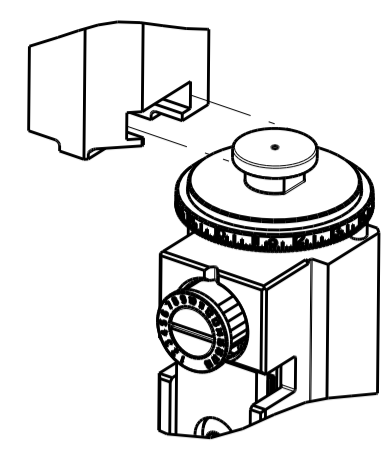


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150300-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150300-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150300-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.70 mm [.185]	F
INSUL	5.50 mm [.217]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: RING TYPE CONNECT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.20-6.80 mm [.244-.268 IN]		∅3.80-5.10 mm [1.150-.201 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR SPEC	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572446-1	25233.331.011	1572446-6	25233.123.011
1572446-2	25233.331.322	1572446-7	25233.123.322
1572446-3	25233.213.004	1572446-8	25233.123.009
1572446-4	25233.213.320	1572446-9	25233.212.179
1572446-5	25233.123.014	1-1572446-0	25233.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10+0.1/-0.05 [.122+.004/-0.002]	8.1
4.00mm2	2.85+0.1/-0.05 [.112+.004/-0.002]	10.8

- 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.
- 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.

**\*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.

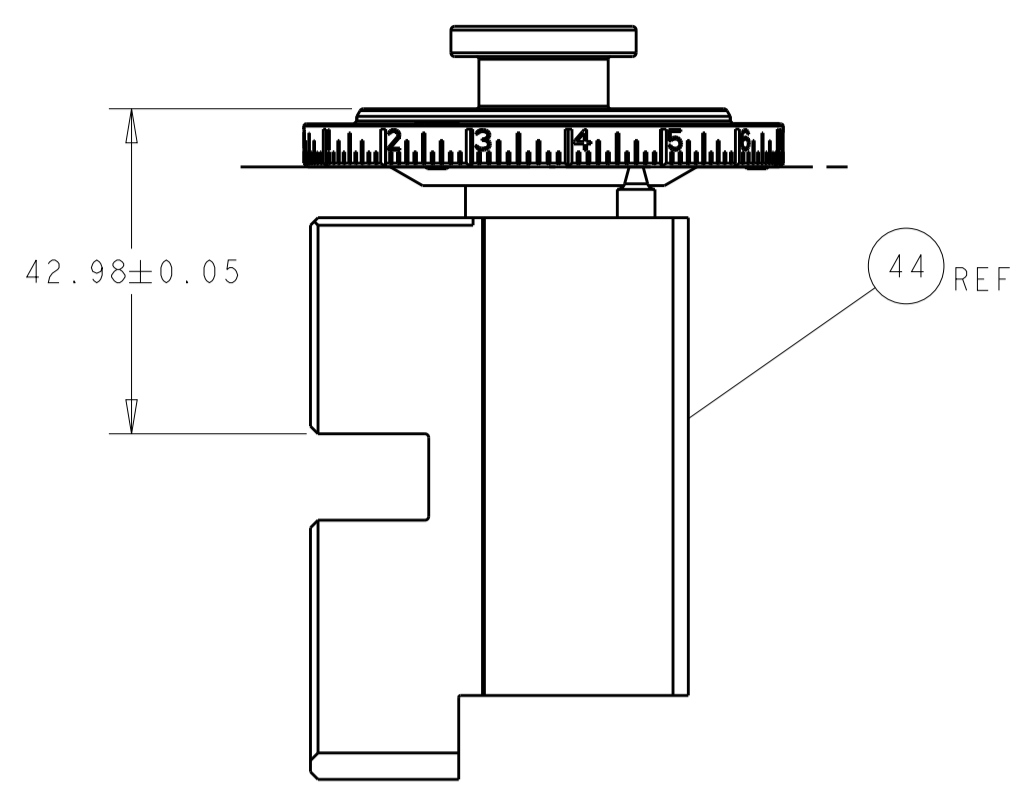
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66			RELEASED	12FEB2013	BW	GB
				ECR-20-010989	04AUG2020	FZ	TE

