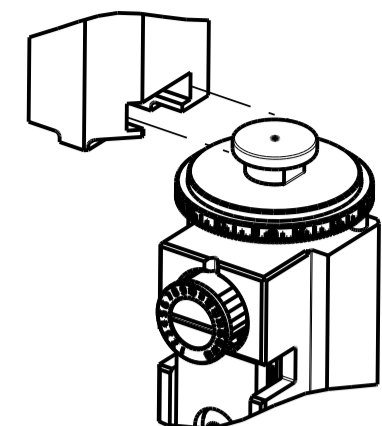


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150162-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150162-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150162-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.32 mm [.170]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H TERMINAL G&H CRIMP SPECIFICATION

TERMINAL NAME: G&H TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.32-6.09 mm [.210-.240 IN]	Ø1.90-3.00 mm [.075-.118 IN]

TERMINAL APPLICATION SPECIFICATION: G&H LEAR SPEC 25221 Rev 9

TERMINALS APPLIED

TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572900-1	25221.123.011	1572499-1	25219.213.004
1572900-2	25221.213.011	1572499-2	25219.213.320
1572900-3	25221.212.179	1572499-3	25219.123.014
1572900-4	25221.214.009	1572499-4	25219.123.011
1572900-5	25221.214.321	1572499-5	25219.123.322
1572900-6	25221.122.323	1572499-6	25219.123.009
1572900-7	25221.123.014	1572499-7	25219.411.031
1572900-8	25221.123.009	1572499-8	25219.212.179
		1572499-9	25219.213.011
		1-1572499-0	25219.213.322

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.25 +/- 0.05 [.089 +/- .002]	7.8
1.0+1.5	2.25 +/- 0.05 [.089 +/- .002]	7.8
2X1.00	2.15 +/- 0.05 [.085 +/- .002]	8.9
1.00+0.75	2.10 +/- 0.05 [.083 +/- .002]	9.2
1.50mm2	2.10 +/- 0.05 [.083 +/- .002]	9.2



- 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 180. 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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.

