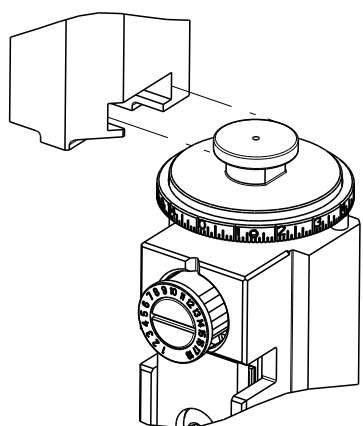
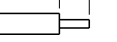


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150579-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150579-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150579-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150579-2	B	PNEUMATIC AND CRIMP TOOLING KIT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



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.31 mm [.091]	F
INSUL	3.12 mm [1.23]	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 $\varnothing$ 1.60-2.10 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



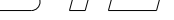
- ① RECOMMENDED SPARE PARTS
 - ② REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ③ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - ④ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT 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

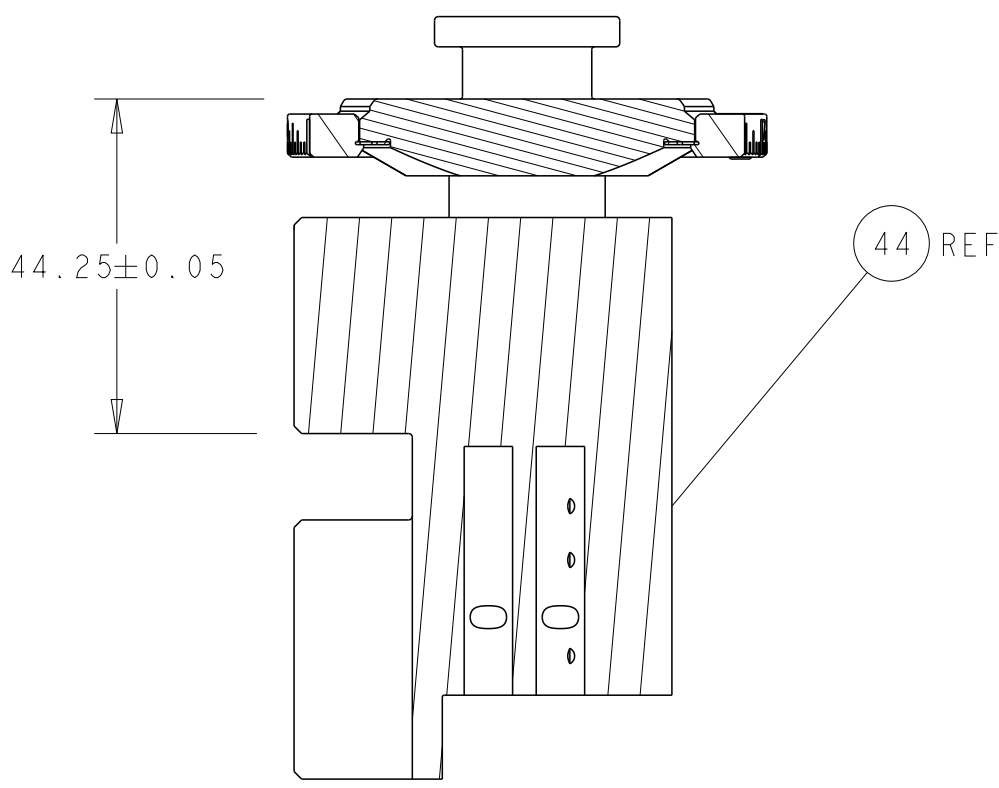
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DBN	APVD
			I	ORIGINAL	06 JUL 2015	GH	TE
			A	RELEASED	03AUG2015	GH	TE
			B	ECR-20-014618	140CT2020	TB	RK

3	-	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
	-	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	240641-6	SPACER	16	
	-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
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	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

