

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|---|-------------|----------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|   | 2150046-2   | F        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | 1901697-1 | 8-2150046-5 | -         | - | 2168400-7 (QUANTITY 2) |
|   | 2150046-5   | F        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SMART APPLICATOR  | 2161326-1             | -         | 8-2150046-4 | -         | - | -                      |
|   | 2150046-6   | F        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | PNEUMATIC FEED    | 2119950-1             | 2119792-2 | -           | 2119641-1 | - | 2063440-2              |
|   | 2150046-7   | F        | FINE CRIMP HEIGHT ADJUST | NONE              | -                 | -                     | -         | -           | -         | - | -                      |
|   | 7-2150046-7 | B        | CRIMP TOOLING KIT        | -                 | -                 | -                     | -         | -           | -         | - | -                      |

| TERMINAL DATA: TE TERMINAL                   |              | TE CRIMP SPECIFICATION         |              |
|--|--------------|--------------------------------|--------------|
| TERMINAL NAME: .250 SERIES FASTIN-FASTON TAB |              |                                |              |
| WIRE STRIP LENGTH                            |              | INSULATION DIAMETER RANGE      |              |
| 5.41-6.07 mm [ .213-.239 IN ]                |              | Ø3.05-4.32 mm [ .120-.170 IN ] |              |
| TERMINAL APPLICATION SPECIFICATION           | (A)114-2025  | -                              | -            |
| TERMINALS APPLIED                            |              |                                |              |
| TE TERMINAL                                  | TE TERMINAL  | TE TERMINAL                    | TE TERMINAL  |
| (A) 42099-2                                  | (A) 160450-5 | (A) 160457-1                   | (A) 160740-1 |
| (A) 42580-2                                  | (A) 160452-1 | (A) 160457-2                   | (A) 160740-2 |
| (A) 160450-1                                 | (A) 160452-2 | (A) 160457-3                   | (A) 170151-1 |
| (A) 160450-2                                 | (A) 160459-1 | (A) 170151-2                   |              |
| (A) 160450-3                                 | (A) 160459-3 | (A) 170151-3                   |              |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 14 AWG    | 1.93 +/- 0.05 [ .076 +/- .002 ] | 3.2                            |
| 2.50mm2   | 1.91 +/- 0.05 [ .075 +/- .002 ] | 3.4                            |
| 16 AWG    | 1.70 +/- 0.05 [ .067 +/- .002 ] | 5.7                            |
| 1.50mm2   | 1.65 +/- 0.05 [ .065 +/- .002 ] | 6.2                            |
| 18 AWG    | 1.55 +/- 0.05 [ .061 +/- .002 ] | 7.2                            |
| 1.00mm2   | 1.52 +/- 0.05 [ .060 +/- .002 ] | 7.5                            |

- 1. RECOMMENDED SPARE PARTS
- 2. GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150046-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150046-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150046-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9. 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.
- 10. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

| TERMINAL DATA: TE TERMINAL                   |              | TE CRIMP SPECIFICATION         |                |
|--|--------------|--------------------------------|----------------|
| TERMINAL NAME: .250 SERIES FASTIN-FASTON TAB |              |                                |                |
| WIRE STRIP LENGTH                            |              | INSULATION DIAMETER RANGE      |                |
| 5.41-6.07 mm [ .213-.239 IN ]                |              | Ø3.05-4.32 mm [ .120-.170 IN ] |                |
| TERMINAL APPLICATION SPECIFICATION           | (B)114-20021 | -                              | -              |
| TERMINALS APPLIED                            |              |                                |                |
| TE TERMINAL                                  | TE TERMINAL  | TE TERMINAL                    | TE TERMINAL    |
| (B) 42098-1                                  | (B) 42460-5  | (B) 280081-6                   | (B) 1-280081-2 |
| (B) 42098-2                                  | (B) 42460-6  | (B) 280081-7                   |                |
| (B) 42098-3                                  | (B) 280081-1 | (B) 280081-8                   |                |
| (B) 42460-1                                  | (B) 280081-2 | (B) 280081-9                   |                |
| (B) 42460-2                                  | (B) 280081-3 | (B) 1-280081-0                 |                |
| (B) 42460-3                                  | (B) 280081-4 | (B) 1-280081-1                 |                |

| WIRE SIZE  | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|------------|---------------------------------|--------------------------------|
| 2.50mm2    | 1.91 +/- 0.05 [ .075 +/- .002 ] | 3.4                            |
| 2x 0.75mm2 | 1.65 +/- 0.05 [ .065 +/- .002 ] | 6.0                            |
| 1.50mm2    | 1.65 +/- 0.05 [ .065 +/- .002 ] | 6.0                            |
| 1.00mm2    | 1.52 +/- 0.05 [ .060 +/- .002 ] | 6.7                            |
| 0.75mm2    | 1.45 +/- 0.05 [ .057 +/- .002 ] | 8.4                            |

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|   |     |    |    |    |    |           |                      |         |
|---|-----|----|----|----|----|-----------|----------------------|---------|
| 1 | -   | -  | 1  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK | 260     |
|   | -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION          | ITEM NO |

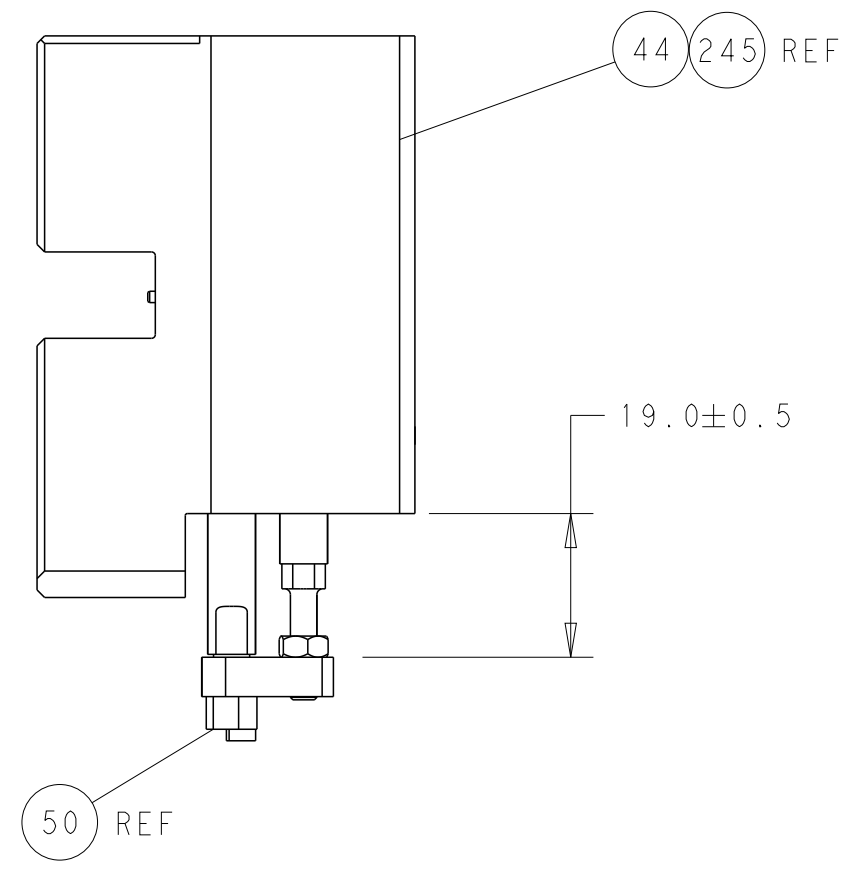
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |           |    |      |
|--------------|-----|------|-----------|-----------|----|------|
| 2119599-2    | A   | 66   | REV       | DATE      | BY | CHKD |
|              |     |      | C2        | 02DEC2016 | TB | TE   |
|              |     |      | D         | 01FEB2017 | TB | TE   |
|              |     |      | E         | 22FEB2017 | TB | TE   |
|              |     |      | F         | 15MAR2017 | TB | CT   |

