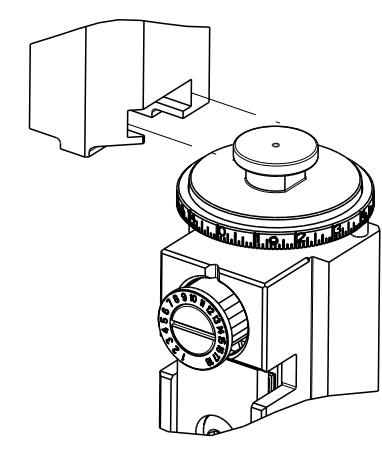


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150270-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150270-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150270-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.60 mm [.142]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL RING TOUNGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		∅1.50-3.30 mm [.059-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR SPEC Rev 10		
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572524-4	25201.XXX.YYY	1-1572631-2	25205.XXX.YYY
1572524-3	25203.XXX.YYY	1-1572631-3	25165.XXX.YYY

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	7.8
0.75mm2	1.85+/-0.05 [.073+/-0.002]	9.0
0.50mm2	1.75+/-0.05 [.069+/-0.002]	10.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. 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.

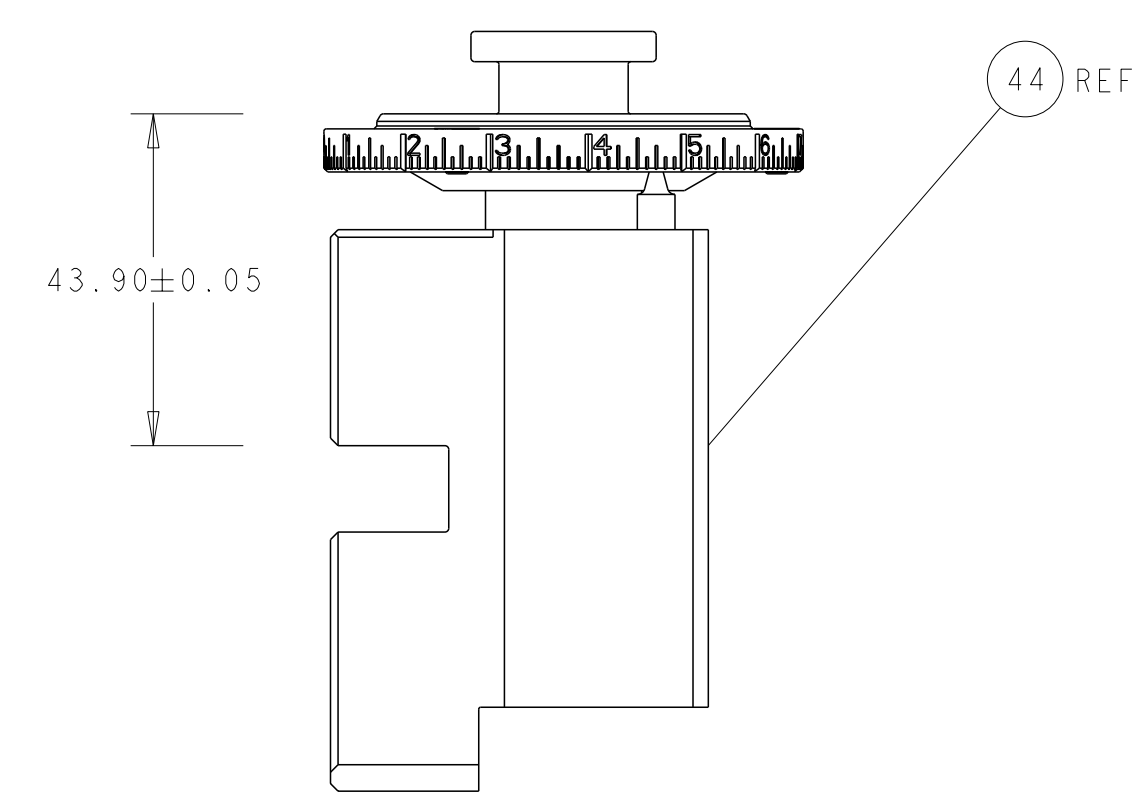
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-19-017897	25NOV2019	FJ	TE
		C		ECR-20-015368	28OCT2020	JWC	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	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	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	455888-5	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-2	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	2	1	4-1803000-1	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	2-240641-9	SPACER	5	
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	1	1803139-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	1	1-1633609-1	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

