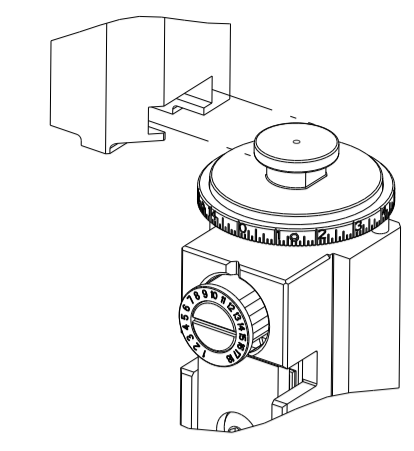


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150297-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150297-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150297-7	F	CRIMP TOOLING KIT	-

SUPERSEDED BY 4150155-2
 SUPERSEDED BY 7-4150155-2

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: RECPT, POSITIVE LOCK, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.17 mm [.173-.204 IN]		Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63119-1	63119-2	2238156-1	2238156-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, POSITIVE LOCK, .250 SERIES, HI TEMP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.17 mm [.173-.204 IN]		Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238139-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.45+/-0.05 [.057+/-0.002]	10.5
20 AWG	1.35+/-0.05 [.053+/-0.002]	11.4
22 AWG	1.30+/-0.05 [.051+/-0.002]	11.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.55+/-0.05 [.061+/-0.002]	10.5
20 AWG	1.45+/-0.05 [.057+/-0.002]	11.4
22 AWG	1.37+/-0.05 [.054+/-0.002]	11.7

- 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 ITEMS 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 IS NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	E		ECR-20-004811	01APR2020	MZ	YY
		F		ECR-21-003364	18MAR2021	JWC	RR
		G		ECR-22-130101	21FEB2022	FZ	TE
		G1		ECR-23-170227	23MAR2023	LG	TE

