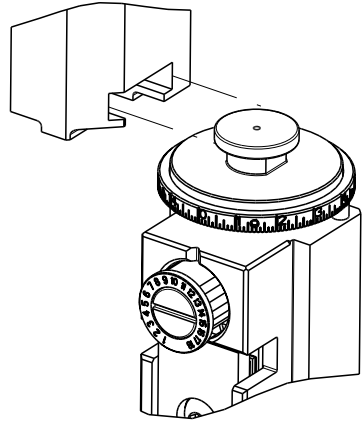


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150274-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150274-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150274-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [.177]	F
INSUL	5.55 mm [.219]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H (LEAR) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 6.00-7.00 mm [.236-.276 IN]		INSULATION DIAMETER RANGE Ø3.40-4.30 mm [.134-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	25235 Rev 16	-	-
TERMINALS APPLIED 			
TE TERMINAL	G&H (LEAR) TERMINAL	TE TERMINAL	G&H (LEAR) TERMINAL
1572522-1	25235.122.014	1572522-6	25235.123.321
1572522-2	25235.123.014	1572522-7	25235.123.322
1572522-3	25235.122.323	1572522-8	25235.212.179
1572522-4	25235.123.009	1572522-9	25235.213.009
1572522-5	25235.123.011	1-1572522-0	25235.213.011
		1-1572522-1	25235.213.321

WIRE SIZE	 CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.15+/-0.10 [.124+/- .004]	5.9
4.00mm2	2.95+/-0.10 [.116+/- .004]	8.1



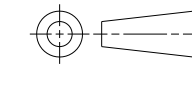
-  RECOMMENDED SPARE PARTS
-  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

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

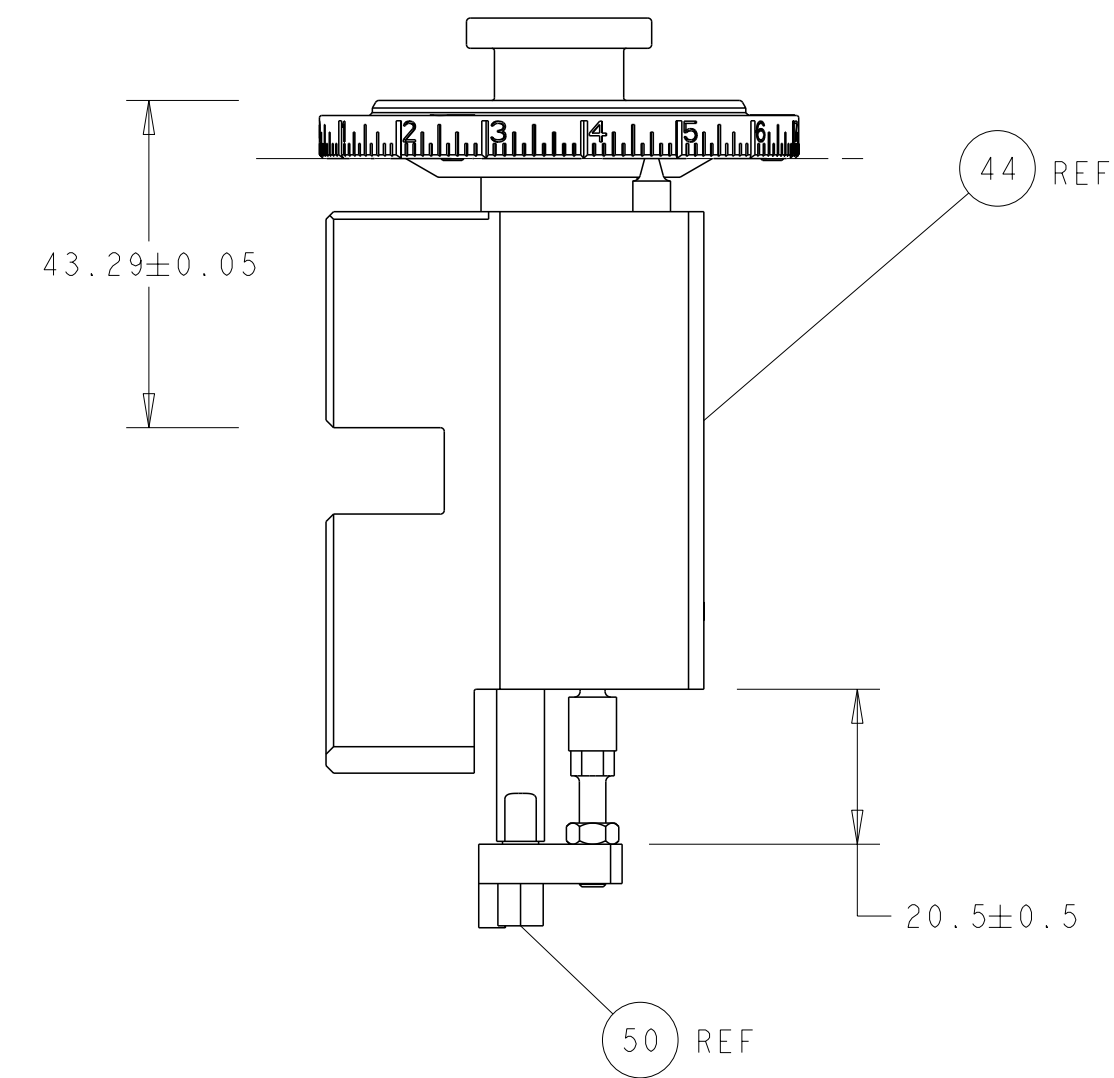
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LOC	DIST	REVISIONS					
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		B		ECR-21-004087	06APR2021	LG	TE
		C		ECR-21-004087	20APR2021	JWC	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-9931111-6	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
 -	1	1	2063961-1	FEED FINGER	51
-	1	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	690455-9	STRIPPER, FRONT CASTING	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	1803292-1	DRAG	20
-	1	1	4-1901696-6	STRIP GUIDE, REAR	19
-	1	1	4-1901695-6	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	4-240641-5	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
 -	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
 -	1	1	690482-4	PLATE, FRONT SHEAR	9
 1	2	1	5-1803059-2	ANVIL, COMBINATION, END FEED	8
 -	1	1	1-2217206-2	BLADE, SLUG	7
-	1	1	7-240641-5	SPACER	5
-	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
 1	2	1	1-1803221-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
 1	2	1	7-1673600-7	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO
				DESCRIPTION	

