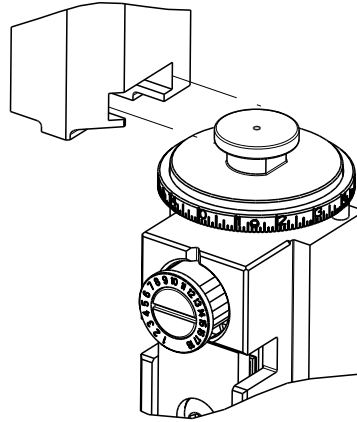
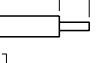



8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150424-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150424-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150424-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150424-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150424-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE F. ST. 4.8 X 0.8			
WIRE STRIP LENGTH 3.80-4.56 mm [.150-.180 IN]		 INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)LEAR DATA SHT 25313 Rev-7		-
	(B)LEAR DATA SHT 25314 Rev-6		-
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
(A) 1949293-1	(A) 25313.213.011	(A) 1949293-7	(A) 25313.417.328
(A) 1949293-2	(A) 25313.213.042	(B) 1572523-1	(B) 25314.123.204
(A) 1949293-3	(A) 25313.213.004	(B) 1572523-2	(B) 25314.123.211
(A) 1949293-4	(A) 25313.123.211	(B) 1572523-3	(B) 25314.213.004
(A) 1949293-5	(A) 25313.123.204	(B) 1572523-4	(B) 25314.417.031
(A) 1949293-6	(A) 25313.417.031		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [1.055+/-0.002]	8.2
0.75mm2	1.30+/-0.05 [1.051+/-0.002]	9.2
0.50mm2	1.25+/-0.05 [1.049+/-0.002]	9.7


- 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 ITEM 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

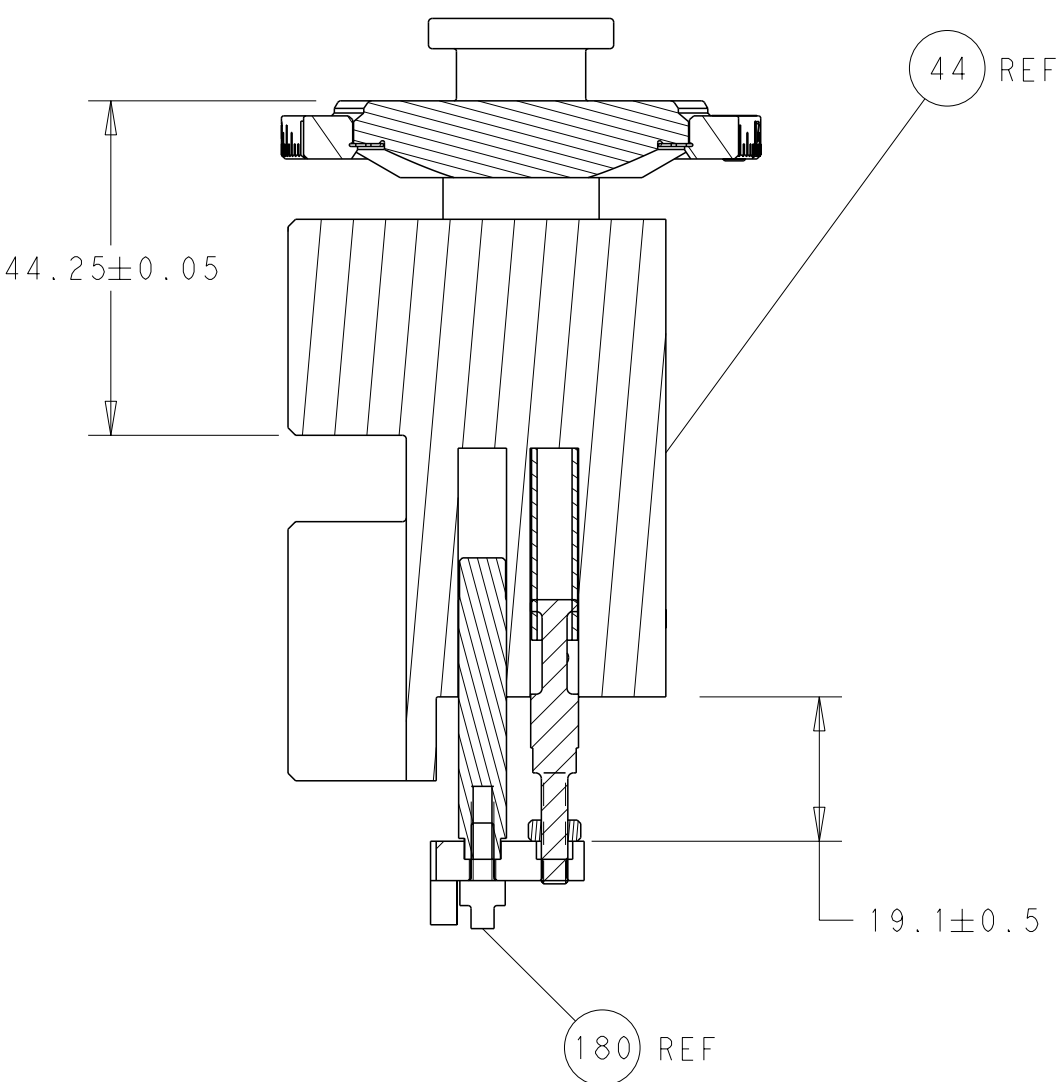
LOC	DIST	REVISIONS					
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			A	RELEASED	10APR2014	KH	UG
			B	ECR-20-003186	04MAR2020	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	1-1976055-0	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
6	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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
-	1	1	1	1	1901681-5	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	-	2063961-9	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	240825-1	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	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	-	1	1	1	690482-5	PLATE, FRONT SHEAR	9
1	1	2	2	1	1-1633384-3	ANVIL, COMBINATION	8
1	-	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	2	1	3-456405-7	CRIMPER, WIRE PREMIUM	1
-77-72-71-2-1		PART NO		DESCRIPTION		ITEM NO	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG CHK L. ZHANG APVD J. GUO	21MAR2014 21MAR2014 21MAR2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APPLICATION SPEC		SIZE 00779	
MATERIAL -		ANGLES FINISH -		WEIGHT -		DRAWING NO C=2150424	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 of 4	
						REV B	