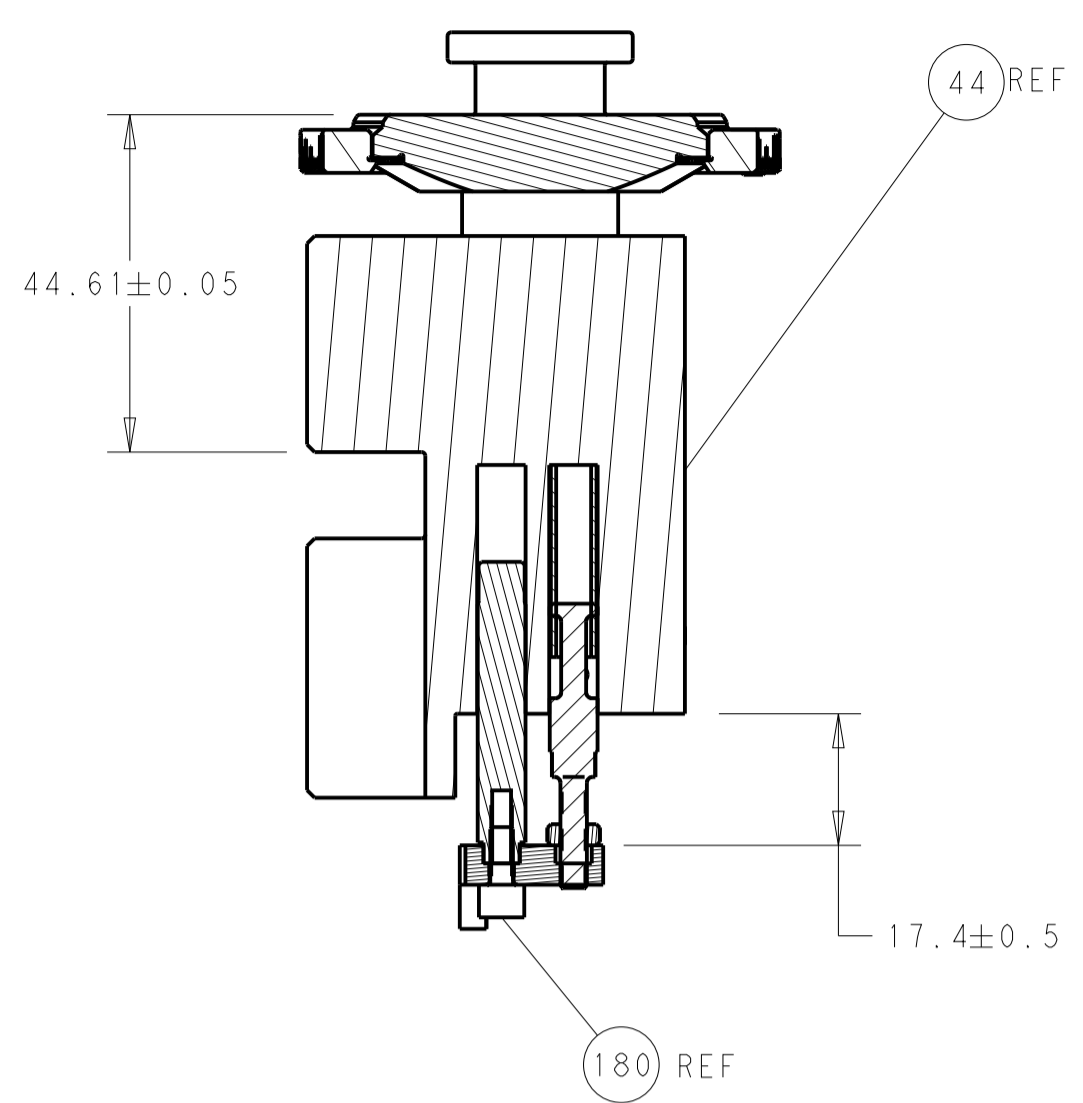
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPD
A	66	B		ECR-17-005417	13APR2017	AW	CT
		B1		ECR-19-007525	13MAY2019	FZ	CT
		C		ECR-20-005941	23APR2020	FZ	TE
		D		ECR-21-003785	31MAR2021	FZ	RK

