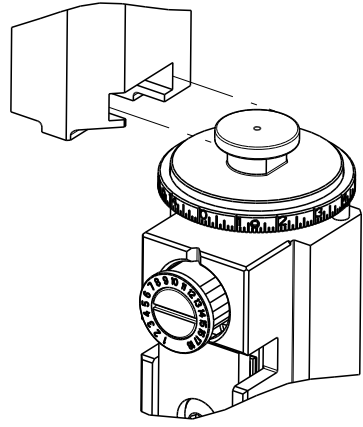
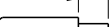


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150090-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150090-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150090-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POS LOCK MK II REC			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		 INSULATION DIAMETER RANGE Ø1.50-3.10 mm [.059-.122 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-5042	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170327-1 			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.81mm2	1.63+/-0.05 [.064+/- .002]	6.5
0.75mm2	1.61+/-0.05 [.063+/- .002]	6.7
0.50mm2	1.47+/-0.05 [.058+/- .002]	8.1
0.30mm2	1.41+/-0.05 [.056+/- .002]	8.7



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 180.

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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

7 FEED MUST BE SET OFF OF INSULATION BARREL.

*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)

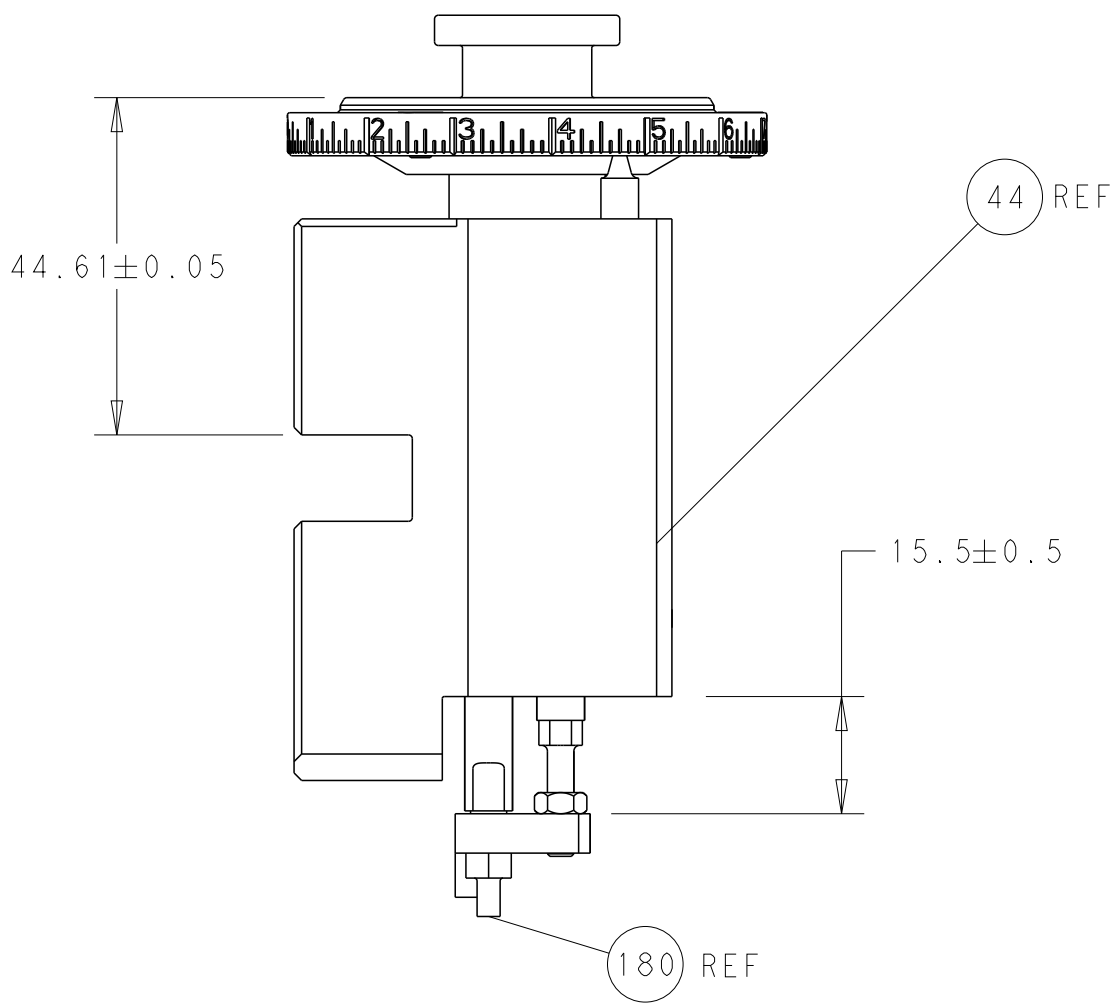
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		B		ECR-19-001361	26JAN2019	TB	CT
		C		ECR-19-011869	29JUL2019	TB	TE

