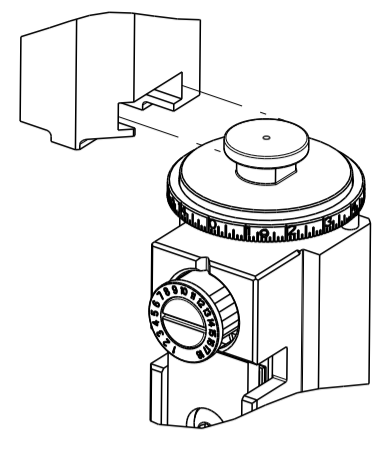


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150388-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150388-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150388-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150388-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150388-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.68 mm [.145]	OV

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: G & H TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FLACHSTECKHULSE 4.80 x 0.8 FASTON			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.00-5.00 mm [.197-.197 IN]	∅2.10-3.10 mm [.083-.122 IN]		
TERMINAL APPLICATION SPECIFICATION	25312		
TERMINALS APPLIED			
TE TERMINAL	G & H TERMINAL	TE TERMINAL	G & H TERMINAL
1572180-1	25312.213.011	1572180-8	25312.123.327
1572180-2	25312.417.328	1572180-9	25312.123.324
1572180-3	25312.417.031	1-1572180-0	25312.123.210
1572180-4	25312.213.178	1-1572180-1	25312.123.211
1572180-5	25312.213.042	1-1572180-2	25312.123.204
1572180-6	25312.213.004	1-1572180-3	25312.123.178
1572180-7	25312.123.330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 1.00mm2	1.75+/-0.05 [.069+/- .002]	4.4
2.50mm2	1.70+/-0.05 [.067+/- .002]	5.0
1.50mm2	1.50+/-0.05 [.059+/- .002]	7.0

- 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 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)

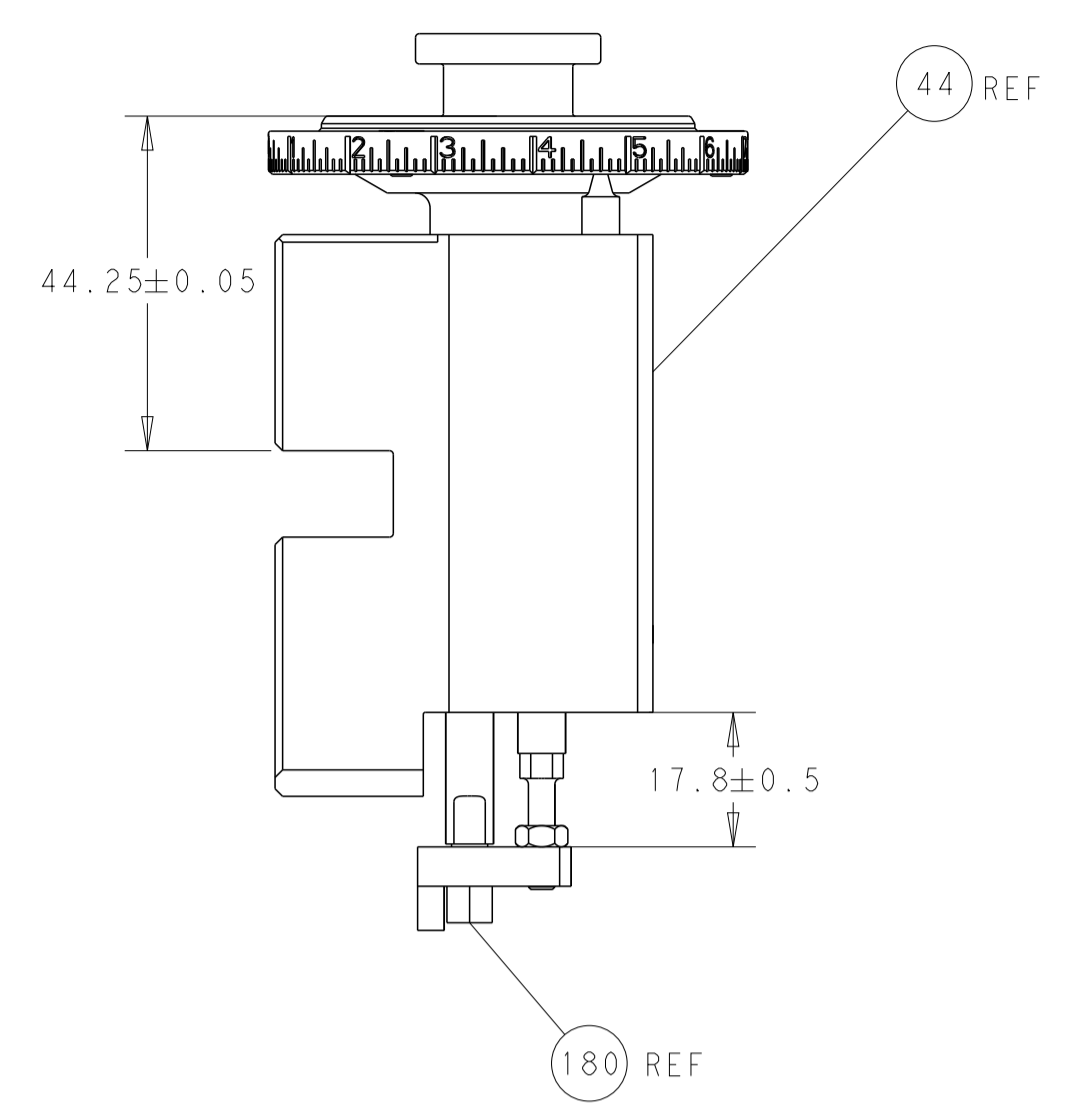
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	18DEC2013	LG	TE
		B		ECR-17-005523	17APR2017	TB	CT
		C		ECR-23-179893	30JUN2023	FZ	GB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239		
-	1	-	1	-	2844940-3	AIR FEED MODULE	238		
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
3	-	1	1	1	1752354-4	STANDOFF, HOLD-DOWN	180		
-	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		
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164		
6	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	1	1	455888-6	SPACER, CRIMPER	82		
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71		
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70		
-	1	1	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	1901681-5	HOLDDOWN, TERMINAL	65		
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60		
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	-	1	-	1	2063961-1	FEED FINGER	58		
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56		
-	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	-	1	-	2063961-9	FEED FINGER	51		
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48		
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47		
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46		
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44		
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	31		
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27		
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	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	1803292-4	DRAG	20		
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18		
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11		
-	-	-	-	-	-	-	10		
1	-	1	1	1	1-690482-2	PLATE, FRONT SHEAR	9		
1	1	2	2	1	1	3-1803001-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6		
-	1	1	1	1	1	4-240641-1	SPACER	5	
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1633963-5	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2	
1	1	2	2	1	1	9-1633305-1	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	-	-	1:1	SHEET 1 OF 4

