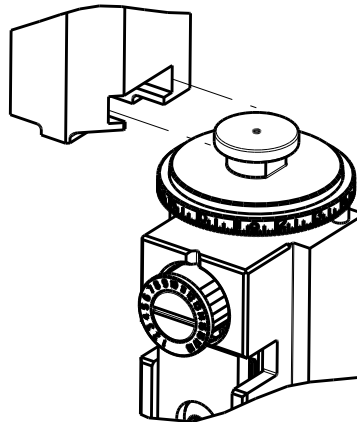


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150030-1	B	FINE CRIMP HEIGHT ADJUST
	2150030-2	B	FINE CRIMP HEIGHT ADJUST
	2150030-5	B	FINE CRIMP HEIGHT ADJUST
	2150030-6	B	NON-CRIMP HEIGHT ADJUST
	2150030-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150030-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2036	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160389-3	42510-2	63609-3	140760-3
160389-4	42510-5	63609-4	140760-4
41772	63127-1	63693-1	140760-5
41772-1	63609-1	140760-1	
42510-1	63609-2	140760-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG or 0.75mm²	1.42+/-0.05 [.056+/- .002]	6.0
(2) 22 AWG	1.37+/-0.05 [.054+/- .002]	6.5
20 AWG or 0.50mm²	1.30+/-0.05 [.051+/- .002]	7.3
0.40mm2	1.27+/-0.05 [.050+/- .002]	7.6
22 AWG or 0.30mm²	1.24+/-0.05 [.049+/- .002]	8.0



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150030-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150030-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150030-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150030-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37. 50 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 12 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

TERMINAL DATA: TE TERMINAL		TE CRIMP SPERIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-20023	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280000-6	280000-7	41771	41771-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm²	1.30+/-0.03 [.051+/- .001]	7.8
0.75mm²	1.30+/-0.03 [.051+/- .001]	7.8
0.65mm²	1.27+/-0.03 [.050+/- .001]	7.6
0.50mm2	1.22+/-0.03 [.048+/- .001]	7.8
0.30mm²	1.14+/-0.03 [.045+/- .001]	8.4

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

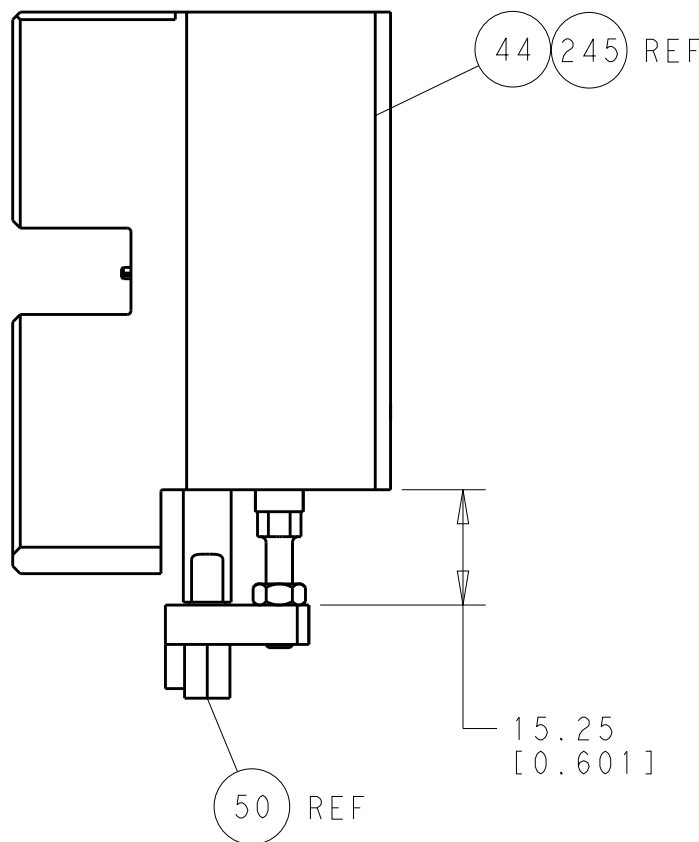
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				I	ORIGINAL	09DEC2011
				A	RELEASED	27FEB2012
				A1	ECR-13-010523	01JUL2013
				B	ECR-13-012365	06AUG2013

