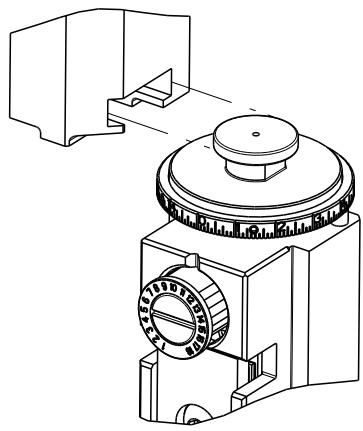


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150579-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150579-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150579-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150579-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150579-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.31 mm [.091]	F
INSUL	3.12 mm [.123]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		GROTE & HARTMANN CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 6.3 TYPE F/O			
WIRE STRIP LENGTH 5.60-6.40 mm [.220-.252 IN]		INSULATION DIAMETER RANGE Ø1.60-2.10 mm [.063-.083 IN]	
TERMINAL APPLICATION 		25722 Rev 9/28/05	
SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572910-1	25722.123.204	1572910-5	25722.417.031
1572910-2	25722.201.004	1572910-6	25722.201.042
1572910-3	25722.123.211	1572910-7	25722.123.242
1572910-4	25722.201.011		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2X FLRY 0.5mm ²			1.60+/-0.05 [.063+/- .002]		6.7
FLRY 1mm ²			1.55+/-0.05 [.061+/- .002]		7.2
FLRY 0.75mm ²			1.50+/-0.05 [.059+/- .002]		7.8
FLRY 0.5mm ²			1.40+/-0.05 [.055+/- .002]		9.0



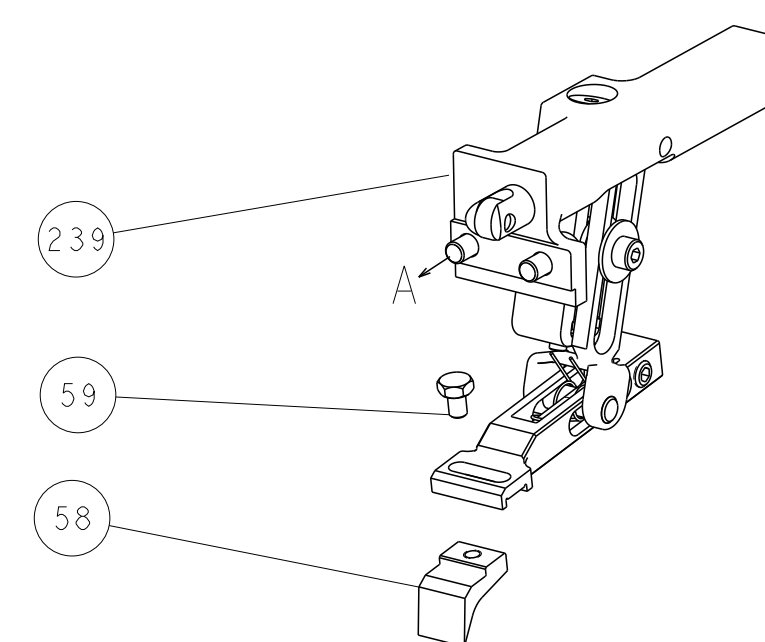
1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

