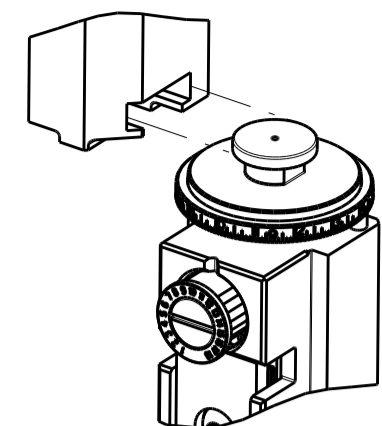


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150667-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150667-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150667-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [.177]	F
INSUL	6.30 mm [.248]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H(LEAR) TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.10-6.90 mm [.240-.272 IN]		∅3.75-5.00 mm [.148-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	25233 Rev 18		
TERMINALS APPLIED			
TE TERMINAL	G&H(LEAR) TERMINAL	TE TERMINAL	G&H(LEAR) TERMINAL
1572446-1	25233.331.011	1572446-6	25233.123.011
1572446-2	25233.331.322	1572446-7	25233.123.322
1572446-3	25233.213.004	1572446-8	25233.123.009
1572446-4	25233.213.320	1572446-9	25233.212.179
1572446-5	25233.123.014	1-1572446-0	25233.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLY 6mm <sup>2</sup>	3.15+/-0.10 [.124+/-0.004]	4.2
2X FLY-A 2.5mm <sup>2</sup>	3.10+/-0.10 [.122+/-0.004]	4.6
2.5+1.5mm <sup>2</sup>	2.95+/-0.10 [.116+/-0.004]	6.2
12 AWG	2.80+/-0.05 [.110+/-0.002]	7.8



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 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.

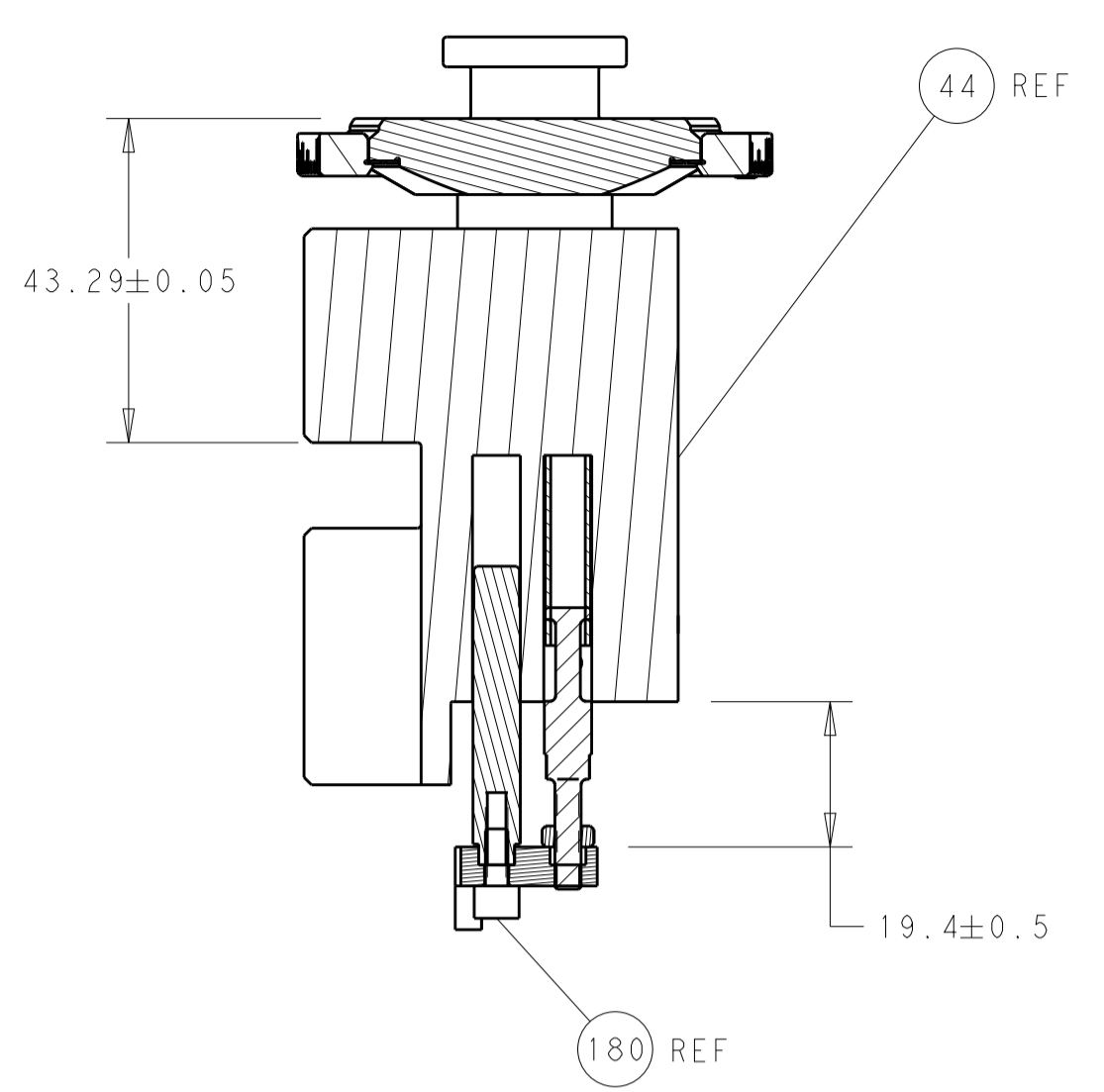
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	A		RELEASED	23JUN2016	BW	GB
		B		ECR-20-017233	04DEC2020	FZ	TE

