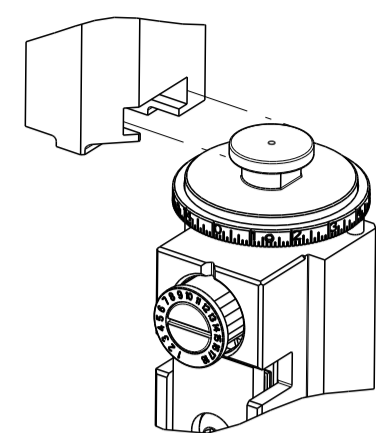


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150646-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150646-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150646-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: CLAW TERMINAL RING TYPE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
6.10-6.90 mm [.240-.272 IN]	∅3.30-5.00 mm [.130-.197 IN]

TERMINAL APPLICATION SPECIFICATION	25231 Rev 9

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949266-1	25231.212.004	1949266-2	25231.212.011
1949266-3	25231.212.179	1949266-4	25231.212.320
1949266-5	25231.122.009	1949266-6	25231.122.011
1949266-7	25231.122.014	1949266-8	25231.122.322
1949266-9	25231.122.323	1-1949266-0	25231.411.131
1-1949266-1	25231.211.XXX	1-1949266-2	25231.213.XXX
1-1949266-3	25231.201.XXX	1-1949266-4	25231.123.XXX
1-1949266-5	25231.111.XXX	1-1949266-6	25231.214.XXX
1-1949266-7	25231.331.XXX	2303636-1	25229.111.XXX
2303636-2	25229.122.XXX	2303636-3	25229.123.XXX
2303636-4	25229.201.XXX	2303636-5	25229.212.XXX
2303636-6	25229.213.XXX	2303636-7	25229.214.XXX
2303636-8	25229.221.XXX	2303636-9	25229.331.XXX
1-2303636-0	25229.411.XXX		

*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.

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm ²	3.15+/-0.10 [.124+/-0.004]	4.0
10 AWG	3.10+/-0.10 [.122+/-0.004]	4.2
4.0mm ² + 0.75mm ²	3.05+/-0.10 [.120+/-0.004]	4.3
(2) 2.5mm ²	3.00+/-0.10 [.118+/-0.004]	4.8
4.00mm ²	2.95+/-0.10 [.116+/-0.004]	5.1
12 AWG	2.80+/-0.05 [.110+/-0.002]	7.0