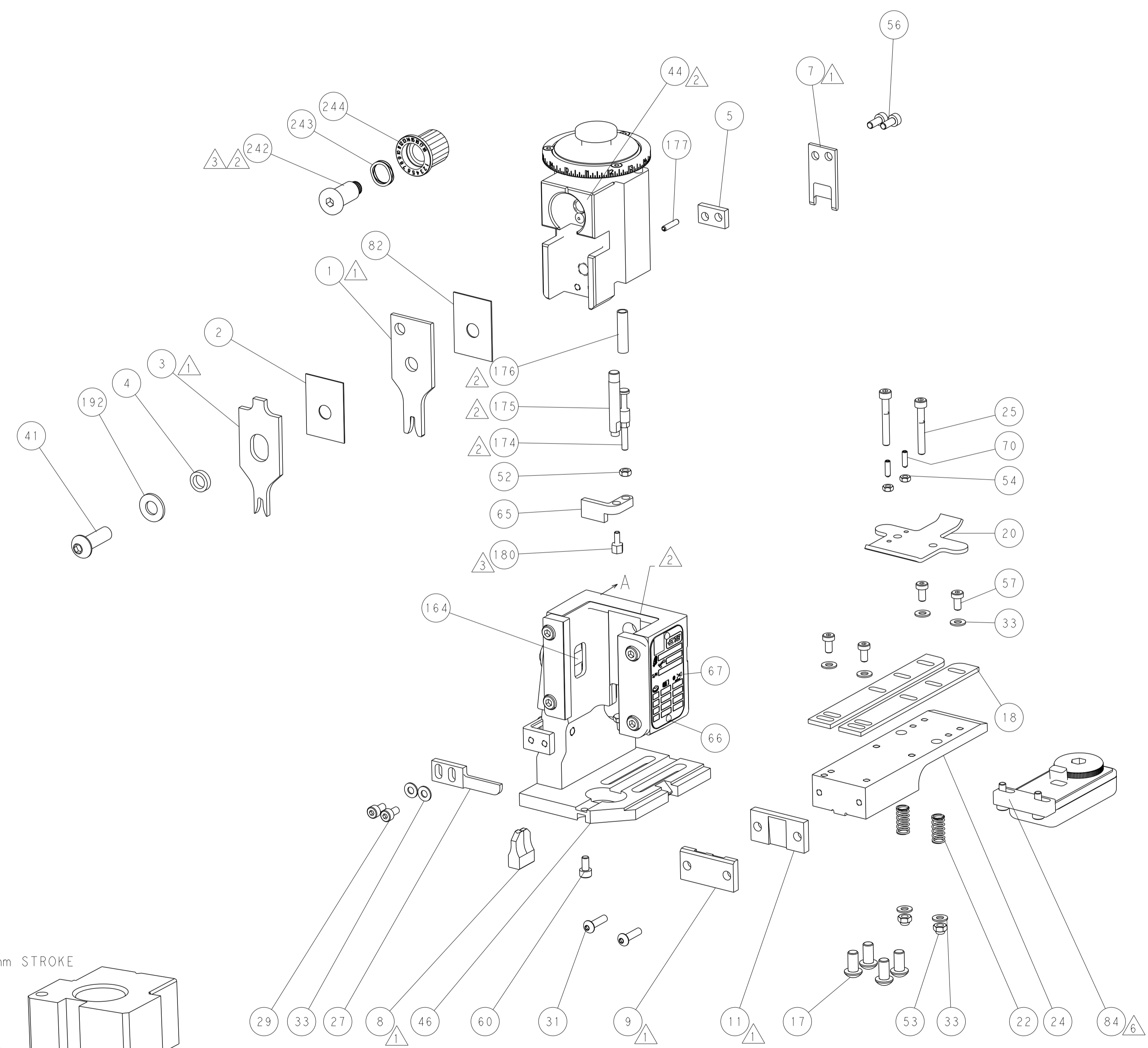
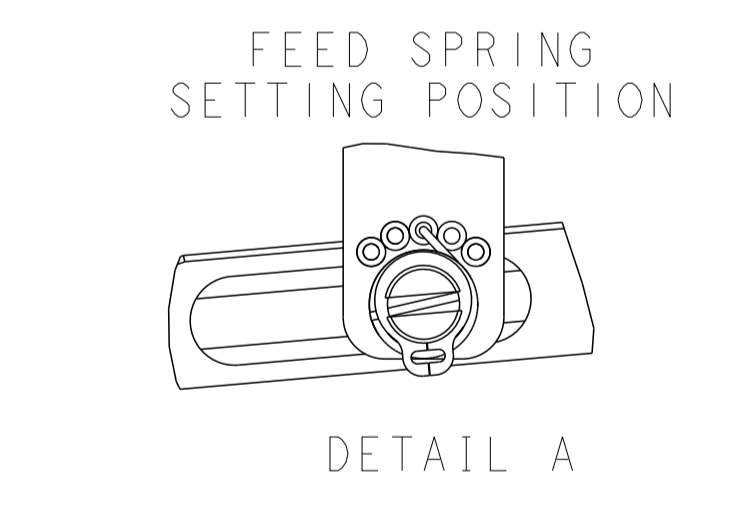
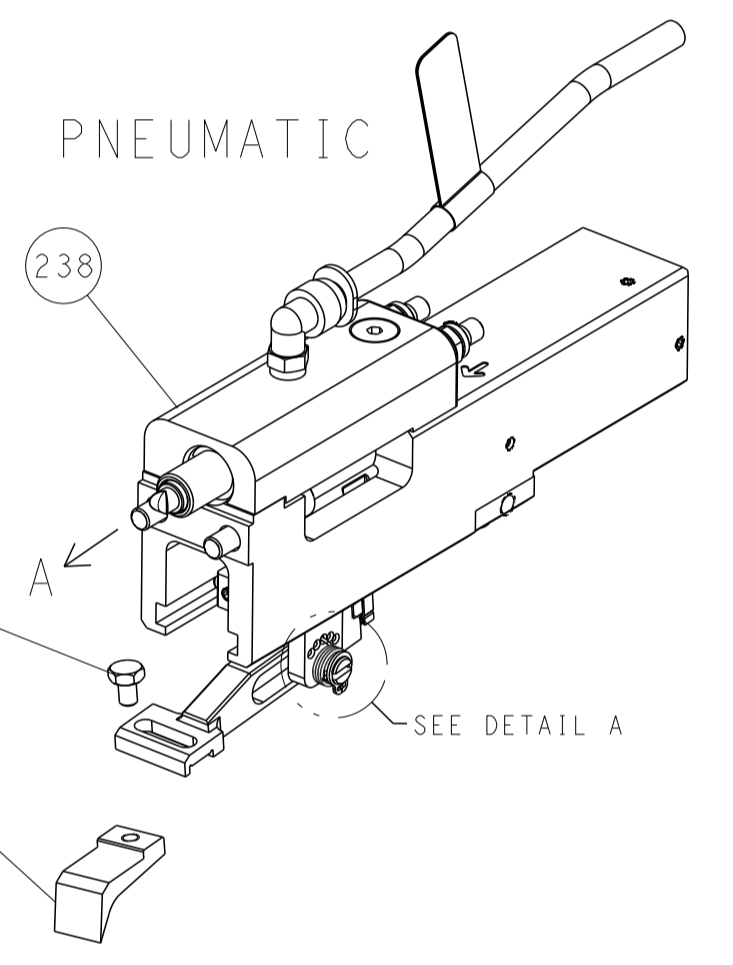
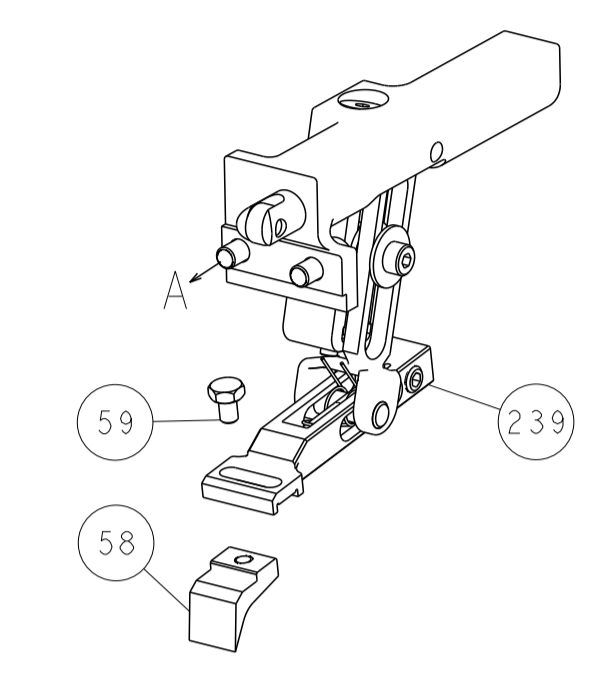
DWN	H. HUANG	18OCT2013	CHK	L. ZHANG	18OCT2013	APVD	J. GUO	18OCT2013	NAME	TE Connectivity
									Harrisburg, PA 17105-3608	
									Ocean End Feed Applicator	
									SIZE	A1
									CAGE CODE	00779
									DRAWING NO	2150388
									RESTRICTED TO	-
									Customer Accessible Production Drawing	REV C

