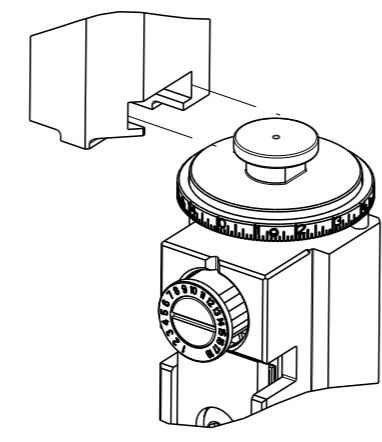


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150525-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150525-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150525-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150525-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150525-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	4.00 mm [.157]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: ESCUBEDO TERMINAL ESCUBEDO CRIMP SPECIFICATION			
TERMINAL NAME: HEMBRA SERIE 6.3			
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	INSULATION DIAMETER RANGE Ø3.00-4.30 mm [.118-.169 IN]		
TERMINAL APPLICATION SPECIFICATION (A)4422 Rev 1 (B)4327 Rev 1			
TERMINALS APPLIED			
TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
(A) 1572582-1	(A) 4422.00	(B) 1572582-7	(B) 4422.24
(A) 1572582-2	(A) 4422.02	(B) 1572582-8	(B) 4422.03
(A) 1572582-3	(A) 4422.10	(B) 1572582-9	(B) 4327.00
(A) 1572582-4	(A) 4422.12	(B) 1-1572582-0	(B) 4327.02
(A) 1572582-5	(A) 4422.30	(B) 1-1572572-1	(B) 4327.30
(A) 1572582-6	(A) 4422.32	(B) 1-1572582-2	(B) 4327.32

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.90 +/- 0.03 [.075 +/- .001]	4.4
2.00mm2	1.80 +/- 0.03 [.071 +/- .001]	5.4
1.50mm2	1.70 +/- 0.03 [.067 +/- .001]	6.4
1.00mm2	1.55 +/- 0.03 [.061 +/- .001]	8.1

- 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 ITEMS 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.

***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.

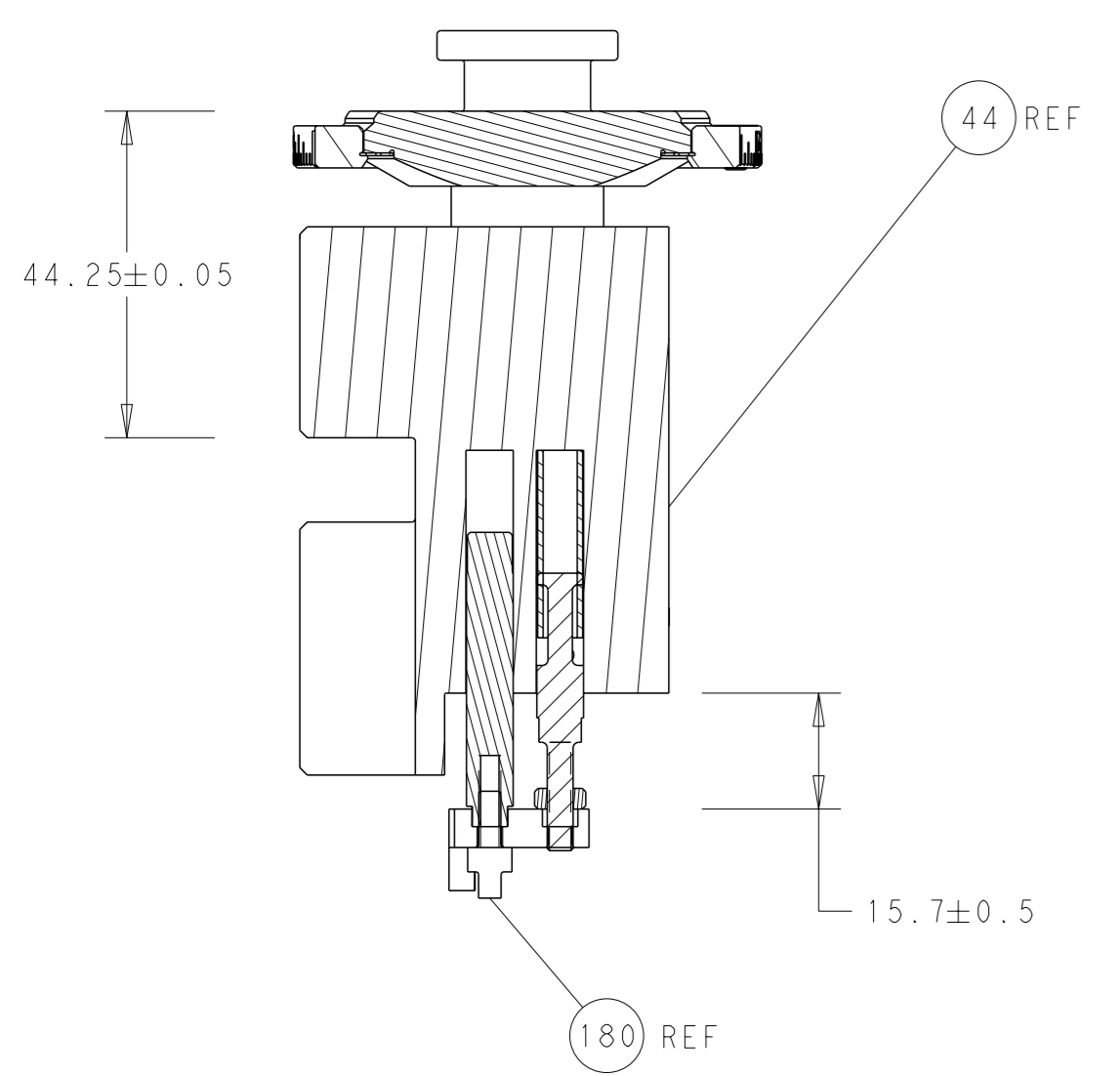
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	17FEB2015	RK	GB
		B		ECR-20-004282	23MAR2020	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	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	1-1976055-2	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	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	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	1901681-4	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	3	3	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	-	2063961-1	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	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	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	3-240641-6	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	-	-	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	-	-	690482-3	PLATE, FRONT SHEAR	9	
1	2	2	1	1	8-1633384-4	ANVIL, COMBINATION	8	
1	-	1	-	-	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	5-1803017-7	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	2	2	1	1	6-1633609-3	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

