

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTIN-FASTON TAB			
WIRE STRIP LENGTH 5.41-6.07 mm [.213-.239 IN]		INSULATION DIAMETER RANGE Ø 3.05-4.32 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
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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ⑦ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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.

APPLICATOR STYLE CONVERSION CHART

SERVO LATCH PLATE	211995-1	1901697-1	8-2150046-5	-	-	2168400-7 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2150046-4	-	-	-
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
-	-	-	-	-	-	-
-	-	-	-	-	-	-

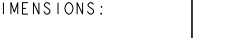
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES		FASTIN-FASTON TAB	
WIRE STRIP LENGTH 5.41-6.07 mm [.213-.239 IN]		INSULATION DIAMETER RANGE Ø3.05-4.32 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-20021	-	-
TERMINALS APPLIED	△	-	-
TE TERMINAL	TE TERMINAL	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) 280425-2
(B) 42098-3	(B) 280081-1	(B) 280081-8	(B) 280425-3
(B) 42460-1	(B) 280081-2	(B) 280081-9	(B) 170151-1
(B) 42460-2	(B) 280081-3	(B) 1-280081-0	(B) 170151-2
(B) 42460-3	(B) 280081-4	(B) 1-280081-1	(B) 170151-3

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.91+/-0.05 [0.75+/- .002]		3.4
2x 0.75mm2		1.65+/-0.05 [0.65+/- .002]		6.0
1.50mm2		1.65+/-0.05 [0.65+/- .002]		6.0
1.00mm2		1.52+/-0.05 [0.60+/- .002]		6.7
0.75mm2		1.45+/-0.05 [0.57+/- .002]		8.4

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

2				1					
SET UP GAUGE	LOC	DIST	REVISIONS						
2119599-2	A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
				-	SEE SHEET 1	-	-	-	
1	1	1			2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE		251	
-	-	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	
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	
-	-	2			21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172	
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	
1	1	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	
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			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			2119792-2	PAWL, EF, AIR		51	
-	-	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			240644-1	PLATE, REAR SHEAR		11	
-	-	-			-	-		10	
1	1	1			690482-3	PLATE, FRONT SHEAR		9	
1	1	1			1333219-4	ANVIL, COMBINATION		8	
1	1	1			690474-9	BLADE, SLUG		7	
-	-	-			-	-		6	
1	1	1			2-240641-7	SPACER		5	
1	1	1			238009-1	BLOCK, FL CRIMPER SPACER		4	
1	1	1			3-2119582-4	CRIMPER, INSULATION F PREMIUM		3	
1	1	1			455888-8	SPACER, CRIMPER		2	
1	1	1			456408-5	CRIMPER, WIRE PREMIUM		1	
7-27-25-22	PART NO		DESCRIPTION						ITEM NO

THIS DRAWING IS A CONTROL DRAWING FOR PRO ELECTRONICS CORPORATION IT IS DERIVED FROM THE PRO CONNECTIVITY CONTROL AND DESIGN ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 06FEB2012 LYN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME CHV 06FEB2012 G. BAILEY APVD 06FEB2012 SXL PRODUCT SPEC - APPLICATION SPEC -	
		FINISH -		Ocean End Feed Applicator -	
MATERIAL -		WEIGHT -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150046 -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 of 4 REV C2	

