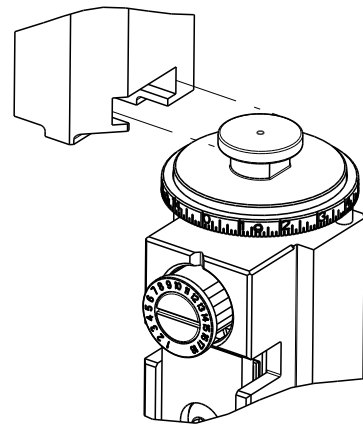


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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150199-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150199-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150199-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.29-3.94 mm [.090-.155 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2074		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL 63854-1	TE TERMINAL 63854-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁴
14 AWG		1.85 +/- 0.05 [1.073 +/- .002]		3.4
16 AWG		1.63 +/- 0.05 [1.064 +/- .002]		5.6
18 AWG		1.47 +/- 0.05 [1.058 +/- .002]		7.5



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
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.

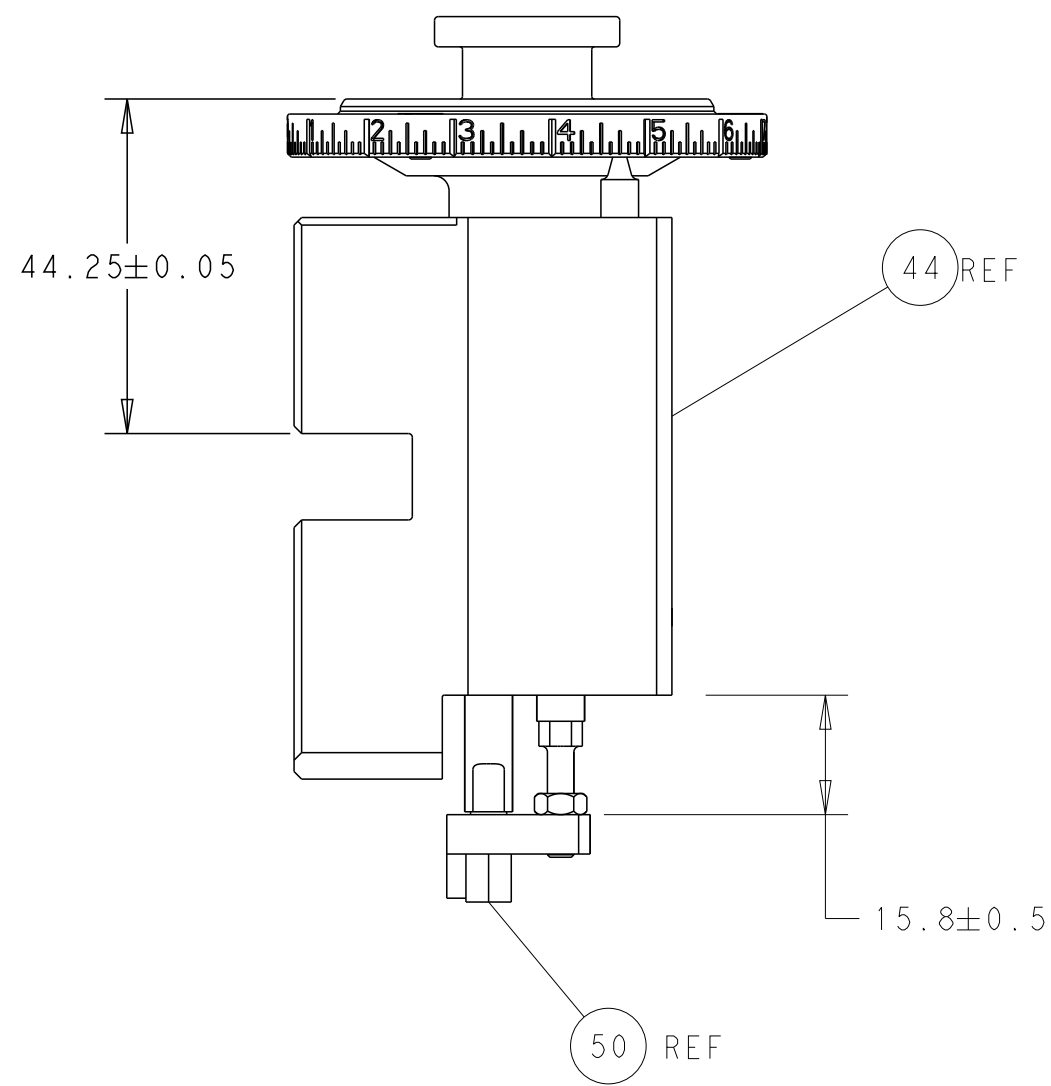
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*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING,
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.