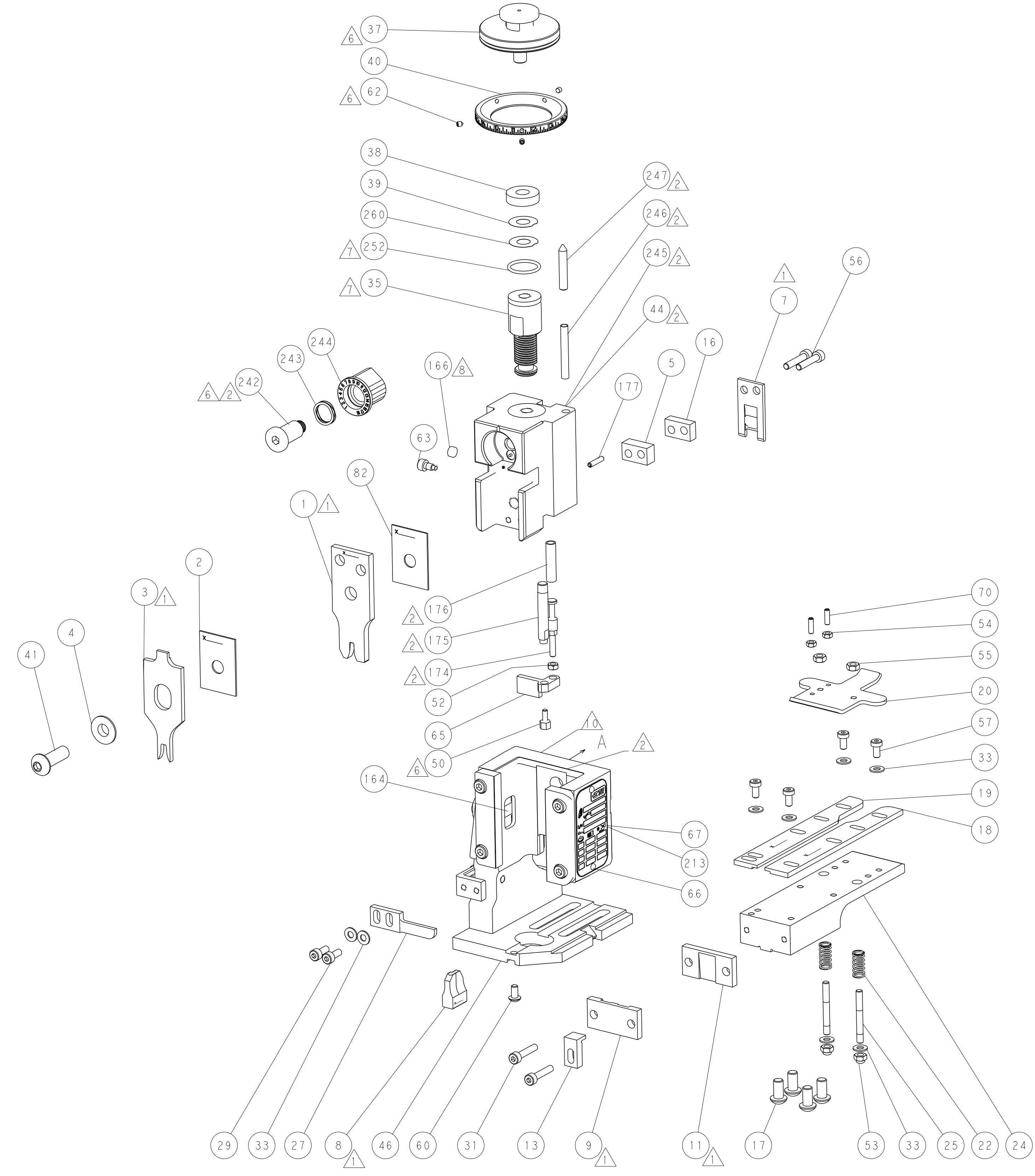
| REV | DATE | BY     | CHKD   | DESCRIPTION | DATE        | OWN                                  | APVD |
|-----|------|--------|--------|-------------|-------------|--------------------------------------|------|
| -   | 1    | -      | 1      | 1           | 8-21084-0   | O-RING, .676 ID, .070 DIA. MAT.      | 252  |
| -   | -    | -      | -      | 1           | 2119640-1   | PUSH ROD, AIR FEED                   | 250  |
| -   | -    | -      | -      | 1           | 1803259-1   | BUSHING, FLANGED                     | 249  |
| -   | -    | -      | -      | 1           | 2119641-1   | FEED CAM, AIR FEED                   | 248  |
| -   | 1    | -      | 1      | 1           | 2119798-1   | DETENT PIN                           | 247  |
| -   | 1    | -      | 1      | 1           | 1-22279-3   | SPRING, COMPRESSION                  | 246  |
| -   | -    | 1      | -      | -           | 2119759-1   | RAM, AMP STYLE, END FEED, NON-ADJUST | 245  |
| -   | 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  |
| -   | -    | 2      | 2      | -           | 2168400-7   | SHCS, LOW HEAD, RoHS, M5 X 10        | 240  |
| -   | -    | -      | -      | 1           | 2063440-2   | AIR FEED MODULE                      | 238  |
| -   | -    | 1      | 1      | -           | 2119740-2   | TAG, IDENTIFICATION                  | 213  |
| -   | -    | REFREF | -      | -           | 1901697-1   | FEED FINGER ASSEMBLY, EF             | 183  |
| -   | 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           | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT  | 172  |
| -   | 1    | 1      | 1      | 1           | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY       | 166  |
| -   | -    | REFREF | REFREF | REFREF      | 994970-2    | COUNTER, MAGNETIC                    | 164  |
| -   | -    | -      | -      | 1           | 240638-1    | SPRING, FEED FINGER                  | 163  |
| -   | -    | -      | -      | 1           | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854       | 137  |
| -   | -    | REFREF | -      | -           | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED              | 135  |
| -   | -    | 1      | 1      | -           | 1633743-1   | SERVO FEED LATCH ASM                 | 133  |
| -   | 1    | 1      | 1      | 1           | 455888-7    | SPACER, CRIMPER                      | 82   |
| -   | 1    | 1      | 1      | 1           | 2119956-2   | DOCUMENTATION PACKAGE                | 71   |
| -   | 2    | 2      | 2      | 2           | 2-18032-2   | SCR, SET, FLT POINT M3 X 10.0        | 70   |
| -   | 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           | 1976052-1   | HOLDDOWN, TERMINAL                   | 65   |
| -   | 1    | -      | 1      | 1           | 2119793-1   | LIMITER, ADJUSTMENT BOLT             | 63   |
| -   | 3    | -      | 3      | 3           | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0  | 62   |
| -   | 1    | 1      | 1      | 1           | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)             | 60   |
| -   | 4    | 4      | 4      | 4           | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8         | 57   |
| -   | 2    | 2      | 2      | 2           | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20       | 56   |
| -   | 2    | 2      | 2      | 2           | 5018030-2   | NUT, HEX, REG, RoHS, M4              | 55   |
