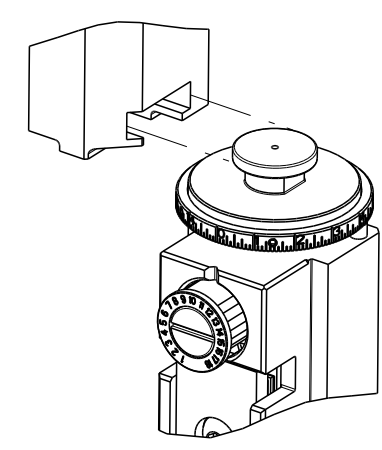


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150181-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150181-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150181-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150181-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150181-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.68 mm [.145]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G & H (LEAR) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: 4.8x0.5/0.8 RECEPTACLE W/ LOCK RING			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.60-5.40 mm [.181-.213 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	2613 Rev 4		
TERMINALS APPLIED			
TE TERMINAL	G & H (LEAR) TERMINAL	TE TERMINAL	G & H (LEAR) TERMINAL
1572911-1	26312.123.211	1572911-2	26312.213.011
1572911-3	26312.123.204	1572911-4	26315.123.211
1572911-5	26312.213.001		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm ²	1.65 +/- 0.05 [.065 +/- .002]	5.6
1.50mm ²	1.45 +/- 0.05 [.057 +/- .002]	7.7

- 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.
- 6. 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.

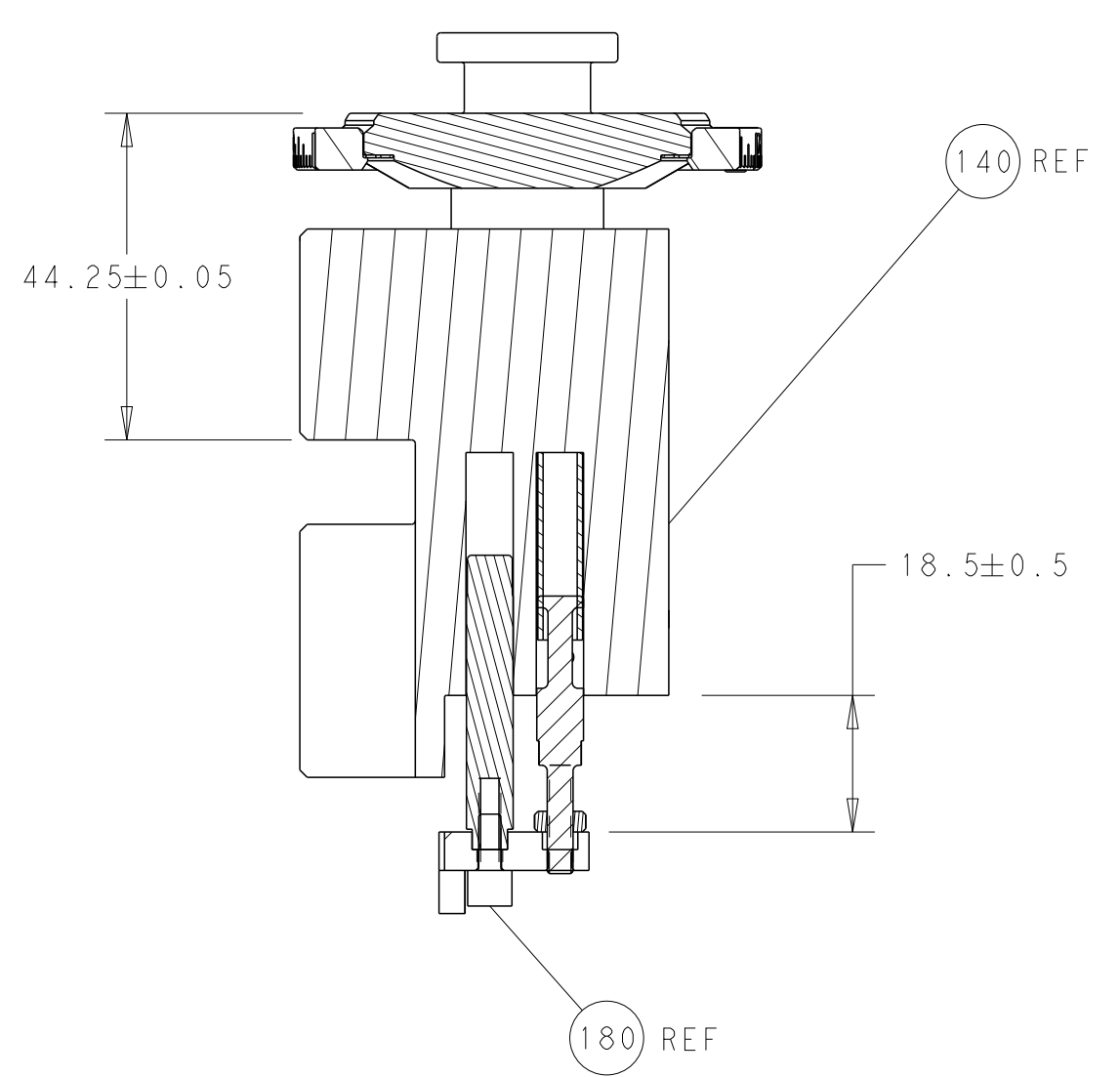
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	12SEP2017	TB	TE
		B		ECR-19-011797	26JUL2019	TB	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	1	1	2119082-3	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	-	-	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	1752354-4	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		
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	1	1	455888-7	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	-	-	2063961-1	FEED FINGER	58		
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	-	2119652-1	FEED CAM, PRE FEED	48		
-	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1752371-3	PLATE, STRIP GUIDE	24		
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23		
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22		
-	1	1	1	1	1803292-4	DRAG	20		
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18		
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
1	-	1	1	1	240833-4	PLATE, REAR SHEAR	11		
-	-	-	-	-	-	-	10		
1	-	1	1	1	1-690495-4	PLATE, FRONT SHEAR	9		
1	1	2	2	1	1	3-1803257-6	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	690474-5	BLADE, SLUG	7	
-	-	-	-	-	-	-	6		
-	1	1	1	1	1	4-240641-1	SPACER	5	
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	2-1803221-7	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	2	2	1	1	3-1803470-4	CRIMPER, WIRE F	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

