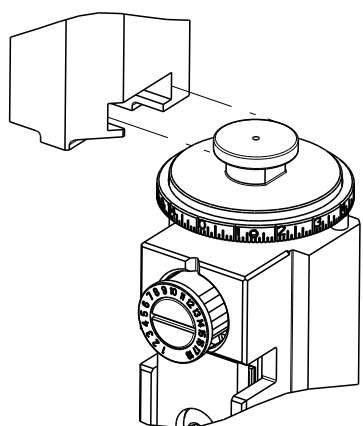


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150402-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150402-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150402-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150402-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150402-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.59 mm [.220]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SRS FAST-IN-ON REC.			
WIRE STRIP LENGTH 5.80-6.60 mm [.228-.260 IN]		INSULATION DIAMETER RANGE Ø4.00-5.20 mm [.157-.205 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160914-1	160914-2	160914-3	160914-4

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		2.58+/-0.05 [.102+/- .002]		5.6
4.00mm2 + 1.0mm2		2.39+/-0.05 [.094+/- .002]		7.9
4.00mm2 + 0.5mm2		2.29+/-0.05 [.090+/- .002]		8.9
4.00mm2		2.20+/-0.05 [.087+/- .002]		9.8



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

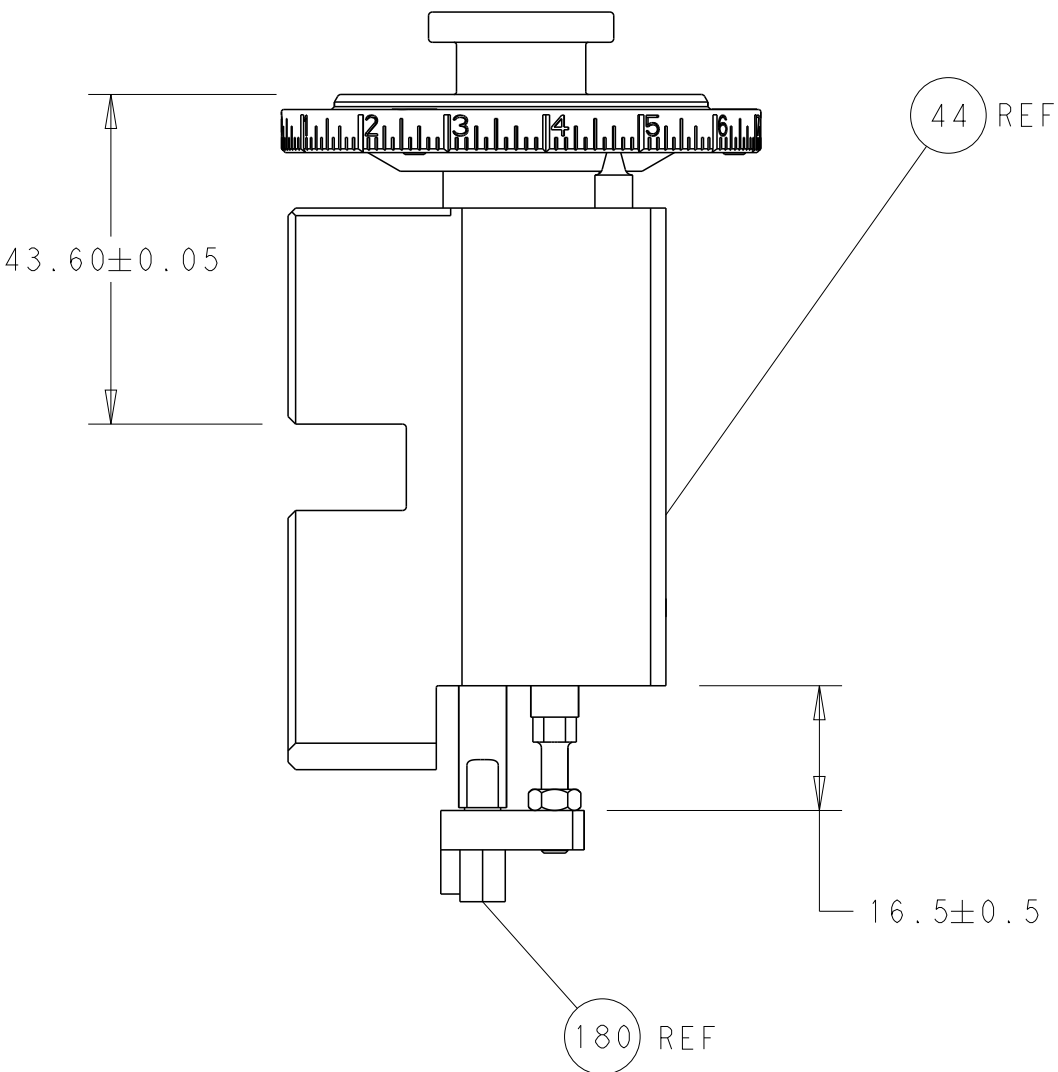
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66						
		P	LTR	DESCRIPTION	DATE	OWN	APPROV
			A1	ECR-16-001945	08FEB2016	MR	JDG
			B	ECR-18-001095	23JAN2018	JAH	GB
			C	ECR-20-015290	27OCT2020	TB	RK