	-	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	2844940-4	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1-1976055-8	STANDOFF, HOLD-DOWN	180
	-	1	1	1-1976053-7	LOCATER BLOCK,TERMINAL	179
	-	1	1	6-9931111-6	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	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	1-1901681-5	HOLDDOWN, TERMINAL	65
	-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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
7	-	1	1	2063961-1	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
	-	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	1-1752371-7	PLATE, STRIP GUIDE	24
	-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-2	DRAG	20
	-	2	2	1901259-5	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	1	240833-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	2	1	8-1633383-0	ANVIL, COMBINATION	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
	-	1	1	6-240641-8	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
	-77	-72	-2	PART NO	DESCRIPTION	ITEM NO

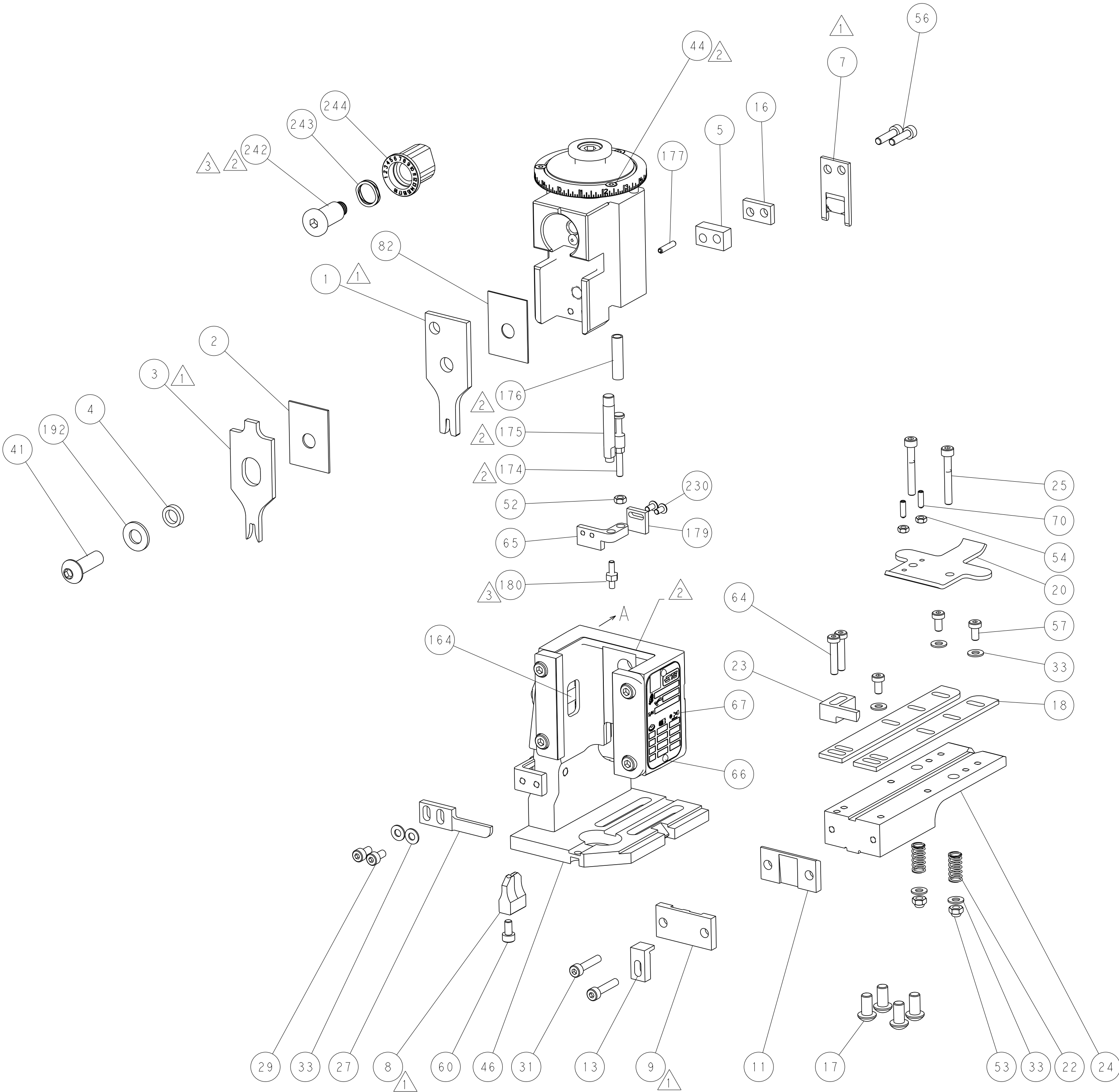
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST EDITION.				DWN R. HUANG	08MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK S. XI	08MAY2012	NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		Ocean End Feed Applicator	
MATERIAL		-		APPLICATION SPEC		-	
-		-		WEIGHT		RESTRICTED TO	
-		-		A1		-	
Customer Accessible Production Drawing		SCALE		1:1		SHEET 1 OF 4	
-		-		-		REV C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

