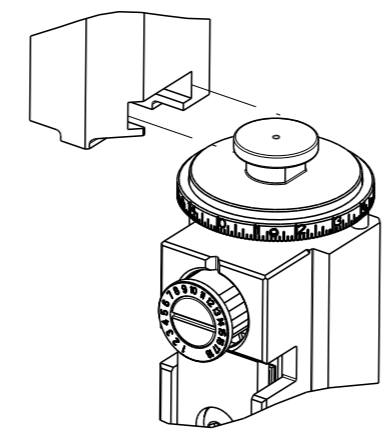


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150424-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150424-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150424-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150424-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150424-7	A	CRIMP TOOLING KIT	-

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 1.40-2.10 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 +/- .002]	8.2
0.75mm2	1.30 +/- 0.05 [.051 +/- .002]	9.2
0.50mm2	1.25 +/- 0.05 [.049 +/- .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.

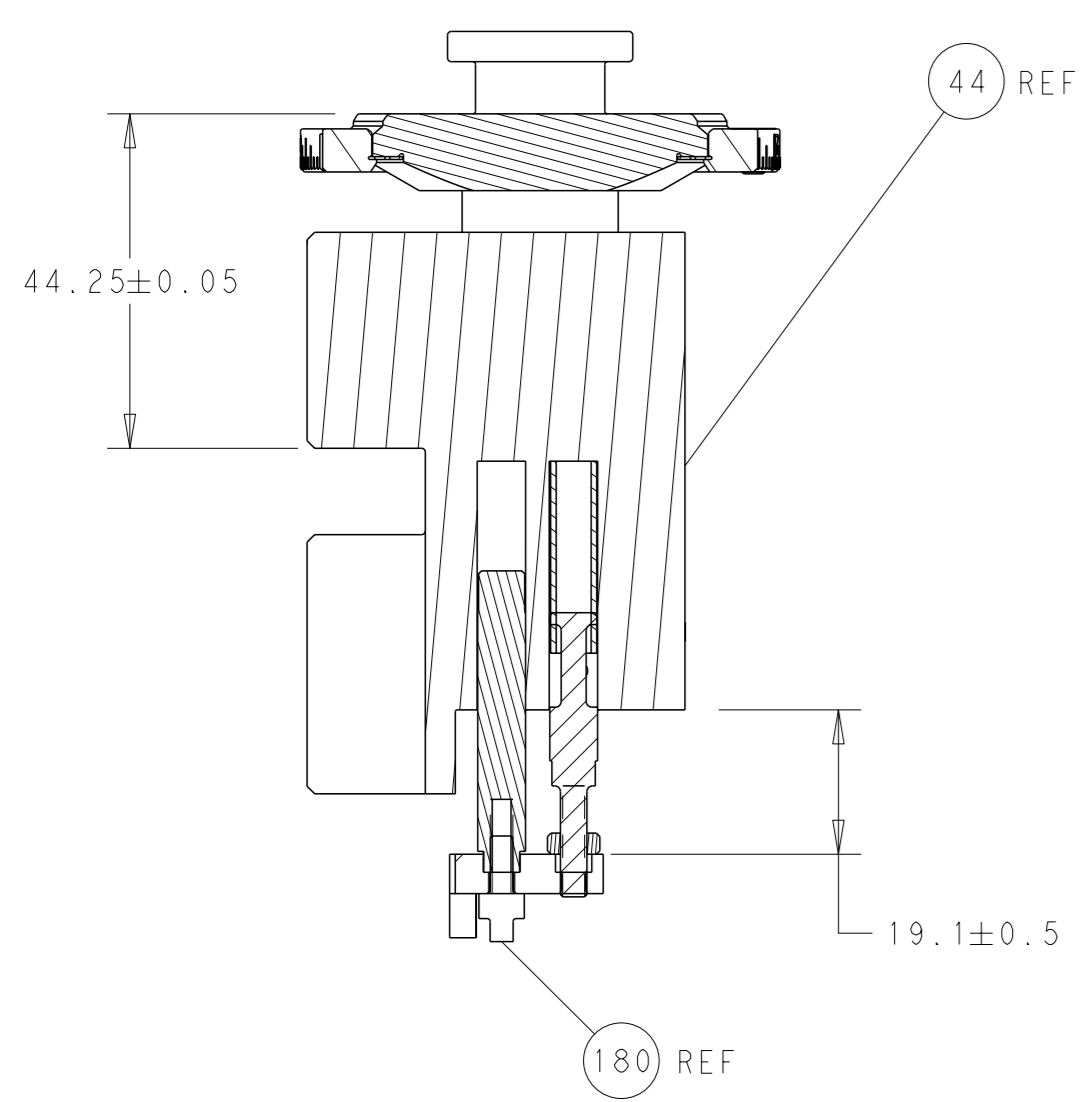
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
6	-	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	2	2	1	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	2	2	1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	2	2	1	1	3-456405-7	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