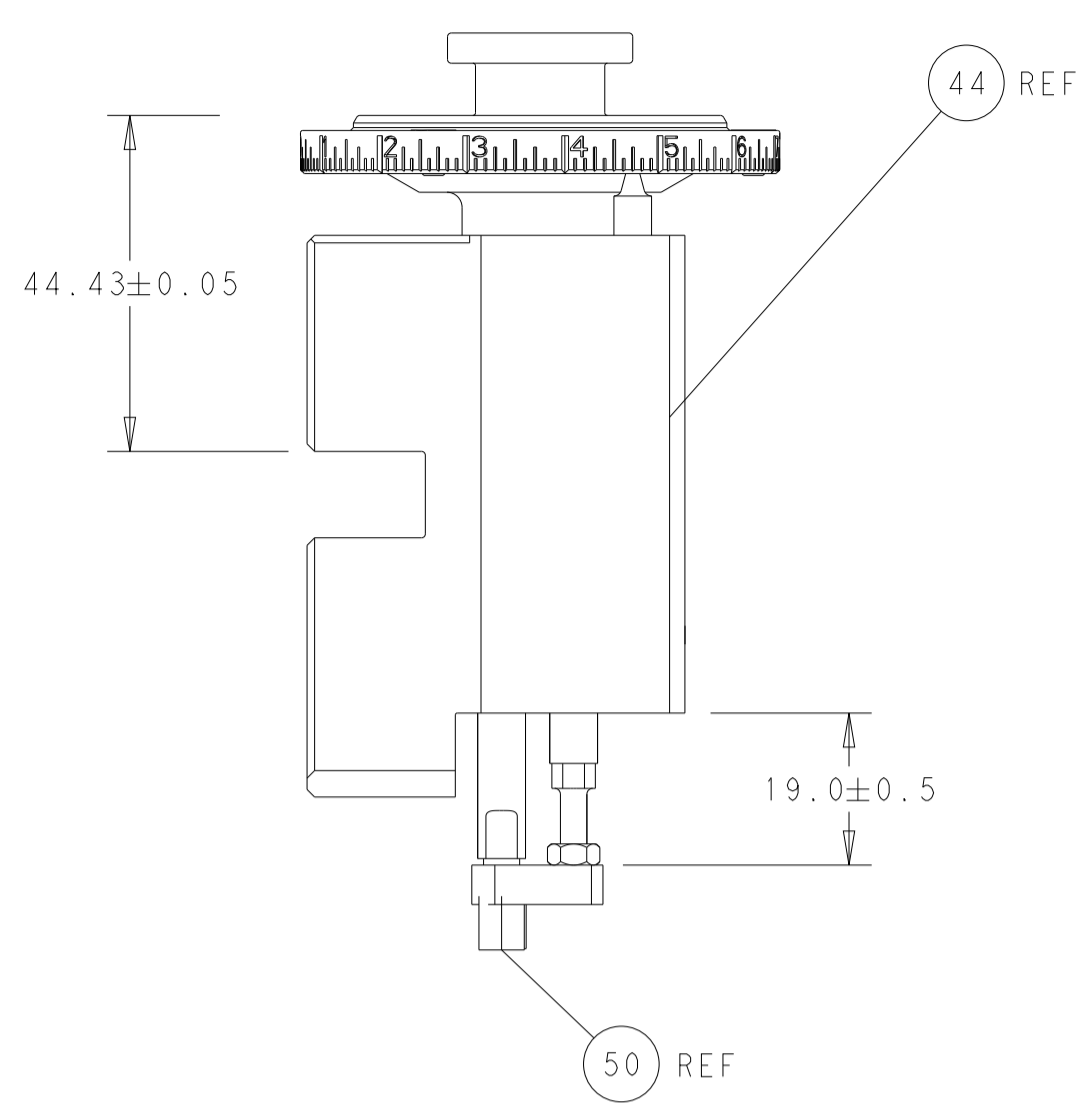
-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	6-993111-6	PIN, SLOTTED SPRING 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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	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
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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
-	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	2-1752371-2	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	240641-1	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
	1	1	240833-3	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	1	1	690482-7	PLATE, FRONT SHEAR	9
	1	2	3-1803615-9	ANVIL, COMBINATION, END FEED	8
	1	1	3-690474-9	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-7	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
	1	2	3-1803762-2	CRIMPER, WIRE F	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)

