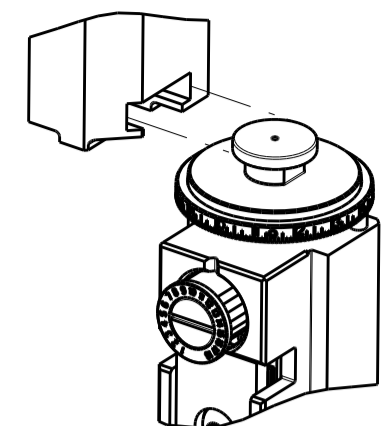


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150299-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-6.00 mm [.205-.236 IN]		Ø1.50-2.00 mm [.059-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25209 REVISION 12		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	4.0
0.75mm2	1.85+/-0.05 [.073+/-0.002]	5.3
0.50mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.35mm2	1.73+/-0.05 [.068+/-0.002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2x 0.50	1.90+/-0.05 [.075+/-0.002]	4.5
1.00mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.75mm2	1.75+/-0.05 [.069+/-0.002]	6.3
2x 0.35	1.70+/-0.05 [.067+/-0.002]	6.7
0.50mm2	1.70+/-0.05 [.067+/-0.002]	6.7

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

***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.

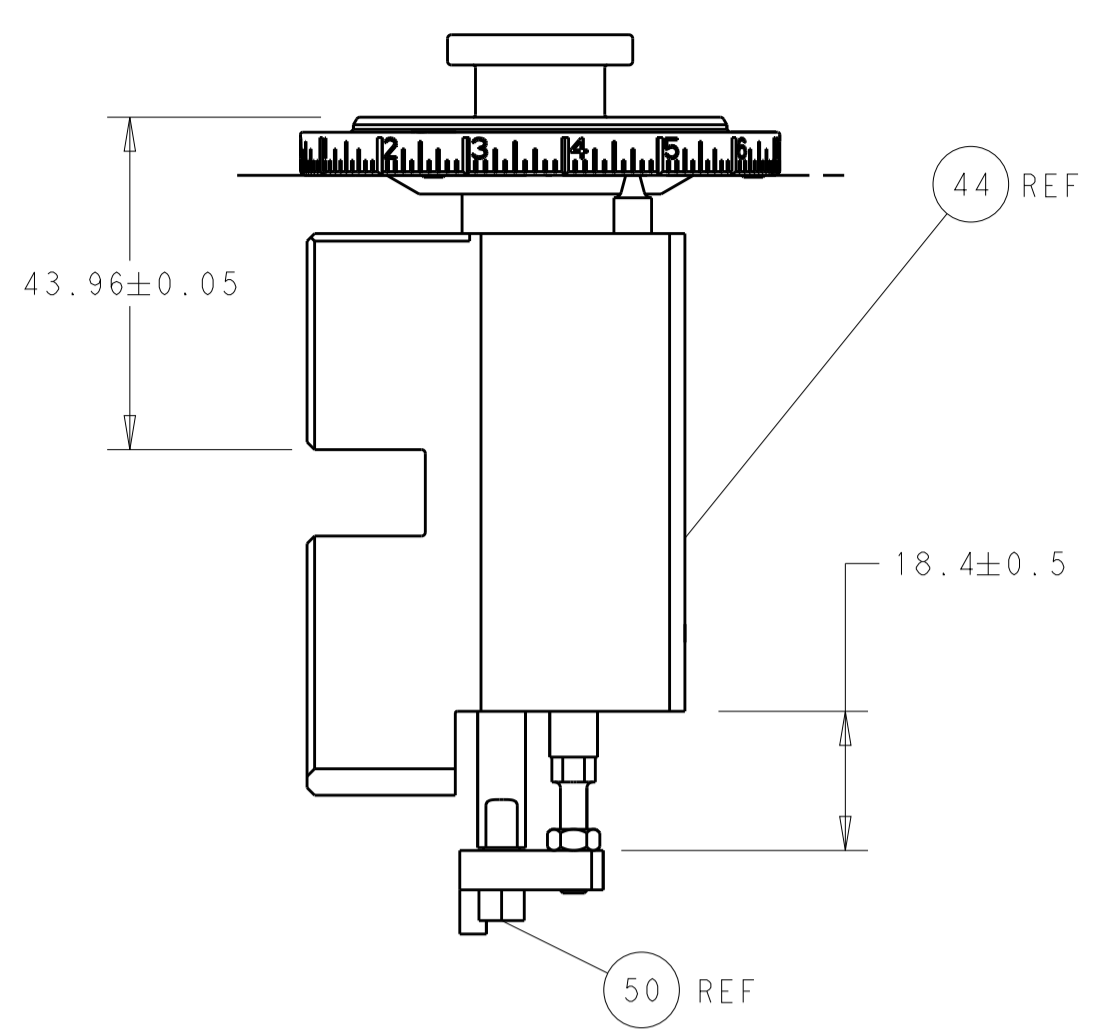
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-14-017572	24NOV2014	RK	GB
		B1		ECR-16-005465	14APR2016	RS	LZ
		C		ECR-19-005818	11APR2019	TB	CT
		D		ECR-20-011001	04AUG2020	FZ	TE