| -   | 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           | 2119792-2   | PAWL, EF, AIR                        | 51   |
| -   | 1    | 1      | 1      | 1           | 1752354-2   | STANDOFF, HOLD-DOWN                  | 50   |
| -   | -    | -      | -      | 1           | 18023-9     | SCR, SKT HD CAP M4 X 6.0             | 49   |
| -   | 1    | 1      | 1      | 1           | 2119655-5   | APPLICATOR BASIC ASSEMBLY, EF        | 46   |
| -   | 1    | -      | -      | 1           | 2119369-1   | RAM, AMP STYLE, END FEED             | 44   |
| -   | 1    | 1      | 1      | 1           | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)            | 41   |
| -   | 1    | -      | -      | 1           | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT    | 40   |
| -   | 1    | -      | -      | 1           | 2119957-1   | APPLICATOR SHIM PACK                 | 39   |
| -   | 1    | 1      | 1      | 1           | 1-2119644-2 | RAM WASHER, PRECISION                | 38   |
| -   | 1    | 1      | 1      | 1           | 2119085-1   | FA HEAD, ATLANTIC STYLE              | 37   |
| -   | 1    | -      | -      | 1           | 2119092-1   | BOLT, ADJUSTMENT                     | 35   |
| -   | 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           | 1320906-1   | STUD, THREADED                       | 25   |
| -   | 1    | 1      | 1      | 1           | 1752371-5   | PLATE, STRIP GUIDE                   | 24   |
| -   | 2    | 2      | 2      | 2           | 2-22281-3   | SPRING, COMPRESSION                  | 22   |
| -   | 1    | 1      | 1      | 1           | 1752373-4   | DRAG                                 | 20   |
| -   | 1    | 1      | 1      | 1           | 1-1901696-9 | STRIP GUIDE, REAR                    | 19   |
| -   | 1    | 1      | 1      | 1           | 1-1901695-9 | STRIP GUIDE, FRONT                   | 18   |
| -   | 4    | 4      | 4      | 4           | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)            | 17   |
| -   | 1    | 1      | 1      | 1           | 6-240641-5  | SPACER                               | 16   |
| -   | 1    | 1      | 1      | 1           | 1752360-1   | SPACER, HOLD-DOWN                    | 13   |
| -   | 1    | 1      | 1      | 1           | 240644-1    | PLATE, REAR SHEAR                    | 11   |
| -   | -    | -      | -      | -           | -           | -                                    | 10   |
| -   | 1    | 1      | 1      | 1           | 690482-4    | PLATE, FRONT SHEAR                   | 9    |
| -   | 1    | 1      | 1      | 1           | 1333219-4   | ANVIL, COMBINATION                   | 8    |
| -   | 1    | 1      | 1      | 1           | 1-690474-7  | BLADE, SLUG                          | 7    |
| -   | -    | -      | -      | -           | -           | -                                    | 6    |
| -   | 1    | 1      | 1      | 1           | 2-240641-7  | SPACER                               | 5    |
| -   | 1    | 1      | 1      | 1           | 238009-1    | BLOCK, FL CRIMPER SPACER             | 4    |
| -   | 1    | 1      | 1      | 1           | 3-2119582-4 | CRIMPER, INSULATION F PREMIUM        | 3    |
| -   | 1    | 1      | 1      | 1           | 455888-8    | SPACER, CRIMPER                      | 2    |
| -   | 1    | 1      | 1      | 1           | 456408-5    | CRIMPER, WIRE PREMIUM                | 1    |

| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED:                          | DRAWN:            | DATE:     | CHKD:     | DATE:     | NAME:  |
|-------------|---|-------------------|-----------|-----------|-----------|--|
| mm          | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± | T. YIN            | 06FEB2012 | G. BAILEY | 06FEB2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| MATERIAL:   | FINISH:   | APVD:             | S. XI     | 06FEB2012 |           | Customer Accessible Production Drawing       |
|             |   | PRODUCT SPEC:     |           |           |           | SCALE: 1:1 SHEET 1 OF 4 REV F                |
|             |   | APPLICATION SPEC: |           |           |           | RESTRICTED TO:                               |
|             |   | WEIGHT:           |           |           |           |  |

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

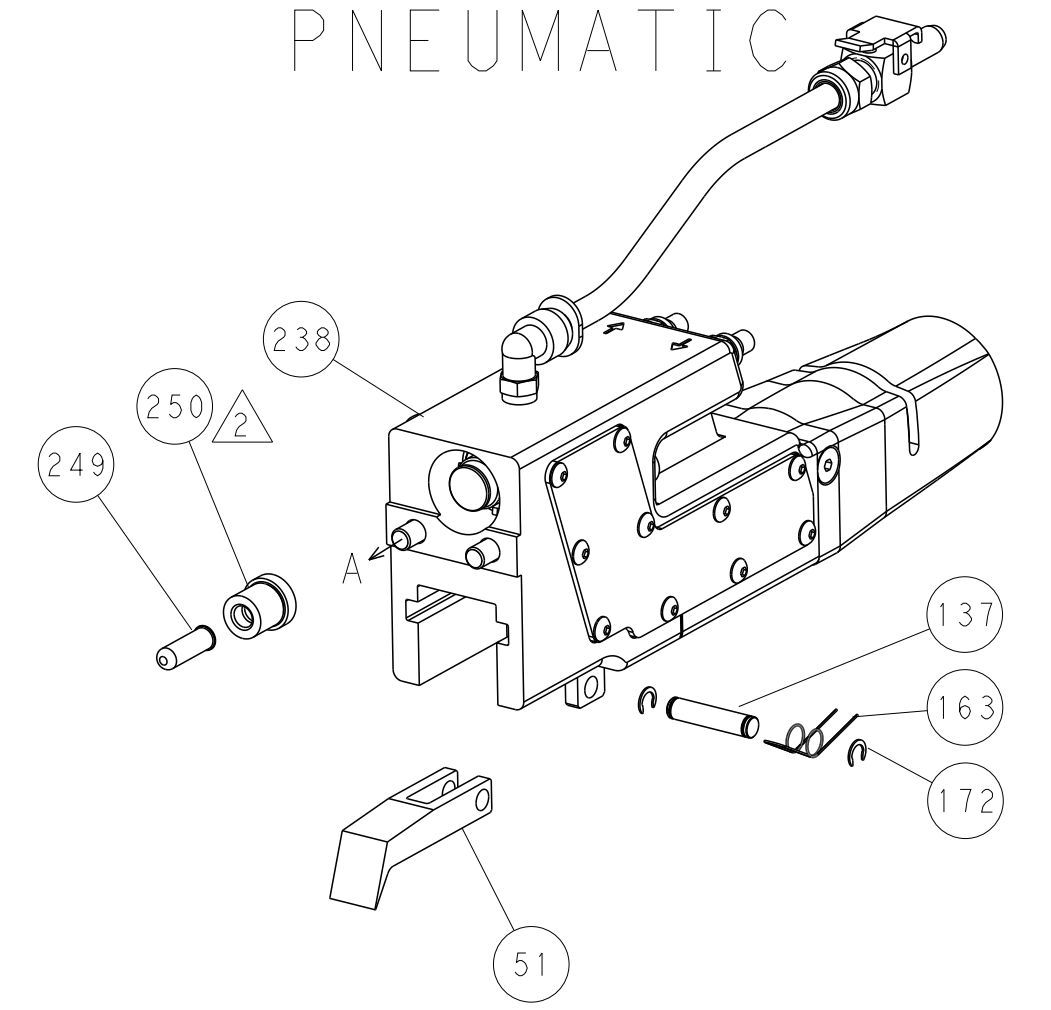


HOLDDOWN SET-UP

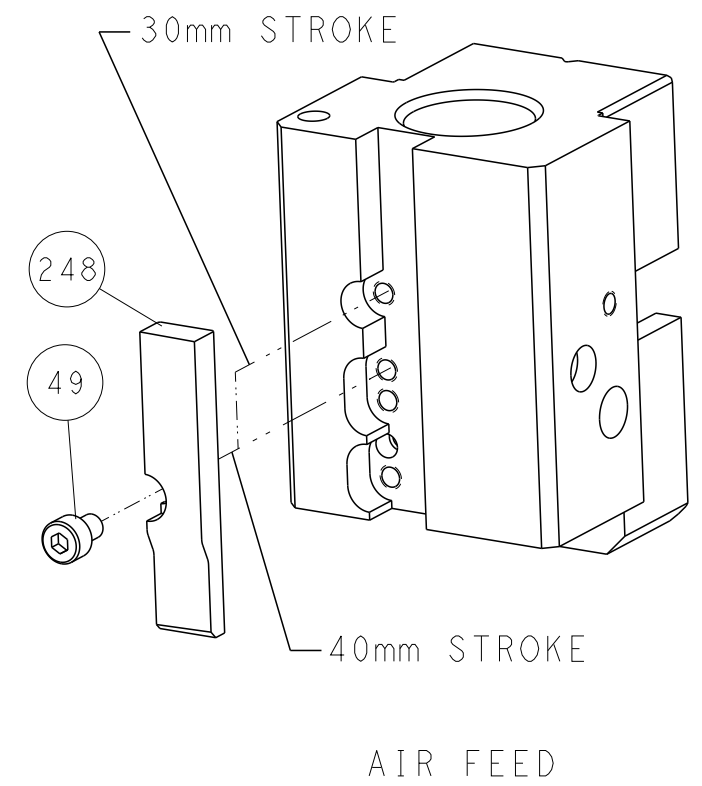


FEED TYPE

PNEUMATIC

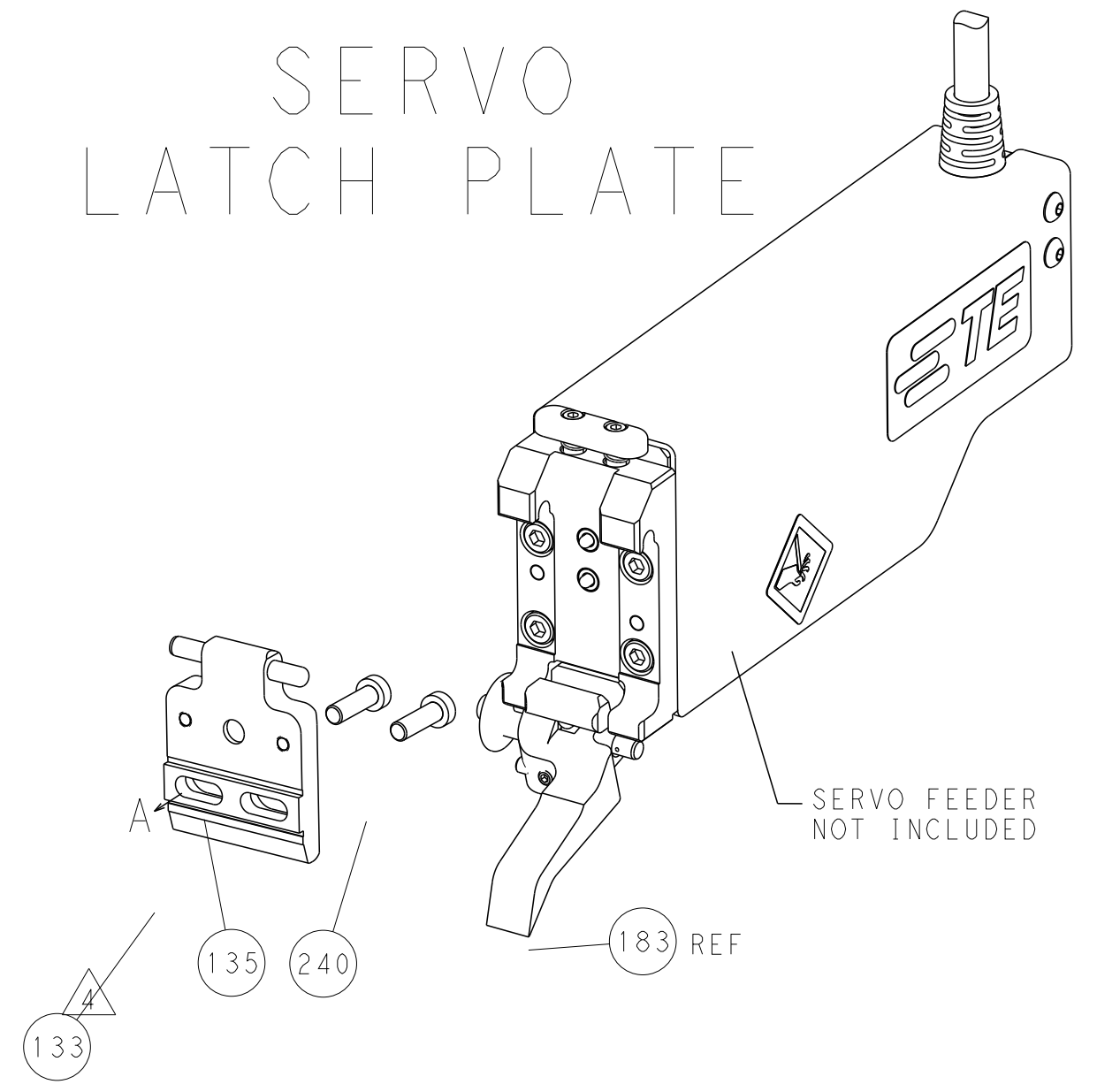


CAM POSITION



AIR FEED

SERVO LATCH PLATE



**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: |         | DWG Y. YIN 06FEB2012    |         | TE Connectivity                         |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                 | 4 PLC ± | 5 PLC ±                                 | Harrisburg, PA 17105-3608 |
|             | ANGLES  | FINISH                                 |         | CHK G. BAILEY 06FEB2012 |         | NAME                                    |                           |
| MATERIAL    |         |  |         | S. XI 06FEB2012         |         | Ocean End Feed Applicator               |                           |
|             |         |  |         | APVD                    |         | SIZE CAGE CODE DRAWING NO RESTRICTED TO |                           |
|             |         |  |         | PRODUCT SPEC            |         | A1 00779 C=2150046                      |                           |
|             |         |  |         | APPLICATION SPEC        |         | SCALE 1:1 SHEET 2 OF 4 REV F            |                           |
|             |         |  |         | WEIGHT                  |         | Customer Accessible Production Drawing  |                           |

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-2    | A   | 66   | P         | LTN | DESCRIPTION | DATE | DWN | APVD |
|              |     |      | -         | -   | SEE SHEET 1 | -    | -   | -    |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                     | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|--|-------------|----------|--------------------------|-------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|  |             |          |                          |                               | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  | 2-2150046-2 | F        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                     | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150046-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  | 2-2150046-5 | F        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE $\triangle$ | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150046-4 | -         | - | -                      |
|  | 2-2150046-7 | F        | FINE CRIMP HEIGHT ADJUST | NONE                          | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-2              |
|  | 7-2150046-7 | B        | CRIMP TOOLING KIT        | -                             | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.79 mm [.110] | F    |
| INSUL                                | 4.06 mm [.160] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                   |              | TE CRIMP SPECIFICATION                    |              |
|--|--------------|---|--------------|
