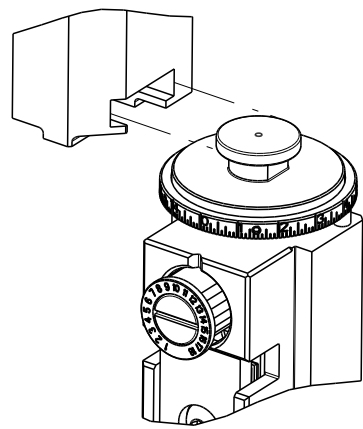


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150646-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150646-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150646-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TYPE			
WIRE STRIP LENGTH 6.10-6.90 mm [.240-.272 IN]		INSULATION DIAMETER RANGE Ø3.30-5.00 mm [.130-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	25231 Rev 9	-	-
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949266-1	25231.212.004	1949266-2	25231.212.011
1949266-3	25231.212.179	1949266-4	25231.212.320
1949266-5	25231.122.009	1949266-6	25231.122.011
1949266-7	25231.122.014	1949266-8	25231.122.322
1949266-9	25231.122.323	1-1949266-0	25231.411.131
1-1949266-1	25231.211.XXX	1-1949266-2	25231.213.XXX
1-1949266-3	25231.201.XXX	1-1949266-4	25231.123.XXX
1-1949266-5	25231.111.XXX	1-1949266-6	25231.214.XXX
1-1949266-7	25231.331.XXX	2303636-1	25229.111.XXX
2303636-2	25229.122.XXX	2303636-3	25229.123.XXX
2303636-4	25229.201.XXX	2303636-5	25229.212.XXX
2303636-6	25229.213.XXX	2303636-7	25229.214.XXX
2303636-8	25229.221.XXX	2303636-9	25229.331.XXX
1-2303636-0	25229.411.XXX		

*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.

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		3.15+/-0.10 [.124+/- .004]		4.0
10 AWG		3.10+/-0.10 [.122+/- .004]		4.2
4.0mm2 + 0.75mm2		3.05+/-0.10 [.120+/- .004]		4.3
(2) 2.5mm2		3.00+/-0.10 [.118+/- .004]		4.8
4.00mm2		2.95+/-0.10 [.116+/- .004]		5.1
12 AWG		2.80+/-0.05 [.110+/- .002]		7.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