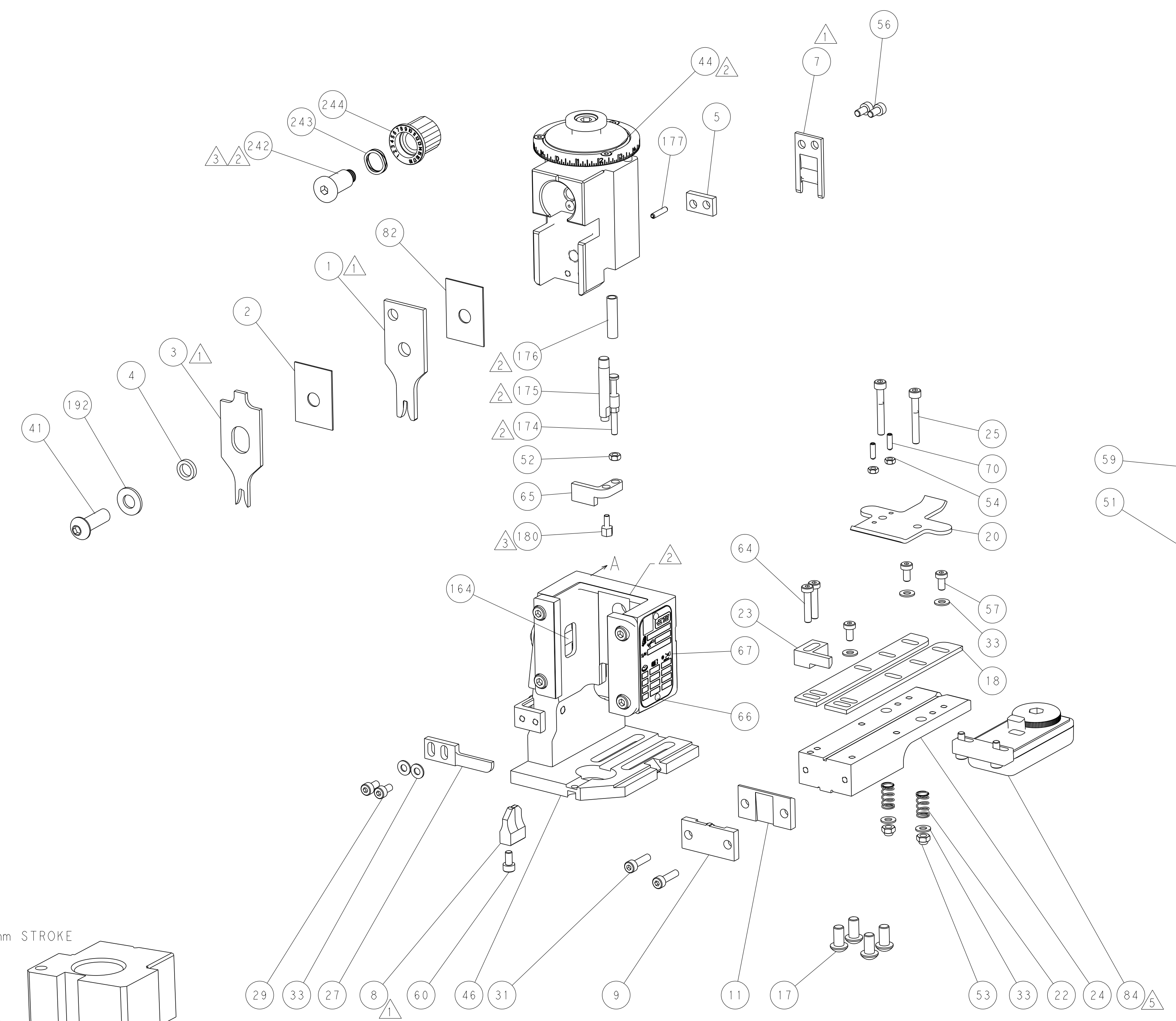
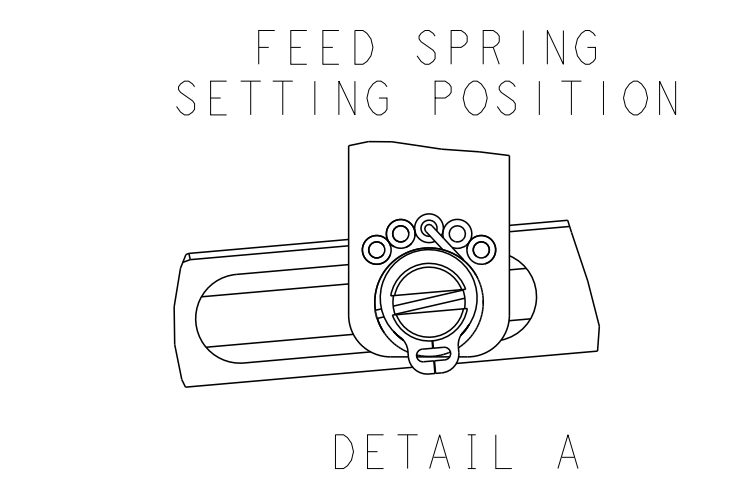
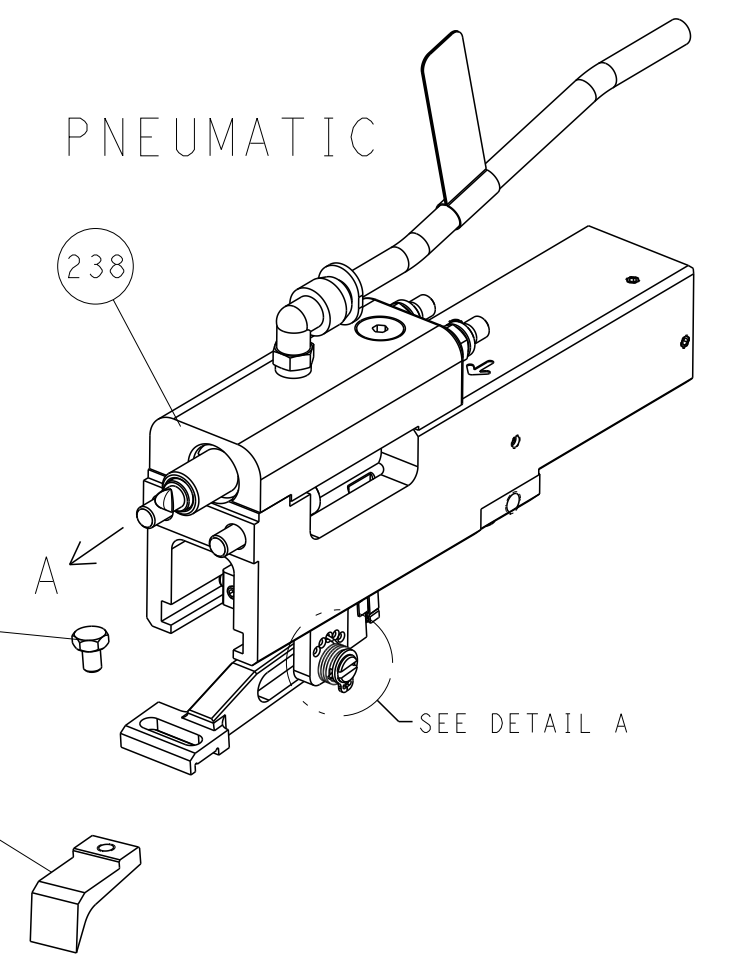
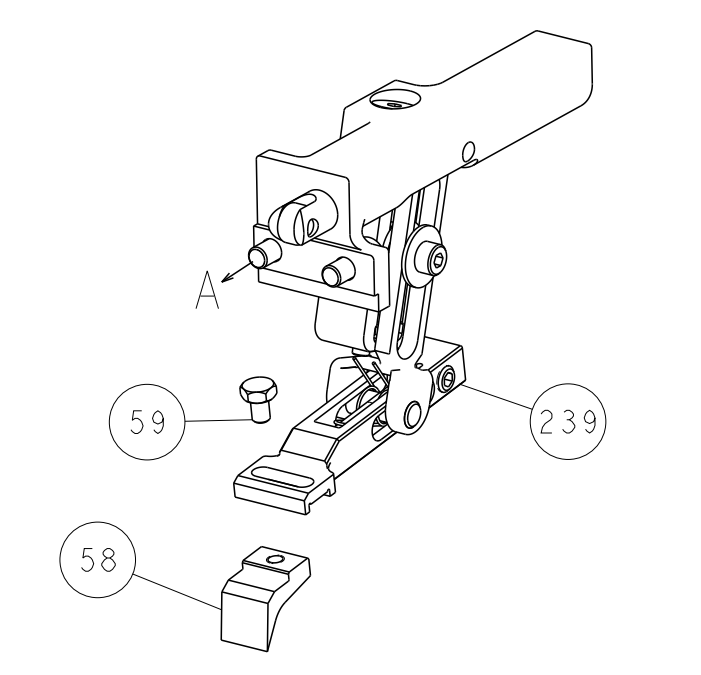
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	PLC	mm	PLC	SIZE	CAGE CODE	DRAWING NO	SCALE
	0 PLC ±		0 PLC ±	A1	00779	2150181	1:1
	1 PLC ±		1 PLC ±	Customer Accessible Production Drawing			
	2 PLC ±		2 PLC ±	SHEET 1 OF 4			
	3 PLC ±		3 PLC ±	REV B			
	4 PLC ±		4 PLC ±				
	ANGLES		FINISH				