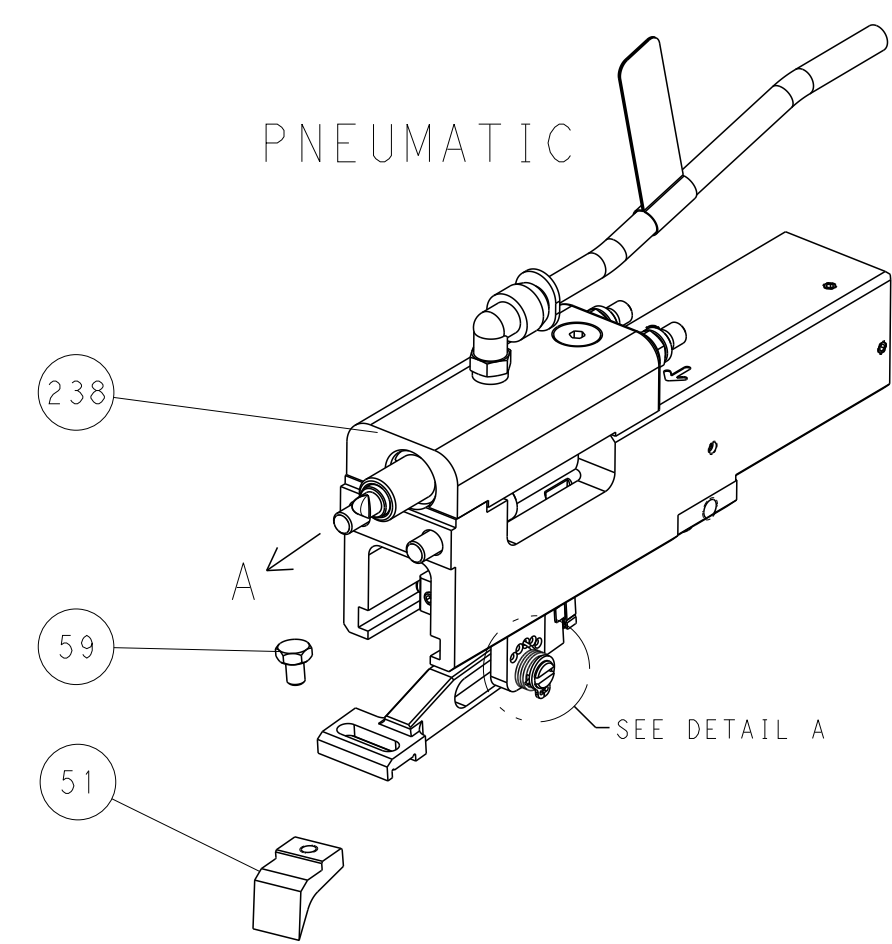
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LOC	DIST	REVISIONS					
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			A	RELEASED	03AUG2015	GH	TE
			B	ECR-20-014618	14OCT2020	TB	RK

	-	1	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	455888-5	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
	-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	-	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	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-3	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	1901259-4	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	-	1	1	1	1	240641-6	SPACER	16
1	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	8-1803001-6	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	240641-7	SPACER	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	7-1803016-1	CRIMPER, INSULATION F	3
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	1	9-1633738-2	CRIMPER, WIRE	1
	-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

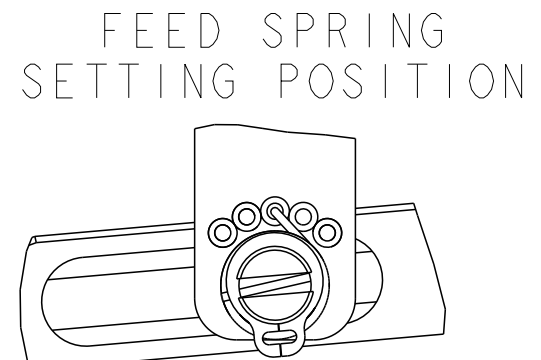
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME:	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±°		APVD: T. ELBIN 7 JULY 2015 PRODUCT SPEC:	
		APPLICATION SPEC:		Ocean End Feed Applicator	
MATERIAL:		FINISH:		SIZE: CAGE CODE: DRAWING NO:	
-		-		A 00779 C-2150579	
WEIGHT:		RESTRICTED TO:		SCALE: 1:1 SHEET 1 OF 4 REV B	
-		-		Customer Accessible Production Drawing	



