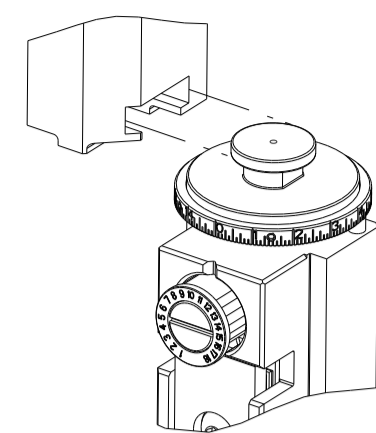


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150289-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150289-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150289-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150289-2	R	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150289-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: BERG TERMINAL BERG CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, MINI PV	
WIRE STRIP LENGTH 3.76-4.27 mm [.148-.168 IN]	INSULATION DIAMETER RANGE Ø0.91-2.62 mm [.036-.103 IN]

TERMINAL APPLICATION SPECIFICATION	BERG	-	-
------------------------------------	------	---	---

TE TERMINAL	BERG TERMINAL	TE TERMINAL	BERG TERMINAL
286512-1	47649-000(LF)	1-1572173-1	48049-001(LF)
286512-2	47565-000(LF)	1572173-6	48049-000(LF)
286512-3	47565-001(LF)	1572173-7	48049-002(LF)
286512-4	47565-002(LF)	1-356085-5	48245-001(LF)
286512-5	48051-000(LF)	356085-1	47439-000(LF)
286512-6	48051-002(LF)	356085-2	47439-001(LF)
286512-7	48248-000(LF)	356085-3	47439-002(LF)
286512-8	48248-002(LF)	1-356085-6	47216-002(LF)
1572173-1	47457-000(LF)	356085-5	48245-000(LF)
1572173-2	47457-001(LF)	356085-6	48245-002(LF)
1572173-3	47457-002(LF)	356085-7	48046-000(LF)
1572173-4	48242-000(LF)	356085-8	48046-002(LF)
286512-9	47649-001(LF)	356085-9	47216-000(LF)
1-286512-0	47649-002(LF)	1-356085-0	47216-001(LF)
1-286512-1	48051-001(LF)	1-356085-1	48046-001(LF)
1-286512-2	48248-001(LF)	1-356085-2	75691-004
1572173-9	48242-001(LF)	1-356085-3	75691-005
1-1572173-0	48242-002(LF)	1-356085-4	75691-006

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.86+/-0.03 [.034+/-0.001]	8.8
24 AWG	0.84+/-0.03 [.033+/-0.001]	9.0
26 AWG	0.81+/-0.03 [.032+/-0.001]	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 50. 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.

***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.

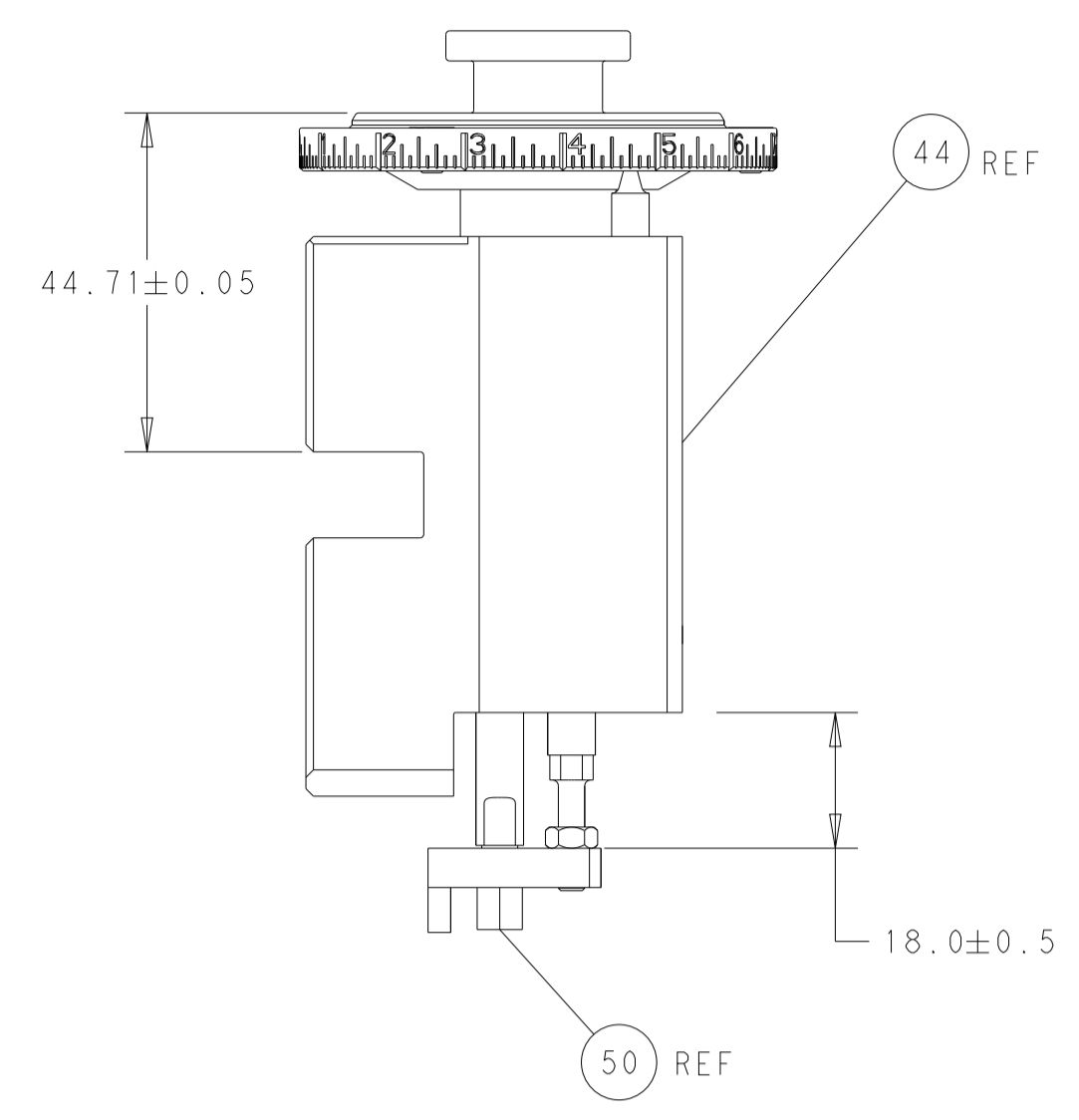
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		P		ECR-19-006524	23APR2019	TB	GB
		P1		ECR-20-008874	22JUN2020	JWC	GB
		R		ECR-21-005935	01JUN2021	FJ	TE
		R1		ECR-22-148911	10AUG2022	FZ	JAH