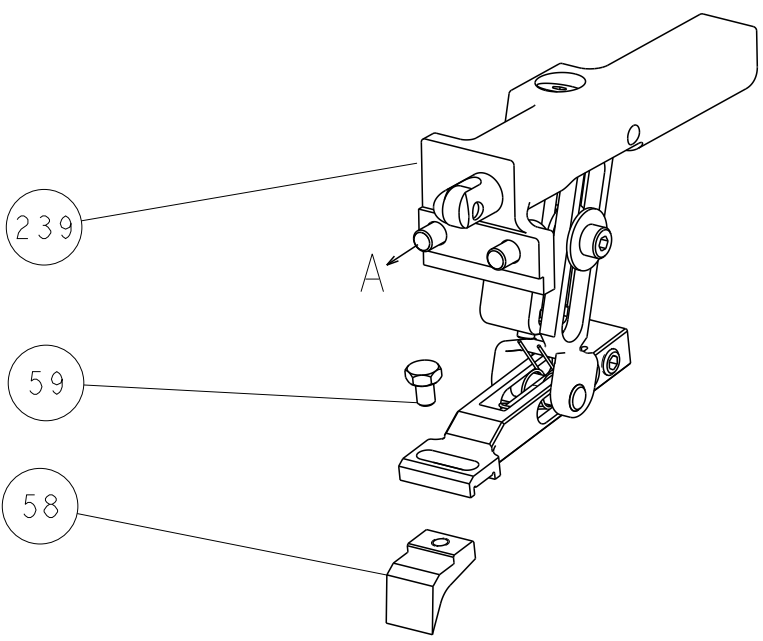
THIS DRAWING IS A COMPUTER GENERATED FILE AND DOES NOT REQUIRE AN ISO CERTIFICATION UNLESS SPECIFICALLY INDICATED OTHERWISE. ANY DIMENSIONS OR TOLERANCES SHOWN ON THIS DRAWING SHOULD BE CHECKED FOR THE LATEST VERSION.						DWN: JOEFNER 6JULY2015 CHG: TELBIN 7JULY2015 TELBIN 7JULY2015		 TE Connectivity 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 PRODUCT SPEC AP40 APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 00779 C=2150579		RESTRICTED TO -	
				WEIGHT -		Customer Accessible Product Drawing SCALE 1:1 SHEET 1 OF 4 REV B			