| TERMINAL NAME: .250 SERIES FASTIN-FASTON TAB |              |   |              |
| WIRE STRIP LENGTH                            |              | INSULATION DIAMETER RANGE                 |              |
| 5.41-6.07 mm [.213-.239 IN]                  |              | $\varnothing$ 3.05-4.32 mm [.120-.170 IN] |              |
| TERMINAL APPLICATION SPECIFICATION           |              | (A)114-2025                               |              |
| TERMINALS APPLIED $\triangle$                |              |   |              |
| TE TERMINAL                                  | TE TERMINAL  | TE TERMINAL                               | TE TERMINAL  |
| (A) 42099-2                                  | (A) 160450-5 | (A) 160457-1                              | (A) 160740-1 |
| (A) 42580-2                                  | (A) 160452-1 | (A) 160457-2                              | (A) 160740-2 |
| (A) 160450-1                                 | (A) 160452-2 | (A) 160457-3                              | (A) 170151-1 |
| (A) 160450-2                                 | (A) 160459-1 | (A) 170151-2                              |              |
| (A) 160450-3                                 | (A) 160459-3 | (A) 170151-3                              |              |

| TERMINAL DATA: TE TERMINAL                   |              | TE CRIMP SPECIFICATION                    |                |
|--|--------------|---|----------------|
| TERMINAL NAME: .250 SERIES FASTIN-FASTON TAB |              |   |                |
| WIRE STRIP LENGTH                            |              | INSULATION DIAMETER RANGE                 |                |
| 5.41-6.07 mm [.213-.239 IN]                  |              | $\varnothing$ 3.05-4.32 mm [.120-.170 IN] |                |
| TERMINAL APPLICATION SPECIFICATION           |              | (B)114-20021                              |                |
| TERMINALS APPLIED $\triangle$                |              |   |                |
| TE TERMINAL                                  | TE TERMINAL  | TE TERMINAL                               | TE TERMINAL    |
| (B) 42098-1                                  | (B) 42460-5  | (B) 280081-6                              | (B) 1-280081-2 |
| (B) 42098-2                                  | (B) 42460-6  | (B) 280081-7                              |                |
| (B) 42098-3                                  | (B) 280081-1 | (B) 280081-8                              |                |
| (B) 42460-1                                  | (B) 280081-2 | (B) 280081-9                              |                |
| (B) 42460-2                                  | (B) 280081-3 | (B) 1-280081-0                            |                |
| (B) 42460-3                                  | (B) 280081-4 | (B) 1-280081-1                            |                |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 14 AWG    | 1.93+/-0.05 [.076+/- .002] | 3.2                            |
| 2.50mm2   | 1.91+/-0.05 [.075+/- .002] | 3.4                            |
| 16 AWG    | 1.70+/-0.05 [.067+/- .002] | 5.7                            |
| 1.50mm2   | 1.65+/-0.05 [.065+/- .002] | 6.2                            |
| 18 AWG    | 1.55+/-0.05 [.061+/- .002] | 7.2                            |
| 1.00mm2   | 1.52+/-0.05 [.060+/- .002] | 7.5                            |

| WIRE SIZE  | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|------------|----------------------------|--------------------------------|
| 2.50mm2    | 1.91+/-0.05 [.075+/- .002] | 3.4                            |
| 2x 0.75mm2 | 1.65+/-0.05 [.065+/- .002] | 6.0                            |
| 1.50mm2    | 1.65+/-0.05 [.065+/- .002] | 6.0                            |
| 1.00mm2    | 1.52+/-0.05 [.060+/- .002] | 6.7                            |
| 0.75mm2    | 1.45+/-0.05 [.057+/- .002] | 8.4                            |

