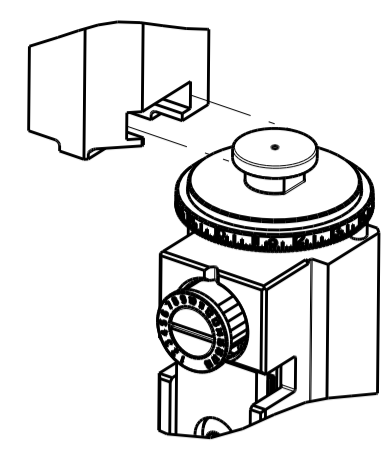


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150299-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-6.00 mm [.205-.236 IN]		Ø1.50-2.00 mm [.059-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25209 REVISION 12		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	4.0
0.75mm2	1.85+/-0.05 [.073+/-0.002]	5.3
0.50mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.35mm2	1.73+/-0.05 [.068+/-0.002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2x 0.50	1.90+/-0.05 [.075+/-0.002]	4.5
1.00mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.75mm2	1.75+/-0.05 [.069+/-0.002]	6.3
2x 0.35	1.70+/-0.05 [.067+/-0.002]	6.7
0.50mm2	1.70+/-0.05 [.067+/-0.002]	6.7

- 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 50.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

**\*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.

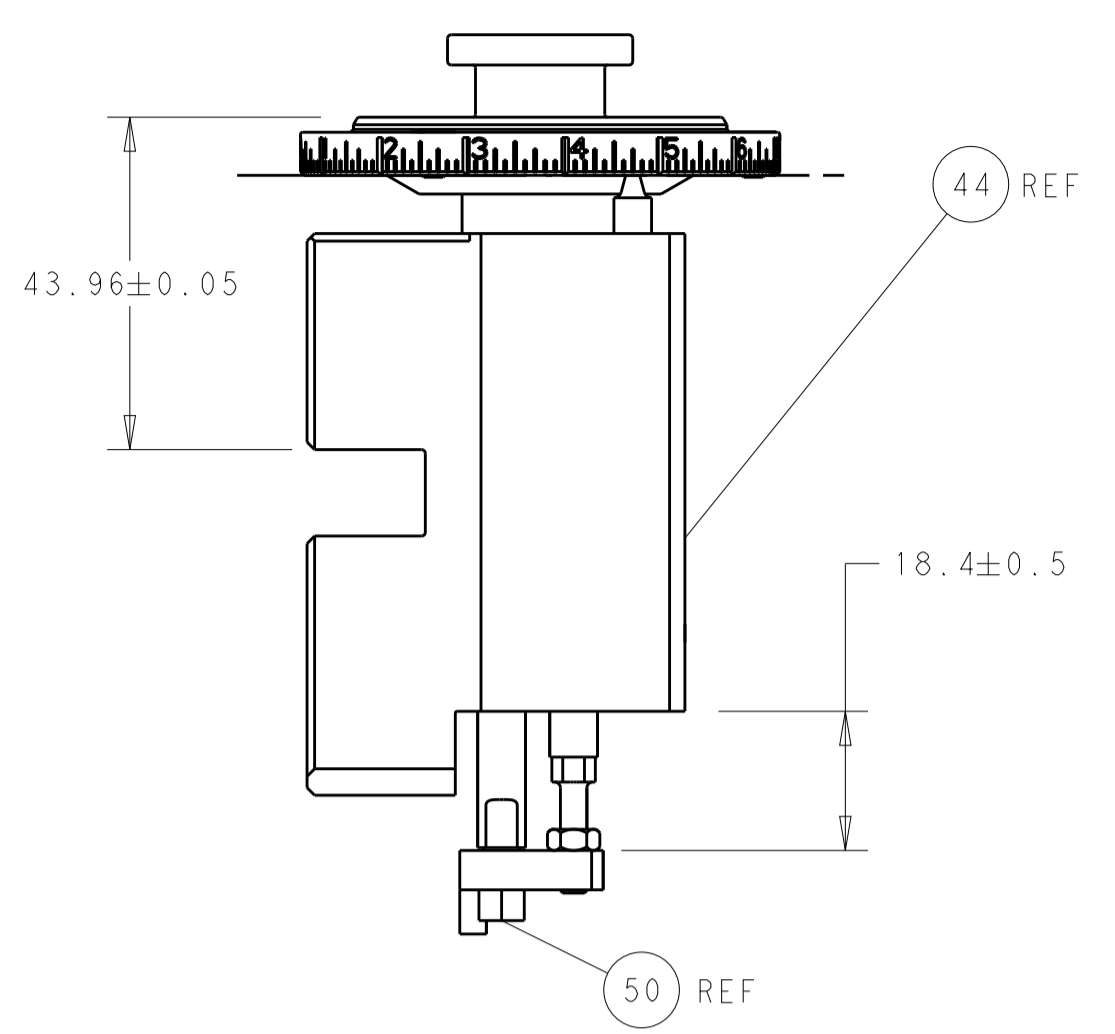
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	B		ECR-14-017572	24NOV2014	RK	GB
		B1		ECR-16-005465	14APR2016	RS	LZ
		C		ECR-19-005818	11APR2019	TB	CT
		D		ECR-20-011001	04AUG2020	FZ	TE