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

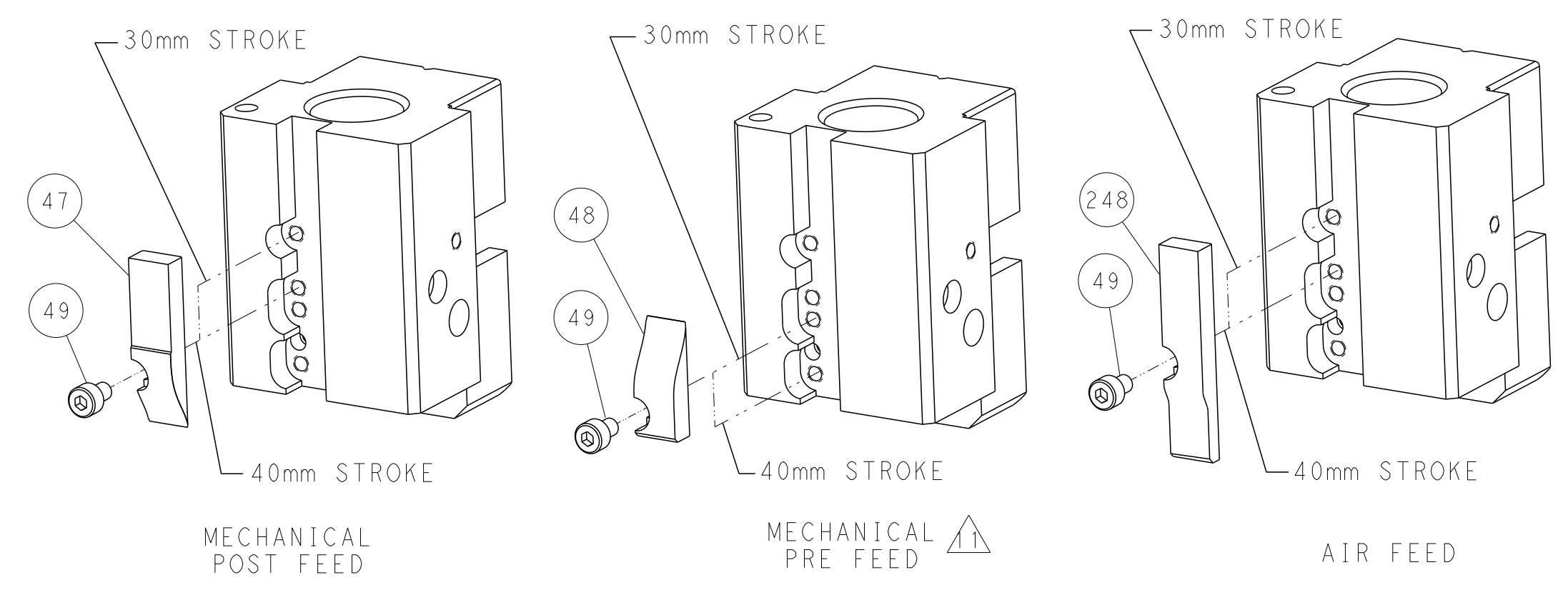


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

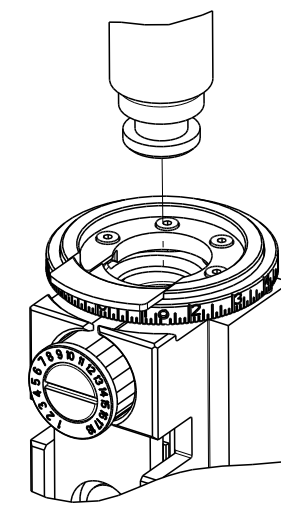


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN B. WEAVER 16AUG2017 CHK T. ELBIN 16AUG2017 APVD T. ELBIN 16AUG2017 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150181 Customer Accessible Production Drawing SHEET 2 OF 4 REV B	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150181-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150181-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150181-7	A	CRIMP TOOLING KIT	-

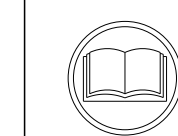
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.68 mm [.145]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G & H (LEAR) TERMINAL				LEAR CRIMP SPECIFICATION			
TERMINAL NAME: 4.8x0.5/0.8 RECEPTACLE W/ LOCK RING							
WIRE STRIP LENGTH 4.60-5.40 mm [.181-.213 IN]				INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]			
TERMINAL APPLICATION SPECIFICATION 2613 Rev 4							
TERMINALS APPLIED							
TE TERMINAL	G & H (LEAR) TERMINAL	TE TERMINAL	G & H (LEAR) TERMINAL	TE TERMINAL	G & H (LEAR) TERMINAL	TE TERMINAL	G & H (LEAR) TERMINAL
1572911-1	26312.123.211	1572911-2	26312.213.011	1572911-3	26312.123.204	1572911-4	26315.123.211
1572911-5	26312.213.001						

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.65+/-0.05 [.065+/- .002]	5.6
1.50mm2	1.45+/-0.05 [.057+/- .002]	7.7



- 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.

