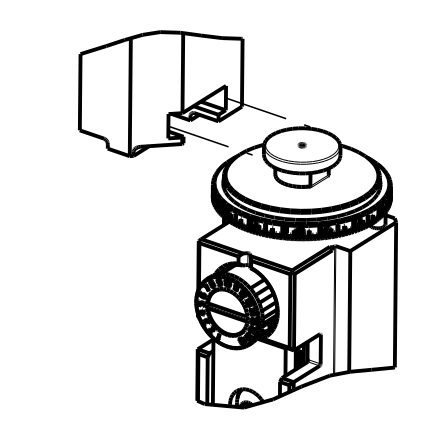


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150041-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150041-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150041-7	A	CRIMP TOOLING KIT	-
7-2150041-8	B	OVERLAP INSULATION CRIMPER	△

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
INSUL	4.57 mm [.180]	OV

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 250 SERIES TAB WITH LATCH

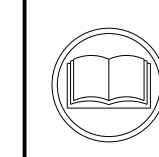
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.80-5.60 mm [.189-.220 IN]	∅2.10-3.40 mm [.083-.134 IN]

TERMINAL APPLICATION SPECIFICATION: 114-5052

TERMINALS APPLIED △

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170030-1	170030-2	170030-3	170030-4
170030-5	170030-9	170340-1	170340-3
1-170340-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.68+/-0.05 [.066+/-0.002]	6.8
1.50mm2	1.63+/-0.05 [.064+/-0.002]	7.0
16 AWG OR 1.25mm2	1.55+/-0.05 [.061+/-0.002]	8.1
18 AWG OR 0.85mm2	1.42+/-0.05 [.056+/-0.002]	9.4
0.75mm2	1.42+/-0.05 [.056+/-0.002]	9.4
20 AWG OR 0.5mm2	1.35+/-0.05 [.053+/-0.002]	10.1



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 FOR CASES THAT IT NEED TO USE WIRES AS DIN 72551-6 OR AVS(INSUL ∅1.60mm-2.7mm)IT IS RECOMMENDED TO USE THE INSULATION CRIMPER OV,PN:2119785-8.
- 8 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

***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.

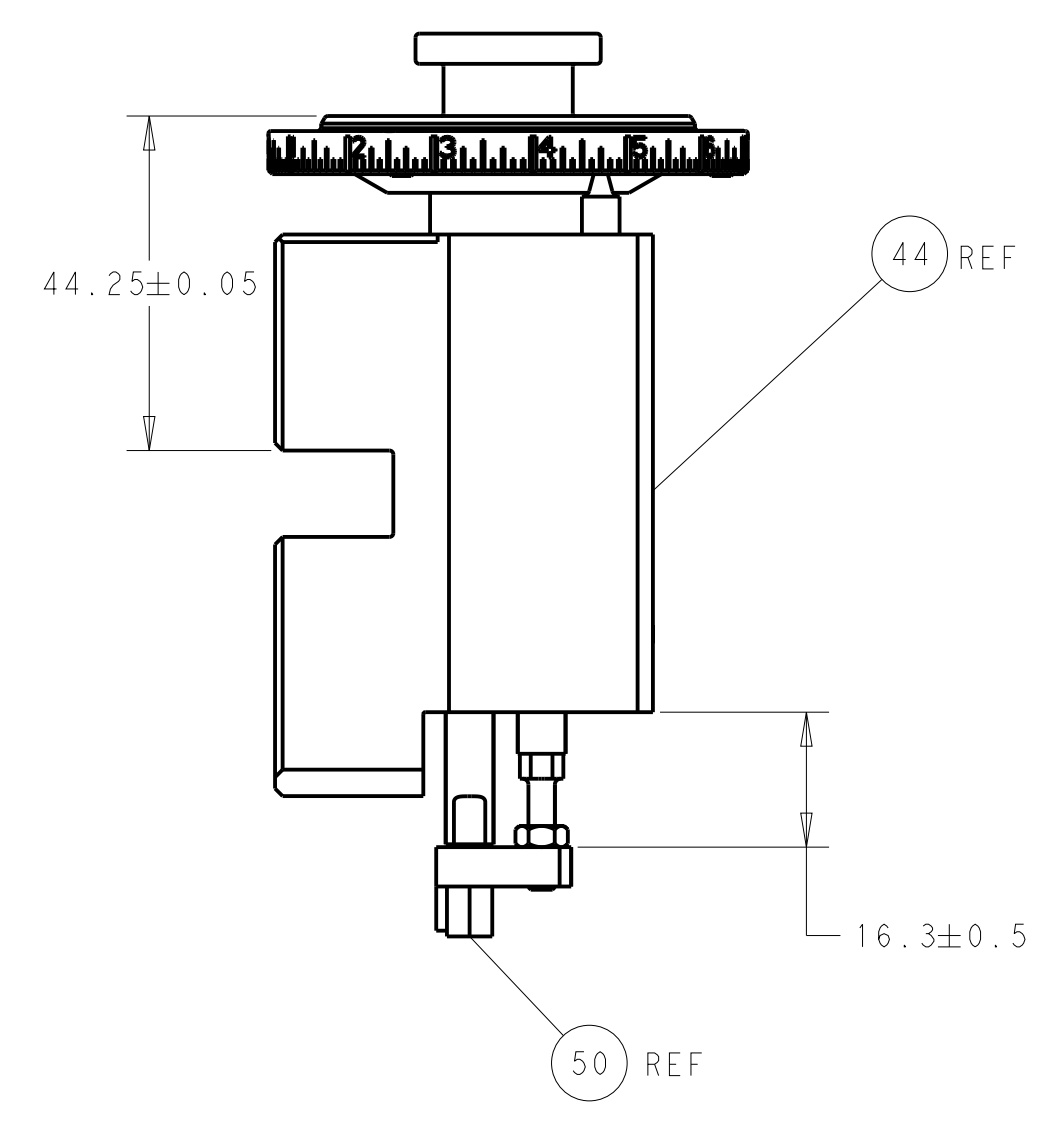
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66						
		B1		ECR-19-011645	24JUL2019	FZ	RK
		B2		ECR-19-012742	13AUG2019	FZ	TE
		B3		ECR-19-017145	05NOV2019	MZ	YY
		C		ECR-21-005972	02JUN2021	FZ	TE

