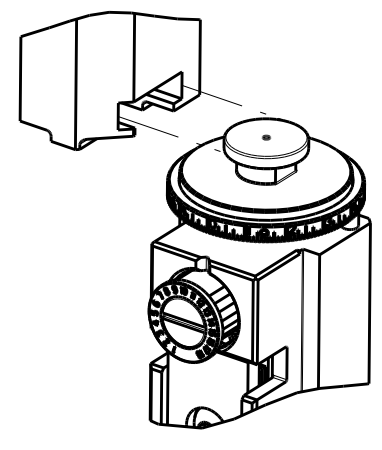


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150177-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150177-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150177-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150177-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150177-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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		INSULATION DIAMETER RANGE	
4.30-5.10 mm [.169-.201 IN]		Ø2.29-3.94 mm [.090-.155 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217094-1	1217094-2	2238135-1	2238135-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57+/-0.05 [.062+/-0.002]	4.5
16 AWG	1.37+/-0.05 [.054+/-0.002]	7.0
18 AWG	1.24+/-0.05 [.049+/-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 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C1		ECR-18-016880	05NOV2018	YY	TE
		D		ECR-18-017991	15NOV2018	JAH	CT
		E		ECR-19-000115	04JAN2019	FL	CT
		E1		ECR-20-006089	27APR2020	FZ	RK

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1	1	1-1752354-0	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	1	1	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	-	1	2063961-1	FEED FINGER	58
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-1	DRAG	20
-	2	2	2	2	1-1901259-0	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240641-1	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	2	2	1	1633386-2	ANVIL, COMBINATION	8
-	1	1	1	1	1-690474-7	BLADE, SLUG	7
-	1	1	1	1	2-240641-4	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	456408-3	CRIMPER, WIRE PREMIUM	1

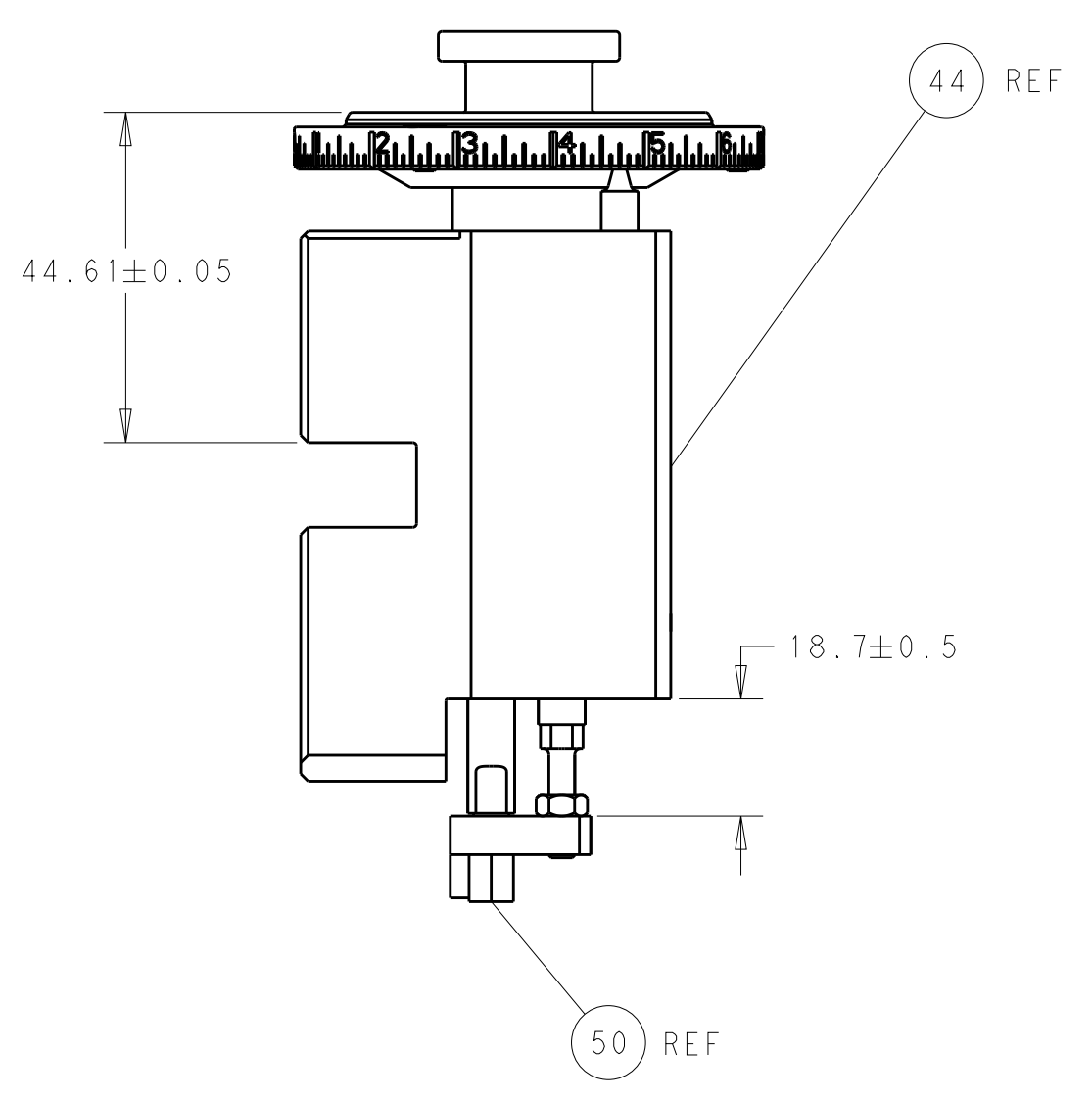
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH ±			
MATERIAL		FINISH		WEIGHT	
				Customer Accessible Production Drawing	