***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.

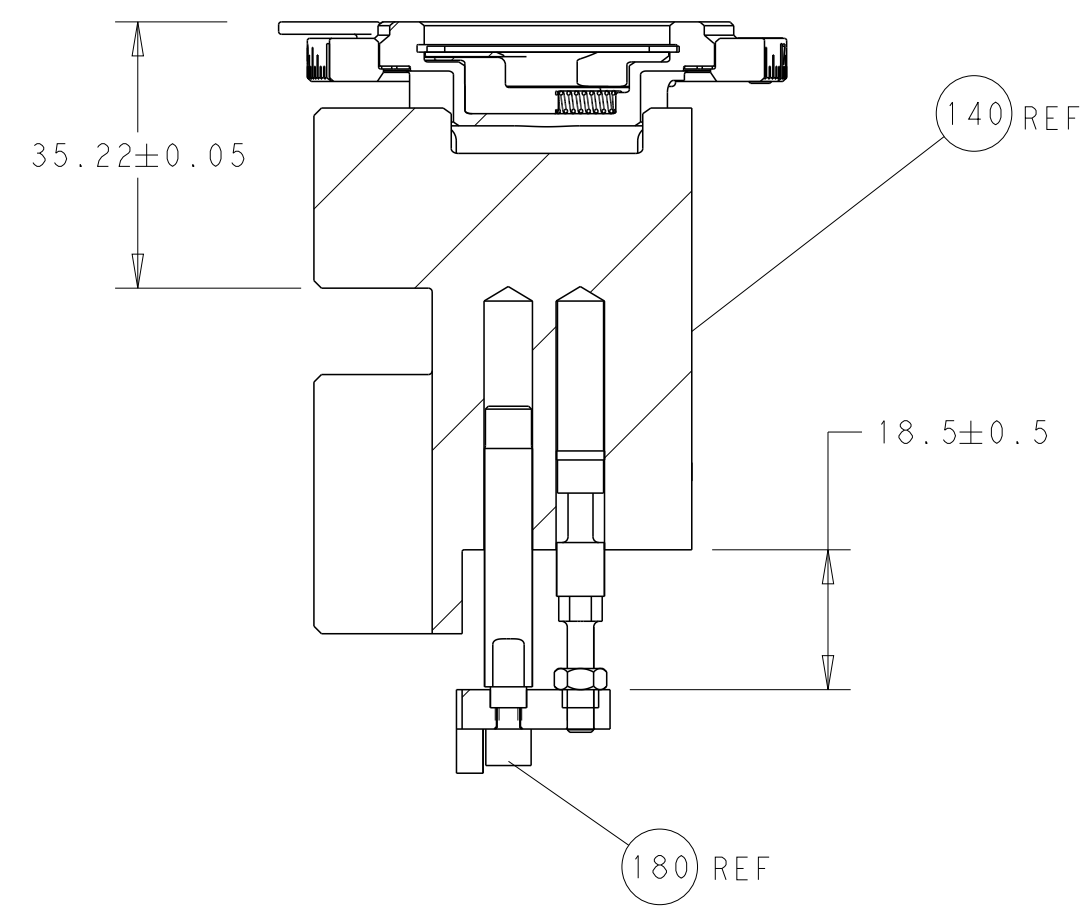
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-3	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	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	
3	-	1	1752354-4	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	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	
5	-	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	1901681-5	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
1	-	1	240833-4	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	1-690495-4	PLATE, FRONT SHEAR	9	
1	1	1	3-1803257-6	ANVIL, COMBINATION, END FEED	8	
1	-	1	690474-5	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-1	SPACER	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	1	2-1803221-7	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	455888-7	SPACER, CRIMPER	2	
1	1	1	3-1803470-4	CRIMPER, WIRE F	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