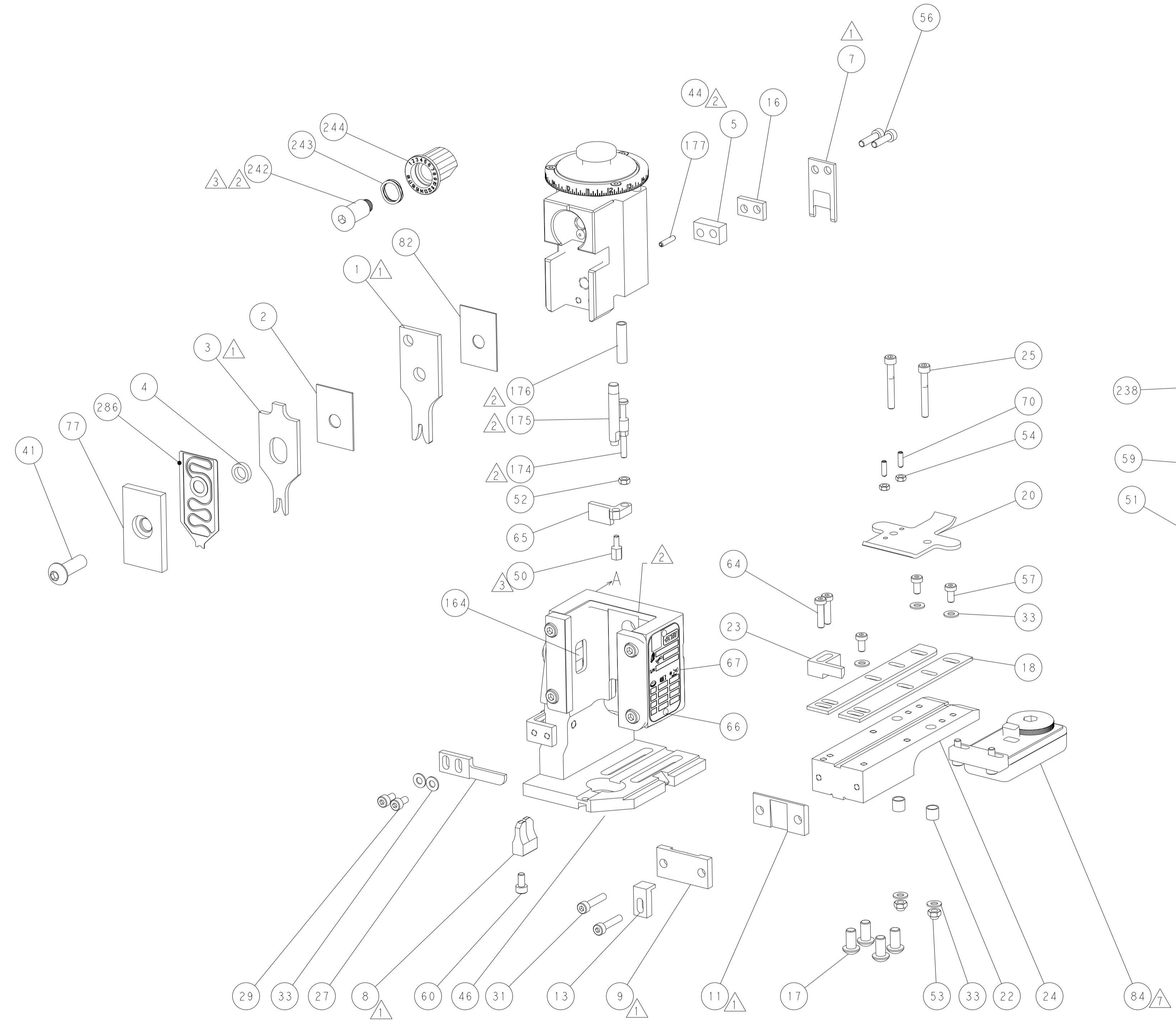
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

DWN	H. HUANG	29OCT2012
CHK	S. XI	29OCT2012
APVD	S. XI	29OCT2012
NAME	Ocean End Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150297
Customer Accessible Production Drawing		
SCALE	1:1	SHEET 1 OF 4
REV	G1	