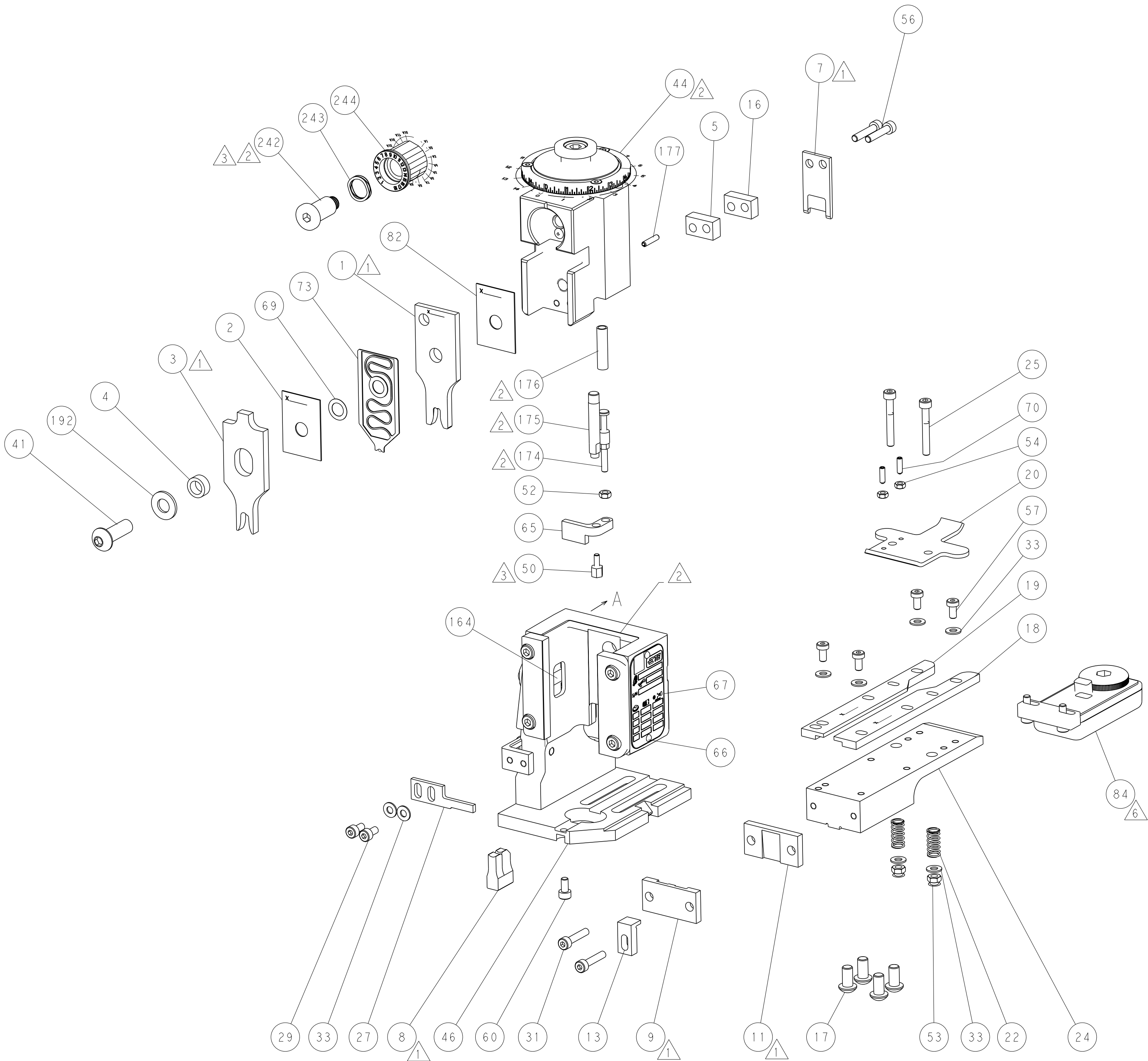
THIS DRAWING IS CONTROLLED. ANY CHANGES TO THIS DRAWING FOR THE LATEST REVISION SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN L. ZHANG 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		CHK L. ZHANG 25JUL2012	NAME Ocean End Feed Applicator		
		APVD S. XI 25JUL2012	PRODUCT SPEC		
			APPLICATION SPEC		
MATERIAL -			SIZE A1		
			CASE CODE 00779		
			DRAWING NO C=2150274		
			RESTRICTED TO		
			CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
			SCALE 1:1		
			SHEET 1 of 4		
			REV C		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