3	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
3	-	1	-	1	2844940-3	AIR FEED MODULE	238
	-	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	1	1-1752354-2	STANDOFF, HOLD-DOWN	180
	-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
5	-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	455888-5	SPACER, CRIMPER	82
1	-	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
1	-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	-	2063961-1	FEED FINGER	58
	-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
1	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	2063961-1	FEED FINGER	51
1	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	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	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
1	-	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1752371-3	PLATE, STRIP GUIDE	24
	-	1	1	1	240825-8	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1	1803292-4	DRAG	20
1	-	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
	-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	2-240641-1	SPACER	16
	-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	1	1	240833-2	PLATE, REAR SHEAR	11
1	-	-	-	-	-	-	10
	-	1	1	1	690482-3	PLATE, FRONT SHEAR	9
	1	2	2	1	1803059-7	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	-	6
1	-	1	1	1	240641-3	SPACER	5
	-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	2	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1-455888-8	SPACER, CRIMPER	2
	1	2	2	1	456414-5	CRIMPER, WIRE	1
-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO

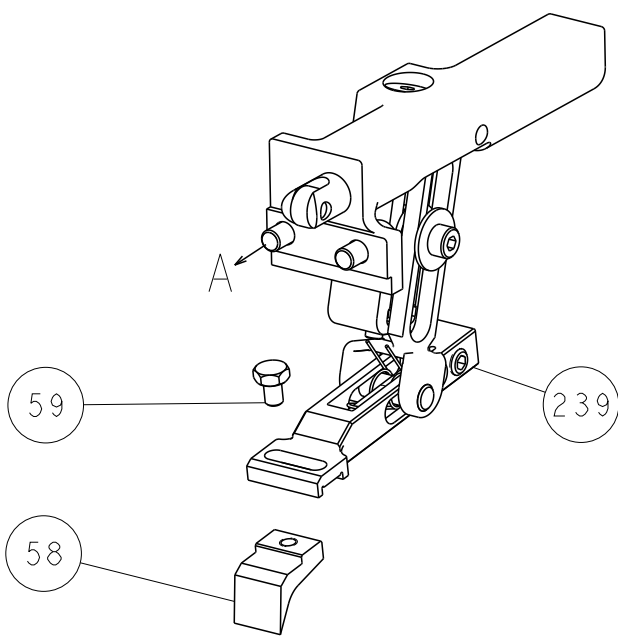
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 16DEC2013 CHK ZHANG 16DEC2013 APP'D U GUO 16DEC2013		 TE Connectivity Harrisburg, PA 17105-3608	
		0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC		NAME Ocean End Feed Applicator - SIZE CAGE CODE DRAWING NO A 00779 C=2150402	
MATERIAL - - -		WEIGHT - - -		RESTRICTED TO - - -		SCALE 1:1 SHEET 1 OF 4 REV C	
Customer Accessible Production							