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

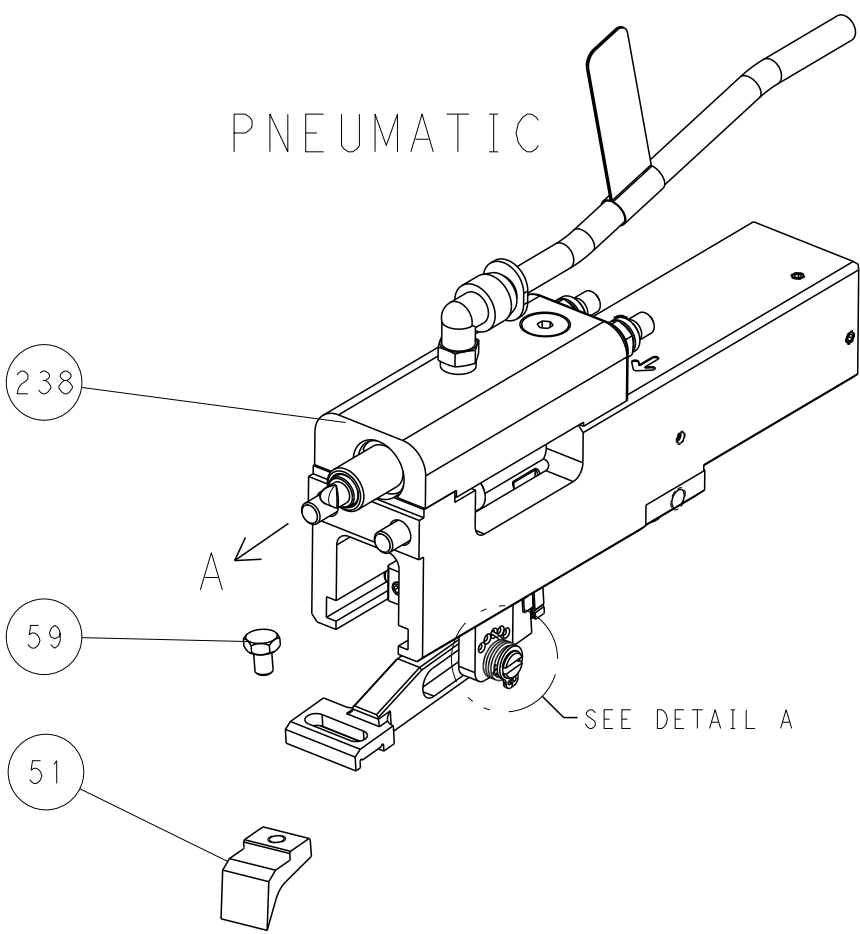


RAM SET-UP

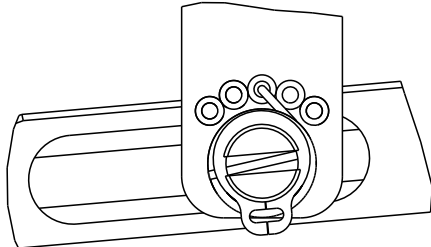