```

2					1			
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		E		ECR-20-004256	20MAR2020	TB	RK	
		F		ECR-21-007025	26JUL2021	JWC	TE	
		G		ECR-22-142428	14JUN2022	TB	TE	
		H		ECR-24-225491	29OCT2024	ROY	TLE	

	-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	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	17
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-4	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	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
	-	-	1	2063961-1	FEED FINGER	58
	-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
3	-	1	1	1-1752354-0	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	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 M8	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	1752371-1	PLATE, STRIP GUIDE	24
	-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAW	20
	-	2	2	1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	240641-6	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
△	-	1	1	240644-1	PLATE, REAR SHEAR	11
△	-	1	1	690482-5	PLATE, FRONT SHEAR	9
△	1	1	1	1-1803000-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-7	BLADE, SLUG	7
	-	1	1	4-240641-1	SPACER	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-8	SPACER, CRIMPER -	2
1	1	1	1	2-456408-8	CRIMPER, WIRE PREMIUM	1
-77	-2	-1		PART NO	DESCRIPTION	ITEM NO

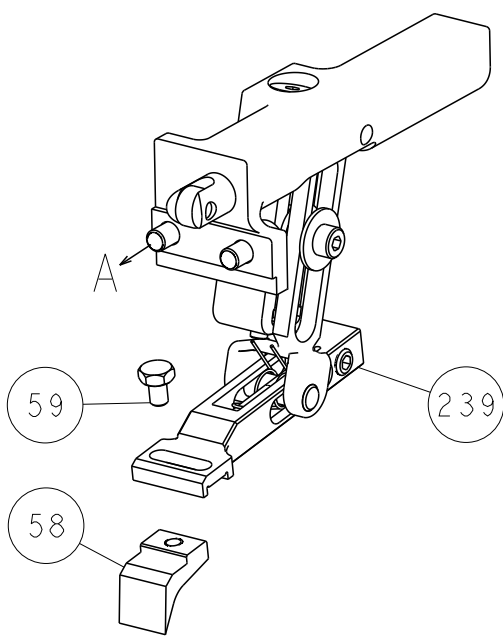
TEC DRAWING IS A CONTROLLED DOCUMENT AND NOT BE LOANED OR REPRODUCED WITHOUT THE WRITTEN CONSENT OF THE COMPANY SHOULD YOU CONTACT US FOR THE LATEST VERSIONS						TE Connectivity Harrisburg PA 17105-3608	
DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 4 PLC ± ANGLES ±° FINISH -		DWN 01MAR2012 S.HUANG CHK 07MAR2012 S.XI APPR 07MAR2012 S.XI PRODUCT SPEC APPLICATION SPEC		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2150199 -	