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

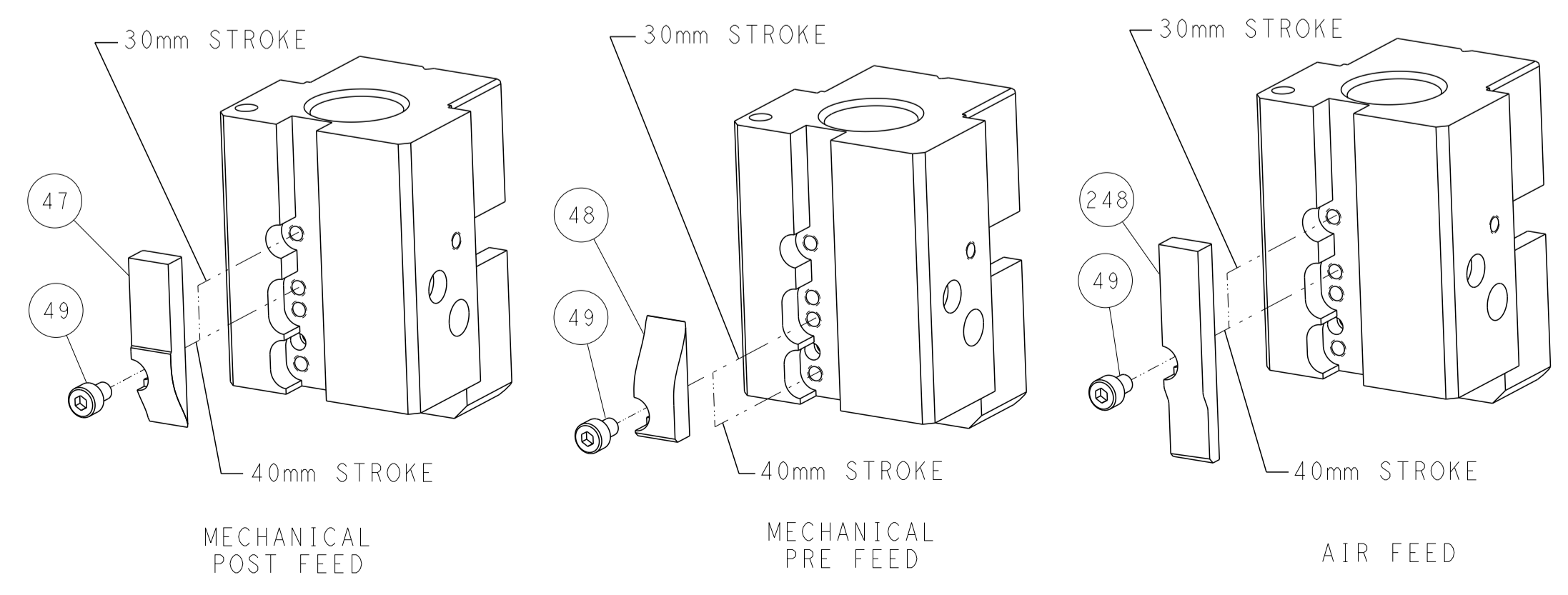


RAM & HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

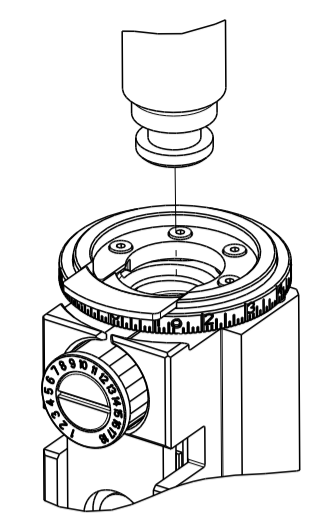


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 18OCT2013 CHK: L. ZHANG 18OCT2013 APVD: J. GUO 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150388 SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL:		WEIGHT:	RESTRICTED TO:

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150388-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150388-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150388-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.64 mm [.1041]	F
INSUL	3.68 mm [.1451]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: G & H TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FLACHSTECKHULSE 4.80 x 0.8 FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.00 mm [.197-.197 IN]	∅2.10-3.10 mm [.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	G & H TERMINAL	TE TERMINAL	G & H TERMINAL
1572180-1	25312.213.011	1572180-8	25312.123.327
1572180-2	25312.417.328	1572180-9	25312.123.324
1572180-3	25312.417.031	1-1572180-0	25312.123.210
1572180-4	25312.213.178	1-1572180-1	25312.123.211
1572180-5	25312.213.042	1-1572180-2	25312.123.204
1572180-6	25312.213.004	1-1572180-3	25312.123.178