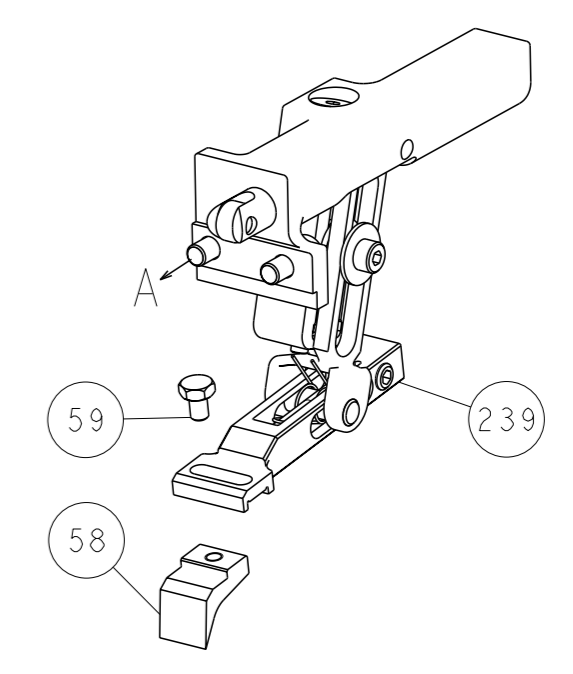
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	SHEET
						1:1	1 OF 4

