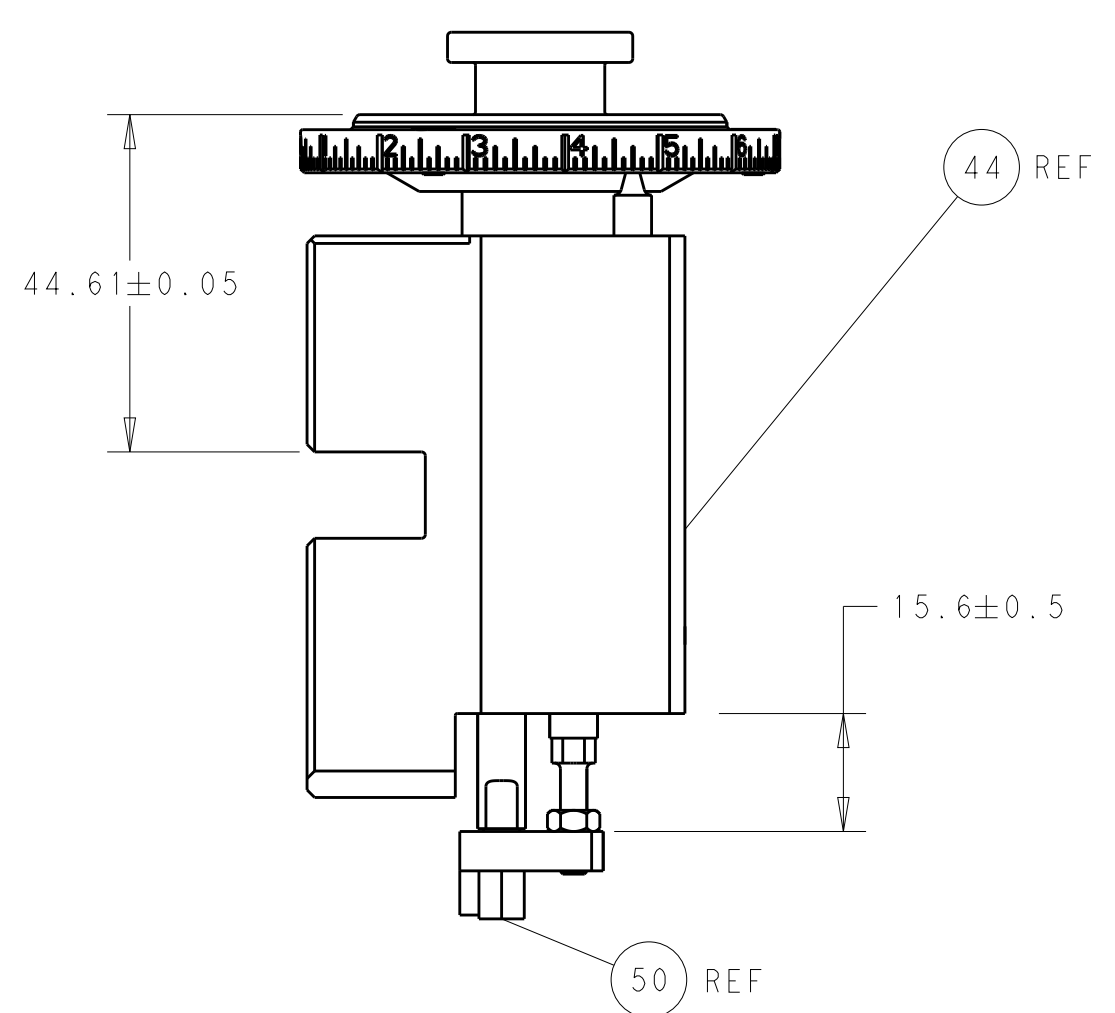
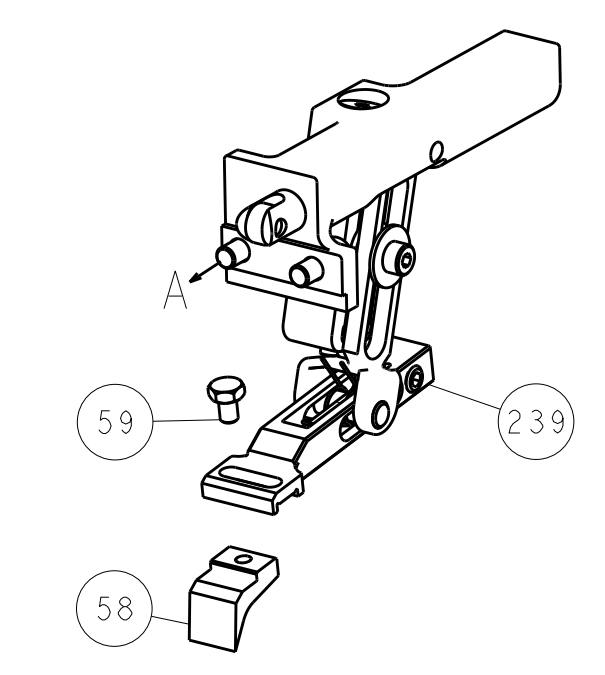