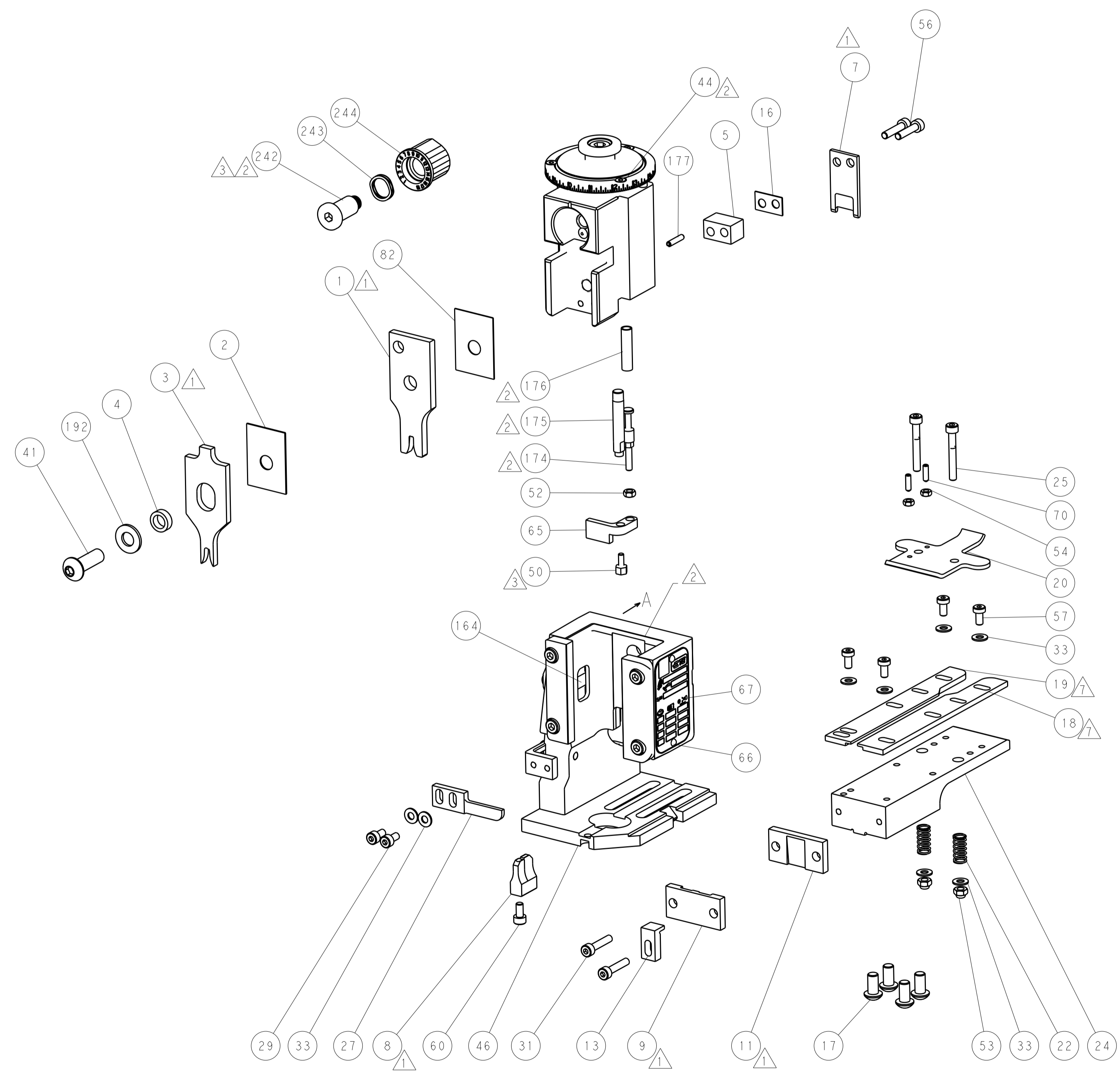
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-993111-6	PIN, SLOTTED 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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-4	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1752354-1	STANDOFF,HOLD-DOWN	50
-	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	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	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-6	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	2	1	2-1803000-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-6	SPACER	5
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	1-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	2	1	4-1633664-7	CRIMPER, WIRE	1
-	77	72	2	PART NO	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: STAKEM 28NOV2012	TE Connectivity Harrisburg, PA 17105-3608
				CHK: G. BAILEY 28NOV2012	
MATERIAL:		FINISH:		APVD: T. ERLIN 28NOV2012	NAME: Ocean End Feed Applicator
WEIGHT:		SCALE: 1:1		SHEET 1 OF 4	REV D