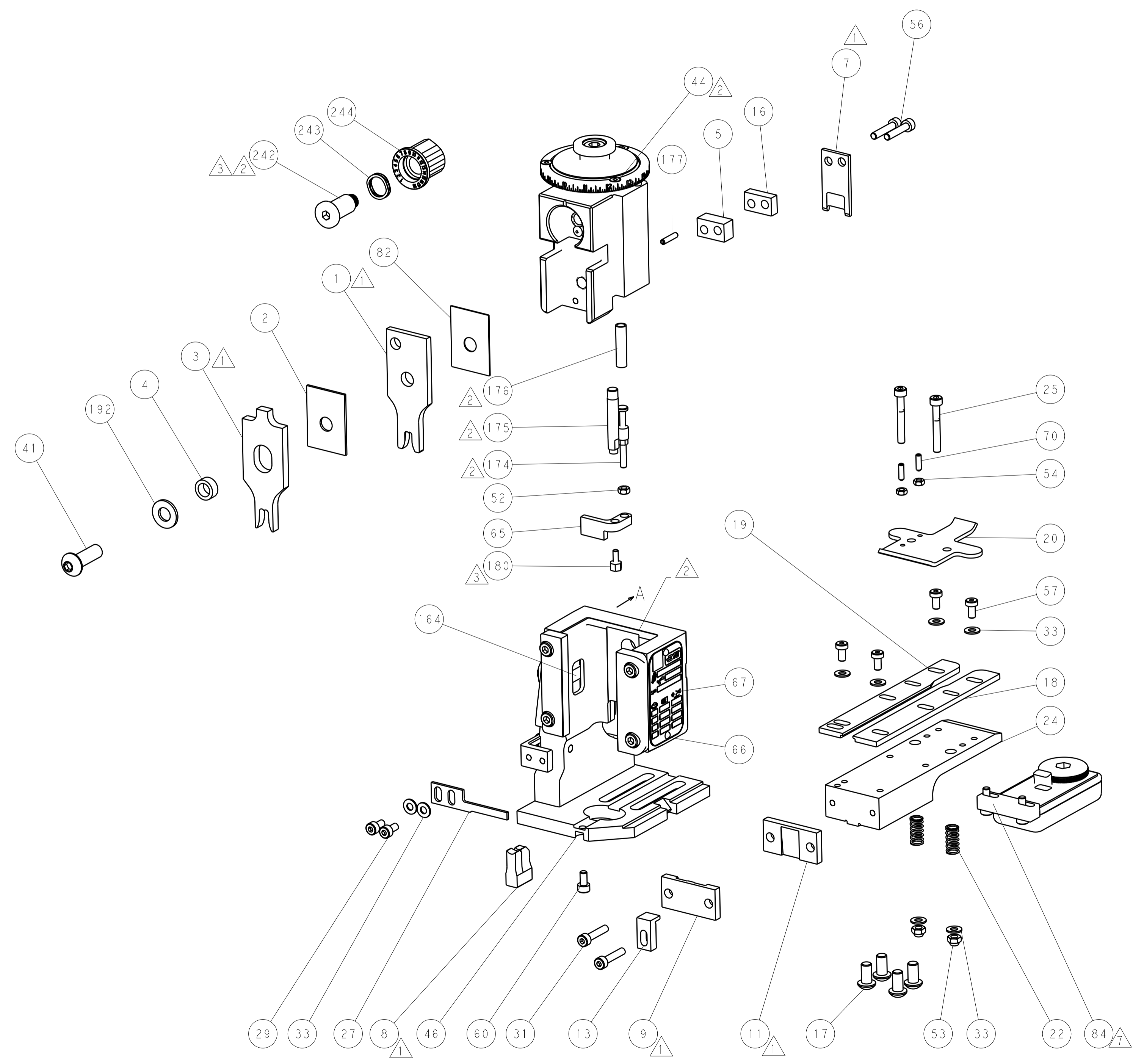
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1752354-2	STANDOFF, HOLD-DOWN	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
7	-	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	1901681-1	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	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	690455-2	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	1803292-4	DRAG	20
-	1	1	1901696-4	STRIP GUIDE, REAR	19
-	1	1	1901695-4	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1-240641-4	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	4-1803059-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-5	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	5-240641-1	SPACER	5
-	1	1	4-238011-6	BLOCK, CRIMPER SPACER	4
1	1	2	1-1803246-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	1803266-4	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	J. HOU	L. ZHANG	L. ZHANG	L. ZHANG	19MAY2016	19MAY2016
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO	
						A1		00779		2150667	
Customer Accessible Production Drawing										SCALE	1:1
										SHEET	1
										OF	4
										REV	B