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

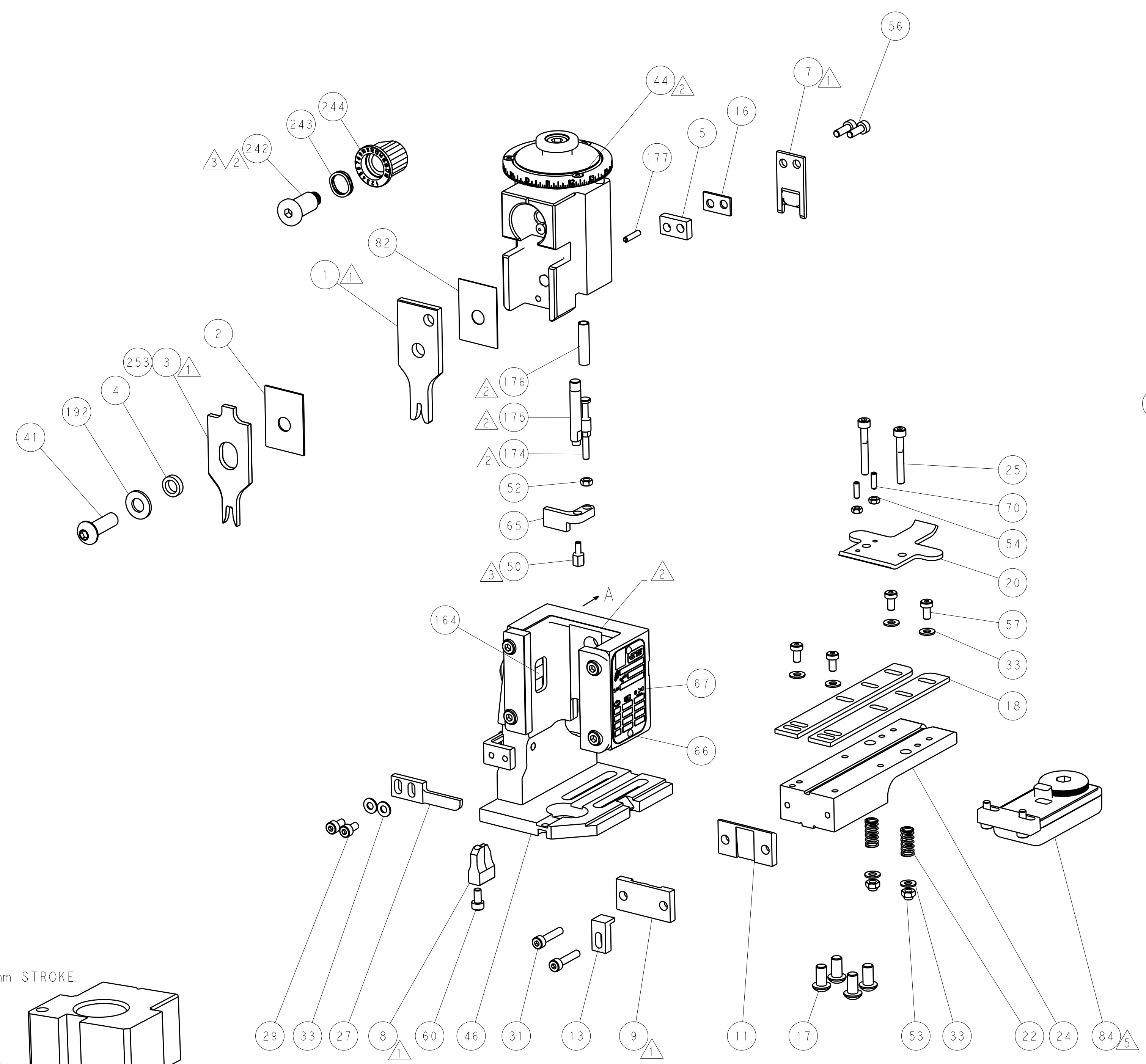
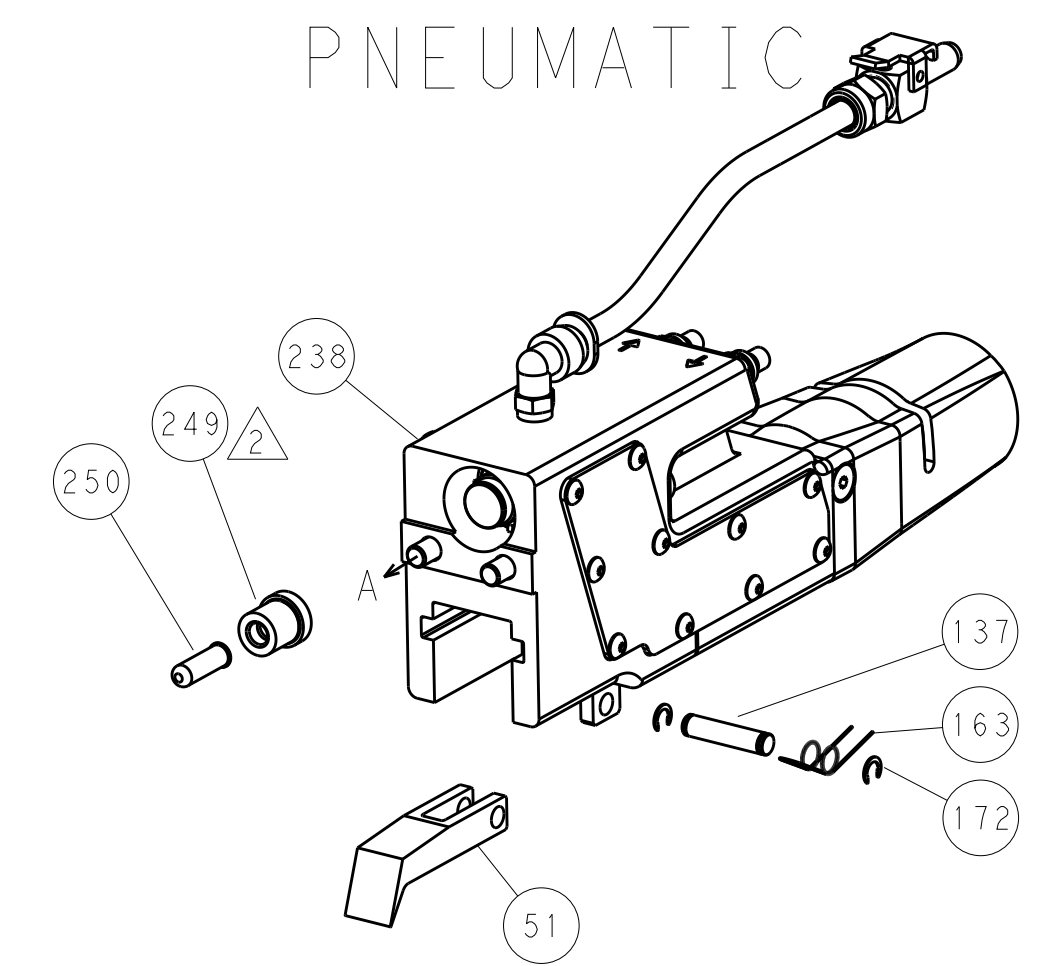