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

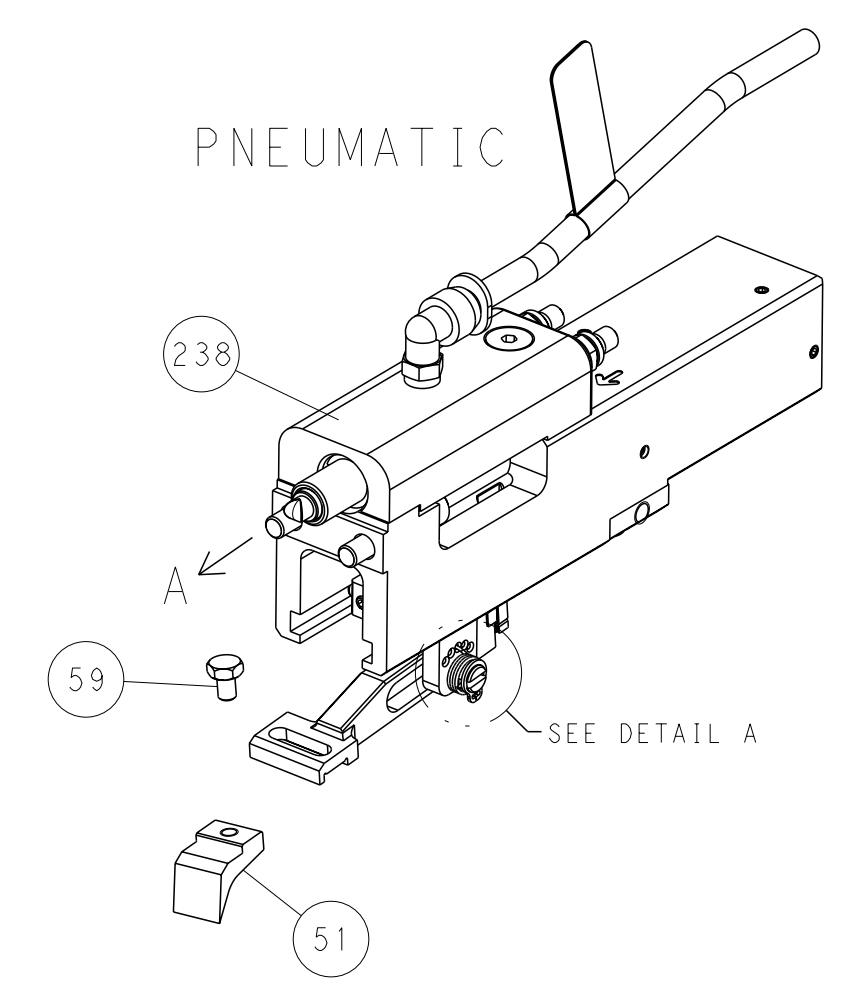
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	FINISH	★
MATERIAL							
Customer Accessible Production Drawing				SCALE	1:1	SHEET	1 of 4