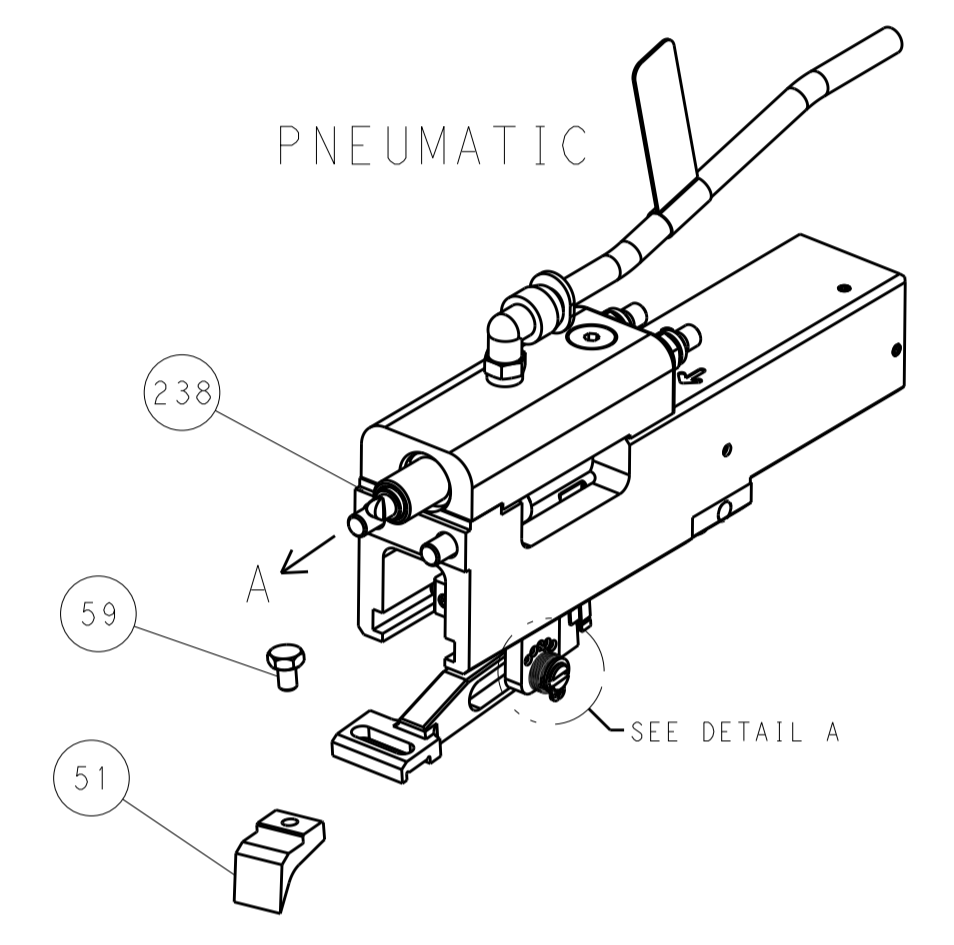
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS					