RAM AND HOLDDOWN SET-UP

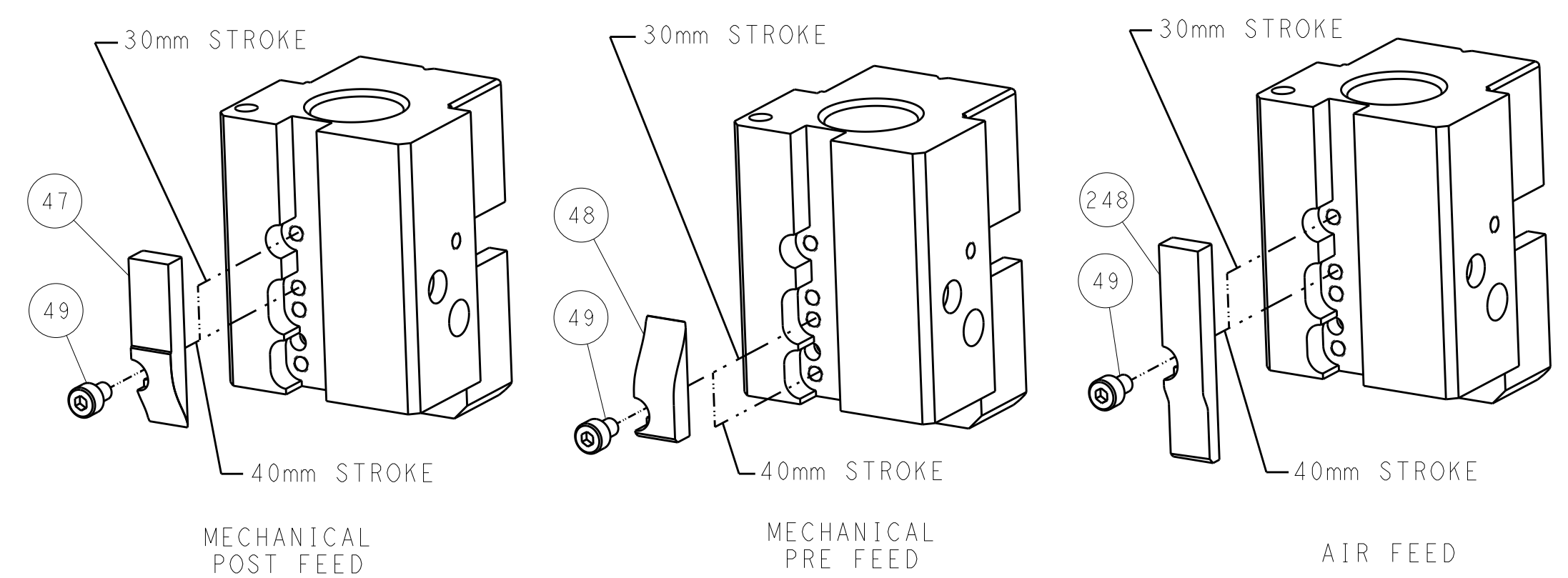
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

