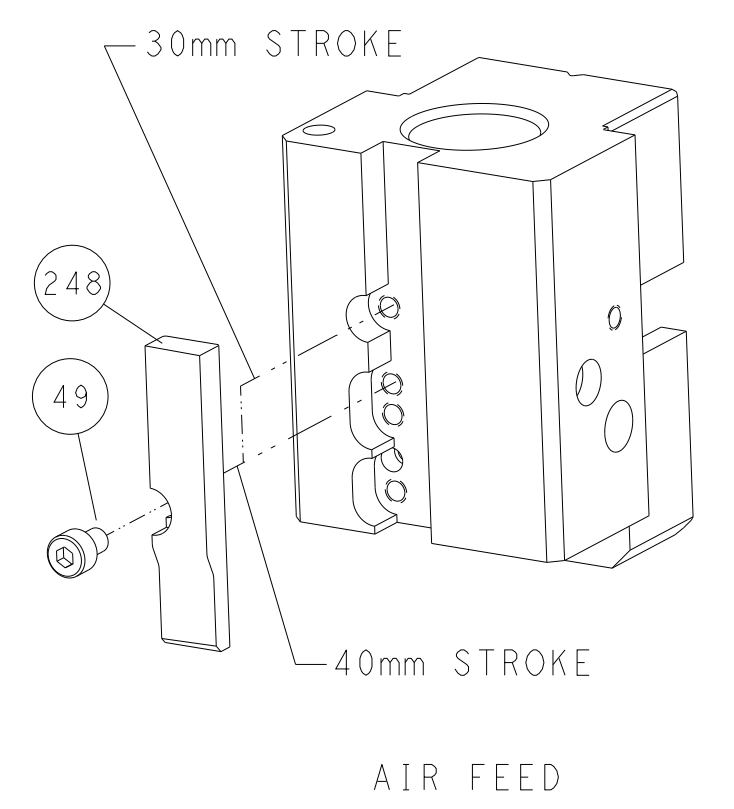
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



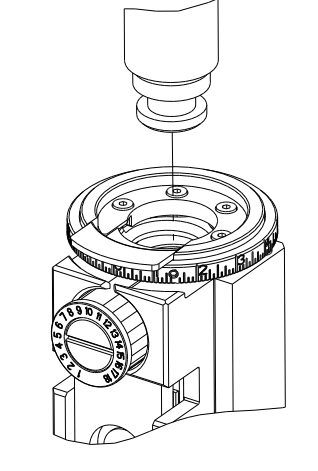
AIR FEED

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SCALE 1:1	RESTRICTED TO SIZE CAGE CODE DRAWING NO. 00779 ©=2150037 SHEET 2 OF 4 REV F
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150037-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150037-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.56 mm (.140)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm (.205-.235 IN)		∅2.16-3.18 mm (.085-.125 IN)	
TERMINAL APPLICATION SPECIFICATION	(A) 114-2025	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 60294-1	(A) 60294-2	(A) 62553-1	(A) 62553-3

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.21-5.97 mm (.205-.235 IN)		∅2.16-3.18 mm (.085-.125 IN)	
TERMINAL APPLICATION SPECIFICATION	(B) 114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 160691-1	(B) 160691-4	(B) 160691-7	
(B) 160691-2	(B) 160691-5	(B) 160645-1	
(B) 160691-3	(B) 160691-6	(B) 160645-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.35 +/- 0.05 [0.053 +/- .002]	5.1
20 AWG	1.22 +/- 0.05 [0.048 +/- .002]	6.7
22 AWG	1.17 +/- 0.05 [0.046 +/- .002]	7.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32 +/- 0.05 [0.052 +/- .002]	5.3
20 AWG	1.22 +/- 0.05 [0.048 +/- .002]	6.7
22 AWG	1.14 +/- 0.05 [0.045 +/- .002]	7.4

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- POSITION ITEM 51 TO FEED OFF THE INSULATION BARREL OF TERMINAL.
- 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.