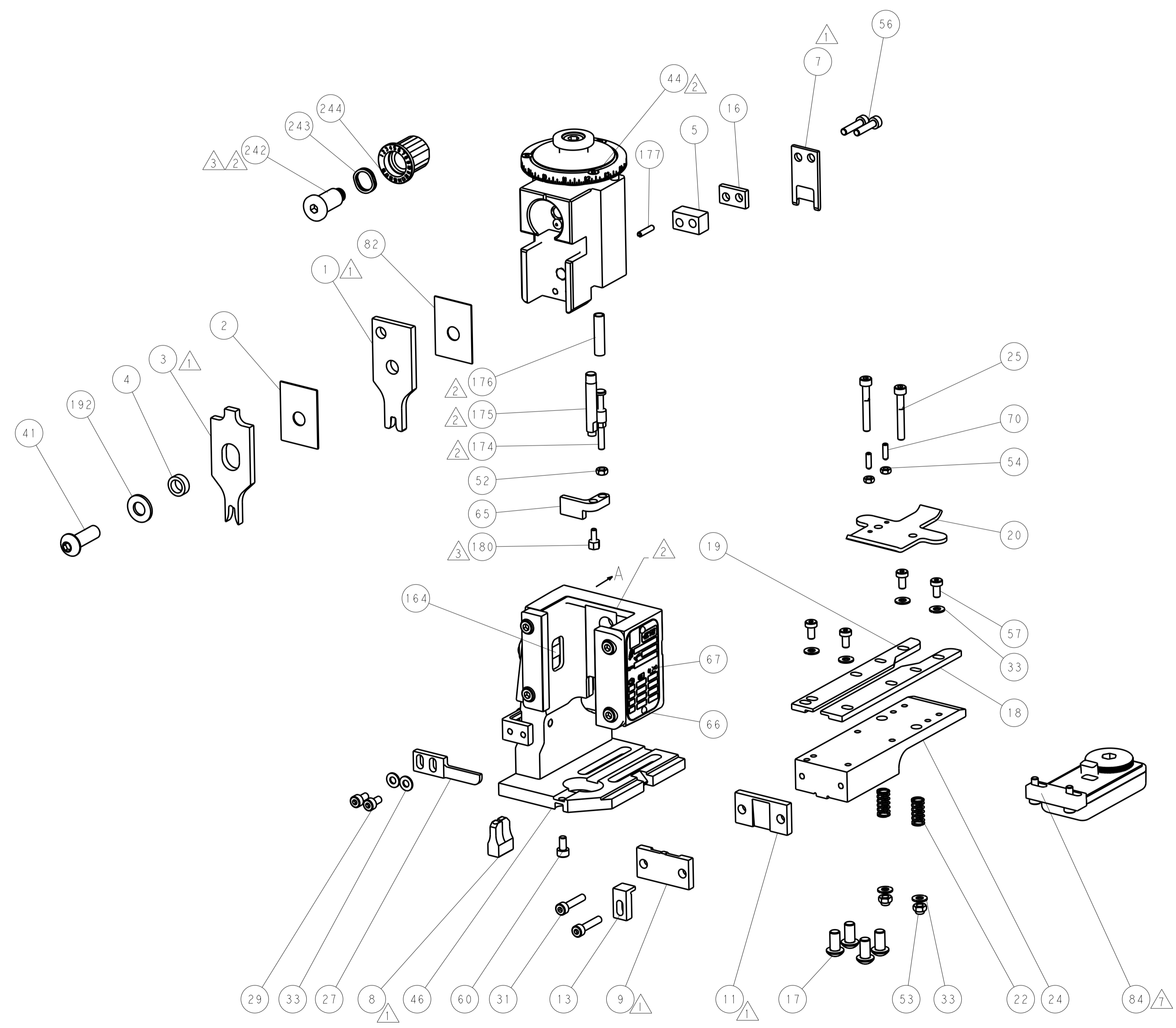
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	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
7	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	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	2-1901696-2	STRIP GUIDE, REAR	19
-	1	1	2-1901695-2	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	240641-8	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	3-690495-6	PLATE, FRONT SHEAR	9
1	1	2	1-1803000-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	5-240641-7	SPACER	5
-	1	1	6-238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	6-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	3-456410-2	CRIMPER, WIRE PREMIUM	1
-	77-72	-	2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	DATE	17OCT2014	DATE	17OCT2014
								NAME	X. ZHAO	DATE	17OCT2014
								NAME	L. ZHANG	DATE	17OCT2014
								NAME	T. ELBIN	DATE	17OCT2014
								PRODUCT SPEC			
								APPLICATION SPEC			
								SIZE	A1	CAGE CODE	00779
								DRAWING NO	2150162		
								RESTRICTED TO			
								WEIGHT			
								SCALE	1:1	SHEET	1 OF 4
								REV	D		