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

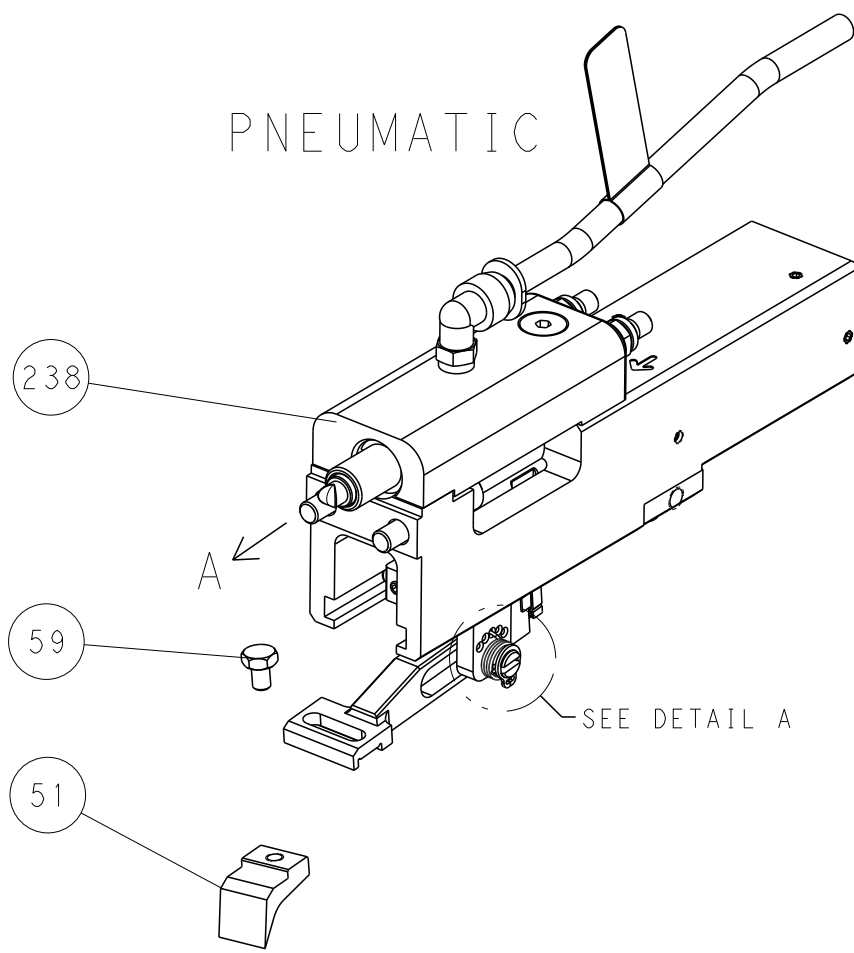


RAM AND HOLDDOWN SET-UP