RAM AND HOLDDOWN SET-UP

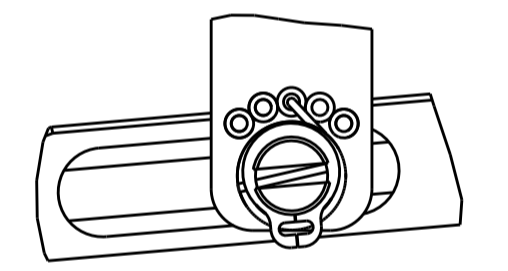


FEED TYPE



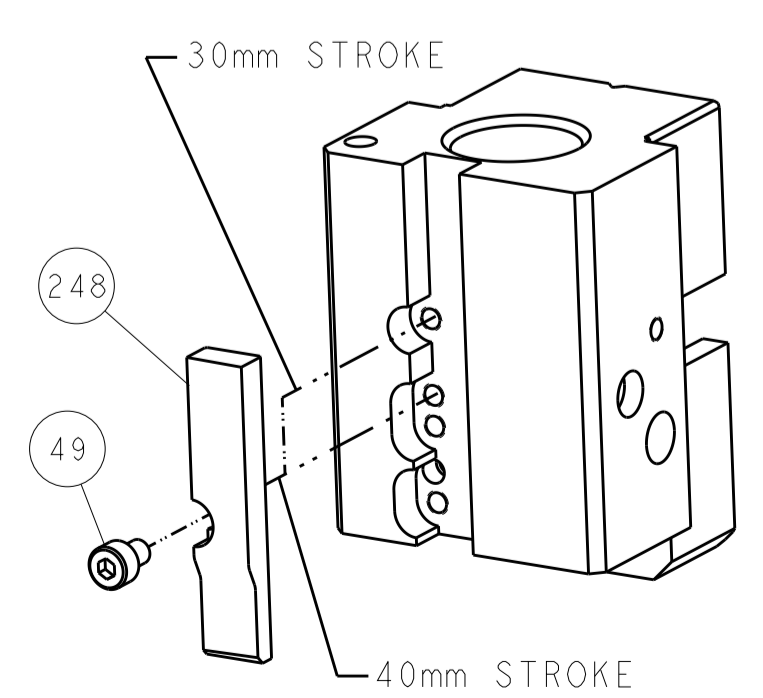
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



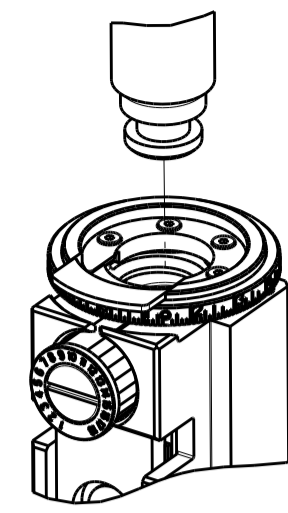
AIR FEED

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J. HOU 19MAY2016 CHK: L. ZHANG 19MAY2016 APVD: L. ZHANG 19MAY2016	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150667	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 2 of 4 REV: B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150667-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150667-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