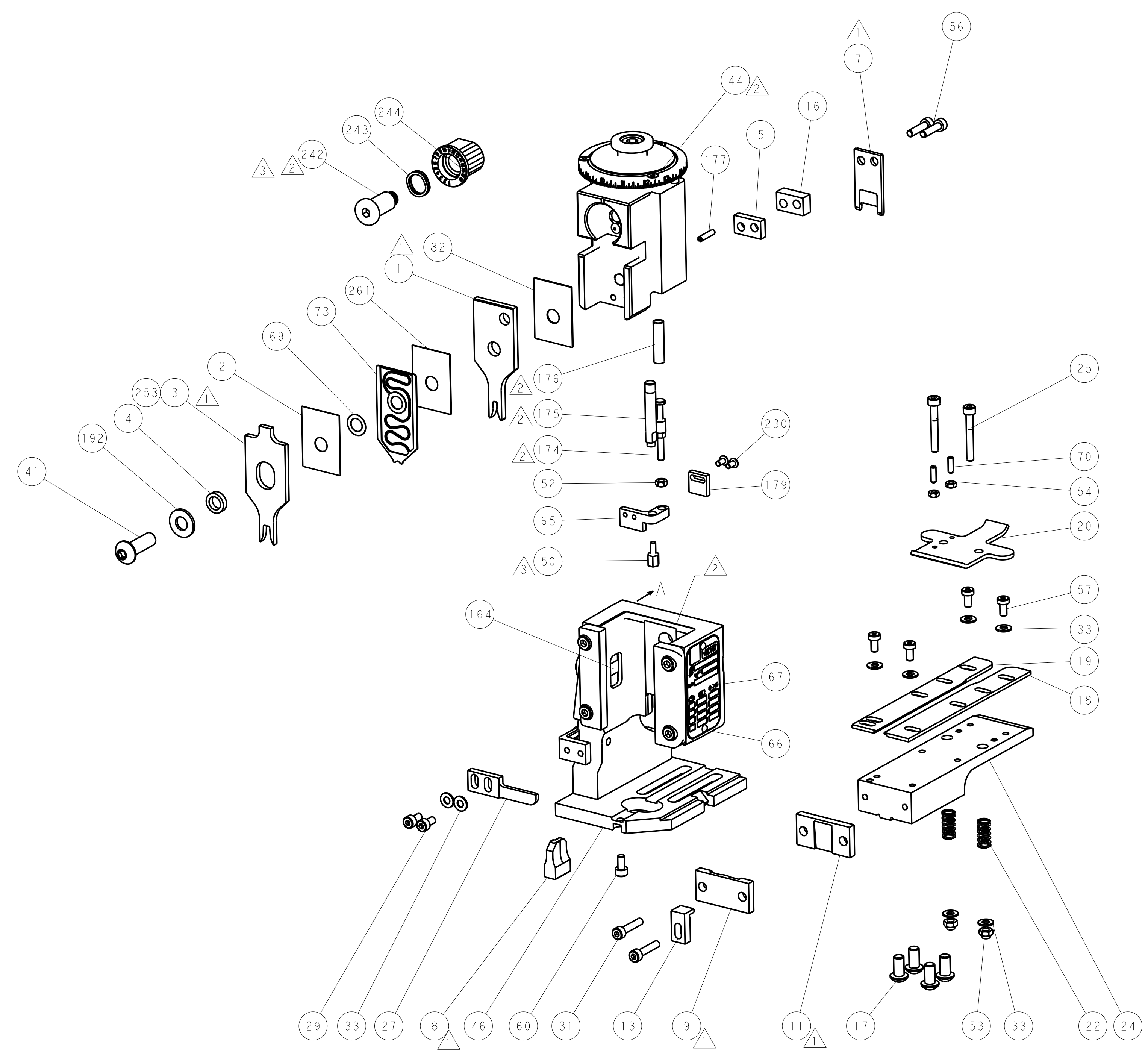
△	-	-	1	1	455888-3	SPACER, CRIMPER	261
△	1	-	-	-	2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	253
	-	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	1	2844940-4	AIR FEED MODULE	238
	-	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	-	1	1	1-1976053-7	LOCATER BLOCK, TERMINAL	179
	-	-	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	2119791-9	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	2119943-1	WASHER, SPACER	69
	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	-	1	1	1-1901681-5	HOLDDOWN, TERMINAL	65
	-	-	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
	-	-	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	1	2063961-9	FEED FINGER	51
△	-	-	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	50
	-	-	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
	-	-	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	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
	-	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	-	1	1	1803292-4	DRAG	20
	-	-	1	1	1901696-3	STRIP GUIDE, REAR	19
	-	-	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	-	1	1	1-240641-5	SPACER	16
	-	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
△	-	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	10
△	-	-	1	1	2-690482-7	PLATE, FRONT SHEAR	9
△	-	1	2	1	1-1333219-1	ANVIL, COMBINATION	8
△	-	-	1	1	1-2217206-1	BLADE, SLUG	7
△	-	-	1	1	1-240641-0	SPACER	5
	-	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△	-	1	2	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	-	1	1	455888-1	SPACER, CRIMPER	2
△	-	1	2	1	456408-6	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	DATE	NAME
mm	0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	H. HUANG	S. XI	13JAN2012	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	APVD	I. CRUZ	13JAN2012	PRODUCT SPEC
					APPLICATION SPEC
		WEIGHT			SIZE CAGE CODE DRAWING NO RESTRICTED TO
					A1 00779 C=2150041
					Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV C