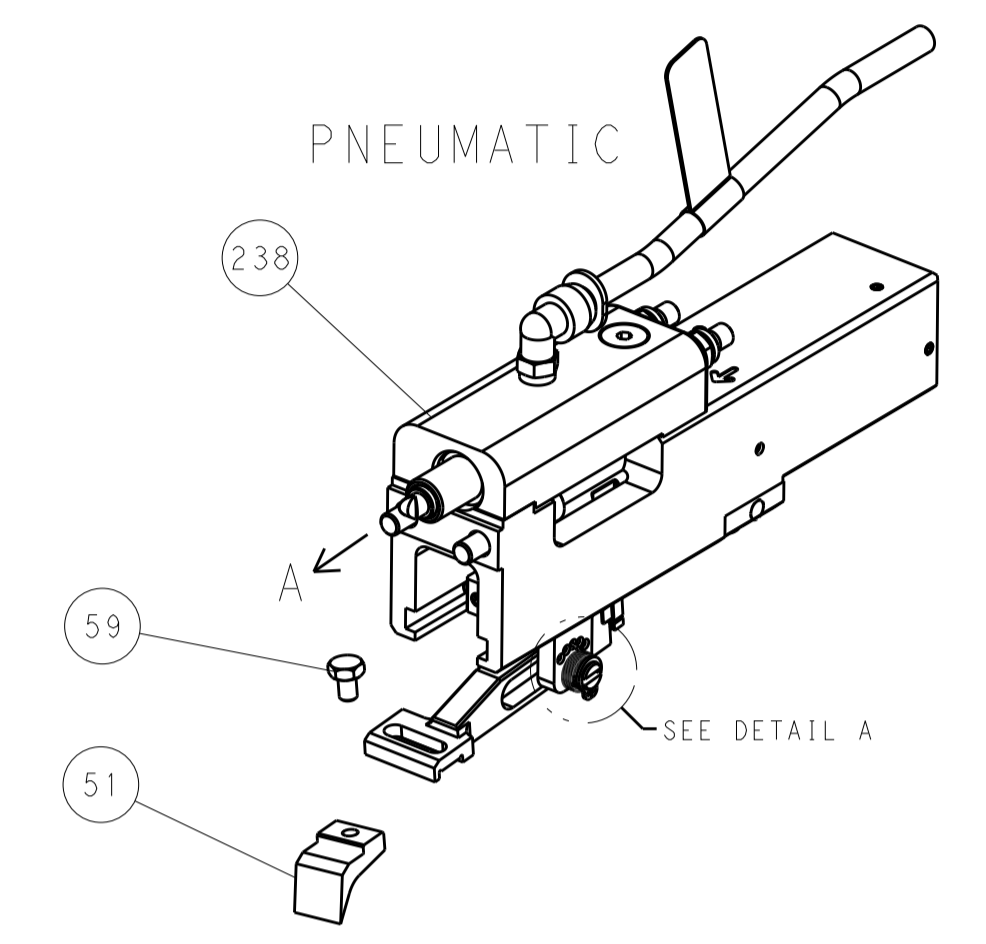
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