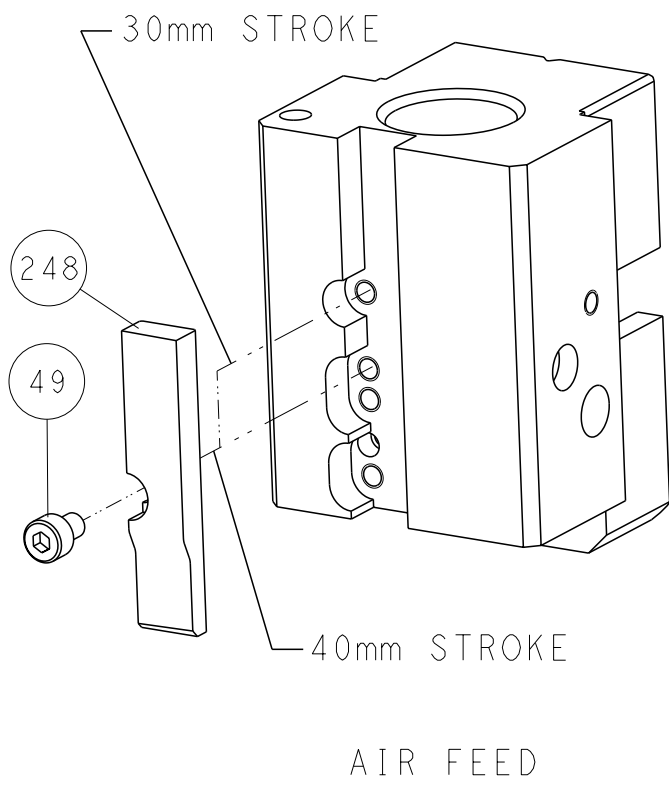
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



