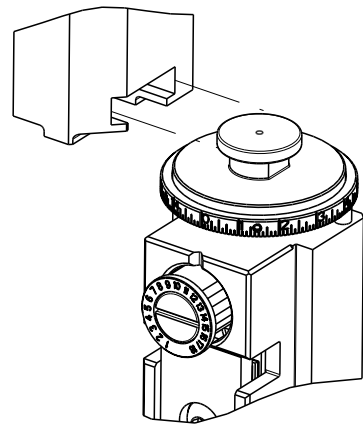
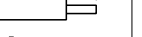


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150549-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150549-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150549-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	8.64 mm [.340]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .250 SERIES			
WIRE STRIP LENGTH 5.33-6.10 mm [.210-.240 IN]			INSULATION DIAMETER RANGE Ø5.84-7.11 mm [.230-.280 IN]
TERMINAL APPLICATION SPECIFICATION 		114-2036	
		-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL 62998-2	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
8 AWG	3.05+/-0.05 [1.120+/-0.002]	3.6
2X 12 AWG	2.79+/-0.05 [1.110+/-0.002]	5.8
10 AWG	2.54+/-0.05 [1.100+/-0.002]	8.5



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.

*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)

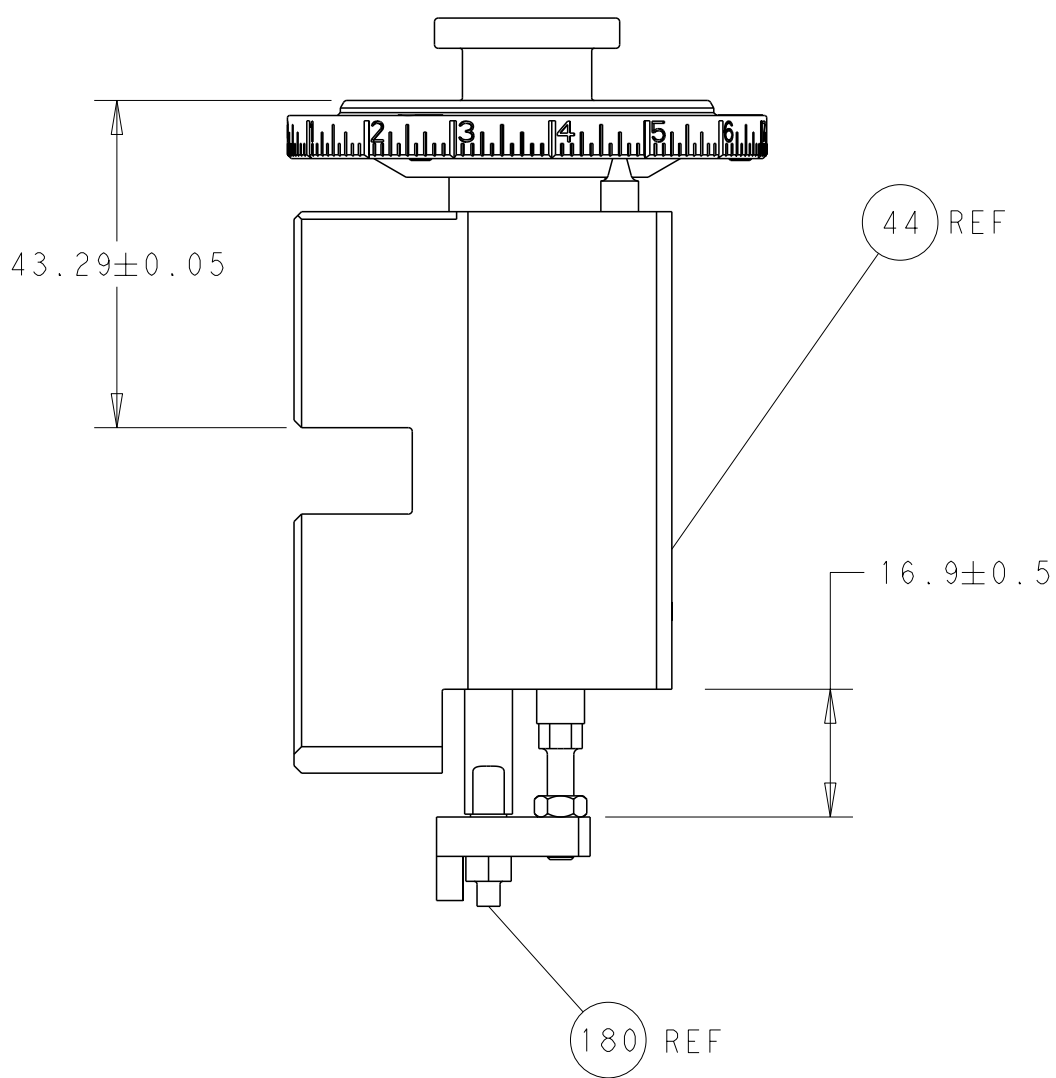
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							APVD
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				D1		ECR-18-012314	06AUG2018
				E		ECR-18-017696	09NOV2018
				F		ECR-19-009701	20JUN2019

