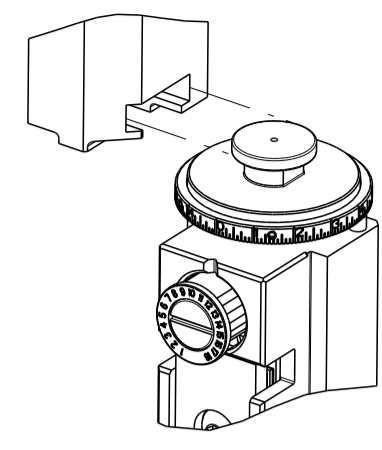


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150030-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150030-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150030-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150030-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150030-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.40-6.40 mm [.173-.252 IN]	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	2238027-3
42510-1	63609-2	140760-2	2238027-4
2238143-1	2238204-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.40-6.40 mm [.173-.252 IN]	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
18 AWG or 0.75mm ²	1.42+/-0.05 [.056+/-0.002]	6.0
22 AWG x 2	1.37+/-0.05 [.054+/-0.002]	6.5
20 AWG or 0.50mm ²	1.30+/-0.05 [.051+/-0.002]	7.3
0.40mm ²	1.27+/-0.05 [.050+/-0.002]	7.6
22 AWG or 0.30mm ²	1.24+/-0.05 [.049+/-0.002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm ²	1.30+/-0.03 [.051+/-0.001]	7.8
0.75mm ²	1.30+/-0.03 [.051+/-0.001]	7.8
0.65mm ²	1.27+/-0.03 [.050+/-0.001]	7.6
0.50mm ²	1.22+/-0.03 [.048+/-0.001]	7.8
0.30mm ²	1.14+/-0.03 [.045+/-0.001]	8.4

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.
- 7 LUBRICANT IS RECOMMENDED.

***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.

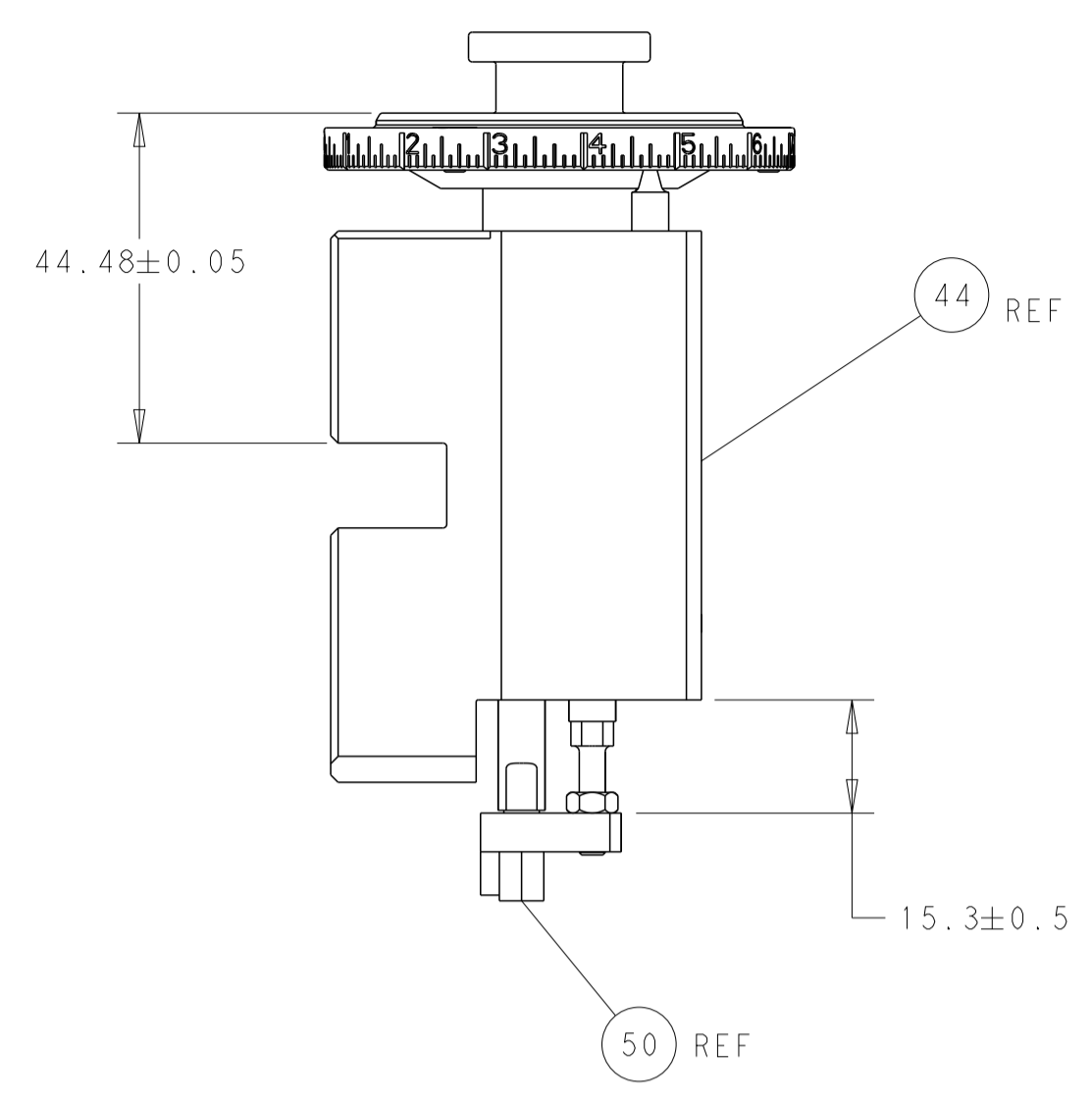
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		H1		ECR-19-016791	29OCT2019	FJ	TE
		J		ECR-20-017512	10DEC2020	FZ	TE
		J1		ECR-20-018206	31DEC2020	FZ	RK
		K		ECR-21-006164	09JUN2021	JWC	RK