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	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
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	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
-	1	1	1	1	455888-1	SPACER, CRIMPER	82
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1	1	1-2119791-8	DEPRESSOR, WIRE	73
-	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	2119943-1	WASHER, SPACER	69
-	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	2-1901681-8	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	2063961-1	FEED FINGER	51
-	1	1	1	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	2168083-8	SCR, SKT HD CAP, 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	240639-2	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	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	1	1	1	1	4-1901696-9	STRIP GUIDE, REAR	19
-	1	1	1	1	5-1901695-0	STRIP GUIDE, FRONT	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
-	2	2	2	2	2-240645-7	SPACER, SHEAR PLATE	10
-	1	1	1	1	1-240642-1	PLATE, FRONT SHEAR	9
1	2	2	1	1	1803042-3	ANVIL, COMBINATION	8
-	1	1	1	1	8-240651-6	BLADE, SLUG	7
-	1	1	1	1	3-240641-4	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	7-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1803087-4	CRIMPER, WIRE	1
-	77	-	71	-	2	-	1

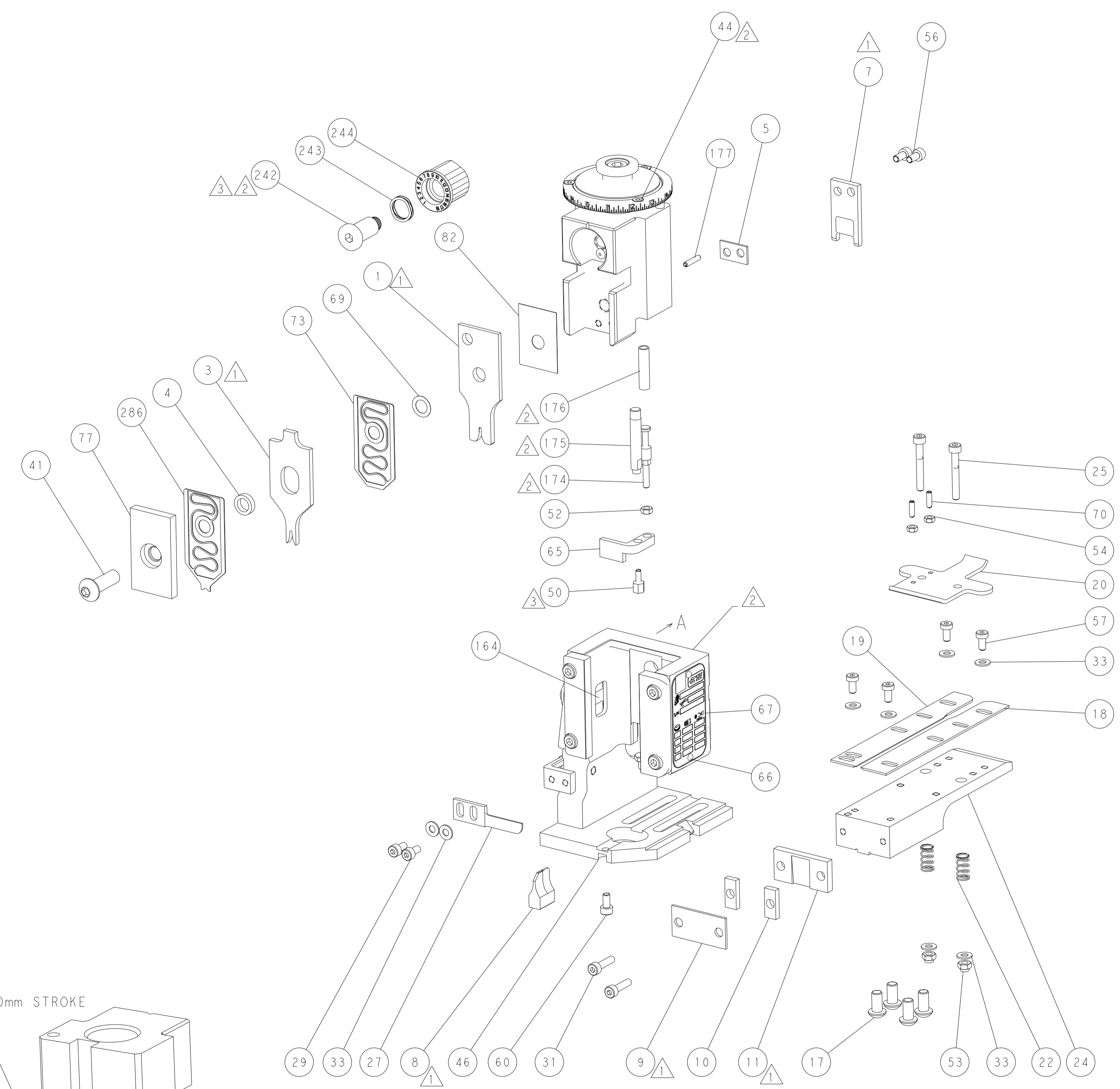
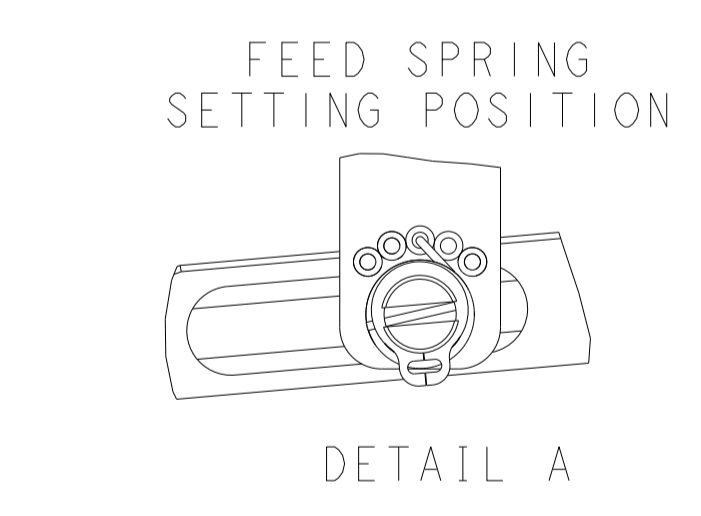
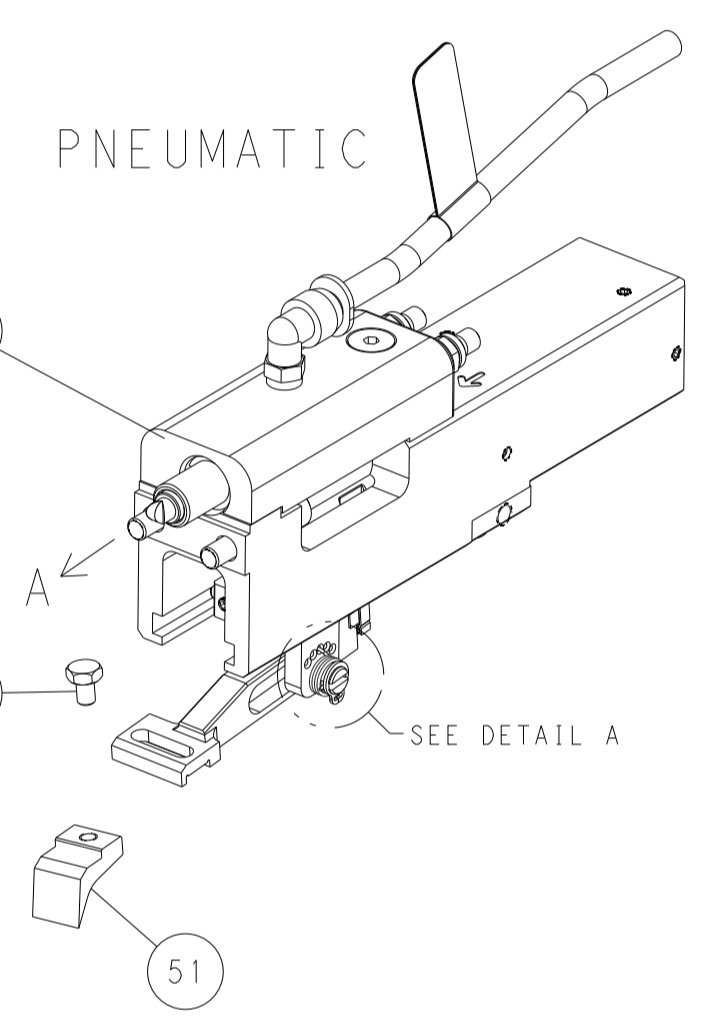
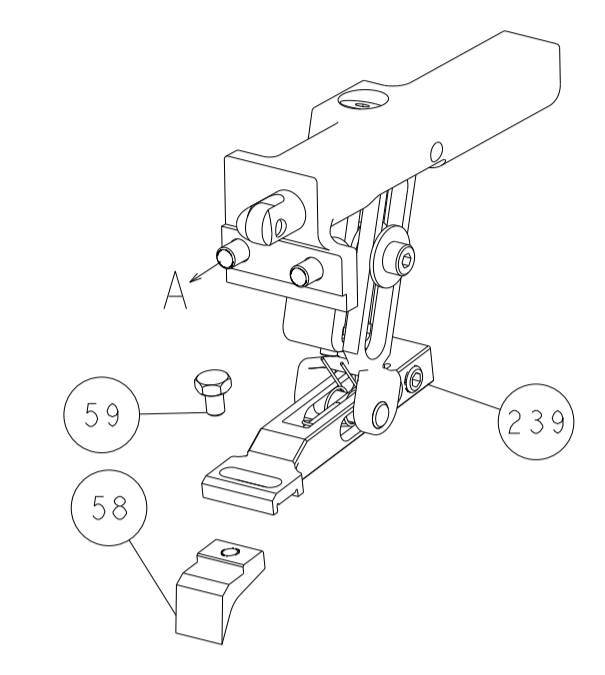
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
WEIGHT		SCALE		SHEET		REV	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 of 4		REV R1	