	-	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	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1-1976055-1	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	1	455888-5	SPACER, CRIMPER	82
	-	1	1	2119791-5	DEPRESSOR, WIRE	73
	-	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	1901681-5	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	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	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	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	240825-5	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-7	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	6-240641-4	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	5-690495-1	PLATE, FRONT SHEAR	9
1	1	2	1	1803003-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-8	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	240641-1	SPACER	5
	-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	1	4-1803018-3	CRIMPER, INSULATION O	3
1	1	2	1	9-1633664-6	CRIMPER, WIRE	1
	-77	-72	-2	PART NO	DESCRIPTION	ITEM NO

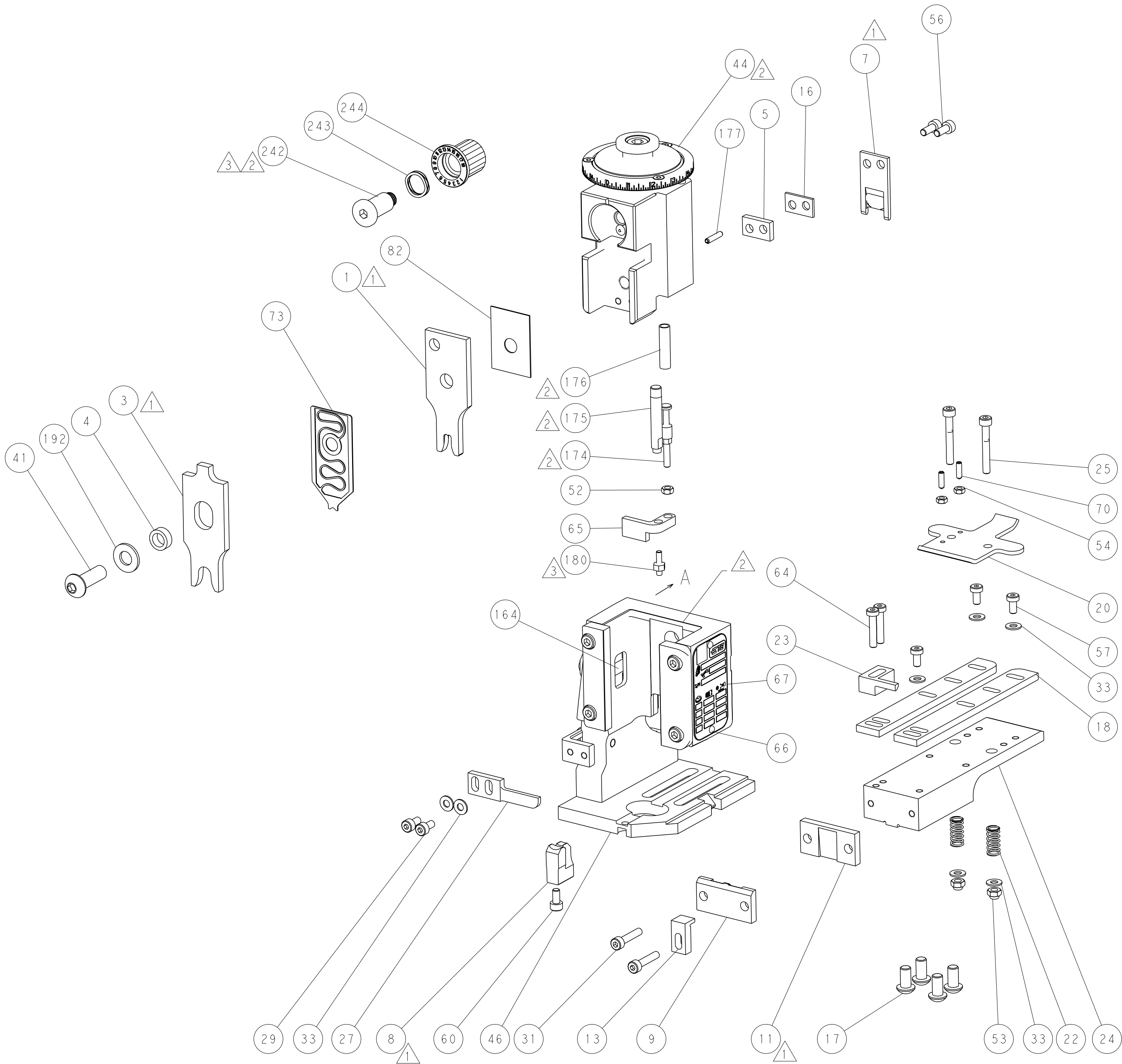
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.					DWG		J. HOW		10JUN2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:					CHK		L. ZHANG		10JUN2015			
mm					APVD		J. GUO		10JUN2015		NAME	
					PRODUCT SPEC						Ocean End Feed Applicator -	
					APPLICATION SPEC							
					SIZE		CAGE CODE		DRAWING NO			
					A		00779		©=2150549			
					Customer Accessible Production Drawing		SCALE		1:1			
MATERIAL					WEIGHT		-				RESTRICTED TO	
-					-						-	
											SHEET 1 OF 4	
											REV F	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