FEED TYPE
MECHANICAL

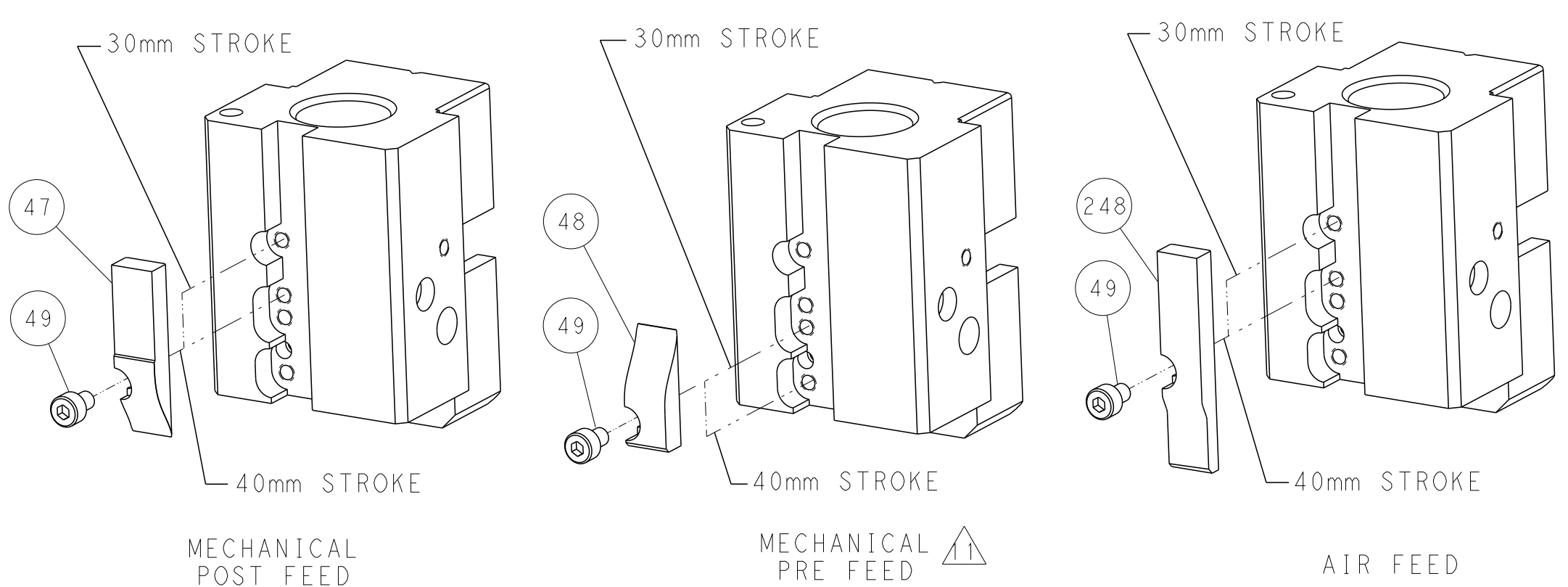


PNEUMATIC



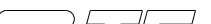
FEED SPRING
SETTING POSITION

DETAIL A



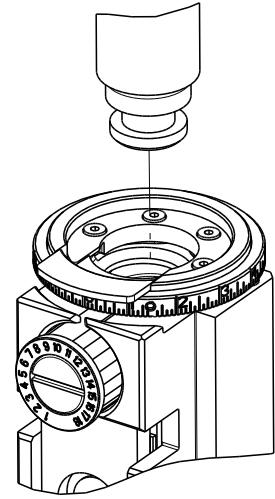
CAM POSITIONS

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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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±° FINISH		NAME: Ocean End Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE: A CAGE CODE: 00779 DRAWING NO: C-2150579 RESTRICTED TO: -	
MATERIAL: -		WEIGHT: -		Customer Accessible Drawing SCALE: 1:1 SHEET: 2 OF 4 REV: B	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150579-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150579-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150579-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.31 mm [.091]	F
INSUL	3.12 mm [.123]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL GROTE & HARTMANN CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,6.3 TYPE F/O			
WIRE STRIP LENGTH 5.60-6.40 mm [.220-.252 IN]		INSULATION DIAMETER RANGE Ø1.60-2.10 mm [.063-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	25722 Rev 9/28/05	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572910-1	25722.123.204	1572910-5	25722.417.031
1572910-2	25722.201.004	1572910-6	25722.201.042
1572910-3	25722.123.211	1572910-7	25722.123.242
1572910-4	25722.201.011		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2X FLRY 0.5mm ²		1.60+/-0.05 [.063+/- .002]		6.7
FLRY 1mm ²		1.55+/-0.05 [.061+/- .002]		7.2
FLRY 0.75mm ²		1.50+/-0.05 [.059+/- .002]		7.8
FLRY 0.5mm ²		1.40+/-0.05 [.055+/- .002]		9.0