OWN	CHK	APVD	DATE	NAME	SCALE	SHEET	OF	REV
L. ZHANG	L. ZHANG	S. XI	24FEB2012	TE Connectivity	1:1	1	4	E1

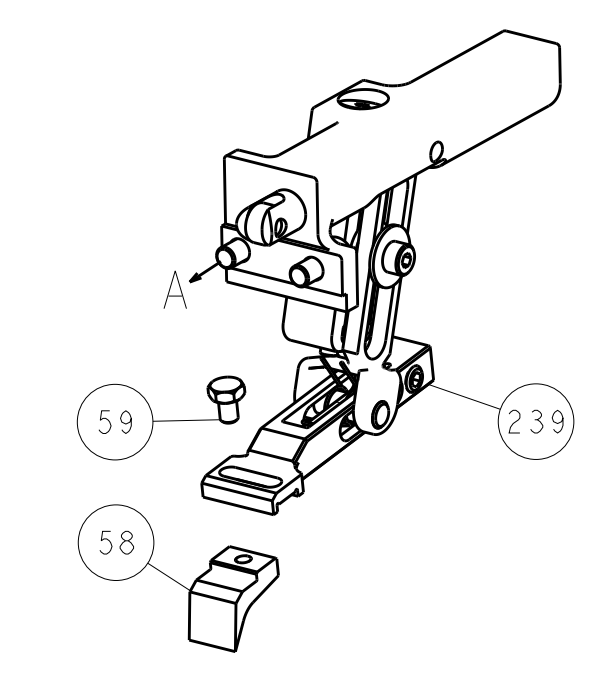