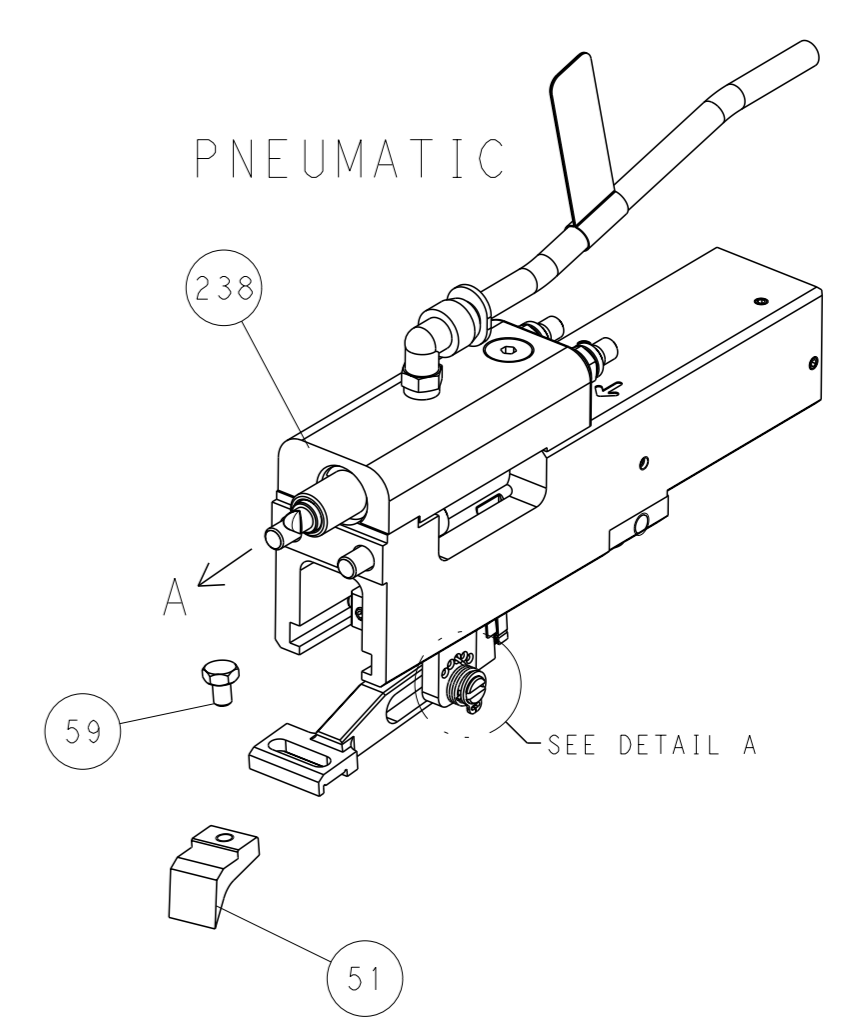
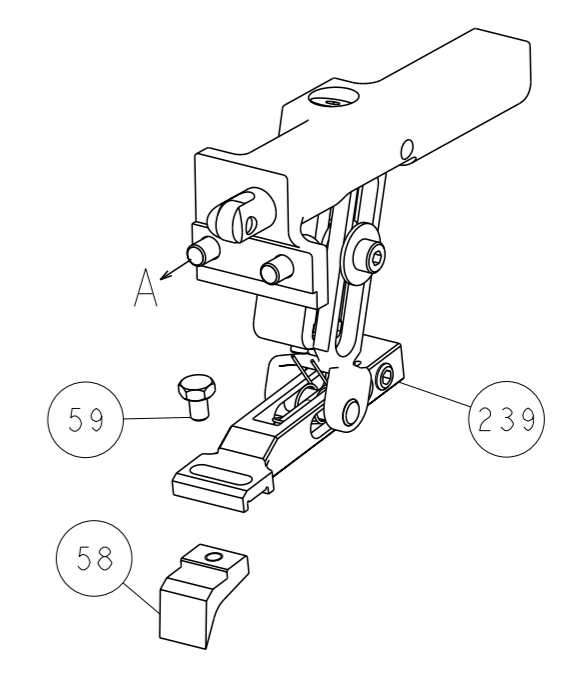
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN J. HOU 16 JAN 2015		TE Connectivity	
mm		0 PLC ±		CHK L. ZHANG 16 JAN 2015		Harrisburg, PA 17105-3608	
1 PLC ±		2 PLC ±		APVD U. GUO 16 JAN 2015		NAME	
3 PLC ±		4 PLC ±		PRODUCT SPEC		Ocean End Feed	
5 PLC ±		FINISH		APPLICATION SPEC		Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
-		-		A1 00779 C=2150525		-	
-		-		Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 of 4 REV B	