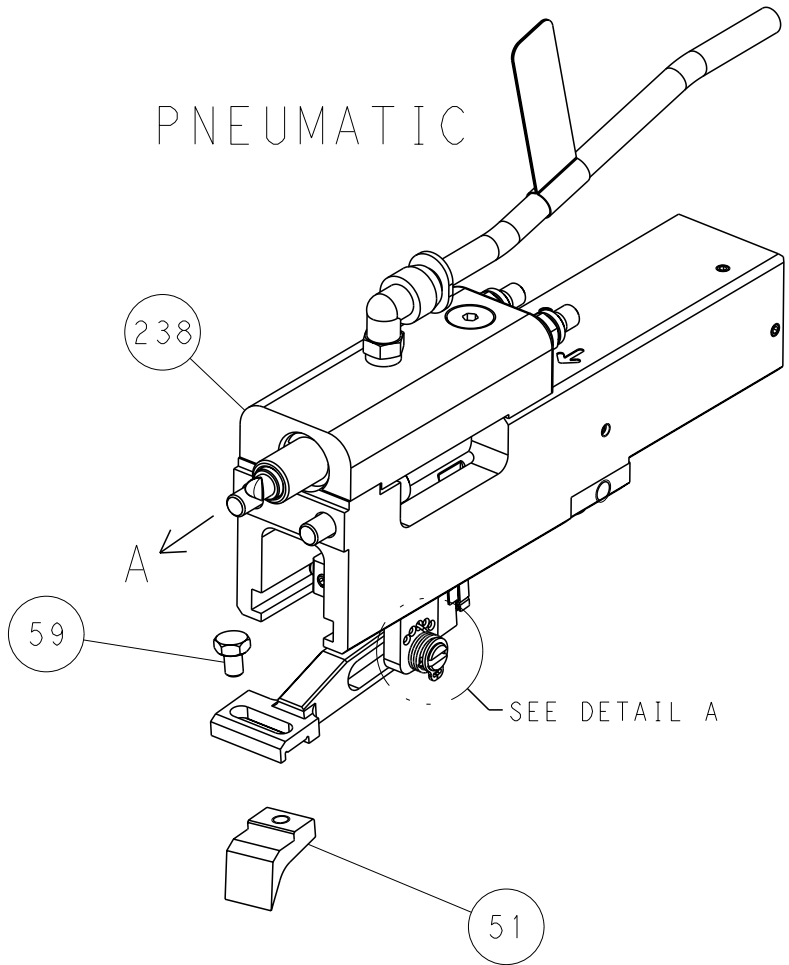
CAM POSITION



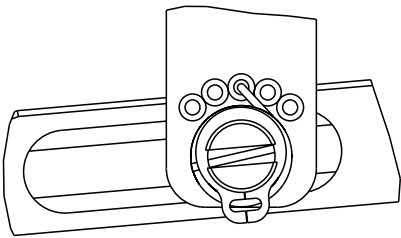
AIR FEED

FEED TYPE

PNEUMATIC



FEED SPRING
SETTING POSITION



DETAIL A

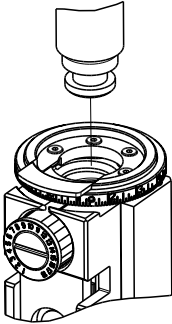
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN L. ZHANG 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG 25JUL2012		
				APVD S. YI 25JUL2012	NAME Ocean End Feed Applicator	
DIMENSIONS: mm				PRODUCT SPEC		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APPLICATION SPEC		
MATERIAL				WEIGHT	SIZE A1	
					CAGE CODE 00779	
					DRAWING NO C=2150274	
					RESTRICTED TO	
					CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
					SCALE 1:1	
					SHEET 2	
					OF 4	
					REV C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150274-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150274-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [1.177]	F
INSUL	5.55 mm [1.219]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H (LEAR) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 6.00-7.00 mm [1.236-1.276 IN]		INSULATION DIAMETER RANGE Ø3.40-4.30 mm [1.134-1.169 IN]	
TERMINAL APPLICATION SPECIFICATION		25235 Rev 16	
TERMINALS APPLIED		- - - -	
TE TERMINAL	G&H (LEAR) TERMINAL	TE TERMINAL	G&H (LEAR) TERMINAL
1572522-1	25235-122.014	1572522-6	25235.123.321
1572522-2	25235.123.014	1572522-7	25235.123.322
1572522-3	25235.122.323	1572522-8	25235.212.179
1572522-4	25235.123.009	1572522-9	25235.213.009
1572522-5	25235.123.011	1-1572522-0	25235.213.011
		1-1572522-1	25235.213.321
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
6.00mm2	3.15+/-0.10 [1.124+/-0.04]	5.9	
4.00mm2	2.95+/-0.10 [1.116+/-0.04]	8.1	



- 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 50. 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 TERMINAL LUBRICANT IS RECOMMENDED.