Customer Accessible Production Drawing

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

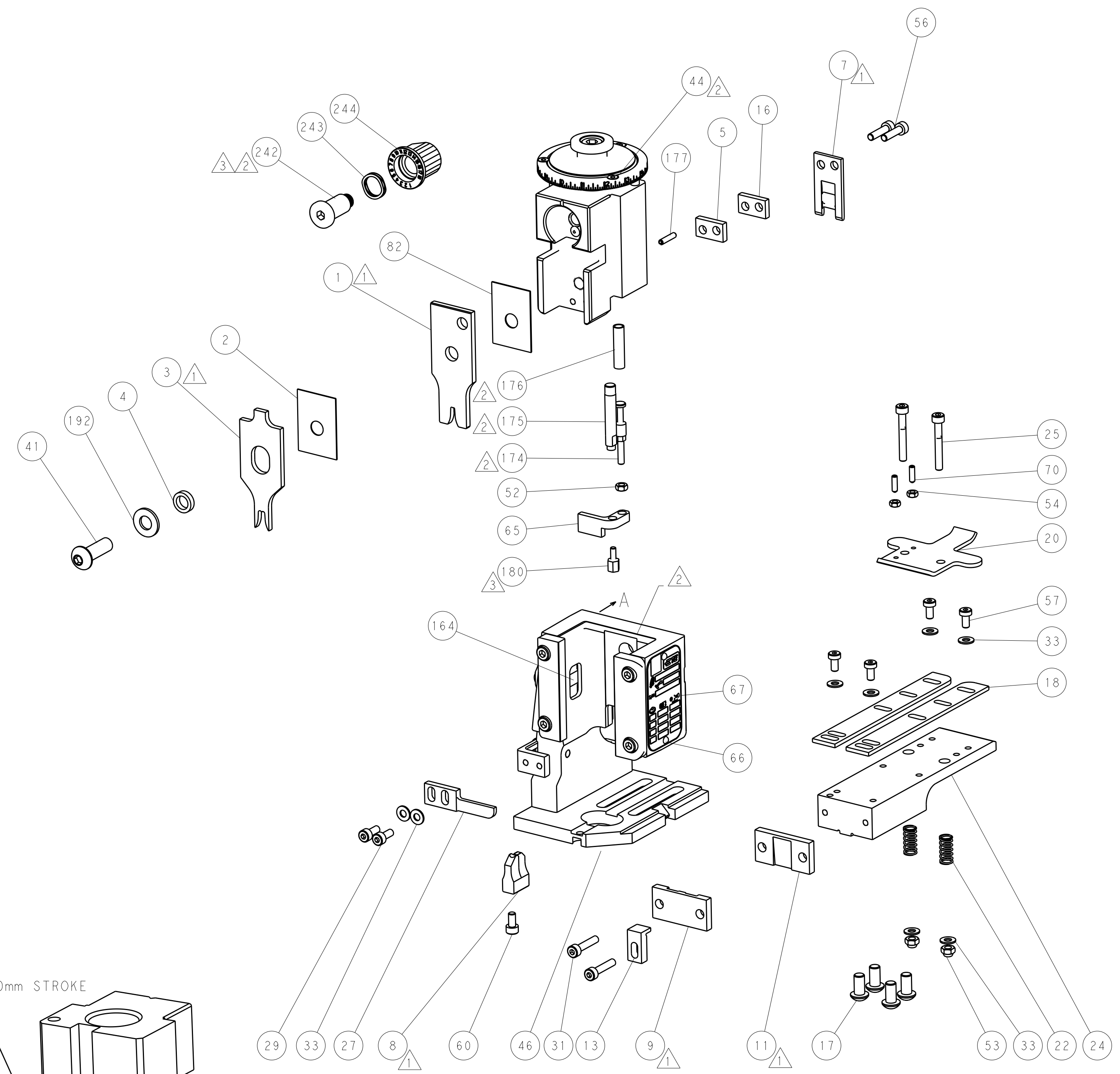
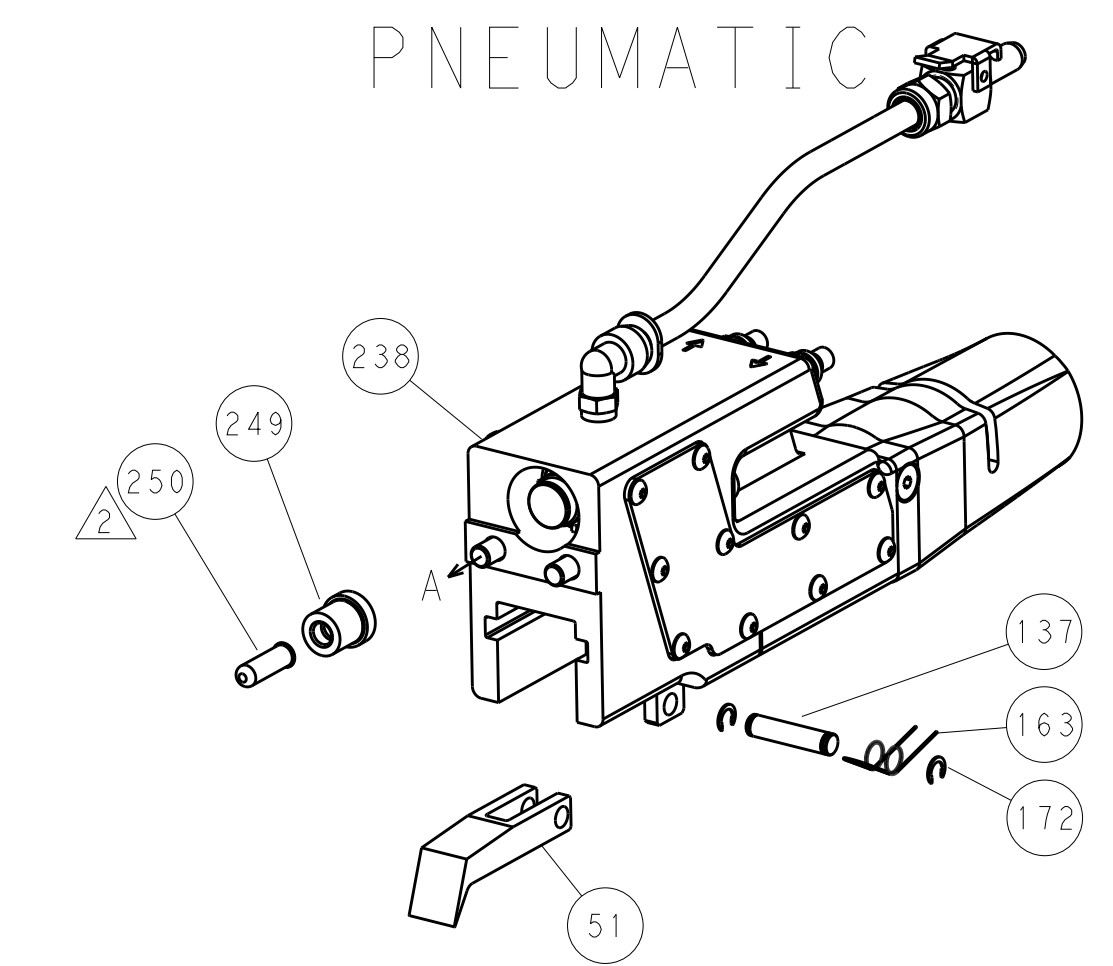