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

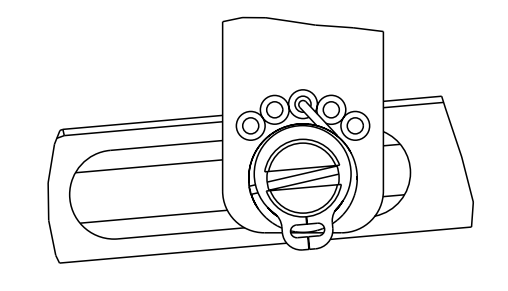


RAM SET-UP

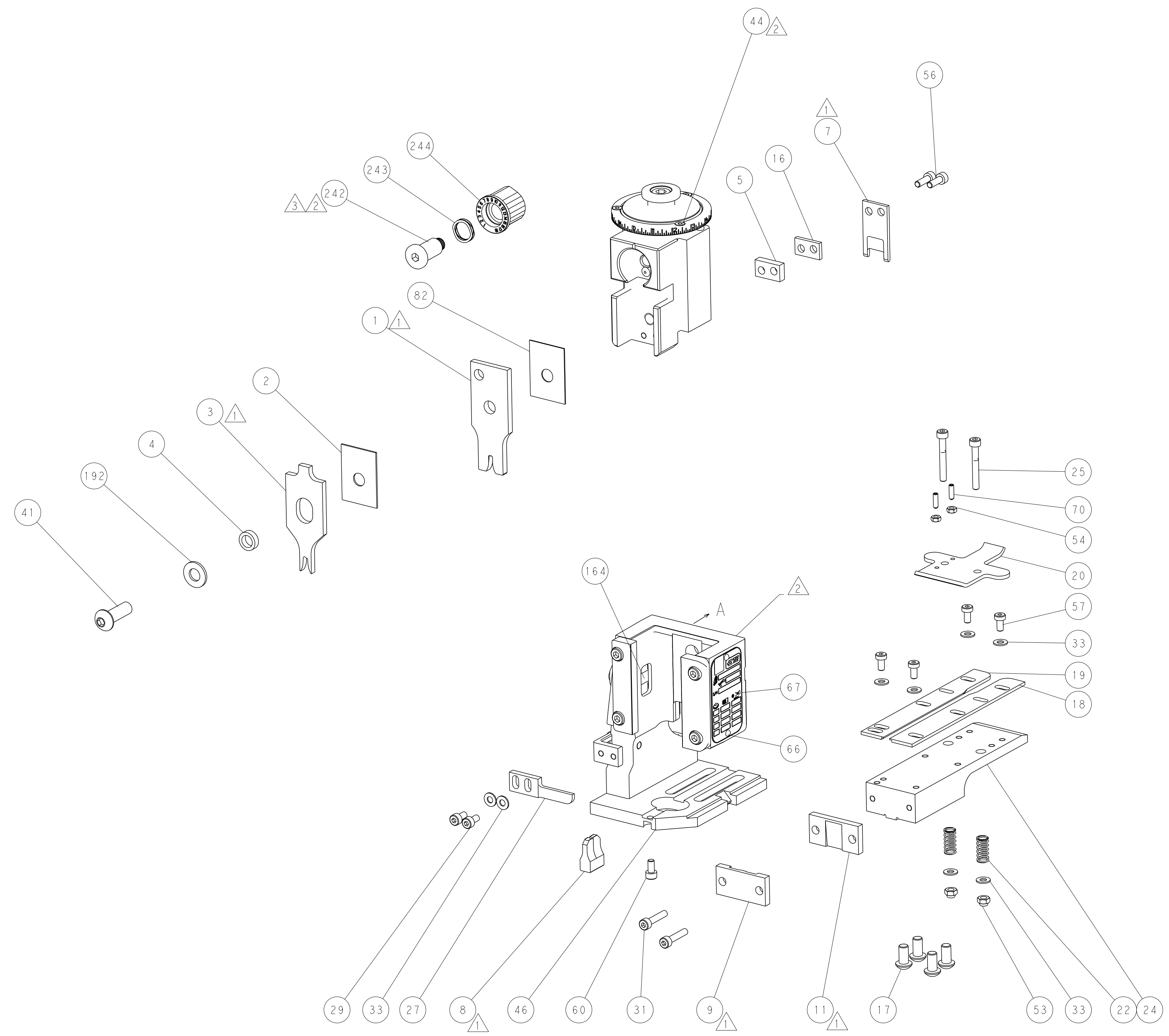
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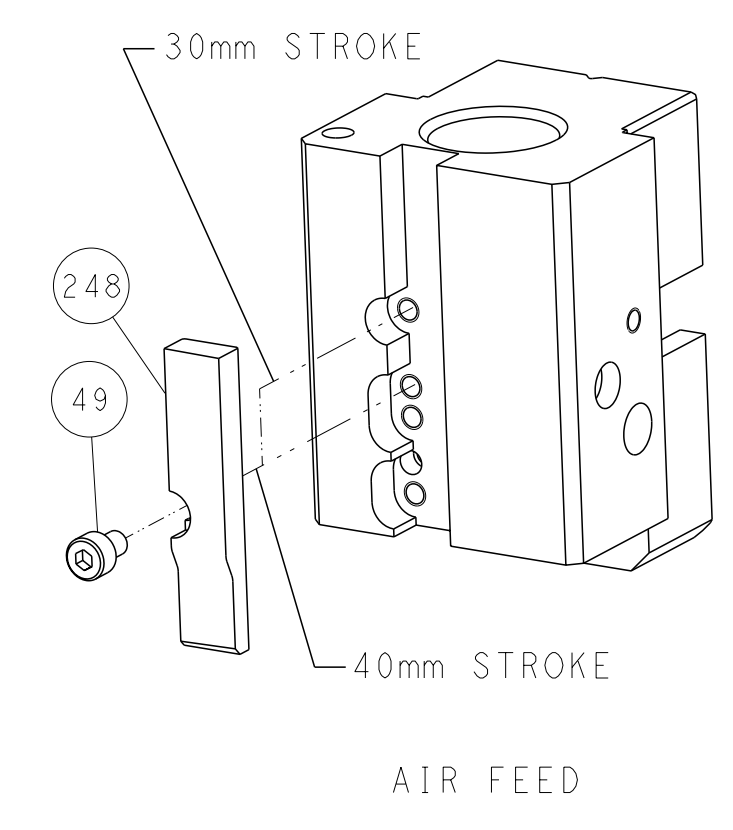
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION



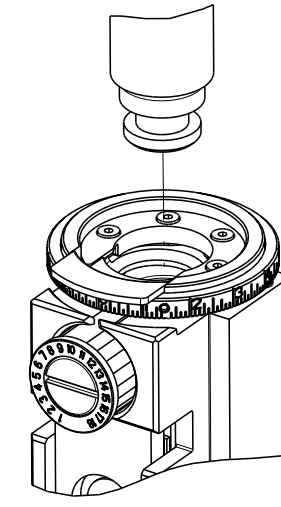
AIR FEED

**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 03JAN2014 CHK G. BAILEY 03JAN2014 APVD U. GUO 03JAN2014	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. A1 00779 C=2150270 WEIGHT -	RESTRICTED TO - SCALE 1:1 SHEET 2 of 4 REV C
MATERIAL - FINISH -		Customer Accessible Production Drawing	

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150270-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150270-7	A	CRIMP TOOLING KIT	-				

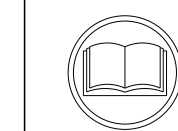
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.1041]	F
INSUL	3.60 mm [.1421]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TOUNGUE			
WIRE STRIP LENGTH 5.70-6.30 mm [.224-.248 IN]		INSULATION DIAMETER RANGE Ø1.50-3.30 mm [.059-.130 IN]	
TERMINAL APPLICATION SPECIFICATION LEAR SPEC Rev 10			
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572524-4	25201.XXX.YYY	1-1572631-2	25205.XXX.YYY
1572524-3	25203.XXX.YYY	1-1572631-3	25165.XXX.YYY

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	7.8
0.75mm2	1.85+/-0.05 [.073+/-0.002]	9.0
0.50mm2	1.75+/-0.05 [.069+/-0.002]	10.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 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.