FEED TYPE
MECHANICAL



PNEUMATIC

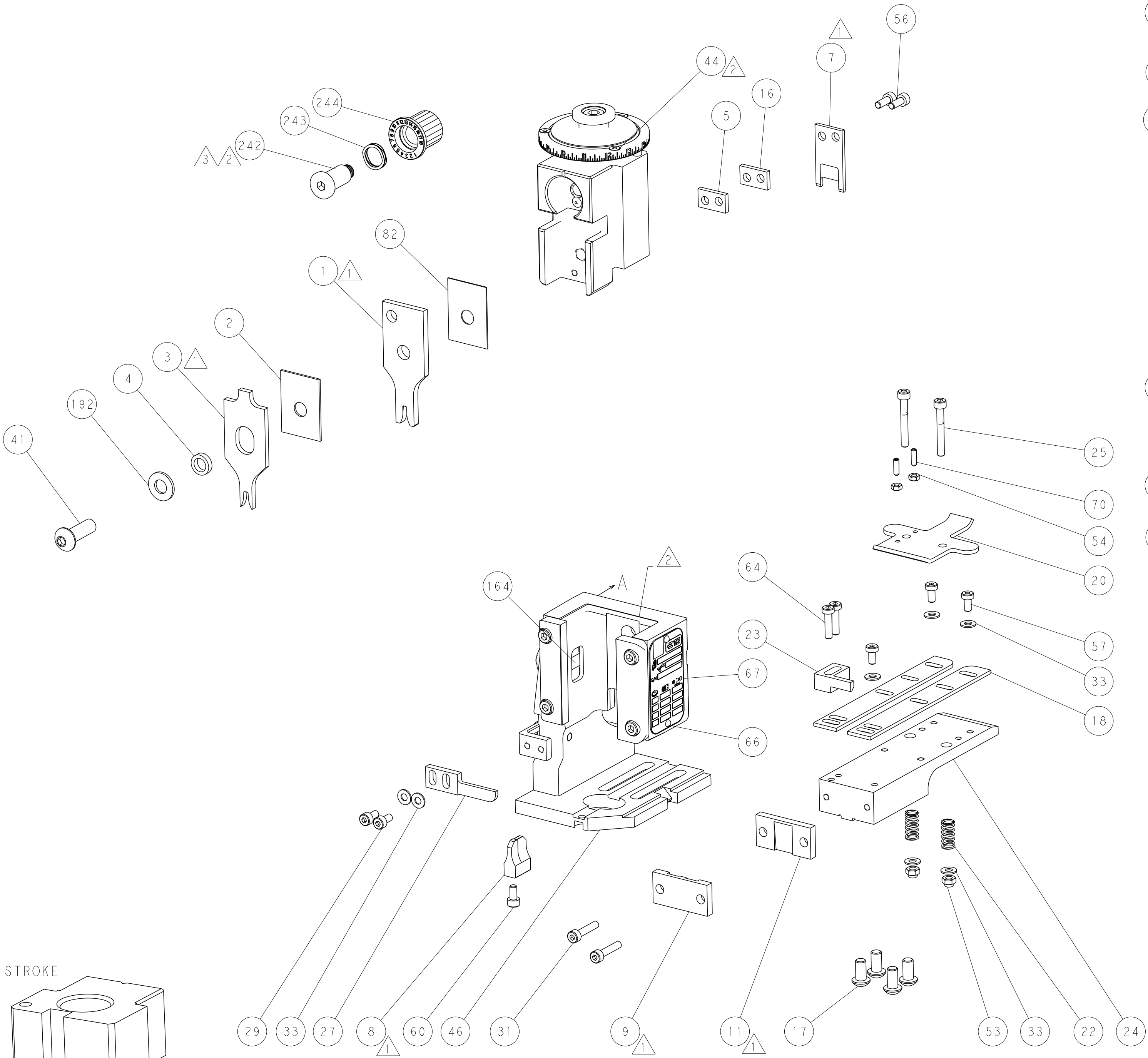
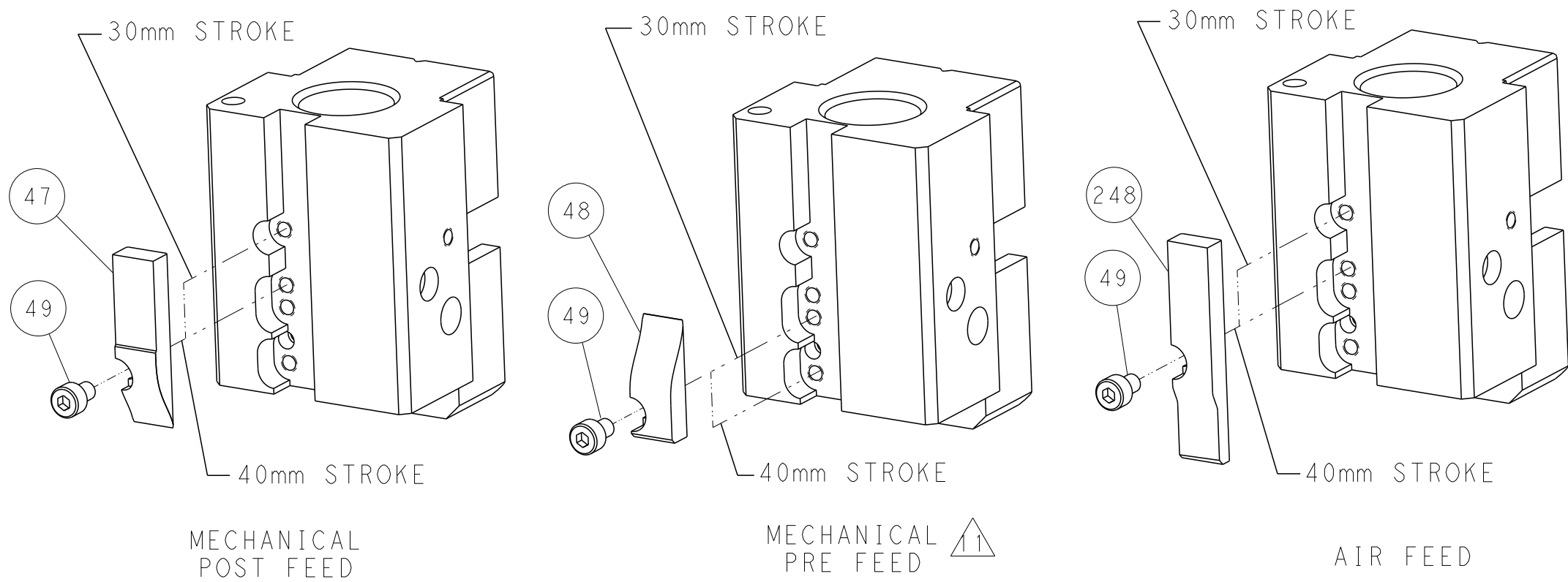