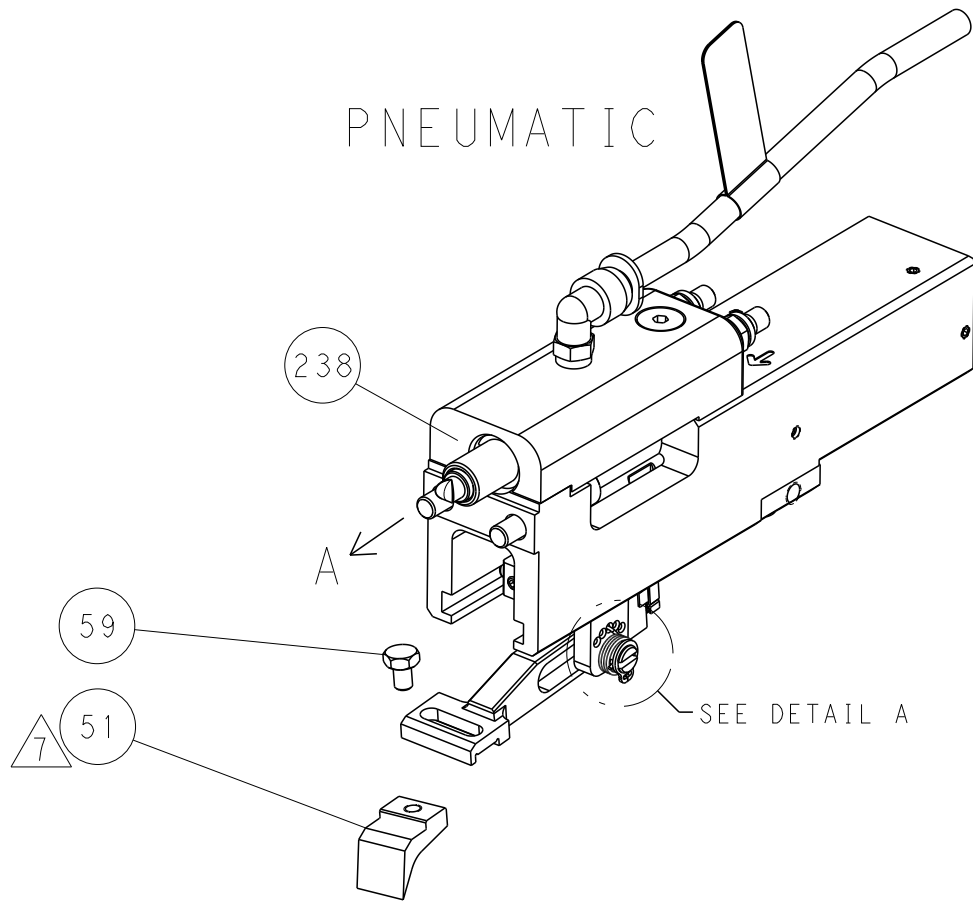
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		P	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-