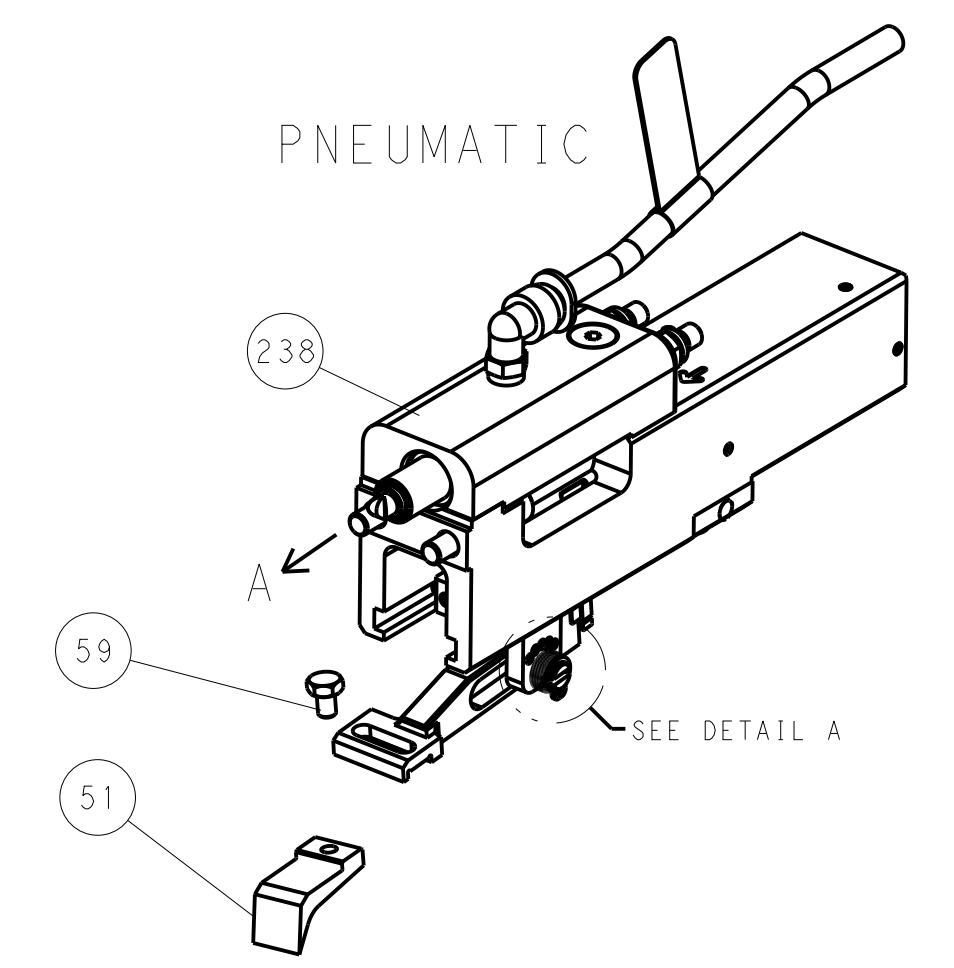
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