- 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 LUBRICANT IS RECOMMENDED.
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)

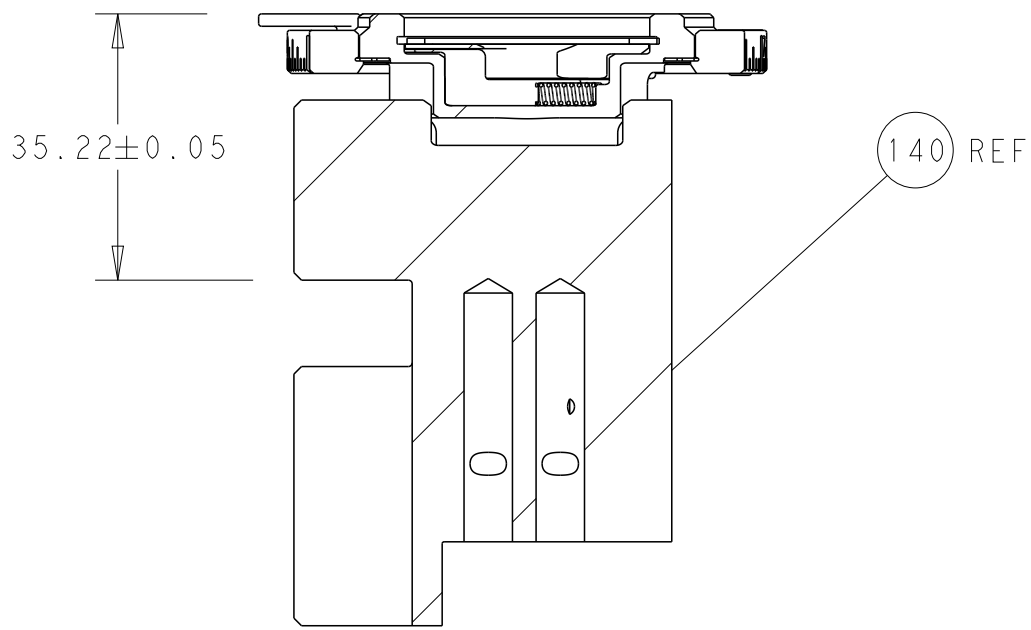
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119082-3	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
-	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	455888-5	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
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	-	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	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	240641-6	SPACER	16
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	1	8-1803001-6	ANVIL, COMBINATION, END FEED	8
1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-7	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	7-1803016-1	CRIMPER, INSULATION F	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	9-1633738-2	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± 5 PLC ± 6 PLC ± 7 PLC ± 8 PLC ± 9 PLC ± 10 PLC ± 11 PLC ± 12 PLC ± 13 PLC ± 14 PLC ± 15 PLC ± 16 PLC ± 17 PLC ± 18 PLC ± 19 PLC ± 20 PLC ± 21 PLC ± 22 PLC ± 23 PLC ± 24 PLC ± 25 PLC ± 26 PLC ± 27 PLC ± 28 PLC ± 29 PLC ± 30 PLC ± 31 PLC ± 32 PLC ± 33 PLC ± 34 PLC ± 35 PLC ± 36 PLC ± 37 PLC ± 38 PLC ± 39 PLC ± 40 PLC ± 41 PLC ± 42 PLC ± 43 PLC ± 44 PLC ± 45 PLC ± 46 PLC ± 47 PLC ± 48 PLC ± 49 PLC ± 50 PLC ± 51 PLC ± 52 PLC ± 53 PLC ± 54 PLC ± 55 PLC ± 56 PLC ± 57 PLC ± 58 PLC ± 59 PLC ± 60 PLC ± 61 PLC ± 62 PLC ± 63 PLC ± 64 PLC ± 65 PLC ± 66 PLC ± 67 PLC ± 68 PLC ± 69 PLC ± 70 PLC ± 71 PLC ± 72 PLC ± 73 PLC ± 74 PLC ± 75 PLC ± 76 PLC ± 77 PLC ± 78 PLC ± 79 PLC ± 80 PLC ± 81 PLC ± 82 PLC ± 83 PLC ± 84 PLC ± 85 PLC ± 86 PLC ± 87 PLC ± 88 PLC ± 89 PLC ± 90 PLC ± 91 PLC ± 92 PLC ± 93 PLC ± 94 PLC ± 95 PLC ± 96 PLC ± 97 PLC ± 98 PLC ± 99 PLC ± 100 PLC ±		SIZE A	
MATERIAL -		FINISH -		WEIGHT -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3 of 4	
				REV B	