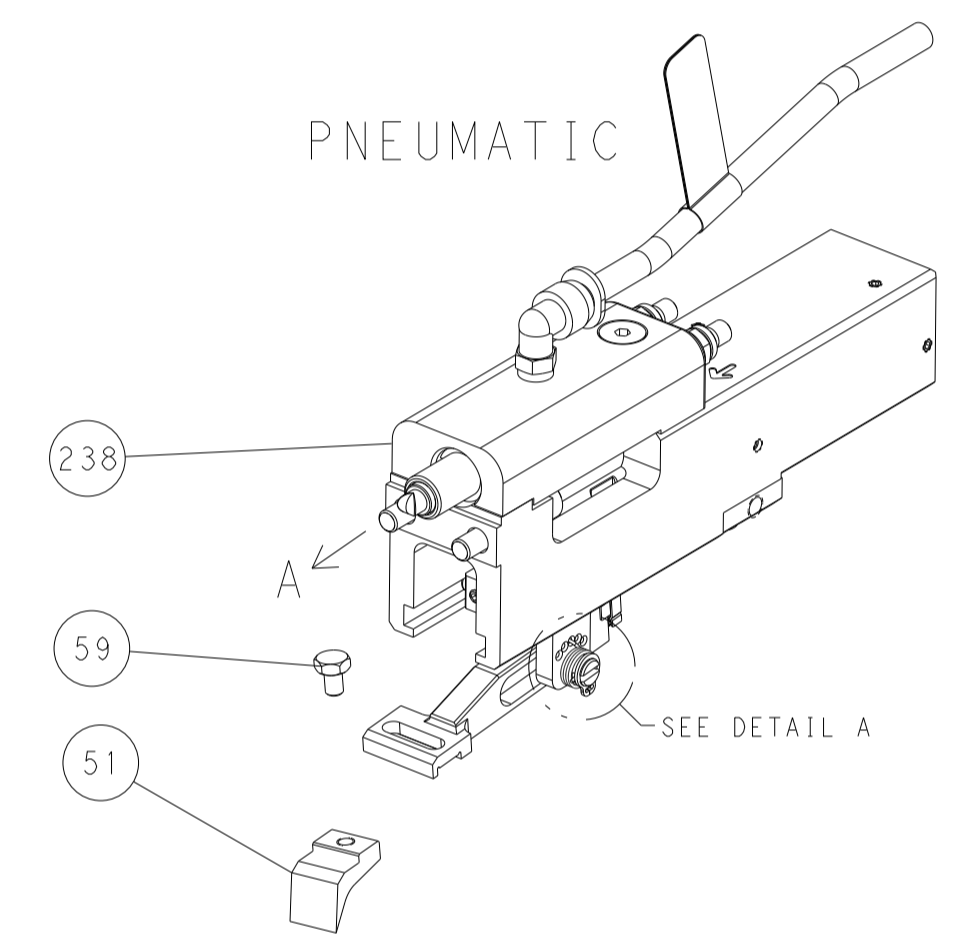
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P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	-	SEE SHEET 1	-	-	-



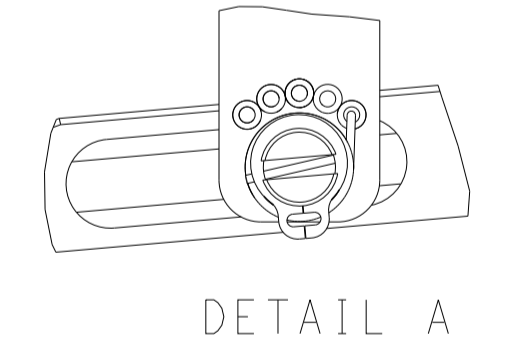
RAM AND HOLDDOWN SET-UP



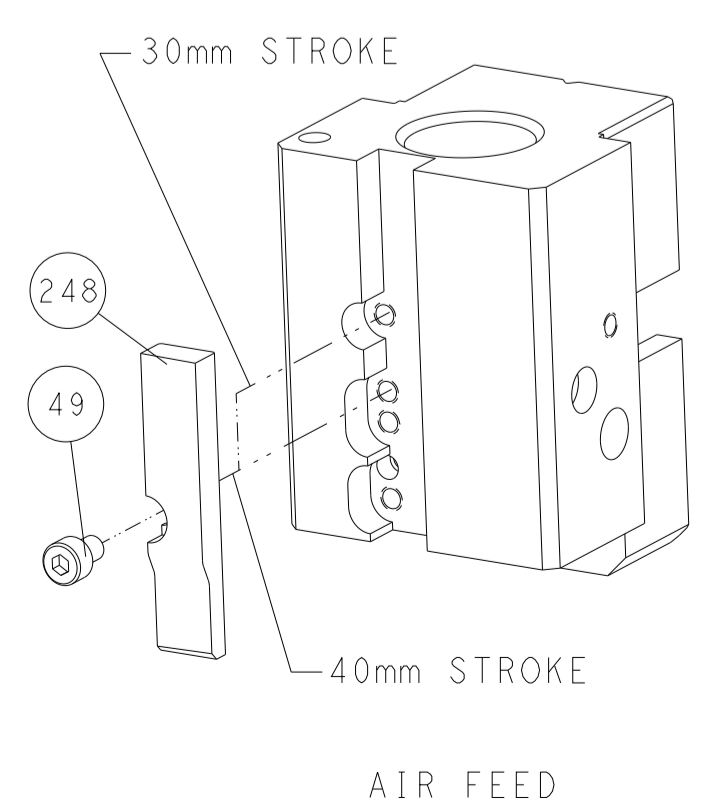
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