RAM AND HOLDDOWN SET-UP

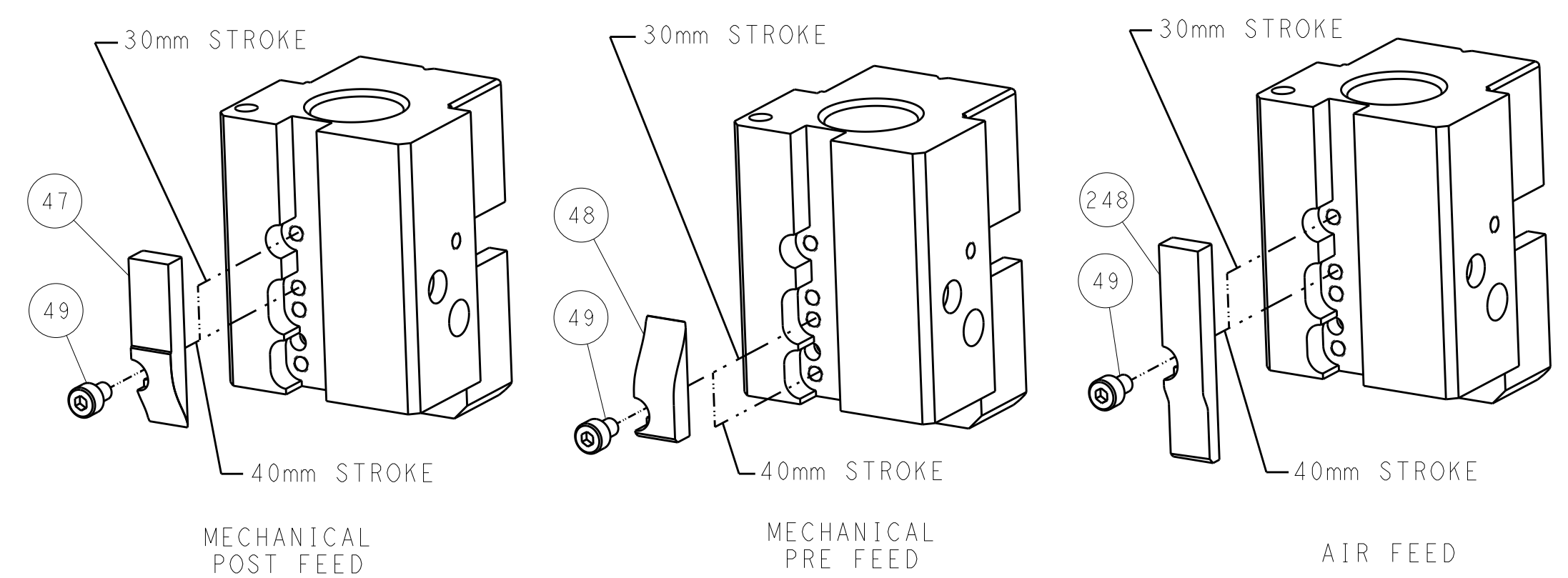
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

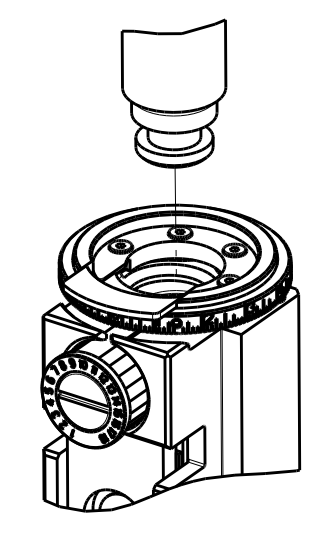


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: L. ZHANG 24FEB2012		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 24FEB2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: S. XI 24FEB2012		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150177	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV E1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150177-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150177-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150177-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