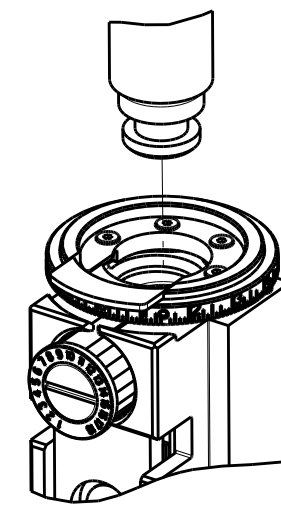


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C.CHEN 09JAN2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK S.XI 09JAN2012		NAME Ocean End Feed Applicator	
				APVD J.CRUZ 09JAN2012		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				PRODUCT SPEC		A1 00779 ©=2150034	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:1 SHEET 2 OF 4 REV E1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150034-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150034-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150034-7	A	CRIMP TOOLING KIT	-
7-2150034-8	E	OVERLAP INSULATION CRIMPER	△9

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 RECEPTACLE WITH LATCH			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.90 mm [.205-.232 IN]		∅2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5052		
TERMINALS APPLIED △5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170032-1	170032-2	170032-5	170342-1
170342-2	170031-1	170031-2	170031-3
170031-5	1-170031-1	1-170031-2	2-170031-1
2-170031-2	4-170031-2		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES RECEPTACLE WITH LATCH			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.90 mm [.205-.232 IN]		∅2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	△9		
TERMINALS APPLIED △5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170342-1	170342-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING △4
2.00mm2	1.45+/-0.05 [.057+/-0.002]	3.3
1.25mm2	1.35+/-0.05 [.053+/-0.002]	6.3
0.85mm2	1.19+/-0.05 [.047+/-0.002]	7.1
△8 0.50mm2	1.12+/-0.05 [.044+/-0.002]	8.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING △4
1.50mm2	1.35+/-0.05 [.053+/-0.002]	6.3

*WARNING
ON INSTALLATION, SET WIRE DISC TO 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.

- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- △ 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ 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; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. 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.
- △ WIRE SIZE 0.50mm2 IS NOT RECOMMENDED BY APPLICATOR PRODUCT ENGINEERING.
- △ FOR CASES THAT IT NEED TO USE WIRES AS DIN 72551-6 OR AVS(INSUL.∅1.6MM-2.7MM)IT IS RECOMMENDED TO USE THE INSULATION CRIMPER OV,PN:2119785-8.