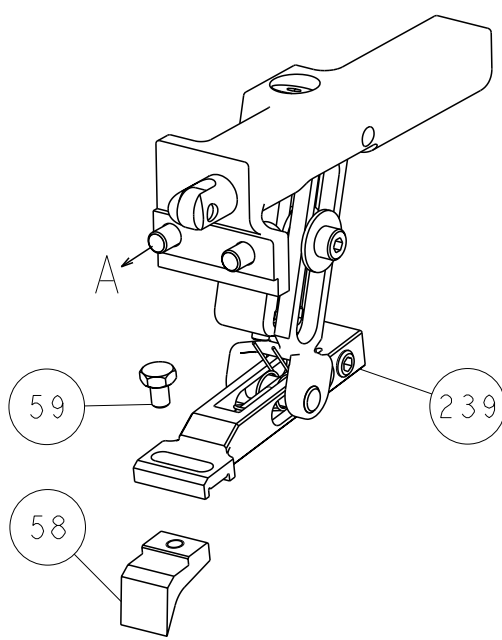
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

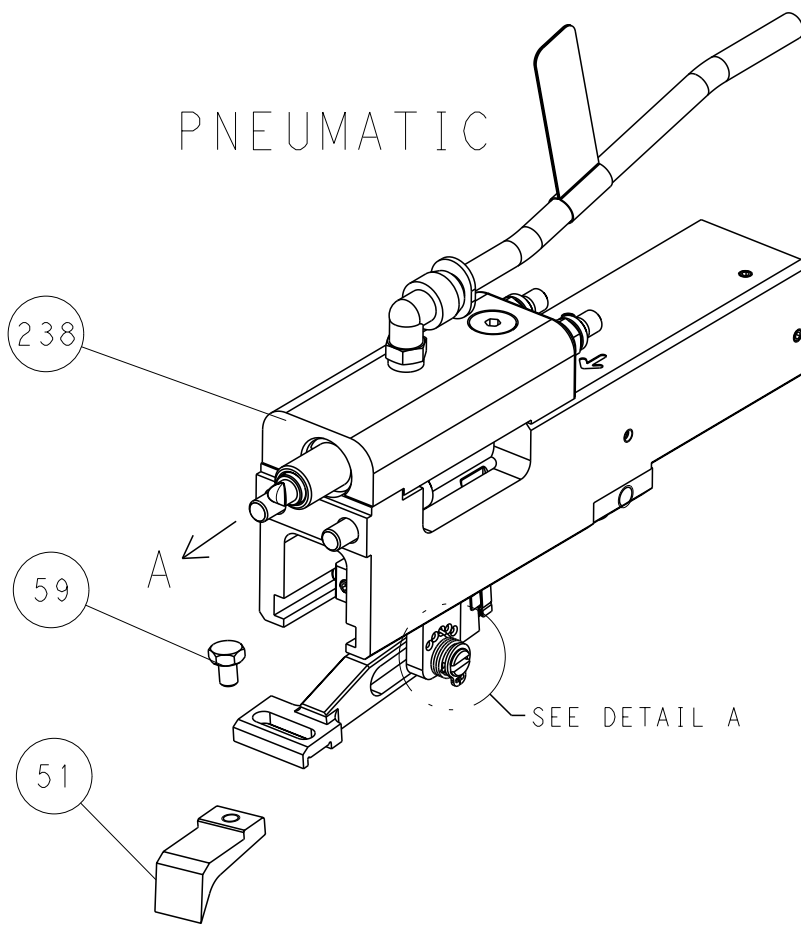


RAM AND HOLDDOWN SET-UP

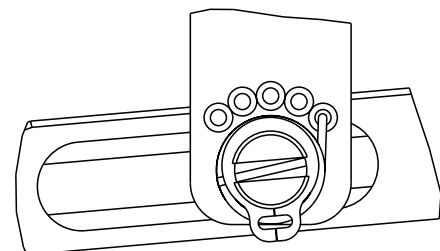
FEED TYPE