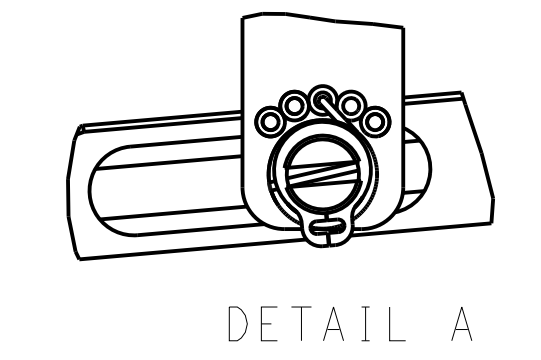
RAM AND HOLDDOWN SET-UP



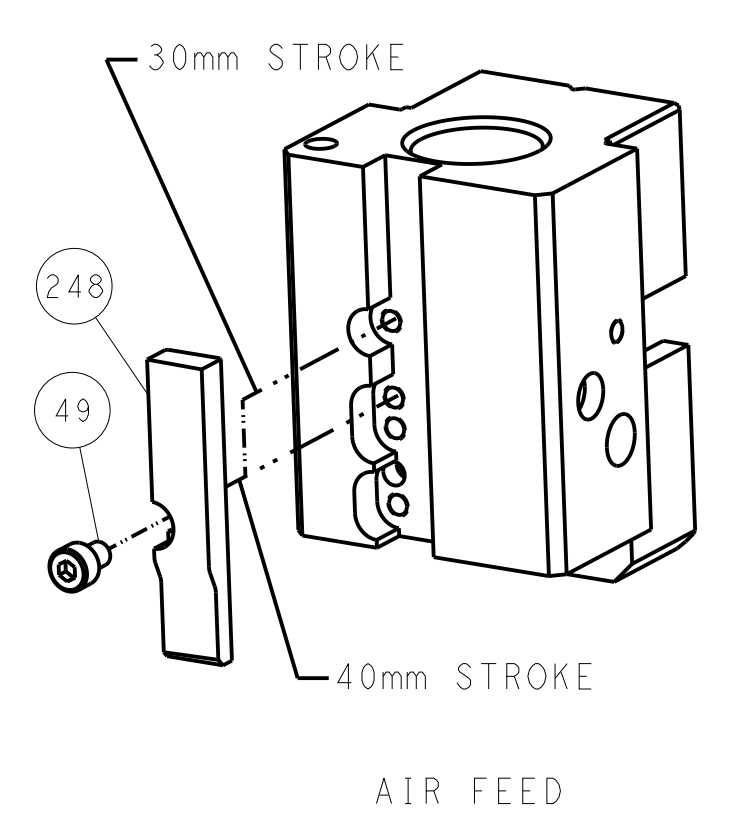
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