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS

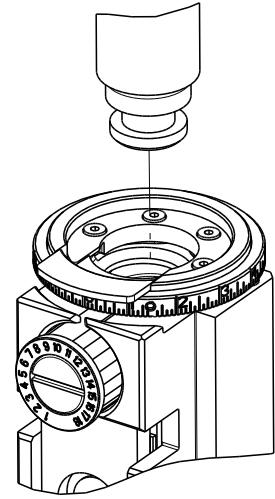


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHK: TELBIN	7 JULY 2015		
				APVD: TELBIN	7 JULY 2015	NAME: Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE: A	
				APPLICATION SPEC		CAGE CODE: 00779	
				WEIGHT: -		DRAWING NO: C=2150579	
				Customer Accessible Production Drawing		RESTRICTED TO: -	
				SCALE: 1:1		SHEET 2 OF 4	
						REV B	

8		7	
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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.

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

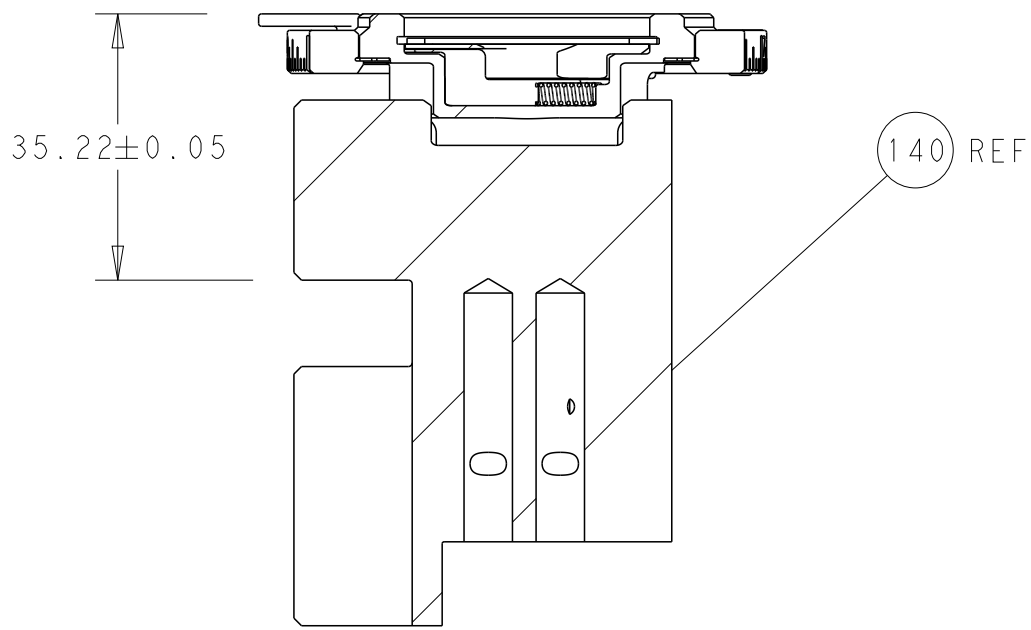
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, 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

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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DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	PRODUCT SPEC APPLICATION SPEC	NAME: Ocean End Feed Applicator	
MATERIAL: -	-	WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150579	RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:1	SHEET: 3 OF 4	REV: B

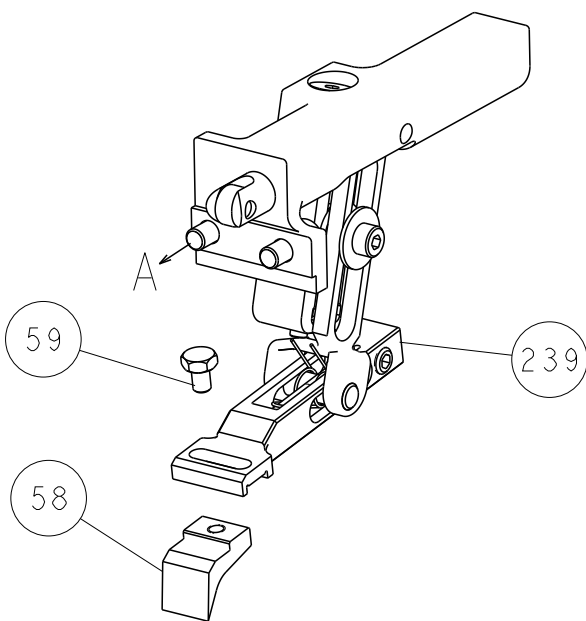
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