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

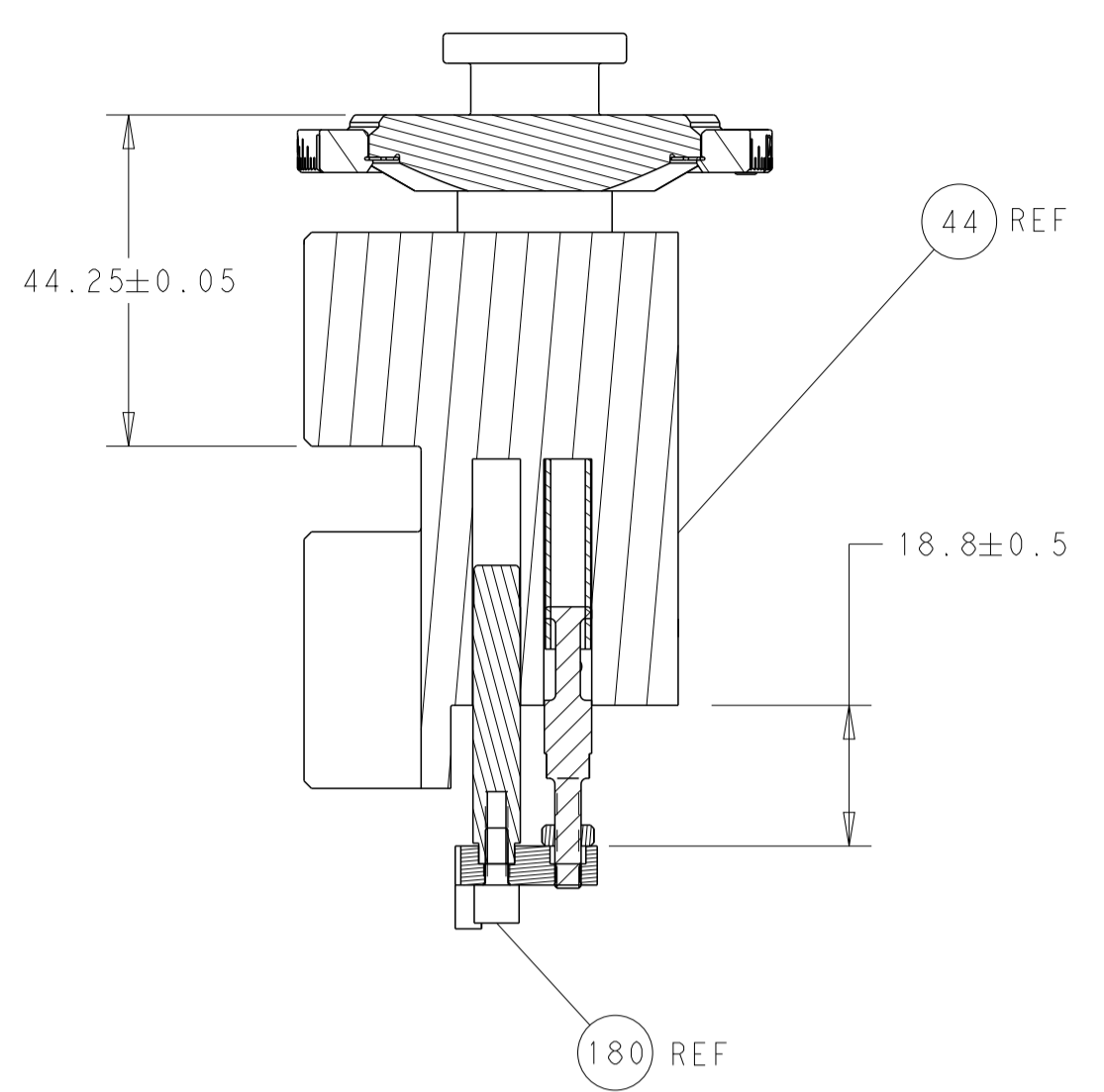
LOC	DIST	REVISIONS					
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		A1		ECR-16-010865	1AUG2016	RS	LZ
		B		ECR-18-017784	13NOV2018	TB	CT
		C		ECR-21-004030	05APR2021	LG	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	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	1752354-5	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	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	1901681-1	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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	690455-3	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	3-1901696-5	STRIP GUIDE, REAR	19	
-	1	1	3-1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-1	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	2	1	4-1803059-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-9	SPACER	5
-	1	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1	9-1803016-0	CRIMPER, INSULATION F	3
-	1	1	1	455888-9	SPACER, CRIMPER	2
-	1	2	1	6-1803188-9	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