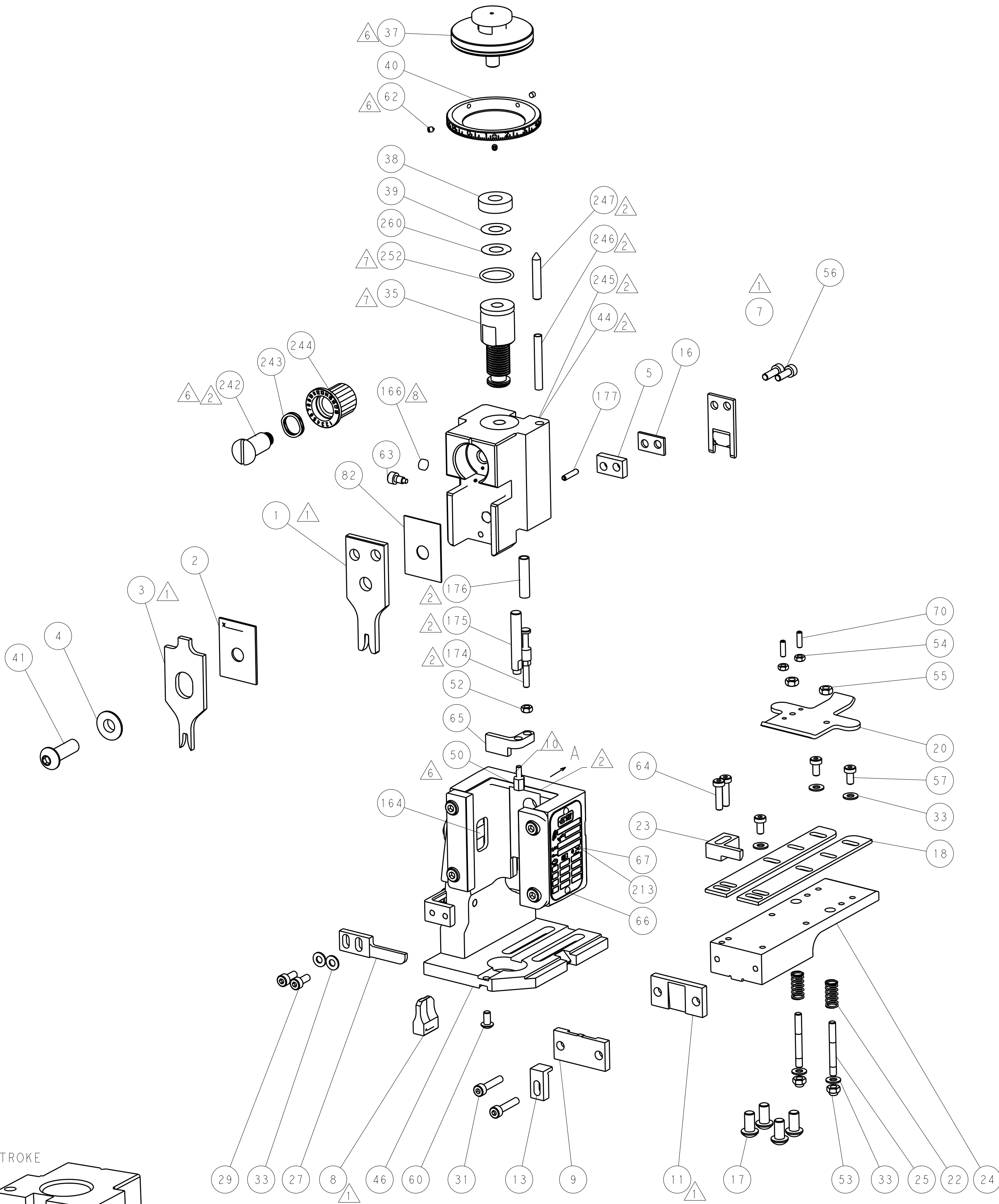
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREFREFREF	-	-	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REFREF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	-	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
-	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1	1	1-1752354-3	STANDOFF,HOLD-DOWN	50
-	-	-	-	1	2	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	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	-	1	1	2119369-1	RAM,AMP STYLE, END FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	7	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	3-240641-3	SPACER	16
-	1	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690495-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1338673-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	1	240641-3	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN B. WEAVER	09DEC2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFENER	09DEC2011	NAME Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC	
		APPLICATION SPEC		SIZE A1	
MATERIAL -		FINISH -		WEIGHT -	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 of 4	
REV B		DRAWING NO 00779		RESTRICTED TO -	

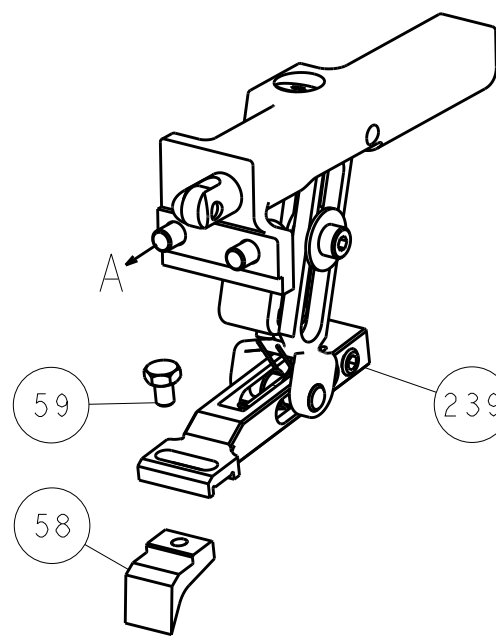
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