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

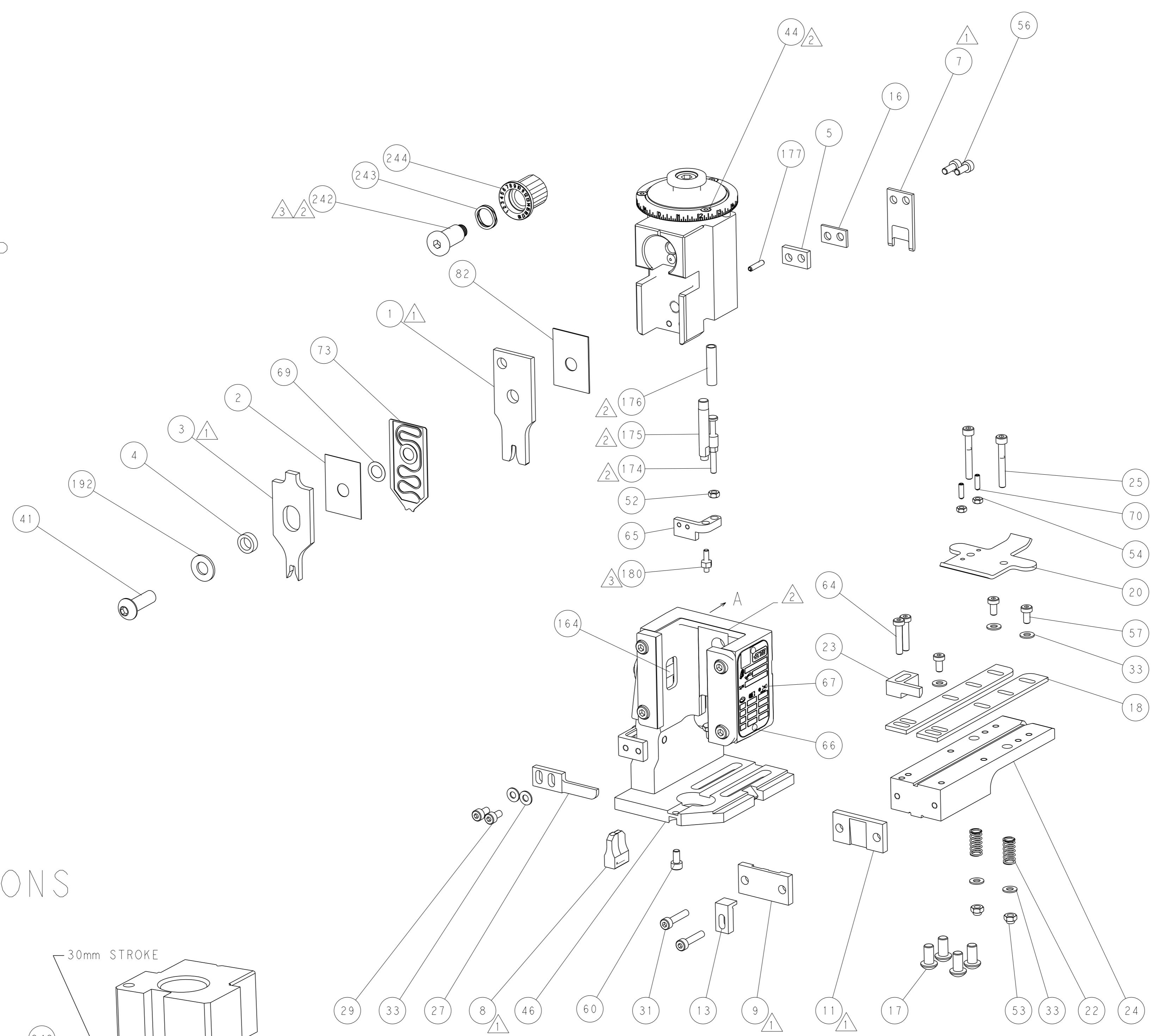
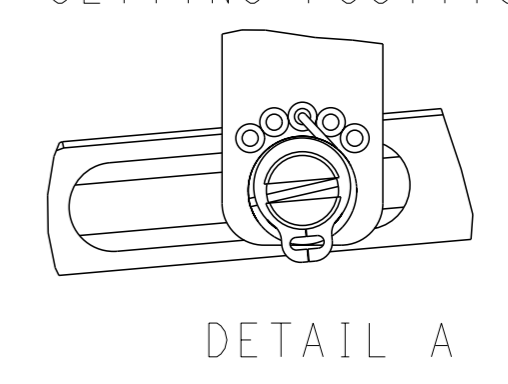