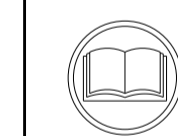
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [ .177 ]	F
INSUL	6.30 mm [ .248 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H(LEAR) TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 6.10-6.90 mm [ .240-.272 IN ]	INSULATION DIAMETER RANGE Ø3.75-5.00 mm [ .148-.197 IN ]
TERMINAL APPLICATION SPECIFICATION 25233 Rev 18	

TERMINALS APPLIED			
TE TERMINAL	G&H(LEAR) TERMINAL	TE TERMINAL	G&H(LEAR) TERMINAL
1572446-1	25233.331.011	1572446-6	25233.123.011
1572446-2	25233.331.322	1572446-7	25233.123.322
1572446-3	25233.213.004	1572446-8	25233.123.009
1572446-4	25233.213.320	1572446-9	25233.212.179
1572446-5	25233.123.014	1-1572446-0	25233.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLY 6mm <sup>2</sup>	3.15+/-0.10 [ .124+/- .004 ]	4.2
2X FLRY-A 2.5mm <sup>2</sup>	3.10+/-0.10 [ .122+/- .004 ]	4.6
2.5+1.5mm <sup>2</sup>	2.95+/-0.10 [ .116+/- .004 ]	6.2
12 AWG	2.80+/-0.05 [ .110+/- .002 ]	7.8



- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- △ 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.

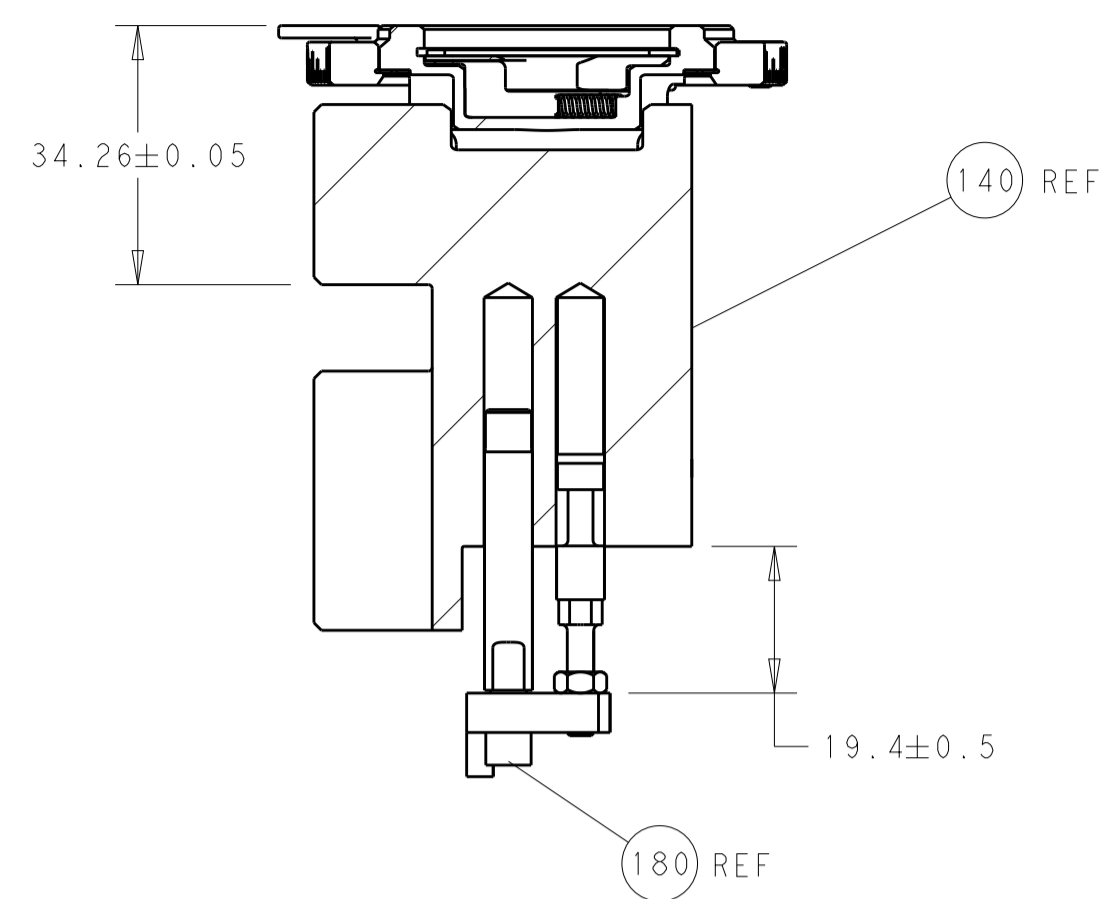
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	DESCRIPTION	ITEM NO
-	1	2119082-7 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 1752354-2 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
△	-	1 2119955-2 ASSY, LUBRICATOR, END FEED	84
-	1	455888-5 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	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	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	690455-2 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	1803292-4 DRAG	20
-	1	1901696-4 STRIP GUIDE, REAR	19
-	1	1901695-4 STRIP GUIDE, FRONT	18
-	1	1-240641-4 SPACER	16
-	1	1752360-1 SPACER, HOLD-DOWN	13
△	-	1 240644-9 PLATE, REAR SHEAR	11
-	-	-	10
△	-	1 690482-3 PLATE, FRONT SHEAR	9
△	1	1 4-1803059-9 ANVIL, COMBINATION, END FEED	8
△	-	1 1-2217206-5 BLADE, SLUG	7
-	-	-	6
-	1	5-240641-1 SPACER	5
-	1	4-238011-6 BLOCK, CRIMPER SPACER	4
△	1	1 1-1803246-4 CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-1 SPACER, CRIMPER	2
△	1	1 1803266-4 CRIMPER, WIRE	1