6	-	1	1	1	1	3-240641-4	SPACER	261
	-	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
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	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
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
7	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-4	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
	-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	-	-	1-2063961-0	FEED FINGER	58
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	1-2063961-0	FEED FINGER	51
3	-	1	1	1	1	1-1752354-1	STANDOFF, HOLD-DOWN	50
	-	1	2	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	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
	-	7	7	7	7	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	3-240641-3	SPACER	16
	-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
7	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
7	-	1	1	1	1	690495-4	PLATE, FRONT SHEAR	9
7	1	2	2	1	1	1338673-1	ANVIL, COMBINATION	8
7	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	1	1	1	1	240641-3	SPACER	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
7	1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
7	1	2	2	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1

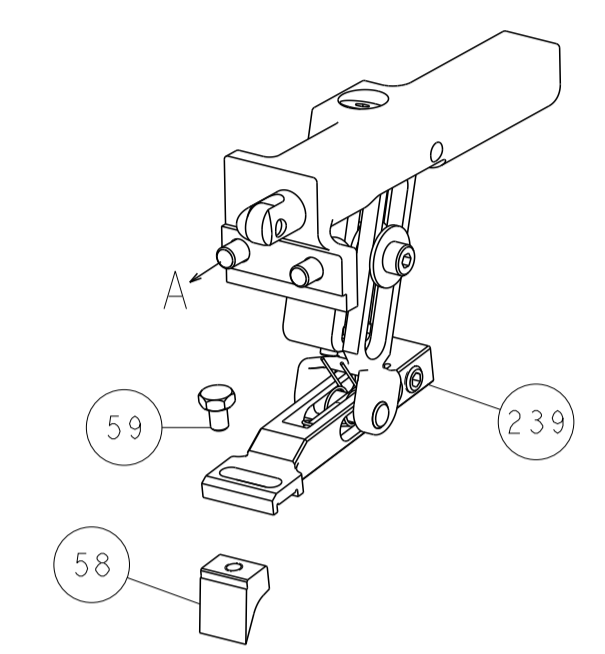
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 OF 4		REV K			