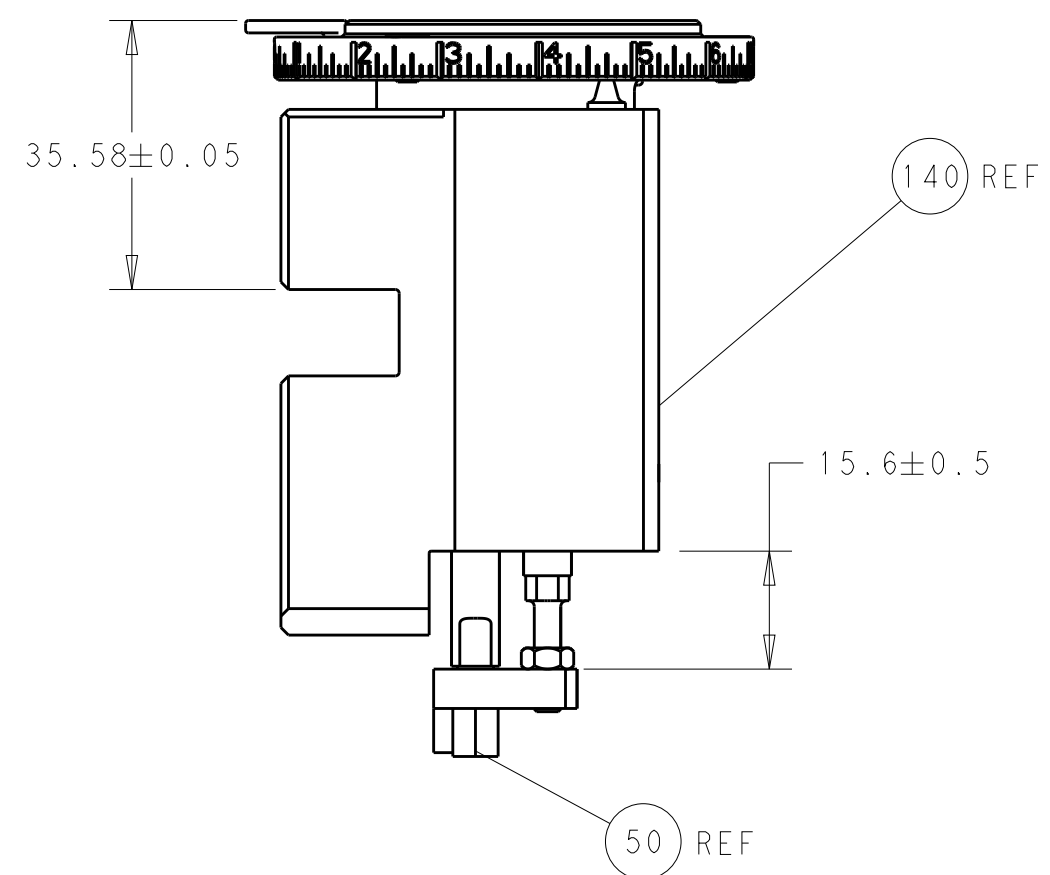
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS						
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY
-	-	-	-	SEE SHEET 1	-	-
△9	1	-	-	2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	253
-	-	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	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
-	-	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
-	-	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
△5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	-	1	1	455888-4	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	2168083-3	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	-	2119792-2	PAWL, EF, AIR	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	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	1752371-3	PLATE, STRIP GUIDE	24
-	-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	-	1	1	1803292-1	DRAG	20
-	-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	-	1	1	3-240641-9	SPACER	16
-	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
△1	-	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
△1	-	1	1	690482-3	PLATE, FRONT SHEAR	9
△1	-	1	1	1333219-2	ANVIL, COMBINATION	8
△1	-	1	1	1-2217206-3	BLADE, SLUG	7
-	-	1	1	1-240641-2	SPACER	5
-	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△1	-	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	455888-8	SPACER, CRIMPER	2
△1	-	1	1	2-456408-9	CRIMPER, WIRE PREMIUM	1

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

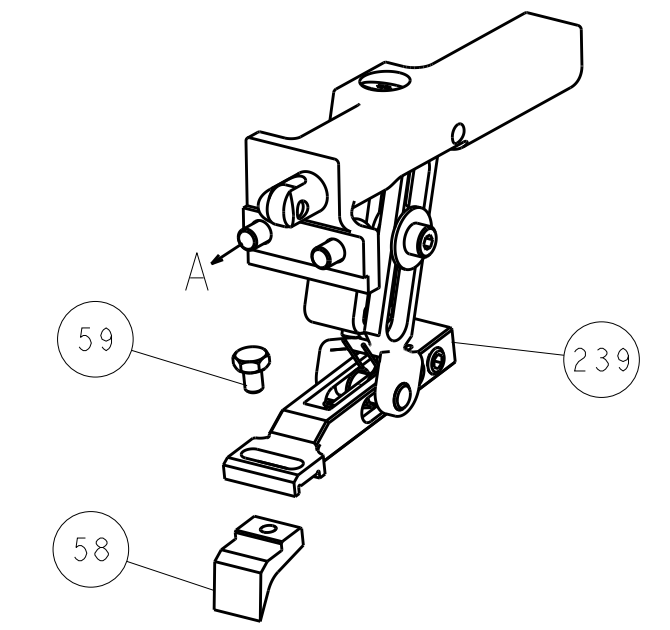
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	3 PLC ±	4 PLC ±	ANGLES ±	09JAN2012	CHK
MATERIAL	FINISH	WEIGHT	SCALE	00779	C=2150034
Customer Accessible Production Drawing				SHEET 3 OF 4	REV E1