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

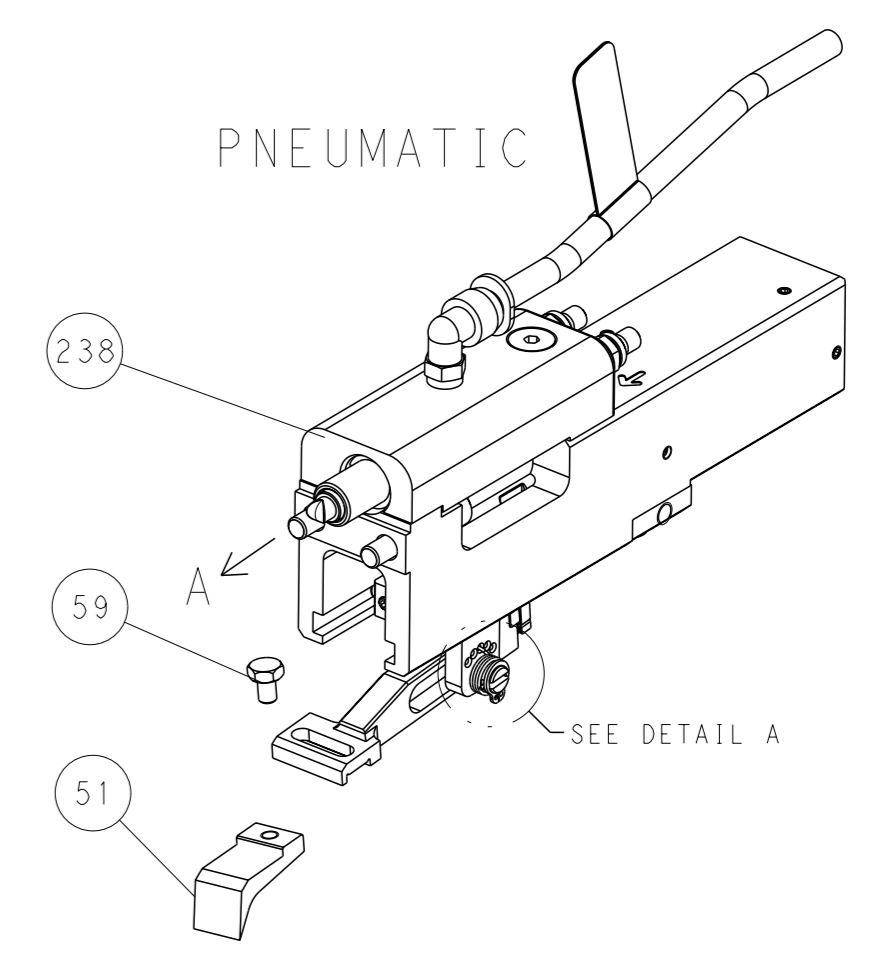


RAM AND HOLDDOWN SET-UP

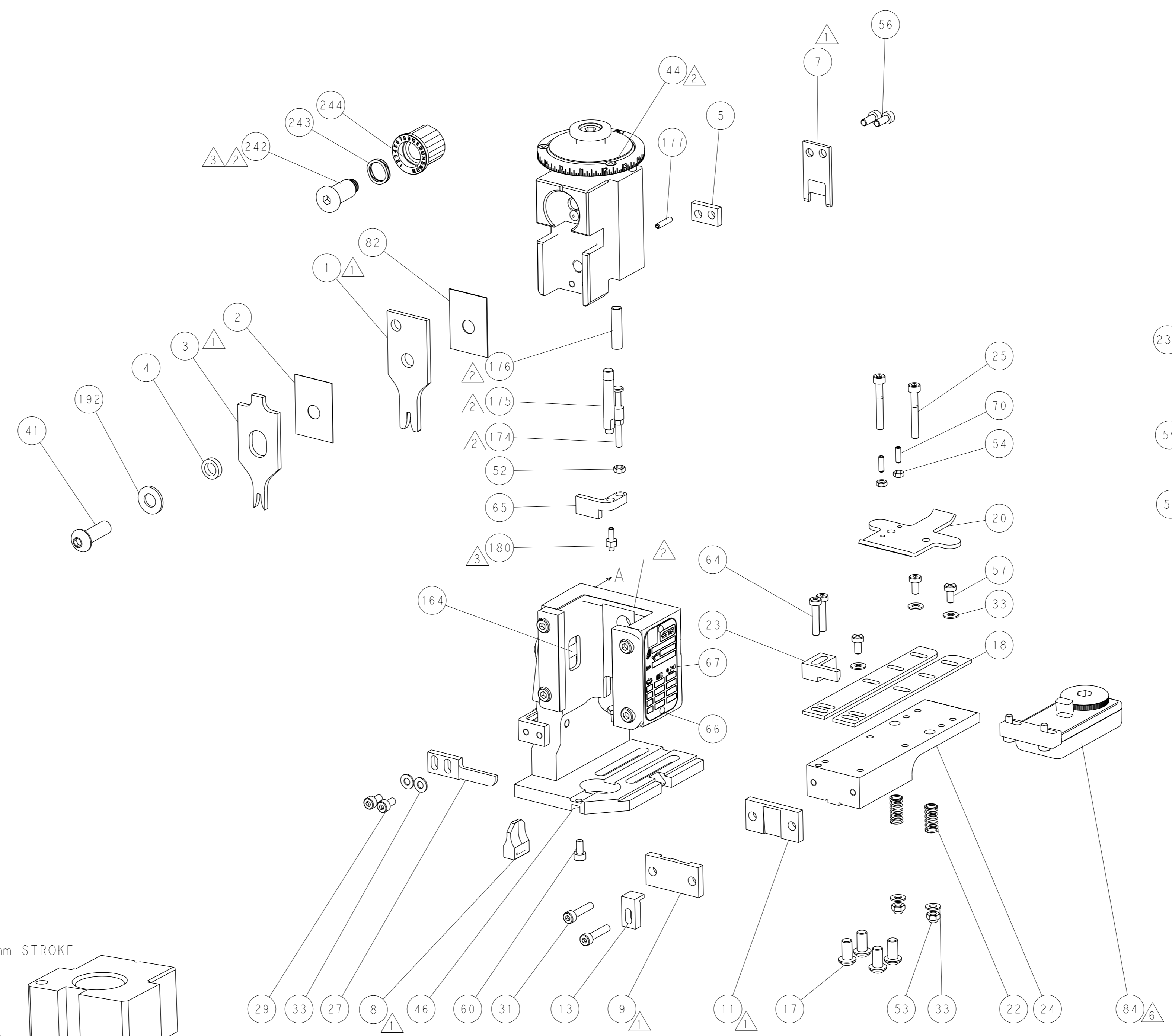
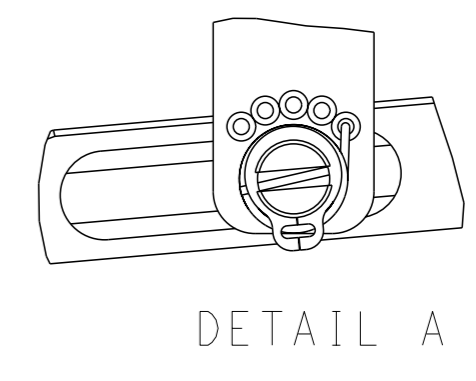
FEED TYPE
MECHANICAL