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

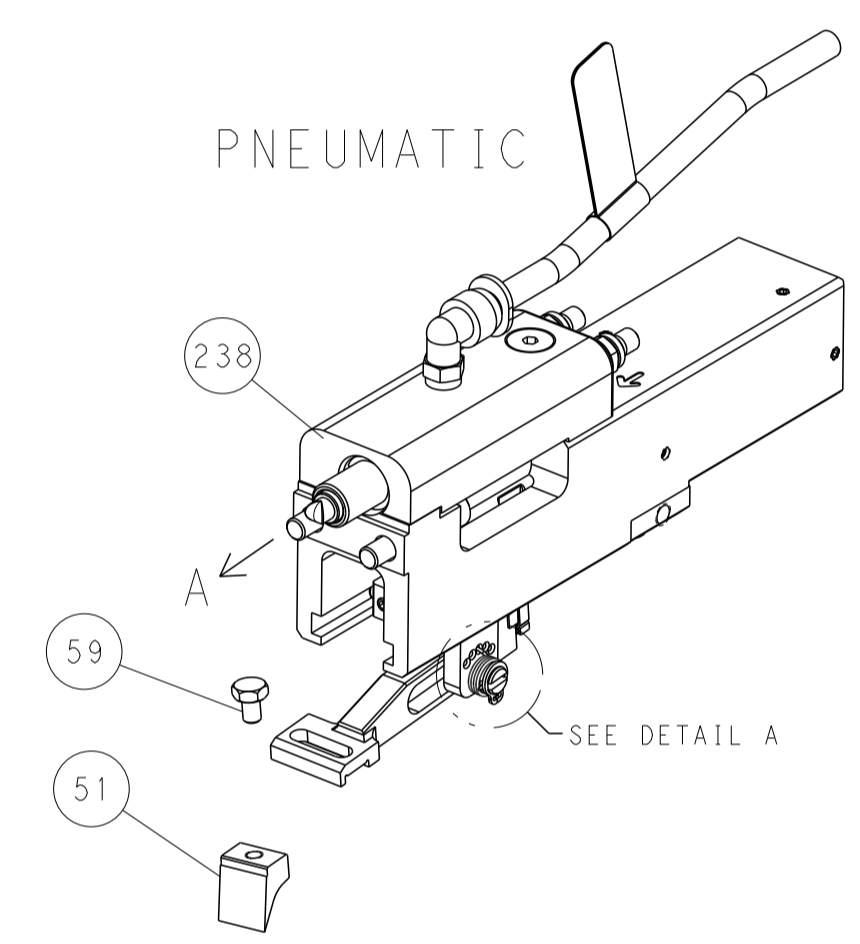


RAM AND HOLDDOWN SET-UP

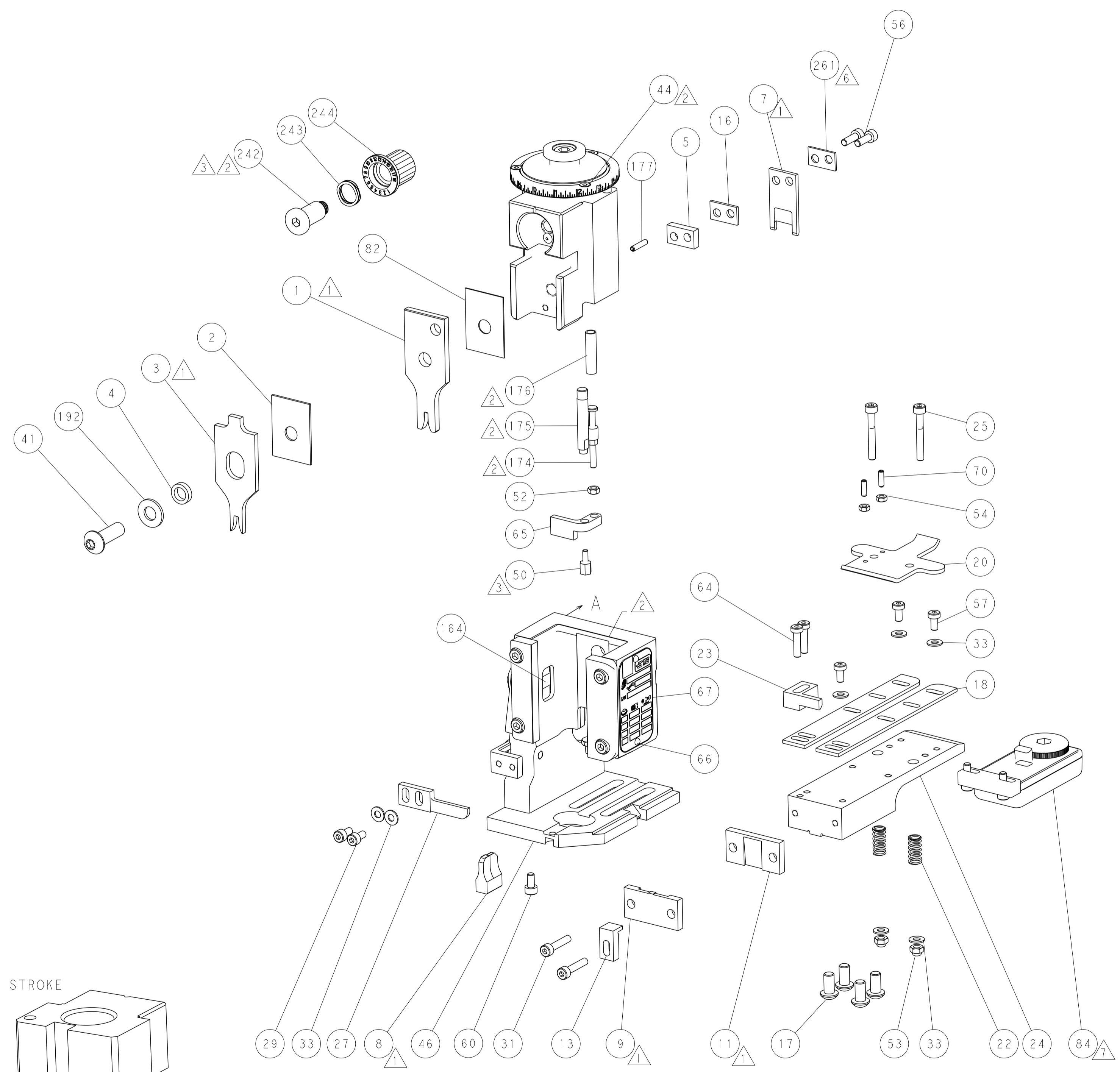
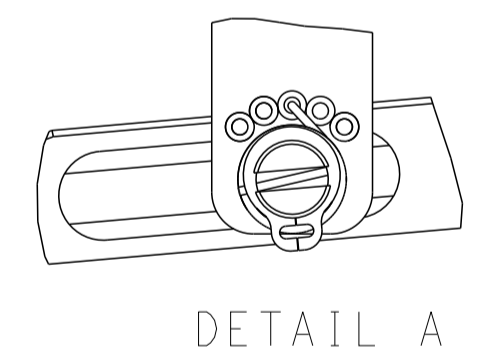
FEED TYPE
MECHANICAL