|             |     |     |     |             |                                     |     |
|-------------|-----|-----|-----|-------------|-------------------------------------|-----|
| -           | -   | -   | 1   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| -           | -   | -   | 1   | 1803259-1   | BUSHING, FLANGED                    | 249 |
| -           | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| -           | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| -           | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| $\triangle$ | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| -           | -   | 2   | -   | 2168400-7   | SHCS, LOW HEAD, RoHS, M5 X 10       | 240 |
| -           | -   | -   | 1   | 2063440-2   | AIR FEED MODULE                     | 238 |
| -           | -   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| -           | 4   | 4   | 4   | 2079383-9   | SCR, BHSC, RoHS (M6 X 20)           | 186 |
| -           | -   | REF | -   | 1901697-1   | FEED FINGER ASSEMBLY, EF            | 183 |
| -           | 1   | 1   | 1   | 6-993111-6  | PIN, SLOTTED SPRING 3.0 X 14.0      | 177 |
| -           | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| -           | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| -           | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| -           | -   | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| $\triangle$ | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| -           | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| -           | -   | -   | 1   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| $\triangle$ | -   | -   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 153 |
| -           | -   | -   | 1   | 2119641-2   | FEED CAM, AIR FEED                  | 152 |
| -           | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145 |
| -           | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144 |
| -           | 1   | 1   | 1   | 2119655-6   | APPLICATOR BASIC ASSEMBLY, EF       | 141 |
| -           | 1   | 1   | 1   | 2119651-1   | RAM, ASIAN STYLE, END FEED          | 140 |
| $\triangle$ | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139 |
| -           | -   | -   | 1   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| -           | -   | REF | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| -           | -   | 1   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| -           | 1   | 1   | 1   | 455888-7    | SPACER, CRIMPER                     | 82  |
| -           | 1   | 1   | 1   | 2119956-2   | DOCUMENTATION PACKAGE               | 71  |
| -           | 2   | 2   | 2   | 2-18032-2   | SCR, SET, FLT POINT M3 X 10.0       | 70  |
| -           | 1   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| -           | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| -           | 1   | 1   | 1   | 1976052-1   | HOLDDOWN, TERMINAL                  | 65  |
| $\triangle$ | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| -           | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |
| -           | 4   | 4   | 4   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57  |
| -           | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 56  |
| -           | 2   | 2   | 2   | 5018030-2   | NUT, HEX, REG, RoHS, M4             | 55  |
| -           | 2   | 2   | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 54  |
| -           | 2   | 2   | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         | 53  |
| -           | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| $\triangle$ | -   | -   | 1   | 2119792-2   | PAWL, EF, AIR                       | 51  |
| $\triangle$ | 1   | 1   | 1   | 1752354-2   | STANDOFF, HOLD-DOWN                 | 50  |
| -           | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| -           | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| -           | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| -           | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| -           | 1   | 1   | 1   | 1-2119644-2 | RAM WASHER, PRECISION               | 38  |
| -           | 8   | 8   | 8   | 1-18028-2   | WASHER, FLAT, REG M4                | 33  |
| -           | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 31  |
| -           | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 29  |
| -           | 1   | 1   | 1   | 240639-1    | STRIPPER (MACHINING)                | 27  |
| -           | 2   | 2   | 2   | 1320906-1   | STUD, THREADED                      | 25  |
| -           | 1   | 1   | 1   | 1752371-5   | PLATE, STRIP GUIDE                  | 24  |
| -           | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22  |
| -           | 1   | 1   | 1   | 1752373-4   | DRAG                                | 20  |
| -           | 1   | 1   | 1   | 1-1901696-9 | STRIP GUIDE, REAR                   | 19  |
| -           | 1   | 1   | 1   | 1-1901695-9 | STRIP GUIDE, FRONT                  | 18  |
| -           | 1   | 1   | 1   | 6-240641-5  | SPACER                              | 16  |
| -           | 1   | 1   | 1   | 1752360-1   | SPACER, HOLD-DOWN                   | 13  |
| $\triangle$ | 1   | 1   | 1   | 240644-1    | PLATE, REAR SHEAR                   | 11  |
| -           | -   | -   | -   | -           | -                                   | 10  |
| $\triangle$ | 1   | 1   | 1   | 690482-4    | PLATE, FRONT SHEAR                  | 9   |
| $\triangle$ | 1   | 1   | 1   | 1333219-4   | ANVIL, COMBINATION                  | 8   |
| $\triangle$ | 1   | 1   | 1   | 1-690474-7  | BLADE, SLUG                         | 7   |
| -           | -   | -   | -   | -           | -                                   | 6   |
| -           | 1   | 1   | 1   | 2-240641-7  | SPACER                              | 5   |
| -           | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4   |
| $\triangle$ | 1   | 1   | 1   | 3-2119582-4 | CRIMPER, INSULATION F PREMIUM       | 3   |
| -           | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2   |
| $\triangle$ | 1   | 1   | 1   | 456408-5    | CRIMPER, WIRE PREMIUM               | 1   |

- $\triangle$  RECOMMENDED SPARE PARTS
- $\triangle$  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\triangle$  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150046-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150046-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\triangle$  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- $\triangle$  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- $\triangle$  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\triangle$  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.
- $\triangle$  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

\*WARNING  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

| - | 1  | 1  | 1  | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251         |
|---|----|----|----|-----------|-------------------------------------|-------------|
| - | 77 | 27 | 25 | 22        | PART NO                             | DESCRIPTION |
|   |    |    |    |           |                                     | ITEM NO     |

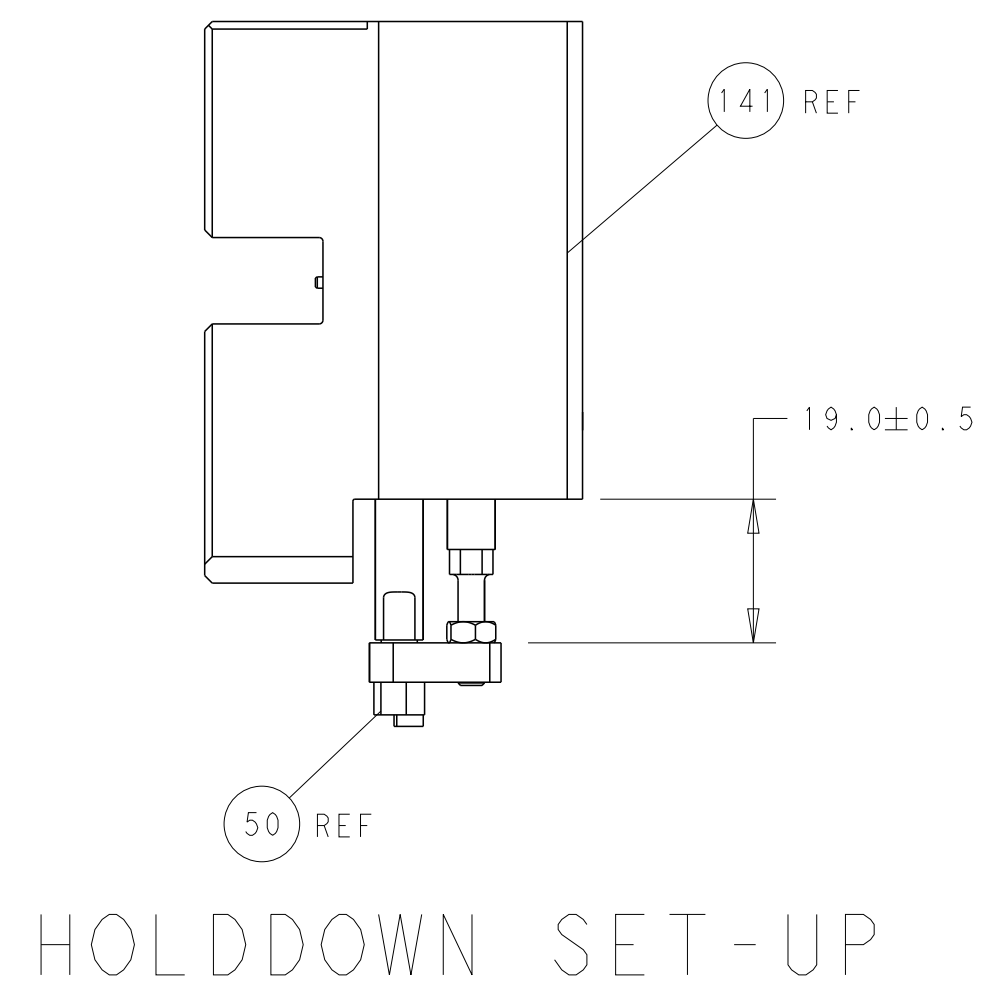
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |          | DATE      | REV |
|-------------|---------|--|----------|-----------|-----|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ±  | 06FEB2012 | 1   |
|             | 3 PLC ± | 4 PLC ±                                | ANGLES ± | 06FEB2012 | 2   |
|             | FINISH  | FINISH                                 | FINISH   | 06FEB2012 | 3   |

| NAME      | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|-----------|------|-----------|------------|---------------|
| G. BAILEY | A1   | 00779     | 2150046    | -             |