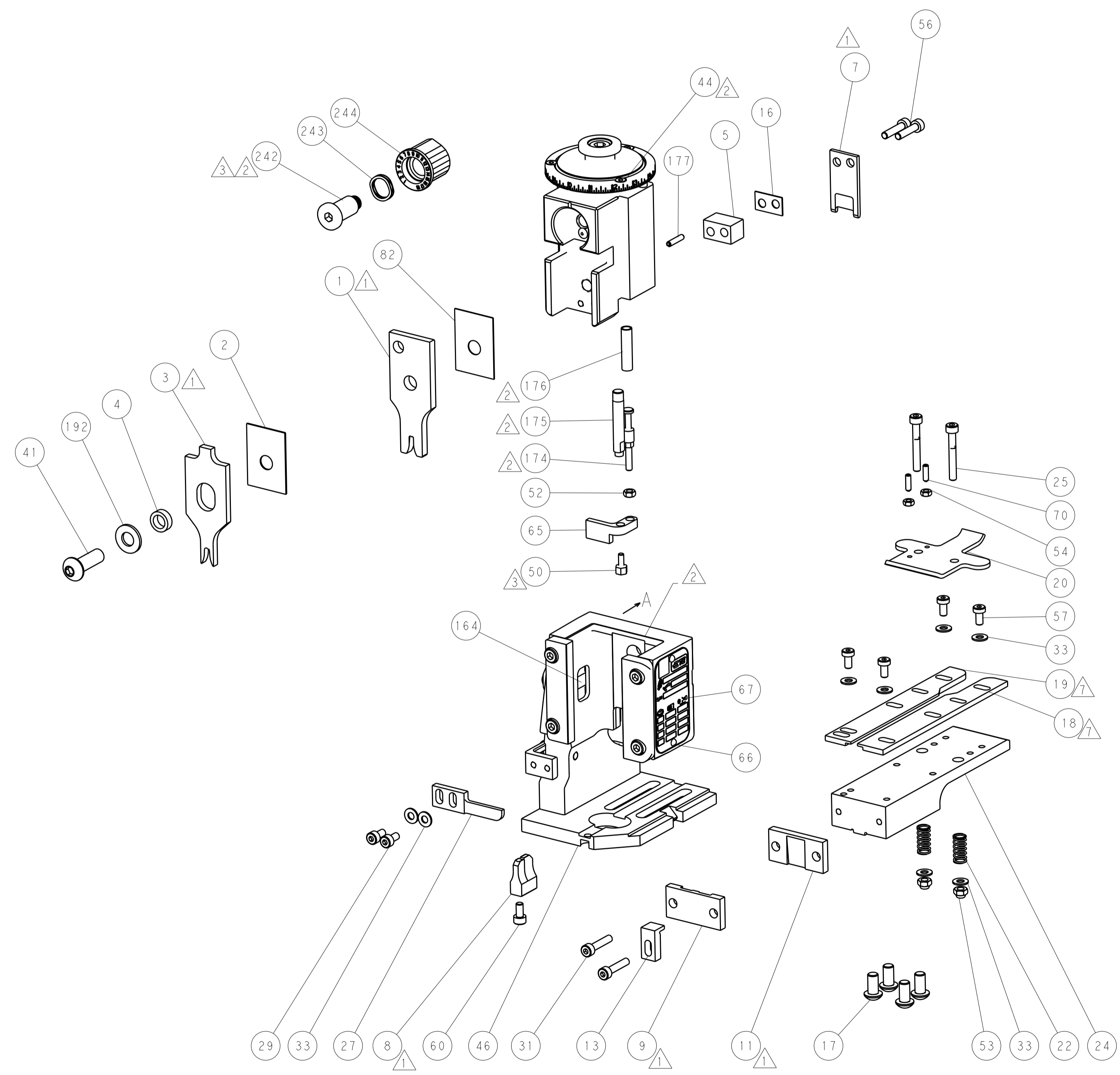
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-993111-6	PIN, SLOTTED 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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-4	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
-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	2063961-1	FEED FINGER	51
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-6	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	2	1-1803000-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-6	SPACER	5
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	4-1633664-7	CRIMPER, WIRE	1
-	77	72	2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	STAKEM	28NOV2012	CHK	28NOV2012
	3 PLC ±	4 PLC ±	ANGLES ±	G. BAILEY		APVD	
	FINISH			E. ERLIN	28NOV2012	NAME	
MATERIAL						TE Connectivity Harrisburg, PA 17105-3608	
						Ocean End Feed Applicator	
						SIZE	CAGE CODE
						A1	00779
						Customer Accessible Production Drawing	SCALE 1:1
						SHEET 1	OF 4
						REV	D