7. 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)

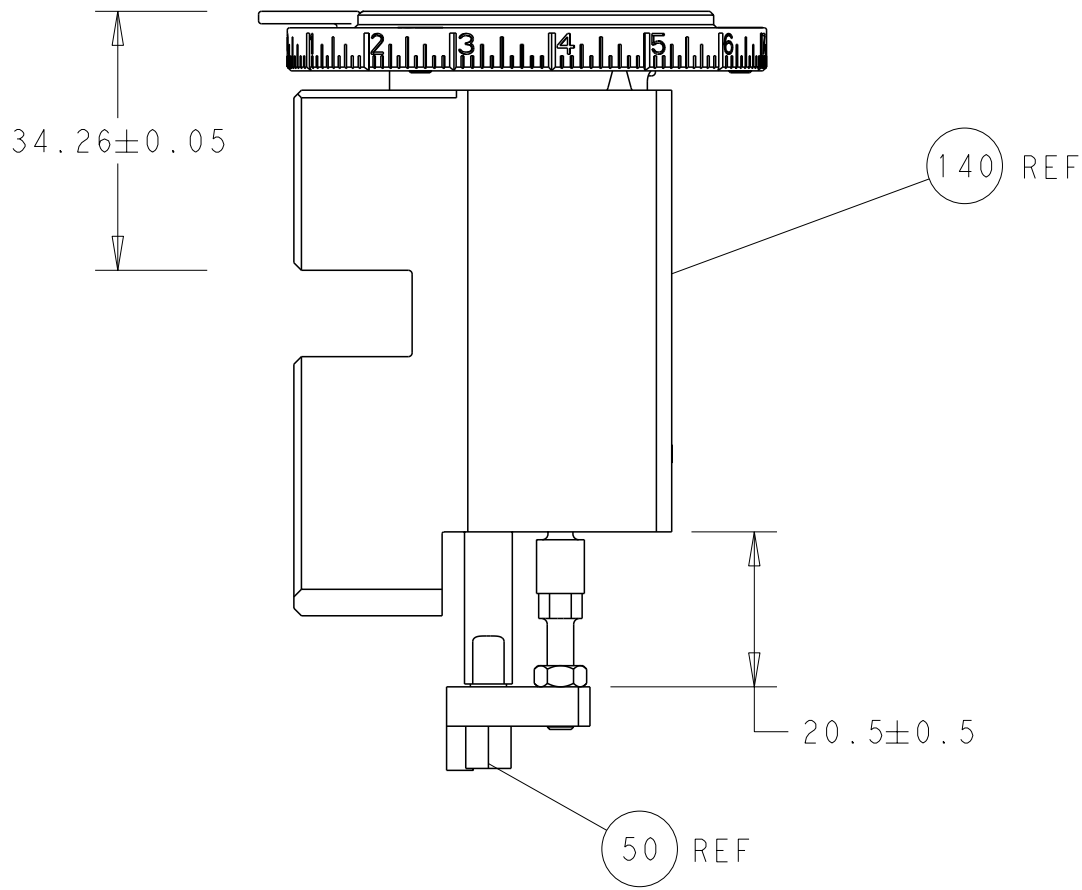
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-4	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
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-1	FEED FINGER	51
-	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	690455-9	STRIPPER, FRONT CASTING	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	1803292-1	DRAG	20
-	1	4-1901696-6	STRIP GUIDE, REAR	19
-	1	4-1901695-6	STRIP GUIDE, FRONT	18
-	1	4-240641-5	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-4	PLATE, FRONT SHEAR	9
1	1	5-1803059-2	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-2	BLADE, SLUG	7
-	1	7-240641-5	SPACER	5
-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1-1803221-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	7-1673600-7	CRIMPER, WIRE	1
-	77	22	PART NO	ITEM NO