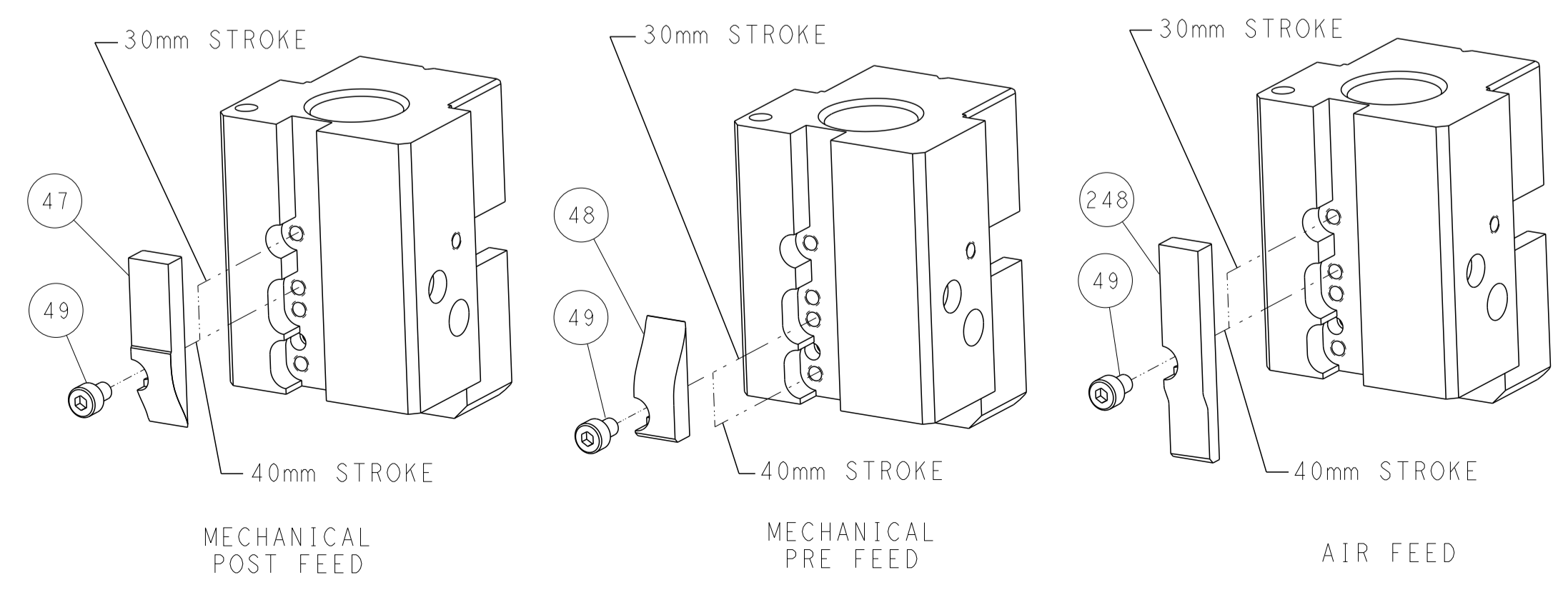
PNEUMATIC



FEED SPRING
SETTING POSITION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN B. WEAVER 09DEC2011 CHK G. HOFFNER 09DEC2011 APVD G. RILEY 09DEC2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150030 SCALE 1:1 SHEET 2 OF 4 REV K	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150030-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150030-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150030-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



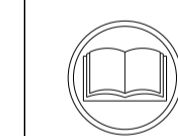
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [1.73-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [1.091-.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	2238027-3
42510-1	63609-2	140760-2	2238027-4
2238143-1	2238204-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [1.73-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [1.091-.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
18 AWG or 0.75mm ²	1.42+/-0.05 [1.056+/-0.002]	6.0
22 AWG x 2	1.37+/-0.05 [1.054+/-0.002]	6.5
20 AWG or 0.50mm ²	1.30+/-0.05 [1.051+/-0.002]	7.3
0.40mm ²	1.27+/-0.05 [1.050+/-0.002]	7.6
22 AWG or 0.30mm ²	1.24+/-0.05 [1.049+/-0.002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm ²	1.30+/-0.03 [1.051+/-0.001]	7.8
0.75mm ²	1.30+/-0.03 [1.051+/-0.001]	7.8
0.65mm ²	1.27+/-0.03 [1.050+/-0.001]	7.6
0.50mm ²	1.22+/-0.03 [1.048+/-0.001]	7.8
0.30mm ²	1.14+/-0.03 [1.045+/-0.001]	8.4



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.
- 7 LUBRICANT IS RECOMMENDED.