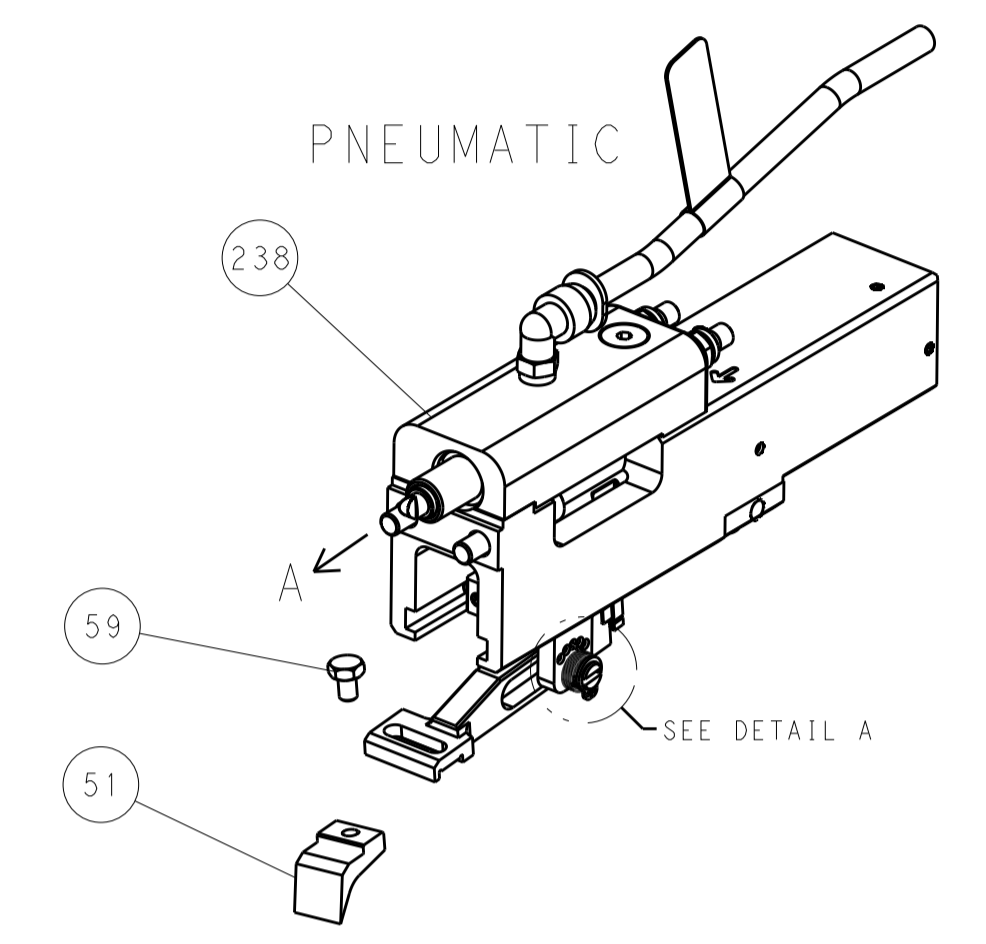
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
DESCRIPTION					
SEE SHEET 1					