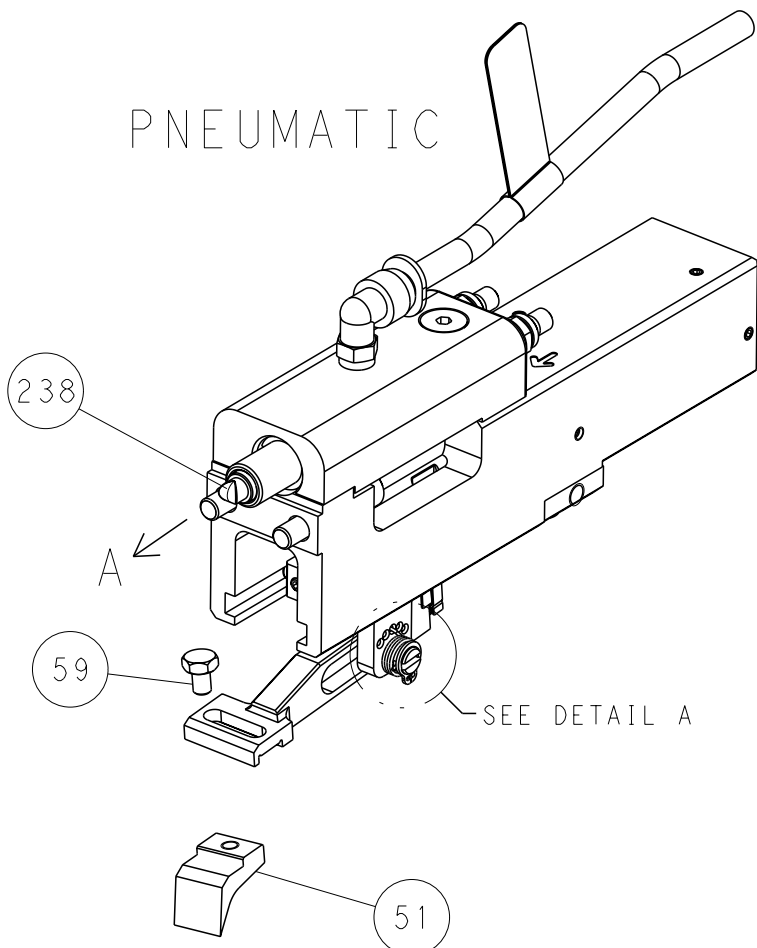
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A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