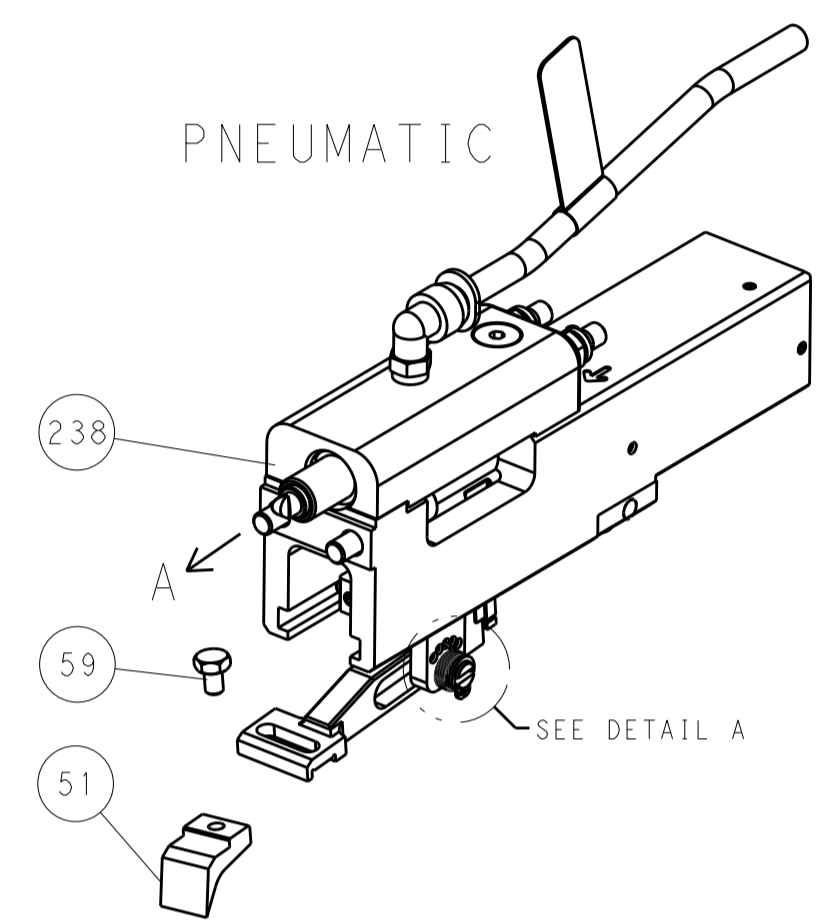
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 19MAY2016		CHK: L. ZHANG 19MAY2016		APVD: L. ZHANG 19MAY2016		NAME: Ocean End Feed Applicator	
0 PLC	±	0.15	±	0.15	±	0.15	±	0.15	±	0.15	±
1 PLC	±	0.25	±	0.25	±	0.25	±	0.25	±	0.25	±
2 PLC	±	0.38	±	0.38	±	0.38	±	0.38	±	0.38	±
3 PLC	±	0.51	±	0.51	±	0.51	±	0.51	±	0.51	±
4 PLC	±	0.64	±	0.64	±	0.64	±	0.64	±	0.64	±
ANGLES	±	0.15	±	0.15	±	0.15	±	0.15	±	0.15	±
FINISH	±	0.15	±	0.15	±	0.15	±	0.15	±	0.15	±
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		1:1		3 OF 4		B	