MECHANICAL



PNEUMATIC

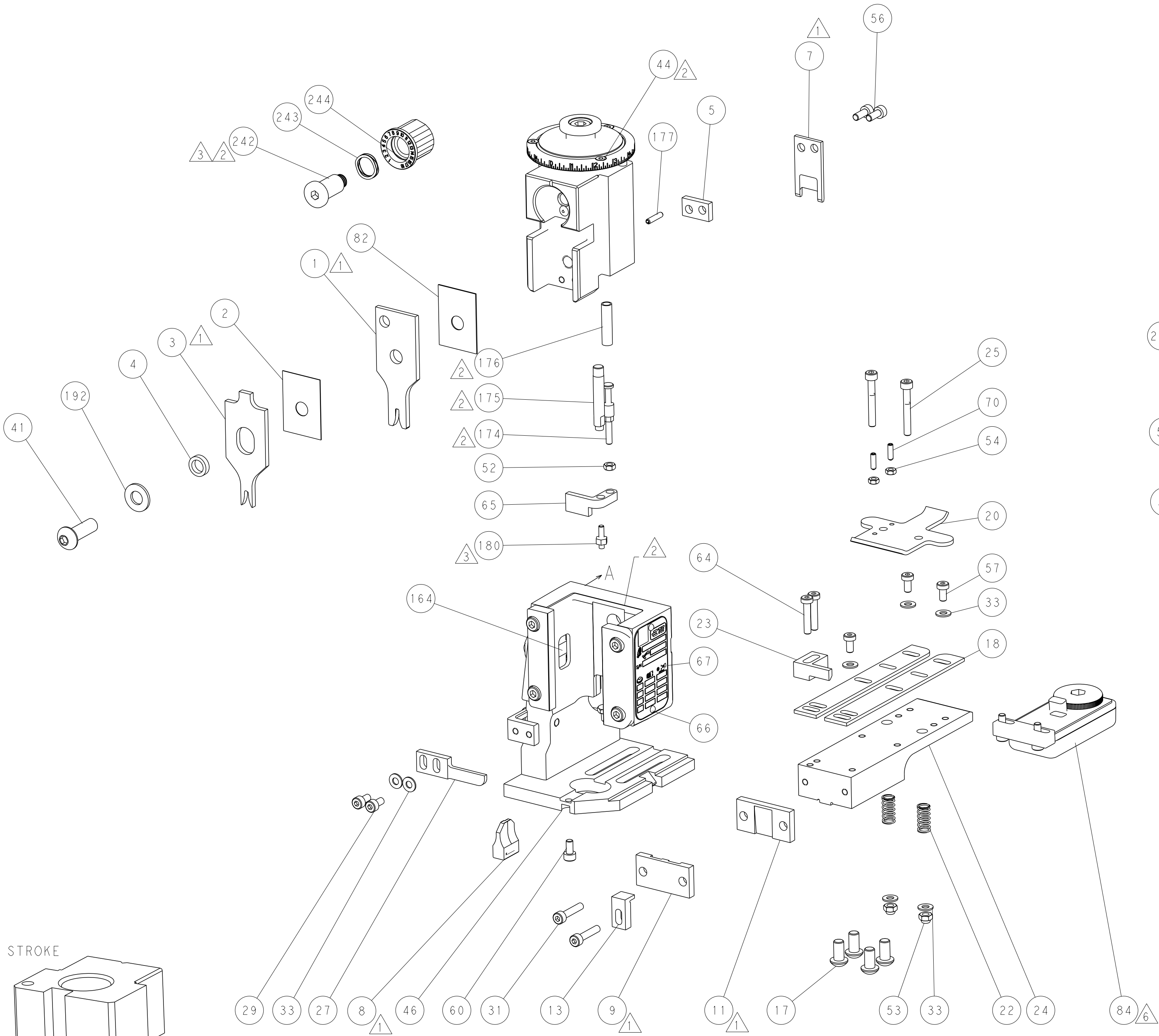
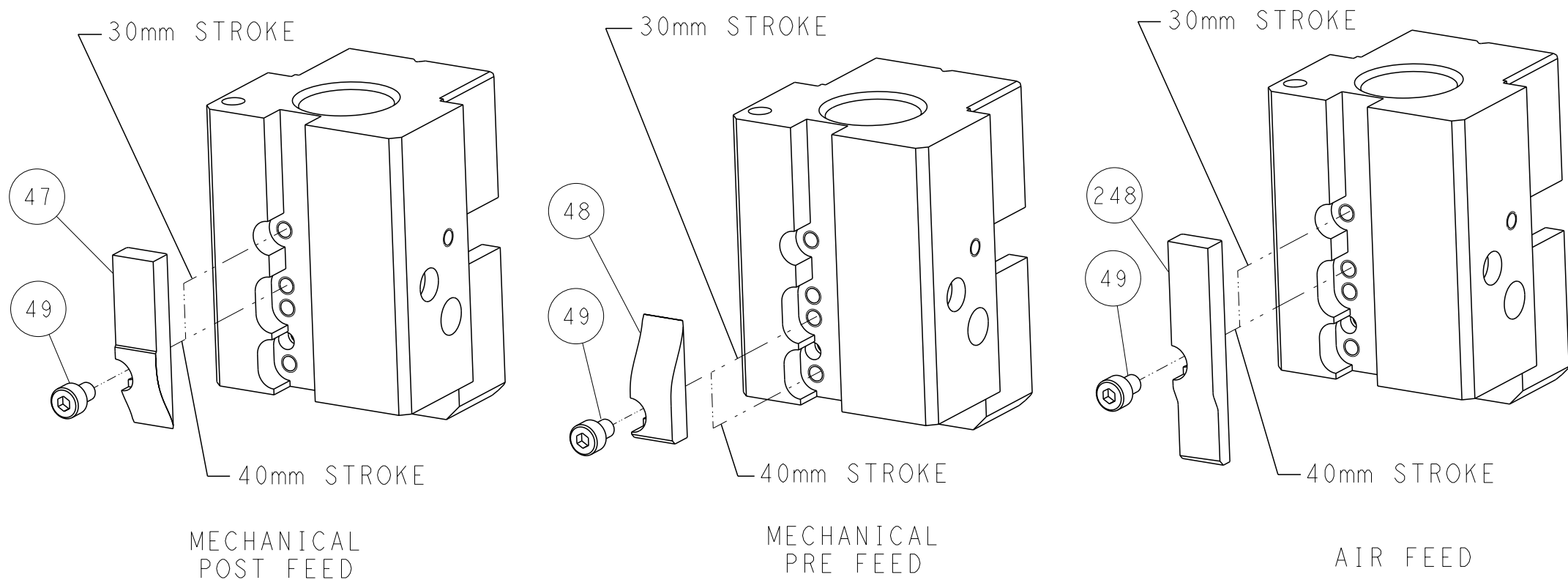