***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.

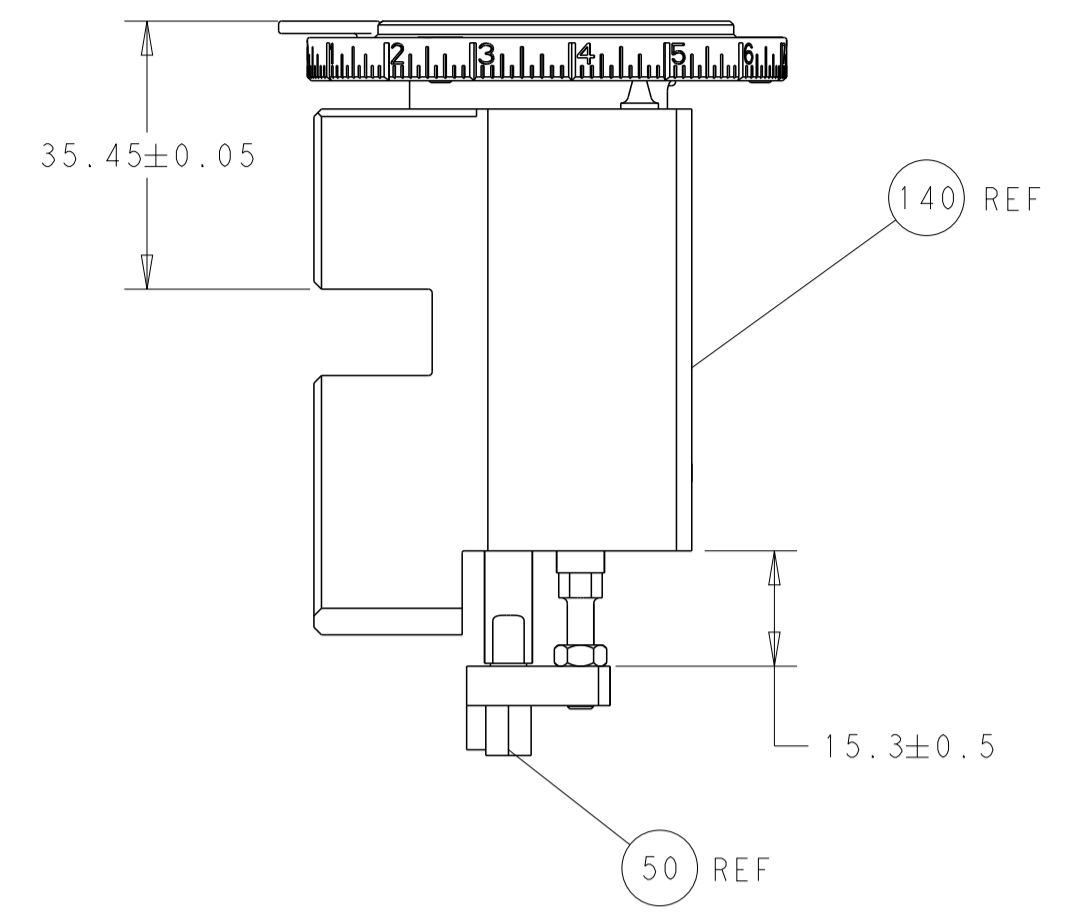
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

6	-	1	1	3-240641-4	SPACER	261
	-	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
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	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
7	-	1	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	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	1-2063961-0	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	-	1-2063961-0	FEED FINGER	51
3	-	1	1	1-1752354-1	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	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	240825-2	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-4	GUIDE, LOWER STRIP	18
	-	1	1	3-240641-3	SPACER	16
	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
	-	1	1	690495-4	PLATE, FRONT SHEAR	9
1	1	1	1	1338673-1	ANVIL, COMBINATION	8
	-	1	1	1-2217206-3	BLADE, SLUG	7
	-	1	1	240641-3	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1