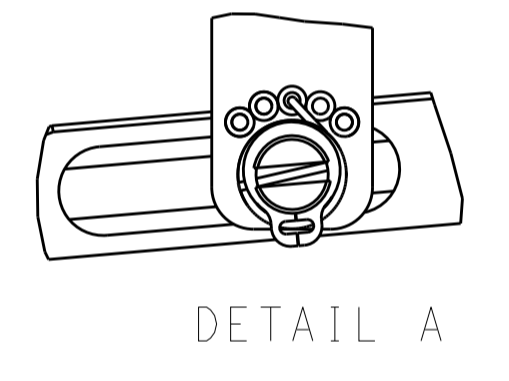
RAM AND HOLDDOWN SET-UP



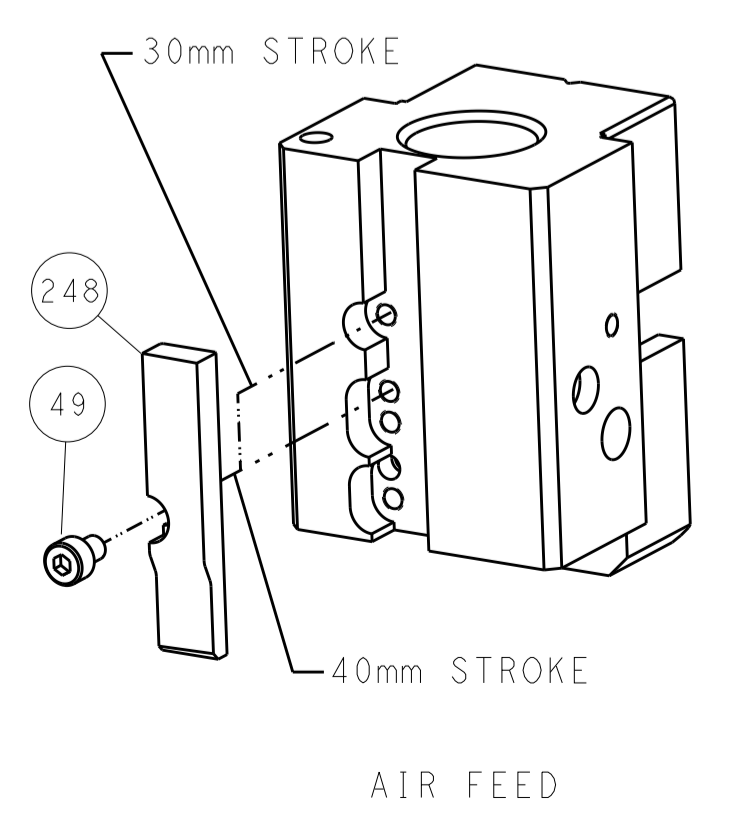
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