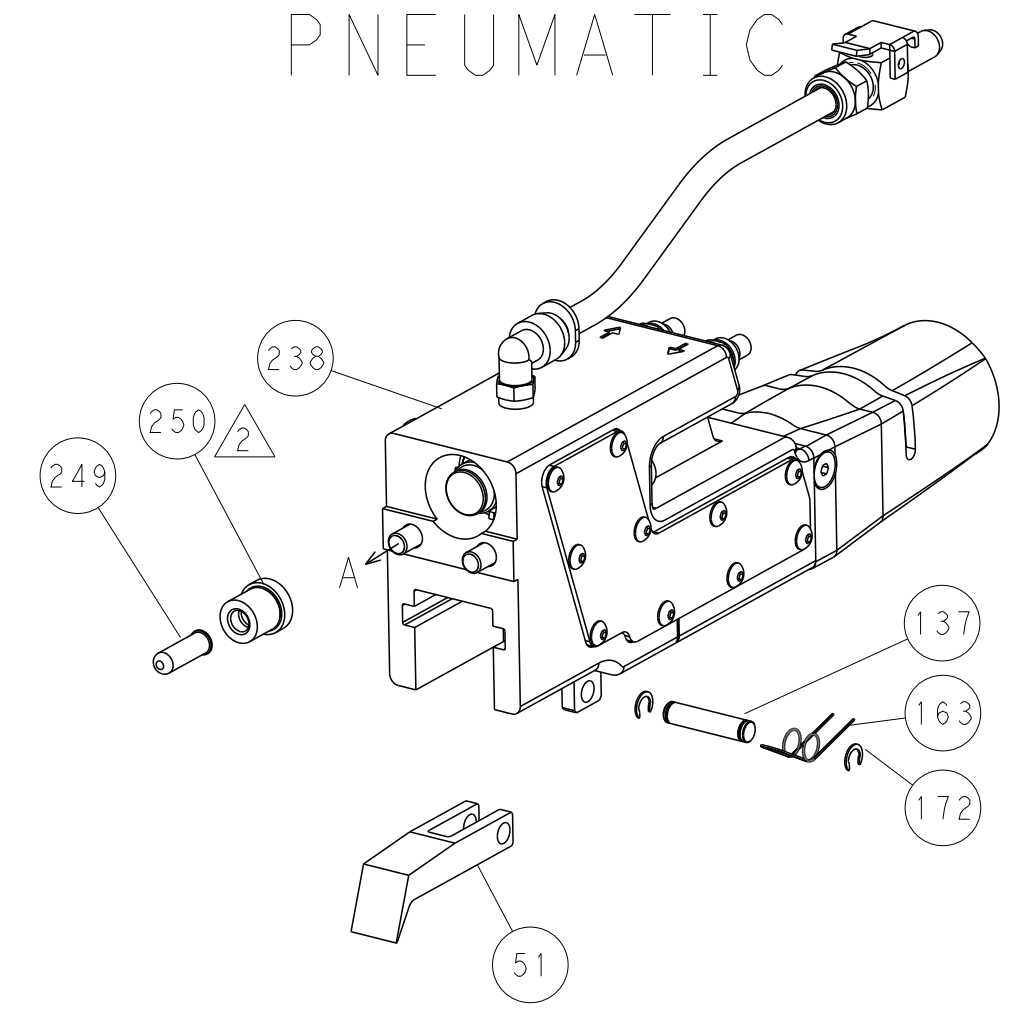
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE | SHEET | OF | REV |
|--|-------|-------|----|-----|
| Customer Accessible Production Drawing | 1:1   | 3     | 4  | F   |