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

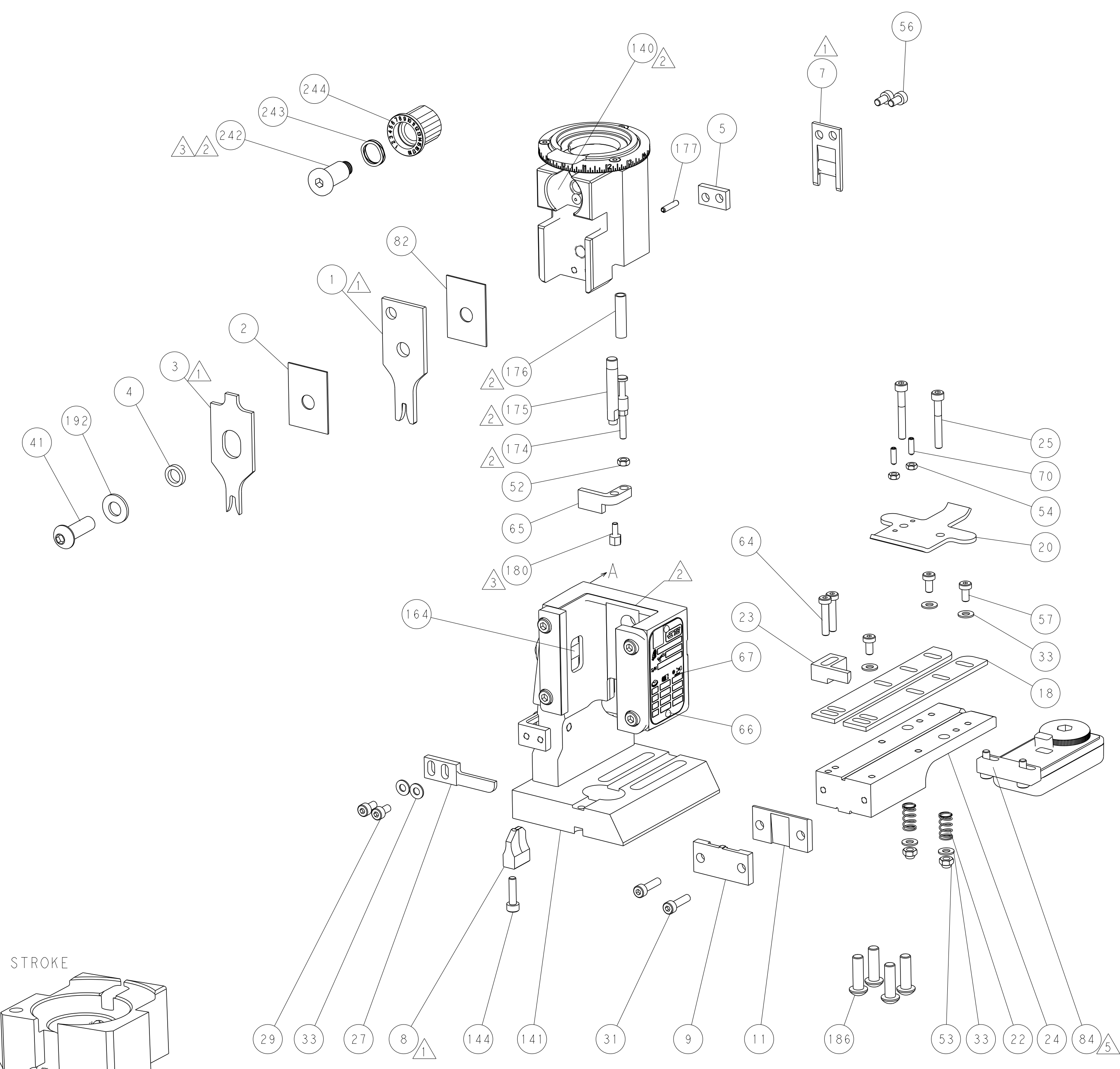
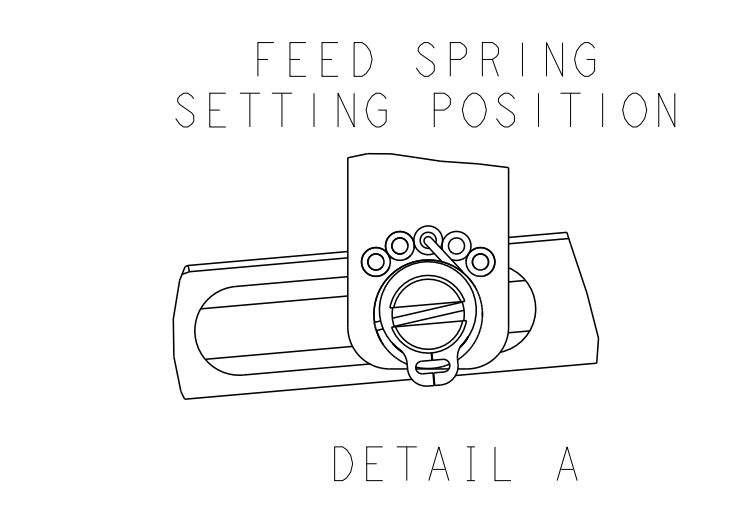
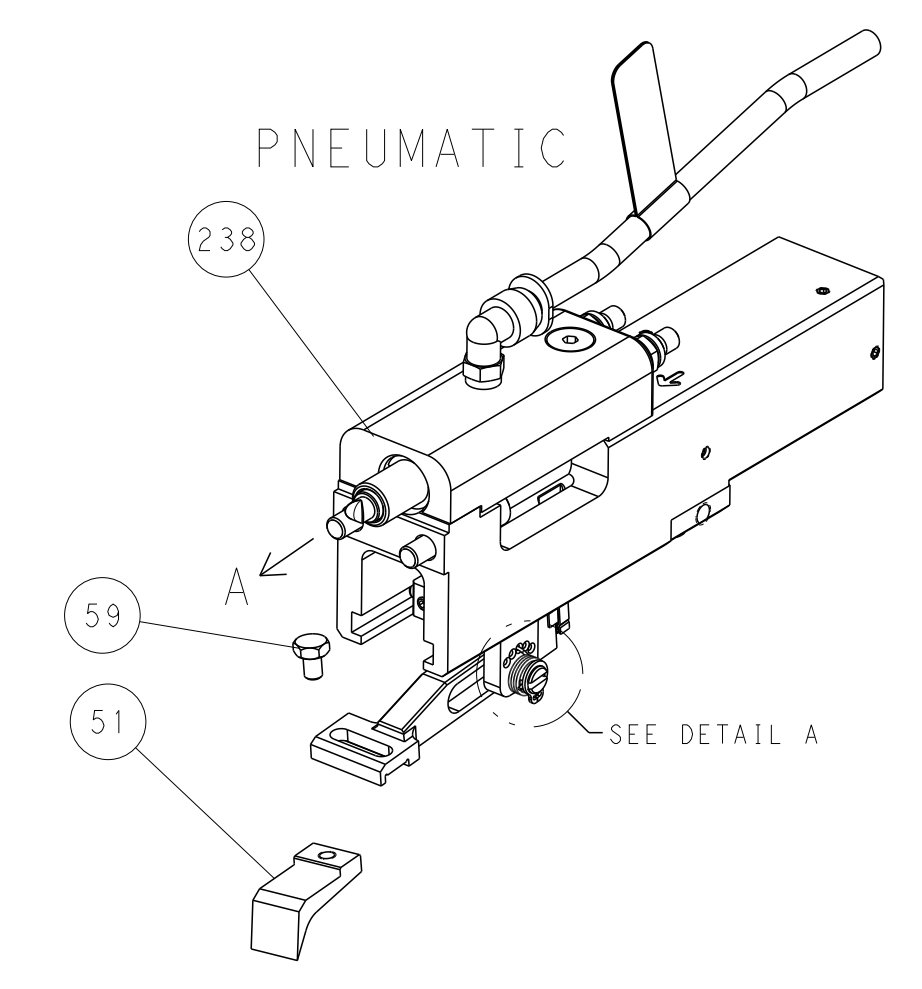
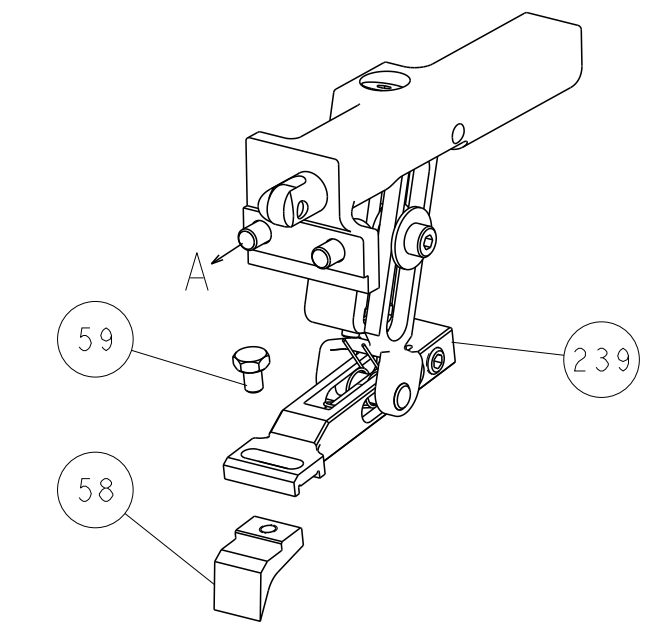
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: .		FINISH: .		WEIGHT: .		SCALE: 1:1		SHEET 3 OF 4		REV B	
Customer Accessible Production Drawing				Customer Accessible Production Drawing							