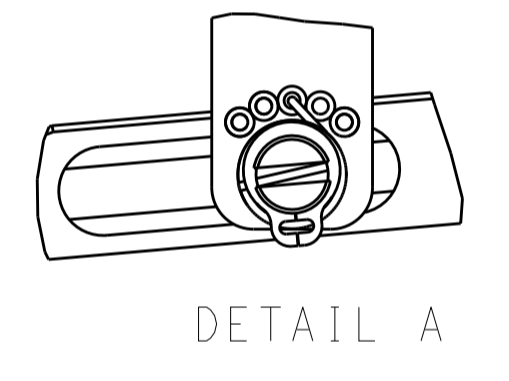
RAM AND HOLDDOWN SET-UP



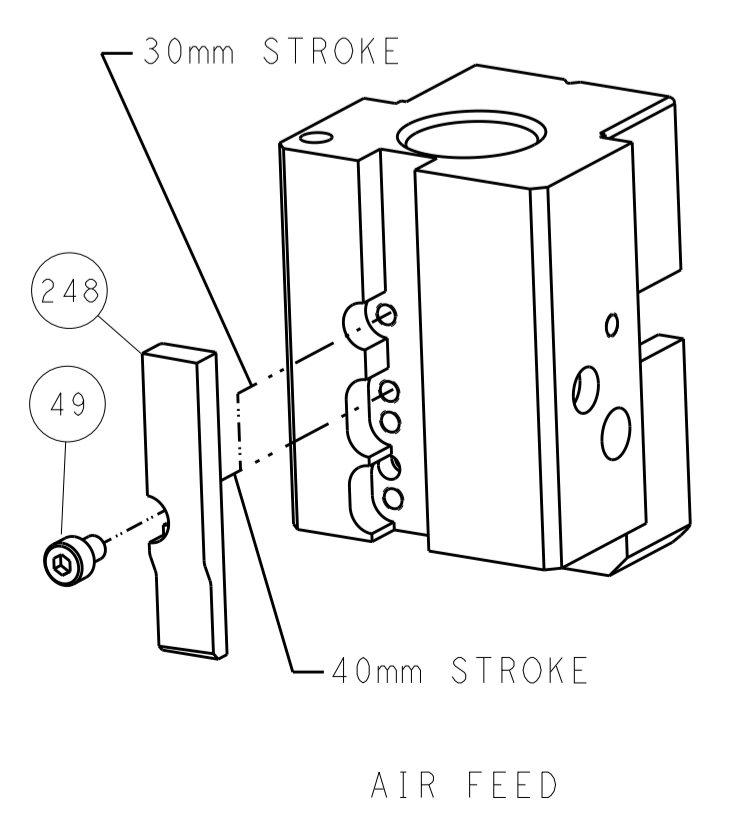
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

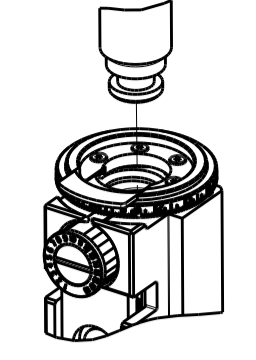


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		DWN: K. STAKEM 28NOV2012 CHK: G. BAILEY 28NOV2012 APVD: T. ERLIN 28NOV2012 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150299 SCALE: 1:1 SHEET: 2 of 4 REV: D		RESTRICTED TO: TE Connectivity Harrisburg, PA 17105-3608	
-----------------------	--	---	--	---	--	---	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150299-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: CLAW TERMINAL RING TONGUE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.20-6.00 mm [.205-.236 IN]	Ø1.50-2.00 mm [.059-.079 IN]