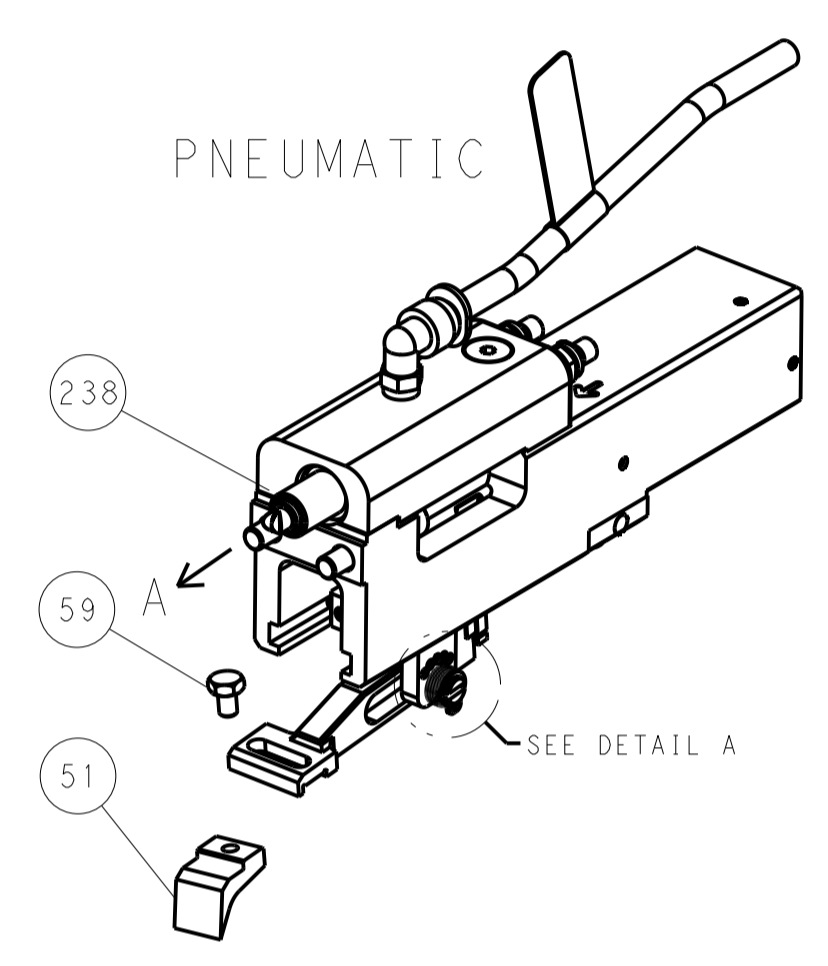
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP

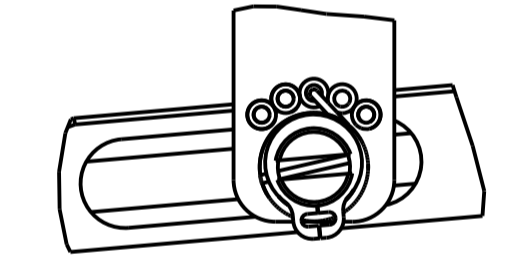


FEED TYPE



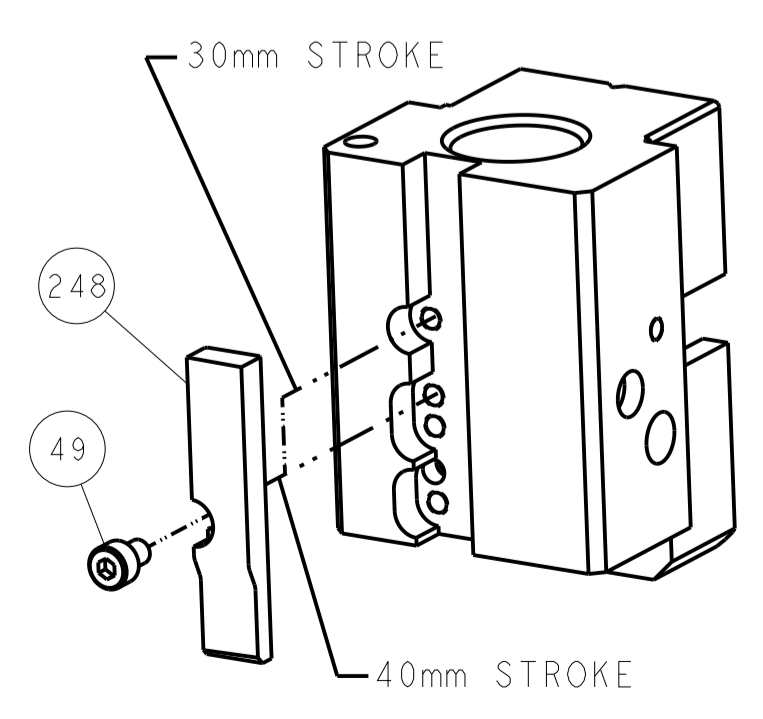
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