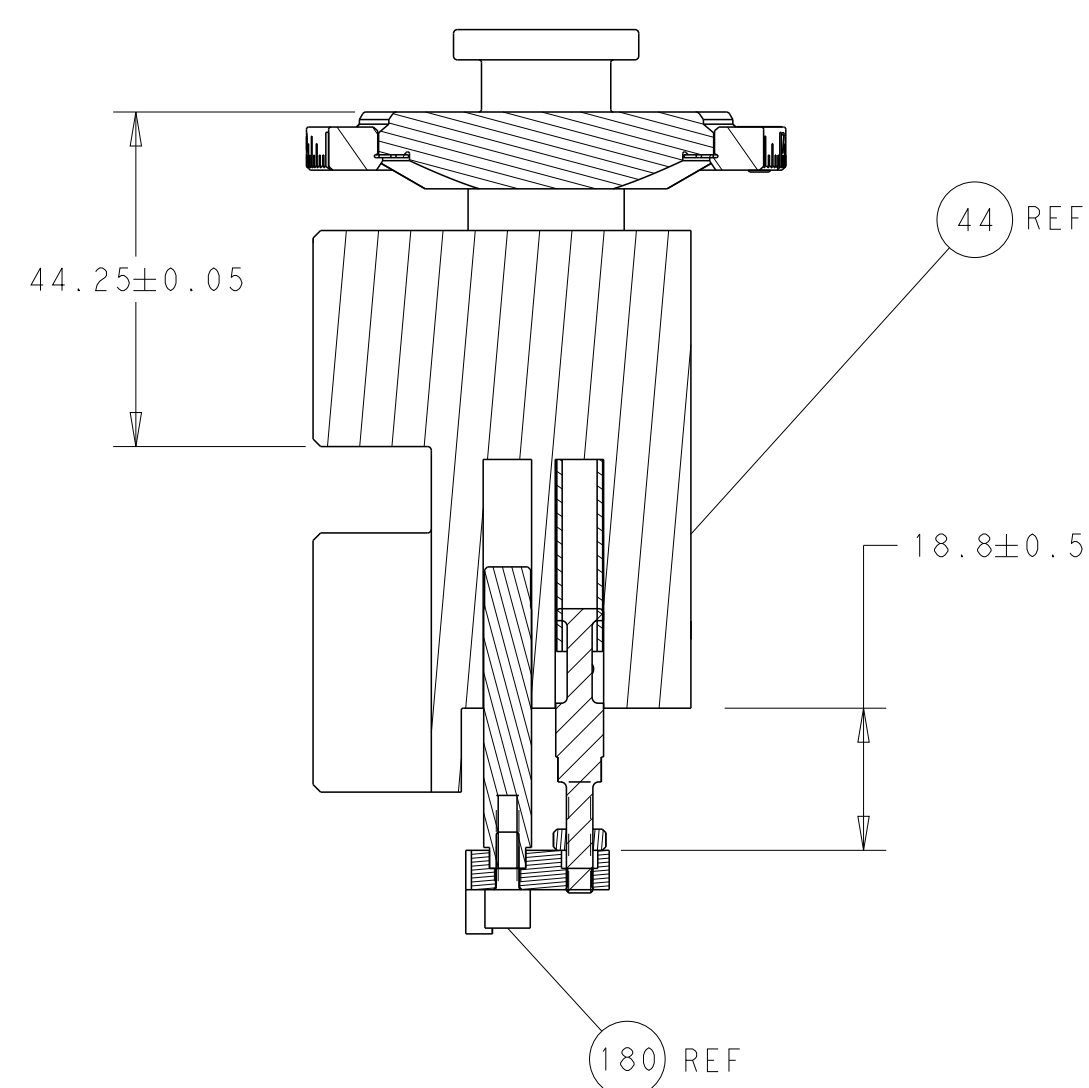
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	22APR2016	MR	GB
			A1	ECR-16-010865	1AUG2016	RS	LZ
			B	ECR-18-017784	13NOV2018	TB	CT
			C	ECR-21-004030	05APR2021	LG	TE