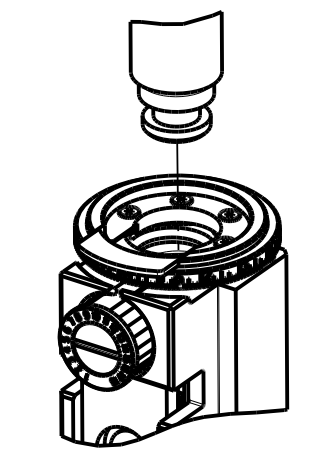


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 13JAN2012 CHK: S. XI 13JAN2012 APVD: J. CRUZ 13JAN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150041 SHEET 2 OF 4 REV C
MATERIAL: FINISH:		RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150041-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150041-7	A	CRIMP TOOLING KIT	-
7-2150041-8	B	OVERLAP INSULATION CRIMPER	△

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
INSUL	4.57 mm [.180]	OV

APPL INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES TAB WITH LATCH			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE ∅2.10-3.40 mm [.083-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5052			
TERMINALS APPLIED △			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170030-1	170030-2	170030-3	170030-4
170030-5	170030-9	170340-1	170340-3
1-170340-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING △
14 AWG OR 2.00mm2	1.68+/-0.05 [.066+/-0.002]	6.8
1.50mm2	1.63+/-0.05 [.064+/-0.002]	7.0
16 AWG OR 1.25mm2	1.55+/-0.05 [.061+/-0.002]	8.1
18 AWG OR 0.85mm2	1.42+/-0.05 [.056+/-0.002]	9.4
0.75mm2	1.42+/-0.05 [.056+/-0.002]	9.4
20 AWG OR 0.5mm2	1.35+/-0.05 [.053+/-0.002]	10.1

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 FOR CASES THAT IT NEED TO USE WIRES AS DIN 72551-6 OR AVS(INSUL ∅1.60mm-2.7mm) IT IS RECOMMENDED TO USE THE INSULATION CRIMPER OV, PN: 2119785-8.
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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.

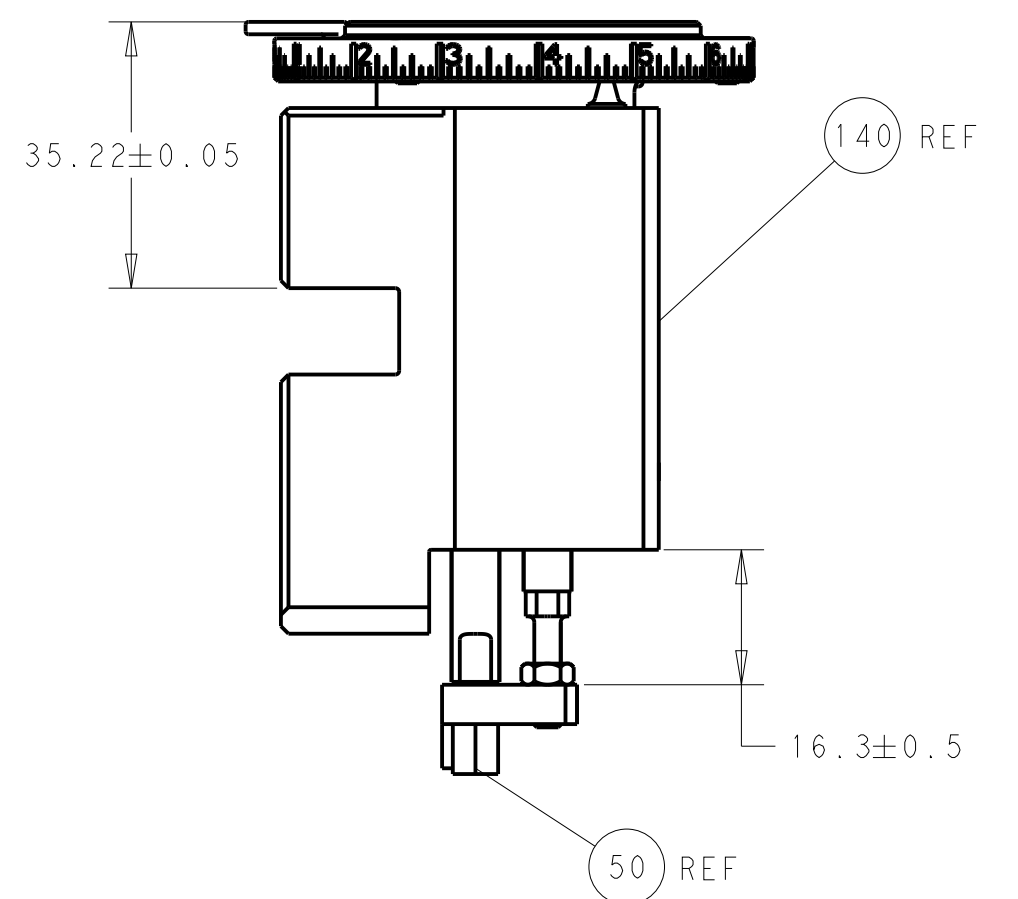
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPD
-	-	1	SEE SHEET 1	-	-