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					
REVISIONS			DESCRIPTION	DATE	BY	APPV
			SEE SHEET 1			

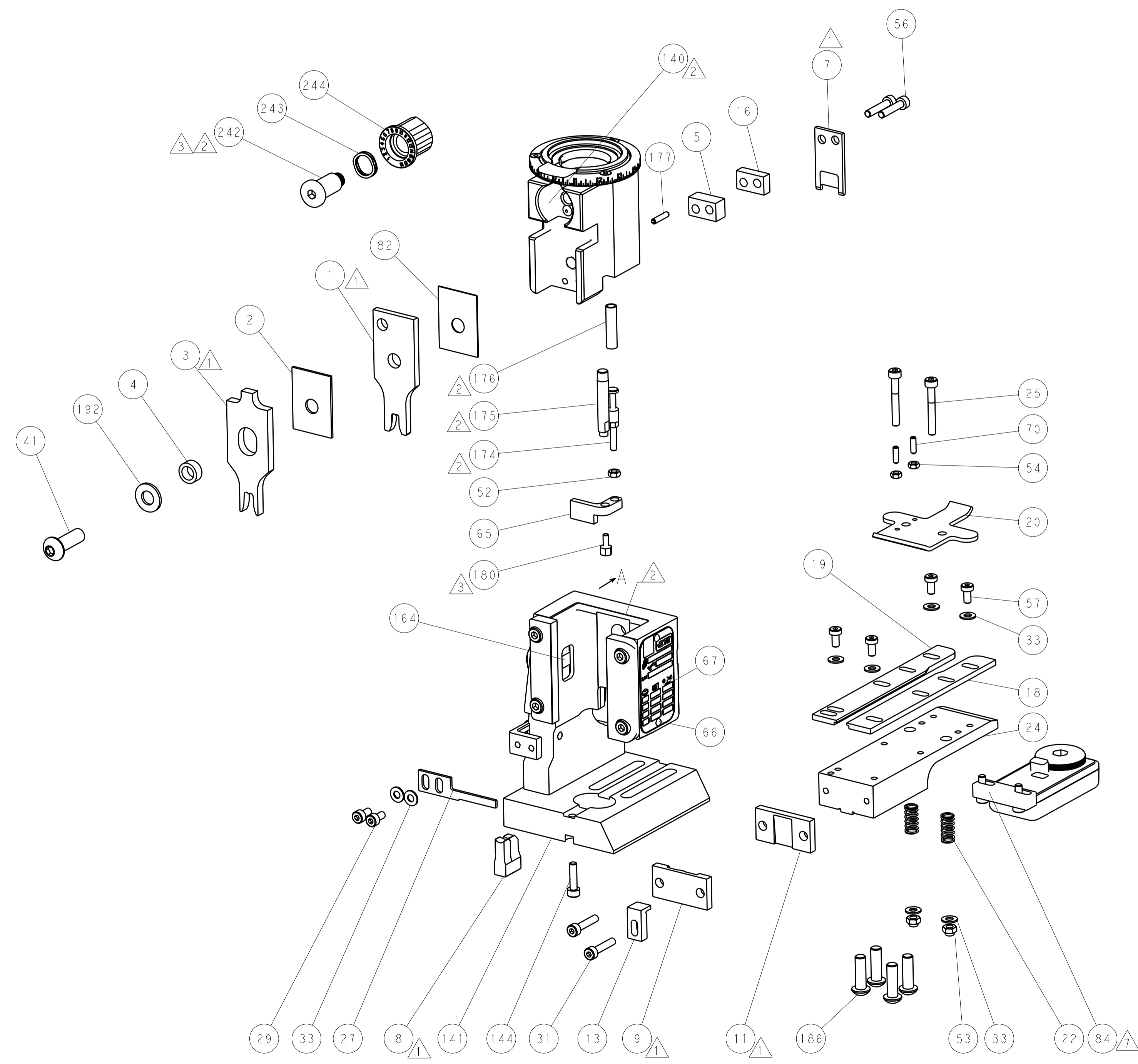
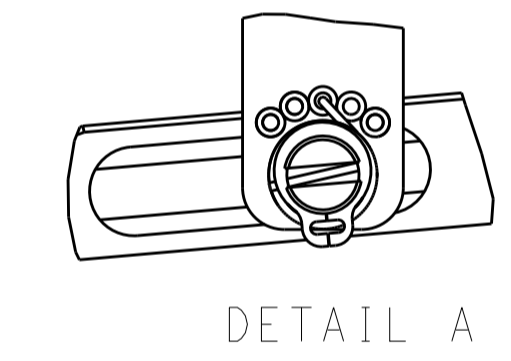