-	1	1	455888-3	SPACER, CRIMPER	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	2119791-5	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	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	2-240641-5	SPACER	16
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	2	1-1803000-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-7	SPACER	5
-	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	1-1633664-8	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

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

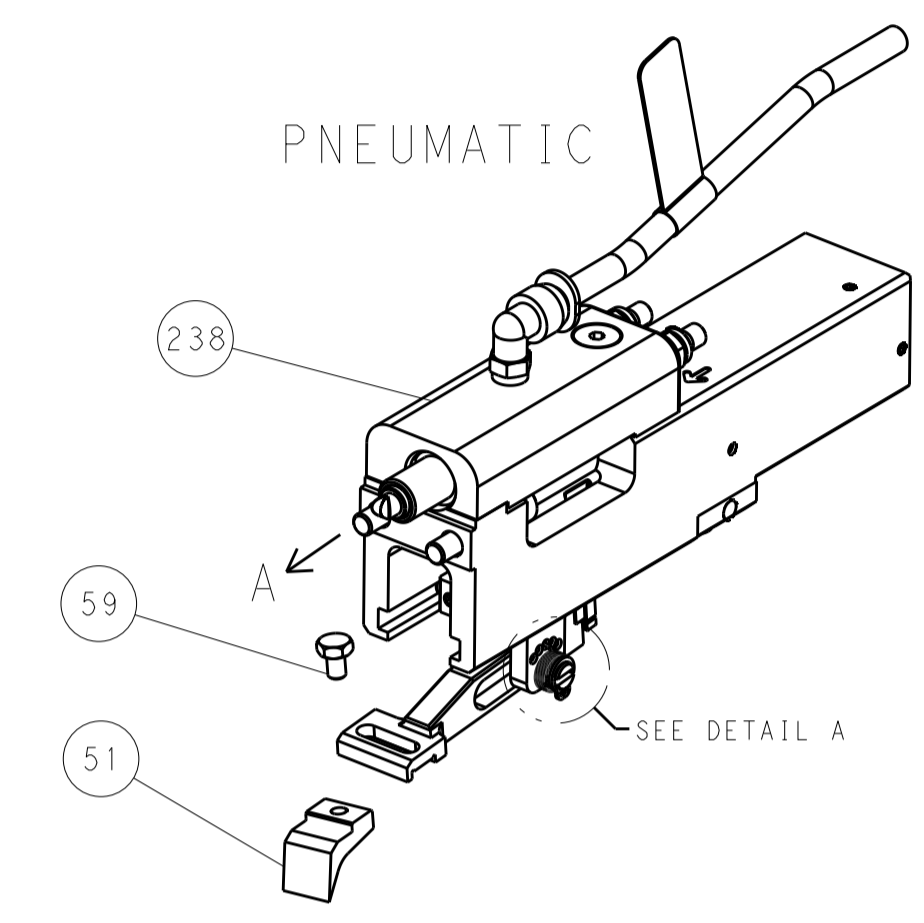
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: Y. YIN 05DEC2012		CHK: G. BAILEY 05DEC2012		APVD: S. XI 05DEC2012		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: B	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: B	