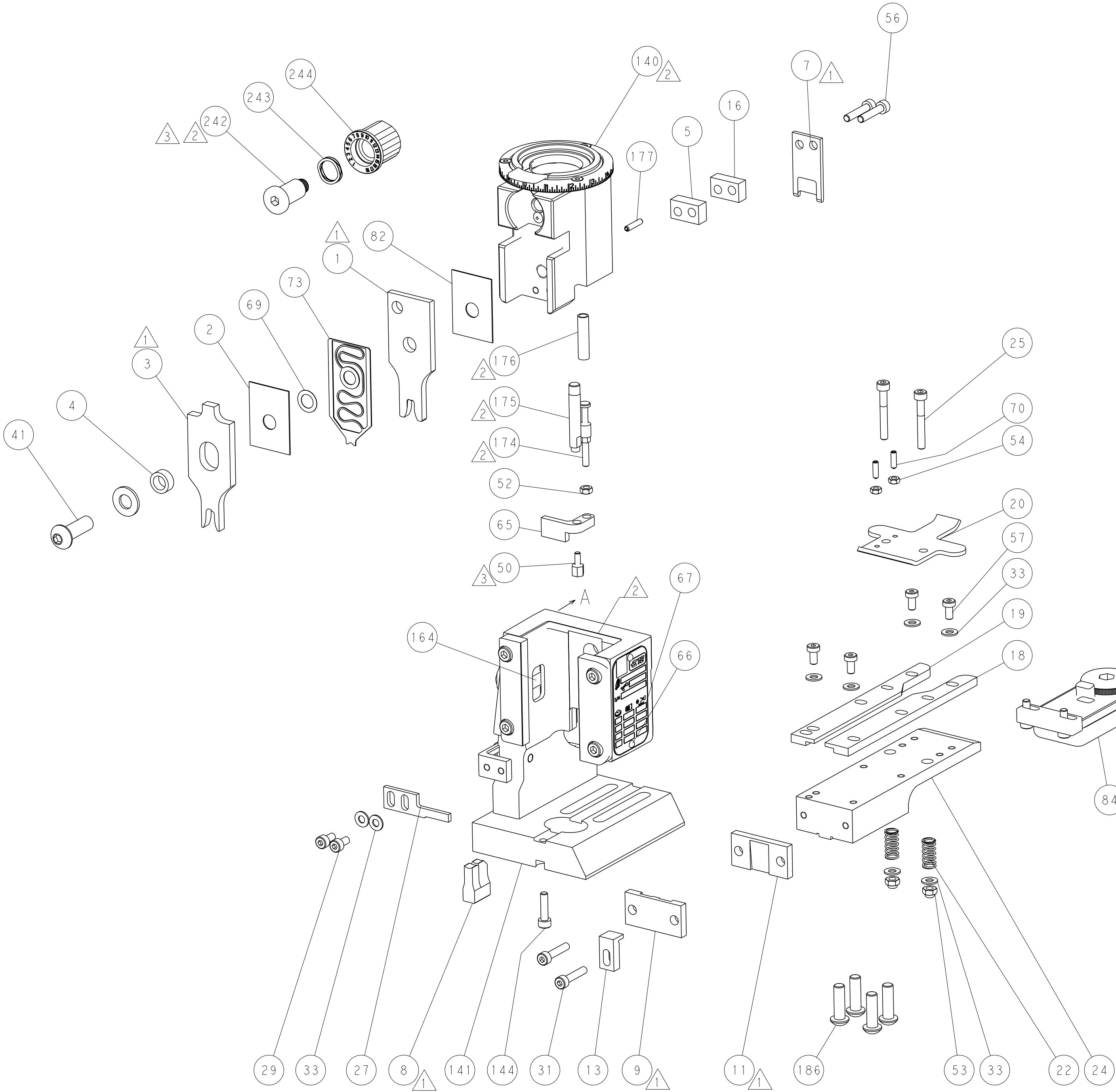
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK L. ZHANG 25JUL2012	NAME Ocean End Feed Applicator				
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APVD S. YI 25JUL2012	PRODUCT SPEC - APPLICATION SPEC -				
MATERIAL -		ANGLES FINISH -		WEIGHT -	SIZE A1		CASE CODE 00779	DRAWING NO C=2150274	RESTRICTED TO
CUSTOMER ACCESSIBLE PRODUCTION DRAWING					SCALE 1:1		SHEET 3 of 4		REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