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	INSULATION DIAMETER RANGE
4.30-5.10 mm [.169-.201 IN]	∅2.29-3.94 mm [.090-.155 IN]

TERMINAL APPLICATION SPECIFICATION 114-2074

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217094-1	1217094-2	2238135-1	2238135-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57 +/- 0.05 [.062 +/- .002]	4.5
16 AWG	1.37 +/- 0.05 [.054 +/- .002]	7.0
18 AWG	1.24 +/- 0.05 [.049 +/- .002]	8.5

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- 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.

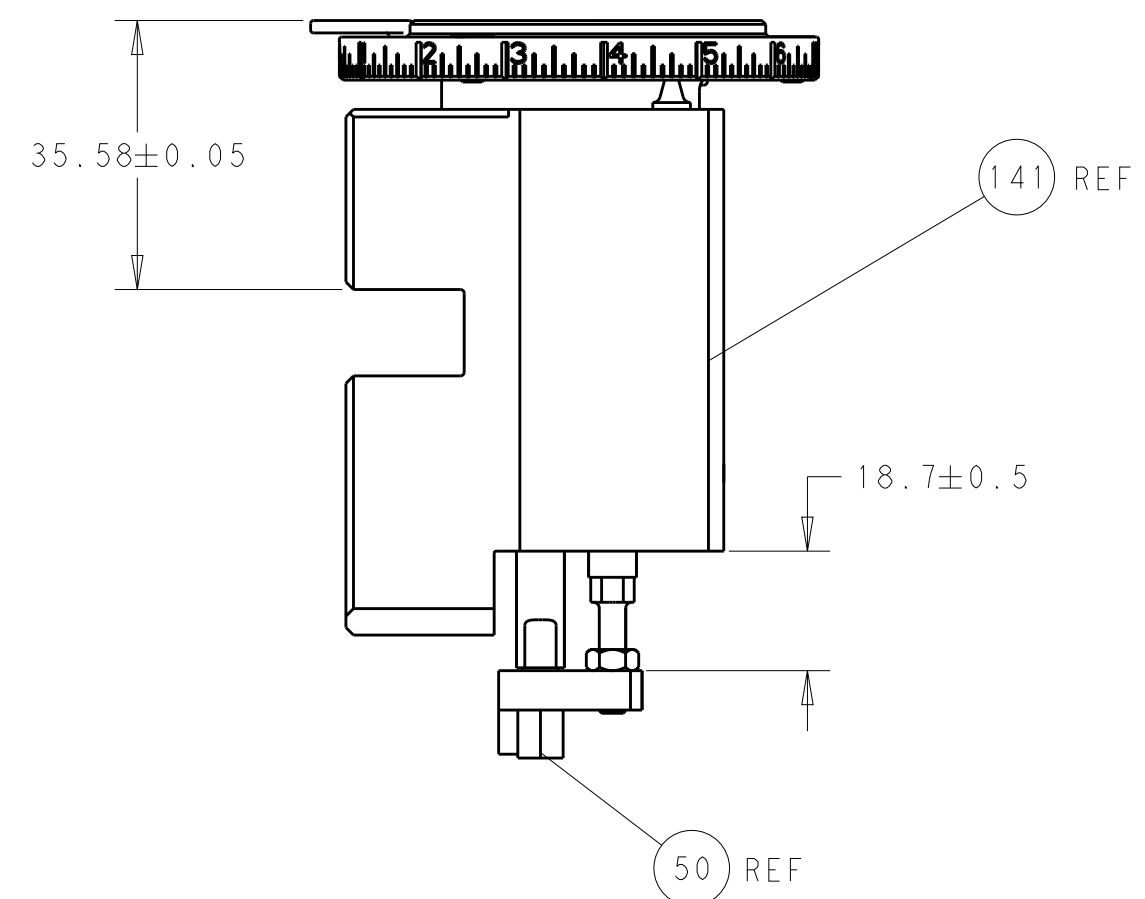
LOC	DIST	REV	DATE	BY	APPV
A	66				

QTY	REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1			2119640-1 PUSH ROD, AIR FEED	250
-	1	1			1803259-1 BUSHING, FLANGED	249
-	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	-			2063440-1 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			1-1752354-0 STANDOFF, HOLD-DOWN	180
-	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
-	2	2			21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF REF	994970-2			COUNTER, MAGNETIC	164
-	1	1			240638-1 SPRING, FEED FINGER	163
-	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
-	1	1			3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1			455888-5 SPACER, CRIMPER	82
-	1	1			1803607-2 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