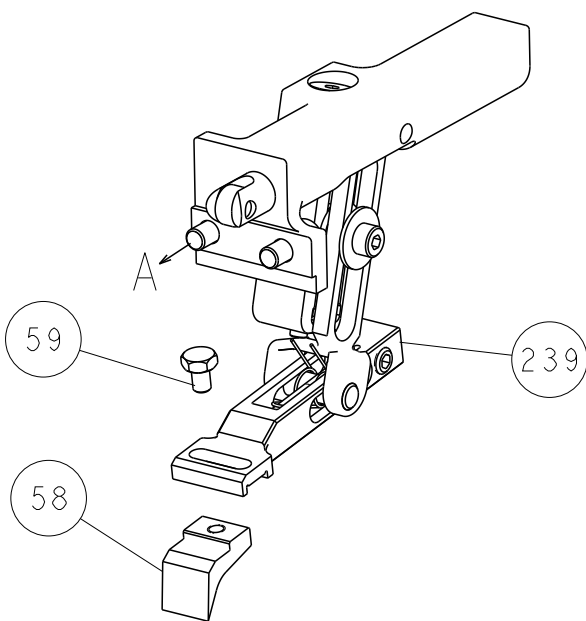
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

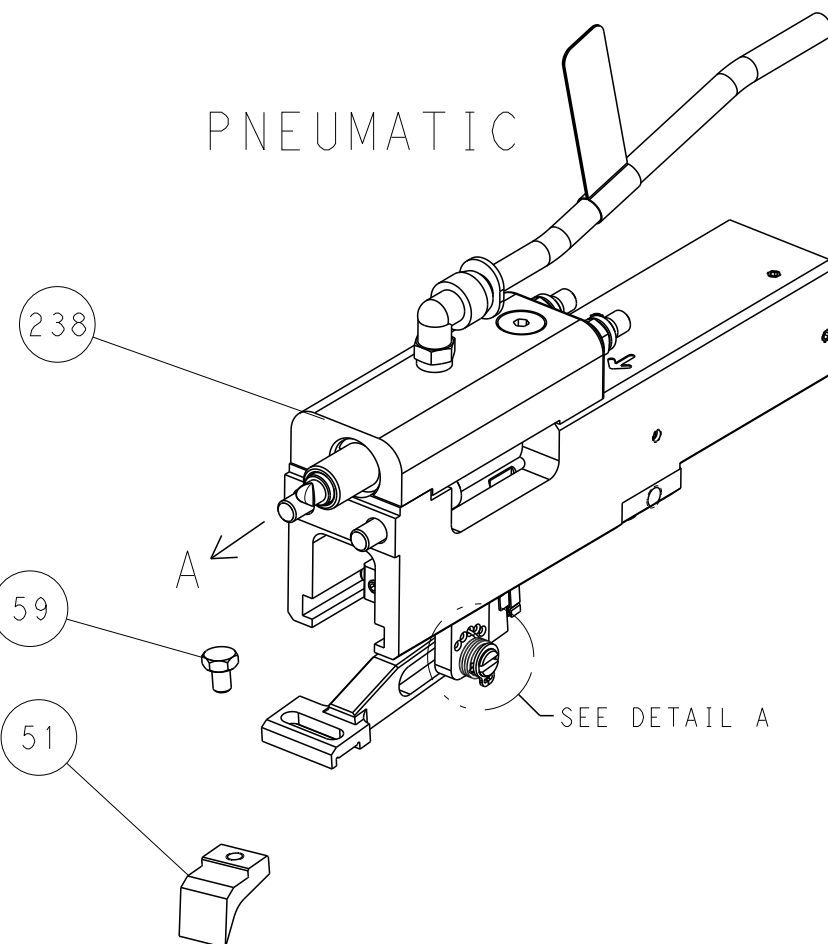


RAM SET-UP

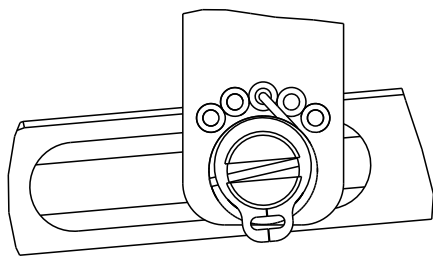
FEED TYPE
MECHANICAL



PNEUMATIC

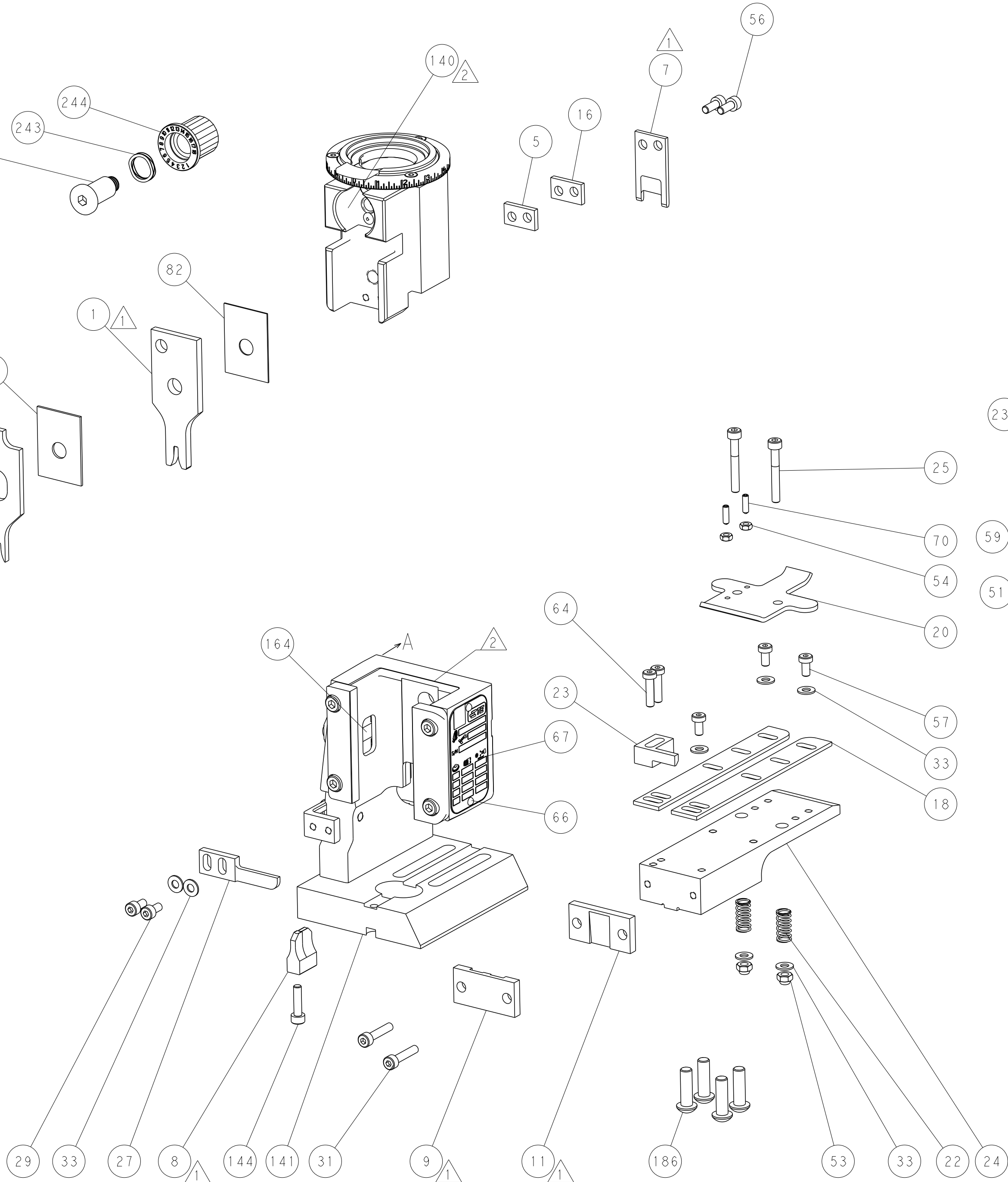