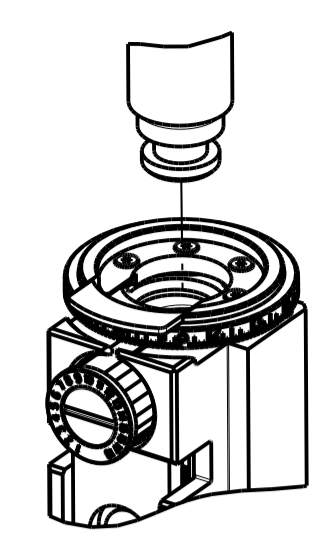
AIR FEED

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 X.ZHAO 17OCT2014 CHK L.ZHANG 17OCT2014 APVD T.FLRIN 17OCT2014		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 CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150162	
MATERIAL:		FINISH:		WEIGHT: Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150162-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150162-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.32 mm [.170]	OV

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: G&H TERMINAL G&H CRIMP SPECIFICATION

TERMINAL NAME: G&H TERMINAL	
WIRE STRIP LENGTH 5.32-6.09 mm [.210-.240 IN]	INSULATION DIAMETER RANGE Ø1.90-3.00 mm [.075-.118 IN]
TERMINAL APPLICATION SPECIFICATION G&H LEAR SPEC 25221 Rev 9	

TERMINALS APPLIED

TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572900-1	25221.123.011	1572499-1	25219.213.004
1572900-2	25221.213.011	1572499-2	25219.213.320
1572900-3	25221.212.179	1572499-3	25219.123.014
1572900-4	25221.214.009	1572499-4	25219.123.011
1572900-5	25221.214.321	1572499-5	25219.123.322
1572900-6	25221.122.323	1572499-6	25219.123.009
1572900-7	25221.123.014	1572499-7	25219.411.031
1572900-8	25221.123.009	1572499-8	25219.212.179
		1572499-9	25219.213.011
		1-1572499-0	25219.213.322

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.25+/-0.05 [.089+/- .002]	7.8
1.0+1.5	2.25+/-0.05 [.089+/- .002]	7.8
2X1.00	2.15+/-0.05 [.085+/- .002]	8.9
1.00+0.75	2.10+/-0.05 [.083+/- .002]	9.2
1.50mm2	2.10+/-0.05 [.083+/- .002]	9.2

- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- △ TERMINAL LUBRICANT IS RECOMMENDED.