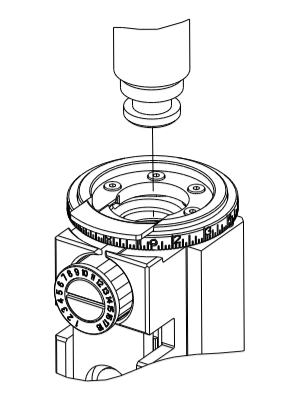
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 29OCT2012		CHK S. XI 29OCT2012		APVD S. XI 29OCT2012		NAME Ocean End Feed Applier	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2150297	RESTRICTED TO
MATERIAL	WEIGHT		SCALE 1:1		SHEET 2 of 4		REV G1		Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150297-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150297-7	F	CRIMP TOOLING KIT	-

SUPERSEDED BY 2-4150155-2

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [1.40]	F

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECPT, POSITIVE LOCK, .250 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.17 mm [.173-.204 IN]	Ø1.52-2.54 mm [.060-.100 IN]

TERMINAL APPLICATION SPECIFICATION 114-2074

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63119-1	63119-2	2238156-1	2238156-2

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECPT, POSITIVE LOCK, .250 SERIES, HI TEMP

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.17 mm [.173-.204 IN]	Ø1.52-2.54 mm [.060-.100 IN]

TERMINAL APPLICATION SPECIFICATION 114-2074

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238139-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.45+/-0.05 [.057+/-0.002]	10.5
20 AWG	1.35+/-0.05 [.053+/-0.002]	11.1
22 AWG	1.30+/-0.05 [.051+/-0.002]	11.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.55+/-0.05 [.061+/-0.002]	10.5
20 AWG	1.45+/-0.05 [.057+/-0.002]	11.4
22 AWG	1.37+/-0.05 [.054+/-0.002]	11.7

- 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 ITEMS 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 IS NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