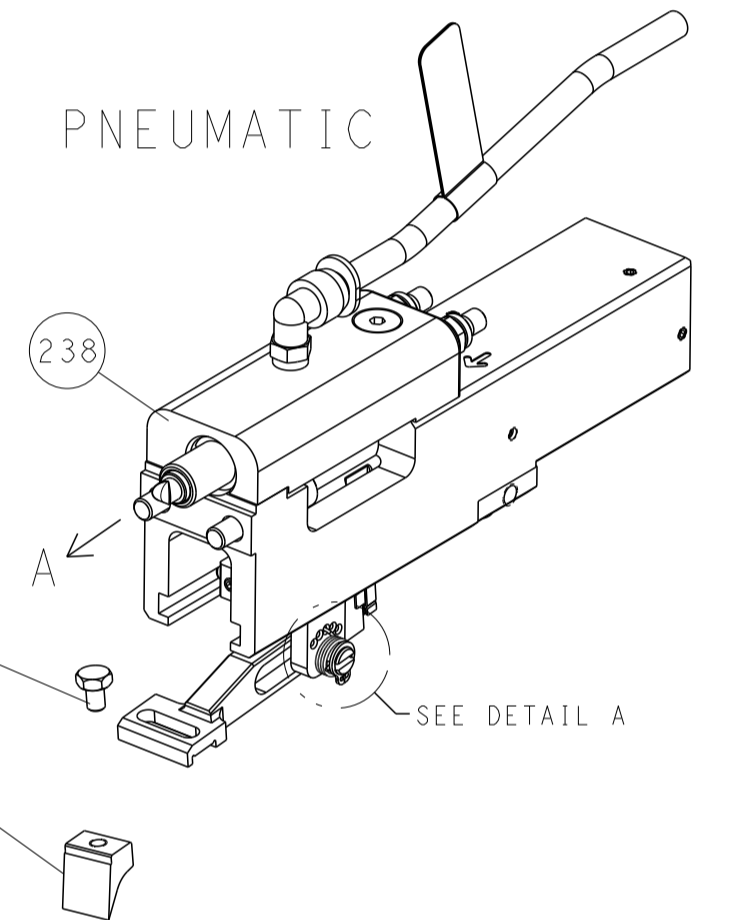
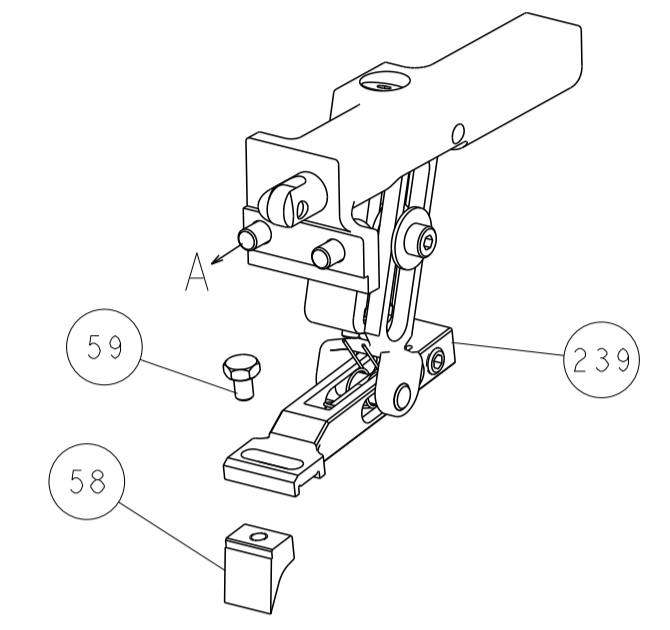
THIS DRAWING IS CONTROLLED THROUGHOUT THE PRODUCT LIFE CYCLE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ORIGINAL DESIGNER AND THE ORIGINAL APPROVER. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ORIGINAL DESIGNER AND THE ORIGINAL APPROVER.		DWN B. WEAVER 09DEC2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFFNER 09DEC2011	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD G. RALLEY 09DEC2011	SIZE A1	
MATERIAL		APPLICATION SPEC	CAGE CODE DRAWING NO 00779 C=2150030	
		WEIGHT	RESTRICTED TO	
		Customer Accessible Production Drawing	SCALE 1:1 SHEET 3 OF 4 REV K	