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

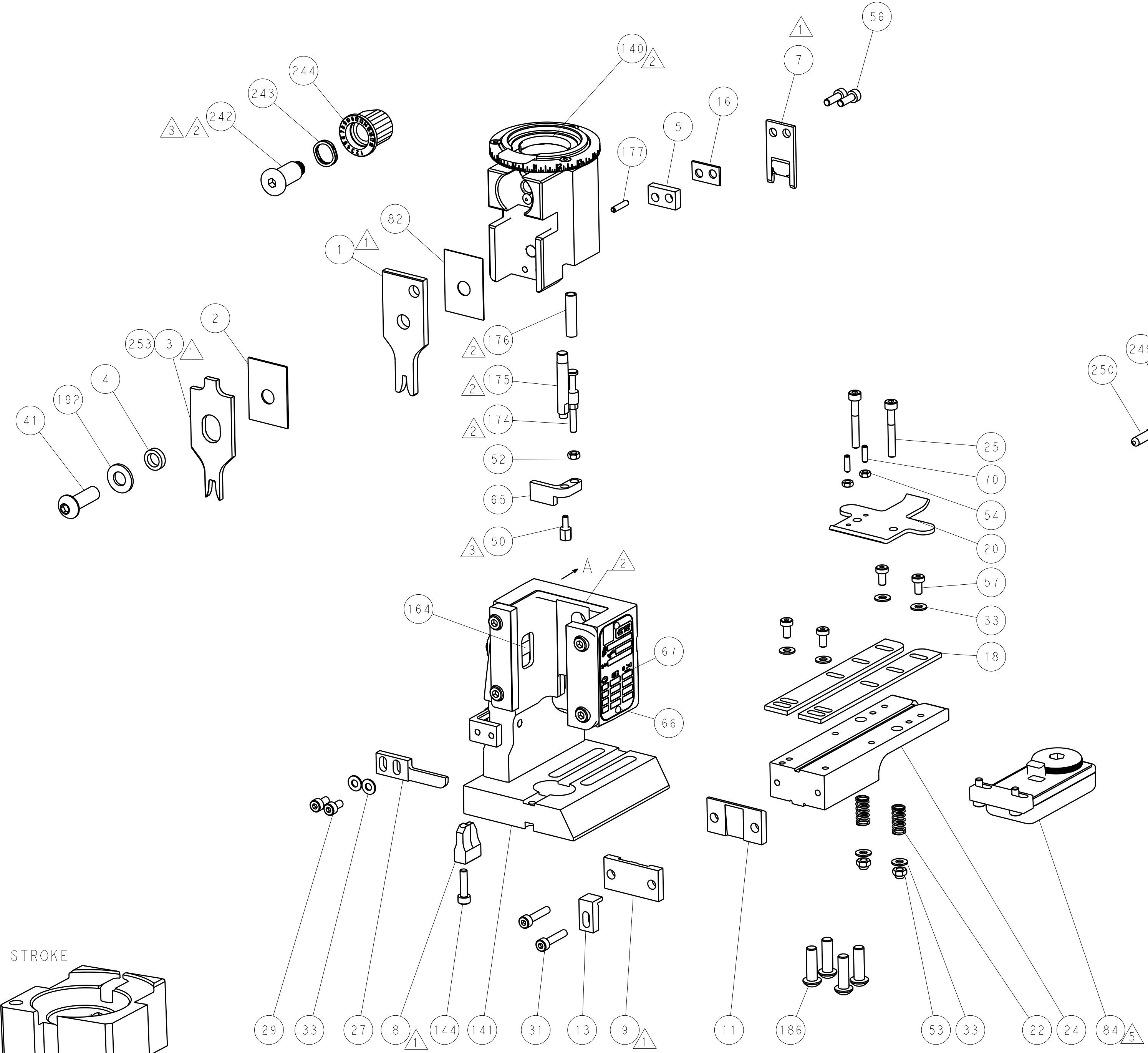
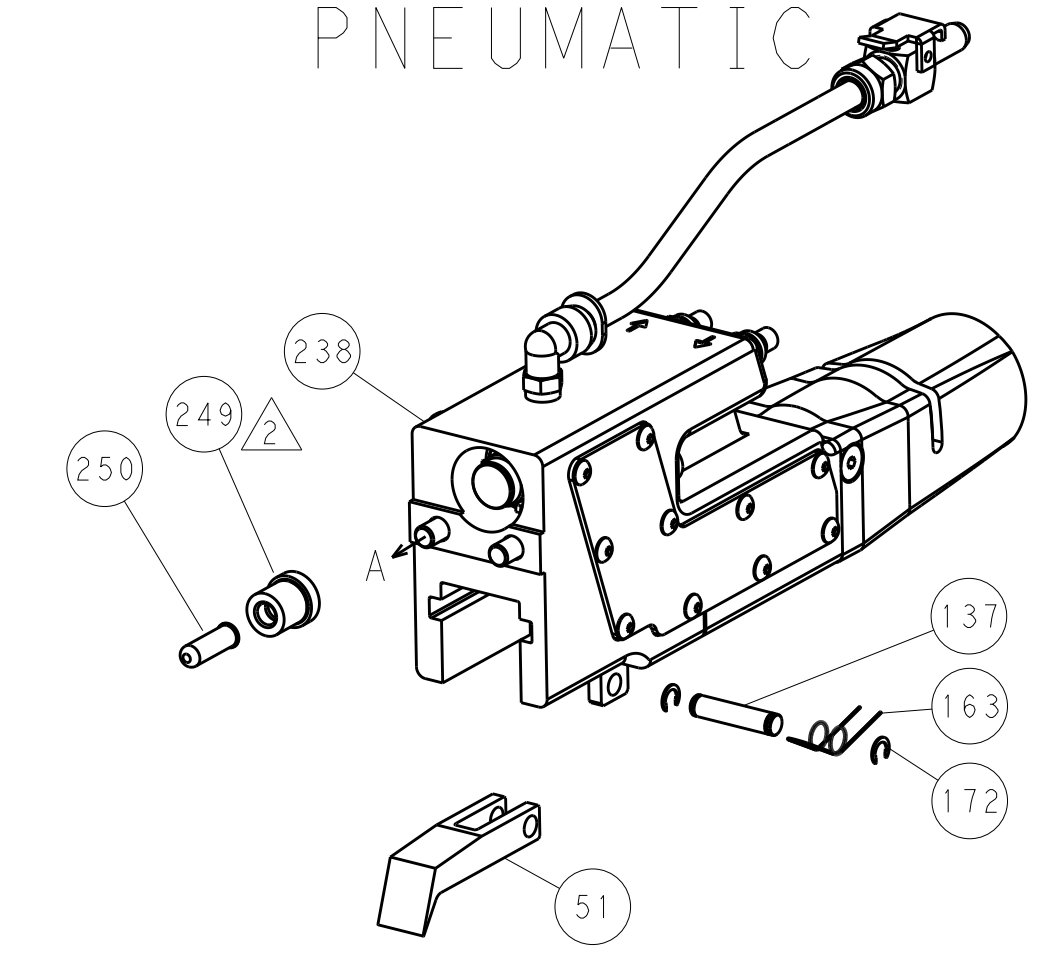