MATERIAL -				Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV H	

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

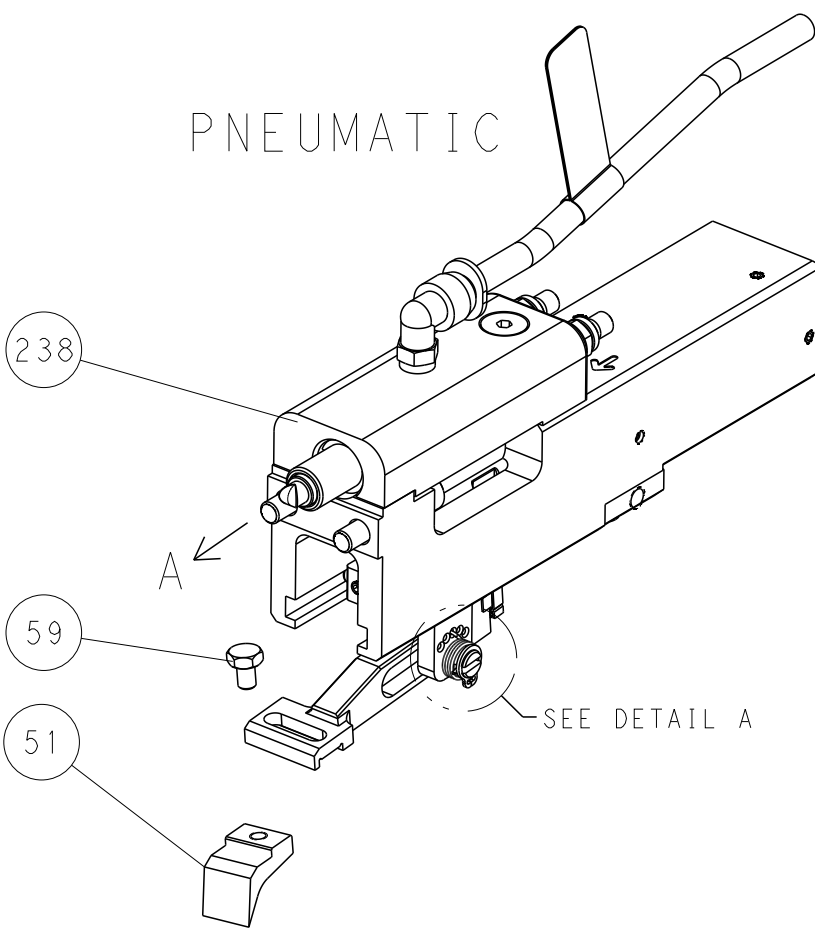


RAM AND HOLDDOWN SET-UP

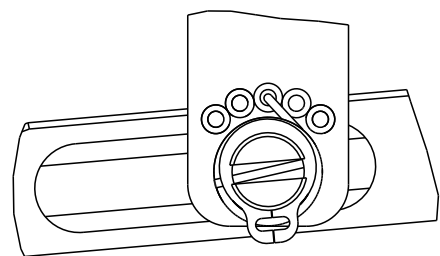
FEED TYPE
MECHANICAL



PNEUMATIC

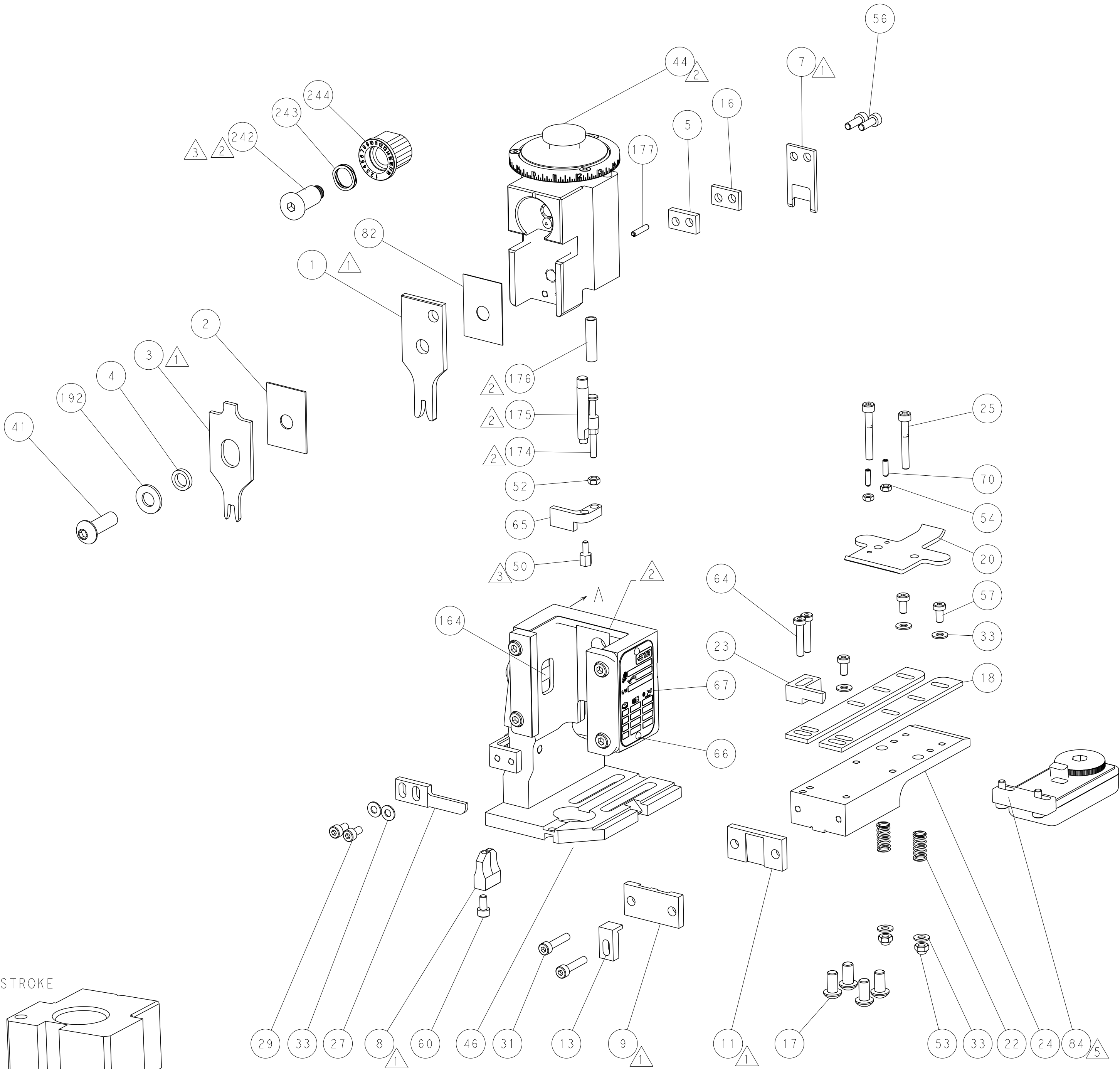
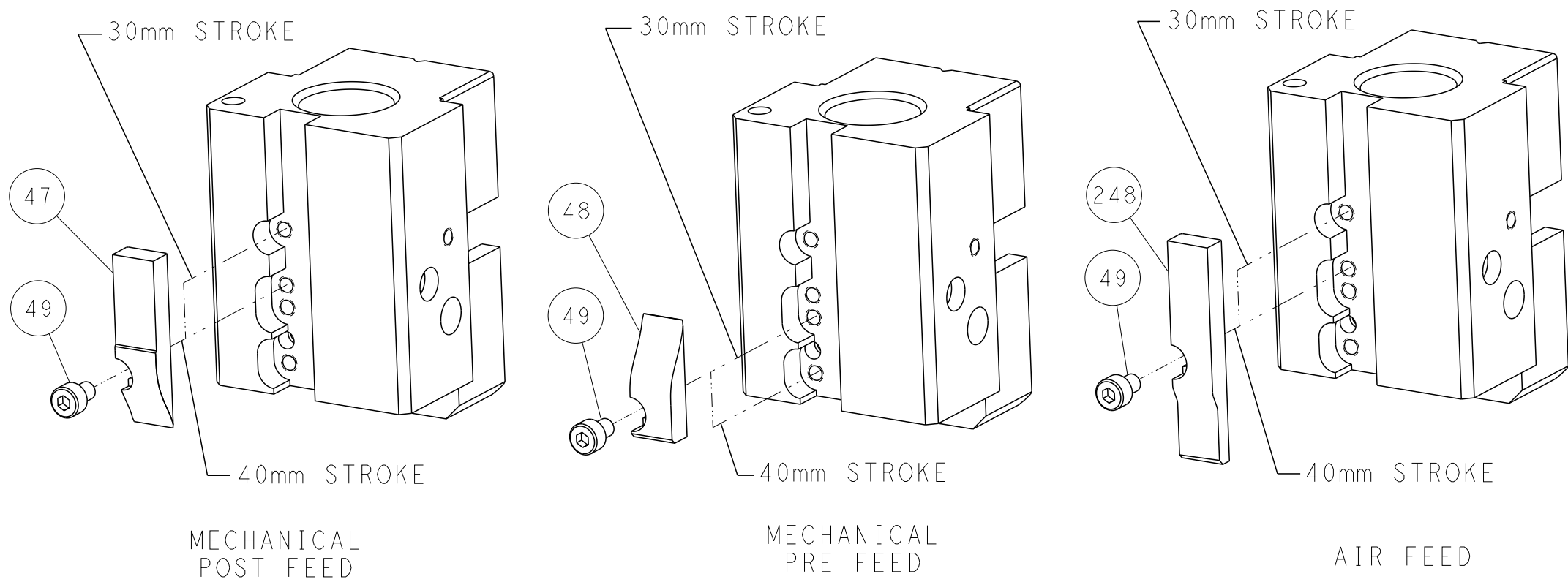


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



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DIMENSIONS:				CHK S. XI 07MAR2012			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD S. XI 07MAR2012			
mm				PRODUCT SPEC			
				APPLICATION SPEC	SIZE A		RESTRICTED TO
MATERIAL				WEIGHT	CAGE CODE 00779		REV
Customer Accessible Production Drawing				SCALE 1:1	SHEET 2 of 4		H