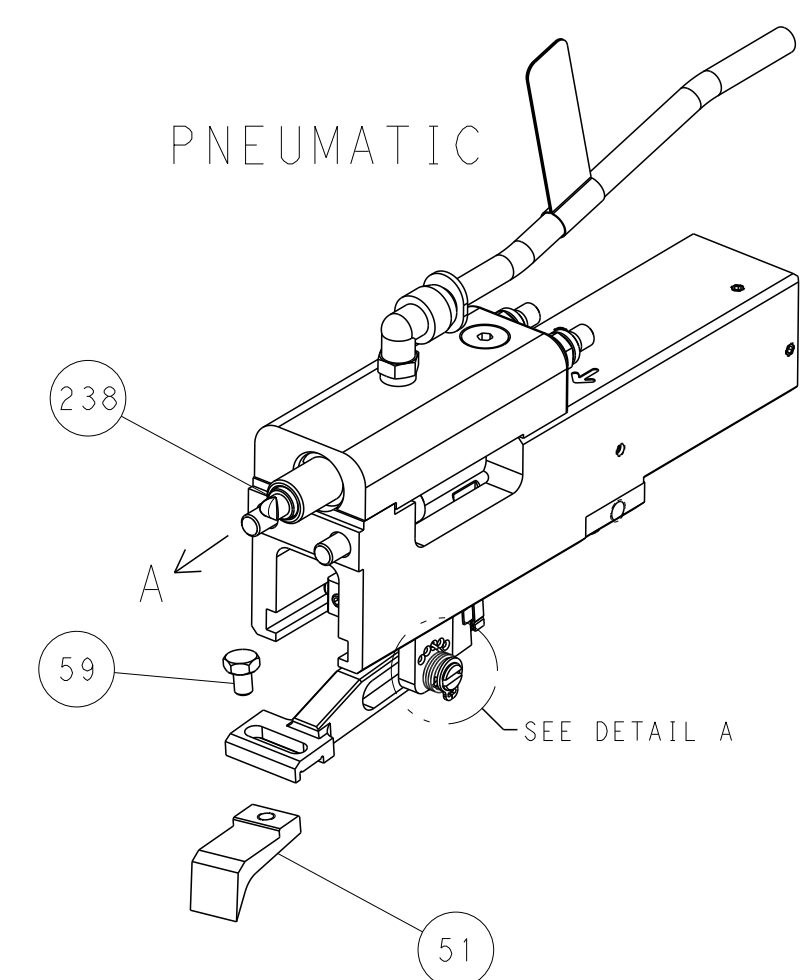
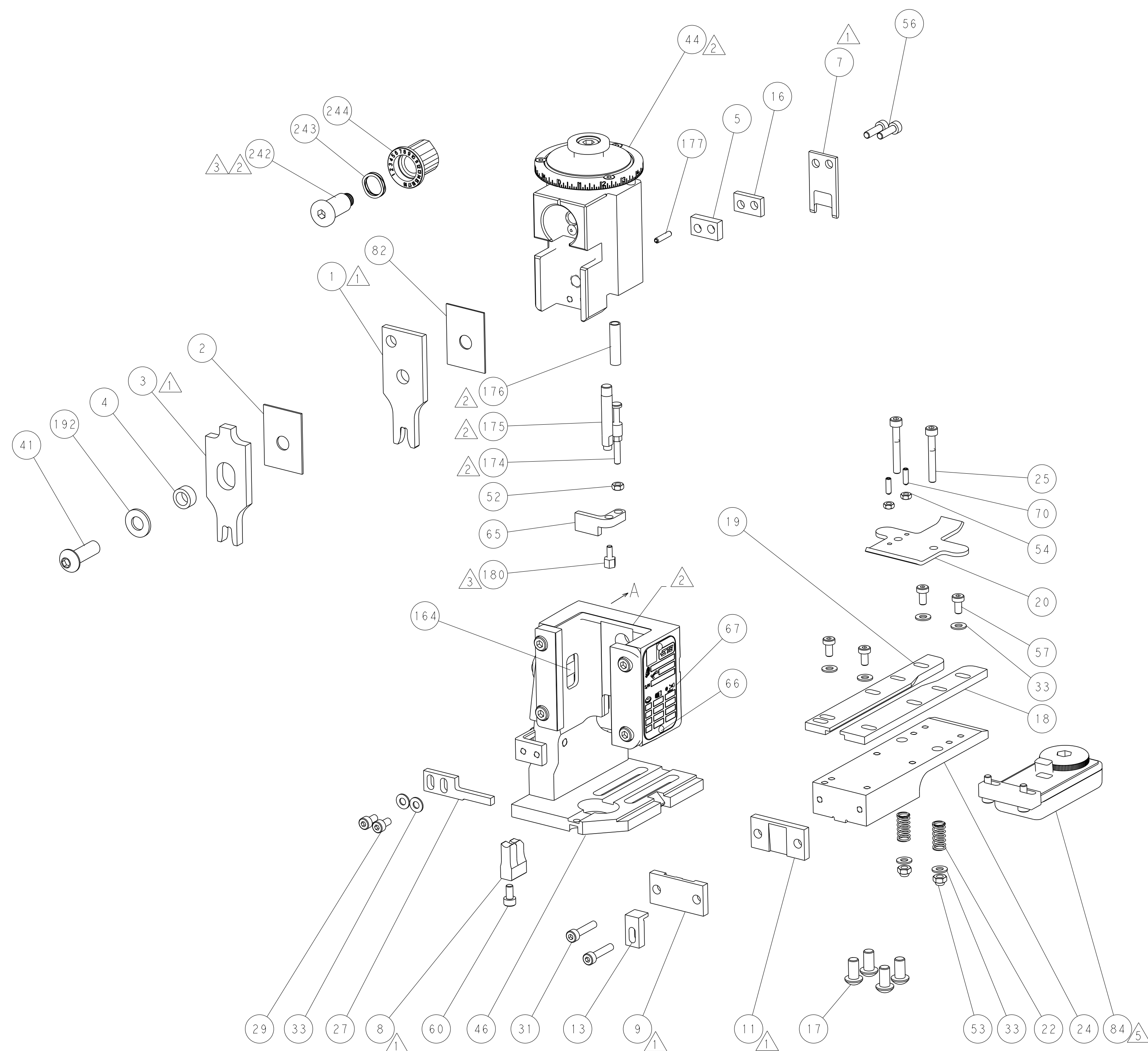
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-4	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1752354-5	STANDOFF,HOLD-DOWN	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
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-7	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	1901681-1	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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	690455-3	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1752371-1	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	3-1901696-5	STRIP GUIDE, REAR	19
	-	1	1	3-1901695-5	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	240641-1	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	4-1803059-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	2-240641-9	SPACER	5
	-	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	9-1803016-0	CRIMPER, INSULATION F	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	1	6-1803188-9	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.		DWN	X.ZHAO	10MAR2016	TE Connectivity Harrisburg, PA 17105-3608						
DIMENSIONS:		CHK	L.ZHANG	10MAR2016	NAME						
mm		APVD	L.ZHANG	10MAR2016	PRODUCT SPEC						
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC							
MATERIAL		FINISH		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
-		-		-		A	00779	C=2150646	-		
Customer Accessible Production Drawing						SCALE	1:1	SHEET	1	OF 4	REV C