1572180-7	25312.123.330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 1.00mm2	1.75 +/- 0.05 [.069 +/- .002]	4.4
2.50mm2	1.70 +/- 0.05 [.067 +/- .002]	5.0
1.50mm2	1.50 +/- 0.05 [.059 +/- .002]	7.0



- △ 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 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.

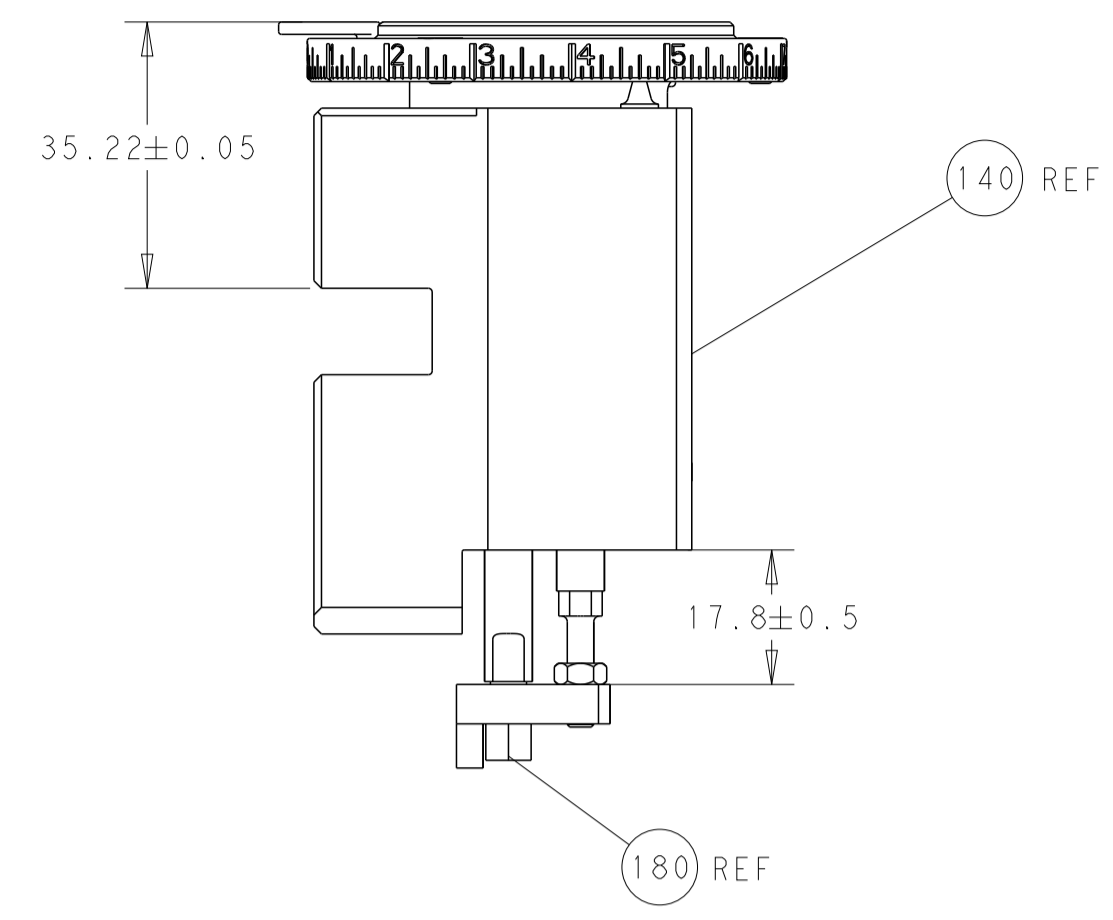
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	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	1752354-4	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	
-	REF REF	-	994970-2	COUNTER, MAGNETIC	164	
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-6	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	1901681-5	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-9	FEED FINGER	51	
-	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	2079383-8	SCR, BHSC, RoHS (M4 X 16)	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	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
△	-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
△	-	1	1-690482-2	PLATE, FRONT SHEAR	9	
△	1	1	3-1803001-3	ANVIL, COMBINATION, END FEED	8	
△	-	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-1	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
△	1	1	1633963-5	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	455888-5	SPACER, CRIMPER	2	
△	1	1	9-1633305-1	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