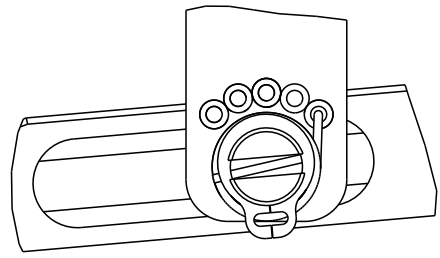
RAM AND HOLDDOWN SET-UP



FEED TYPE

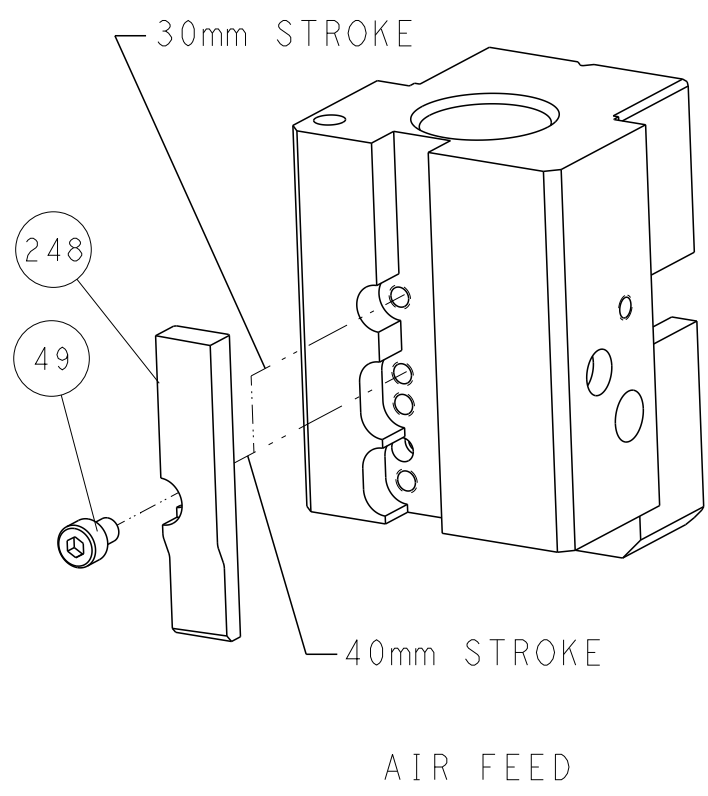


FEED SPRING SETTING POSITION



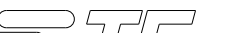
DETAIL A

CAM POSITION



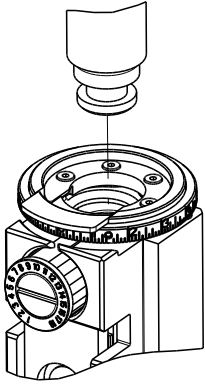
AIR FEED

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

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI PRODUCT SPEC -	08MAY2012		NAME Ocean End Feed Applicator -				
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APPLICATION SPEC -			SIZE A1	CAGE CODE 00779	DRAWING NO C=2150090	RESTRICTED TO -	
MATERIAL -		-		WEIGHT -			Customer Accessible Production Drawing			SCALE 1:1	SHEET 2 of 4

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150090-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150090-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POS LOCK MK II REC			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE Ø1.50-3.10 mm [.059-.122 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170327-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.81mm2	1.63+/-0.05 [.064+/- .002]	6.5
0.75mm2	1.61+/-0.05 [.063+/- .002]	6.7
0.50mm2	1.47+/-0.05 [.058+/- .002]	8.1
0.30mm2	1.41+/-0.05 [.056+/- .002]	8.7



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- FEED MUST BE SET OFF OF INSULATION BARREL.

*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	LTR	DESCRIPTION	DATE
					-	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
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1-1976055-8	STANDOFF, HOLD-DOWN	180
-	1	1-1976053-7	LOCATER BLOCK,TERMINAL	179
-	1	6-9931111-6	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	455888-6	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	1-1901681-5	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	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	1-1752371-7	PLATE, STRIP GUIDE	24
-	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-2	DRAG	20
-	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	240641-1	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-4	PLATE, FRONT SHEAR	9
1	1	8-1633383-0	ANVIL, COMBINATION	8
-	1	1-2217206-0	BLADE, SLUG	7
-	1	6-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-9	SPACER, CRIMPER	2
1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				CHK -	-	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APVD S. XI	08MAY2012	SIZE CAGE CODE DRAWING NO 00779 ©=2150090	
MATERIAL -				APPLICATION SPEC -	-	RESTRICTED TO -	
Customer Accessible Production Drawing				WEIGHT -	-	SCALE 1:1	
				SHEET 3 OF 4		REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