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

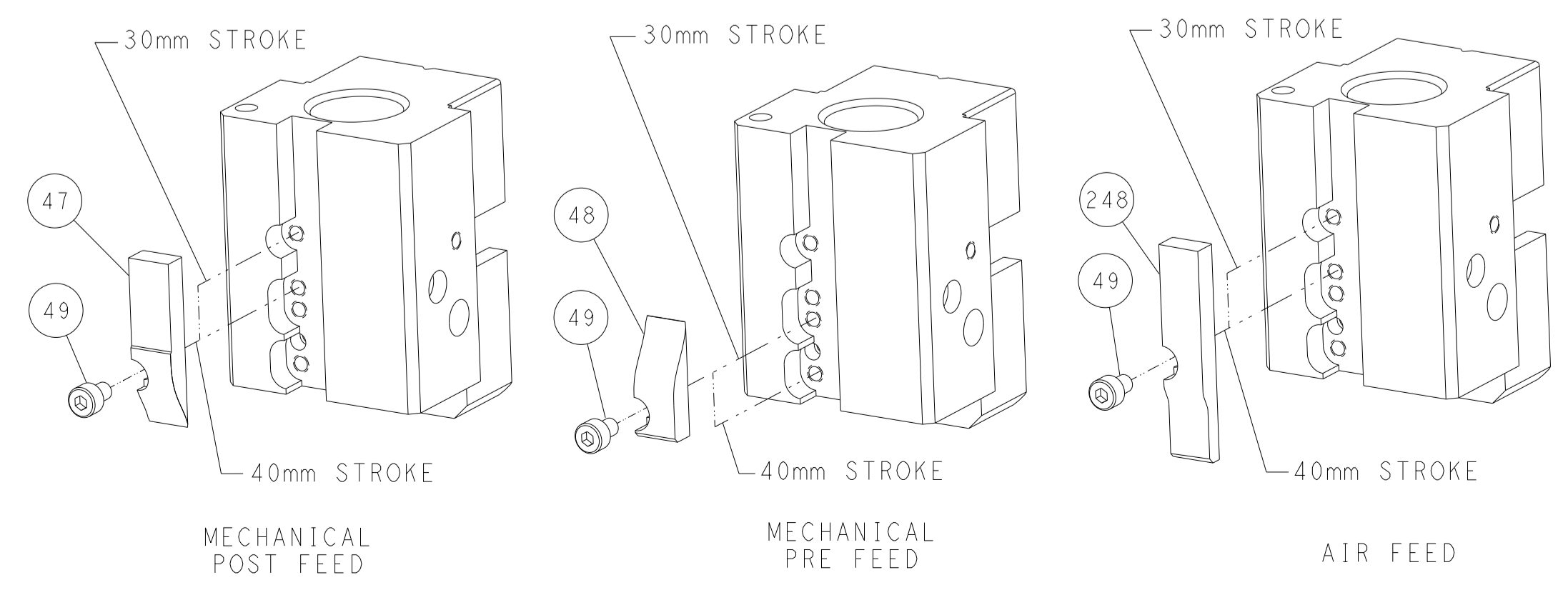


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

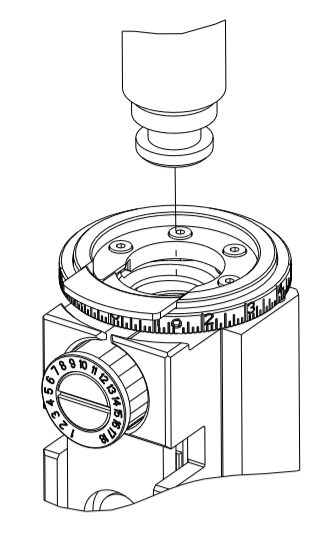


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN C. CHEN 20SEP2012 CHK S. XI 20SEP2012 APVD J. CRUZ 20SEP2012	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 CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150289 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV R1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150289-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150289-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150289-7	L	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: BERG TERMINAL BERG CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, MINI PV