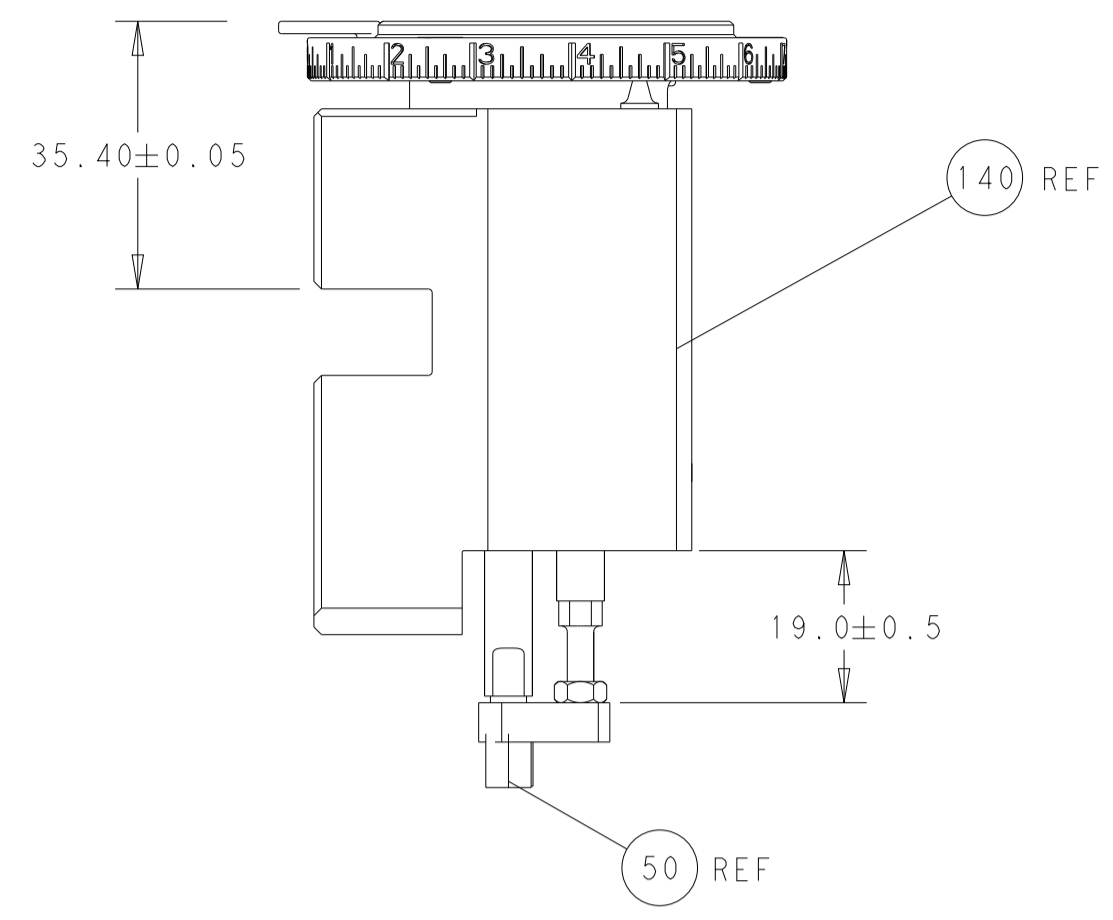
LOC	DIST	REV	DATE	BY	CHKD	APPD
A	66					

REV	DATE	DESCRIPTION	ITEM NO	
-	1	2119791-5	DEPRESSOR, WIRE	286
-	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
-	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	455888-6	SPACER, CRIMPER	82
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	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
-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2063961-1	FEED FINGER	51
-	1	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
-	7	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	2-1752371-2	PLATE, STRIP GUIDE	24
-	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	240641-1	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240833-3	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-7	PLATE, FRONT SHEAR	9
-	1	3-1803615-9	ANVIL, COMBINATION, END FEED	8
-	1	3-690474-9	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-7	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
-	1	3-1803762-2	CRIMPER, WIRE F	1