RAM AND HOLDDOWN SET-UP

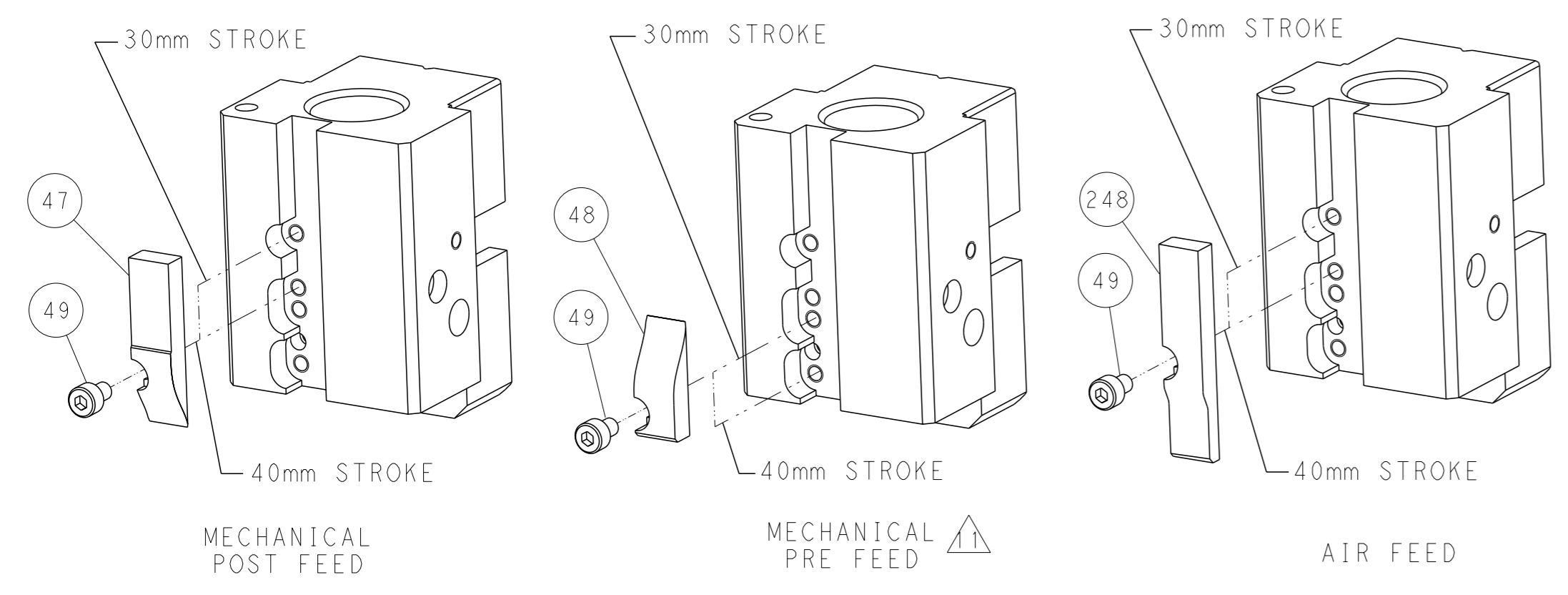
FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION



CAM POSITIONS

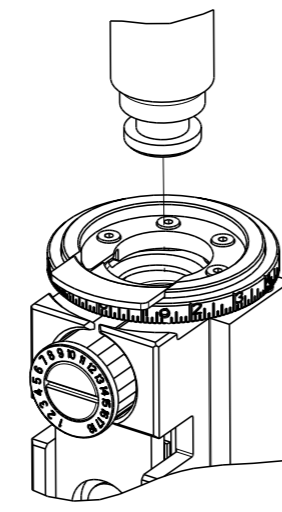


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		OWN: J. HOU 16 JAN 2015 CHK: L. ZHANG 16 JAN 2015 APVD: H. GUO 16 JAN 2015 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150525 SHEET 2 OF 4 REV B	TE Connectivity Harrisburg, PA 17105-3608
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150525-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150525-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150525-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	4.00 mm [.157]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: ESCUBEDO TERMINA/ESCUBEDO CRIMP SPECIFICATION

TERMINAL NAME: HEMBRA SERIE 6.3	
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	INSULATION DIAMETER RANGE Ø3.00-4.30 mm [.118-.169 IN]
TERMINAL APPLICATION SPECIFICATION (A)4422 Rev 1	-
(B)4327 Rev 1	-

TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
(A) 1572582-1	(A) 4422.00	(B) 1572582-7	(B) 4422.24
(A) 1572582-2	(A) 4422.02	(B) 1572582-8	(B) 4422.03
(A) 1572582-3	(A) 4422.10	(B) 1572582-9	(B) 4327.00
(A) 1572582-4	(A) 4422.12	(B) 1-1572582-0	(B) 4327.02
(A) 1572582-5	(A) 4422.30	(B) 1-1572572-1	(B) 4327.30
(A) 1572582-6	(A) 4422.32	(B) 1-1572582-2	(B) 4327.32

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm ²	1.90 +/- 0.03 [.075 +/- .001]	4.4
2.00mm ²	1.80 +/- 0.03 [.071 +/- .001]	5.4
1.50mm ²	1.70 +/- 0.03 [.067 +/- .001]	6.4
1.00mm ²	1.55 +/- 0.03 [.061 +/- .001]	8.1

- 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 ITEMS 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.
- 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.

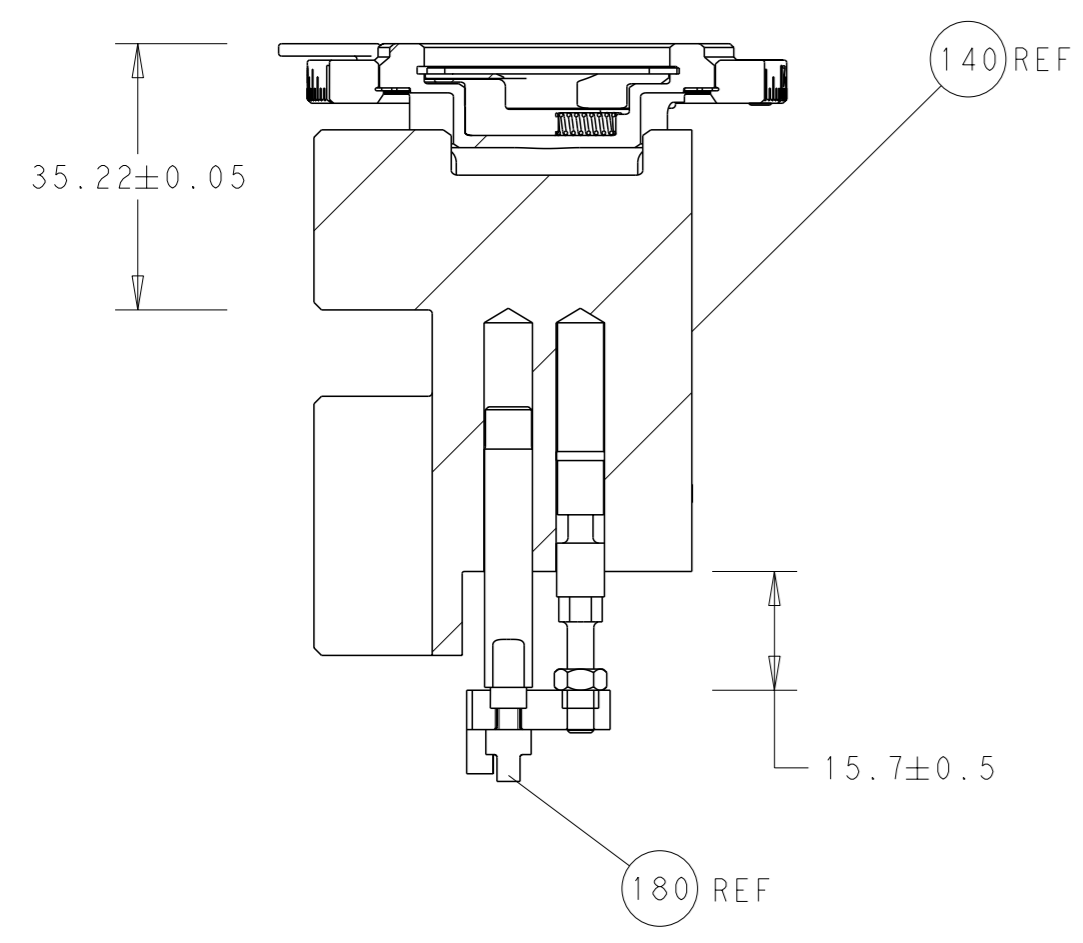
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-2	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
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	1-1976055-2	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
-	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	455888-6	SPACER, CRIMPER	82
-	1	1	2119791-9	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	1901681-4	HOLDDOWN, TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	3	3	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	-	2063961-1	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
-	7	7	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	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	3-240641-6	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	8-1633384-4	ANVIL, COMBINATION	8
-	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-1	SPACER	5
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	5-1803017-7	CRIMPER, INSULATION F	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	6-1633609-3	CRIMPER, WIRE	1