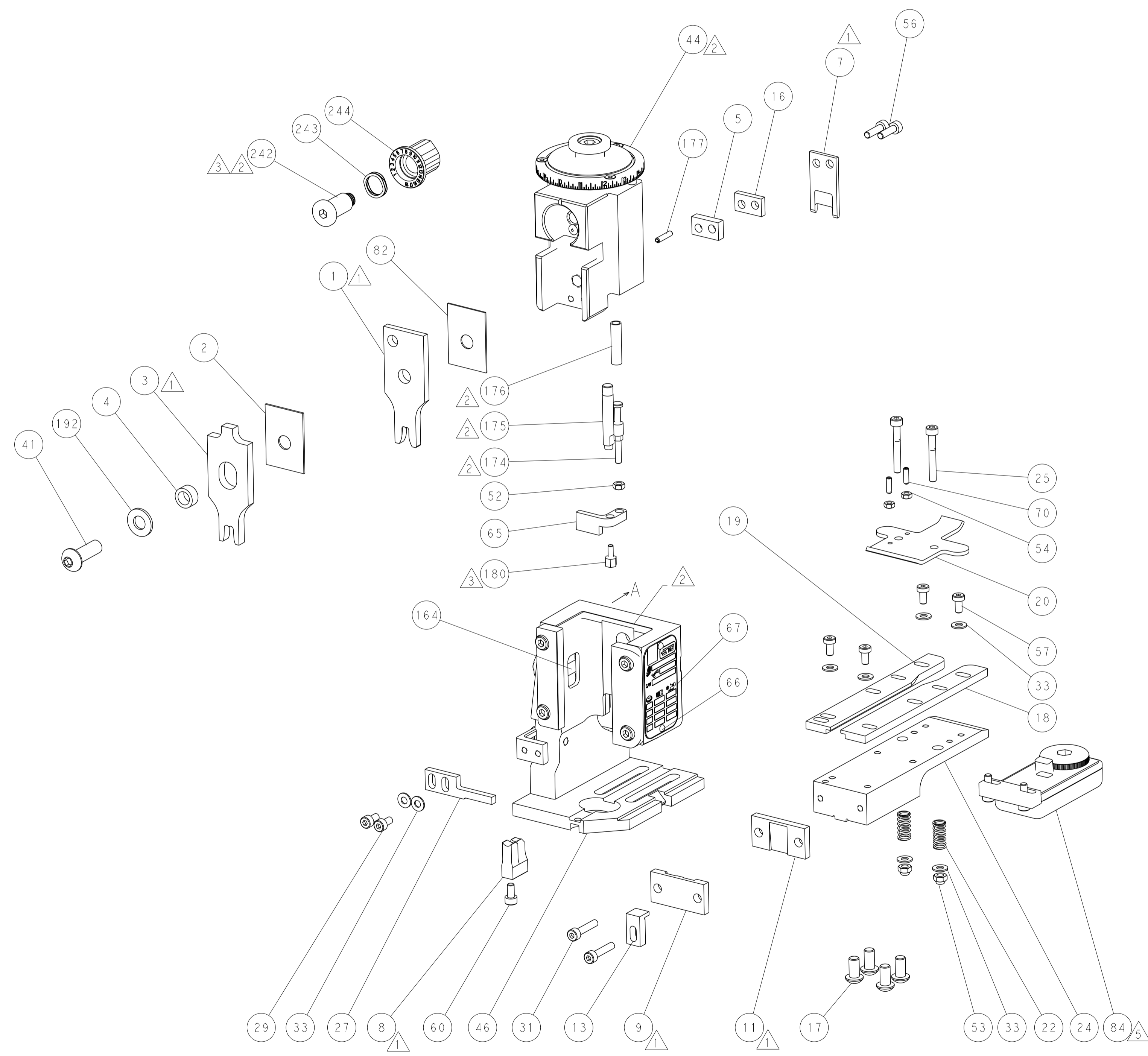
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	1	4	1	C

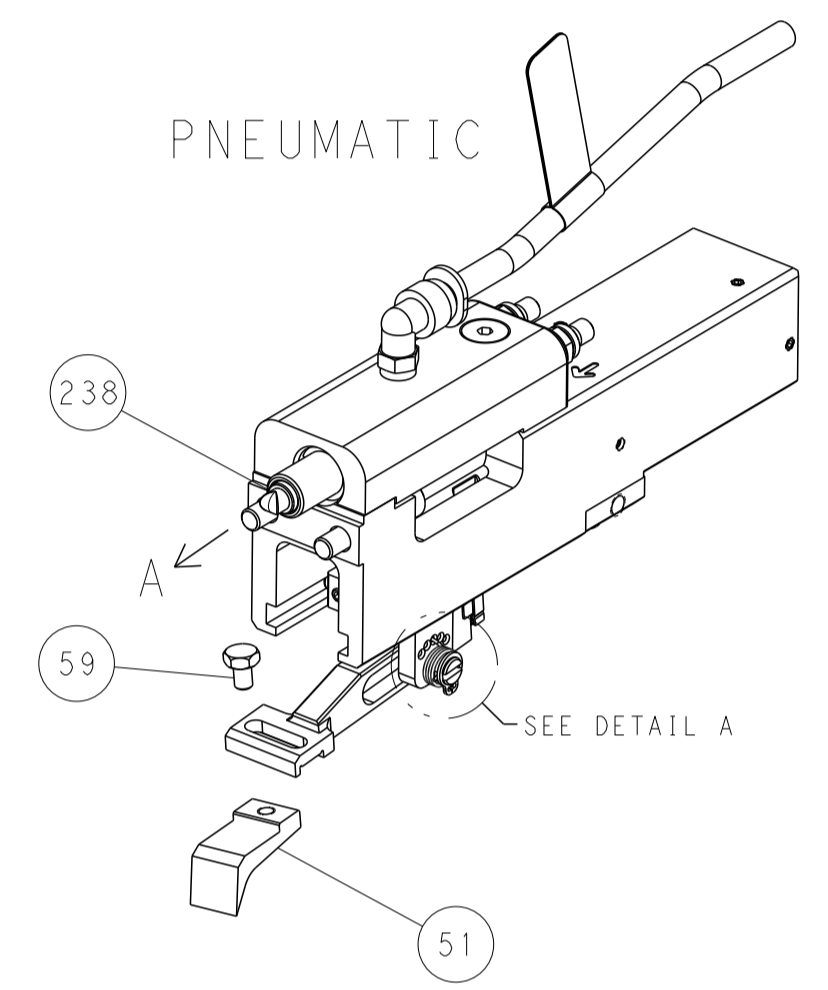
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-