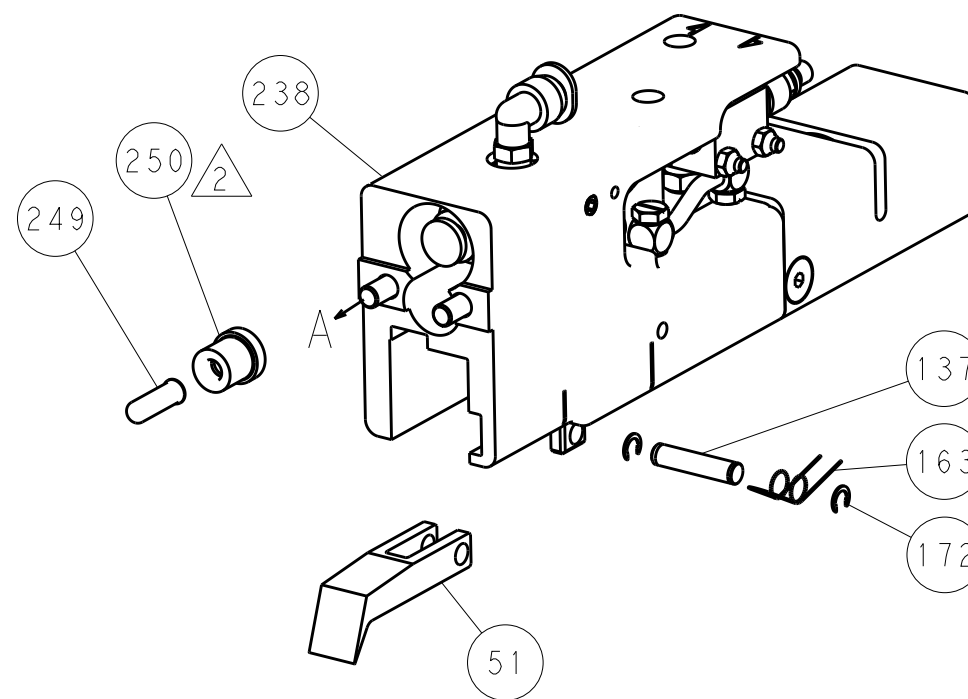
HOLDDOWN SET-UP



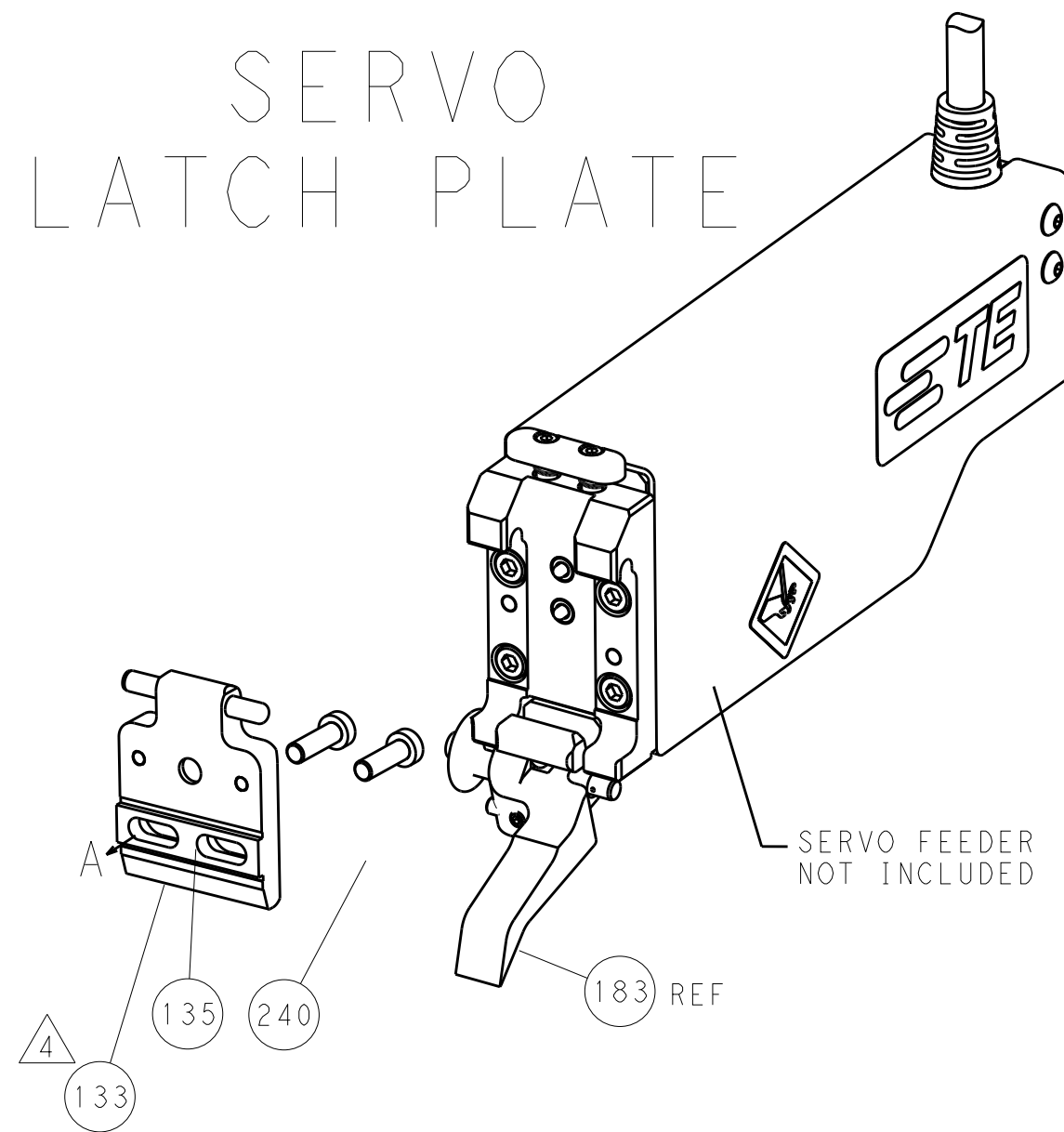
FEED TYPE
MECHANICAL



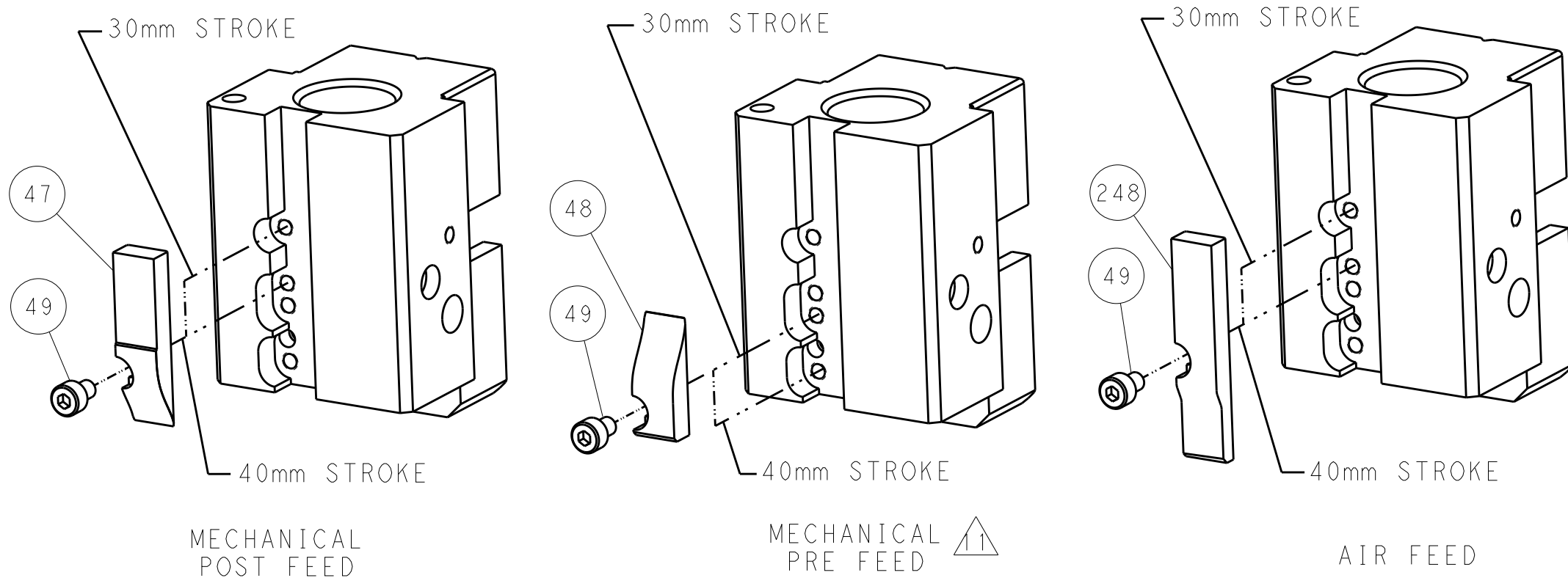
PNEUMATIC



SERVO
LATCH PLATE

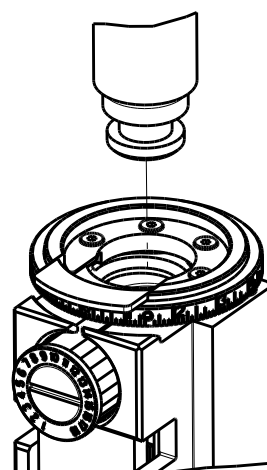


CAM POSITIONS



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN: B. WEAVER 09DEC2011 CHK: G. HOFFNER 09DEC2011 APVD: G. BAILEY 09DEC2011				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A11 CAGE CODE: 00779 DRAWING NO: C-2150030			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV B			

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150030-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150030-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150030-4	-	-	-
	2-2150030-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150030-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150030-4	-	-	-
	2-2150030-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
2-2150030-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2150030-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		 INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-2036	-	-
	-	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160389-3	42510-2	63609-3	140760-3
160389-4	42510-5	63609-4	140760-4
41772	63127-1	63693-1	140760-5
41772-1	63609-1	140760-1	
42510-1	63609-2	140760-2	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG or 0.75mm ²			1.42+/-0.05 [0.056+/- .002]		6.0
(2) 22 AWG			1.37+/-0.05 [0.054+/- .002]		6.5
20 AWG or 0.50mm ²			1.30+/-0.05 [0.051+/- .002]		7.3
0.40mm ²			1.27+/-0.05 [0.050+/- .002]		7.6
22 AWG or 0.30mm ²			1.24+/-0.05 [0.049+/- .002]		8.0

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280000-6	280000-7	41771	41771-1