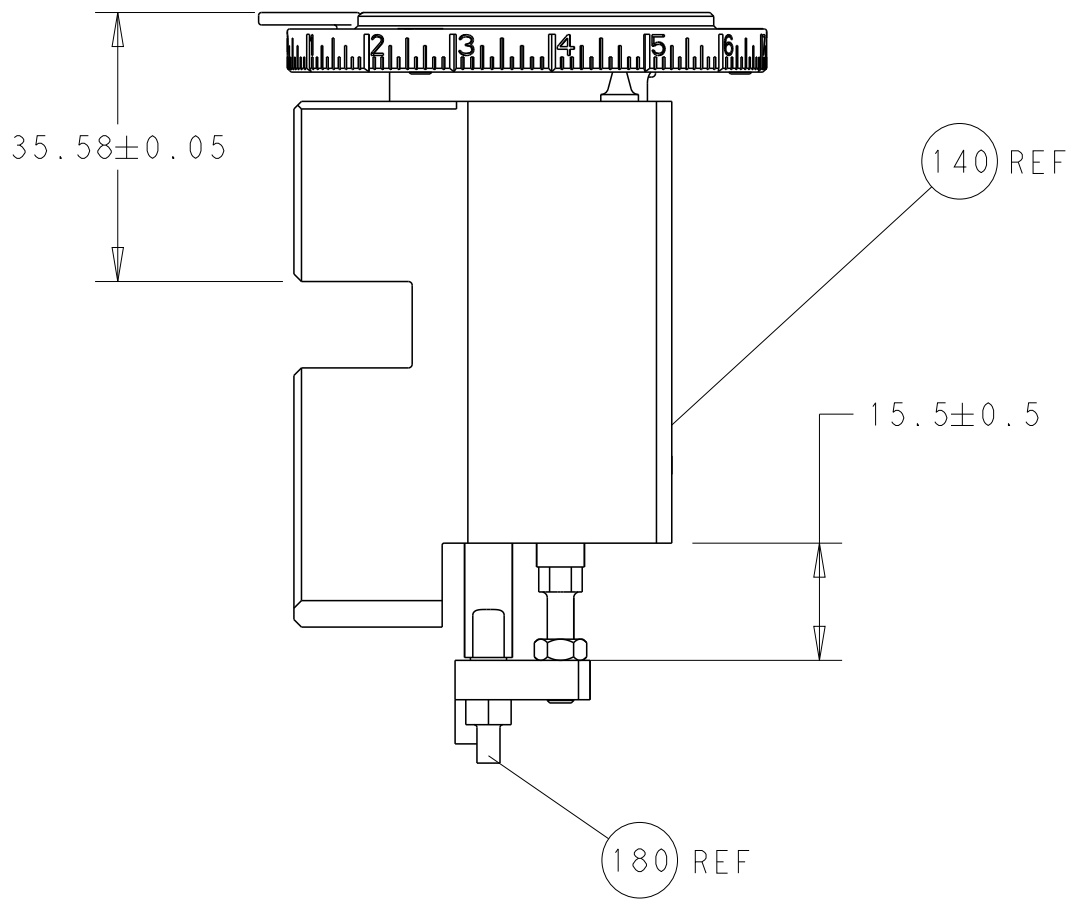
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A