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

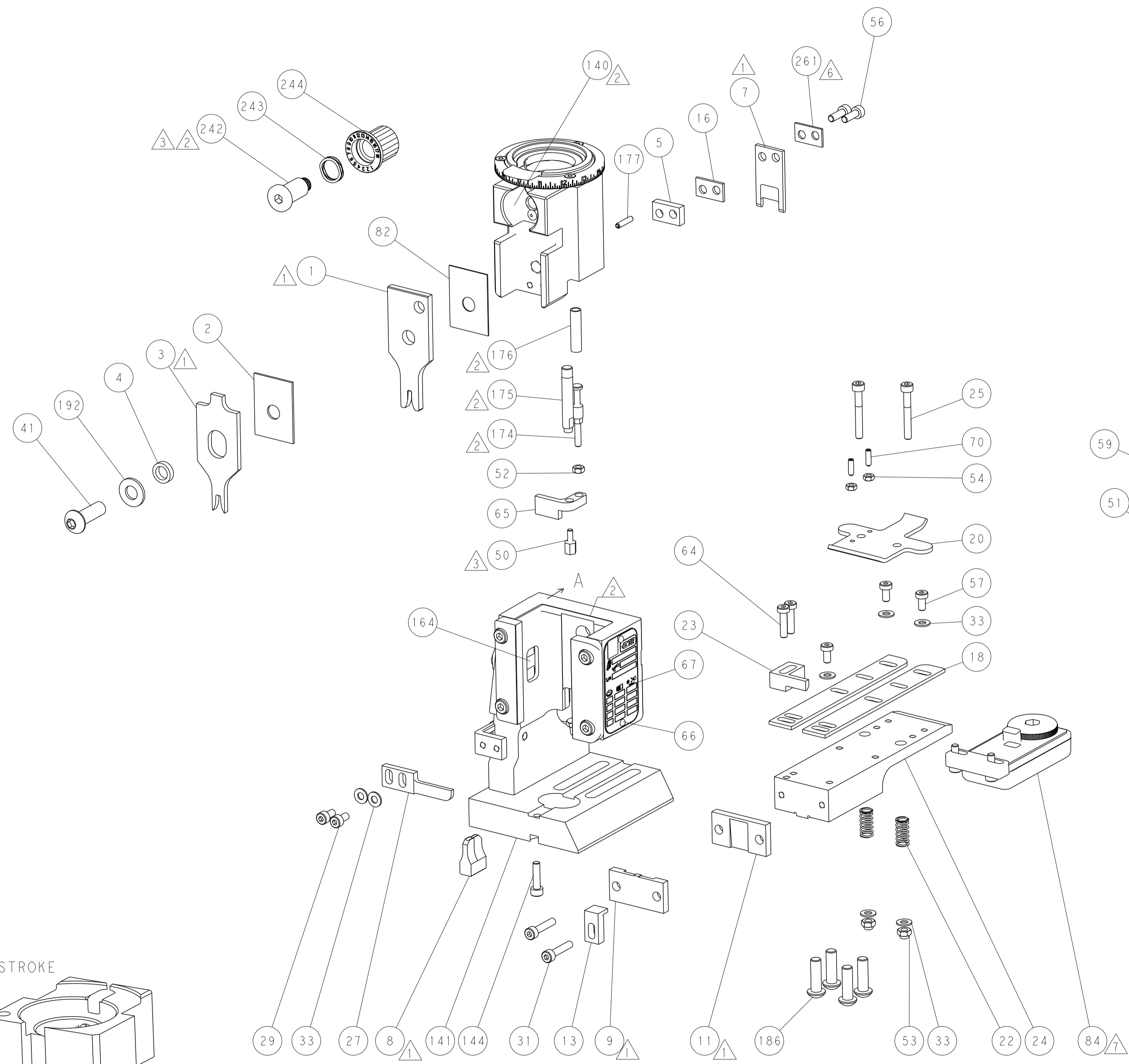
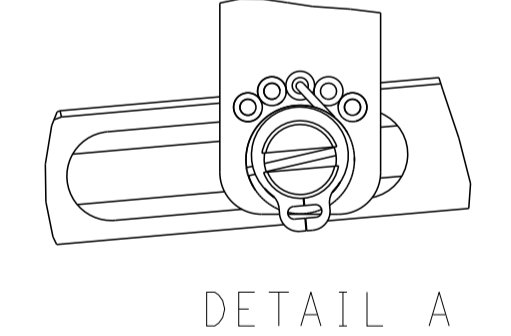