***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.

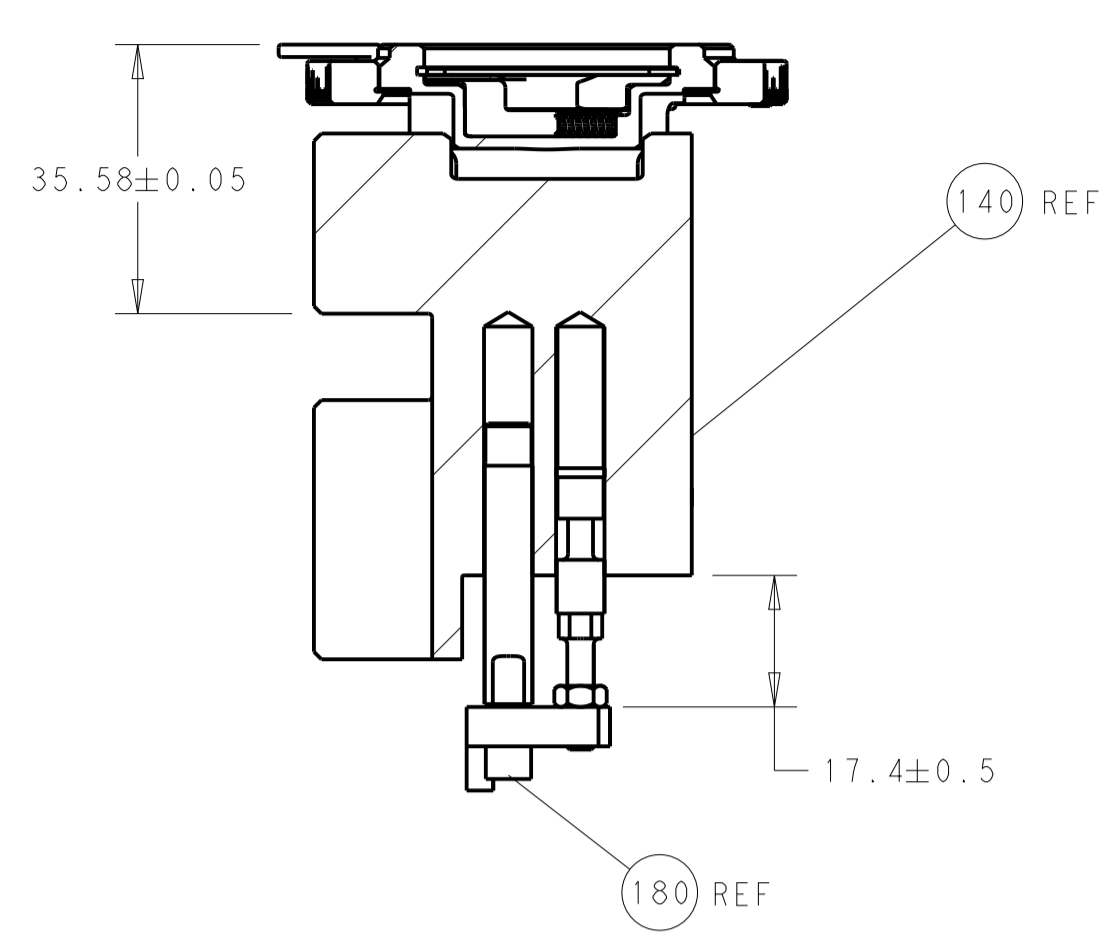
LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DESCRIPTION	DATE	BY	APPD
-	1	2119082-3	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
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
△	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	2063961-1	FEED FINGER	51
-	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	2-1901696-2	STRIP GUIDE, REAR	19
-	1	2-1901695-2	STRIP GUIDE, FRONT	18
-	1	240641-8	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
△	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	10
△	1	3-690495-6	PLATE, FRONT SHEAR	9
△	1	6-1803000-1	ANVIL, COMBINATION, END FEED	8
△	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	6
-	1	5-240641-7	SPACER	5
-	1	6-238011-8	BLOCK, CRIMPER SPACER	4
△	1	6-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
△	1	3-456410-2	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)