△	-	-	1	455888-3	SPACER, CRIMPER	261
△	-	-	-	2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	253
-	-	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	1	2844940-4	AIR FEED MODULE	238
-	-	-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	-	-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	-	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	-	1	1-1976053-7	LOCATER BLOCK, TERMINAL	179
-	-	-	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	2119791-9	DEPRESSOR, WIRE	73
-	-	-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	-	-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	-	-	1	2119943-1	WASHER, SPACER	69
-	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	-	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	1	1-1901681-5	HOLDDOWN, TERMINAL	65
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	-	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2063961-9	FEED FINGER	51
△	-	-	1	1-1752354-1	STANDOFF, HOLD-DOWN	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	8	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	1752371-1	PLATE, STRIP GUIDE	24
-	-	-	2	2-22281-3	SPRING, COMPRESSION	22
-	-	-	1	1803292-4	DRAG	20
-	-	-	1	1901696-3	STRIP GUIDE, REAR	19
-	-	-	1	1901695-3	STRIP GUIDE, FRONT	18
-	-	-	1	1-240641-5	SPACER	16
-	-	-	1	1752360-1	SPACER, HOLD-DOWN	13
△	-	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
△	-	-	1	2-690482-7	PLATE, FRONT SHEAR	9
△	-	-	1	1-1333219-1	ANVIL, COMBINATION	8
△	-	-	1	1-2217206-1	BLADE, SLUG	7
-	-	-	1	1-240641-0	SPACER	5
-	-	-	1	238011-2	BLOCK, CRIMPER SPACER	4
△	-	-	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	-	-	1	455888-1	SPACER, CRIMPER	2
△	-	-	1	456408-6	CRIMPER, WIRE PREMIUM	1