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

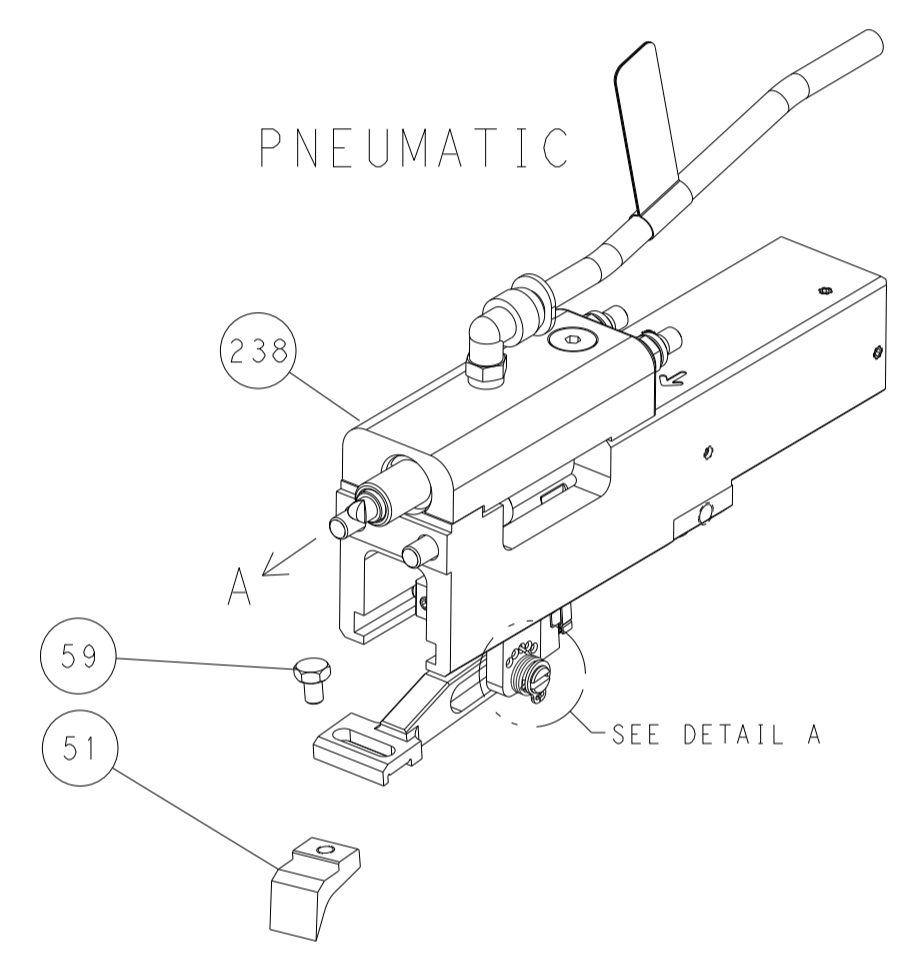
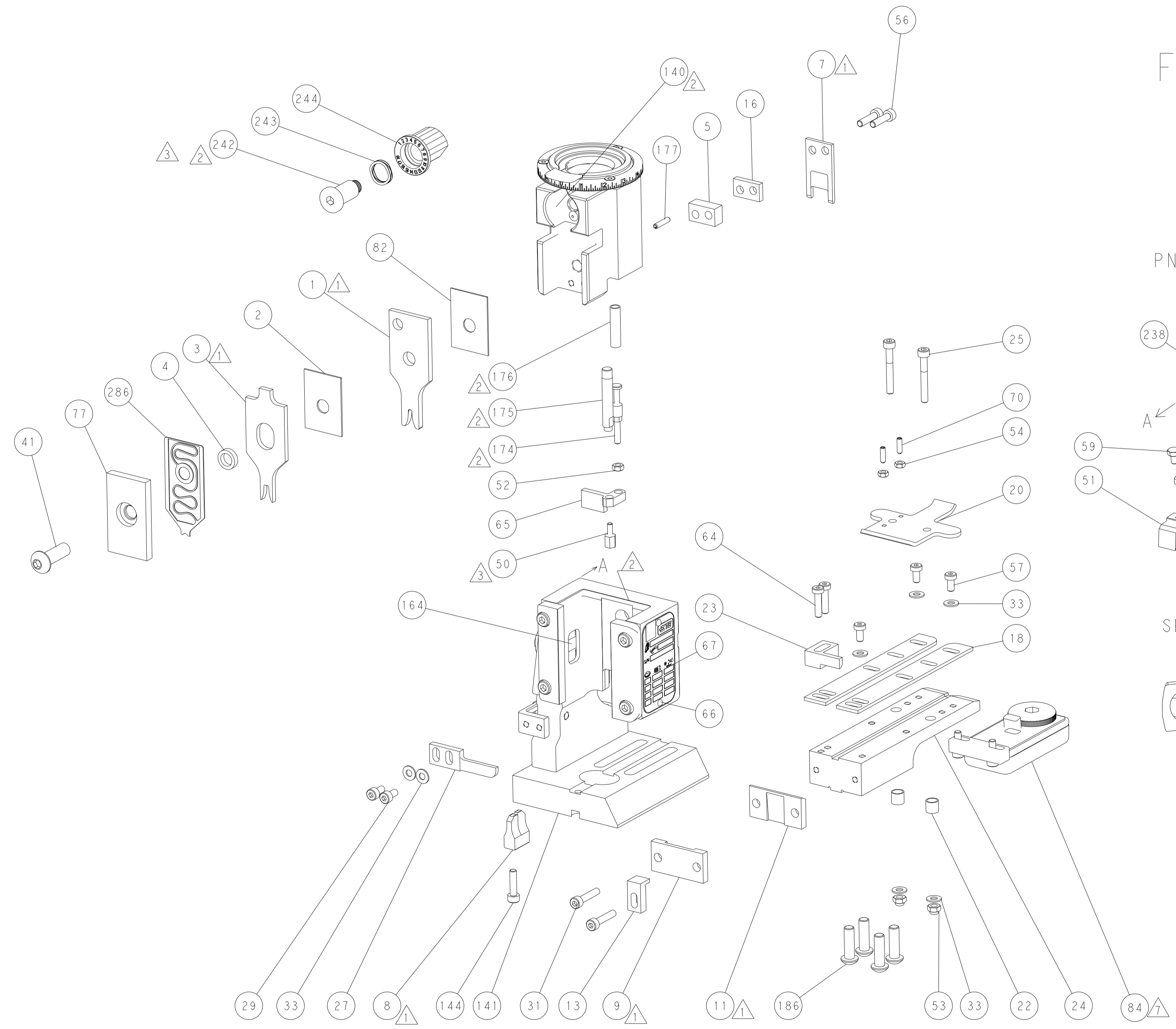
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	CHK	DATE	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	H. HUANG	29OCT2012	S. XI
MATERIAL		APPD	29OCT2012	PRODUCT SPEC
		APPLICATION SPEC		
		WEIGHT		
		SCALE	1:1	SHEET 3 OF 4
		REV	G1	