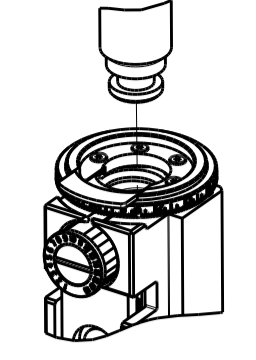


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. STAKEM 28NOV2012 CHK: G. BAILEY 28NOV2012 APVD: T. ERLIN 28NOV2012	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: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150299 RESTRICTED TO:
MATERIAL:		FINISH:	WEIGHT: SCALE: 1:1 SHEET: 2 of 4 REV: D

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150299-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-6.00 mm [.205-.236 IN]		Ø1.50-2.00 mm [.059-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25209 REVISION 12		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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0.75mm2	1.85+/-0.05 [.073+/-0.002]	5.3
0.50mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.35mm2	1.73+/-0.05 [.068+/-0.002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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2x 0.35	1.70+/-0.05 [.067+/-0.002]	6.7
0.50mm2	1.70+/-0.05 [.067+/-0.002]	6.7

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

***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	REV	DATE	BY	APPD
A	66				

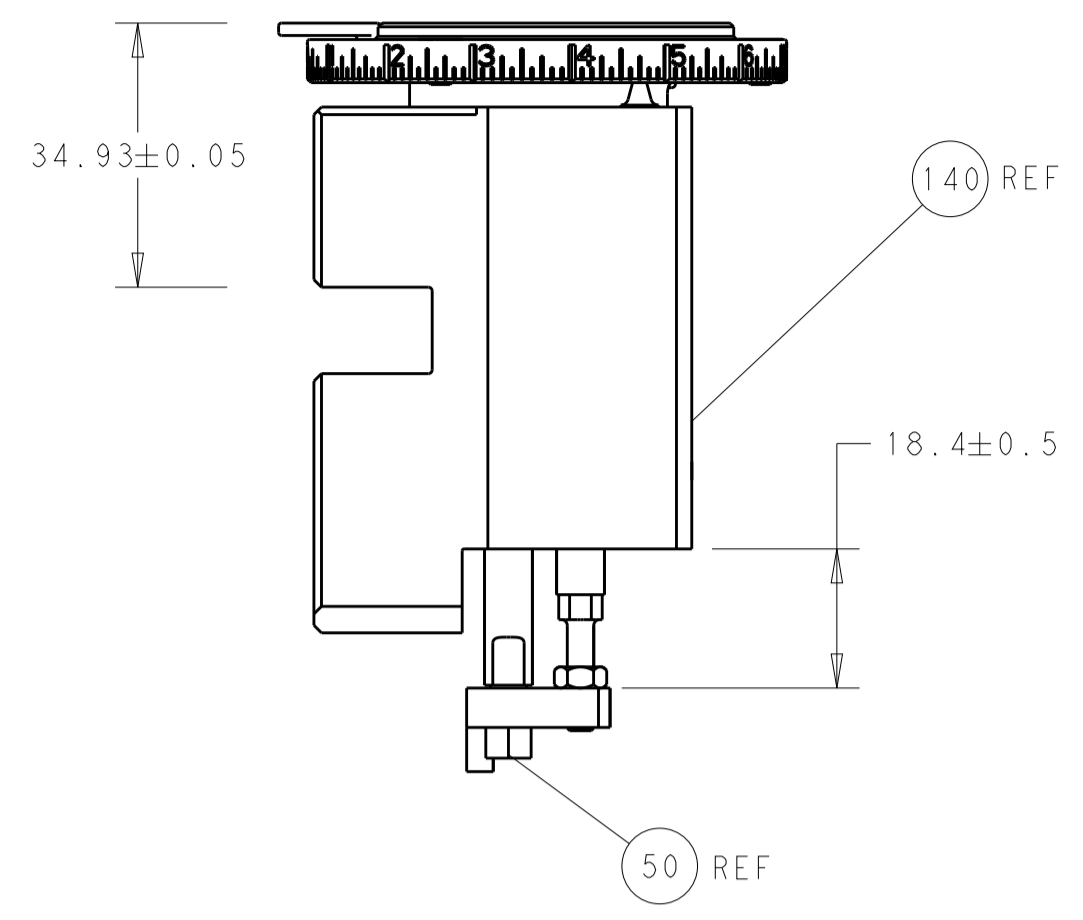
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
-	1	2119082-8			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-4			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	455888-4			82
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-1			65
-	1	5-18022-5			59
-	4	2168400-4			57
-	2	2-2168083-6			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-1			51
-	1	1752354-1			50
-	1	18023-9			49
-	1	1803602-1			41
-	8	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	240639-1			27
-	2	1-2168083-5			25
-	1	1752371-5			24
-	2	2-22281-3			22
-	1	1803292-4			20
-	1	1-1901696-5			19
-	1	1-1901695-5			18
-	1	6-240641-6			16
-	1	1752360-1			13
-	1	240644-1			11
-	-	-			10
-	1	690482-4			9
1	1	2-1803000-3			8
-	1	1-2217206-2			7
-	-	-			6
-	1	2-240641-6			5
-	1	4-238011-2			4
1	1	1-2119785-7			3
-	1	455888-6			2
1	1	4-1633664-7			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