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

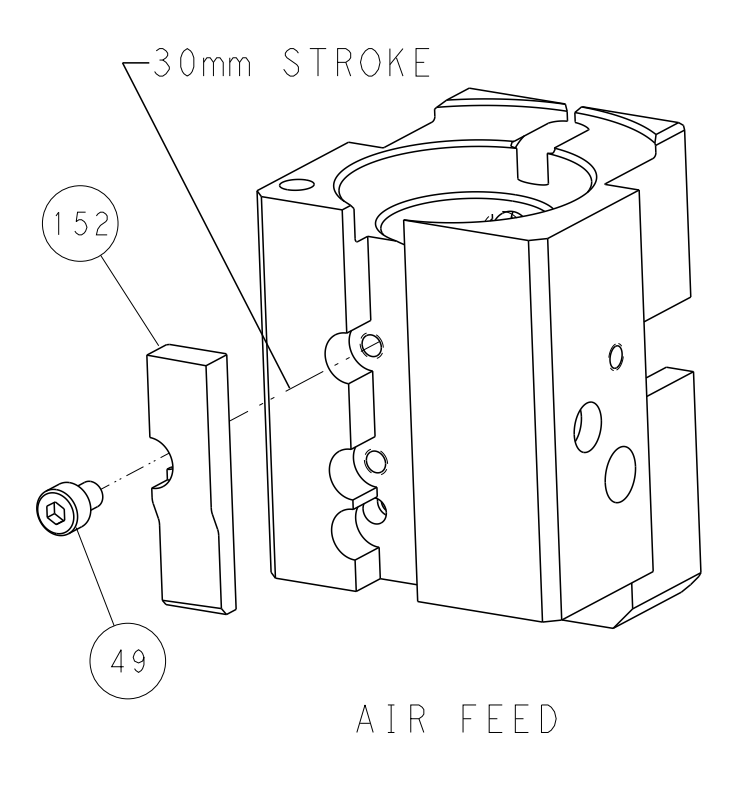
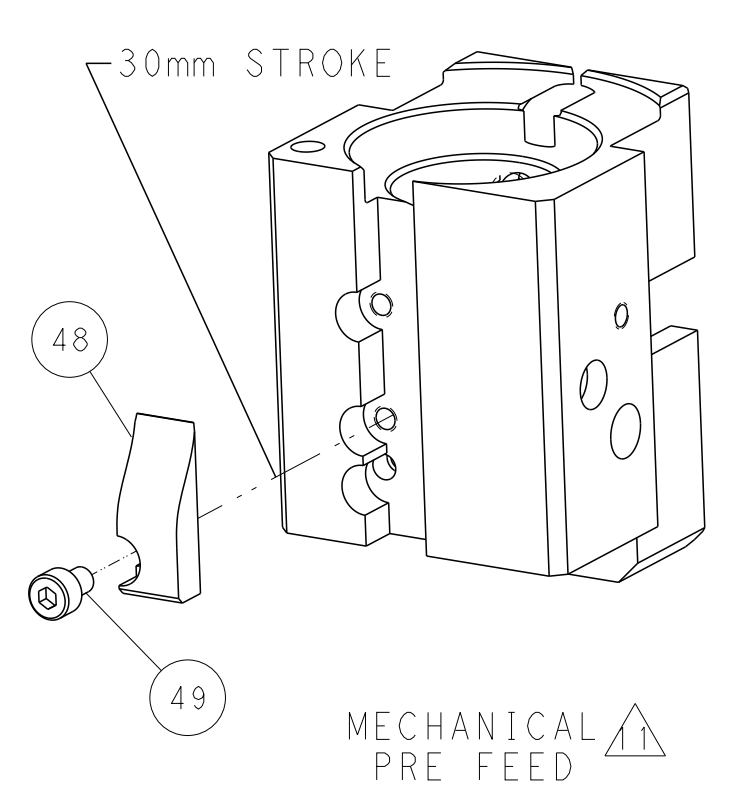
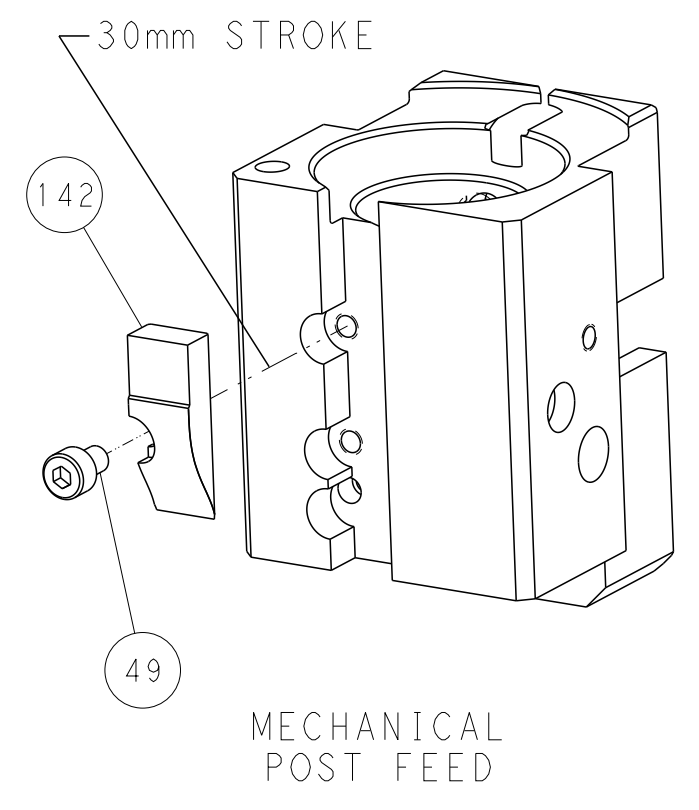


RAM AND HOLDDOWN SET-UP

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER 16AUG2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: T. ELBIN 16AUG2017	NAME: Ocean End Feed Applicator		RESTRICTED TO:
MATERIAL:		WEIGHT:		SIZE: A1	CAGE CODE: 00779	DRAWING NO: C-2150181	
Customer Accessible Production Drawing				SCALE: 1:1	SHEET: 4	OF: 4	REV: B