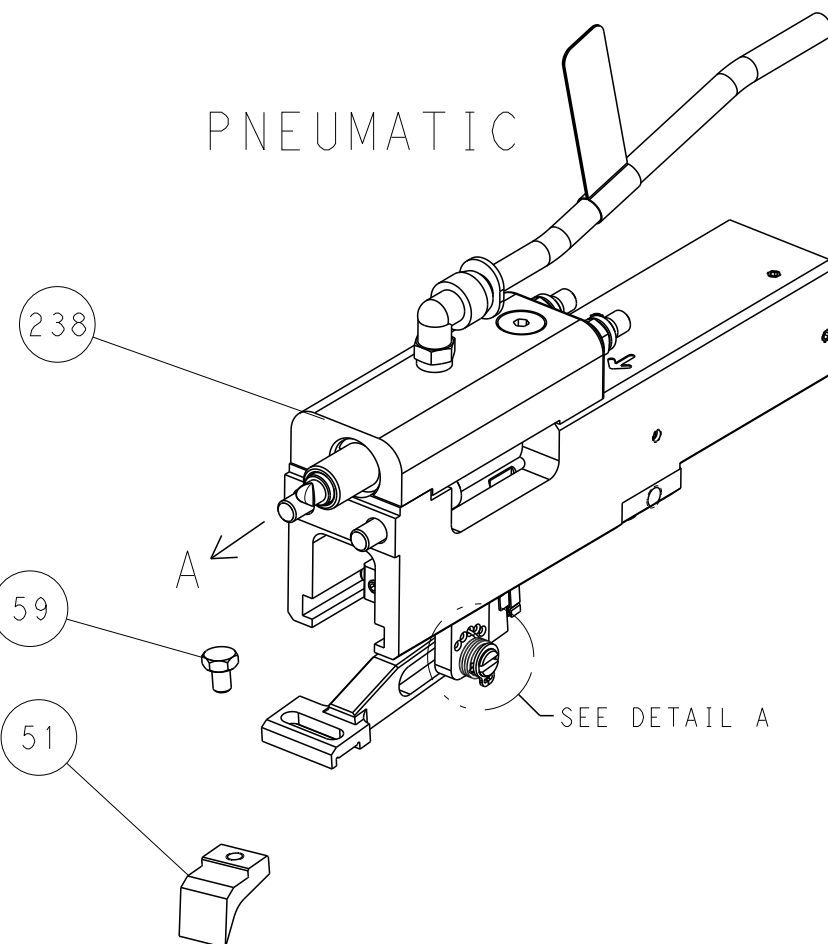


RAM SET-UP

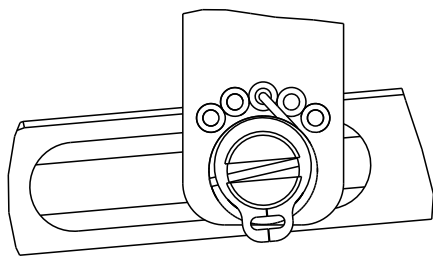
FEED TYPE
MECHANICAL



PNEUMATIC

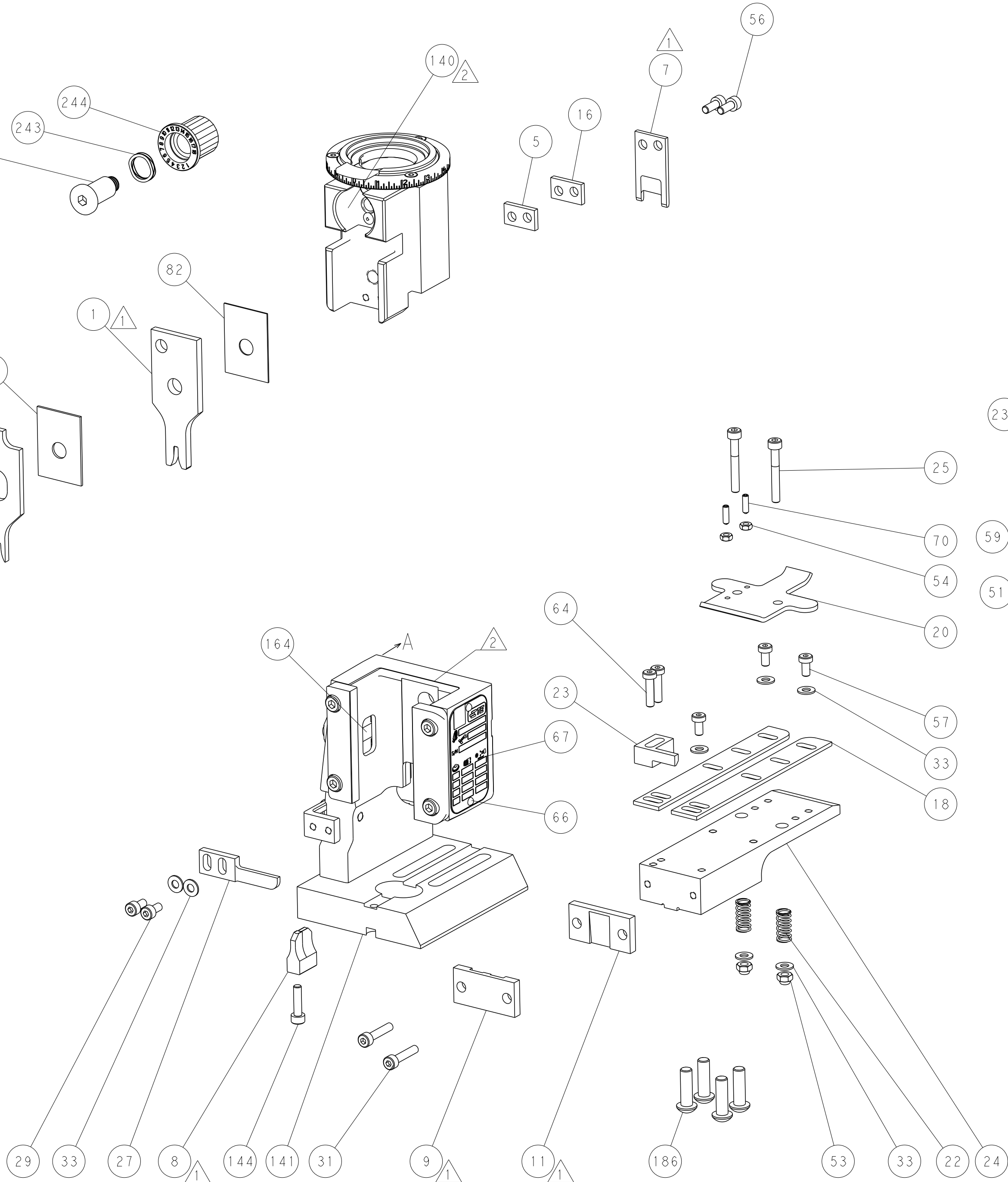
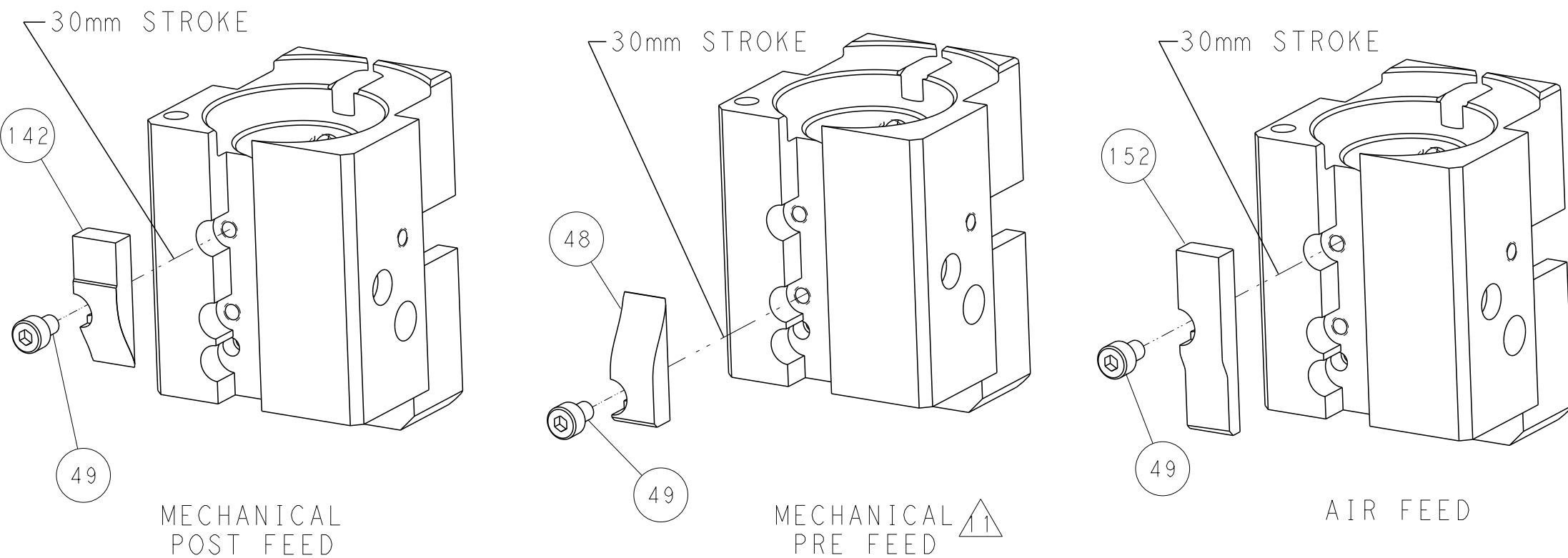


FEED SPRING
SETTING POSITION



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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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2150579	
MATERIAL				Customer Accessible Production Drawing		SCALE 1:1 SHEET 4 OF 4 REV B	

Mouser Electronics

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[TE Connectivity:](#)

[2150579-2](#)