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS

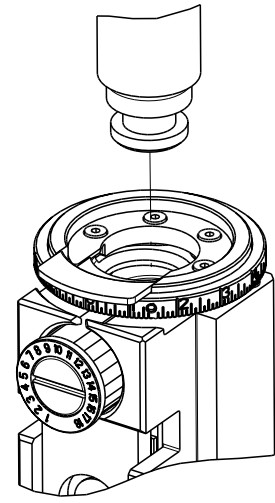


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

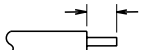





THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN K. HUANG 21MAR2014	TE Connectivity Harrisburg, PA 17105-3608		
CHK L. ZHANG 21MAR2014				NAME	Ocean End Feed Applicator		
APVD J. GUO 21MAR2014				PRODUCT SPEC	-		
APPLICATION SPEC				SIZE	A1		
MATERIAL				WEIGHT	00779		
Customer Accessible Production 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
2-2150424-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150424-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150424-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE F. ST. 4.8 X 0.8			
WIRE STRIP LENGTH 3.80-4.56 mm [.150-.180 IN]			INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION			(A)LEAR DATA SHT 25313 Rev-7 - (B)LEAR DATA SHT 25314 Rev-6 -
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
(A) 1949293-1	(A) 25313.213.011	(A) 1949293-7	(A) 25313.417.328
(A) 1949293-2	(A) 25313.213.042	(B) 1572523-1	(B) 25314.123.204
(A) 1949293-3	(A) 25313.213.004	(B) 1572523-2	(B) 25314.123.211
(A) 1949293-4	(A) 25313.123.211	(B) 1572523-3	(B) 25314.213.004
(A) 1949293-5	(A) 25313.123.204	(B) 1572523-4	(B) 25314.417.031
(A) 1949293-6	(A) 25313.417.031		
WIRE SIZE 	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
1.00mm2	1.40+/-0.05 [.055+/-0.002]		8.2
0.75mm2	1.30+/-0.05 [.051+/-0.002]		9.2
0.50mm2	1.25+/-0.05 [.049+/-0.002]		9.7



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 ITEM 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.

6 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

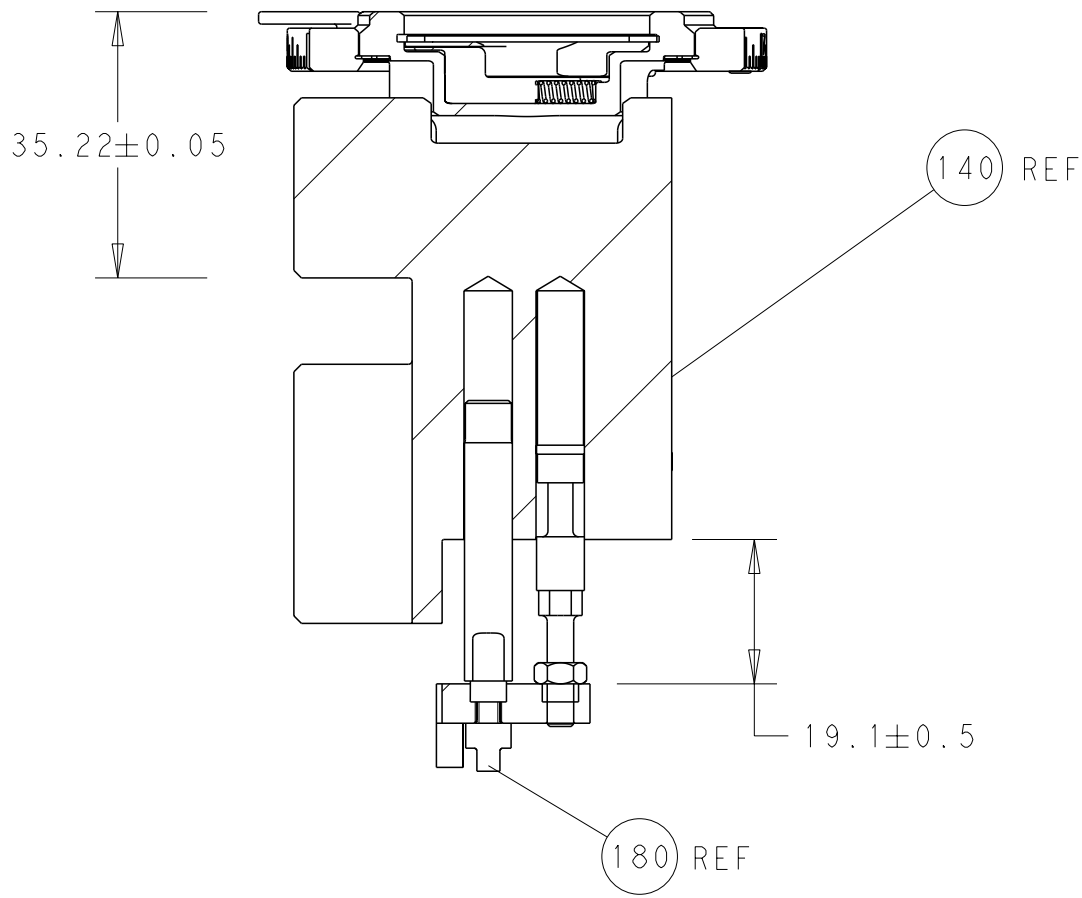
2		1	
LOC	DIST	REVISONS	
A	66	P	LYR
			DESCRIPTION
			DATE
			OWN
			APVD
			SEE SHEET 1