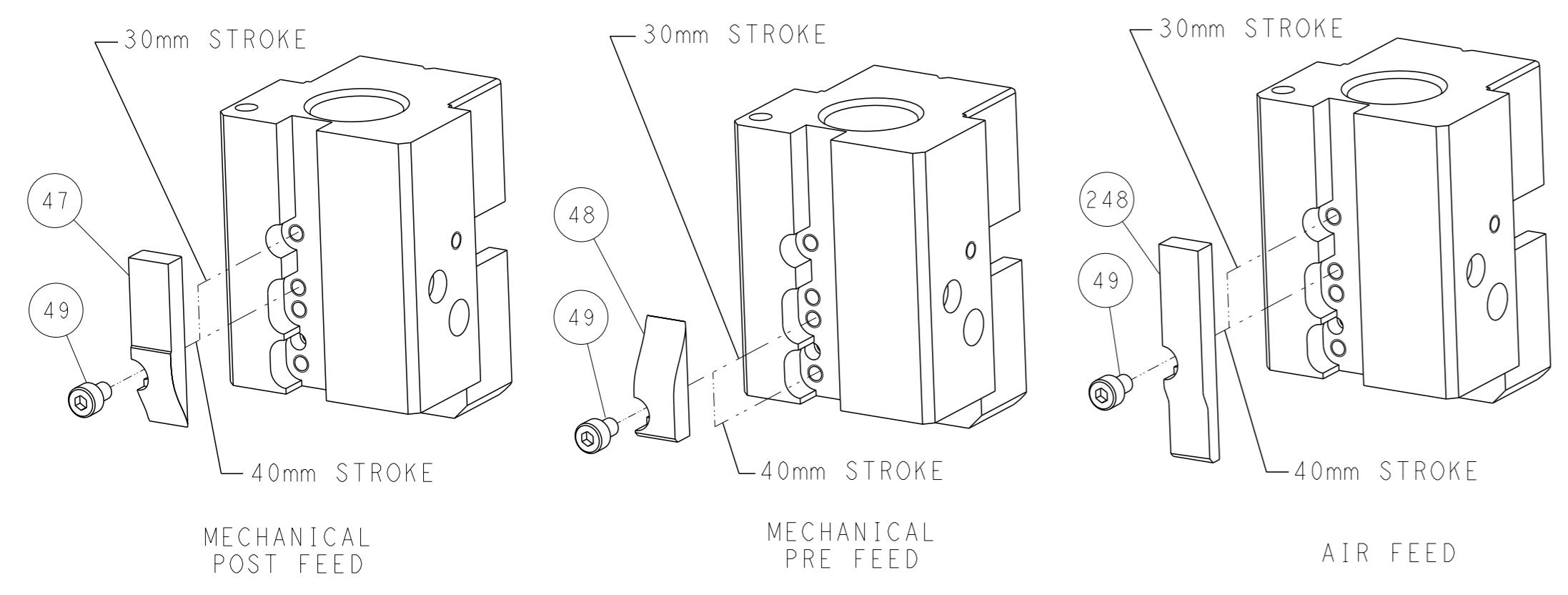
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

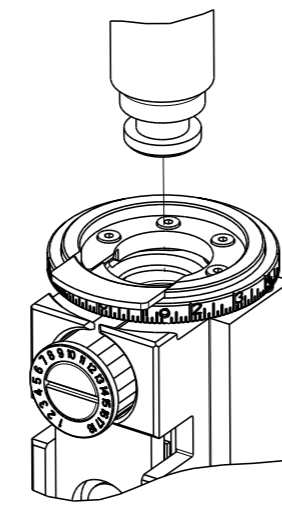


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: K. HUANG CHK: L. ZHANG APVD: J. GUO	Z1MAR2014 Z1MAR2014 Z1MAR2014	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150424	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
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
1.00mm ²	1.40 +/- 0.05 [.055 +/- .002]	8.2
0.75mm ²	1.30 +/- 0.05 [.051 +/- .002]	9.2
0.50mm ²	1.25 +/- 0.05 [.049 +/- .002]	9.7

- 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 180. 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