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.76-4.27 mm [.148-.168 IN]	Ø0.91-2.62 mm [.036-.103 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	BERG TERMINAL	TE TERMINAL	BERG TERMINAL
286512-1	47649-000(LF)	1-1572173-1	48049-001(LF)
286512-2	47565-000(LF)	1572173-6	48049-000(LF)
286512-3	47565-001(LF)	1572173-7	48049-002(LF)
286512-4	47565-002(LF)	1-356085-5	48245-001(LF)
286512-5	48051-000(LF)	356085-1	47439-000(LF)
286512-6	48051-002(LF)	356085-2	47439-001(LF)
286512-7	48248-000(LF)	356085-3	47439-002(LF)
286512-8	48248-002(LF)	1-356085-6	47216-002(LF)
1572173-1	47457-000(LF)	356085-5	48245-000(LF)
1572173-2	47457-001(LF)	356085-6	48245-002(LF)
1572173-3	47457-002(LF)	356085-7	48046-000(LF)
1572173-4	48242-000(LF)	356085-8	48046-002(LF)
286512-9	47649-001(LF)	356085-9	47216-000(LF)
1-286512-0	47649-002(LF)	1-356085-0	47216-001(LF)
1-286512-1	48051-001(LF)	1-356085-1	48046-001(LF)
1-286512-2	48248-001(LF)	1-356085-2	75691-004
1572173-9	48242-001(LF)	1-356085-3	75691-005
1-1572173-0	48242-002(LF)	1-356085-4	75691-006

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.86+/-0.03 [.034+/-0.001]	8.8
24 AWG	0.84+/-0.03 [.033+/-0.001]	9.0
26 AWG	0.81+/-0.03 [.032+/-0.001]	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 50. 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.

***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.

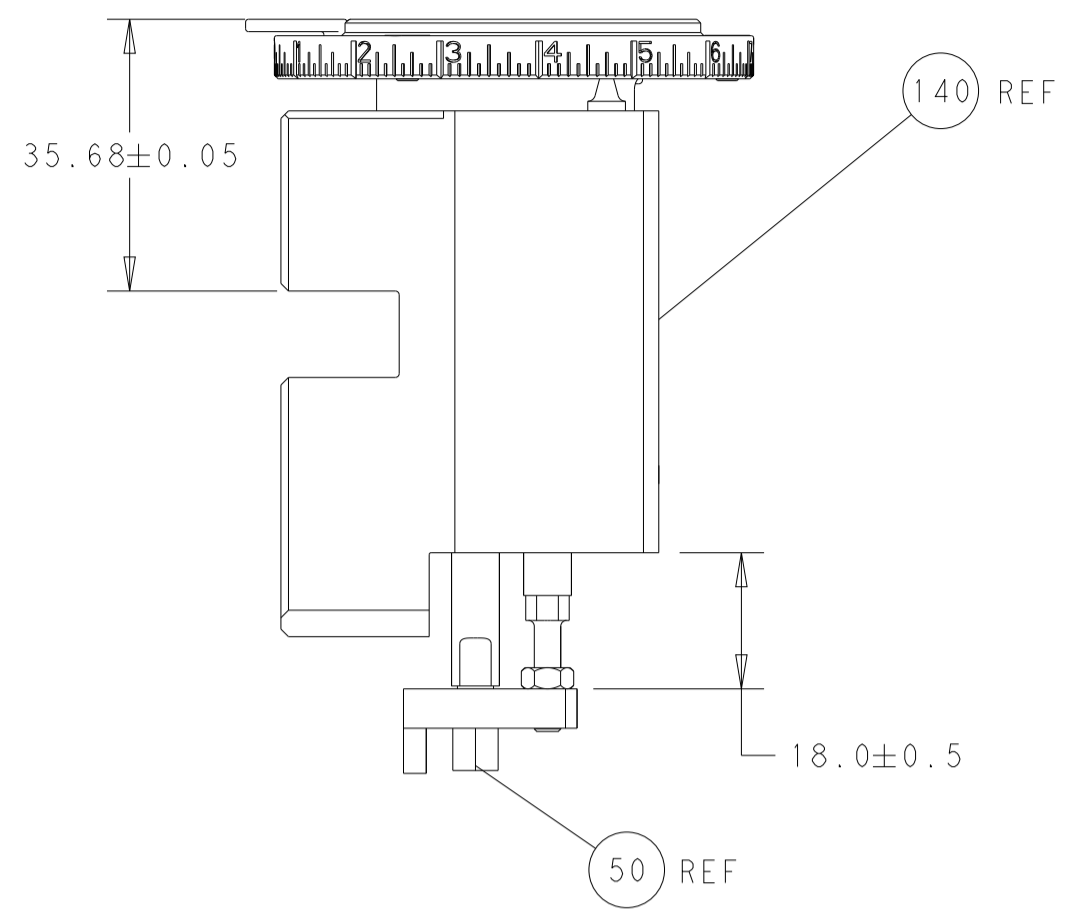
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	1	455888-1	SPACER, CRIMPER	82
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1-2119791-8	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	2119943-1	WASHER, SPACER	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2-1901681-8	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	2063961-1	FEED FINGER	51
-	1	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-2	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	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	4-1901696-9	STRIP GUIDE, REAR	19
-	1	1	5-1901695-0	STRIP GUIDE, FRONT	18
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2-240645-7	SPACER, SHEAR PLATE	10
-	1	1	1-240642-1	PLATE, FRONT SHEAR	9
1	1	1	1803042-3	ANVIL, COMBINATION	8
-	1	1	8-240651-6	BLADE, SLUG	7
-	1	1	3-240641-4	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	7-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	2
1	1	1	1803087-4	CRIMPER, WIRE	1