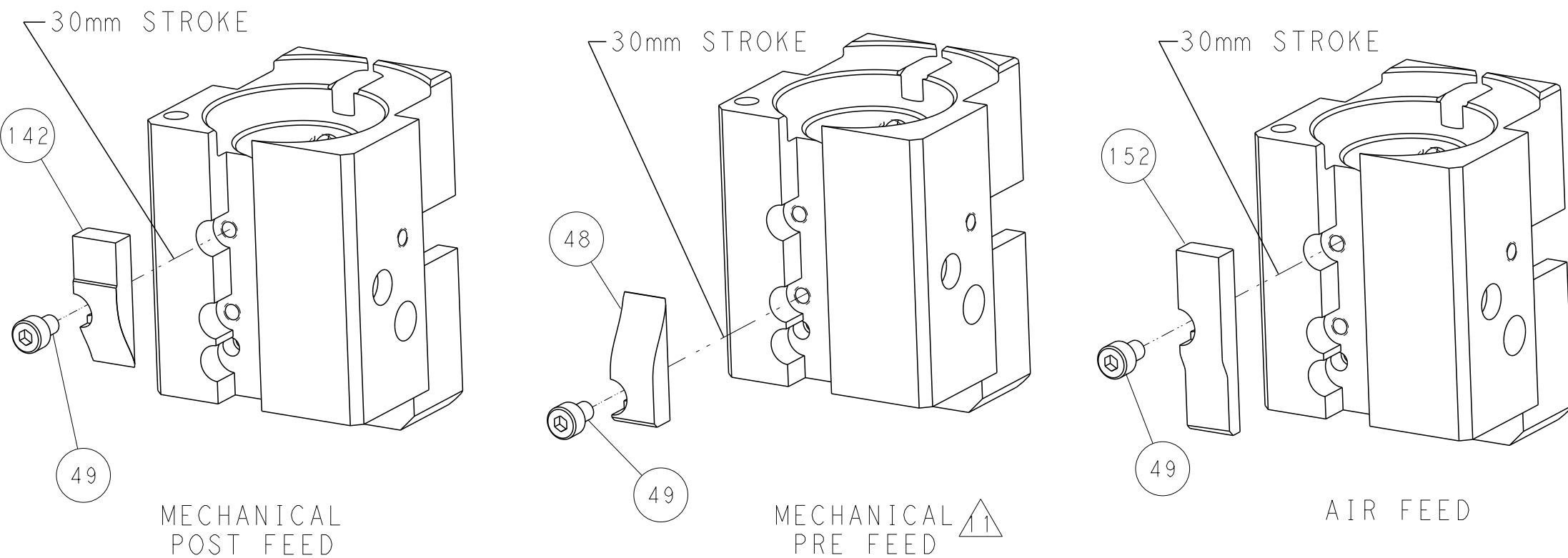


FEED SPRING
SETTING POSITION



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)

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				CHK	7 JULY 2015				
				APVD	7 JULY 2015	NAME			
				PRODUCT SPEC		Ocean End Feed Applicator			
				APPLICATION SPEC					
				WEIGHT		SIZE			
				Customer Accessible Production Drawing		A 00779 C=2150579			
				SCALE		SHEET 4 OF 4			
				REV		B			

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2150579-1](#)