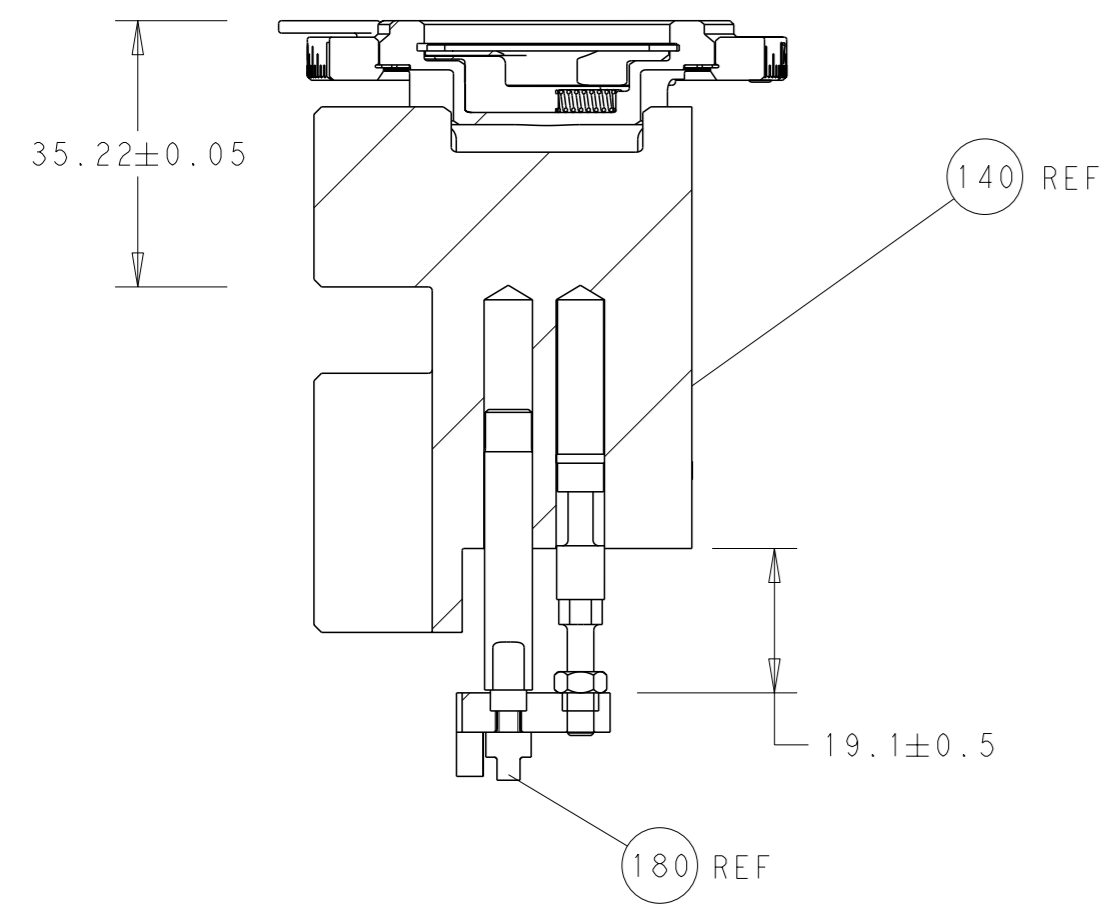
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
A	66	P	LY#	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	ITEM NO