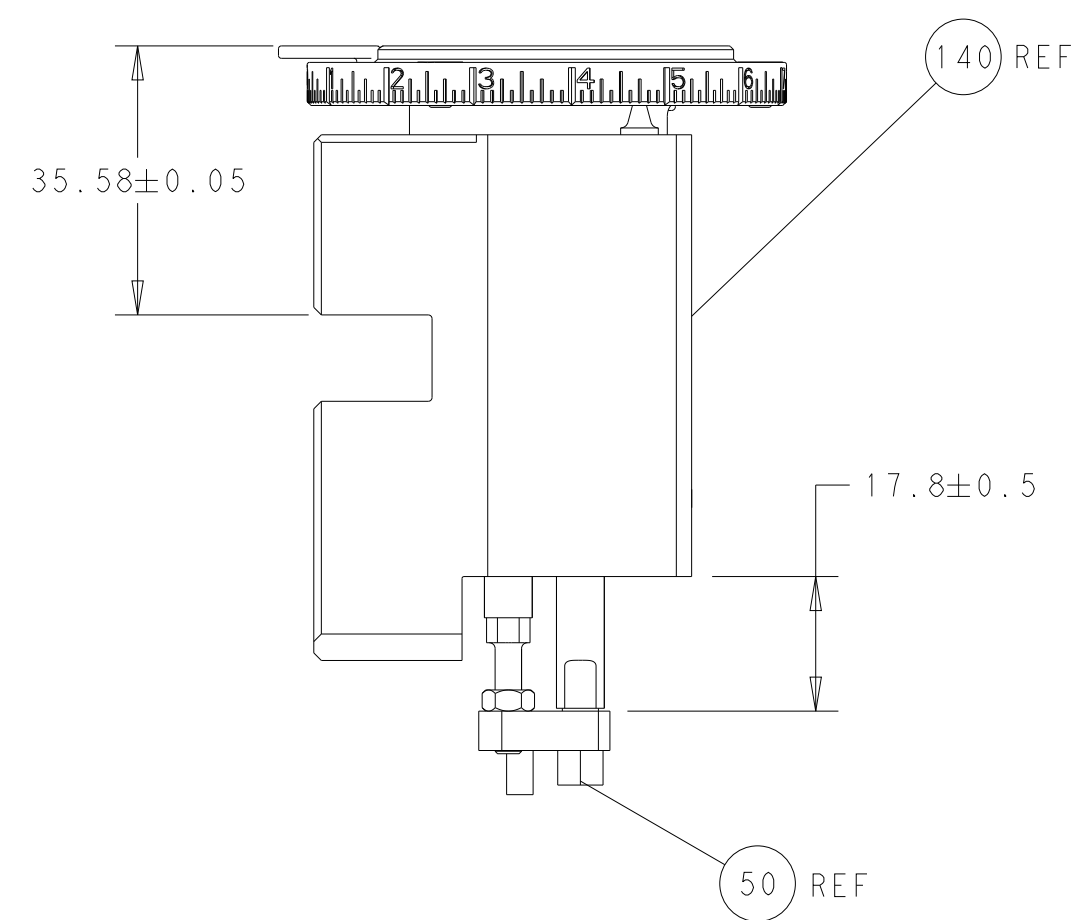
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS				
A	66	P	LTN	DATE	OWN	APVD
		-	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	2844940-4	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	1976052-1	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-9	FEED FINGER	51
-	1	1752354-3	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-8	STRIP GUIDE, REAR	19
-	1	1-1901695-8	STRIP GUIDE, FRONT	18
-	1	5-240641-8	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1338673-6	ANVIL, COMBINATION	8
-	1	1-2217206-3	BLADE, SLUG	7
-	1	7-240641-4	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-2	SPACER, CRIMPER	2
-	1	1-456406-6	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