REVISONS		DATE	OWN	APVD
A	66	-	-	-
SEE SHEET 1				

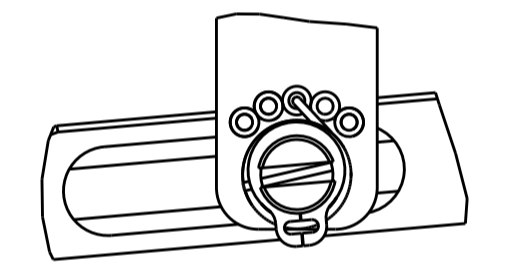


RAM SET-UP

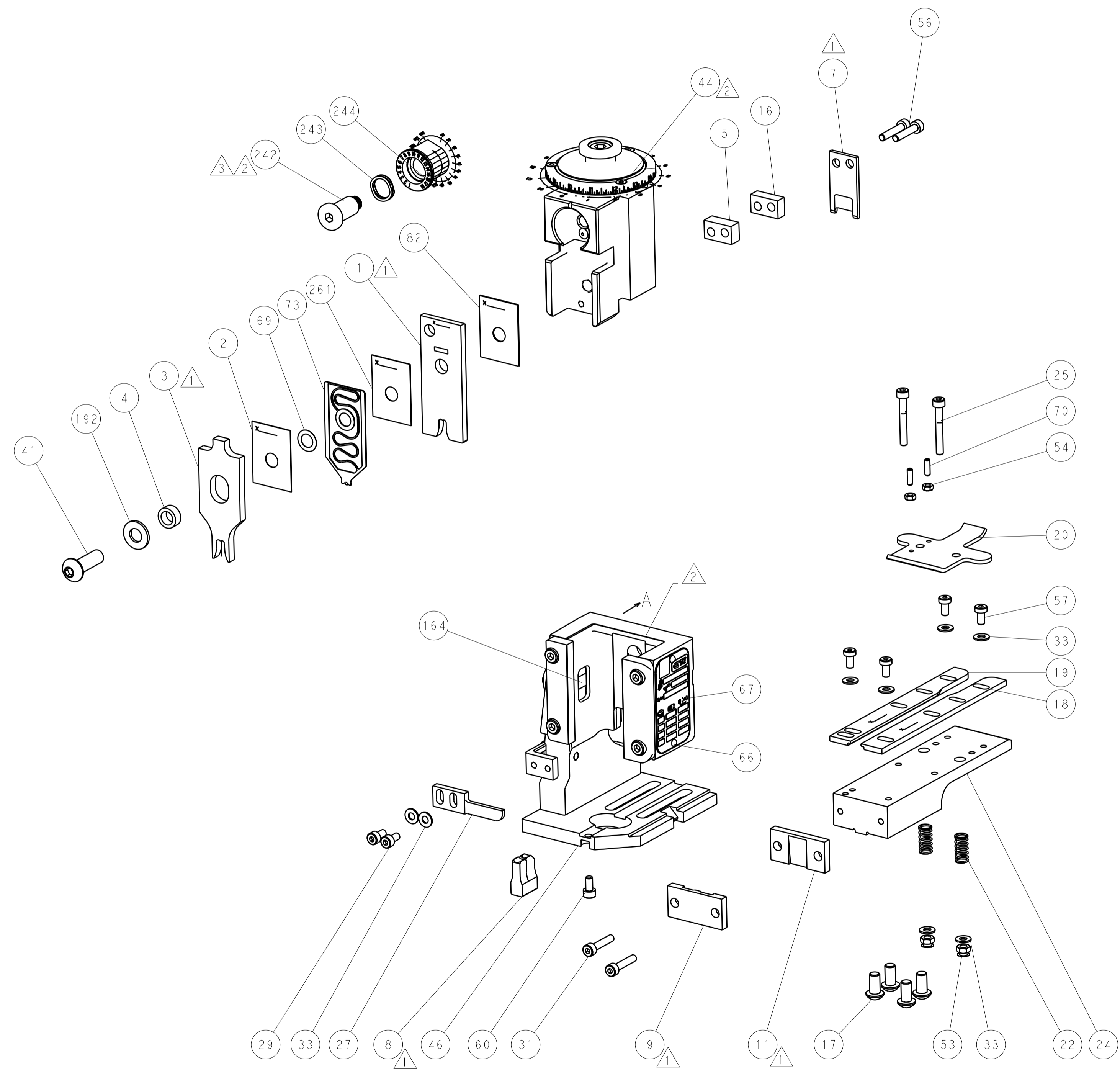
FEED TYPE



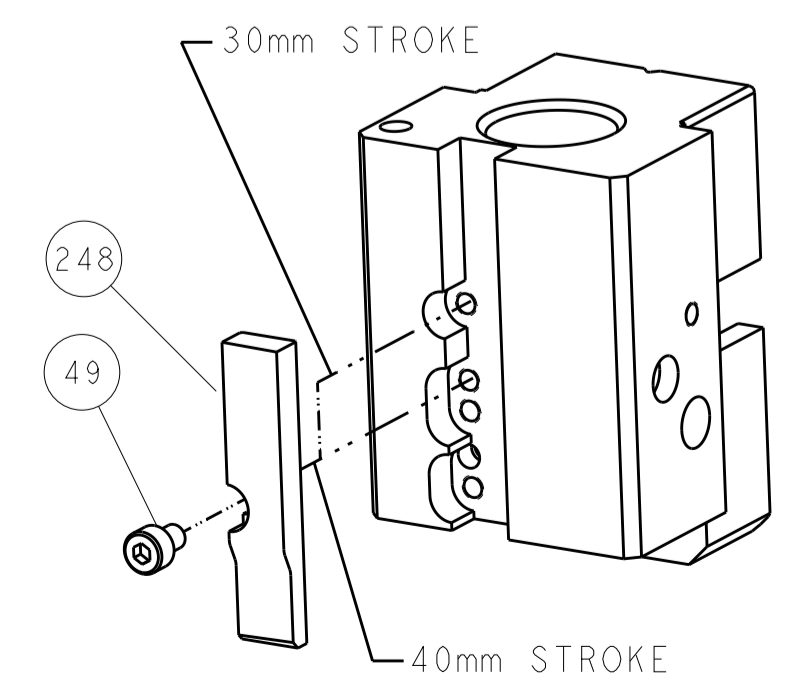
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION



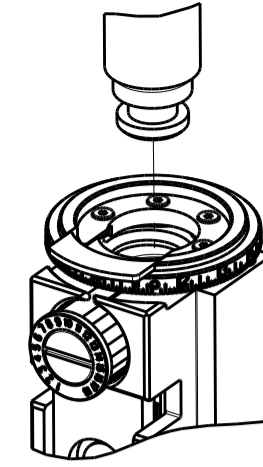
AIR FEED

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 05DEC2012		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 05DEC2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: S. XI 05DEC2012		NAME: Ocean End Feed Applicator	
FINISH:		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
MATERIAL:		3 PLC ±		APPLICATION SPEC:		RESTRICTED TO:	
		4 PLC ±		WEIGHT:		A1 00779 ©=2150300	
		ANGLES ±		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150300-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150300-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



CRIMP	SIZE	TYPE
WIRE	4.70 mm [ .185 ]	F
INSUL	5.50 mm [ .217 ]	F
APPLICATOR INSTRUCTIONS 408-35043		

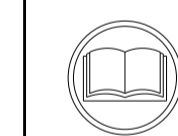
TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: RING TYPE CONNECT	
WIRE STRIP LENGTH 6.20-6.80 mm [ .244-.268 IN ]	INSULATION DIAMETER RANGE Ø3.80-5.10 mm [ .150-.201 IN ]
TERMINAL APPLICATION SPECIFICATION	LEAR SPEC

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572446-1	25233.331.011	1572446-6	25233.123.011
1572446-2	25233.331.322	1572446-7	25233.123.322
1572446-3	25233.213.004	1572446-8	25233.123.009
1572446-4	25233.213.320	1572446-9	25233.212.179
1572446-5	25233.123.014	1-1572446-0	25233.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10+0.17/-0.05 [ .122+.004/- .002 ]	8.1
4.00mm2	2.85+0.17/-0.05 [ .112+.004/- .002 ]	10.8



- 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.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