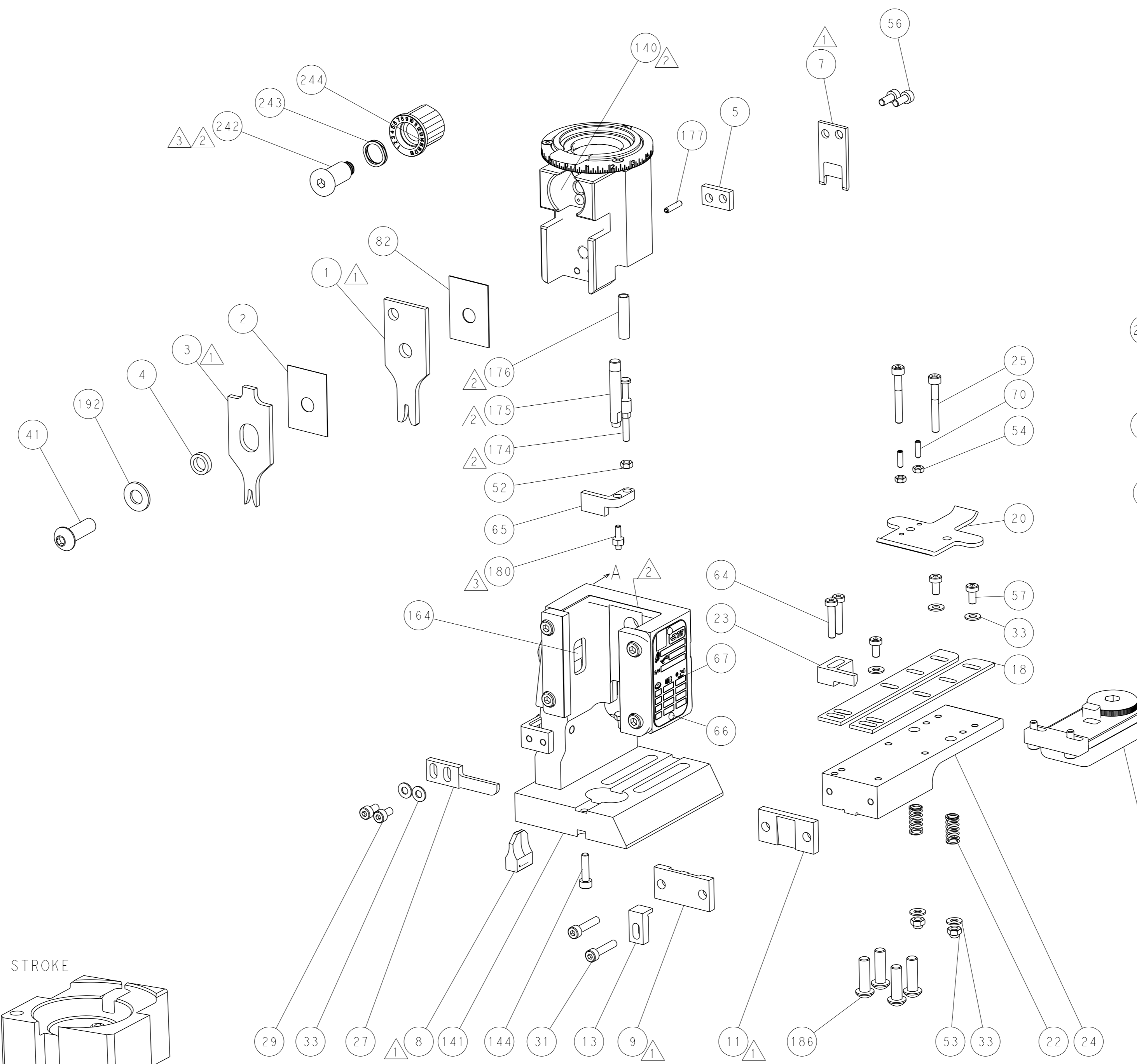
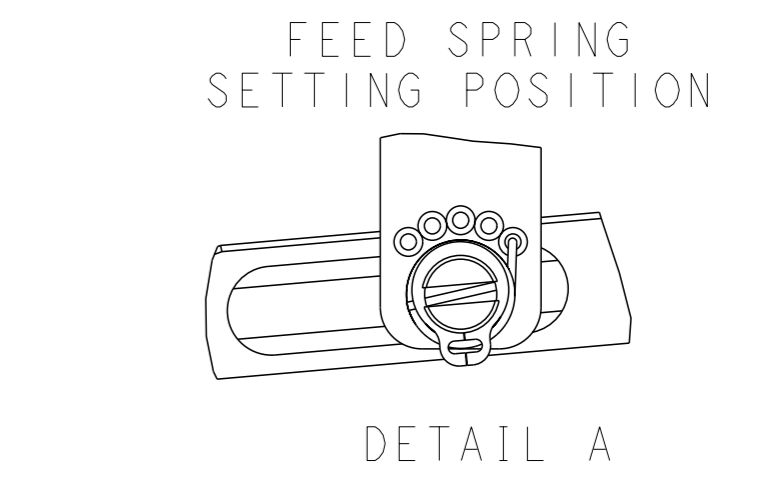
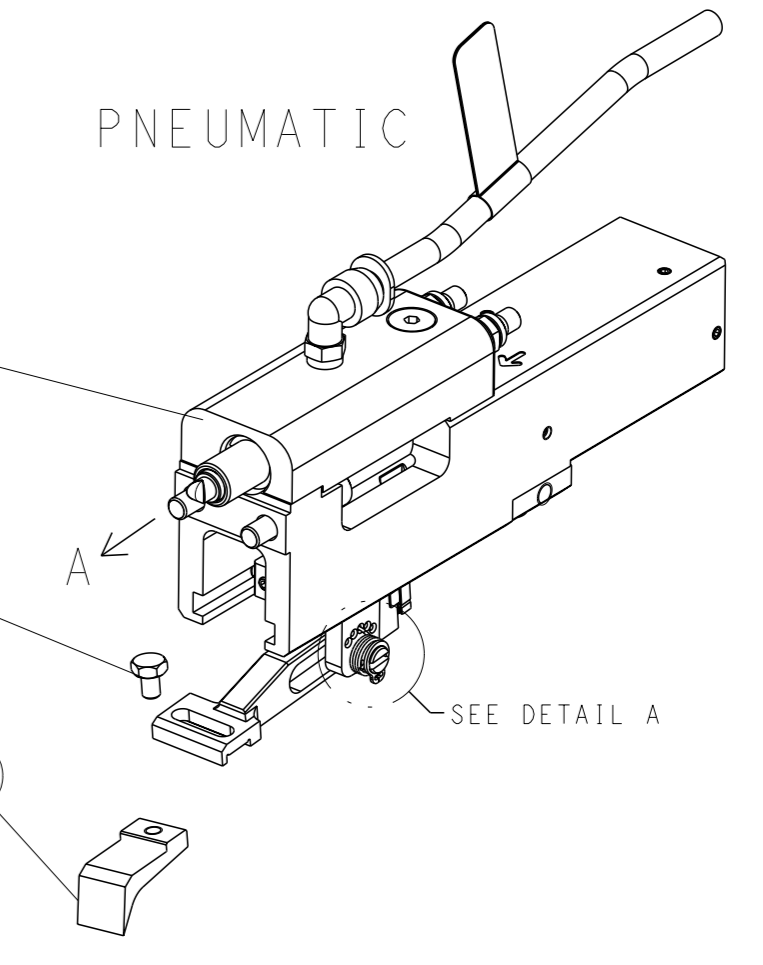
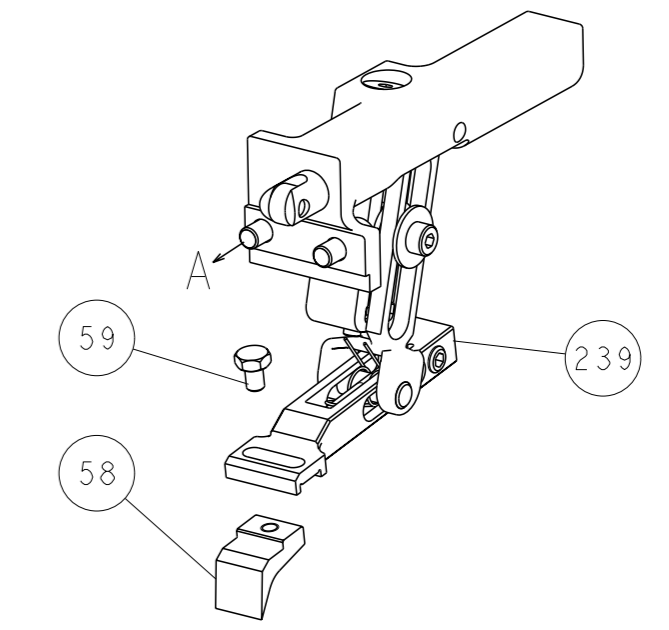
<small>THE DRAWING IS CONTROLLED BY THE REVISIONS CONTROL SYSTEM. ANY CHANGES TO THE DRAWING MUST BE MADE THROUGH THE REVISIONS CONTROL SYSTEM. THIS DRAWING IS UNPUBLISHED.</small>		DWG: H. HUANG 21MAR2014 CHK: L. ZHANG 21MAR2014 APVD: J. GUO 21MAR2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150424 SCALE: 1:1 SHEET: 3 of 4 REV: B
MATERIAL:		WEIGHT:	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:1	SHEET: 3 of 4