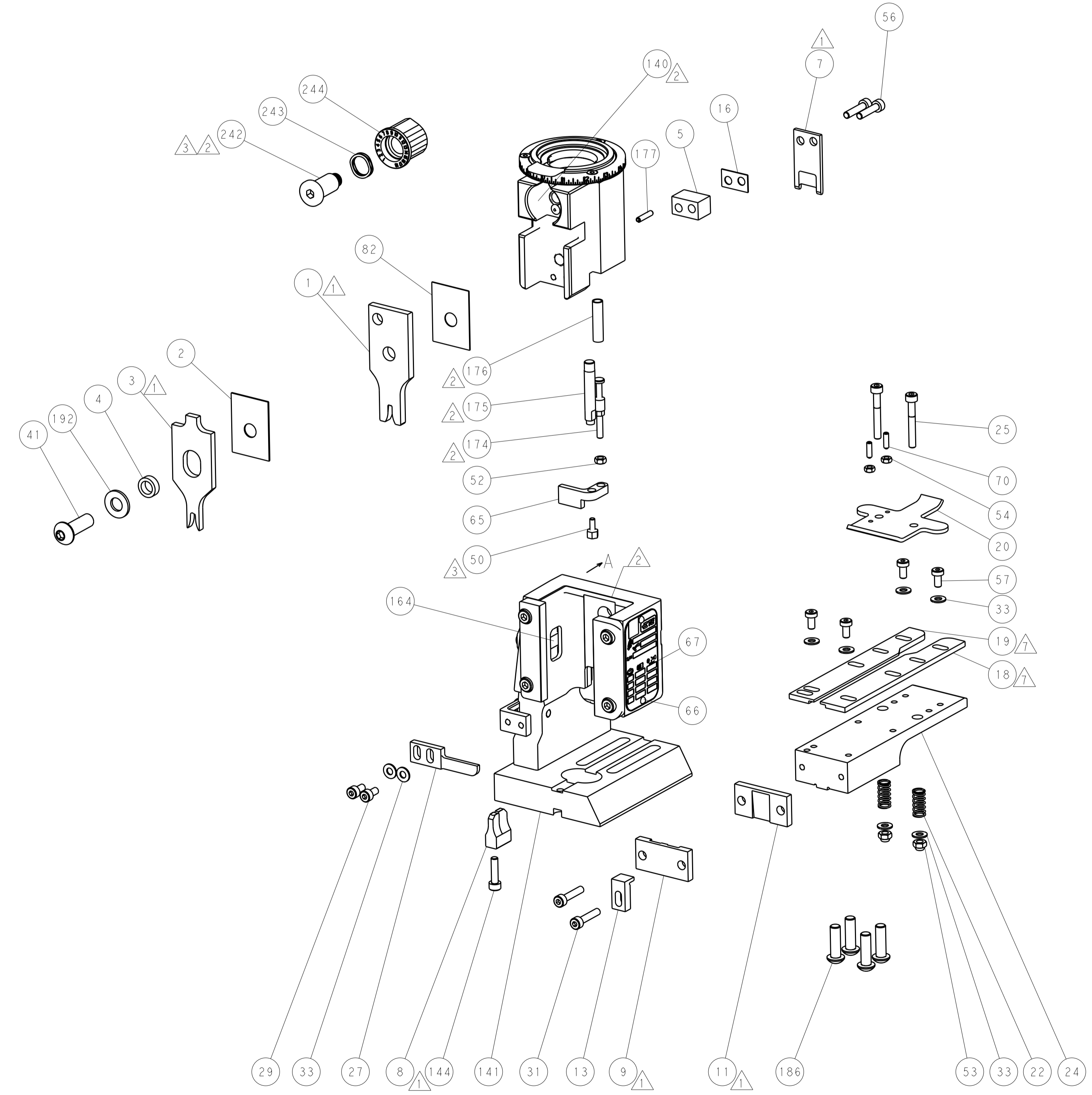
CHK	STAKEM	28NOV2012	
CHK	G. BAILEY	28NOV2012	
APVD	T. ERLIN	28NOV2012	