TERMINAL APPLICATION SPECIFICATION: NONE

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: CLAW TERMINAL RING TONGUE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-6.00 mm [.197-.236 IN]	Ø1.30-2.10 mm [.051-.083 IN]

TERMINAL APPLICATION SPECIFICATION: LEAR DATA SHT 25209 REVISION 12

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	4.0
0.75mm2	1.85+/-0.05 [.073+/-0.002]	5.3
0.50mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.35mm2	1.73+/-0.05 [.068+/-0.002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2x 0.50	1.90+/-0.05 [.075+/-0.002]	4.5
1.00mm2	1.80+/-0.05 [.071+/-0.002]	5.8
0.75mm2	1.75+/-0.05 [.069+/-0.002]	6.3
2x 0.35	1.70+/-0.05 [.067+/-0.002]	6.7
0.50mm2	1.70+/-0.05 [.067+/-0.002]	6.7

- 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 50.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

**\*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.

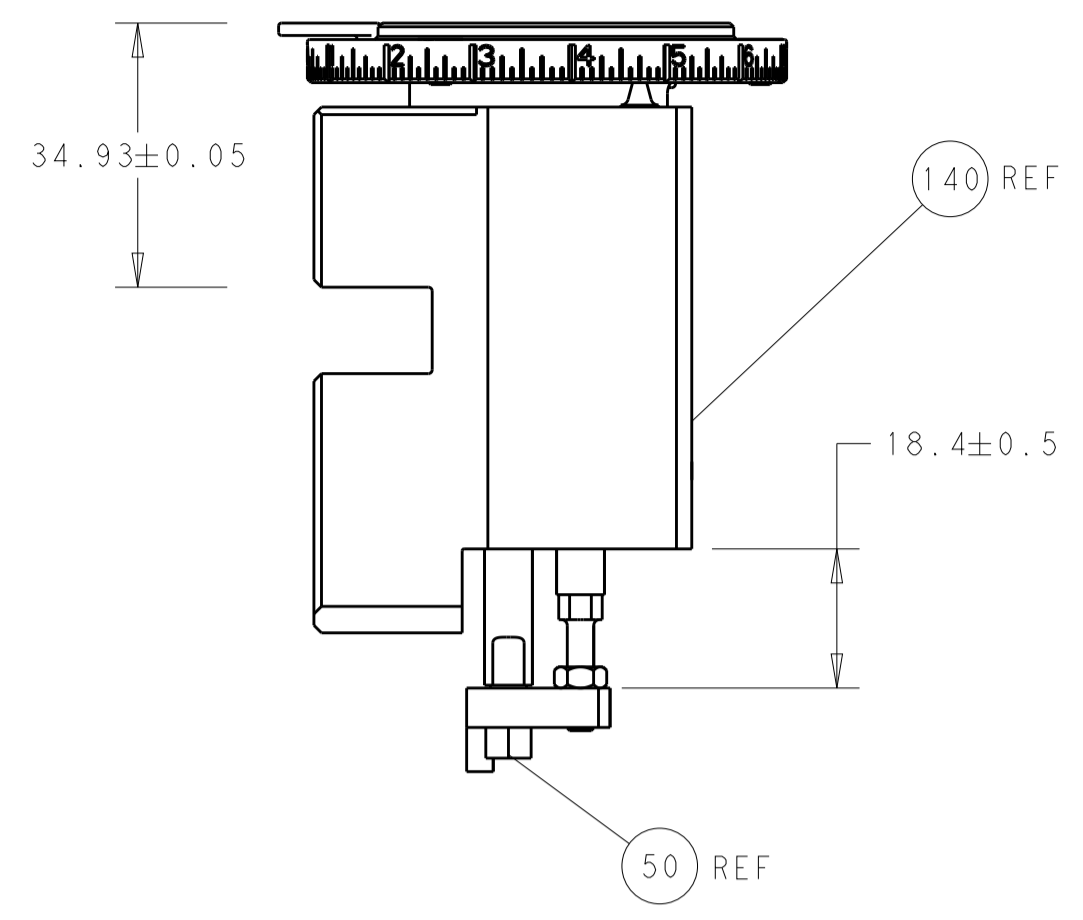
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPD
A	66				