WIRE SIZE			CRIMP HEIGHT WI_CRIMP_UNIT		CRIMP HEIGHT REFERENCE SETTING
0.80mm ²			1.30+/-0.03 [.051+/- .001]		7.8
0.75mm ²			1.30+/-0.03 [.051+/- .001]		7.8
0.65mm ²			1.27+/-0.03 [.050+/- .001]		7.6
0.50mm ²			1.22+/-0.03 [.048+/- .001]		7.8
0.30mm ²			1.14+/-0.03 [.045+/- .001]		8.4

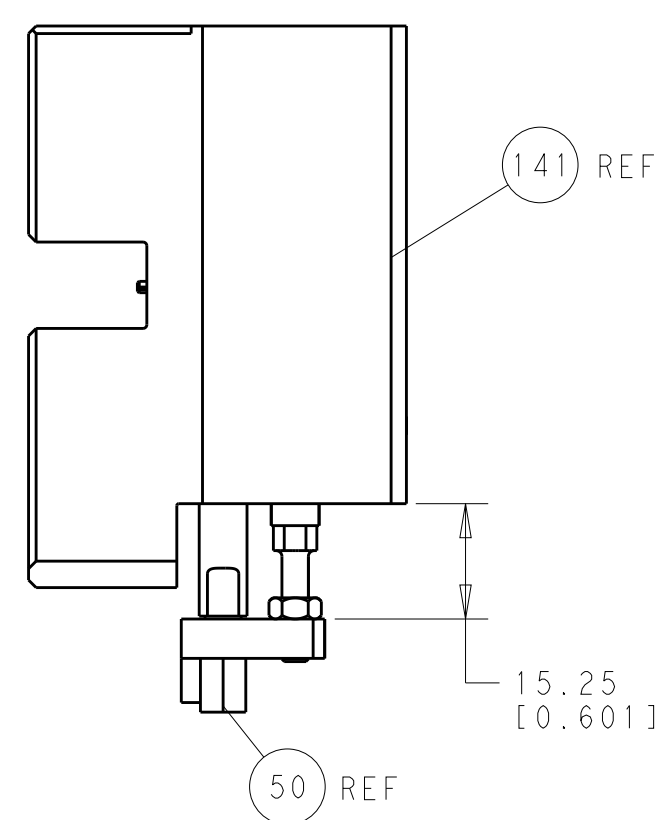
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*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.
```

-	-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSON	246
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 77-27-25-22-21						PART NO	DESCRIPTION	ITEM NO