-	1	1	2119082-4	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	1-1976055-0	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	1901681-5	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	-	2063961-9	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	240825-1	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	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1-1633384-3	ANVIL, COMBINATION	8
-	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-1	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	3-456405-7	CRIMPER, WIRE PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE 00779	
MATERIAL -		FINISH -		DRAWING NO C=2150424	
		WEIGHT -		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:1	
				SHEET 3	
				OF 4	
				REV B	

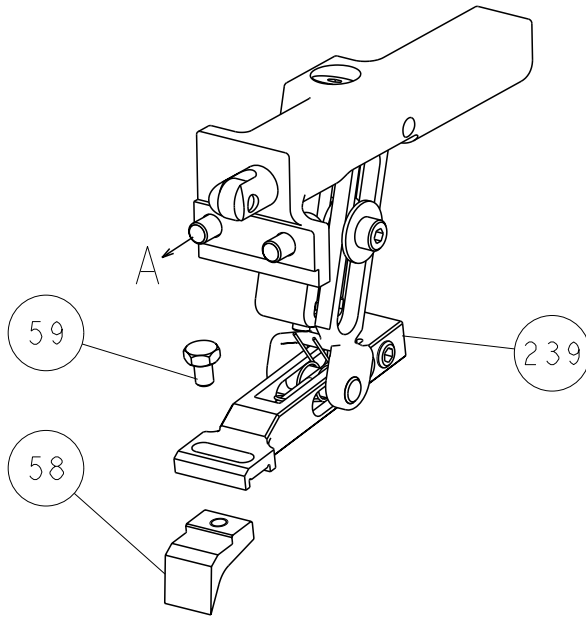
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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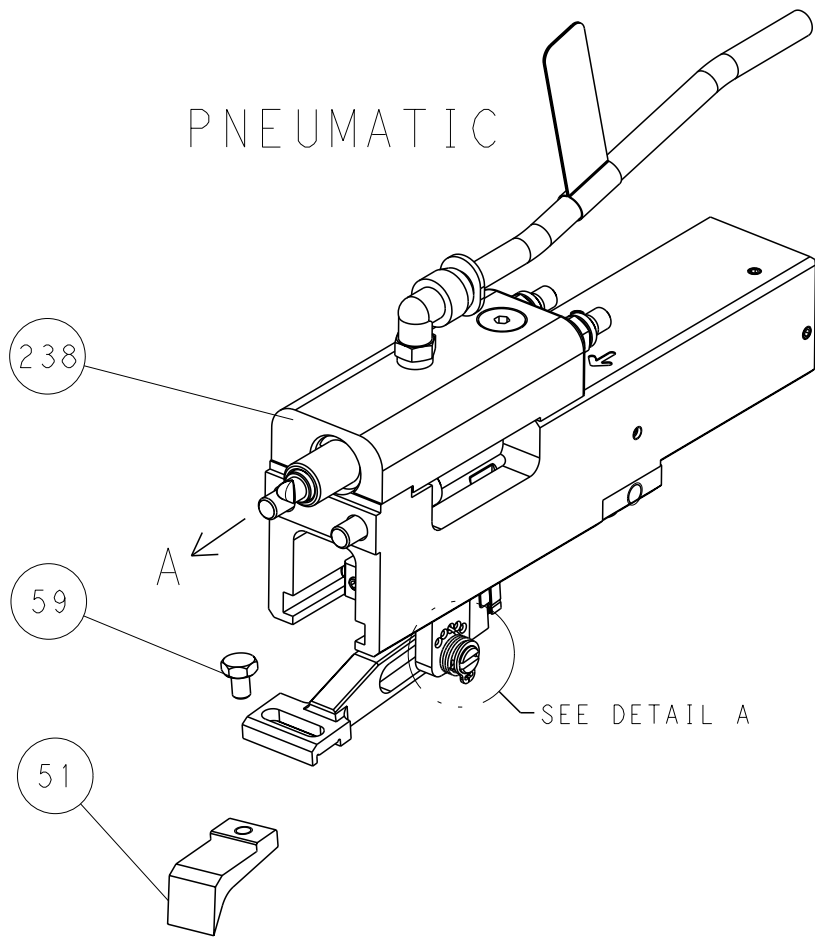