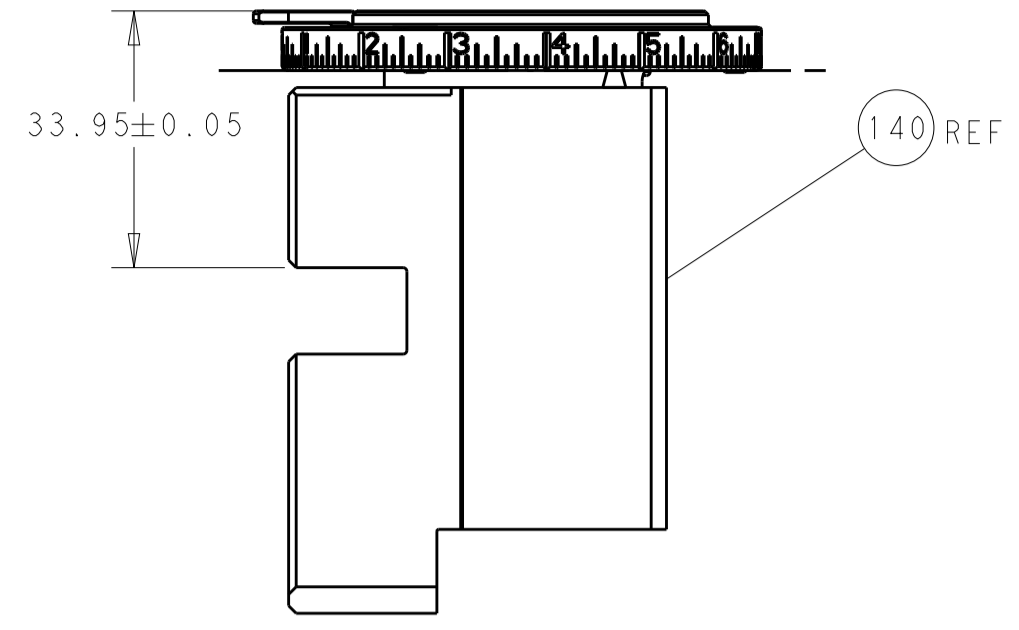
LOC	DIST	REV	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	455888-3	SPACER, CRIMPER	261
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	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	455888-6	SPACER, CRIMPER	82
-	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	2-240641-5	SPACER	16
1	-	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
1	-	690482-4	PLATE, FRONT SHEAR	9
1	1	2-1803000-4	ANVIL, COMBINATION, END FEED	8
1	-	1-2217206-2	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-7	SPACER	5
-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	6-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-3	SPACER, CRIMPER	2
1	1	4-1633664-8	CRIMPER, WIRE	1

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

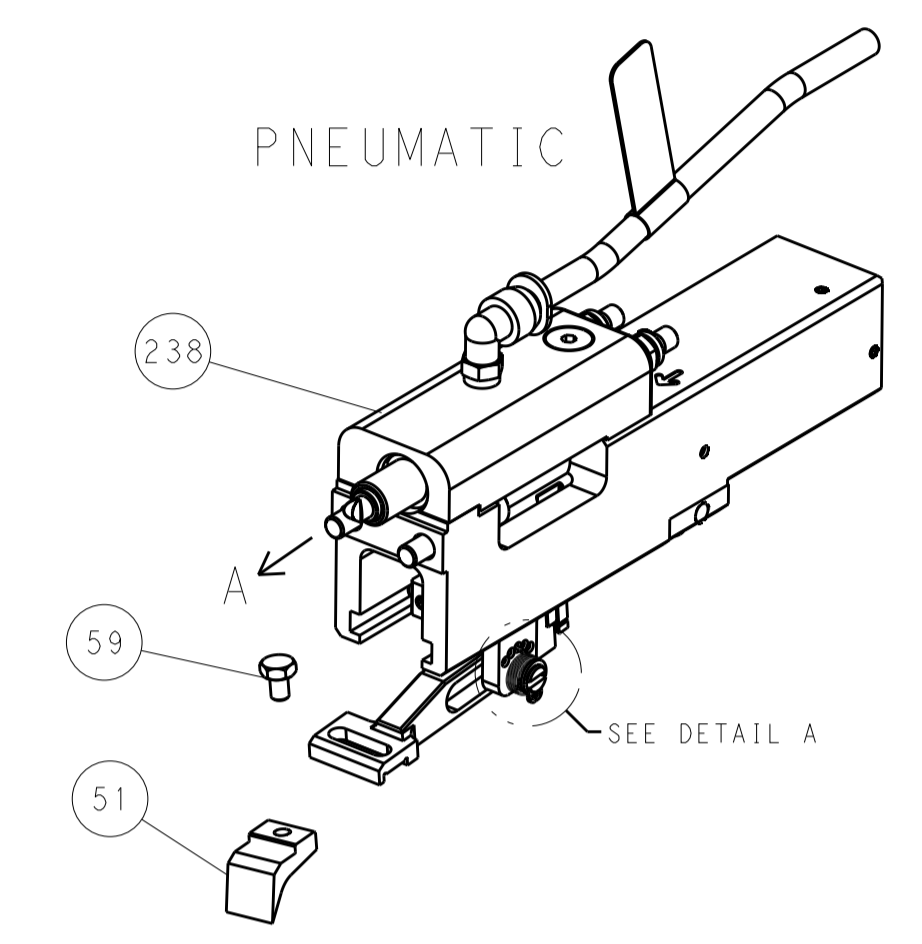
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 05DEC2012		CHK G. BAILEY 05DEC2012		APVD S. XI 05DEC2012		NAME	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		PRODUCT SPEC	
ANGLES		FINISH		WEIGHT		SCALE		SHEET		REV	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		1:1		3 OF 4		B	