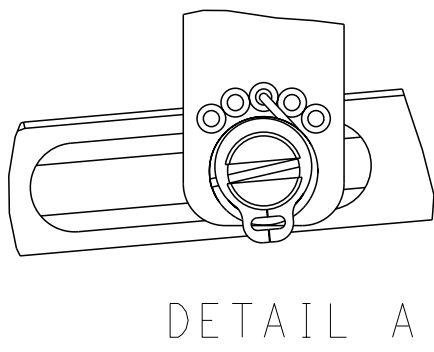
RAM AND HOLDDOWN SET-UP



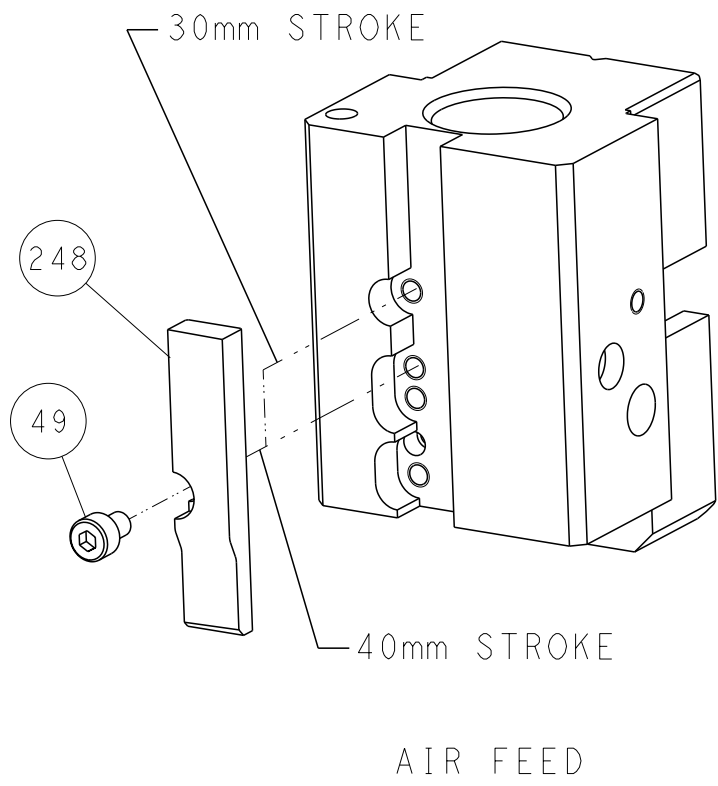
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



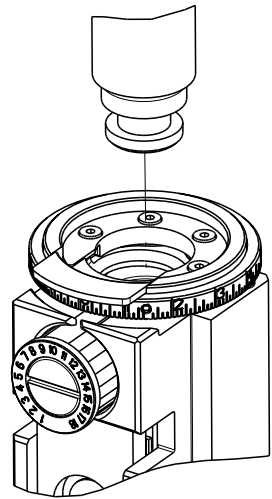
AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN J. HOW 10JUN2015	TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG 10JUN2015		
				APVD U. GUO 10JUN2015	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				SIZE	CAGE CODE	DRAWING NO
				A1	00779	C=2150549
				WEIGHT	RESTRICTED TO	
				Customer Accessible Production Drawing	-	
				SCALE	1:1	SHEET 2 OF 4
				REV	F	

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150549-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150549-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	8.64 mm [.340]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .250 SERIES			
WIRE STRIP LENGTH 5.33-6.10 mm [.210-.240 IN]		INSULATION DIAMETER RANGE Ø5.84-7.11 mm [.230-.280 IN]	
TERMINAL APPLICATION SPECIFICATION			
114-2036			
TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL	
62998-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		3.05+/-0.05 [.120+/- .002]		3.6
2X 12 AWG		2.79+/-0.05 [.110+/- .002]		5.8
10 AWG		2.54+/-0.05 [.100+/- .002]		8.5



- 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.
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)