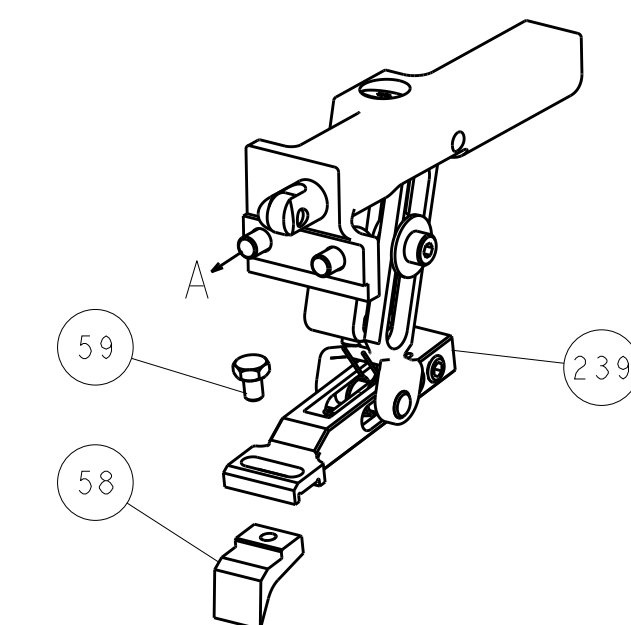
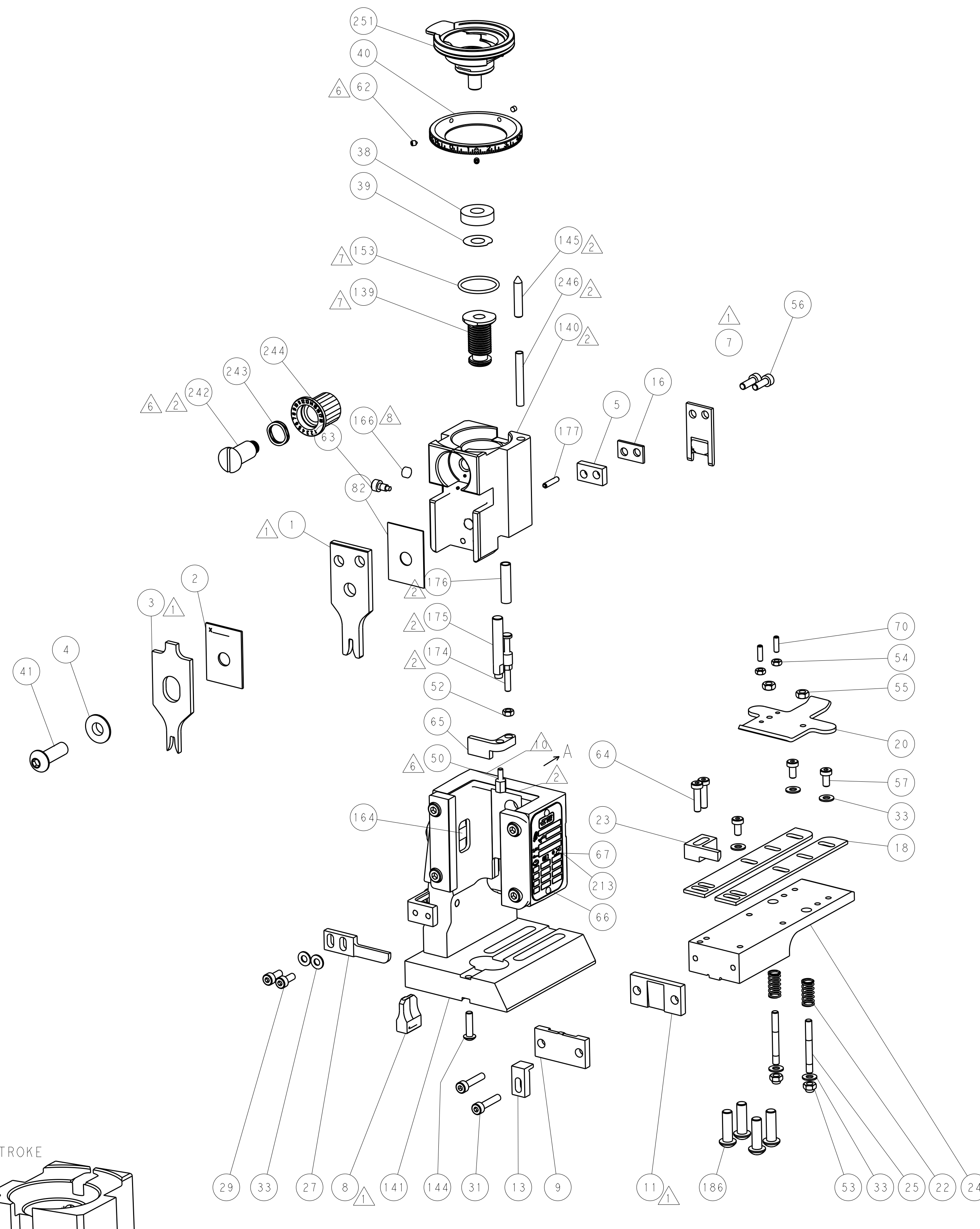
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE			LOC	DIST	REVISIONS					
2119599-2			A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
						-	SEE SHEET 1	-	-	-
1	1	1		2119083-1	RETAINER, INSULATION DIAL					242
2	-	-		2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10					240
-	-	1		2119580-1	MECHANICAL FEED ASSEMBLY					239
-	1	-		2063440-1	AIR FEED MODULE					238
1	-	-		2119740-2	TAG,IDENTIFICATION					213
4	4	4		2079383-9	SCR, BHSC, RoHS (M6 X 20)					186
REF	-	-		1901697-1	FEED FINGER ASSEMBLY,EF					183