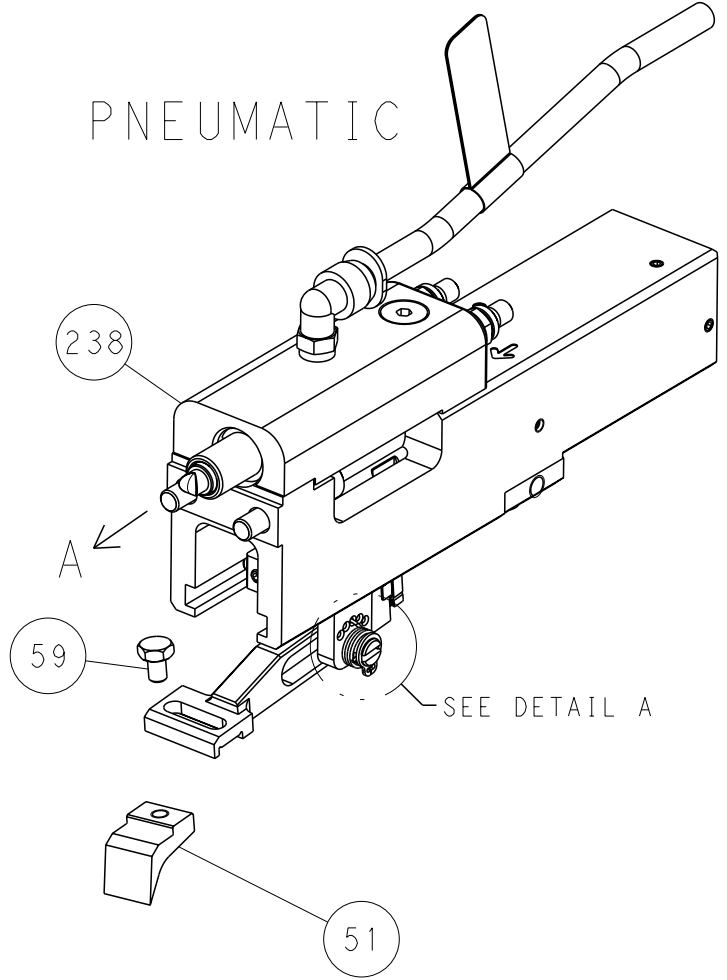


RAM AND HOLDDOWN SET-UP

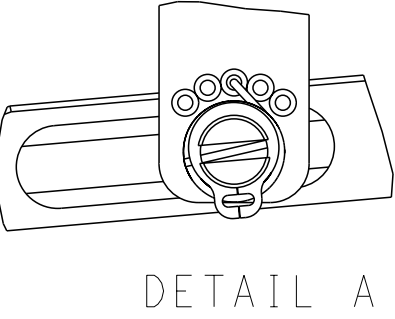


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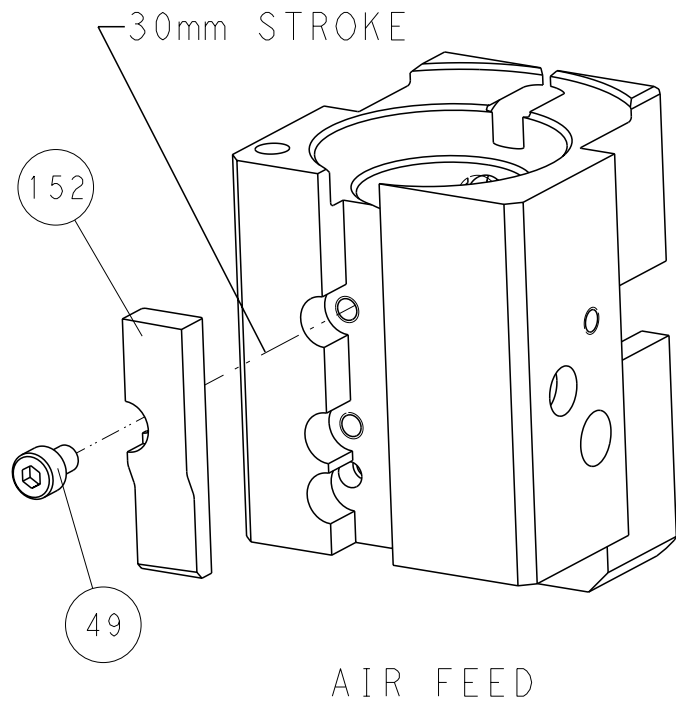
PNEUMATIC



FEED SPRING SETTING POSITION



CAM POSITION



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 SHALL BE CONTACTED FOR THE LATEST REVISION				DWN L. ZHANG 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608			
				CHK L. ZHANG 25JUL2012				
				APVD S. YI 25JUL2012	NAME Ocean End Feed Applicator			
				PRODUCT SPEC				
				APPLICATION SPEC				
				WEIGHT				
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING				
				SCALE 1:1				
				SHEET 4				
				OF 4				
				REV C				

Mouser Electronics

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