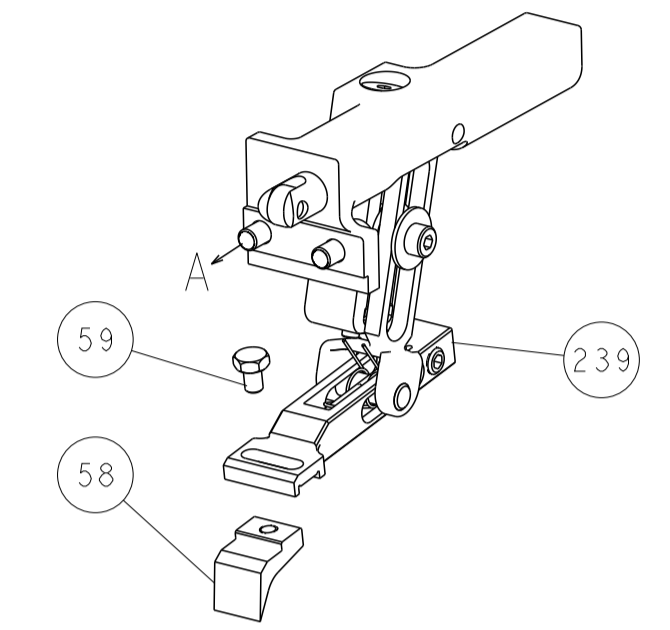
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	18OCT2013	CHK	18OCT2013
	3 PLC ±	4 PLC ±	ANGLES ±	L. ZHANG		APVD	
	FINISH			J. GUO	18OCT2013	NAME	
MATERIAL						PRODUCT SPEC	
						APPLICATION SPEC	
						SIZE	
						CAGE CODE	
						DRAWING NO	
						RESTRICTED TO	
						WEIGHT	
						A1 00779	©=2150388
						Customer Accessible Production Drawing	SCALE 1:1 SHEET 3 OF 4 REV C