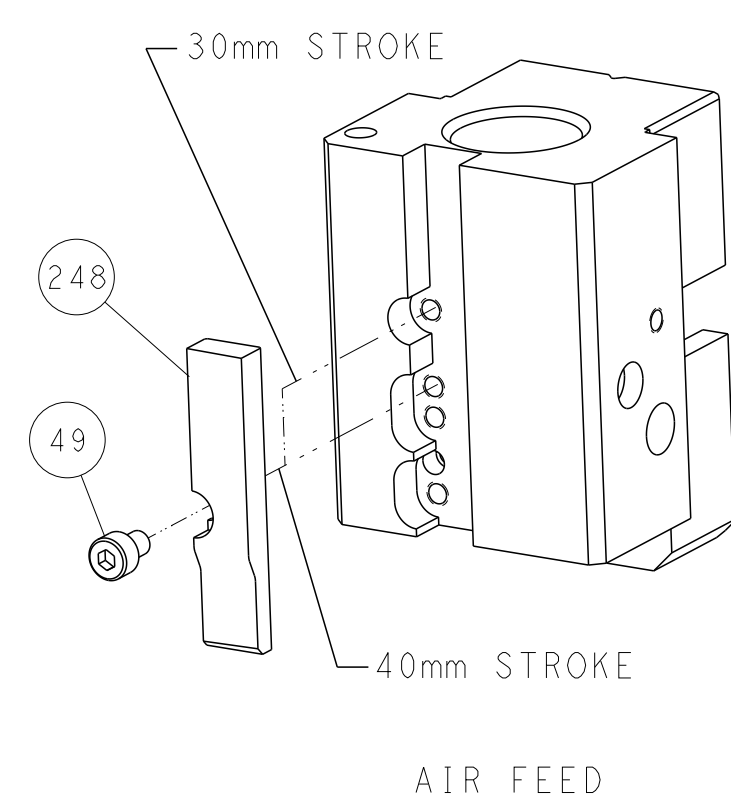
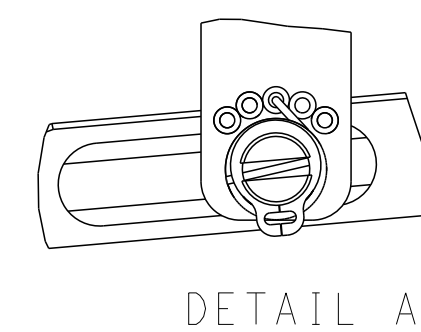
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