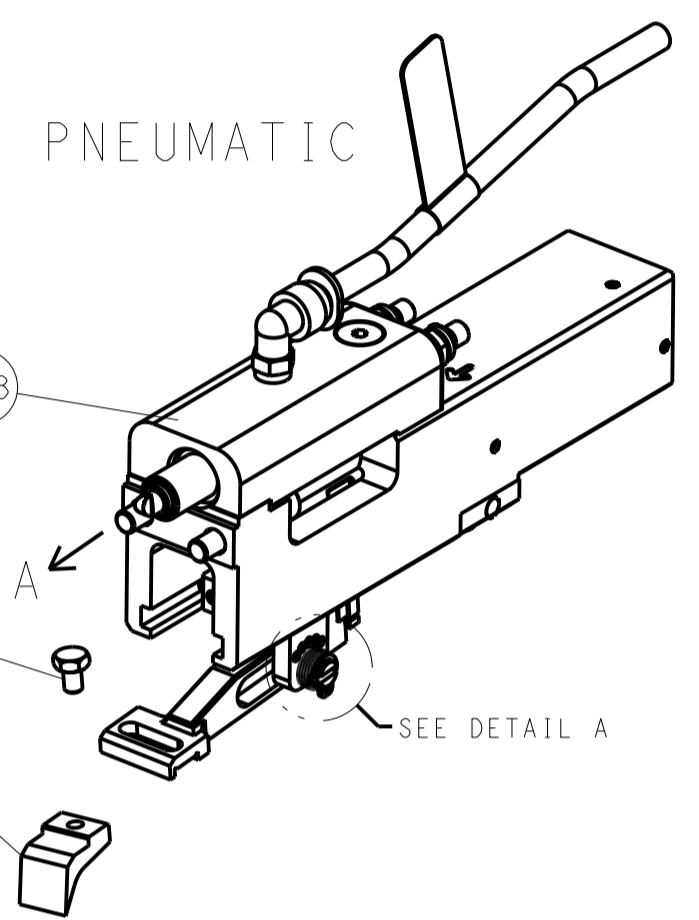
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X ZHAO 11OCT2014 CHK L ZHANG 17OCT2014 APVD T FLRIN 17OCT2014		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		C=2150162	
				Customer Accessible Production Drawing		SHEET 3 OF 4	