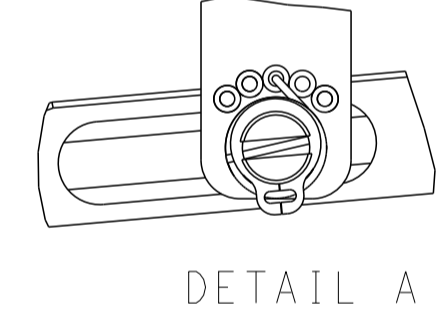
RAM AND HOLDDOWN SET-UP



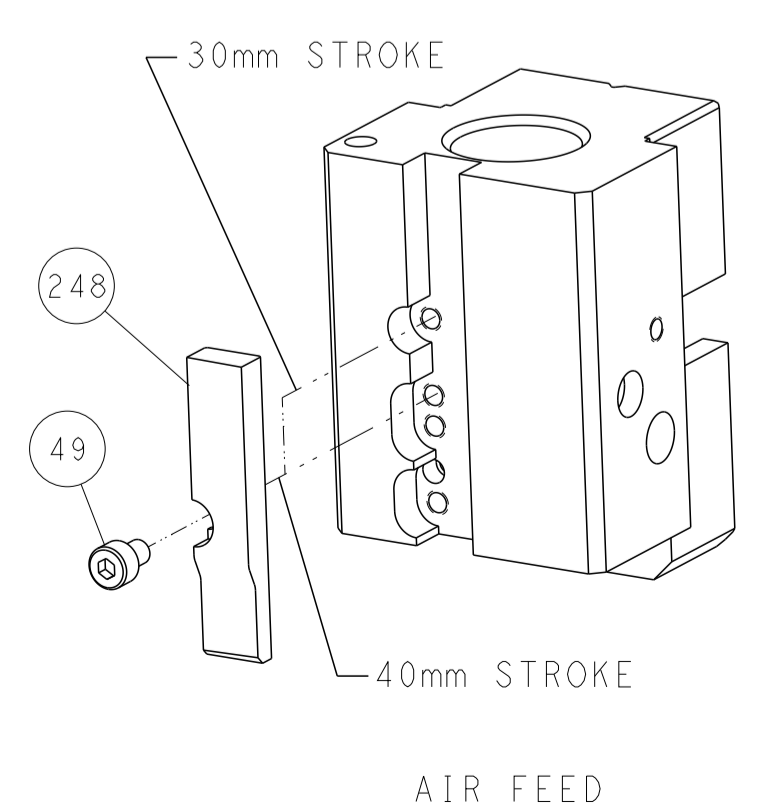
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