RAM AND HOLDDOWN SET-UP

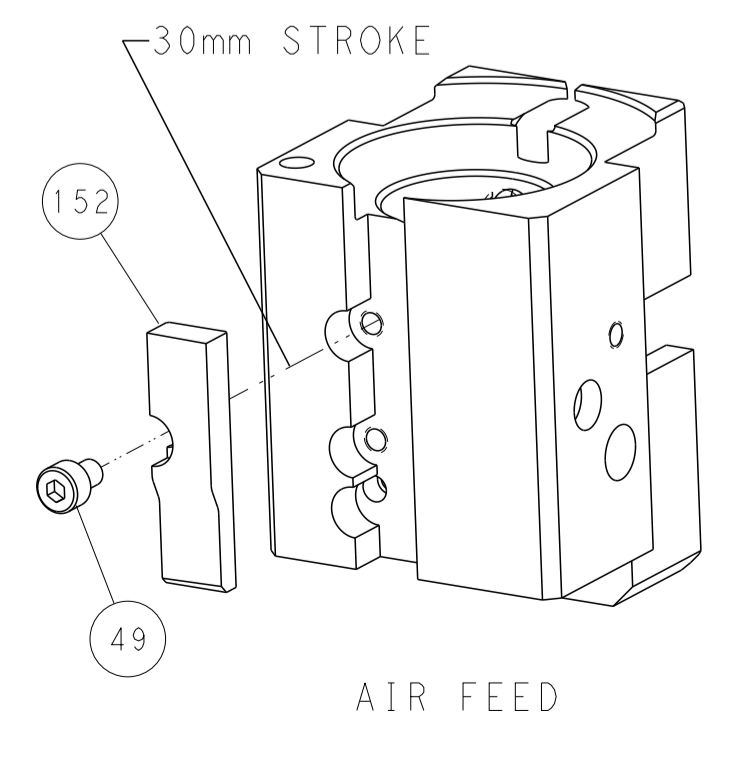
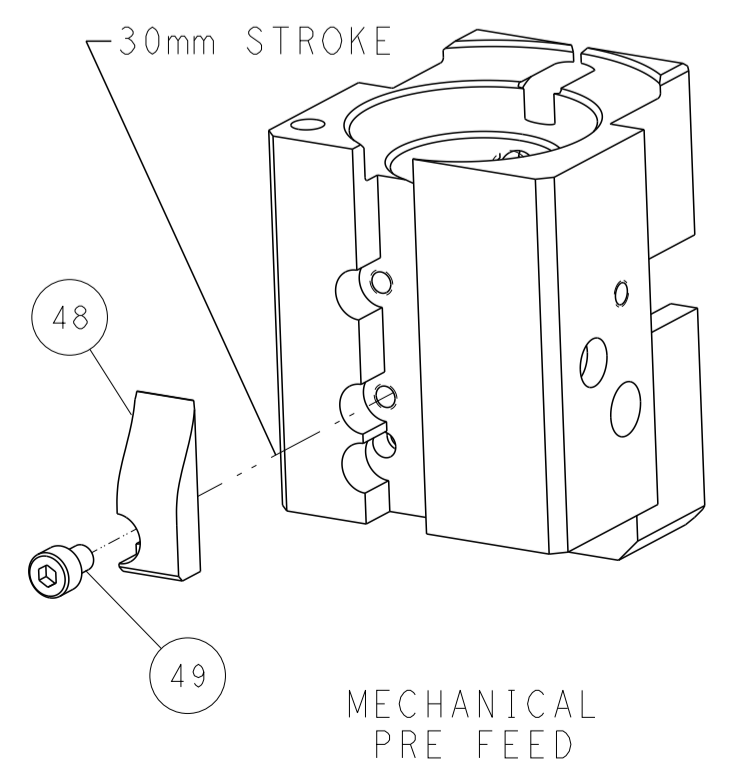
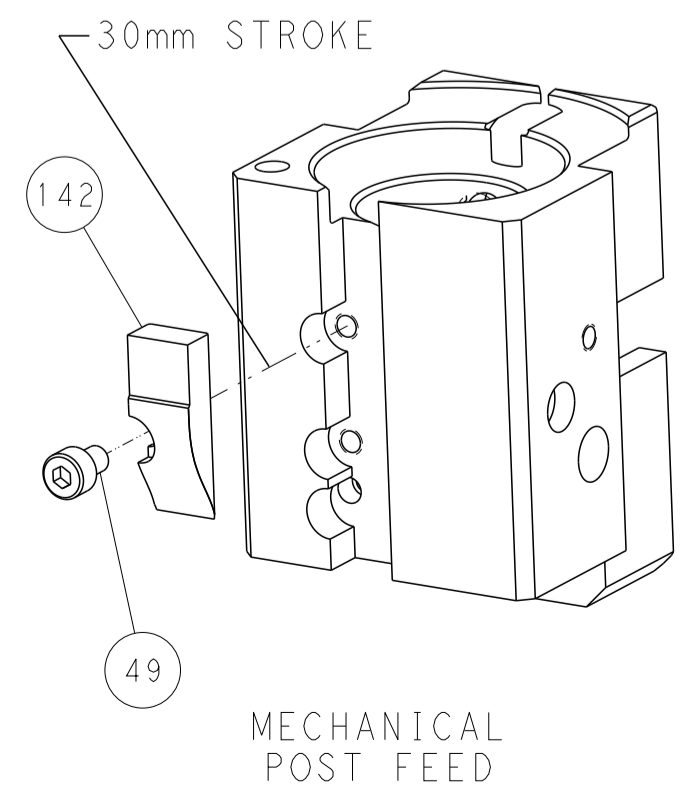
FEED TYPE
MECHANICAL



FEED SPRING
SETTING POSITION



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09DEC2011		CHK: G. HOFENER 09DEC2011		APVD: G. BAILEY 09DEC2011		NAME: STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:1	SHEET: 4	OF: 4	REV: K	Customer Accessible Production Drawing				

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