1	1	1		6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0					177
1	1	1		8-22280-7	SPRING, COMPRESSION					176
1	1	1		1752353-2	GUIDE PIN,HOLDDOWN					175
1	1	1		1901680-2	GUIDE PIN,HOLDDOWN					174
-	2	-		21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT					172
1	1	1		994969-1	MAGNET, RARE EARTH HIGH ENERGY					166
REF	REF	REF		994970-2	COUNTER, MAGNETIC					164
-	1	-		240638-1	SPRING, FEED FINGER					163
1	1	1		8-21084-1	O-RING, .801 ID, .070 DIA. MAT.					153
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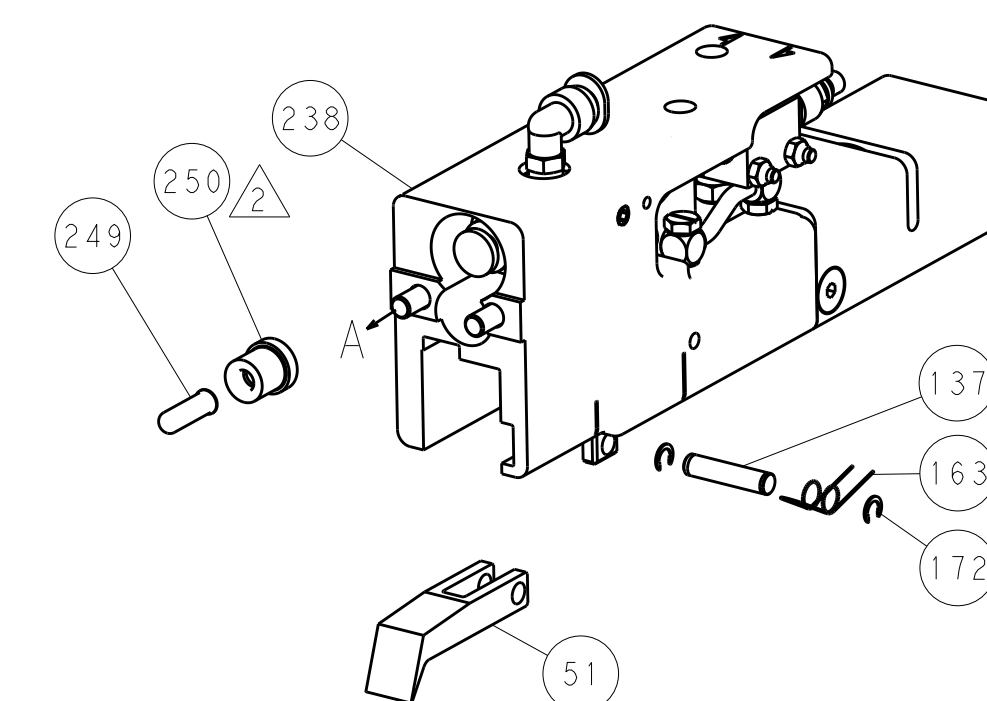
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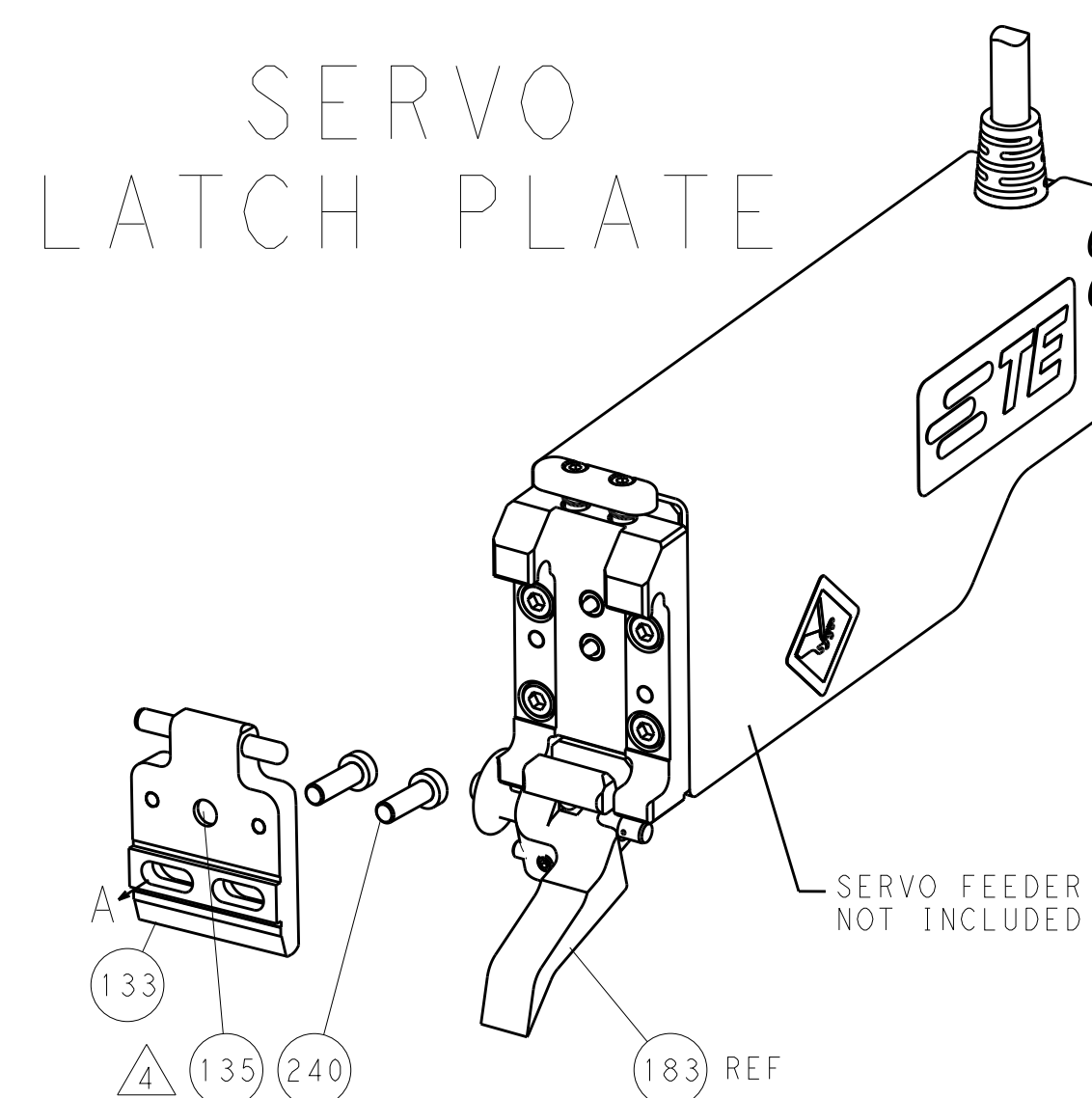