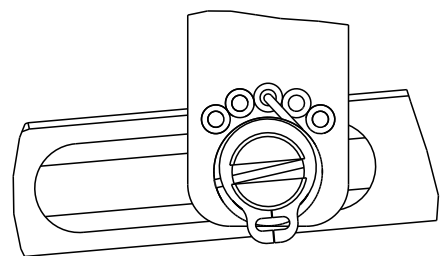
FEED TYPE
MECHANICAL



PNEUMATIC

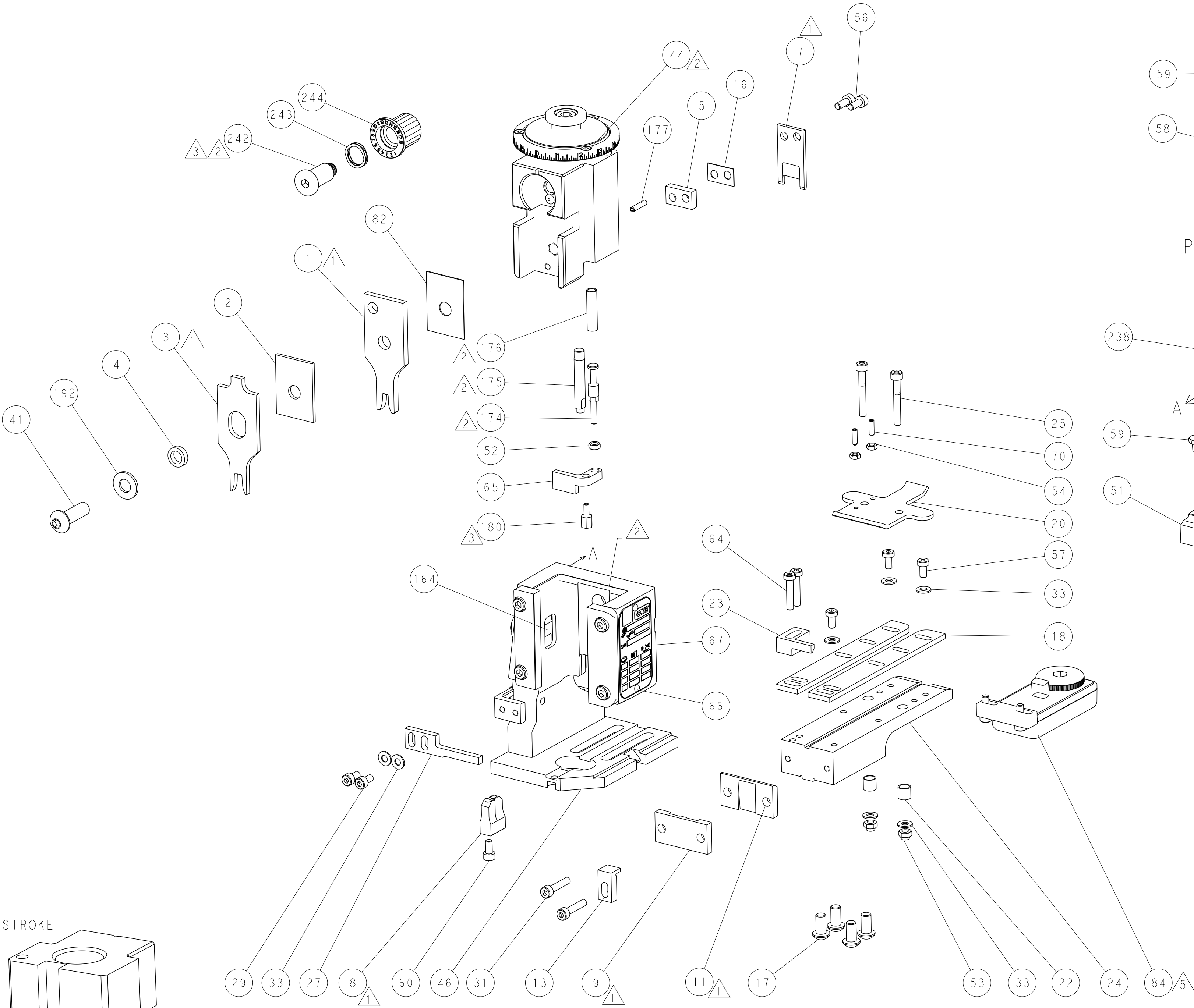
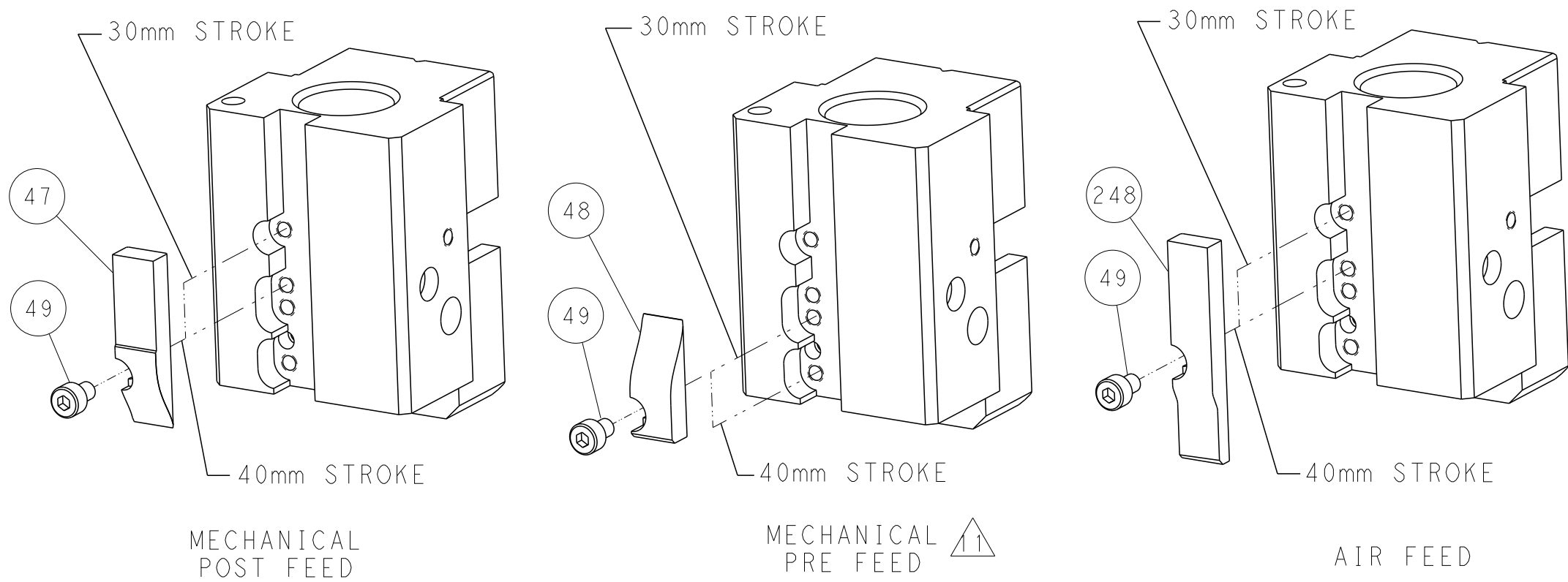