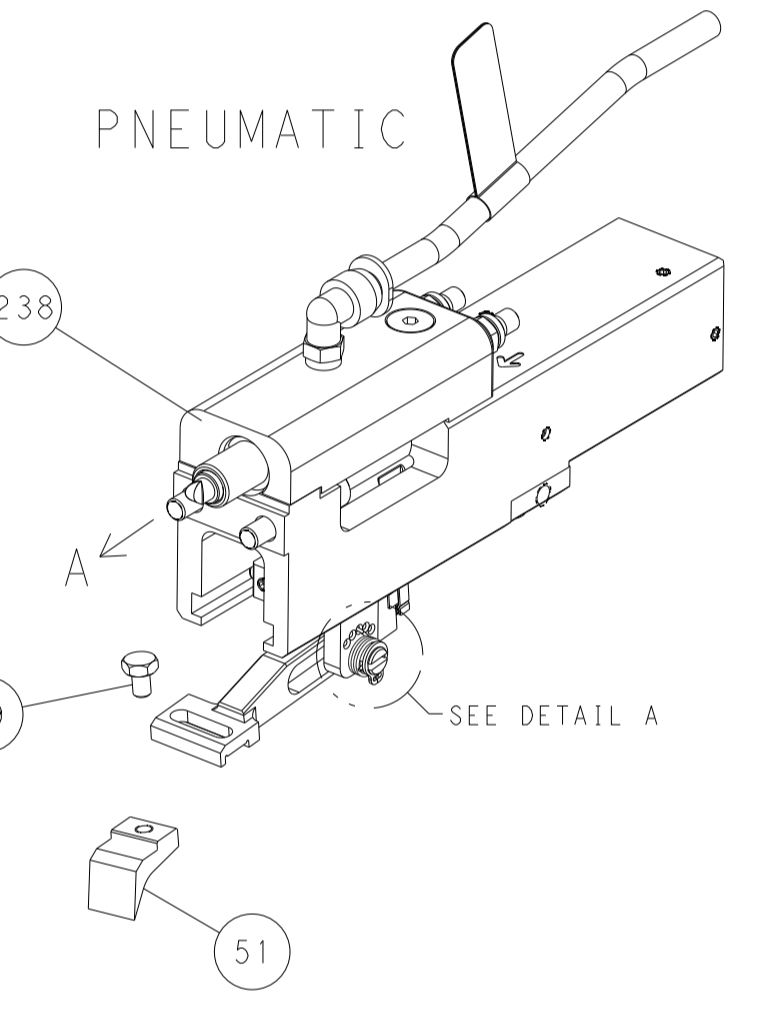
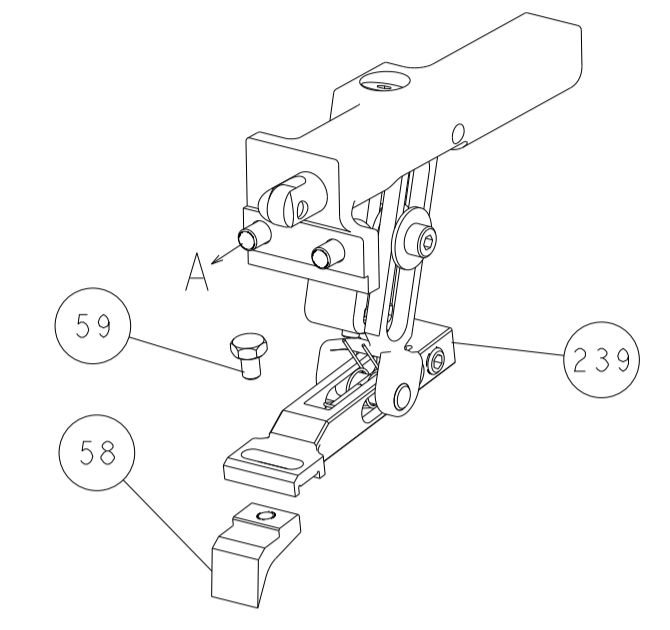
77-22-21	PART NO	DESCRIPTION	ITEM NO
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	±		
1 PLC	±		
2 PLC	±		
3 PLC	±		
4 PLC	±		
ANGLES	±		
FINISH			
MATERIAL			
DWN C. CHEN 20SEP2012		TE Connectivity Harrisburg, PA 17105-3608	
CHK S. XI 20SEP2012		NAME Ocean End Feed Applicator	
APVD J. CRUZ 20SEP2012		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
PRODUCT SPEC		A1 00779 ©=2150289	
APPLICATION SPEC		SCALE 1:1 SHEET 3 OF 4 REV 1	
WEIGHT		Customer Accessible Production Drawing	