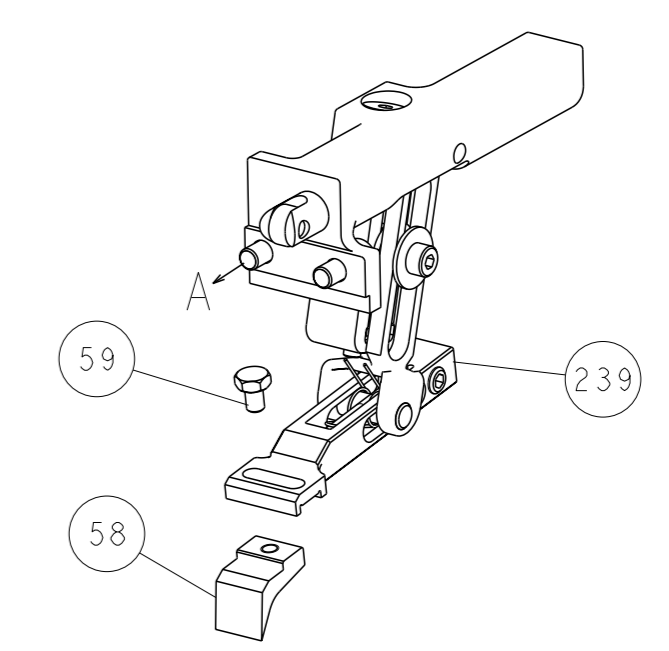
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	OWN	16 JAN 2015	J. HOU	TE Connectivity
	ANGLES FINISH					CHK	16 JAN 2015	L. ZHANG	Harrisburg, PA 17105-3608
						APVD	16 JAN 2015	U. GUO	Ocean End Feed Applicator
						PRODUCT SPEC			
						APPLICATION SPEC			
						SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
						WEIGHT	A1	00779 ©=2150525	