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS

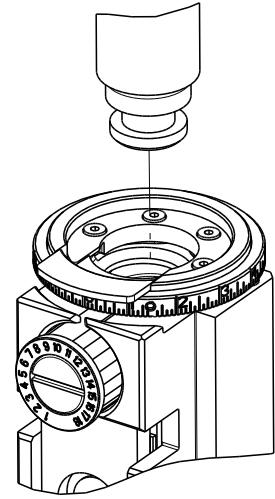


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK L. ZHANG 16DEC2013				NAME	Ocean End Feed Applicator	
APVD J. GUO 16DEC2013				PRODUCT SPEC	-	
APPLICATION SPEC				SIZE	A1	
MATERIAL				WEIGHT	00779	
FINISH				SCALE	1:1	
Customer Accessible Production Drawing				SHEET	2 of 4	
				REV	C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150402-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150402-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150402-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.60]	F
INSUL	5.59 mm [2.20]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SRS FASTIN-ON REC.			
WIRE STRIP LENGTH 5.80-6.60 mm [1.228-.260 IN]		INSULATION DIAMETER RANGE Ø4.00-5.20 mm [1.157-.205 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18022	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160914-1	160914-2	160914-3	160914-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.58+/-0.05 [1.02+/-0.02]	5.6
4.00mm2 + 1.0mm2	2.39+/-0.05 [1.094+/-0.02]	7.9
4.00mm2 + 0.5mm2	2.29+/-0.05 [1.090+/-0.02]	8.9
4.00mm2	2.20+/-0.05 [1.087+/-0.02]	9.8



- 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 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.

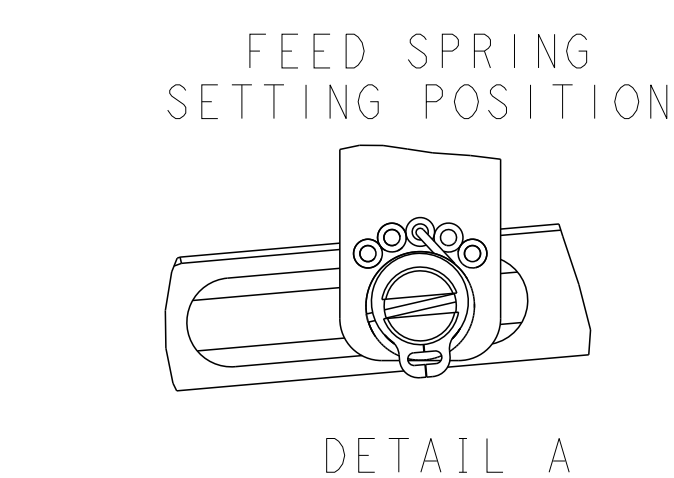
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	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	-	2844940-3	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
3	-	1	1-1752354-2	STANDOFF,HOLD-DOWN	180
-	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	-	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
5	-	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	1901681-1	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-1	FEED FINGER	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	690455-1	STRIPPER, FRONT CASTING	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	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	2-240641-1	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	1803059-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-8	SPACER, CRIMPER	2
1	1	1	456414-5	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		SIZE		CAGE CODE	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		DRAWING NO		RESTRICTED TO	
		APPLICATION SPEC		OCEAN END FEED APPLICATOR		00779		2150402	
MATERIAL		WEIGHT		Customer Accessible Production Drawing		SCALE		1:1	
-		-		3		SHEET		OF 4	
								REV	
								C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION



30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

30mm STROKE

152

49

AIR FEED



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[7-2150402-7](#)