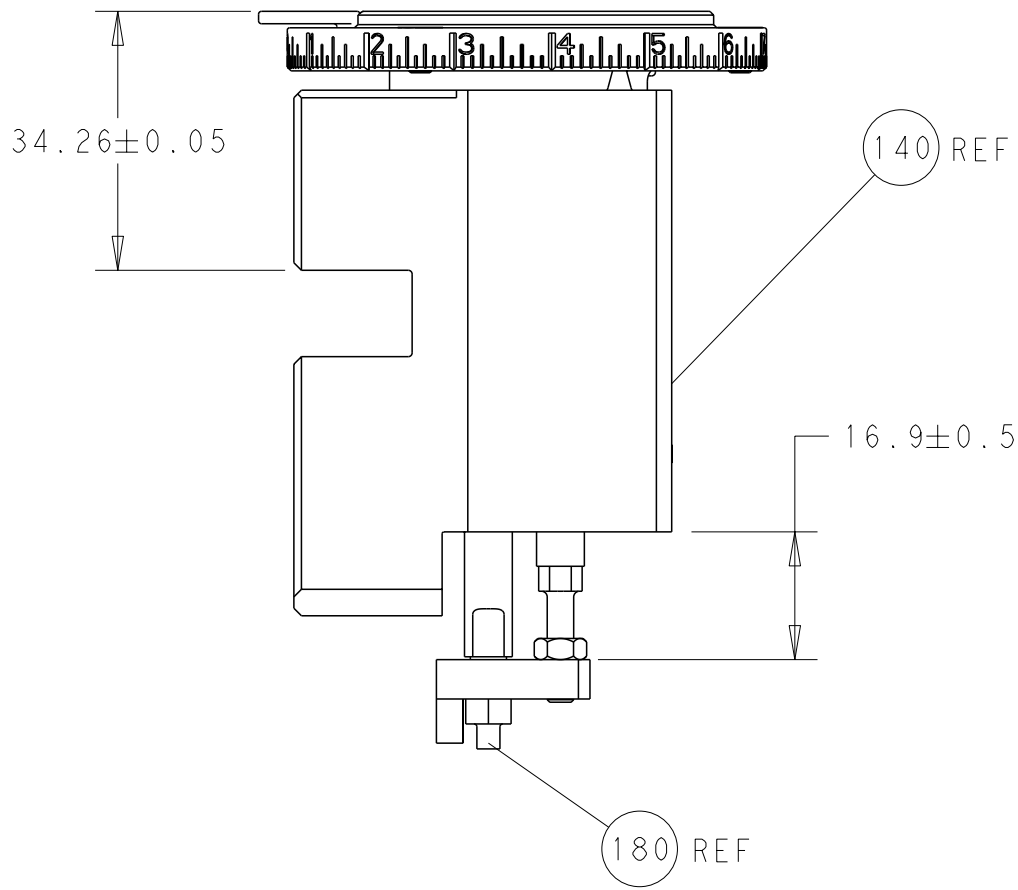
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		P	LYR	DESCRIPTION	DATE	DWN
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-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL
-	1	2844940-3	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1-1976055-1	STANDOFF, HOLD-DOWN
-	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	455888-5	SPACER, CRIMPER	82
-	1	2119791-5	DEPRESSOR, WIRE	73
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752371-5	PLATE, STRIP GUIDE	24
-	1	240825-5	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	6-240641-4	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240644-9	PLATE, REAR SHEAR
-	-	-	-	10
	-	1	5-690495-1	PLATE, FRONT SHEAR
	1	1	1803003-3	ANVIL, COMBINATION, END FEED
	-	1	2217206-8	BLADE, SLUG
-	-	-	-	6
-	1	240641-1	SPACER	5
-	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	1	4-1803018-3	CRIMPER, INSULATION O
	1	1	9-1633664-6	CRIMPER, WIRE
-	77-22	PART NO		ITEM NO