-	1	1			5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	1			2063961-1 FEED FINGER	58
-	4	4			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
-	1	-			2119792-2 PAWL, EF, AIR	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
-	8	8			1-18028-2 WASHER, FLAT, REG M4	33
-	2	2			2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2			1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	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
-	2	2			2-22281-3 SPRING, COMPRESSION	22
-	1	1			1803292-1 DRAG	20
-	2	2			1-1901259-0 GUIDE, LOWER STRIP	18
-	1	1			240641-1 SPACER	16
-	1	1			1752360-1 SPACER, HOLD-DOWN	13
1	-	1			240644-1 PLATE, REAR SHEAR	11
1	-	1			690482-4 PLATE, FRONT SHEAR	9
1	1	1			1633386-2 ANVIL, COMBINATION	8
1	-	1			1-690474-7 BLADE, SLUG	7
-	1	1			2-240641-4 SPACER	5
-	1	1			238011-2 BLOCK, CRIMPER SPACER	4
1	1	1			2119582-3 CRIMPER, INSULATION F PREMIUM	3
-	1	1			455888-4 SPACER, CRIMPER	2
1	1	1			456408-3 CRIMPER, WIRE PREMIUM	1
-	77-22-21				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)

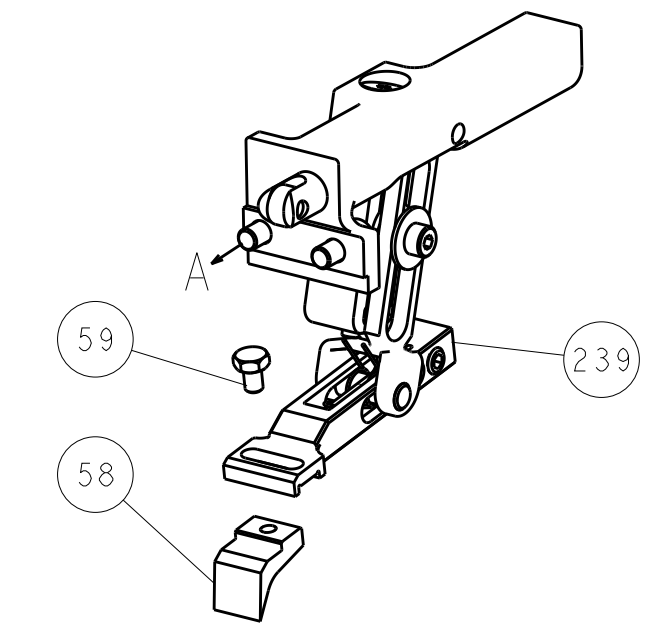
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN L. ZHANG 24FEB2012 CHK L. ZHANG 24FEB2012 APPV S. XI 24FEB2012 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1 SHEET 3 OF 4 REV E1		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150177 Customer Accessible Production Drawing	
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