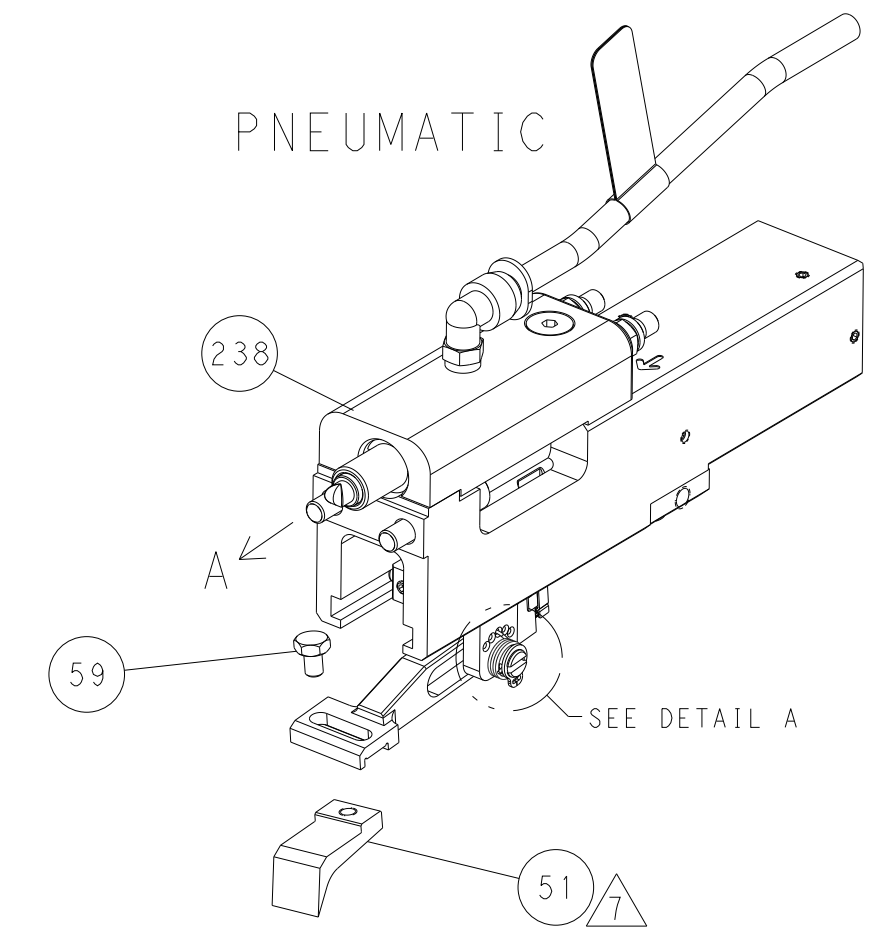
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	12JAN2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	12JAN2012	
	3 PLC ±	4 PLC ±	ANGLES ±	G. BAILEY		
	FINISH			S. XI	12JAN2012	
MATERIAL		WEIGHT		APVD		NAME
						Ocean End Feed Applicator
						SIZE
						A1 00779
						CAGE CODE
						00779
						DRAWING NO
						2150037
						RESTRICTED TO
						-
						Customer Accessible Production Drawing
						SCALE
						1:1
						SHEET
						3 of 4
						REV
						F