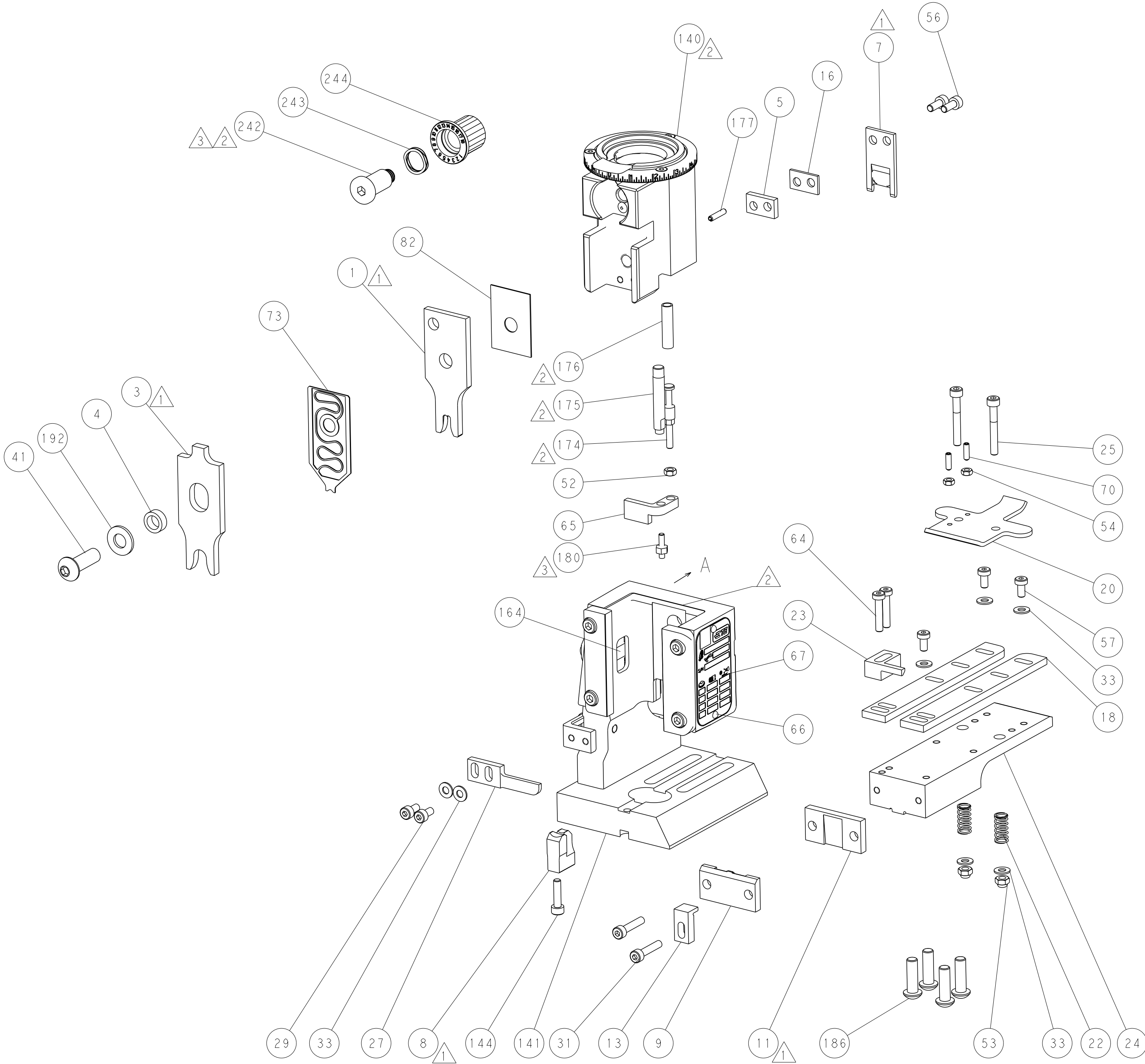
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				CHK L. ZHANG 10JUN2015			
DIMENSIONS: mm				APVD J. GUO 10JUN2015	NAME Ocean End Feed Applicator		
				PRODUCT SPEC	SIZE CAGE CODE DRAWING NO		
				APPLICATION SPEC	RESTRICTED TO		
MATERIAL -				WEIGHT -	A1 00779 ©=2150549		
				Customer Accessible Production Drawing	SCALE 1:1		
					SHEET 3		
					OF 4		
					REV F		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