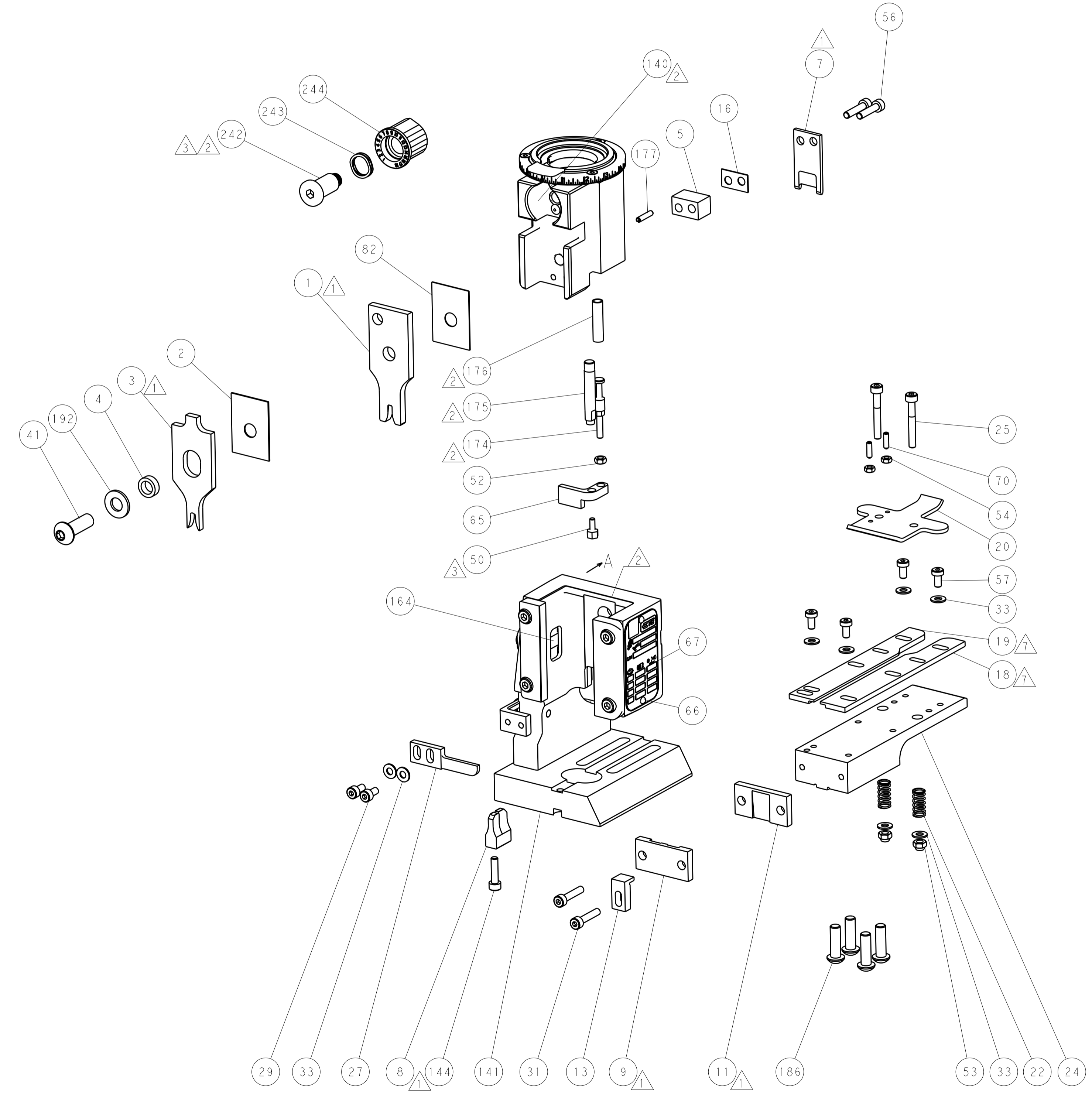
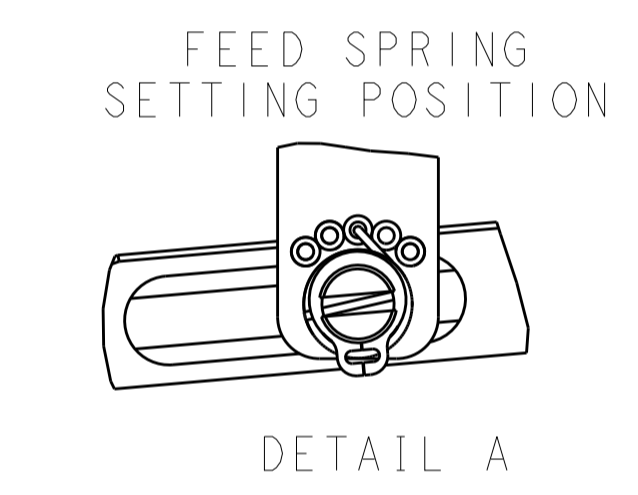
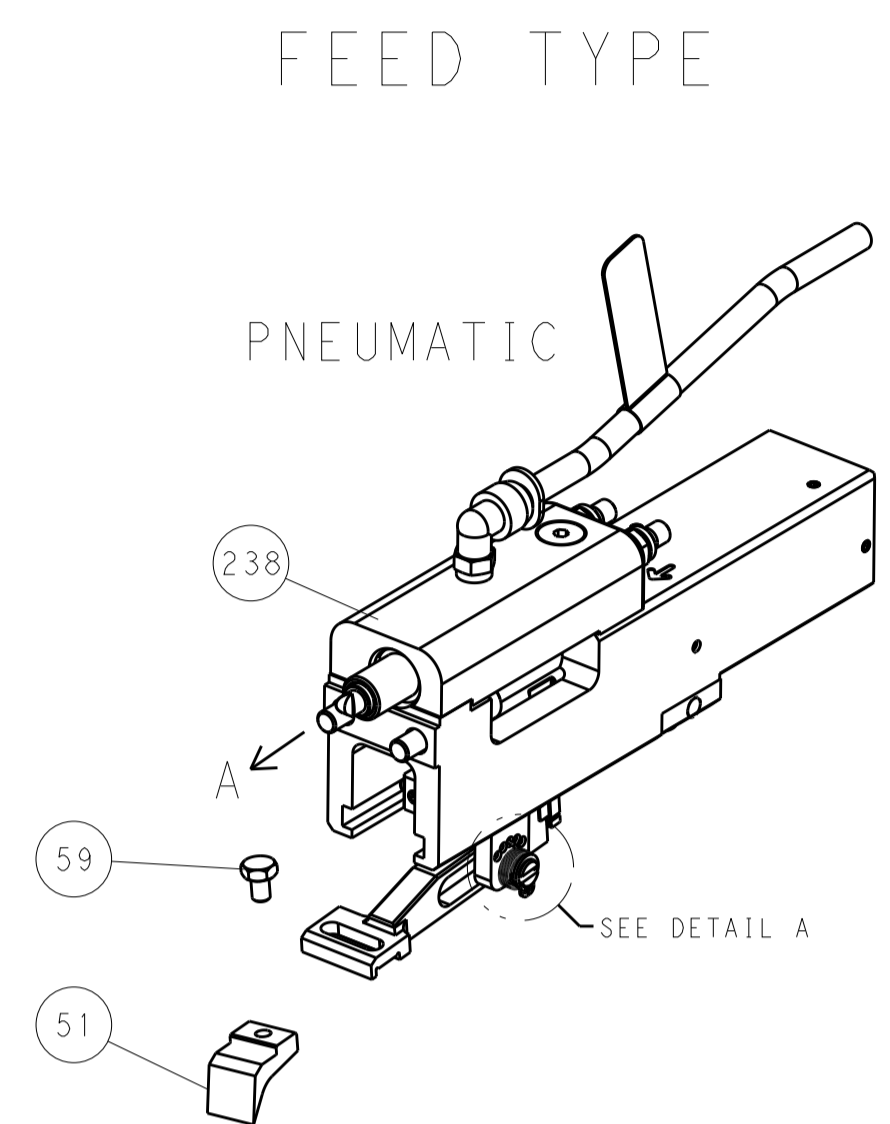
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	1	2119082-8			
-	1	2079764-1			
-	1	2119083-1			
-	1	2844940-4			
-	1	1-18028-0			
-	4	2079383-9			
-	1	6-993111-6			
-	1	8-22280-7			
-	1	1752353-2			
-	1	1901680-2			
-	REF	994970-2			
-	1	2119641-2			
-	1	2168083-8			
-	1	2119655-6			
-	1	1803518-1			
-	1	455888-4			
-	1	1803607-4			
-	2	2-18032-2			
-	1	2119740-1			
-	2	2168078-1			
-	1	1901681-1			
-	1	5-18022-5			
-	4	2168400-4			
-	2	2-2168083-6			
-	2	5018030-1			
-	2	986965-8			
-	1	1-5018030-0			
-	1	2063961-1			
-	1	1752354-1			
-	1	18023-9			
-	1	1803602-1			
-	8	1-18028-2			
-	2	2168083-9			
-	2	2168083-2			
-	1	240639-1			
-	2	1-2168083-5			
-	1	1752371-5			
-	2	2-22281-3			
-	1	1803292-4			
-	1	1-1901696-5			
-	1	1-1901695-5			
-	1	6-240641-6			
-	1	1752360-1			
-	1	240644-1			
-	-	-			
-	1	690482-4			
1	1	2-1803000-3			
-	1	1-2217206-2			
-	-	-			
-	1	2-240641-6			
-	1	4-238011-2			
1	1	1-2119785-7			
-	1	455888-6			
1	1	4-1633664-7			
-	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: STAKEM 28NOV2012 CHK: G. BAILEY 28NOV2012 APVD: T. ERLIN 28NOV2012		NAME: TE Connectivity Harrisburg, PA 17105-3608 PRODUCT SPEC: Ocean End Feed Applicator APPLICATION SPEC:	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150299 RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 OF 4 REV D	