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		1	SEE SHEET 1		

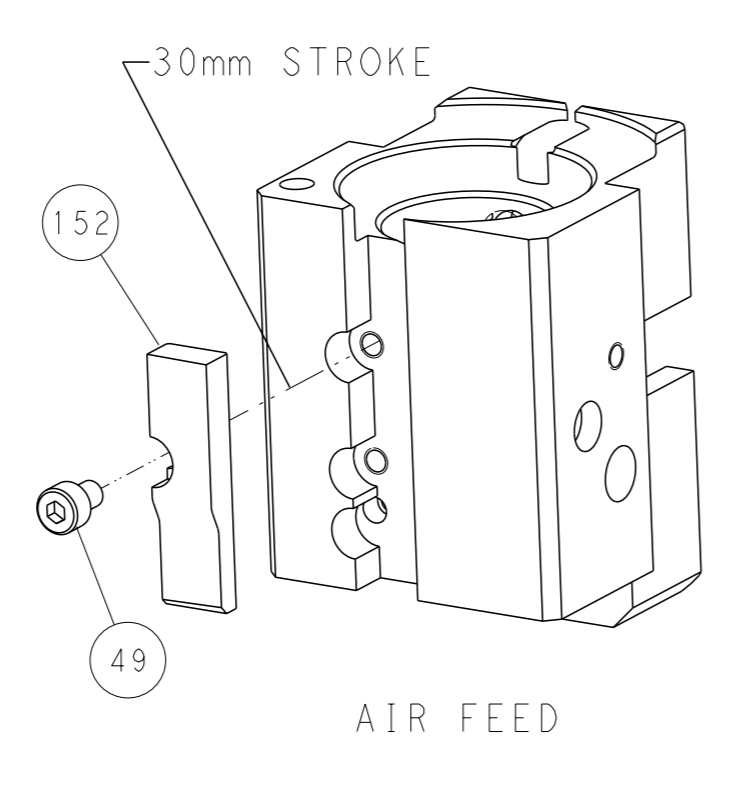
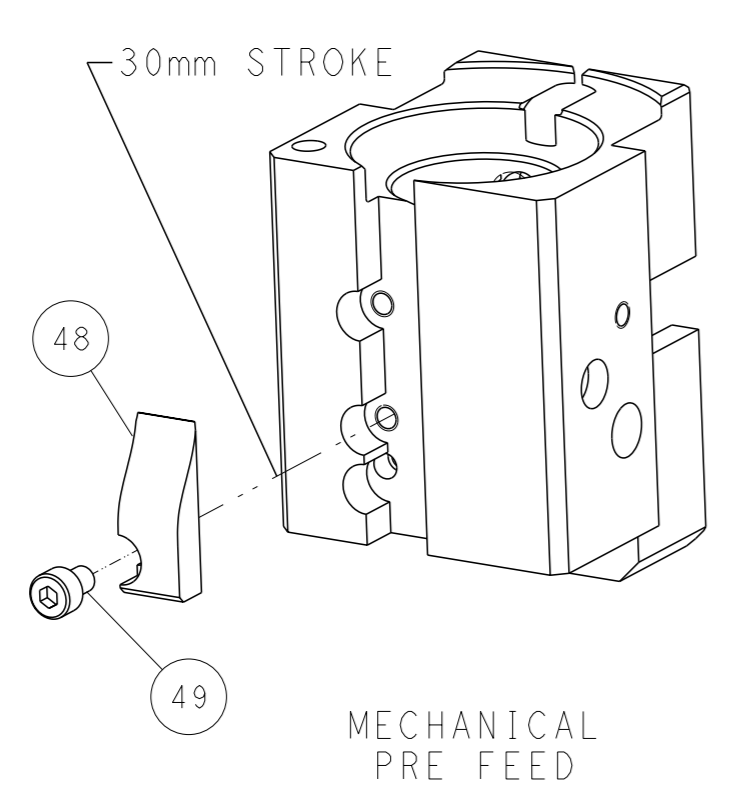
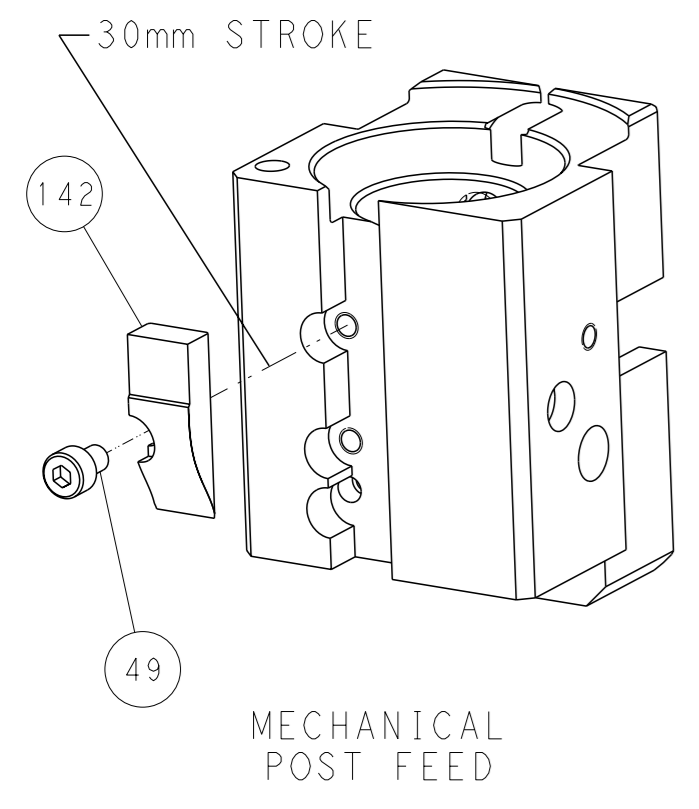


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: K. HUANG CHK: L. ZHANG APVD: J. GUO PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		Z1MAR2014 Z1MAR2014 Z1MAR2014 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150424 SCALE: 1:1 SHEET: 4 of 4 REV: B		STE TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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