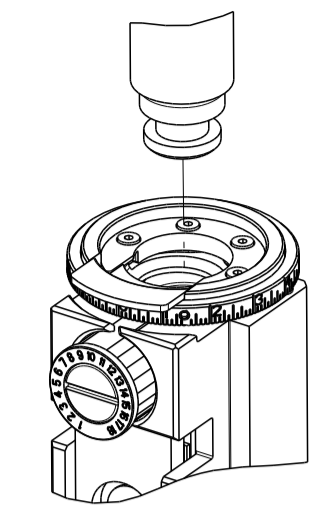


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN X.ZHAO 10MAR2016 CHK L.ZHANG 10MAR2016 APVD L.ZHANG 10MAR2016	NAME Ocean End Feed Applicator	SIZE CAGE CODE DRAWING NO A1 00779 C=2150646	RESTRICTED TO -	
MATERIAL: -		WEIGHT: -		Customer Accessible Production Drawing		SCALE 1:1	SHEET 2 OF 4	REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150646-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150646-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TYPE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
6.10-6.90 mm [.240-.272 IN]	∅3.30-5.00 mm [1.130-.197 IN]		
TERMINAL APPLICATION SPECIFICATION			
25231 Rev 9			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949266-1	25231.212.004	1949266-2	25231.212.011
1949266-3	25231.212.179	1949266-4	25231.212.320
1949266-5	25231.122.009	1949266-6	25231.122.011
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1949266-9	25231.122.323	1-1949266-0	25231.411.131
1-1949266-1	25231.211.XXX	1-1949266-2	25231.213.XXX
1-1949266-3	25231.201.XXX	1-1949266-4	25231.123.XXX
1-1949266-5	25231.111.XXX	1-1949266-6	25231.214.XXX
1-1949266-7	25231.331.XXX	2303636-1	25229.111.XXX
2303636-2	25229.122.XXX	2303636-3	25229.123.XXX
2303636-4	25229.201.XXX	2303636-5	25229.212.XXX
2303636-6	25229.213.XXX	2303636-7	25229.214.XXX
2303636-8	25229.221.XXX	2303636-9	25229.331.XXX
1-2303636-0	25229.411.XXX		

***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.

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm ²	3.15+/-0.10 [.124+/- .004]	4.0
10 AWG	3.10+/-0.10 [.122+/- .004]	4.2
4.0mm ² + 0.75mm ²	3.05+/-0.10 [.120+/- .004]	4.3
(2) 2.5mm ²	3.00+/-0.10 [.118+/- .004]	4.8
4.00mm ²	2.95+/-0.10 [.116+/- .004]	5.1
12 AWG	2.80+/-0.05 [.110+/- .002]	7.0