LOC	DIST	REV	DATE	BY	APPV
A	66				

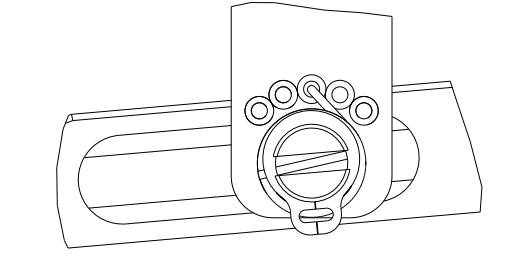


RAM AND HOLDDOWN SET-UP

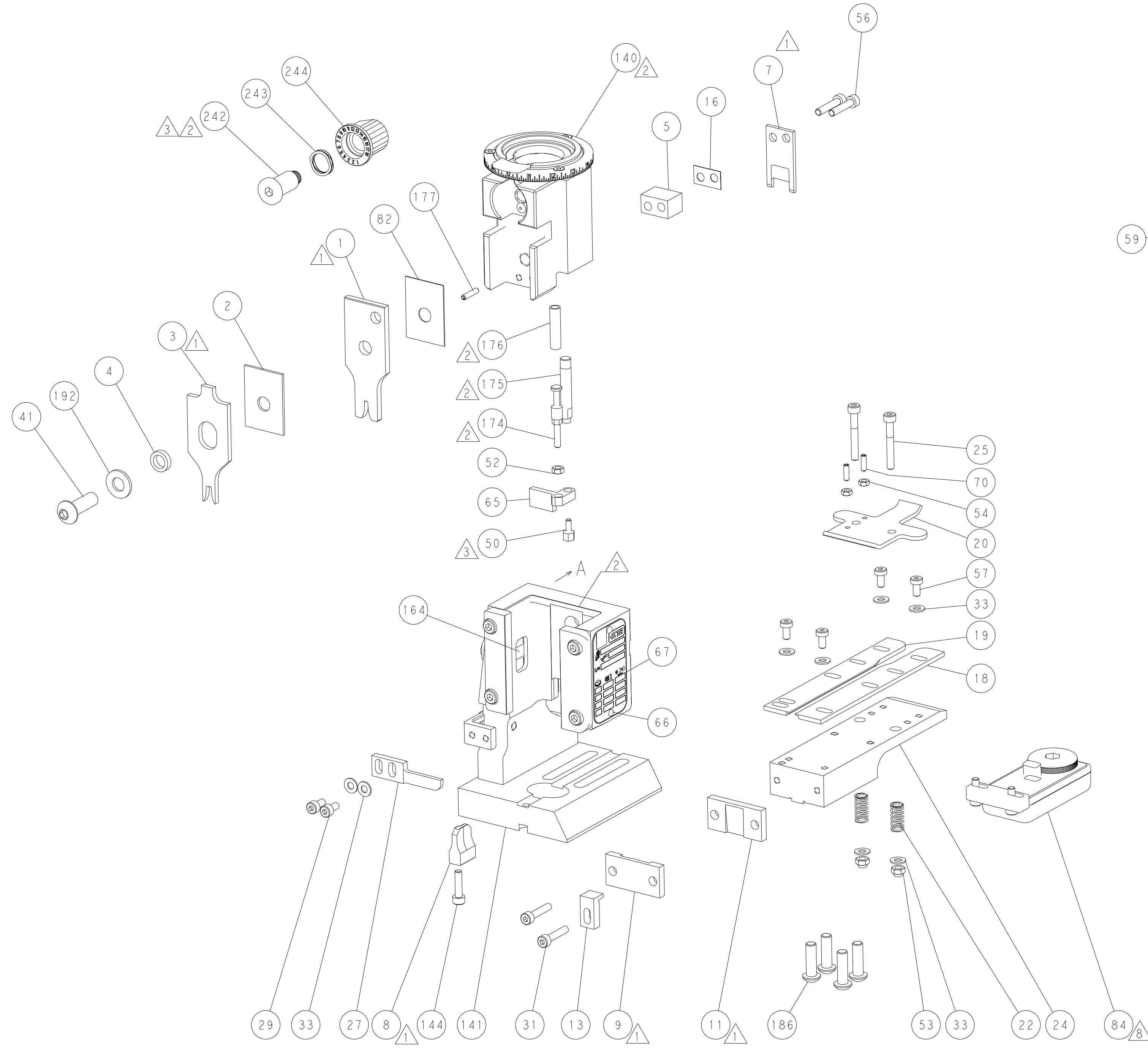
FEED TYPE



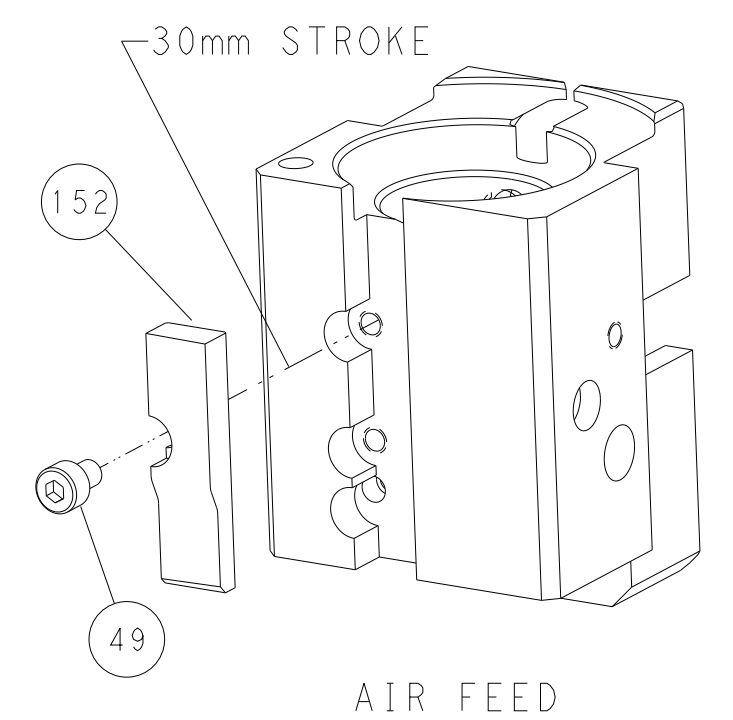
FEED SPRING SETTING POSITION



DETAIL A



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)

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150037	RESTRICTED TO F
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 4 of 4 REV: F