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

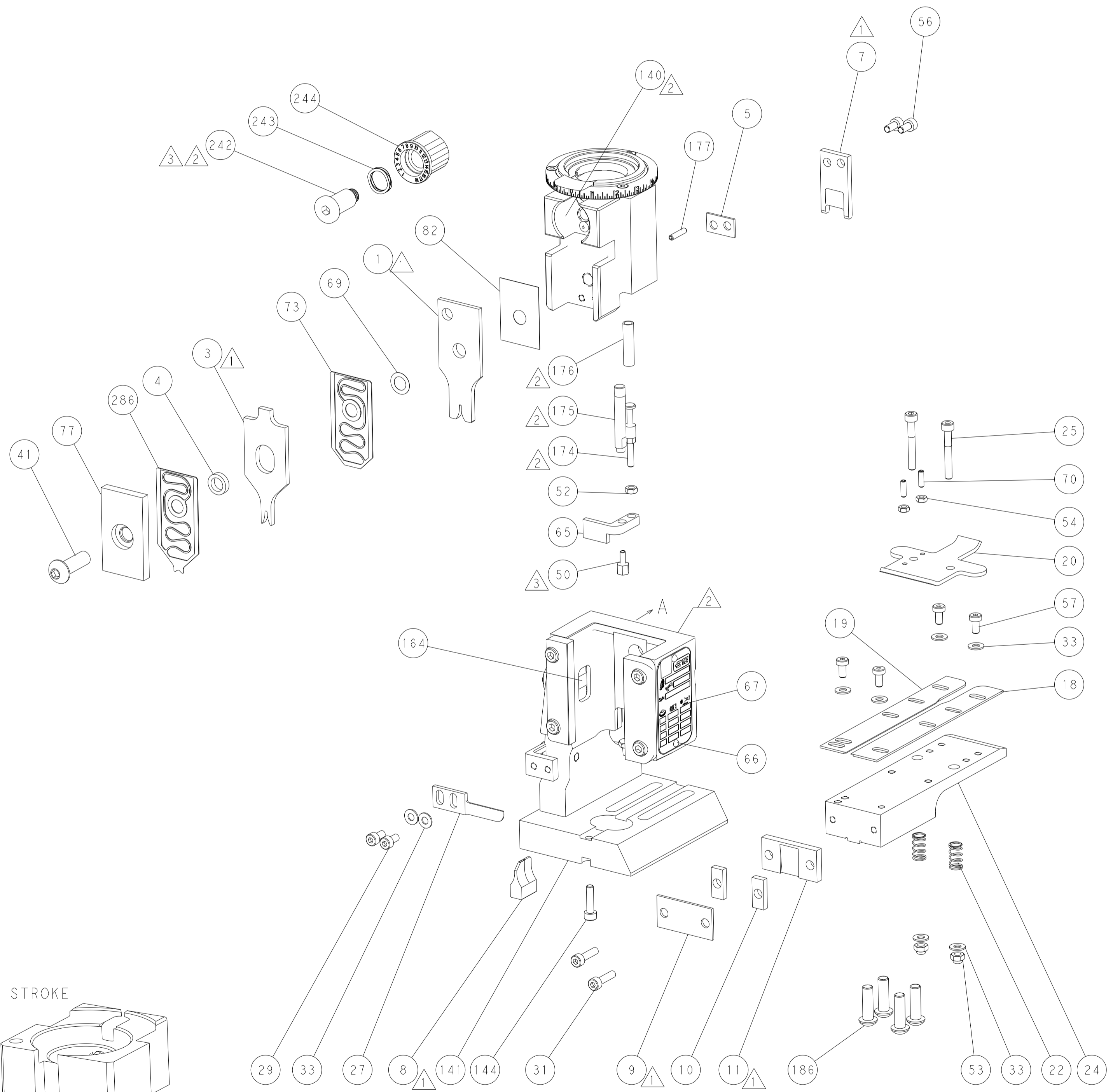
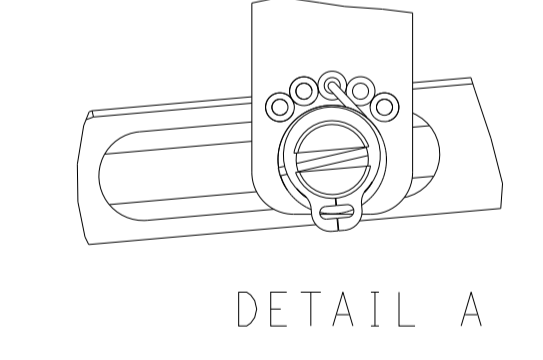