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

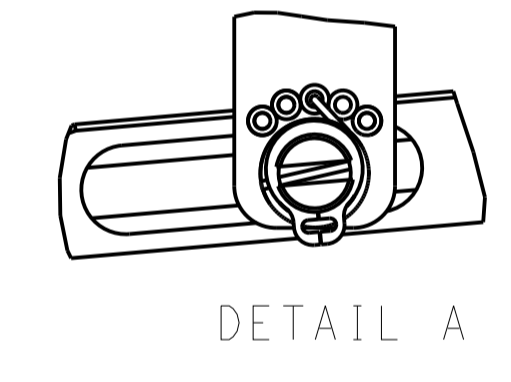


RAM AND HOLDDOWN SET-UP

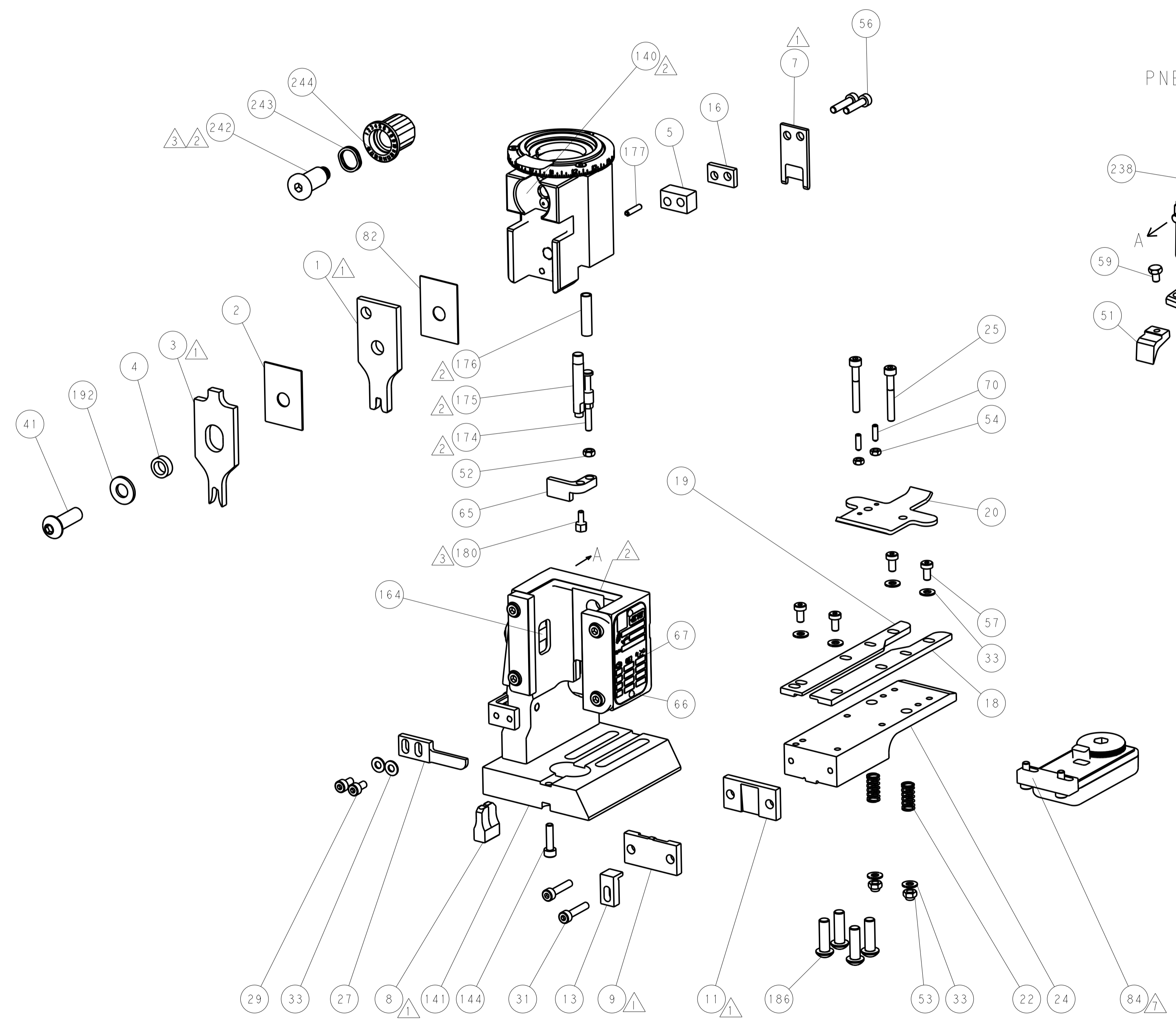
FEED TYPE



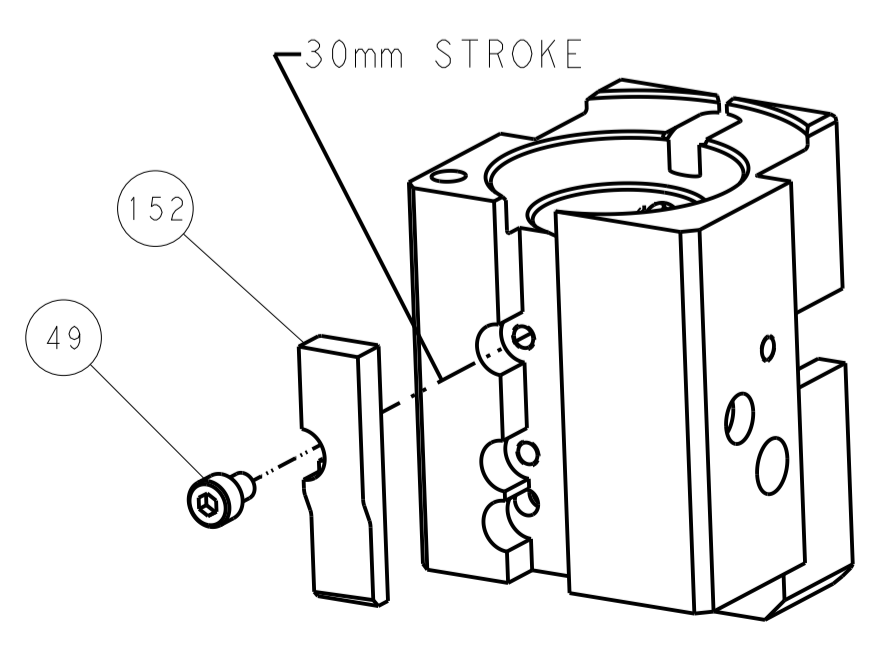
FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150162 SHEET 4 OF 4 REV D
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	