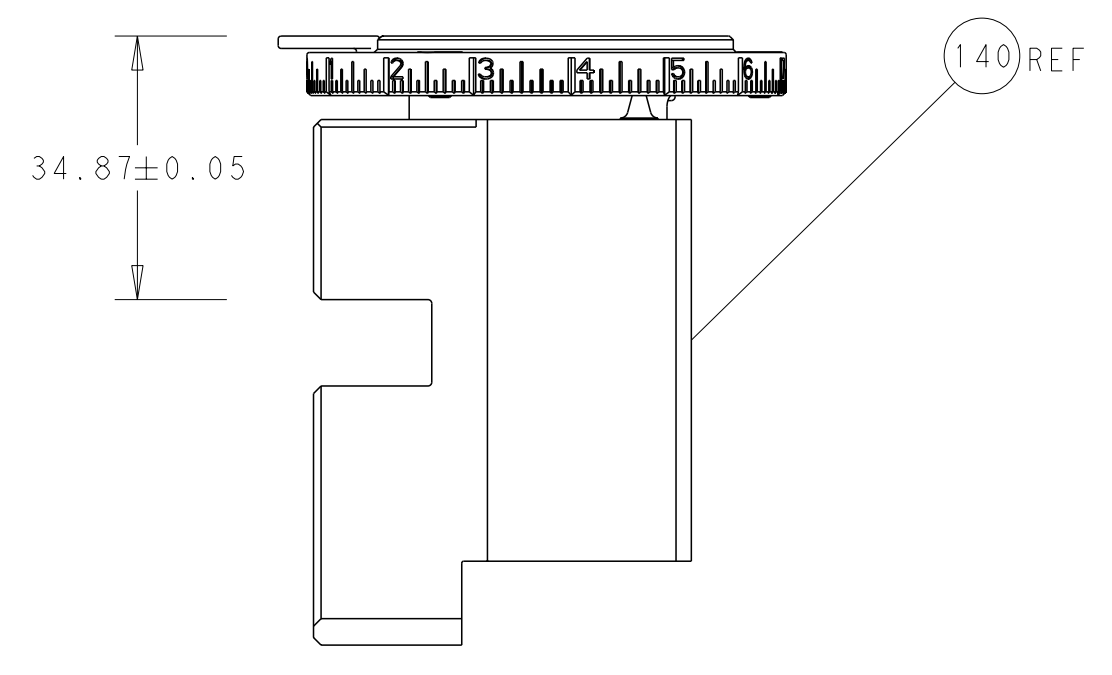
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-8	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
-	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	455888-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1901696-3	STRIP GUIDE, REAR	19
-	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	240641-2	SPACER	16
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	4-1803000-1	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-9	SPACER	5
-	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1803139-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
1	1	1-1633609-1	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

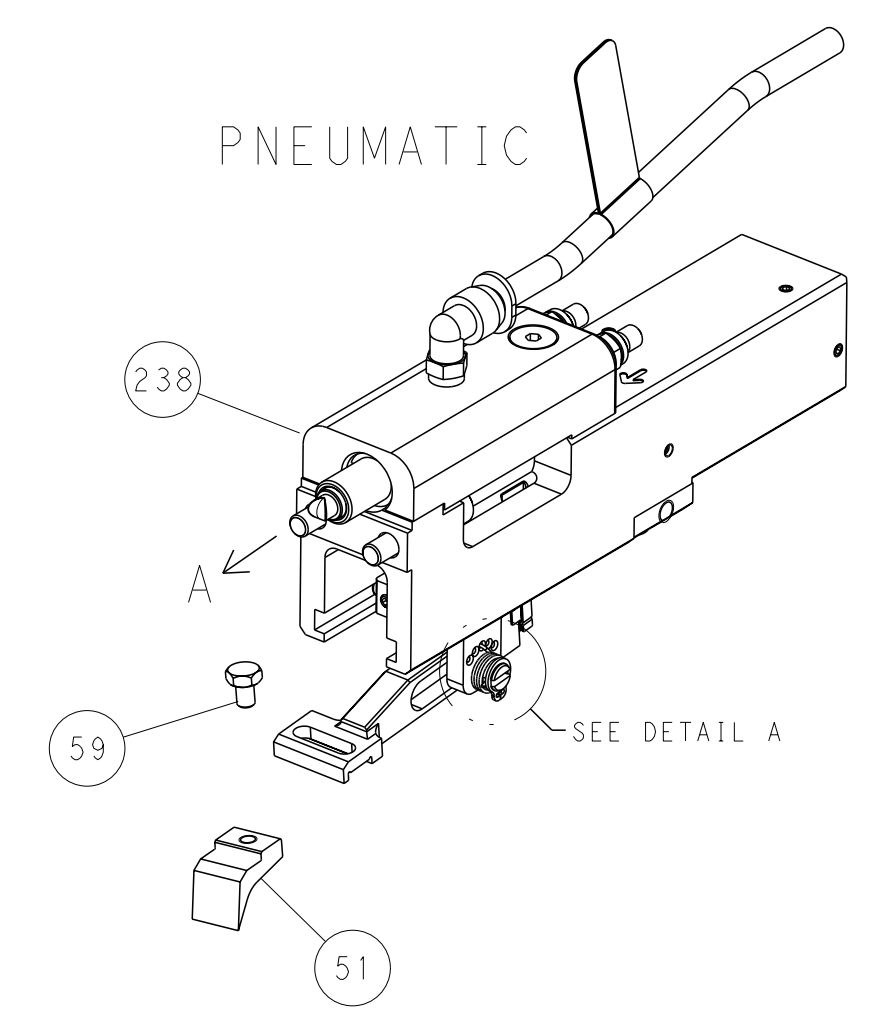
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 03JAN2014		CHK G. BAILEY 03JAN2014		APVD U. GUO 03JAN2014		NAME	
0 PLC	±	1 PLC	±	TE Connectivity		Harrisburg, PA 17105-3608		SIZE		CAGE CODE DRAWING NO	
2 PLC	±	3 PLC	±	Ocean End Feed		Applicator		RESTRICTED TO		SCALE	
4 PLC	±	5 PLC	±	Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 of 4		REV C	
ANGLES	±	FINISH	±	WEIGHT		A1 00779 ©=2150270		Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 of 4 REV C	