C

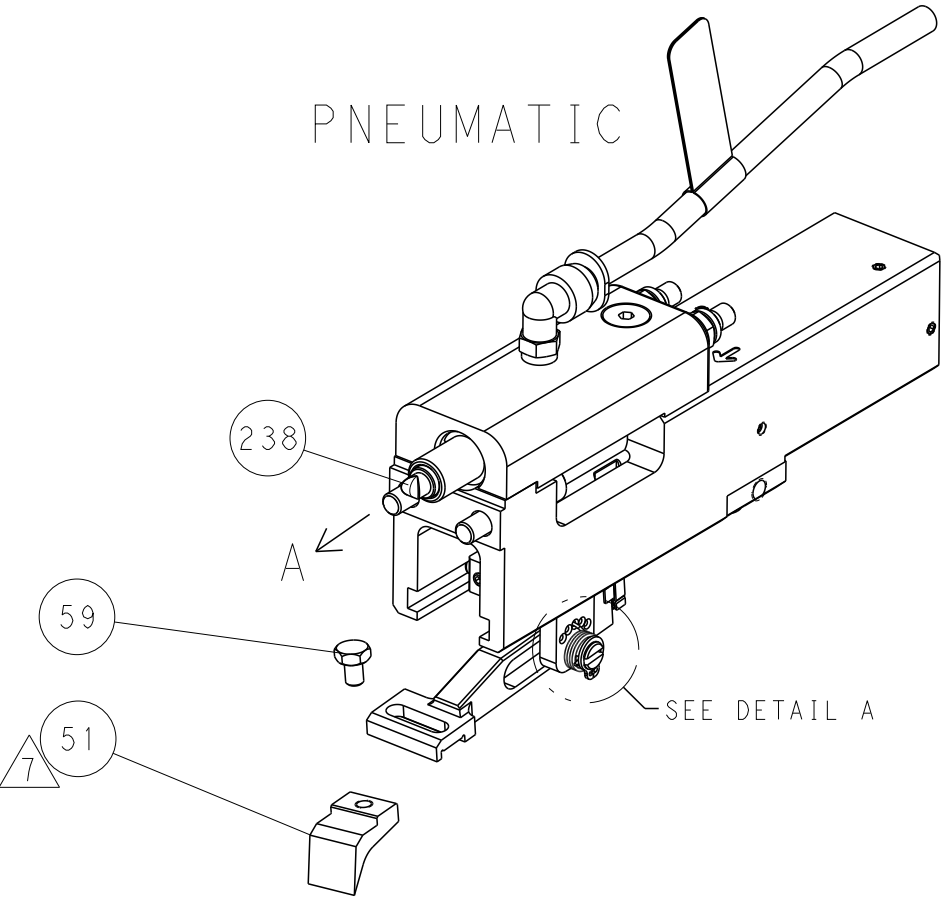
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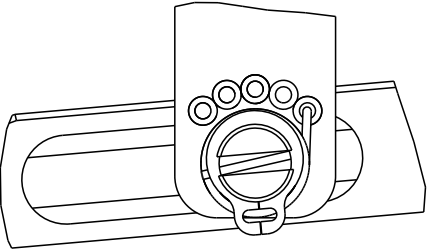