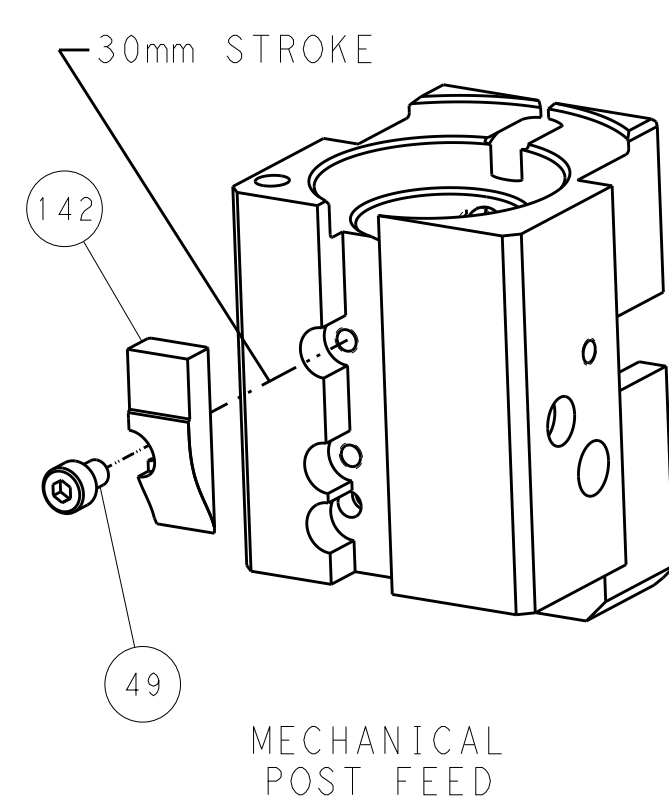
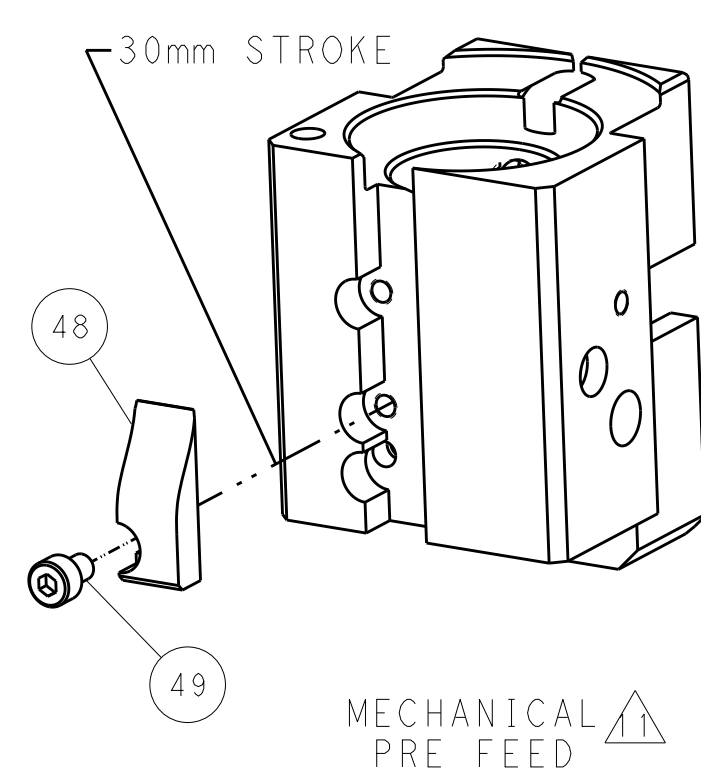
HOLDDOWN SET-UP



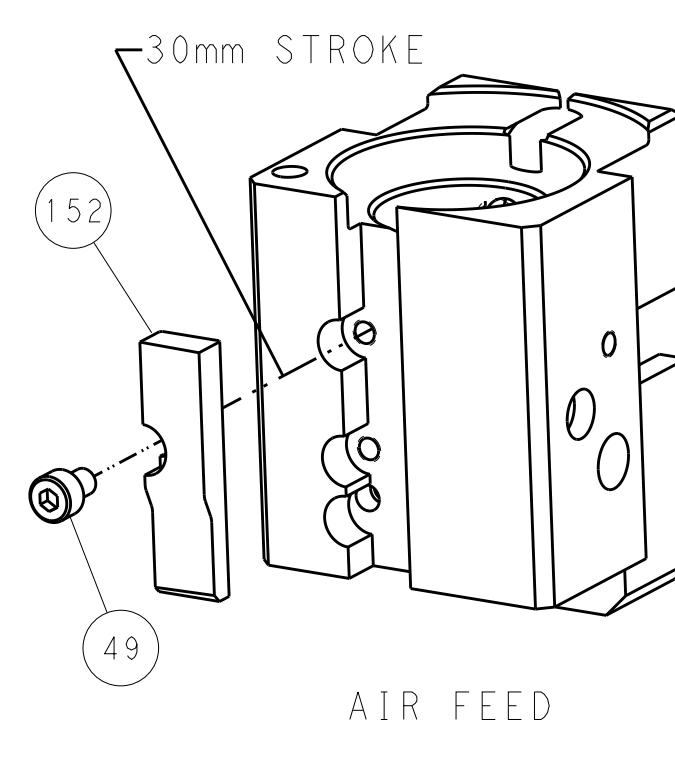
FEED TYPE
MECHANICAL



PNEUMATIC

SERVO
LATCH PLATEMECHANICAL
POST FEED

MECHANICAL
PRE FEED



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 ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean End Feed Applicator -	
MATERIAL -		FINISH -		SIZE A1 CAGE CODE 00779 DRAWING NO C=2150030	
WEIGHT -		RESTRICTED TO -		SCALE 1:1 SHEET A OF A REV A	
Customer Accessible Production Drawing					

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