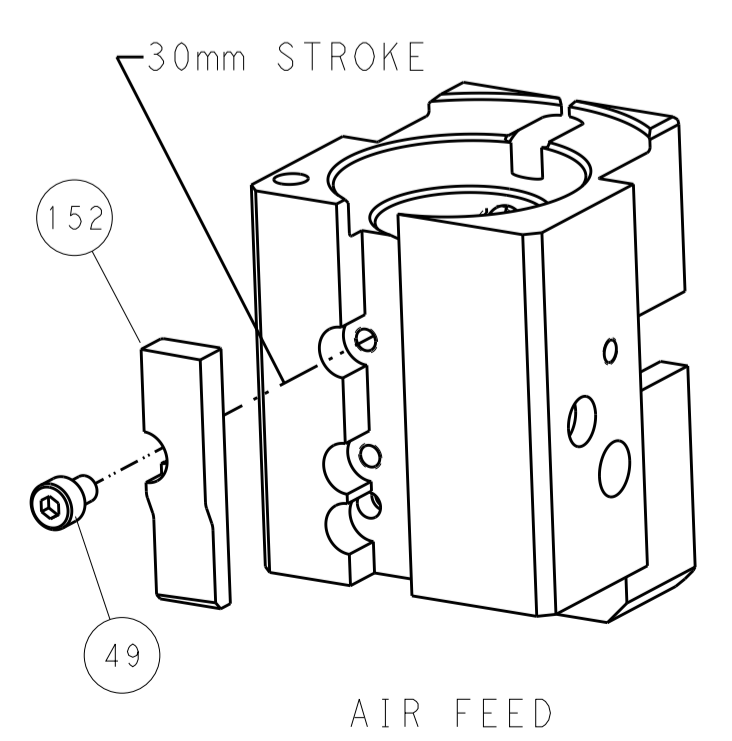
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. STAKEM 28NOV2012 CHK: G. BAILEY 28NOV2012 APVD: T. ERLIN 28NOV2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150299 SHEET: 4 of 4 REV: D
Customer Accessible Production Drawing			