RAM AND HOLDDOWN SET-UP



FEED SPRING
SETTING POSITION



CAM POSITION

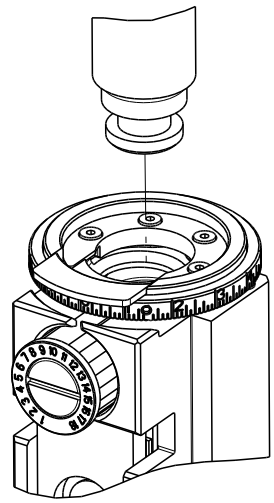
AIR FEED

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

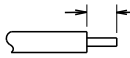
THIS DRAWING IS A CONTROLLED DOCUMENT FOR FPD ELECTRONICS CORPORATION 17-15-2009-01 THIS DRAWING IS THE PROPERTY OF FPD ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: 10MAR2016 CHK: 10MAR2016 APVD: 10MAR2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150646	
MATERIAL: FINISH:		WEIGHT: -		RESTRICTED TO: -	
Customer Accessible Production Drawing					
				SCALE: 1:1 SHEET: 2 of 4 REV: C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150646-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150646-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TYPE			
WIRE STRIP LENGTH 6.10-6.90 mm [.240-.272 IN]			INSULATION DIAMETER RANGE Ø3.30-5.00 mm [.130-.197 IN]
TERMINAL APPLICATION SPECIFICATION	25231 Rev 9	-	-
TERMINALS APPLIED 			
			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949266-1	25231.212.004	1949266-2	25231.212.011
1949266-3	25231.212.179	1949266-4	25231.212.320
1949266-5	25231.122.009	1949266-6	25231.122.011
1949266-7	25231.122.014	1949266-8	25231.122.322
1949266-9	25231.122.323	1-1949266-0	25231.411.131
1-1949266-1	25231.211.XXX	1-1949266-2	25231.213.XXX
1-1949266-3	25231.201.XXX	1-1949266-4	25231.123.XXX
1-1949266-5	25231.111.XXX	1-1949266-6	25231.214.XXX
1-1949266-7	25231.331.XXX	2303636-1	25229.111.XXX
2303636-2	25229.122.XXX	2303636-3	25229.123.XXX
2303636-4	25229.201.XXX	2303636-5	25229.212.XXX
2303636-6	25229.213.XXX	2303636-7	25229.214.XXX
2303636-8	25229.221.XXX	2303636-9	25229.331.XXX
1-2303636-0	25229.411.XXX		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.15+/-0.10 [.124+/- .004]	4.0
10 AWG	3.10+/-0.10 [.122+/- .004]	4.2
4.0mm2 + 0.75mm2	3.05+/-0.10 [.120+/- .004]	4.3
(2) 2.5mm2	3.00+/-0.10 [.118+/- .004]	4.8
4.00mm2	2.95+/-0.10 [.116+/- .004]	5.1
12 AWG	2.80+/-0.05 [.110+/- .002]	7.0



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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