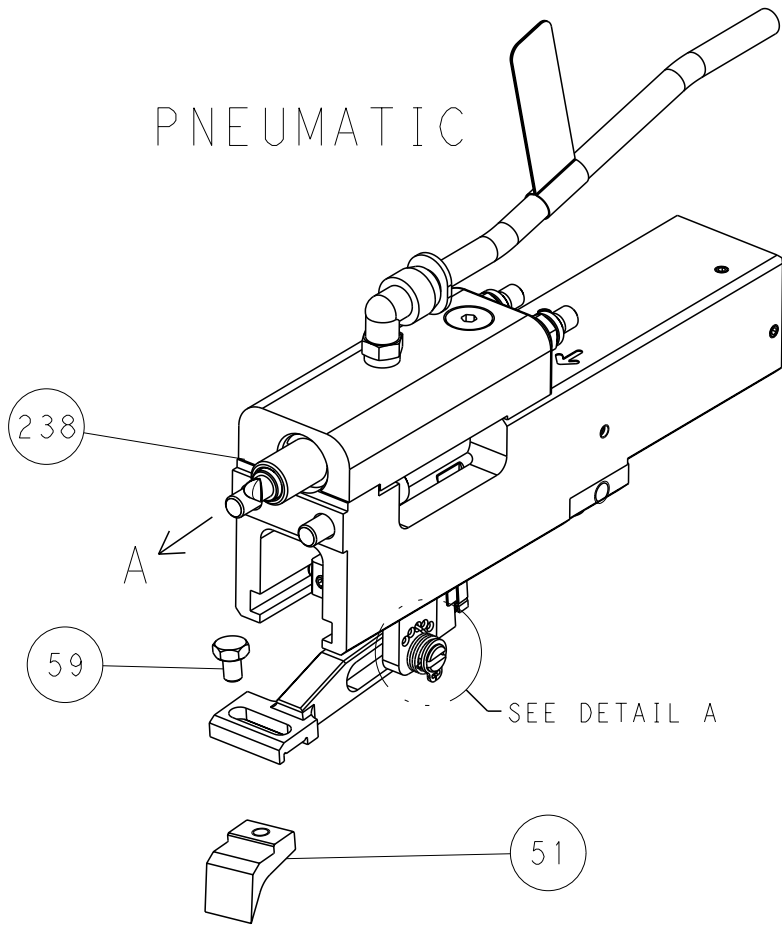
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A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



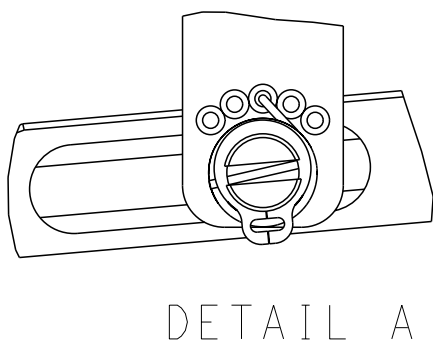
RAM AND HOLDDOWN SET-UP



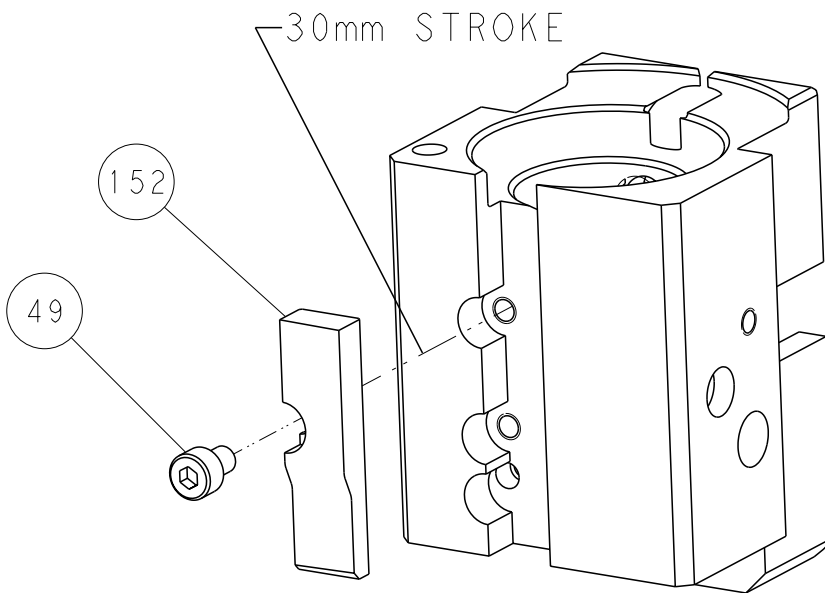
FEED TYPE



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOW 10JUN2015	TE Connectivity Harrisburg, PA 17105-3608		
				CHK L. ZHANG 10JUN2015			
				APVD U. GUO 10JUN2015	NAME Ocean End Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1		
				APPLICATION SPEC	CAGE CODE 00779		
				WEIGHT	DRAWING NO C=2150549		
MATERIAL				FINISH	Customer Accessible Production Drawing		
					SCALE 1:1	SHEET 4	OF 4
						REV F	

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2150549-1](#)