RAM AND HOLDDOWN SET-UP

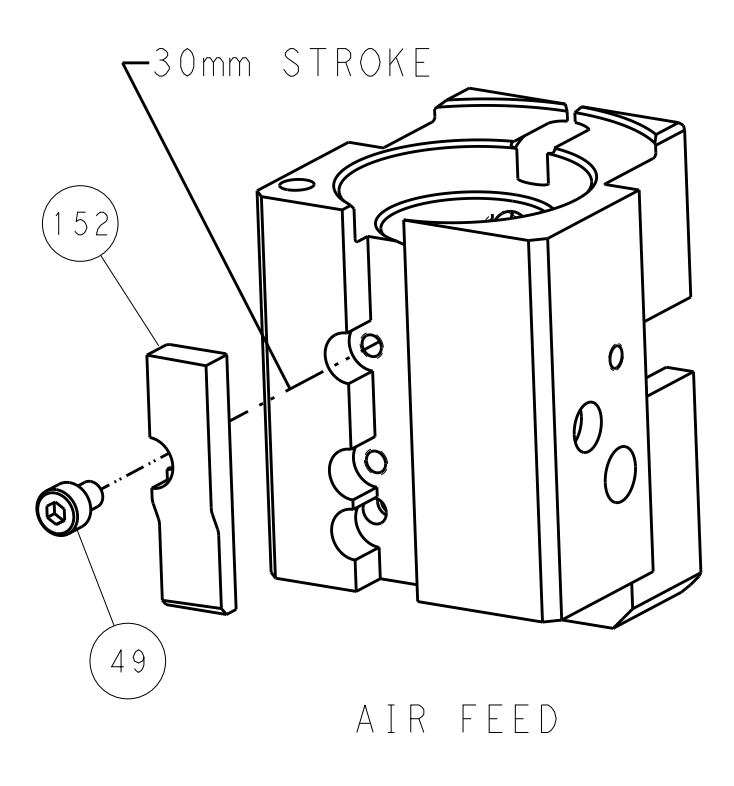
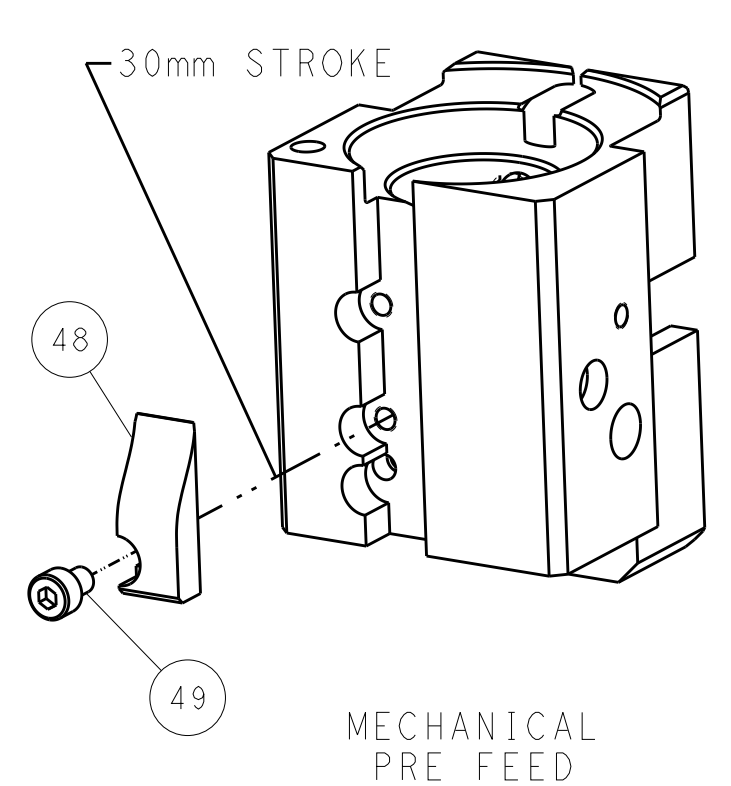
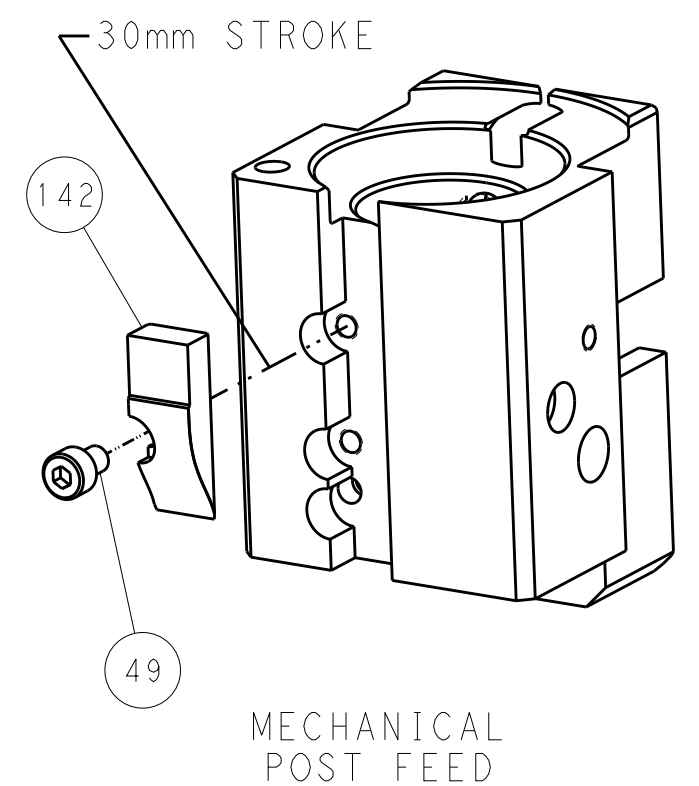
FEED TYPE
MECHANICAL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 09JAN2012		STE TE Connectivity	
mm	0 PLC	±		CHK: S. XI 09JAN2012	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: J. CRUZ 09JAN2012	SIZE: A1		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC	CAGE CODE: 00779		
	3 PLC	±		APPLICATION SPEC	DRAWING NO: C=2150034		
	4 PLC	±		WEIGHT	SCALE: 1:1		
	ANGLES	±		Customer Accessible Production Drawing		SHEET 4 OF 4	REV E1
MATERIAL:	FINISH:						