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

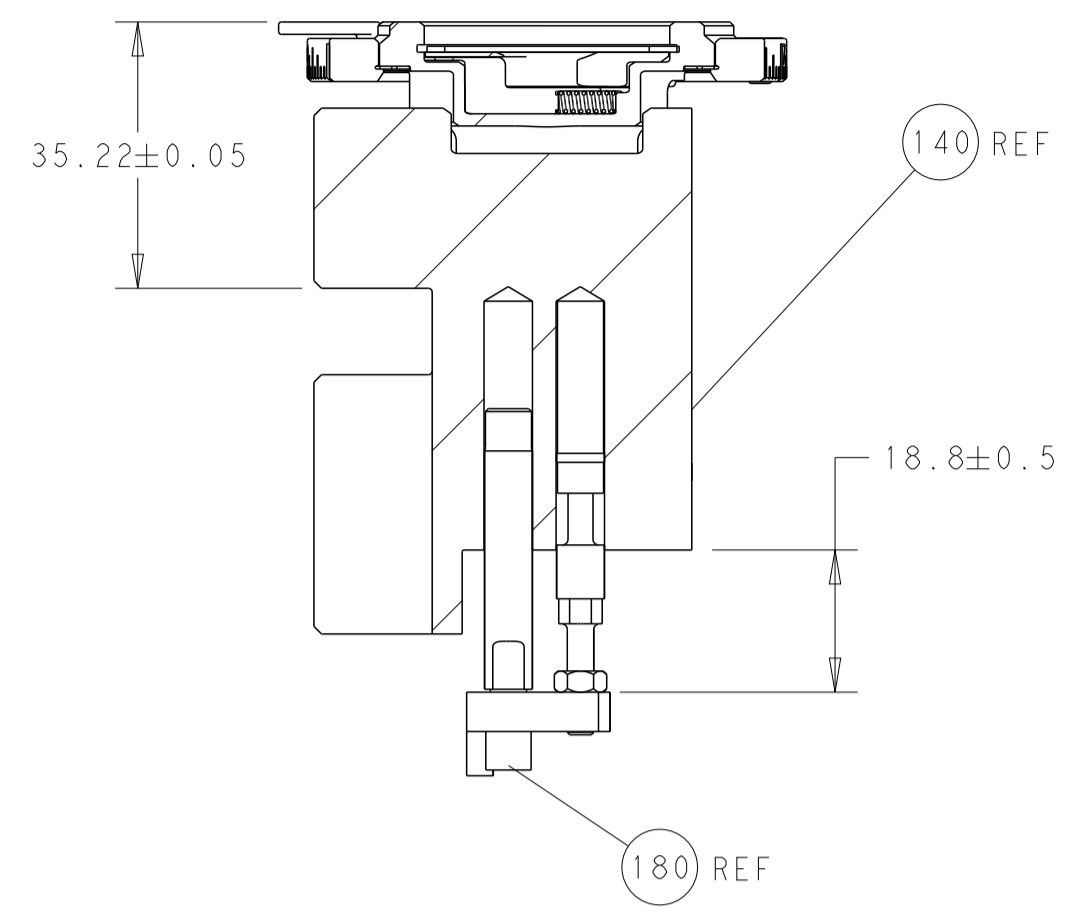
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-6	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	
3	-	1	1752354-5	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	
3	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-7	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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	690455-3	STRIPPER, FRONT CASTING	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	3-1901696-5	STRIP GUIDE, REAR	19	
-	1	3-1901695-5	STRIP GUIDE, FRONT	18	
-	1	240641-1	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	690482-3	PLATE, FRONT SHEAR	9	
1	1	4-1803059-2	ANVIL, COMBINATION, END FEED	8	
-	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	6	
-	1	2-240641-9	SPACER	5	
-	1	6-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	9-1803016-0	CRIMPER, INSULATION F	3	
-	1	455888-9	SPACER, CRIMPER	2	
1	1	6-1803188-9	CRIMPER, WIRE	1	
-	77-22	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)

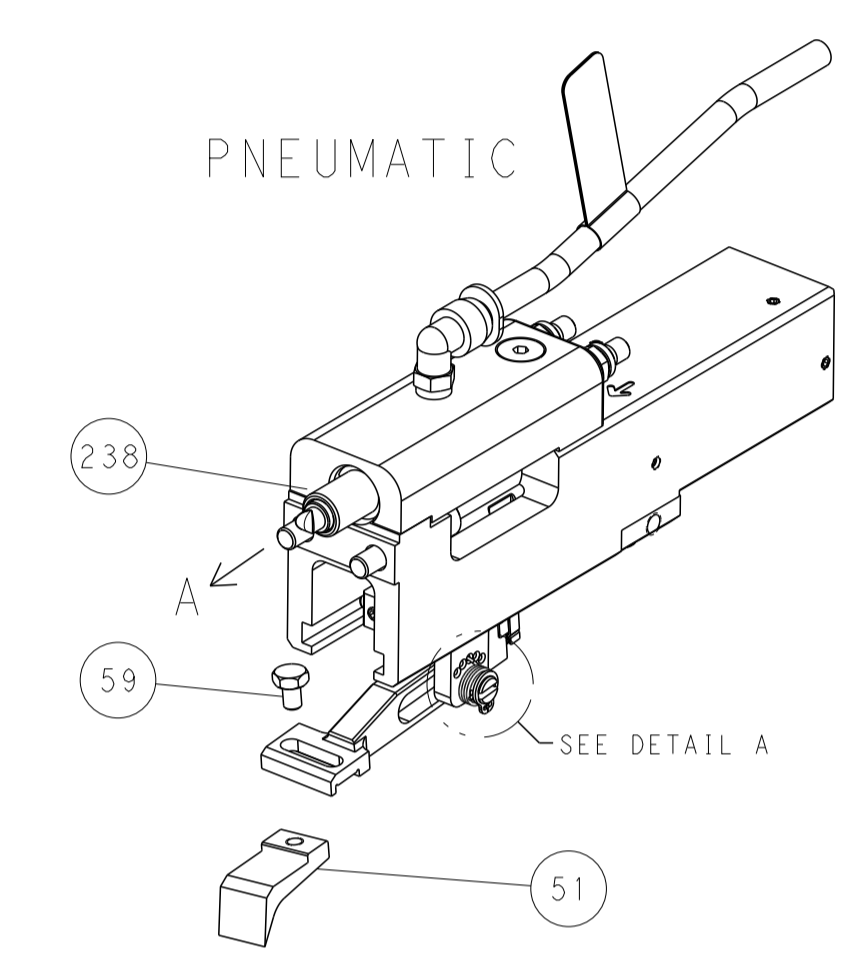
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±		DWN X ZHAO 10MAR2016 CHK L ZHANG 10MAR2016 APVD L ZHANG 10MAR2016 PRODUCT SPEC APPLICATION SPEC		NAME Ocean End Feed Applicator	
MATERIAL		WEIGHT		SCALE		SHEET 3 OF 4	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4		REV C	