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

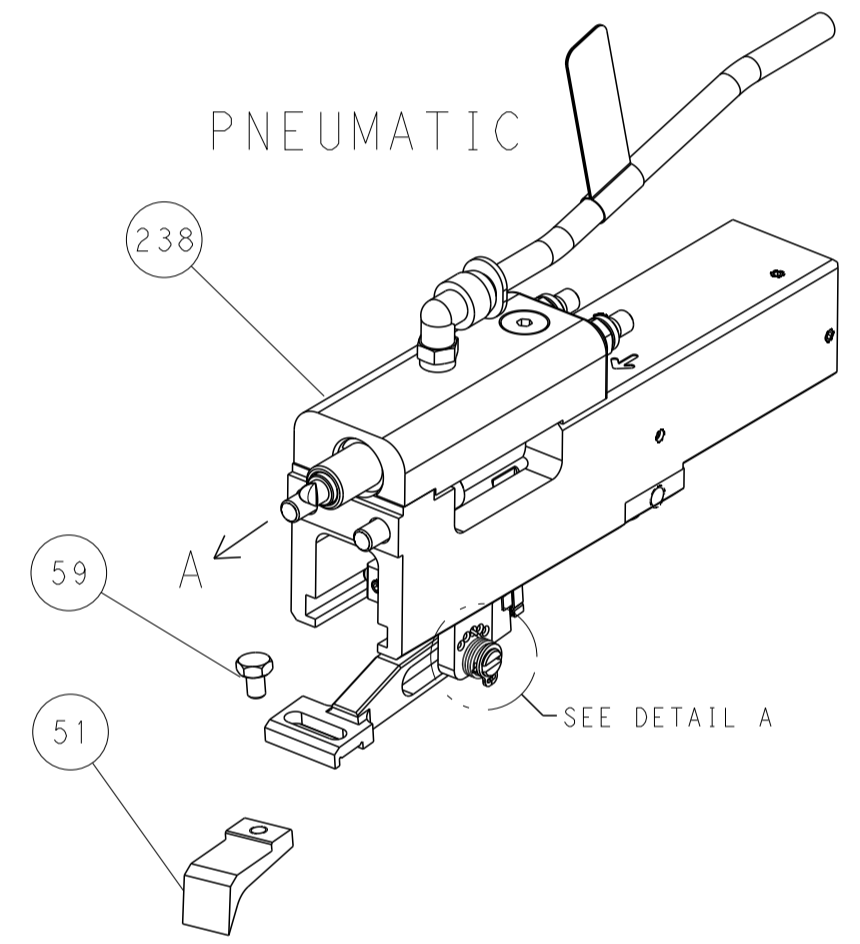


RAM & HOLDDOWN SET-UP

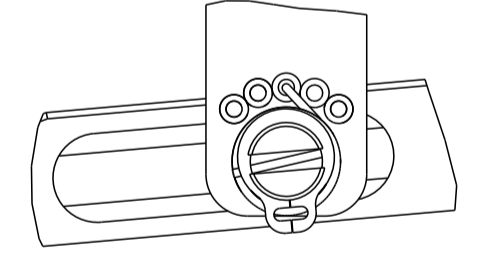
FEED TYPE
MECHANICAL



PNEUMATIC

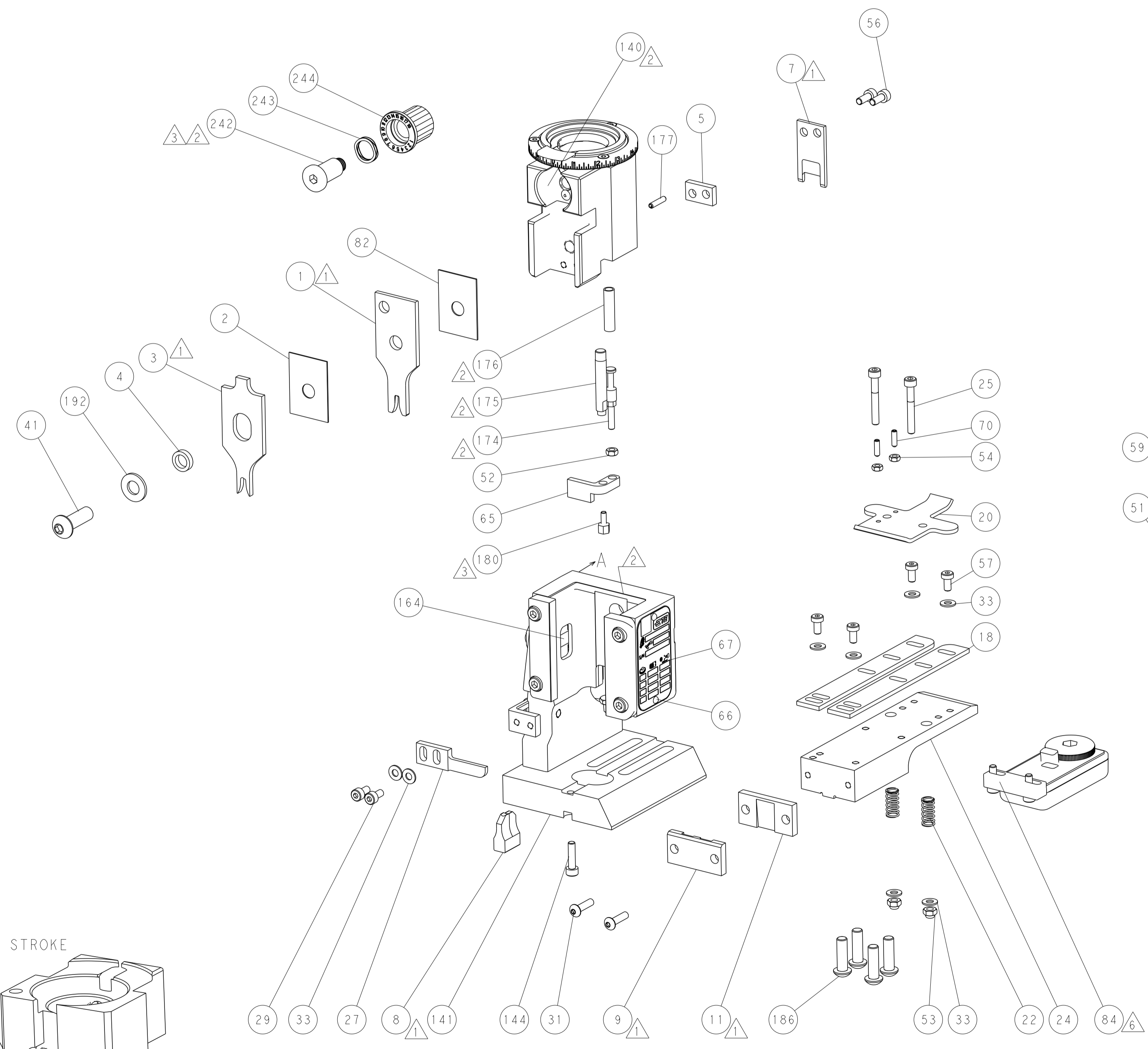
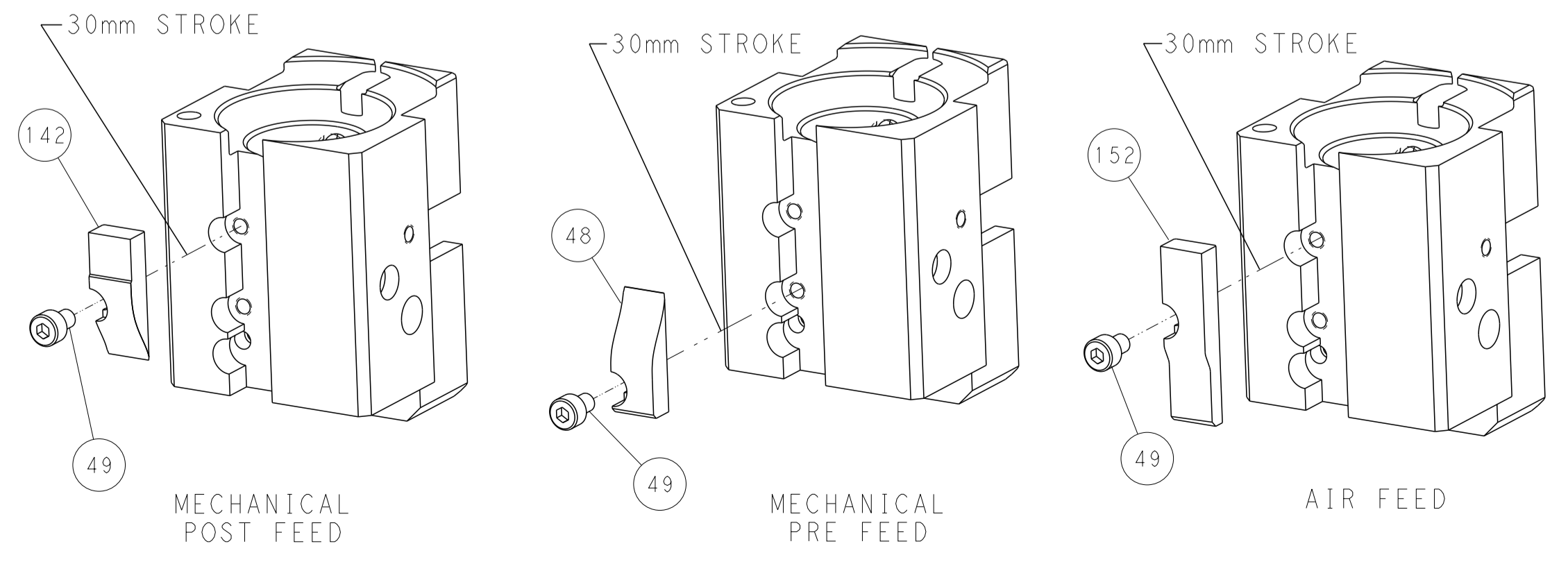


FEED SPRING
SETTING POSITION



DETAIL A

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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 18OCT2013 CHK L. ZHANG 18OCT2013 APVD JJ. GUO 18OCT2013		NAME Ocean End Feed Applier	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150388		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV C	