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

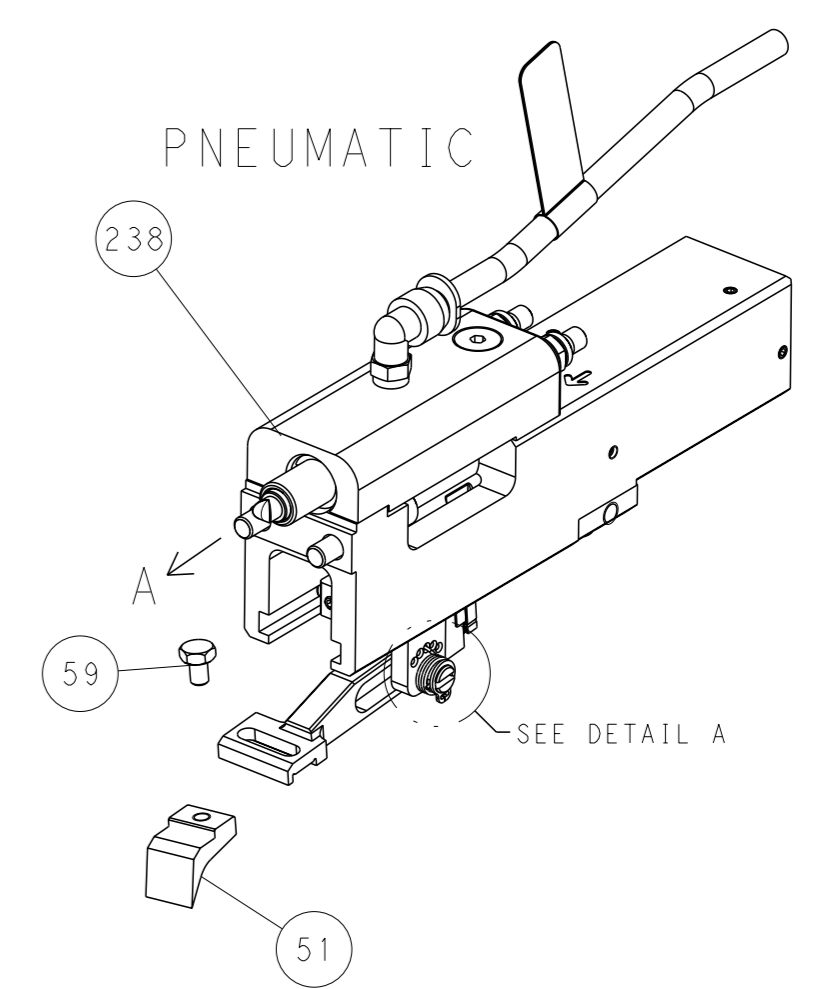


RAM AND HOLDDOWN SET-UP

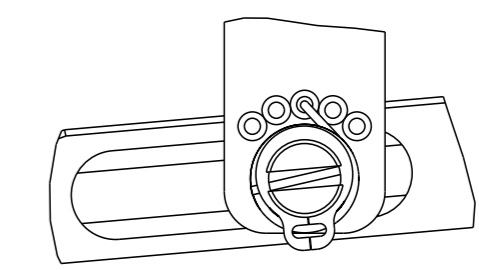
FEED TYPE
MECHANICAL



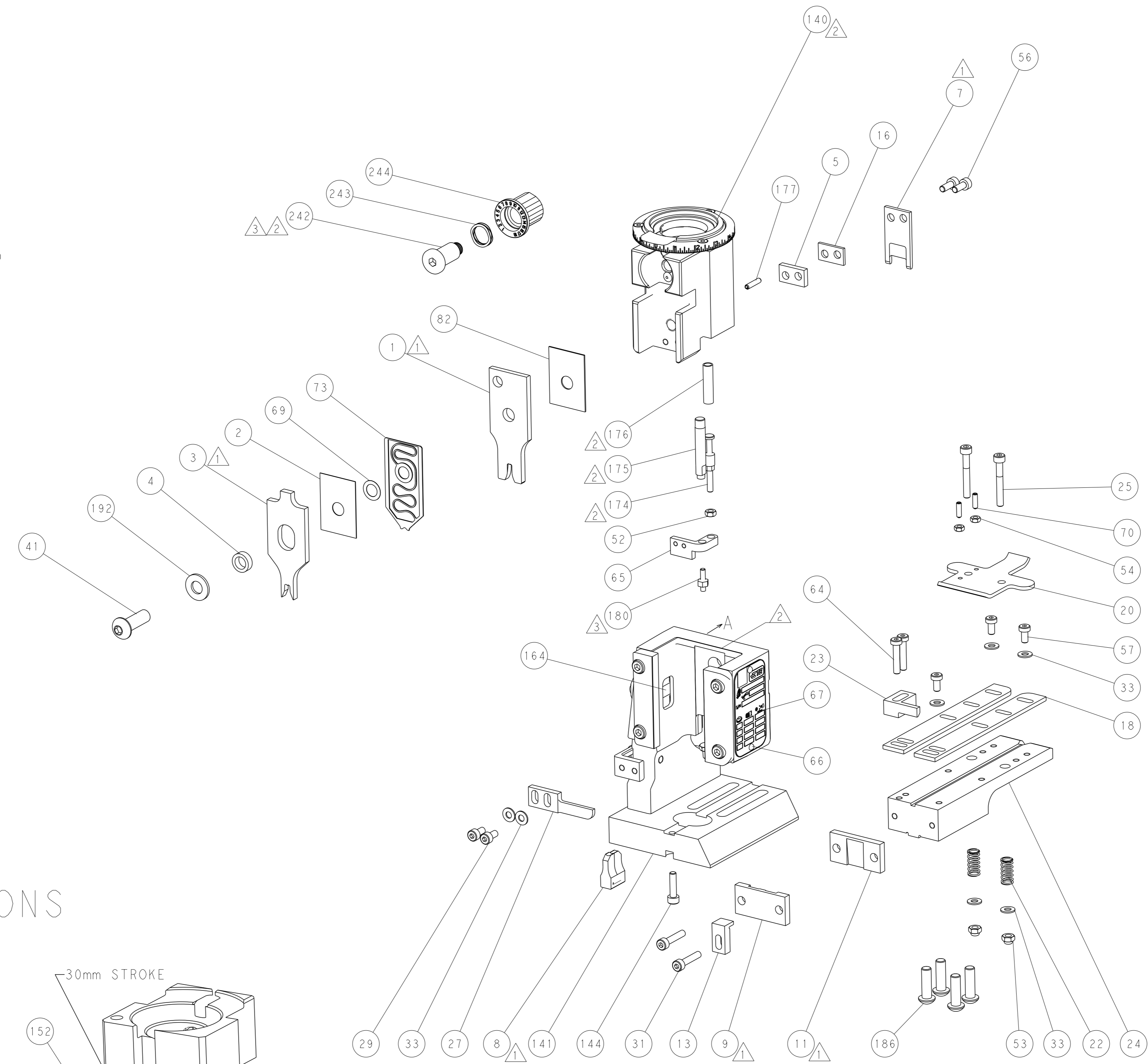
PNEUMATIC



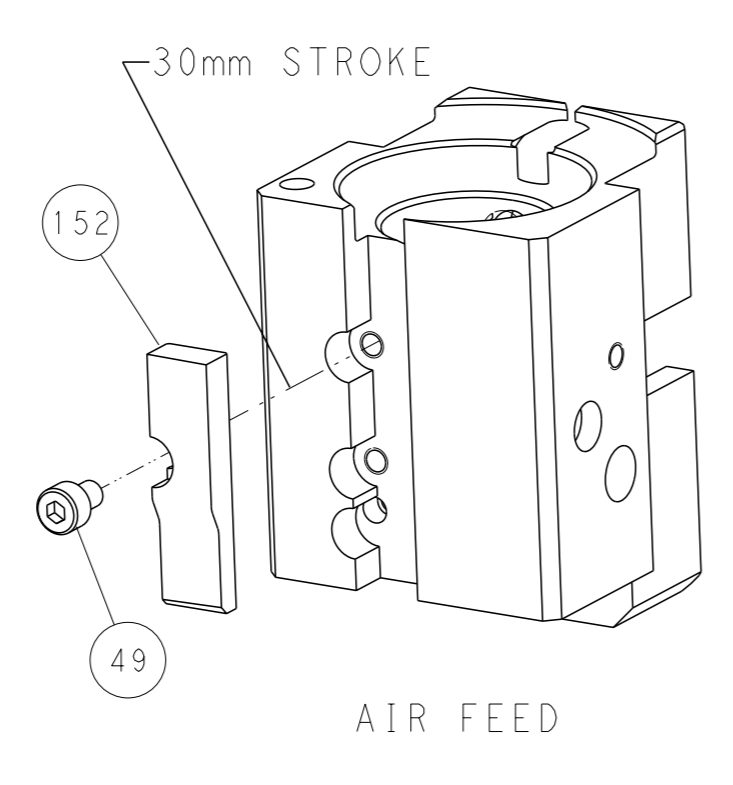
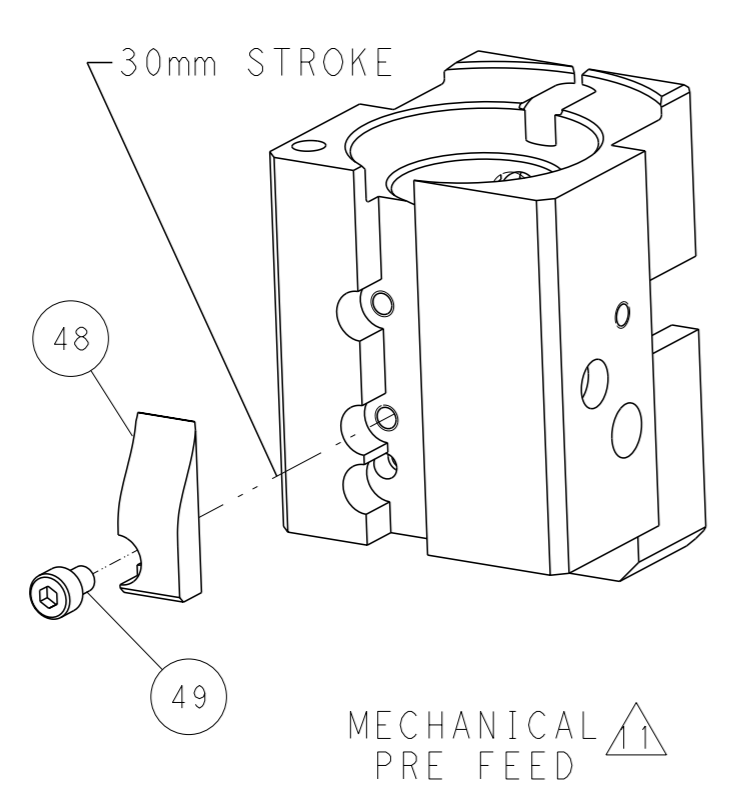
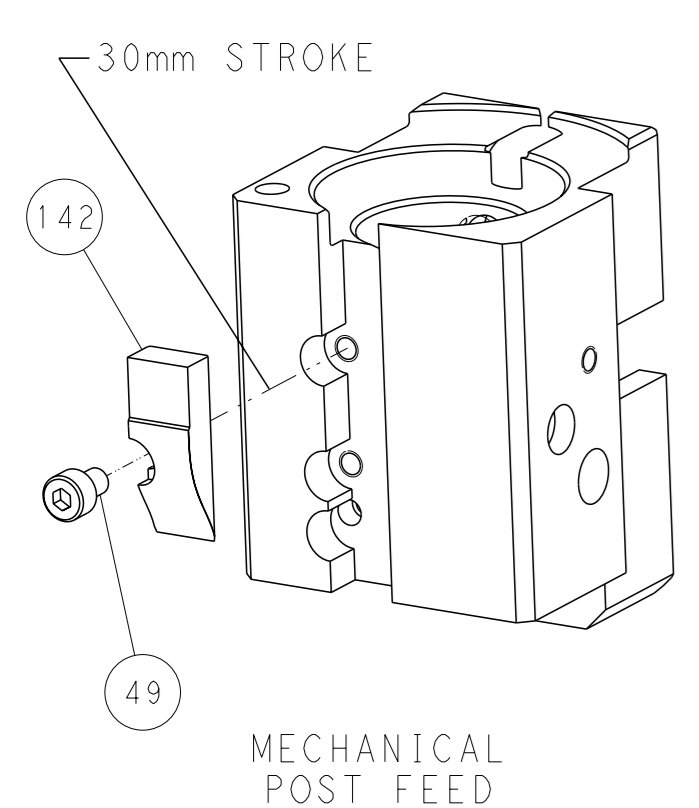
FEED SPRING
SETTING POSITION



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	J. HOU	16 JAN 2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK	L. ZHANG	16 JAN 2015	
	1 PLC	±		APVD	U. GUO	16 JAN 2015	NAME
	2 PLC	±		PRODUCT SPEC			Ocean End Feed
	3 PLC	±		APPLICATION SPEC			Applicator
	4 PLC	±		MATERIAL			SIZE
	ANGLES	±	*	WEIGHT			CAGE CODE
	FINISH			Customer Accessible Production Drawing			DRAWING NO.
			SCALE	1:1		SHEET	4 of 4
			REV	B		RESTRICTED TO	