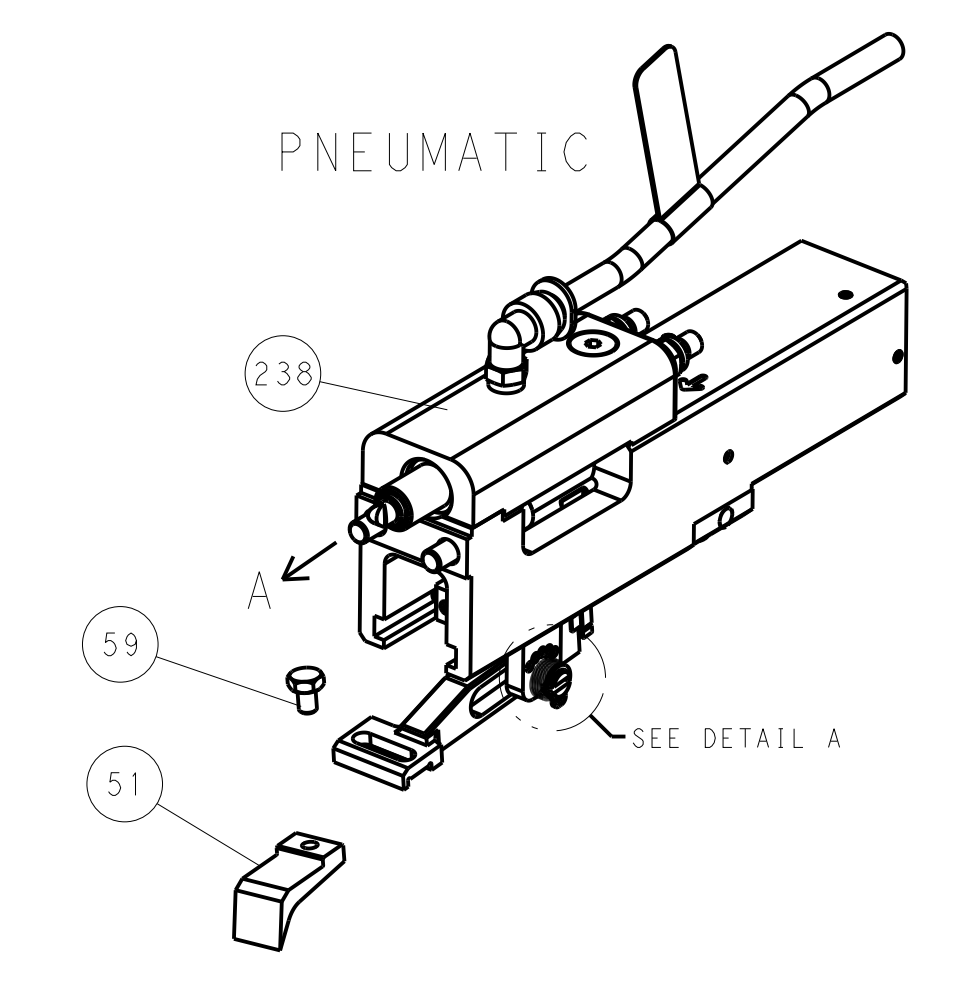
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	TE Connectivity
	ANGLES	FINISH	WEIGHT	SCALE	SHEET	OF	REV
				1:1	3	4	C