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

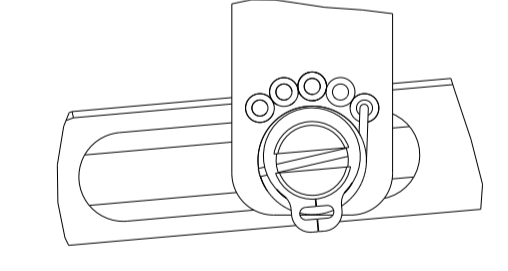


RAM AND HOLDDOWN SET-UP

FEED TYPE

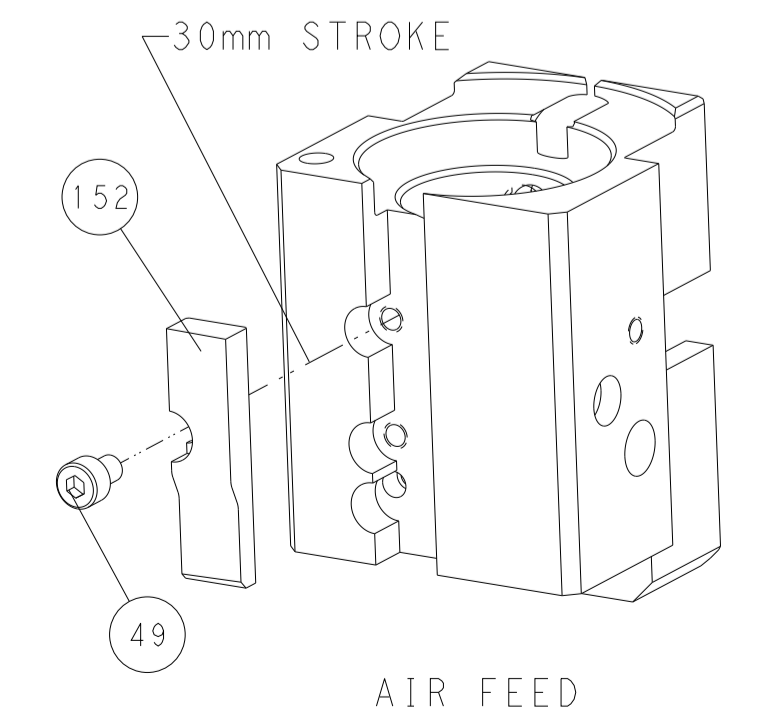


FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG CHK: S. XI APVD: S. XI	29OCT2012 29OCT2012 29OCT2012	NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150297 SCALE: 1:1 SHEET: 4 OF 4 REV: G1	STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	