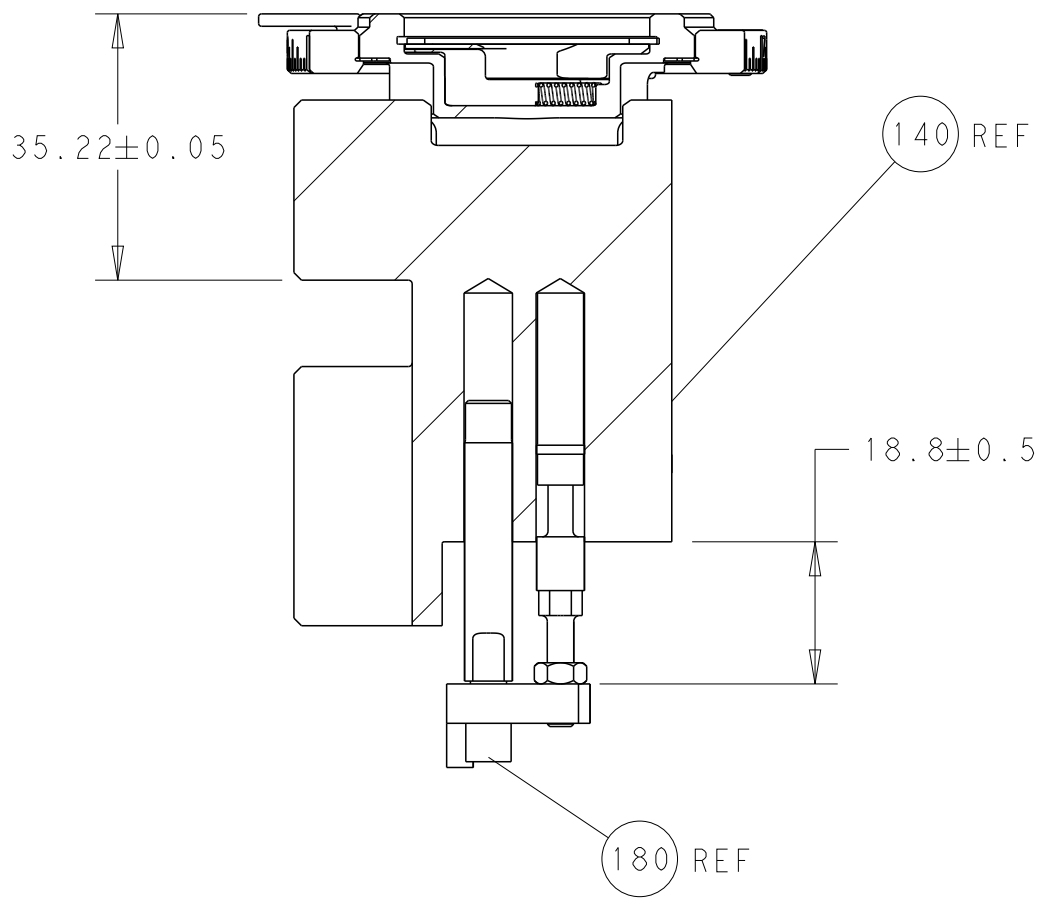
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1752354-5	STANDOFF,HOLD-DOWN	180
	-	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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-7	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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	690455-3	STRIPPER, FRONT CASTING	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1752371-1	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	1	3-1901696-5	STRIP GUIDE, REAR	19
	-	1	3-1901695-5	STRIP GUIDE, FRONT	18
	-	1	240641-1	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	4-1803059-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	6
	-	1	2-240641-9	SPACER	5
	-	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	9-1803016-0	CRIMPER, INSULATION F	3
	-	1	455888-9	SPACER, CRIMPER	2
1	1	1	6-1803188-9	CRIMPER, WIRE	1
-77-22			PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT AND ITS CONTENTS ARE UNCLASSIFIED UNLESS INDICATED OTHERWISE. IT IS SUBJECT TO CONTROLLED DOCUMENTATION AND TESTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN X.ZHAO CHK L.ZHANG APVD L.ZHANG	10MAR2016 10MAR2016 10MAR2016	STE 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	
MATERIAL -		WEIGHT -		SIZE A	CAGE CODE 00779
				DRAWING NO C=2150646	RESTRICTED TO -
				Customer Accessible Production Drawing	SCALE 1:1
				SHEET 3	OF 4
				REV C	

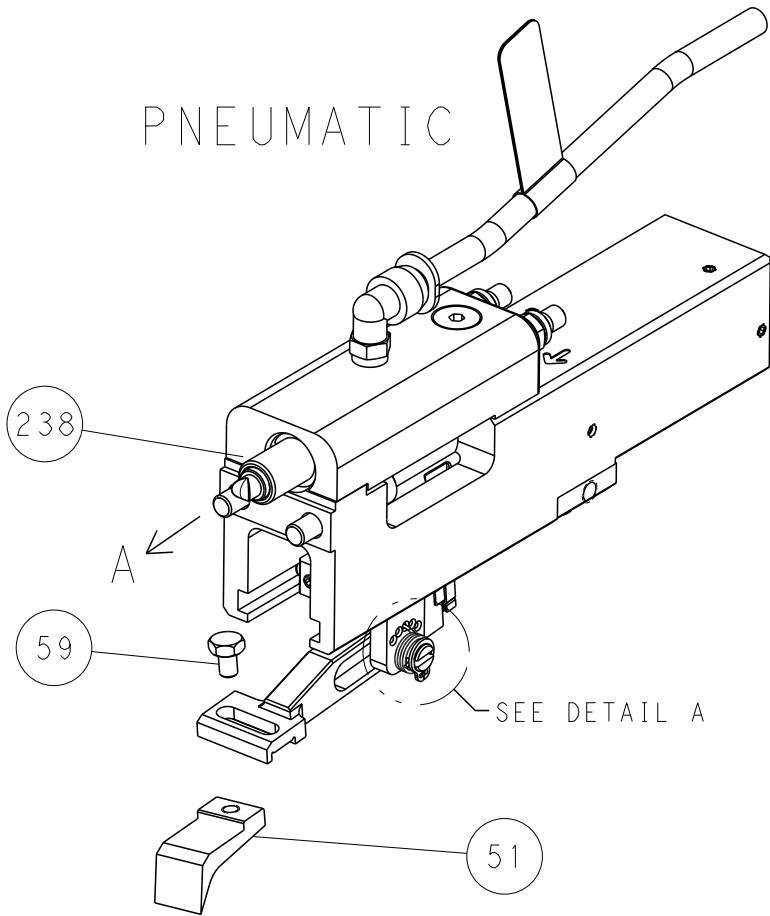
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

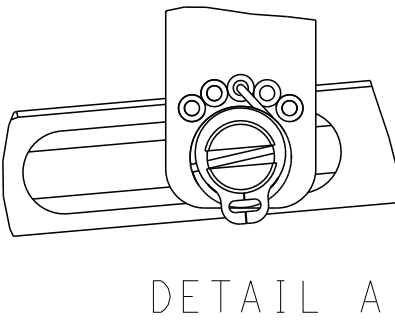


RAM AND HOLDDOWN SET-UP

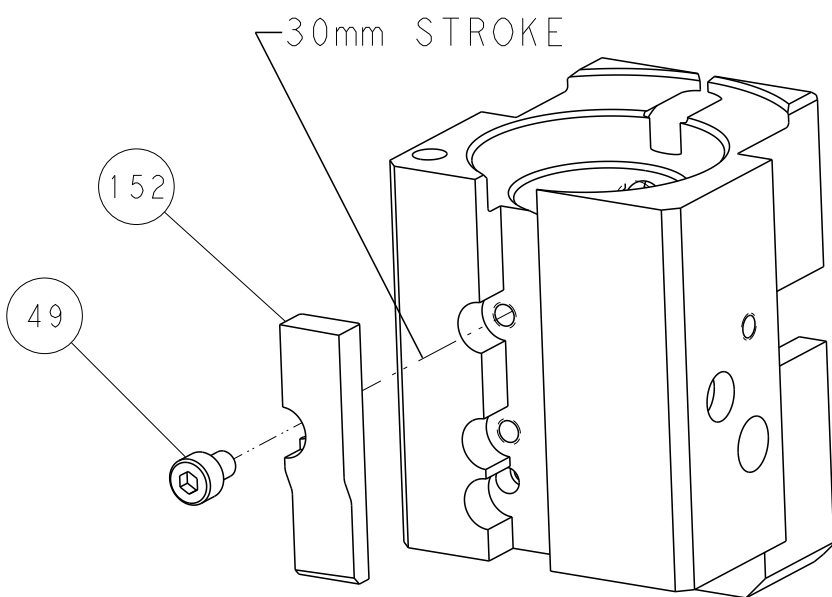
FEED TYPE



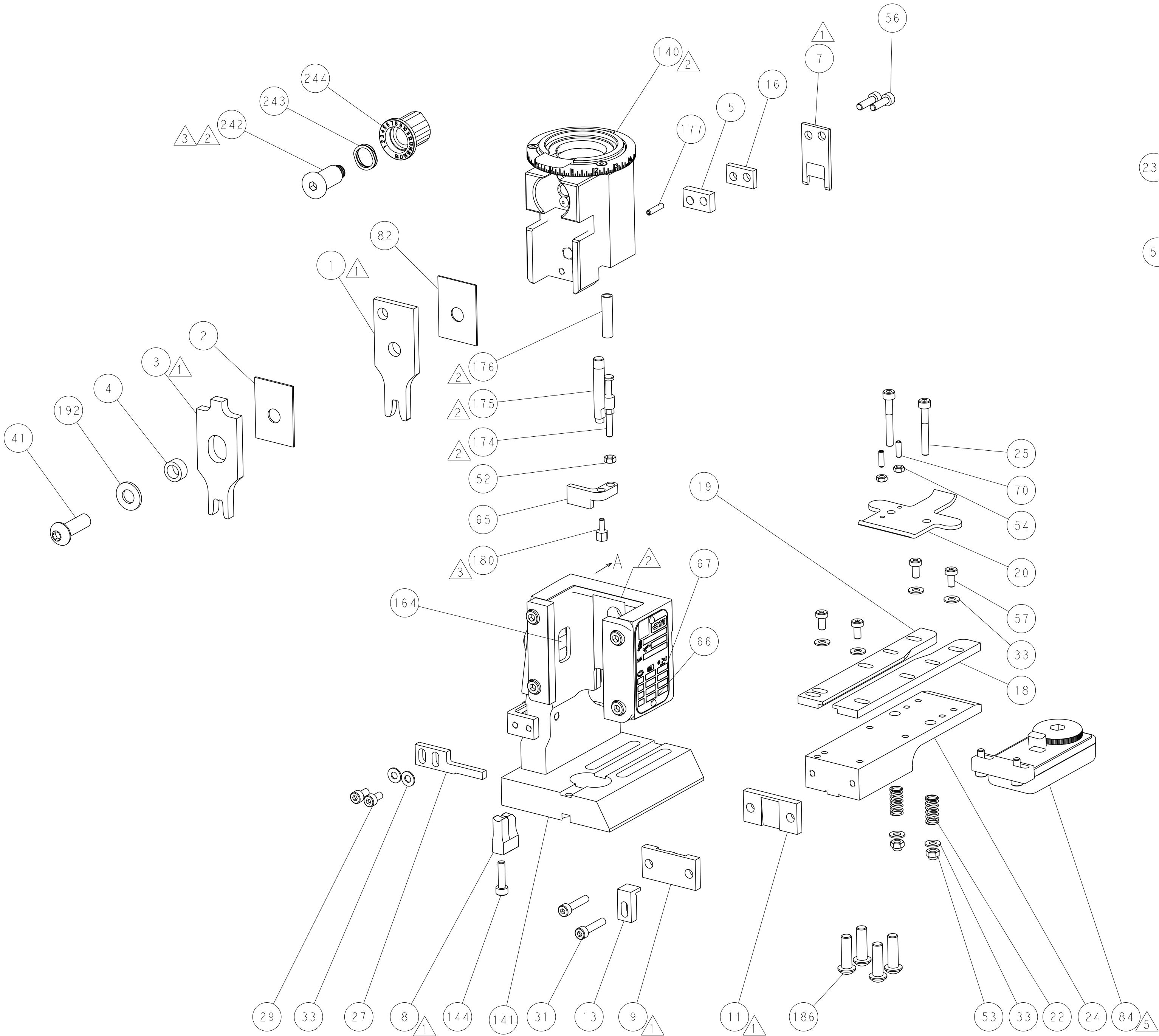
FEED SPRING SETTING POSITION



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)

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										CHK		L. ZHANG	10MAR2016										
										APVD		L. ZHANG	10MAR2016	NAME		Ocean End Feed Applicator							
										PRODUCT SPEC				-									
										APPLICATION SPEC													
										WEIGHT				SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
										-				A1		00779		C=2150646		-			
Customer Accessible Production Drawing														SCALE		1:1		SHEET		4 OF 4		REV C	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[7-2150646-7](#)