RAM AND HOLDDOWN SET-UP

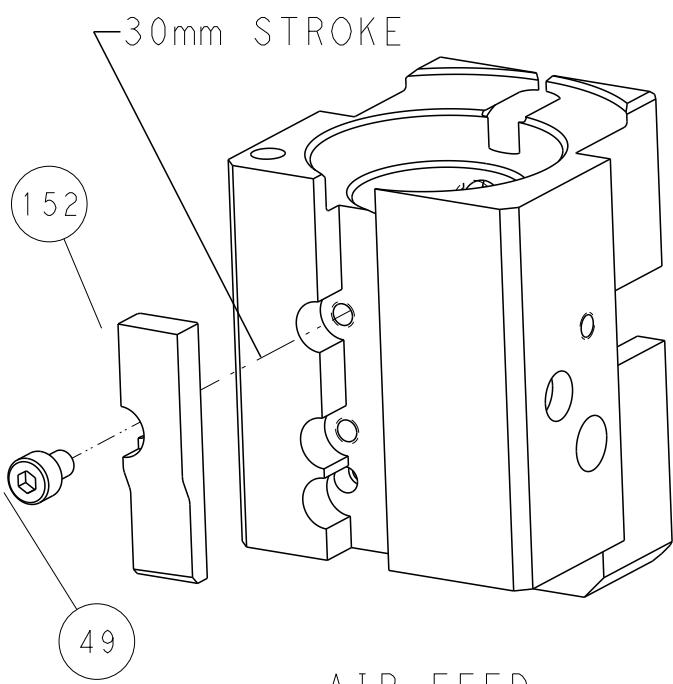
FEED TYPE



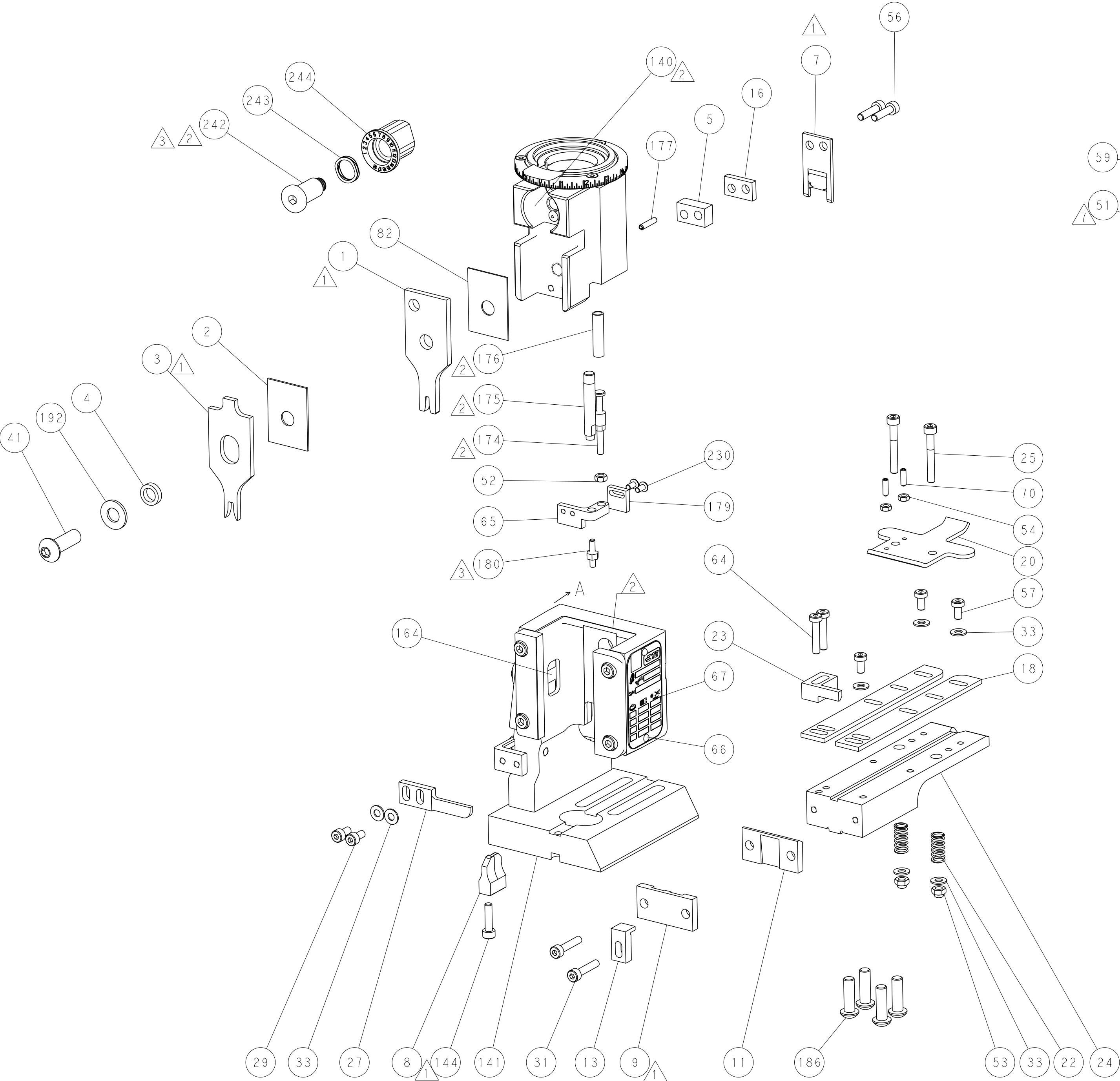
FEED SPRING SETTING POSITION



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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				CHK	-	-	Harrisburg, PA 17105-3608						
				APVD	S. XI	08MAY2012	NAME Ocean End Feed Applicator						
				PRODUCT SPEC									
				APPLICATION SPEC									
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO						
				A1	00779	C=2150090	-						
				Customer Accessible Production Drawing		SCALE	1:1	SHEET	4	OF	4	REV	C
						REV							

Mouser Electronics

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[TE Connectivity:](#)

[2150090-2](#)