LOC	DIST	REV	DATE	BY	APPV
A	66				

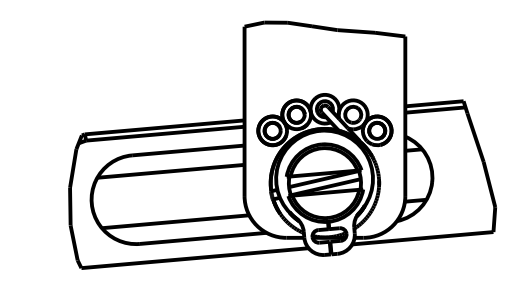


RAM AND HOLDDOWN SET-UP

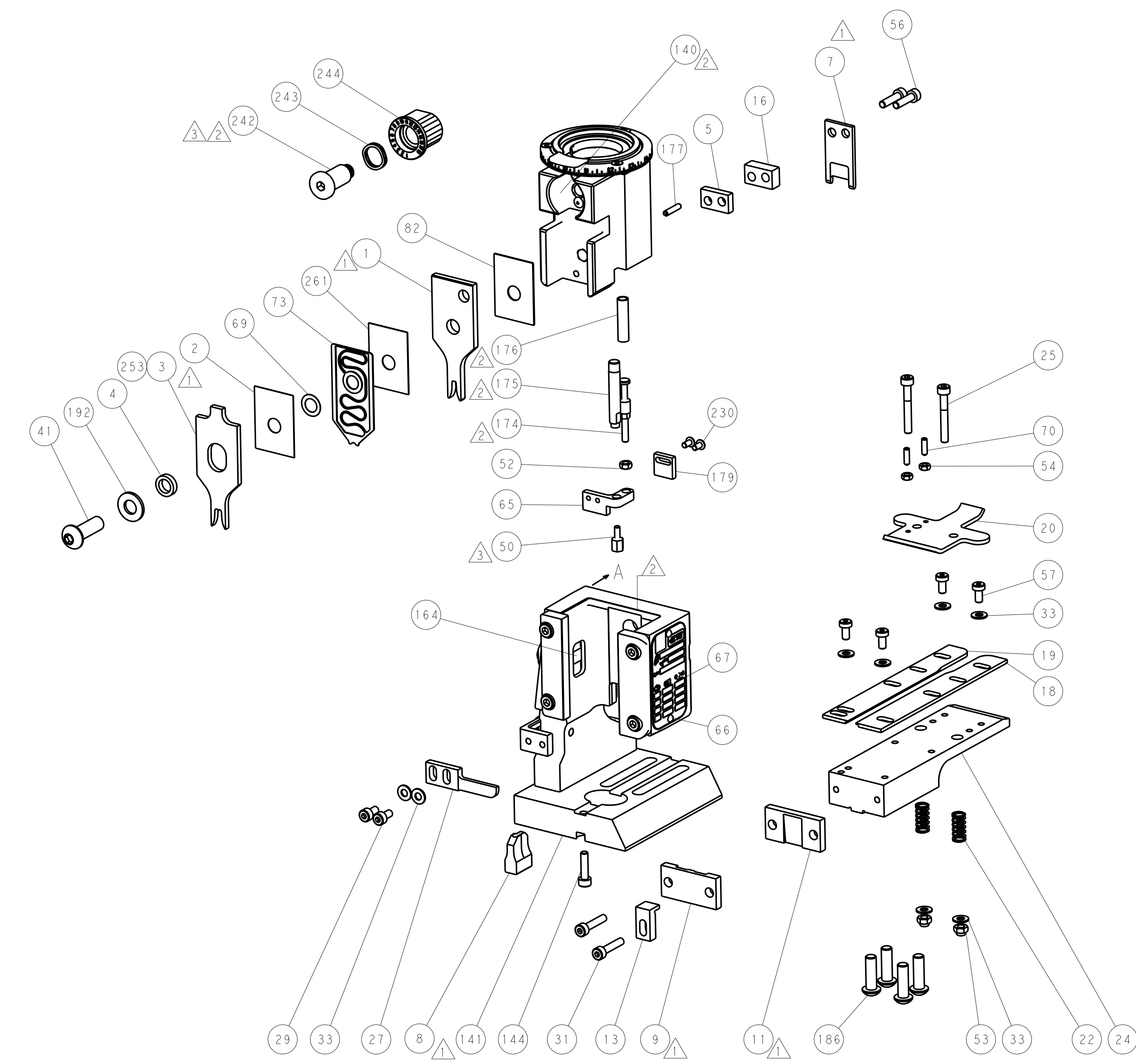
FEED TYPE



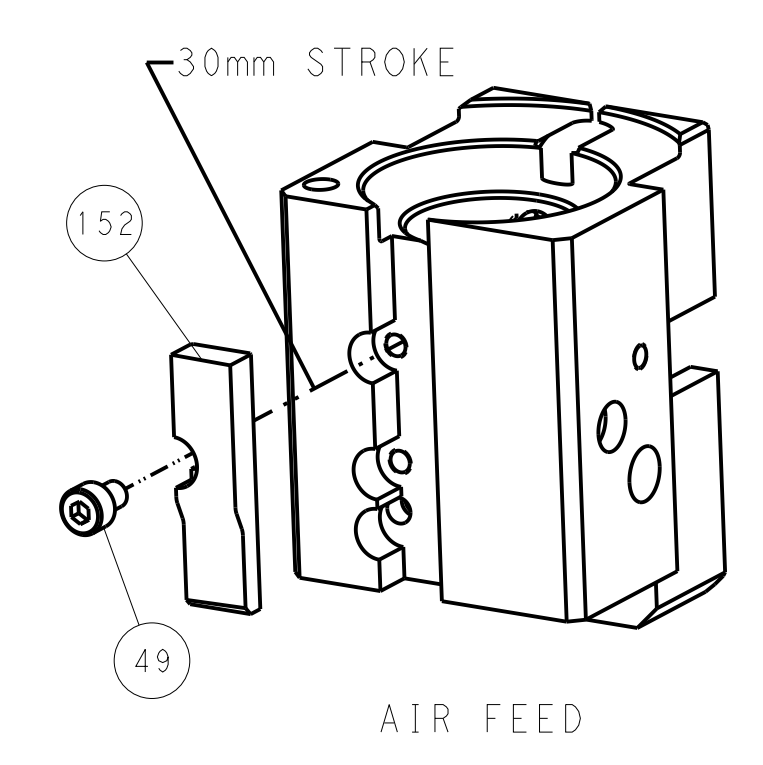
FEED SPRING SETTING POSITION



DETAIL A



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: K. HUANG 13JAN2012 CHK: S. XI 13JAN2012 APVD: J. CRUZ 13JAN2012		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150041	
MATERIAL:		FINISH:		WEIGHT:		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV C	