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

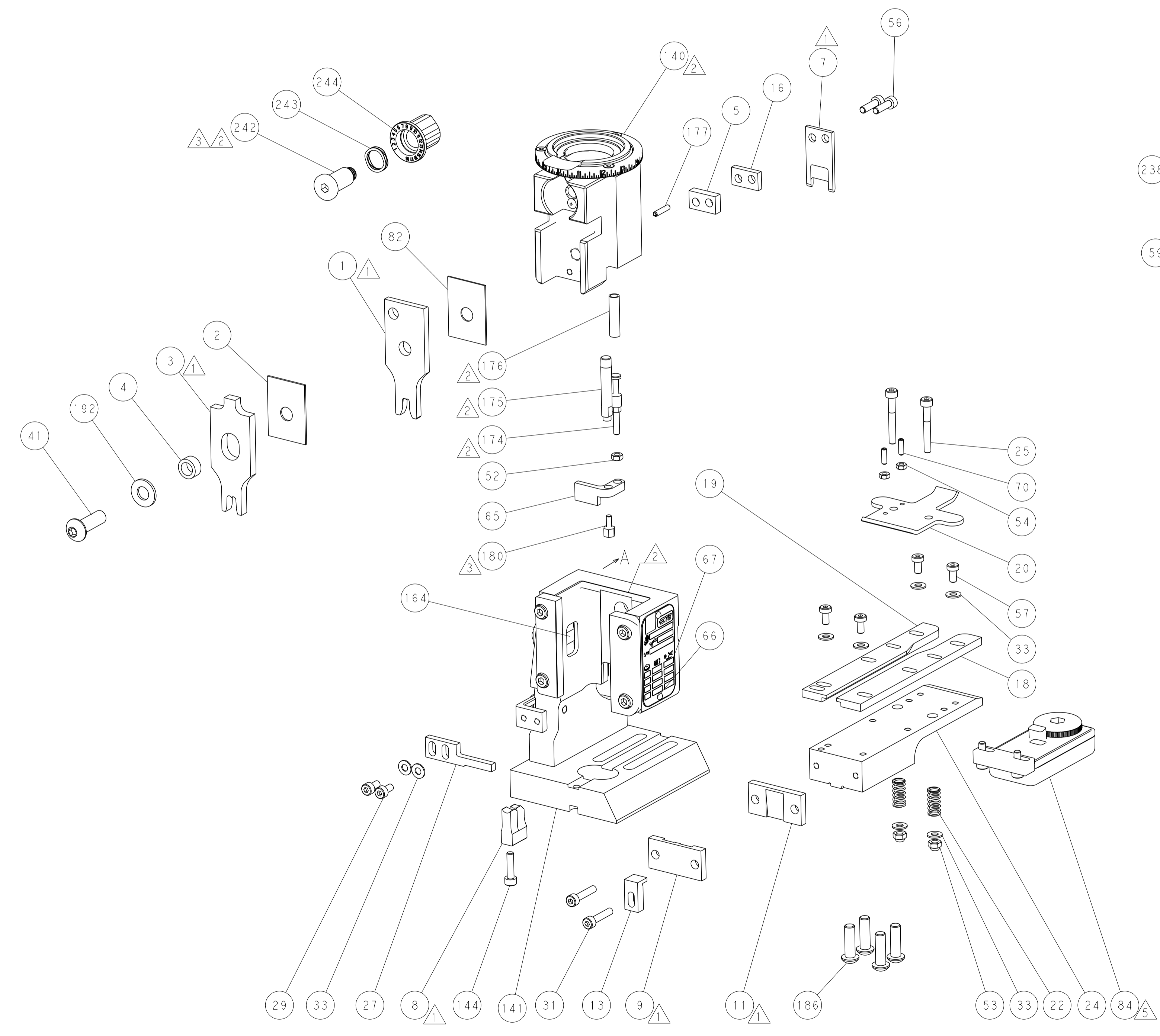
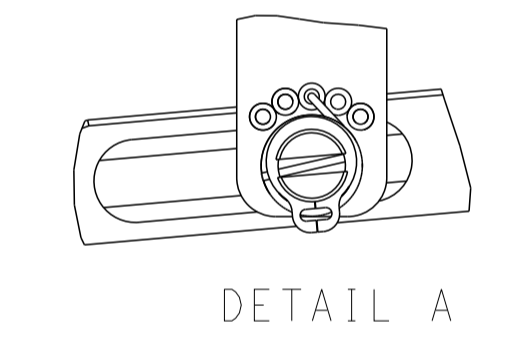