RAM AND HOLDDOWN SET-UP

FEED TYPE

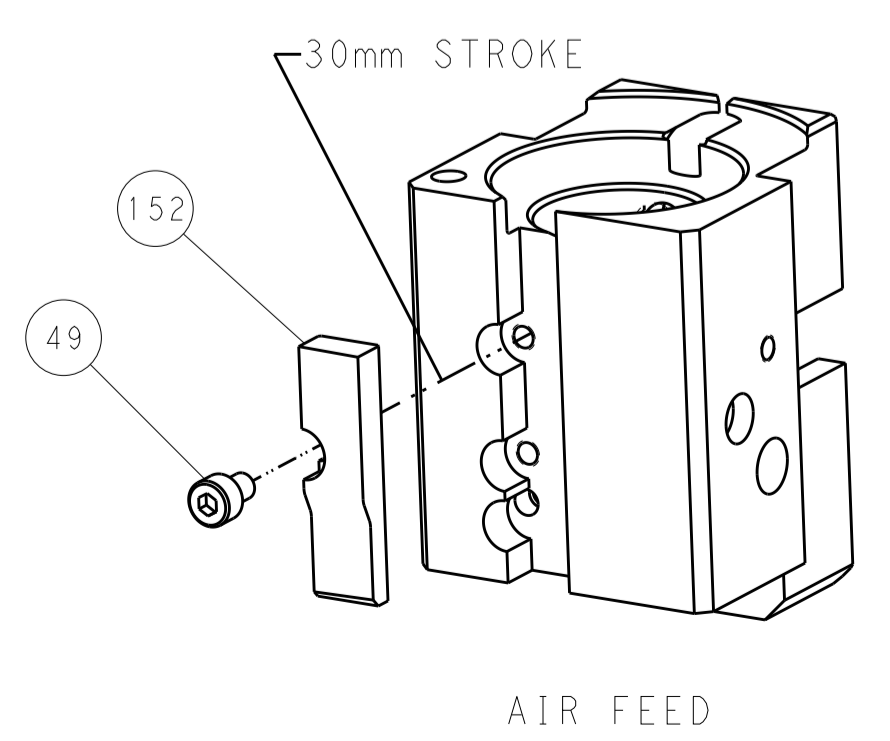


FEED SPRING SETTING POSITION



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

CAM POSITION



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 19MAY2016		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:1	A1	00779	©=2150667	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV B			