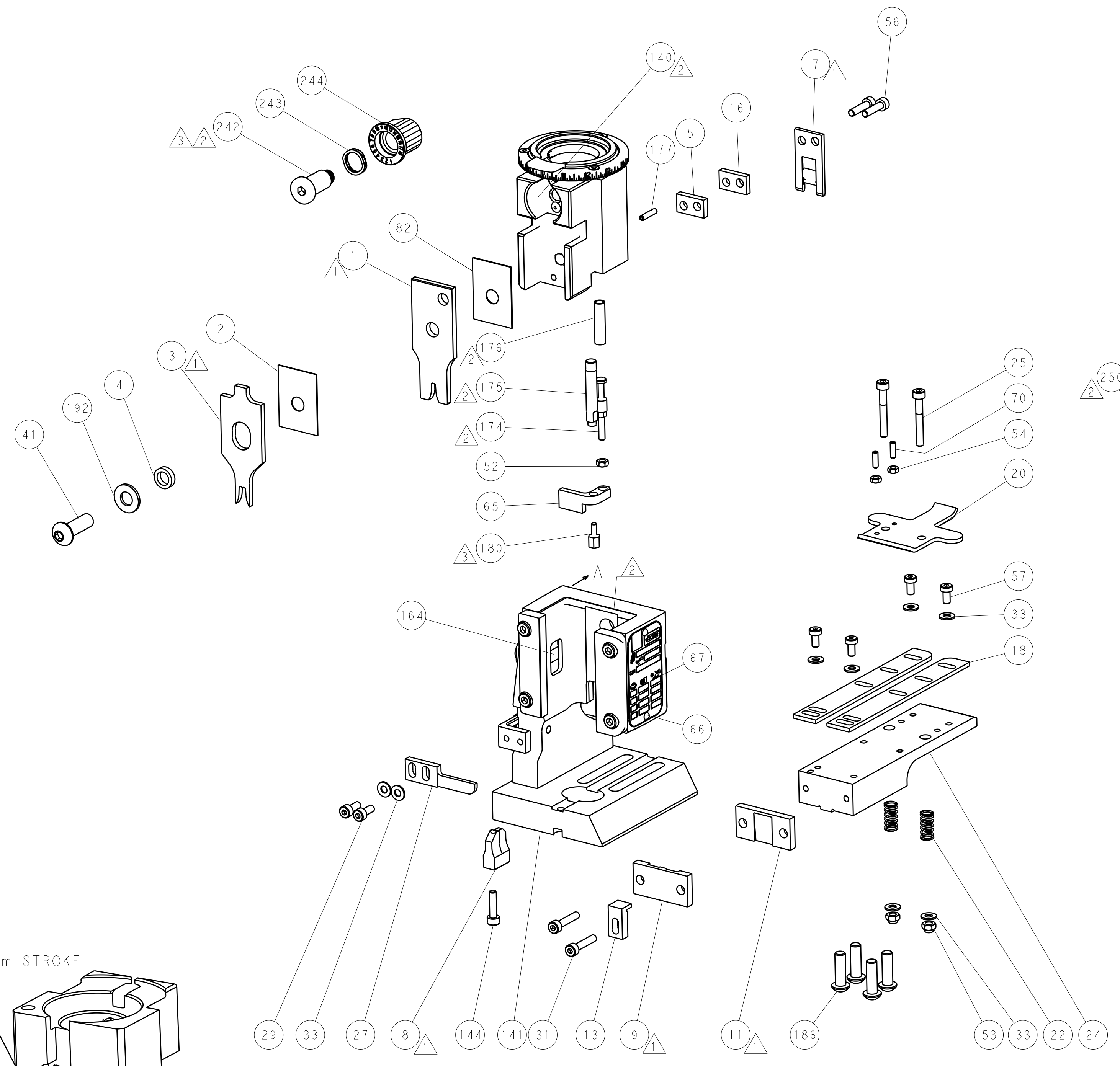
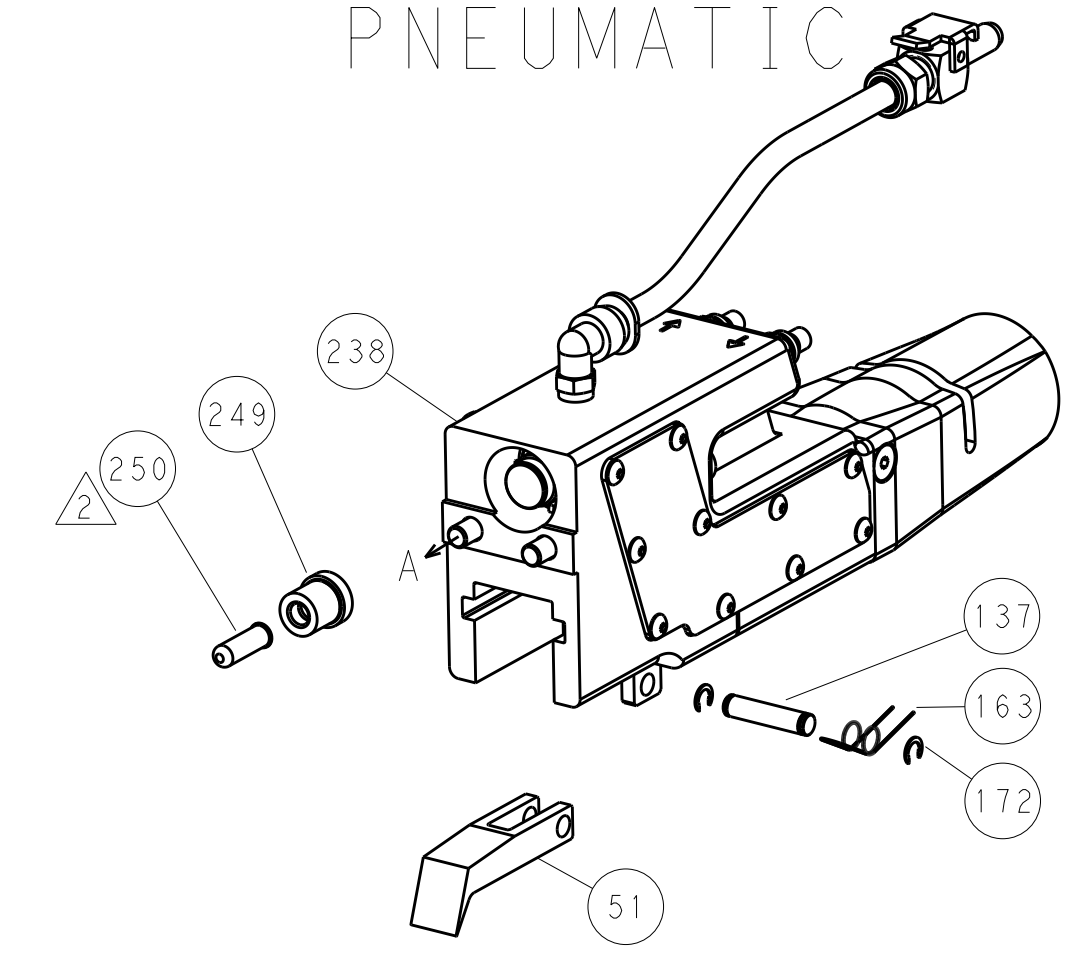