RAM AND HOLDDOWN SET-UP

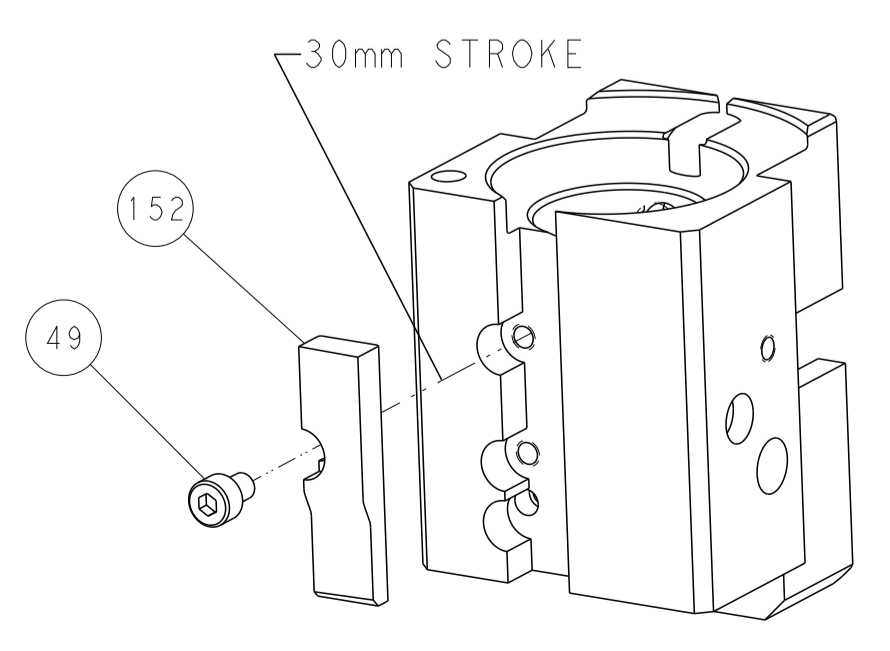
FEED TYPE



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN X.ZHAO 10MAR2016 CHK L.ZHANG 10MAR2016 APVD L.ZHANG 10MAR2016	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 - SIZE CAGE CODE DRAWING NO. A1 00779 C=2150646 WEIGHT - Customer Accessible Production Drawing	RESTRICTED TO - SCALE 1:1 SHEET 4 OF 4 REV C