RAM AND HOLDDOWN SET-UP

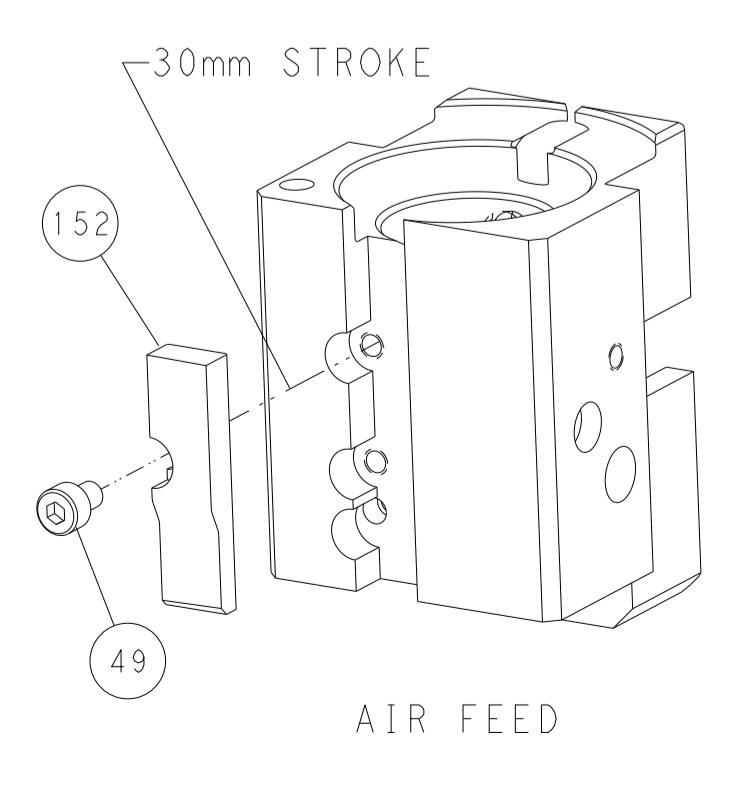
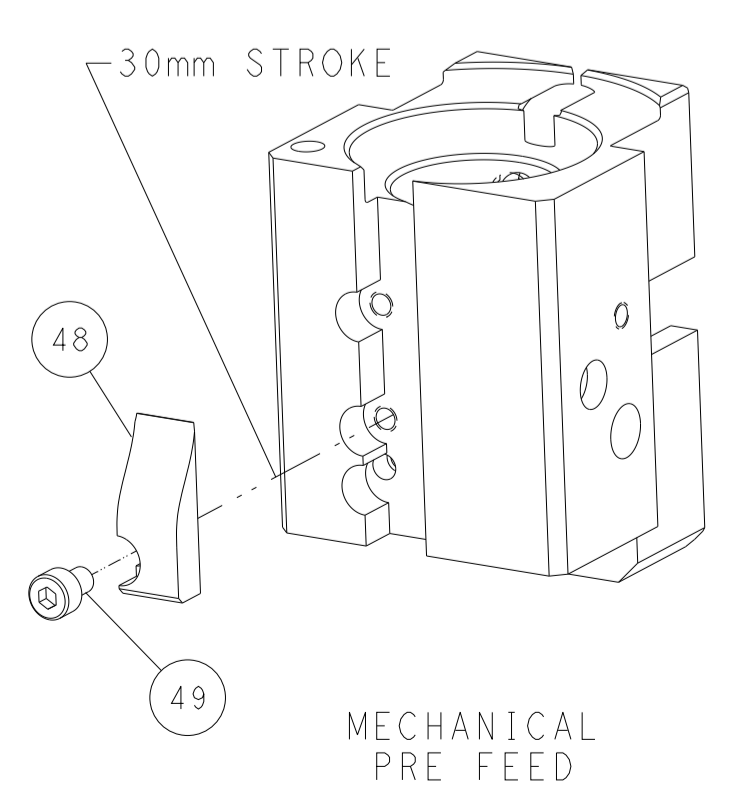
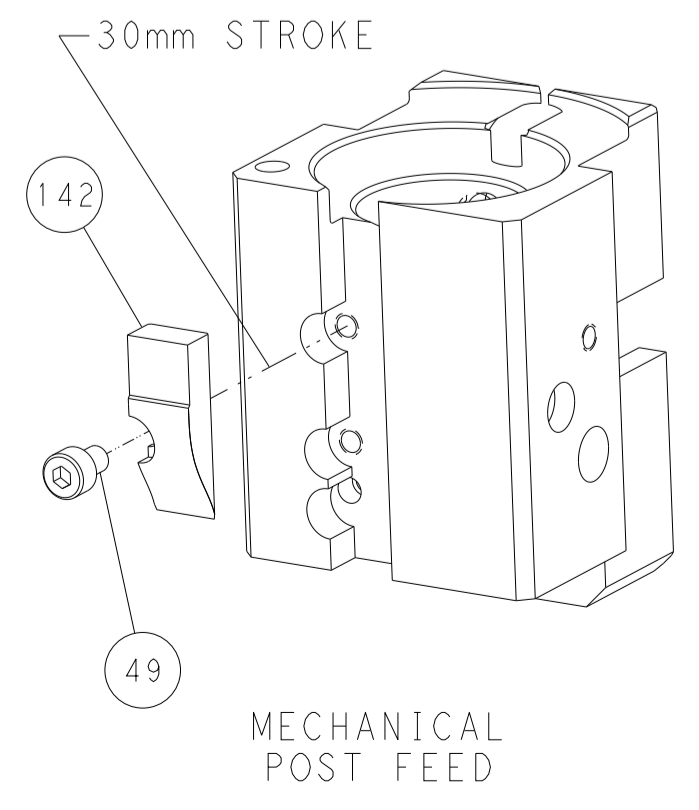
FEED TYPE
MECHANICAL



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN CHK: S. XI APVD: J. CRUZ	20SEP2012 20SEP2012 20SEP2012	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150289	RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT:	SCALE: 1:1 SHEET: 4 of 4 REV: R1	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION