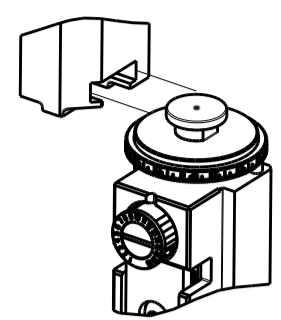


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150492-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150492-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150492-7	A	CRIMP TOOLING KIT	-

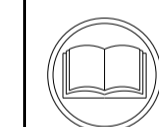
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	5.65 mm [.222]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.20-6.80 mm [.244-.268 IN]		∅3.56-4.75 mm [1.40-.187 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR SPEC 25237 Rev 7		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949580-1	25237.123.011	1949580-2	25237.XXX.YYY

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.15 +/- 0.1 [.124 +/- .004]	7.3
4.00mm2	2.95 +/- 0.1 [.116 +/- .004]	9.6



- 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.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

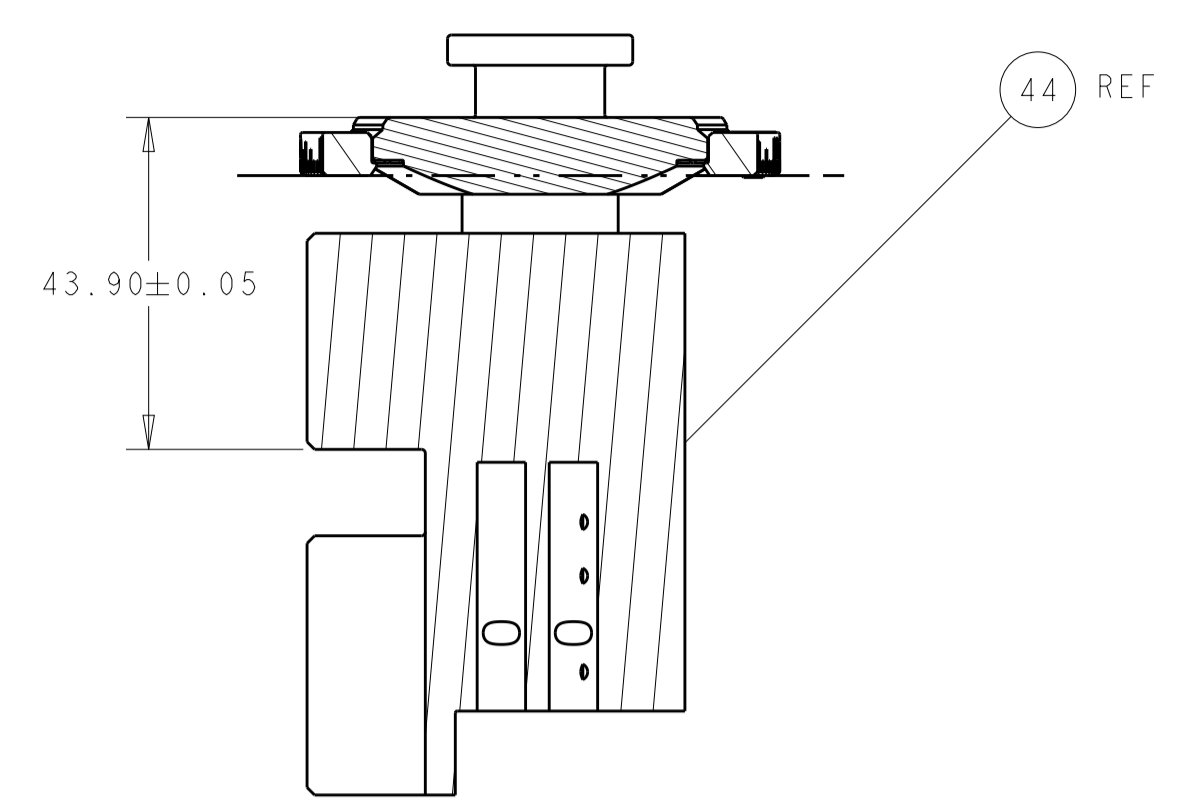
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		REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-15-003715	06MAR2015	MR	GB
		B1		ECR-18-009996	28JUN2018	FL	CT
		C		ECR-19-014148	10SEP2019	FJ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-2	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-4	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-2063961-0	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	7-1901696-3	STRIP GUIDE, REAR	19	
-	1	1	7-1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	7-240641-2	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	2	1	5-1803000-9	ANVIL, COMBINATION, END FEED	8
-	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	7-240641-7	SPACER	5	
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
-	1	2	1	7-1633962-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-5	SPACER, CRIMPER	2	
-	1	2	1	456428-1	CRIMPER, WIRE	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

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

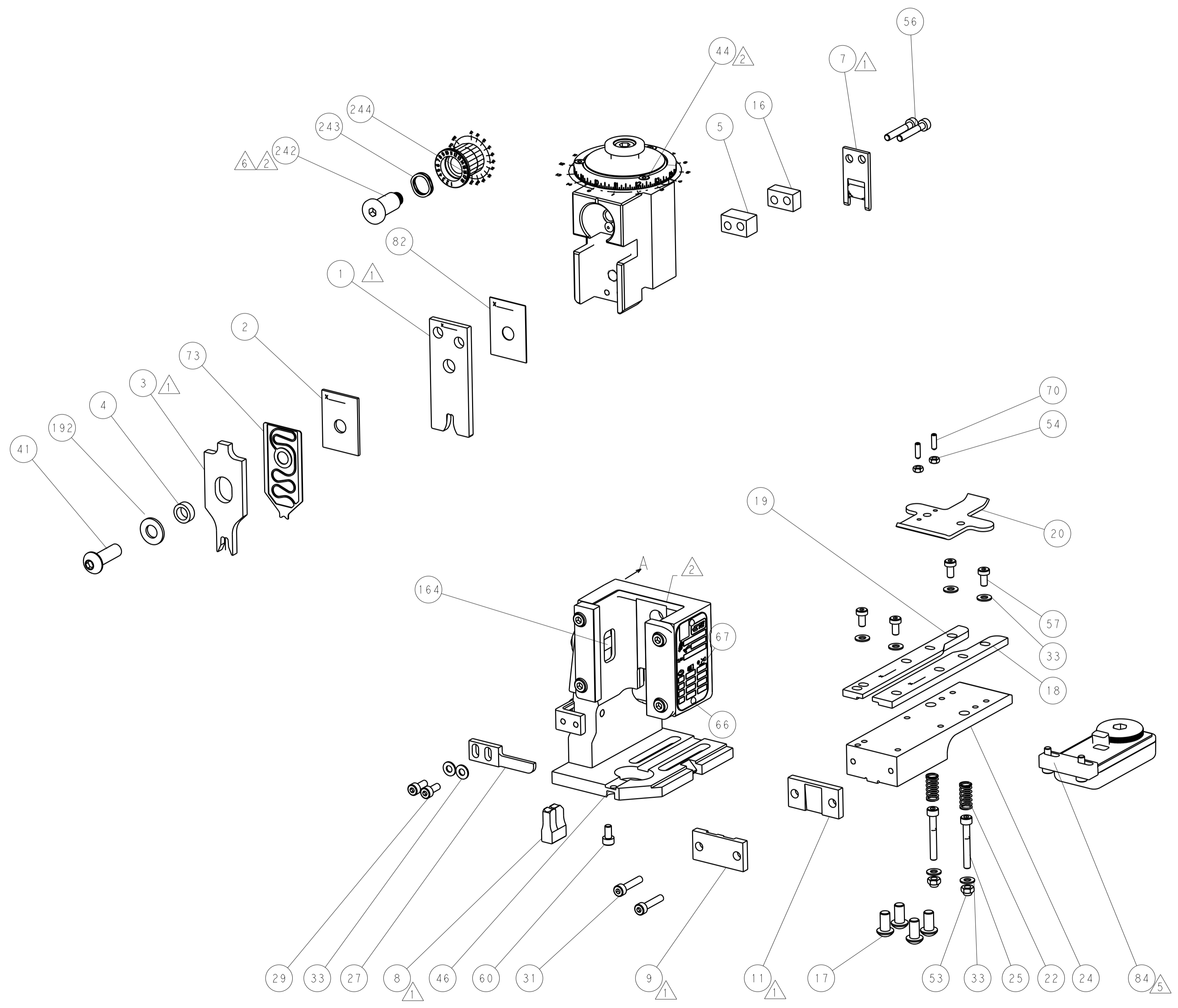
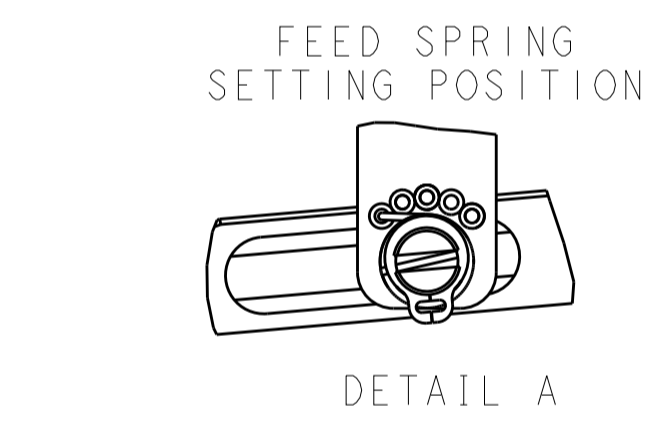
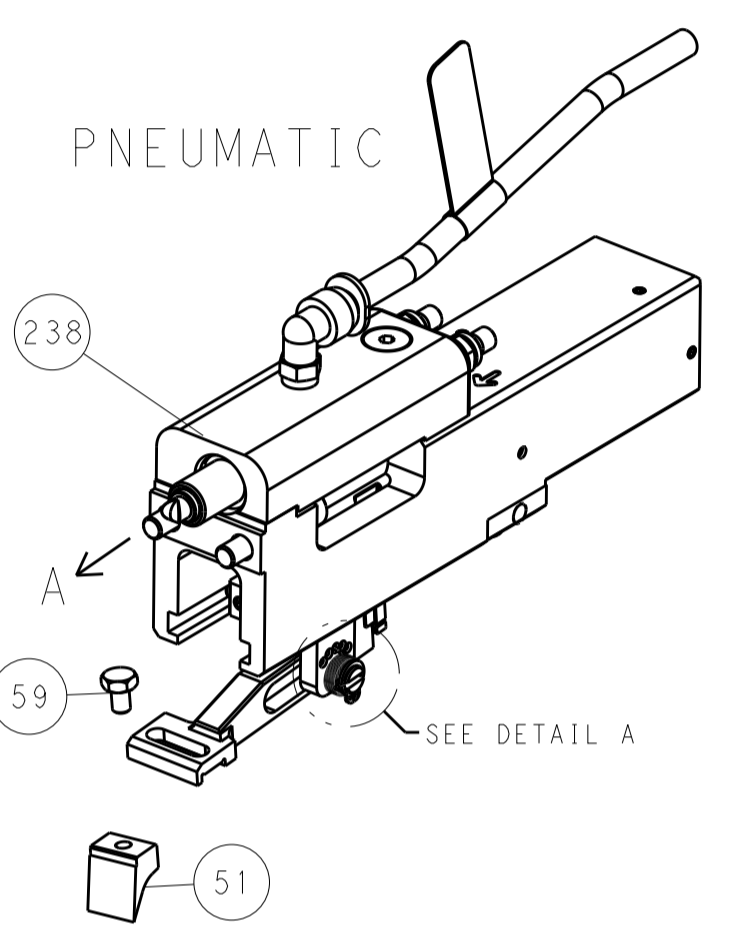
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 10OCT2014		REV: Y.YIN 10OCT2014		NAME: Ocean End Feed Applicator	
mm		0 PLC ±		CHK: Y.YIN 10OCT2014		APVD: H.GUO 10OCT2014		SIZE: A	
		1 PLC ±		PRODUCT SPEC		CAGE CODE: 00779		DRAWING NO: 2150492	
		2 PLC ±		APPLICATION SPEC		SCALE: 1:1		SHEET 1 OF 4	
		3 PLC ±		WEIGHT		RESTRICTED TO		REV: C	
		4 PLC ±		MATERIAL		Customer Accessible Production Drawing			
		ANGLES		FINISH		SCALE: 1:1		SHEET 1 OF 4	
						SCALE: 1:1		SHEET 1 OF 4	

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

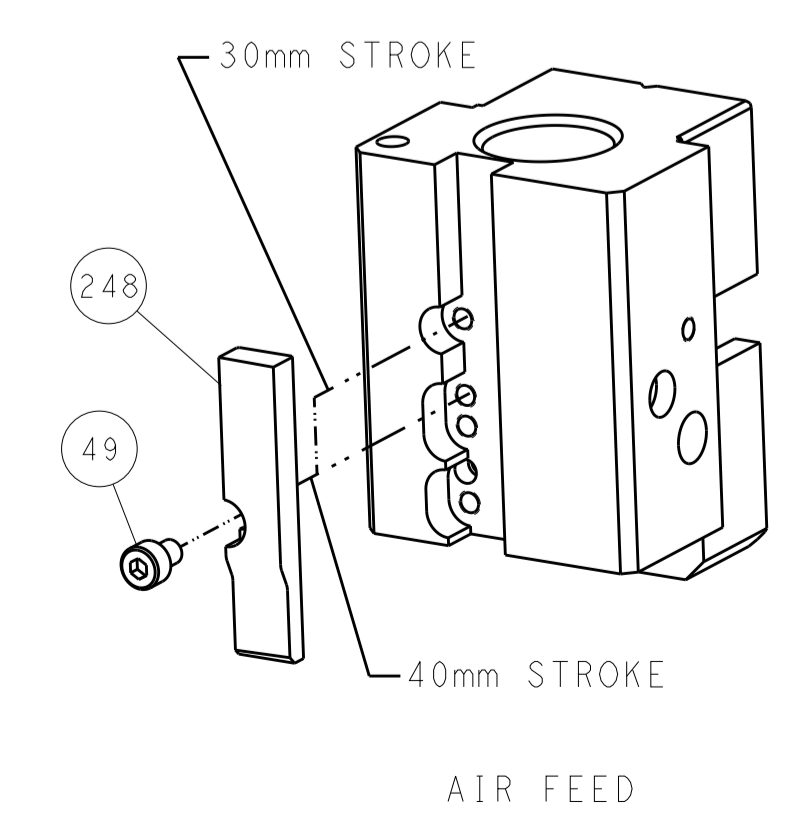


RAM SET-UP

FEED TYPE



CAM POSITION

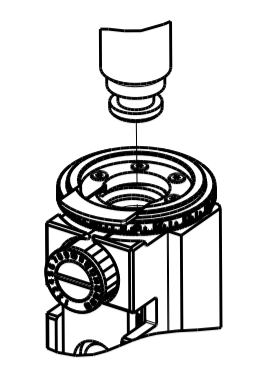


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN J.HOU 10OCT2014 CHK Y.YIN 10OCT2014 APVD H.GUO 10OCT2014	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 WEIGHT SCALE 1:1	RESTRICTED TO SIZE CAGE CODE DRAWING NO A11 00779 C=2150492 SHEET 2 OF 4 REV C
MATERIAL FINISH		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150492-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150492-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	5.65 mm [.222]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 6.20-6.80 mm [.244-.268 IN]		INSULATION DIAMETER RANGE 3.56-4.75 mm [.140-.187 IN]	
TERMINAL APPLICATION SPECIFICATION LEAR SPEC 25237 Rev 7			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949580-1	25237.123.011	1949580-2	25237.XXX.YYY

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.15+/-0.1 [.124+/- .004]	7.3
4.00mm2	2.95+/-0.1 [.116+/- .004]	9.6



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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.

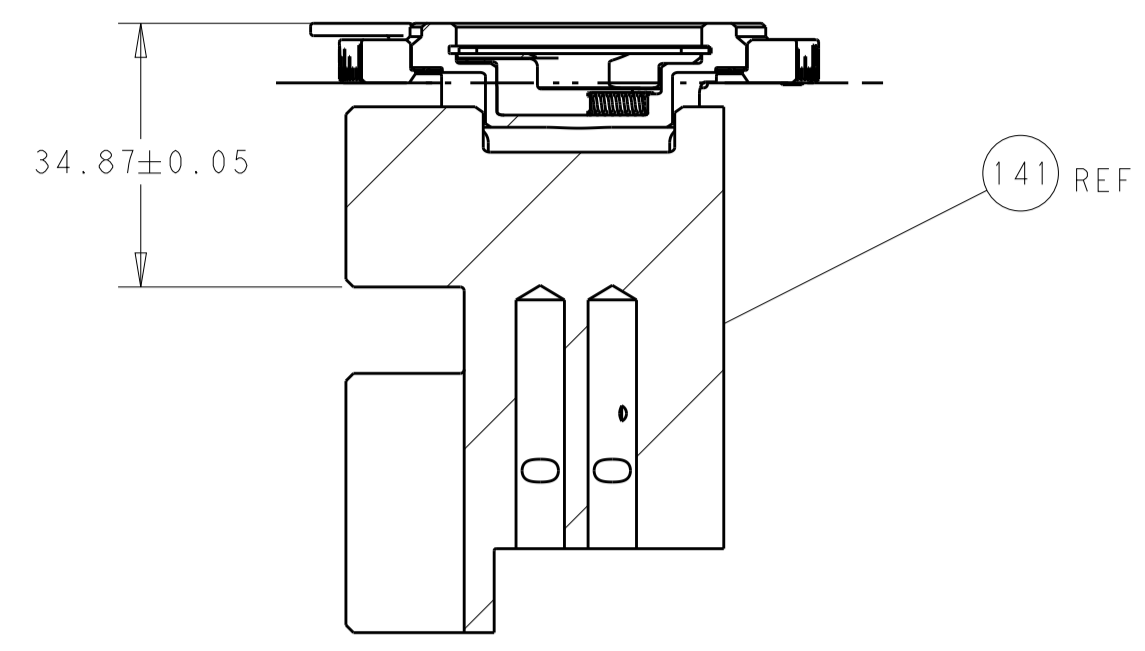
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	2119082-2	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	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	455888-4	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-2063961-0	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	240639-1	STRIPPER (MACHINING)	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	1803292-4	DRAG	20	
-	1	7-1901696-3	STRIP GUIDE, REAR	19	
-	1	7-1901695-3	STRIP GUIDE, FRONT	18	
-	1	7-240641-2	SPACER	16	
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10	
1	-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	5-1803000-9	ANVIL, COMBINATION, END FEED	8	
1	-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6	
-	1	7-240641-7	SPACER	5	
-	1	238011-3	BLOCK, CRIMPER SPACER	4	
1	1	7-1633962-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1-455888-5	SPACER, CRIMPER	2	
1	1	456428-1	CRIMPER, WIRE	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN J.HOU 10OCT2014 CHK Y.YIN 10OCT2014 APVD H.GUO 10OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1 SHEET 3 OF 4 REV C		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150492	
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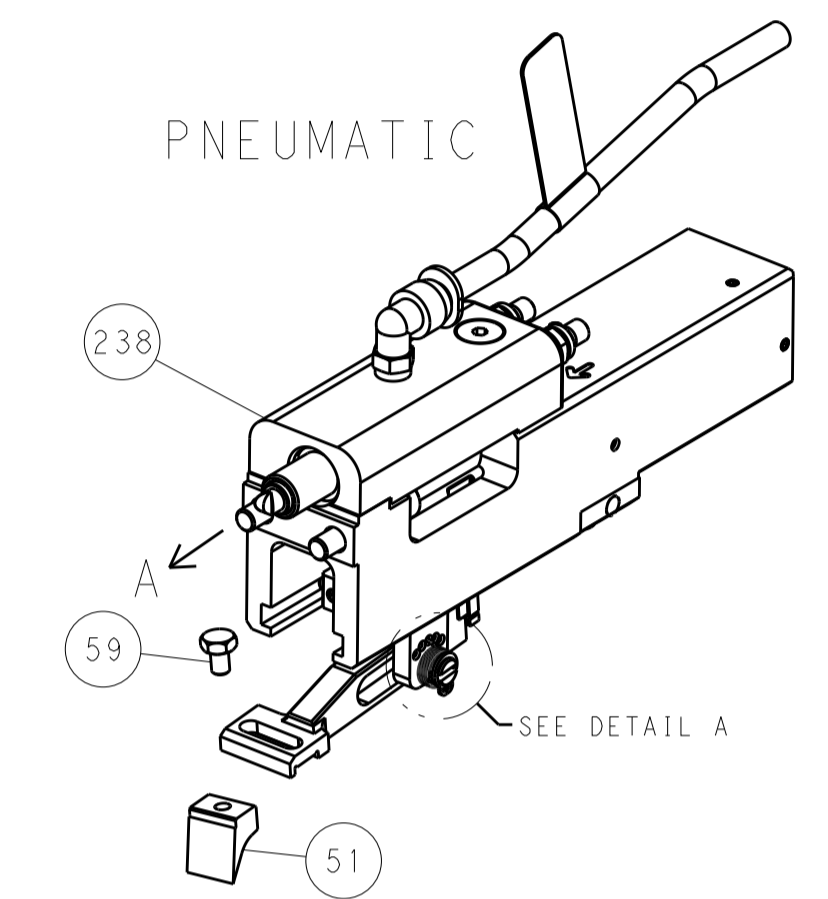
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



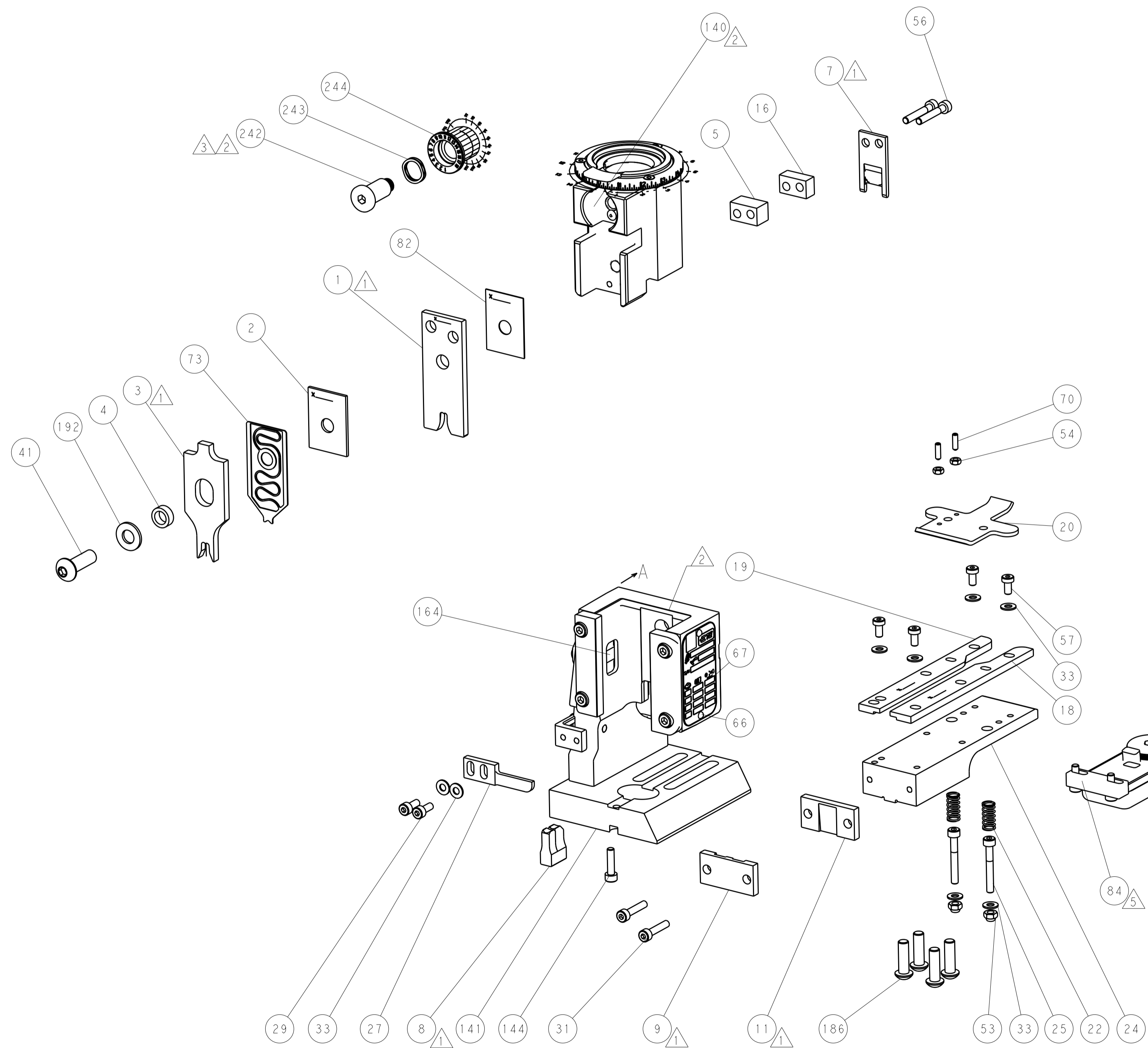
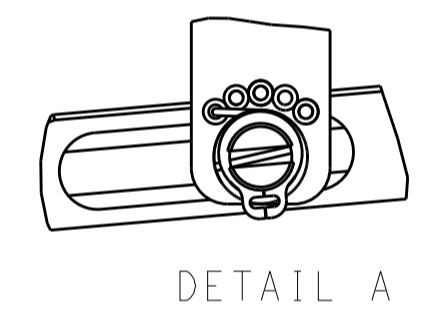
RAM SET-UP

FEED TYPE

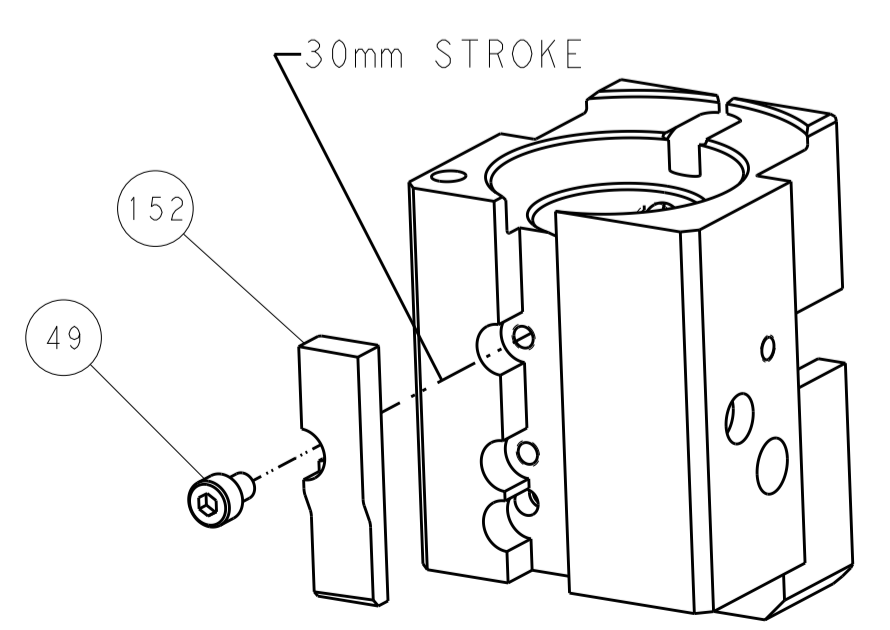
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J.HOU 10OCT2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD Y.YIN 10OCT2014	NAME Ocean End Feed Applicator
MATERIAL	FINISH	ANGLES	WEIGHT	SCALE 1:1	SHEET 4 OF 4	REV C	RESTRICTED TO
				Customer Accessible Production Drawing	00779 ©=2150492		