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

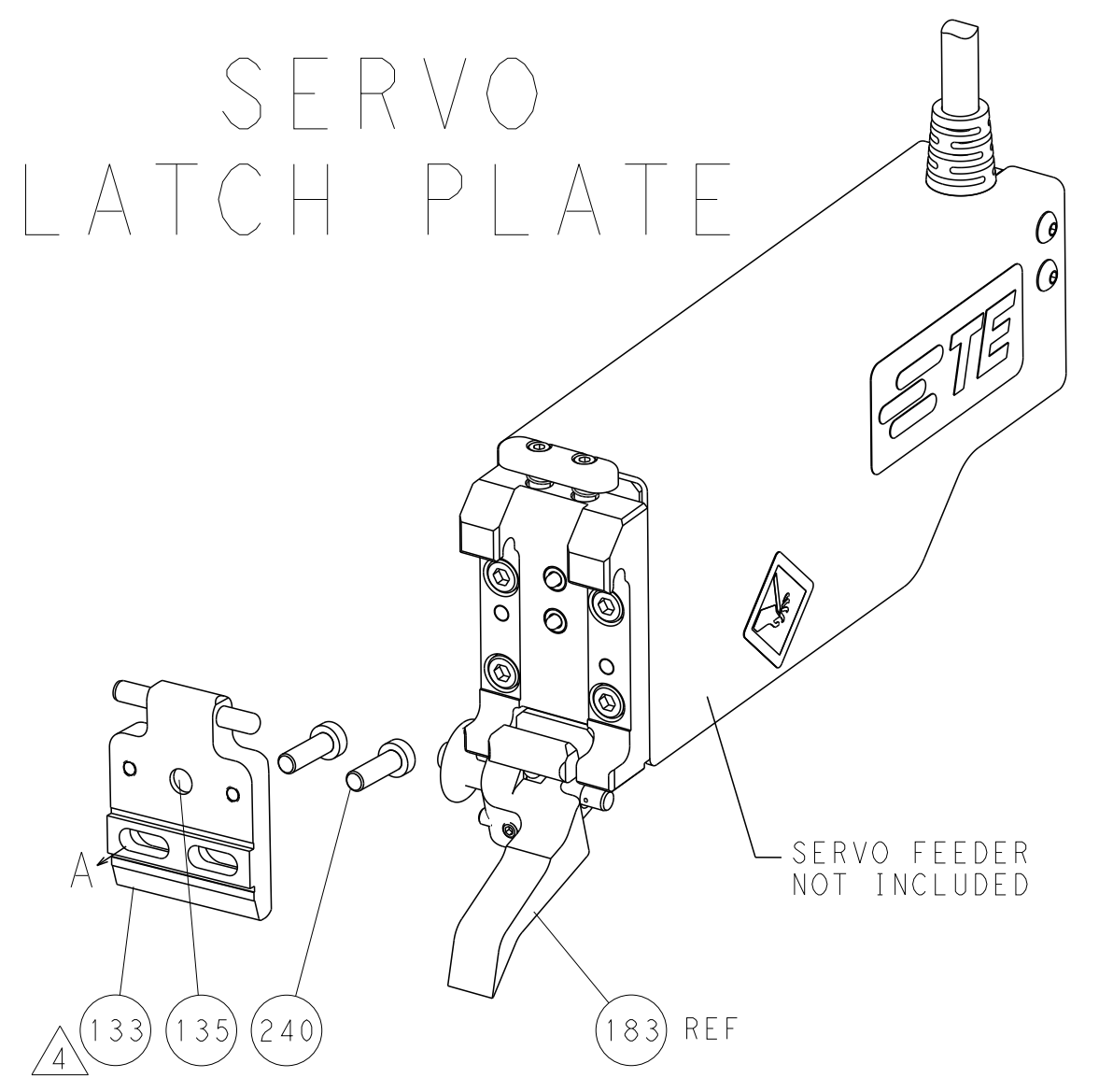


FEED TYPE

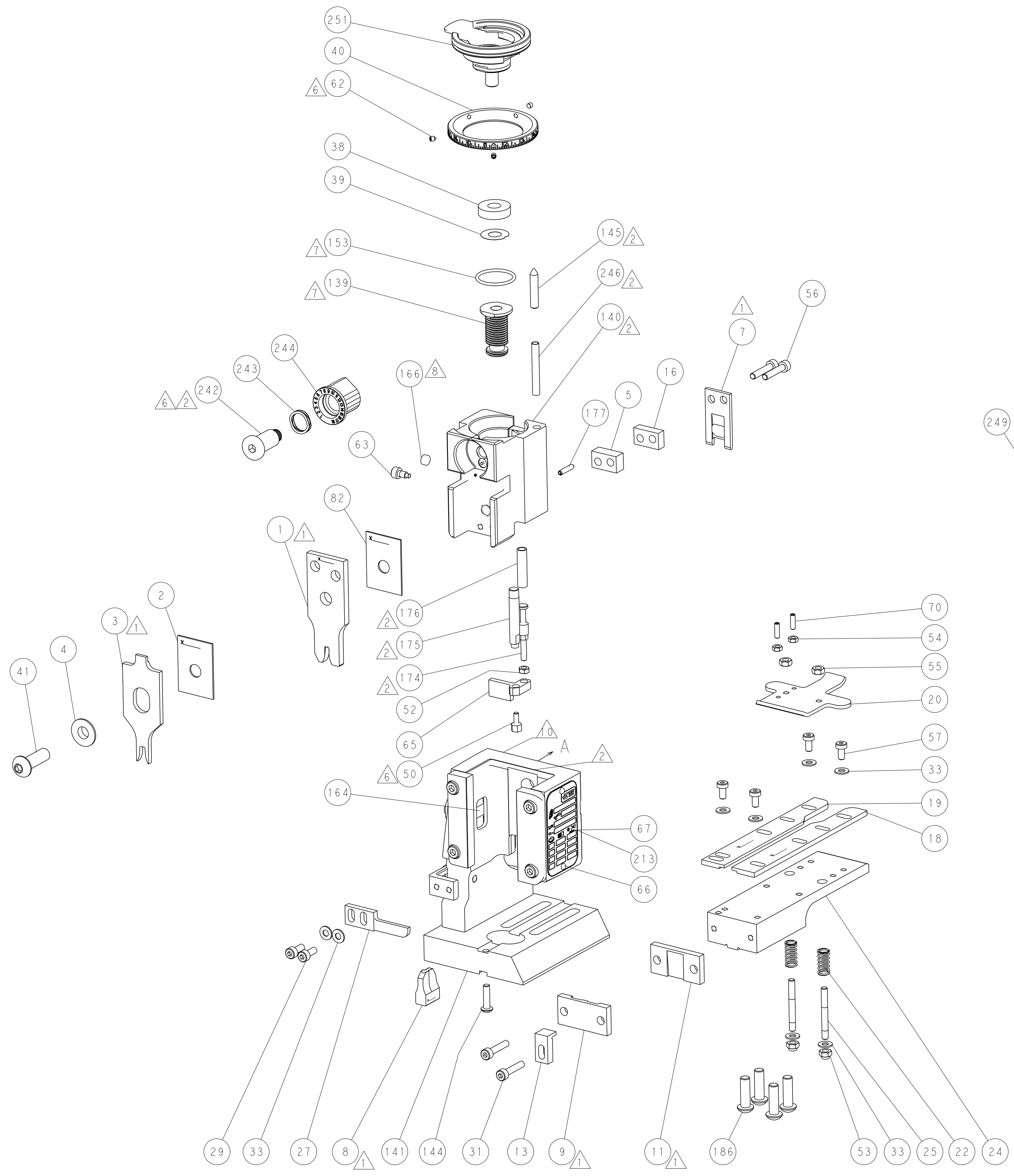
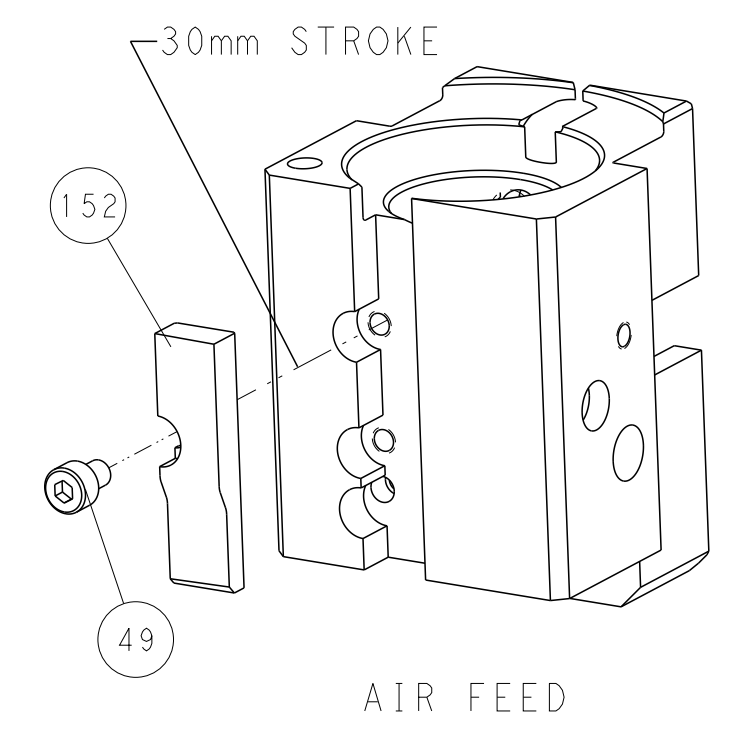
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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 Y. YIN 06FEB2012                   |           | STE TE Connectivity Harrisburg, PA 17105-3608 |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ±   | NAME  | Ocean End Feed Applicator |
| MATERIAL:   | FINISH: | WEIGHT:                                | SCALE:  | Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4                                  | REV F                     |