LOC	DIST	REV	DATE	BY	APPV
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		2			
		3			
		4			
		5			
		6			
		7			
		8			

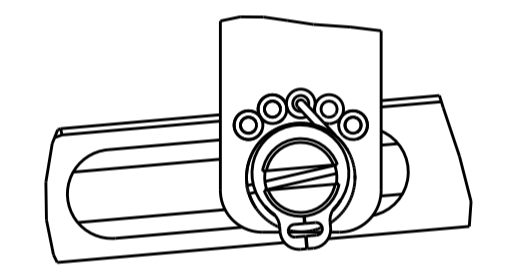


RAM SET-UP

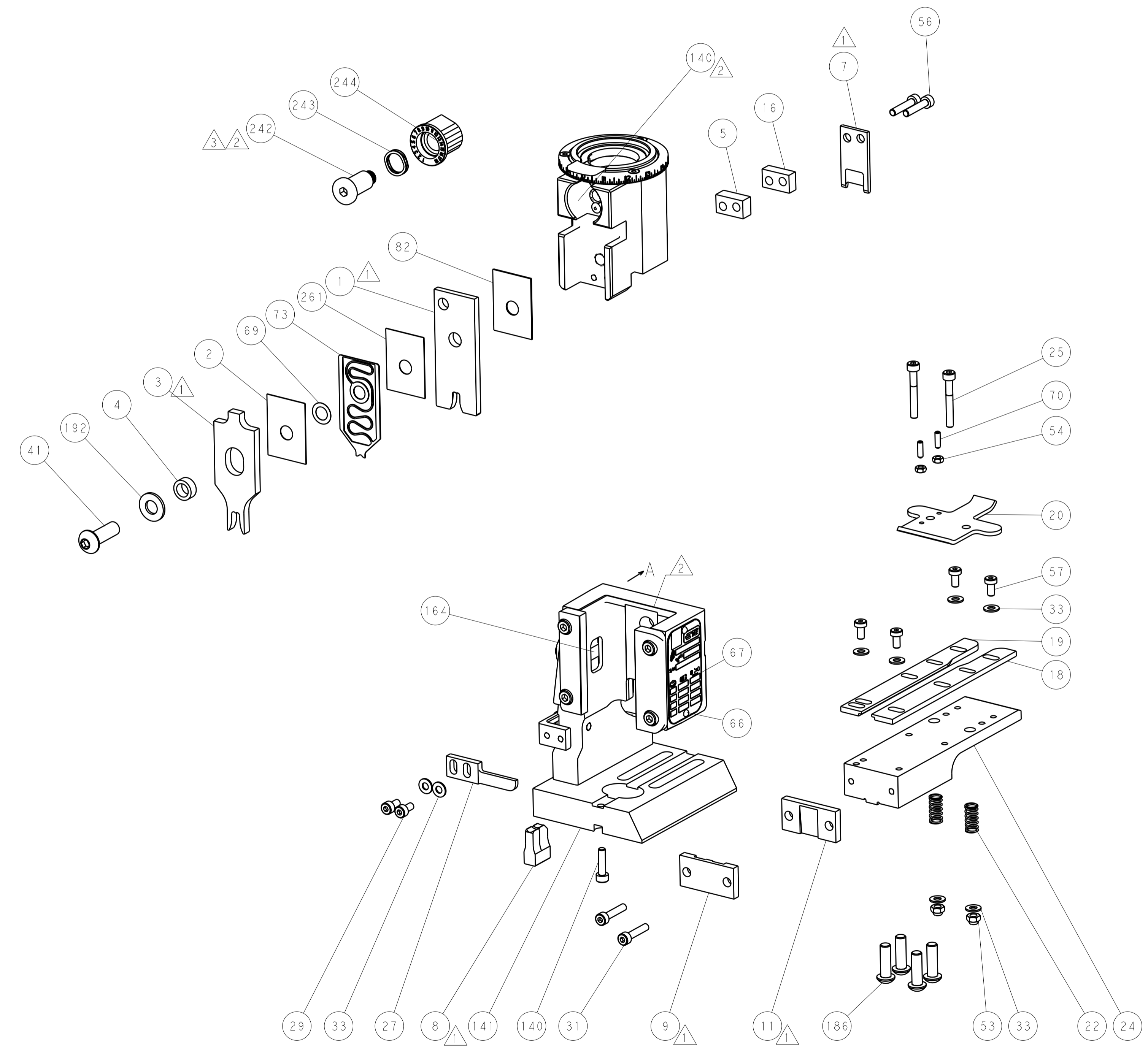
FEED TYPE



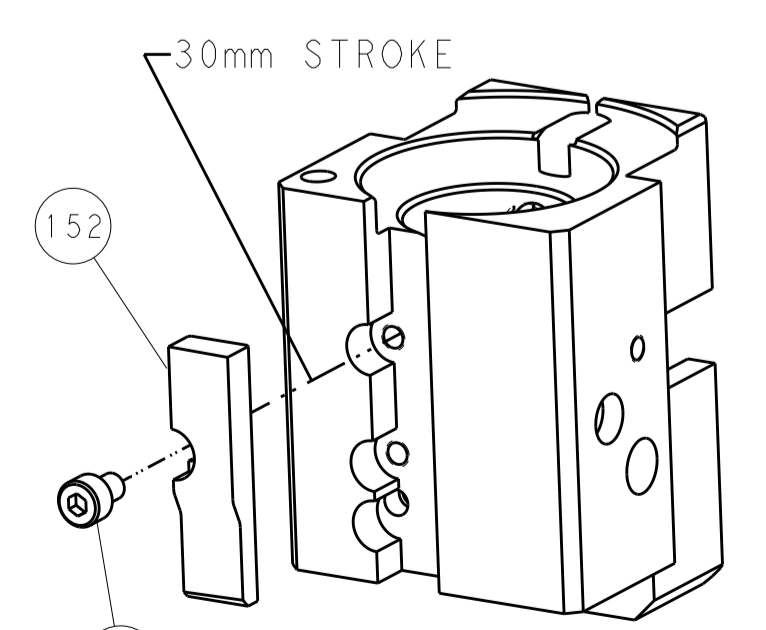
FEED SPRING SETTING POSITION



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 05DEC2012		STE TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 05DEC2012		Harrisburg, PA 17105-3608	
HOLE		1 PLC ±		S. XI 05DEC2012		NAME: Ocean End Feed Applicator	
MATERIAL:		2 PLC ±		APVD: S. XI 05DEC2012		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:	
		3 PLC ±		PRODUCT SPEC:		A1 00779 ©=2150300	
		4 PLC ±		APPLICATION SPEC:		WEIGHT: SCALE: 1:1 SHEET 4 OF 4 REV B	
		ANGLES ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		Customer Accessible Production Drawing	