NAME	TE Connectivity
ADDRESS	Harrisburg, PA 17105-3608
PRODUCT SPEC	Ocean End Feed Applicator
APPLICATION SPEC	
SIZE	A1
CAGE CODE	00779
DRAWING NO	2150299
RESTRICTED TO	
WEIGHT	
SCALE	1:1
SHEET	3 OF 4
REV	D

LOC	DIST	REV	DATE	BY	APPV
A	66				

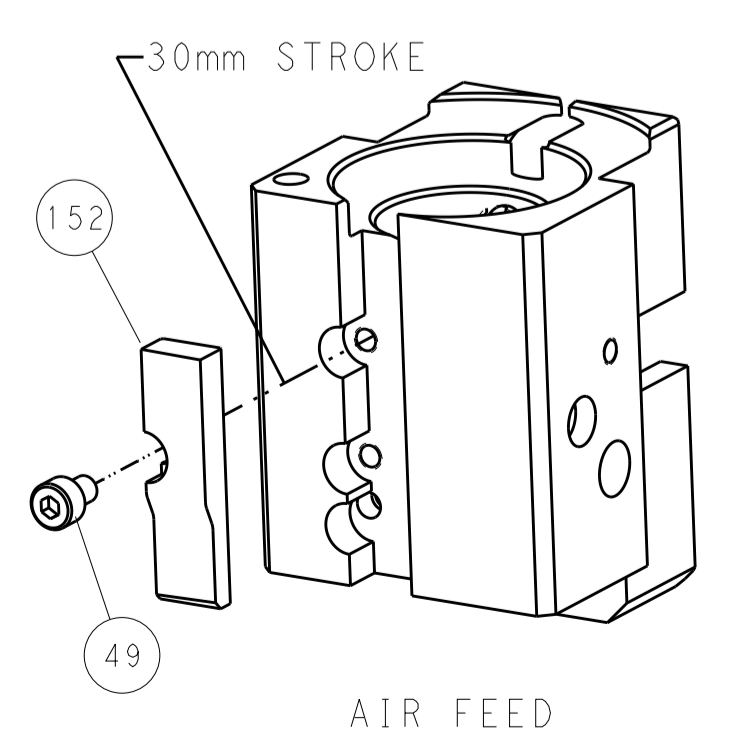


RAM AND HOLDDOWN SET-UP



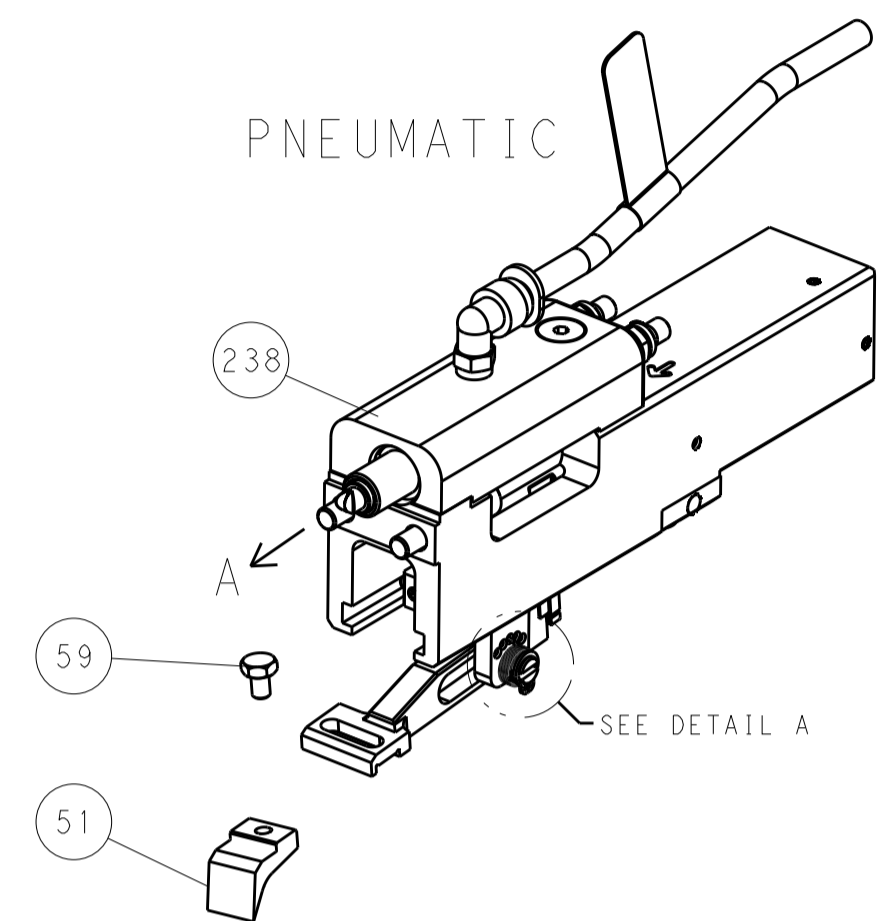
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

CAM POSITION

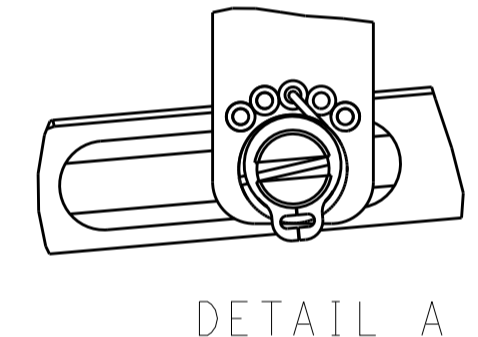


AIR FEED

FEED TYPE



FEED SPRING SETTING POSITION



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 28NOV2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK: G. BAILEY 28NOV2012	NAME: Ocean End Feed Applicator		
MATERIAL:				APVD: T. ERLIN 28NOV2012	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150299
				Customer Accessible Production Drawing	SCALE: 1:1	SHEET: 4	OF 4 REV: D