RAM AND HOLDDOWN SET-UP

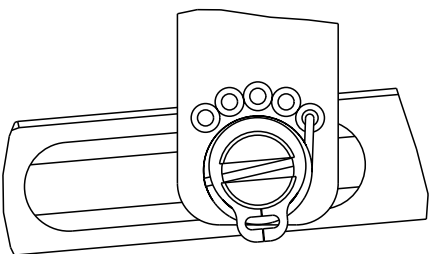
FEED TYPE
MECHANICAL



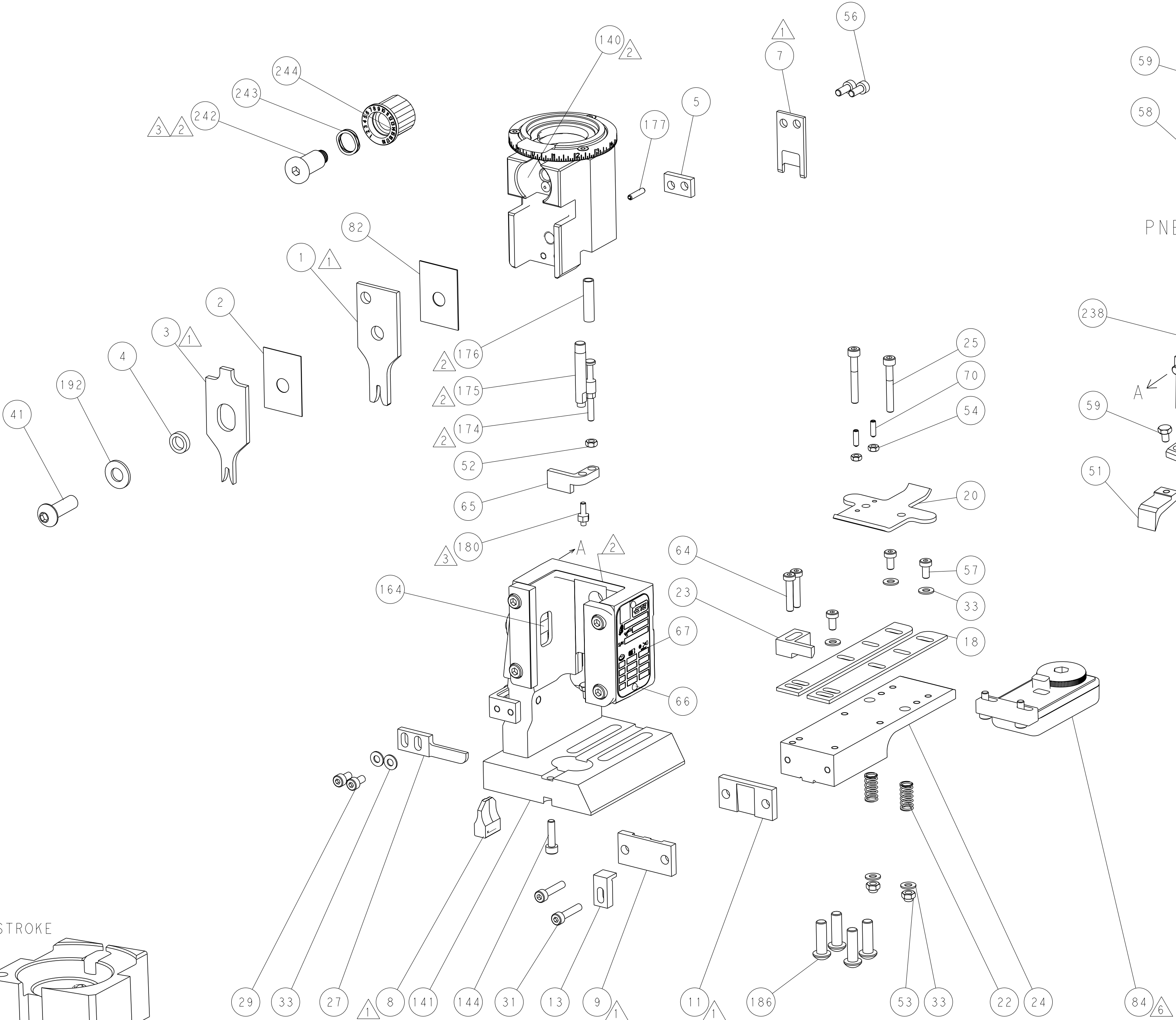
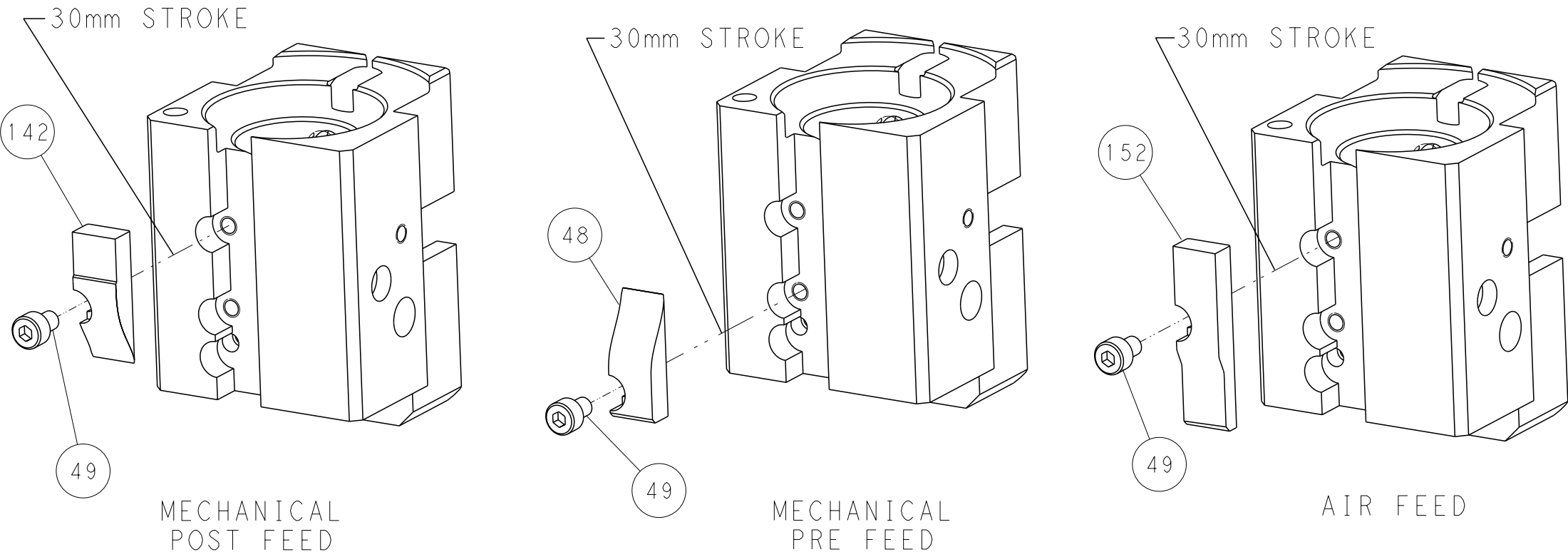
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG	21MAR2014	TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG	21MAR2014		
				APVD J. GUO	21MAR2014	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2150424	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1		SHEET 4	
						OF 4	
						REV B	

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