RAM AND HOLDDOWN SET-UP

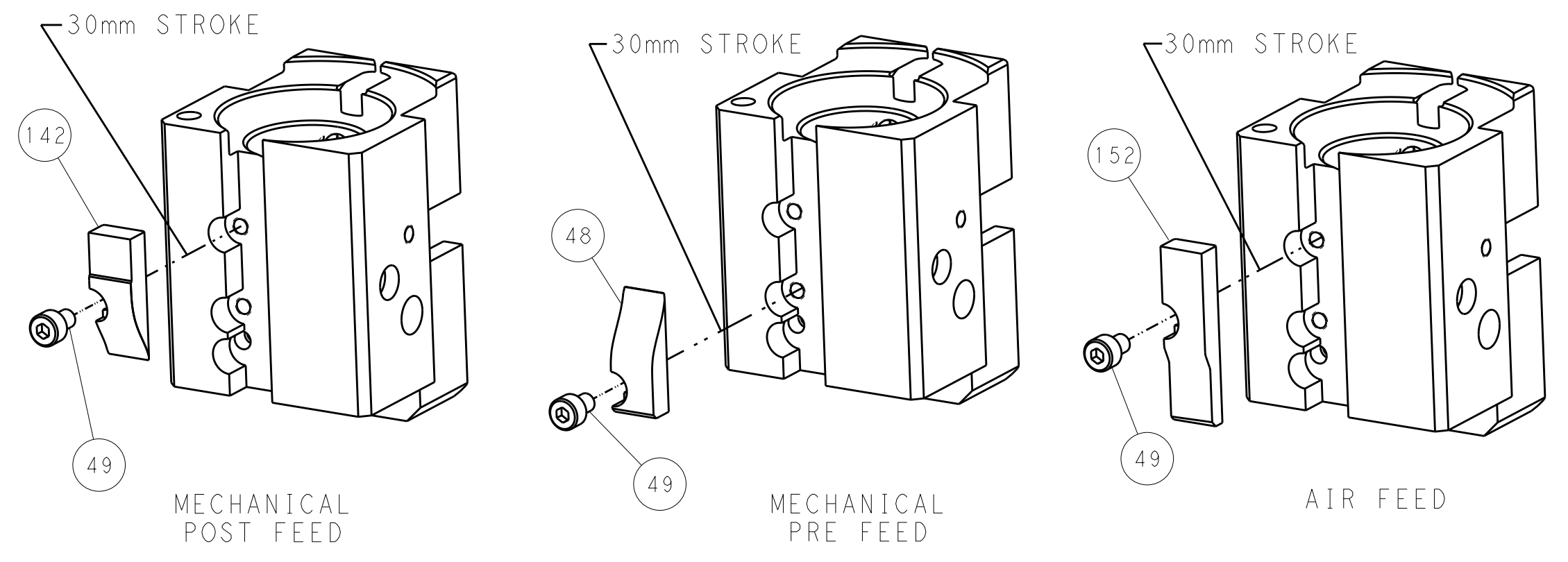
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN L. ZHANG 24FEB2012 CHK L. ZHANG 24FEB2012 APVD S. XI 24FEB2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applier SIZE CAGE CODE DRAWING NO A1 00779 C=2150177 SCALE 1:1 SHEET 4 OF 4 REV E1		RESTRICTED TO - - -	
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[2150177-1](#)