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

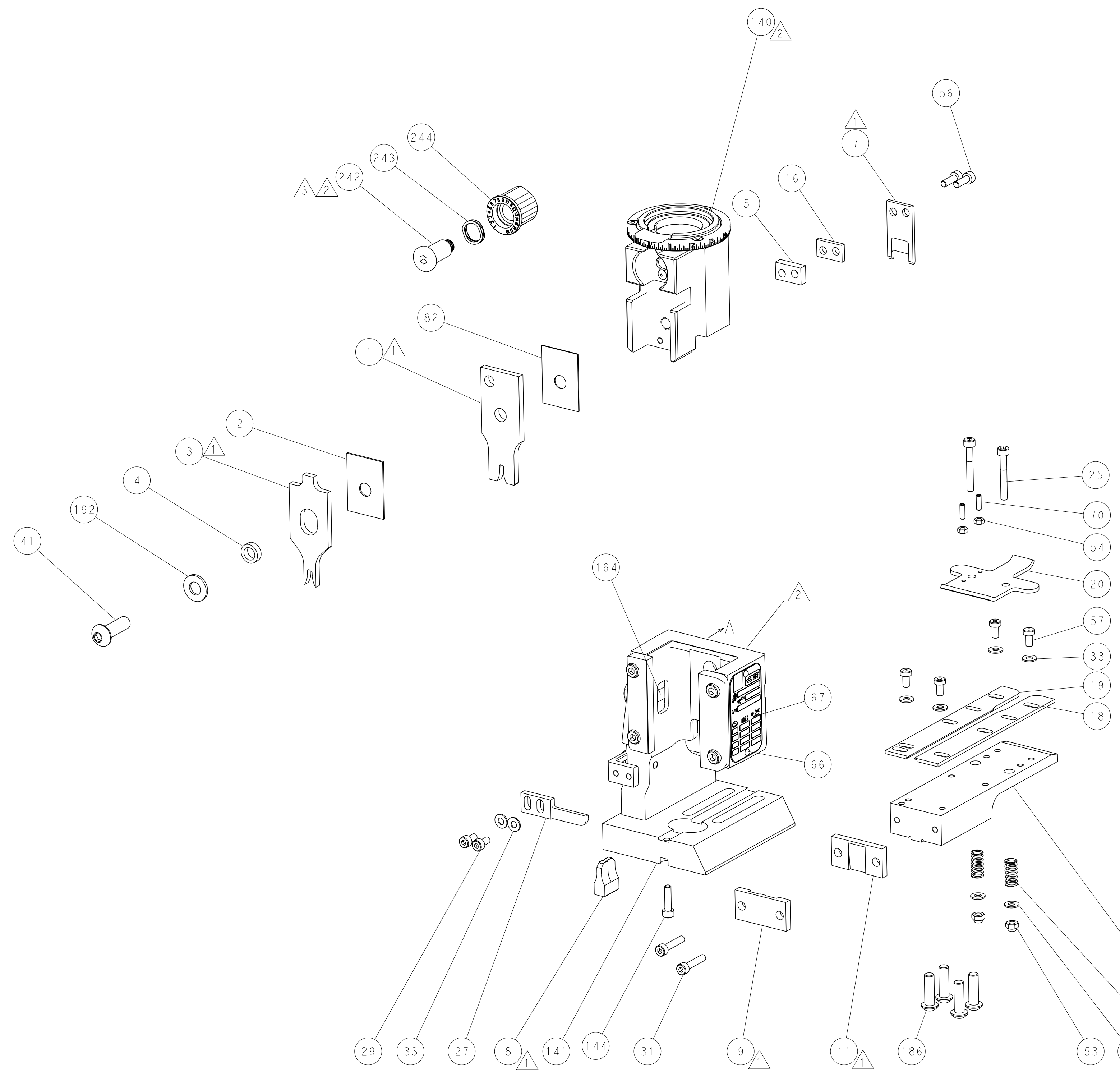


RAM SET-UP

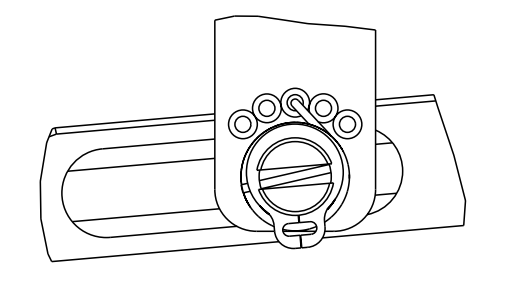
FEED TYPE



PNEUMATIC

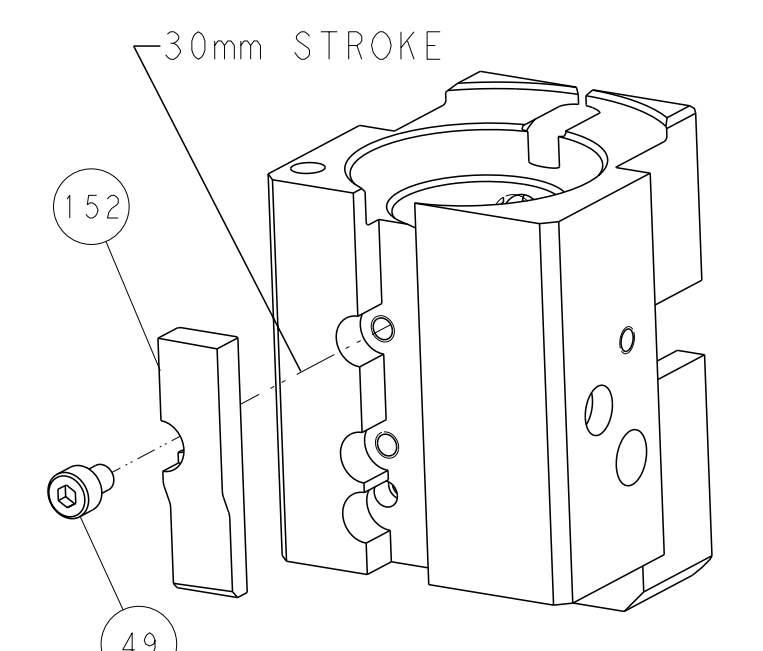


FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 03JAN2014 CHK G. BAILEY 03JAN2014 APVD U. GUO 03JAN2014	NAME Ocean End Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	SIZE CAGE CODE DRAWING NO A1 00779 C=2150270	RESTRICTED TO -
MATERIAL		WEIGHT Customer Accessible Production Drawing	SCALE 1:1 SHEET 4 OF 4 REV C