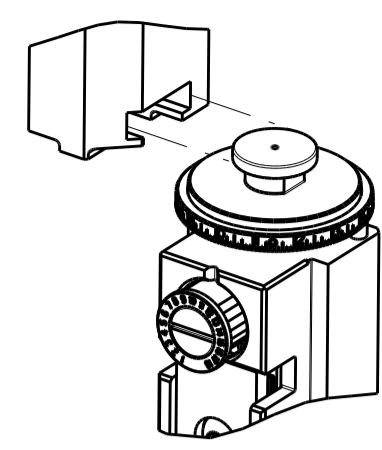


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150578-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150578-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150578-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150578-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150578-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.82 mm [.072]	F
INSUL	2.90 mm [.114]	F

APPL INSTRUCTIONS  
408-35043

TERMINAL DATA:	LEAR TERMINAL	GROTE & HARTMAN CRIMP SPECIFICATION	
TERMINAL NAME:	TERMINAL		
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.60-4.40 mm [.142-.173 IN]	1.60-2.10 mm [.063-.083 IN]		
TERMINAL APPLICATION SPECIFICATION	25365 Rev 3/1/95		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572989-1	25365.213.211	1572989-3	25365.213.011
1572989-2	25365.123.204	1572989-4	25365.213.004

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY 1mm <sup>2</sup>	1.20+/-0.05 [.047+/-0.002]	5.6
FLRY 0.75mm <sup>2</sup>	1.10+/-0.05 [.043+/-0.002]	6.7
FLRY 0.5mm <sup>2</sup>	1.05+/-0.05 [.041+/-0.002]	7.2

- 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 ITEMS 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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.

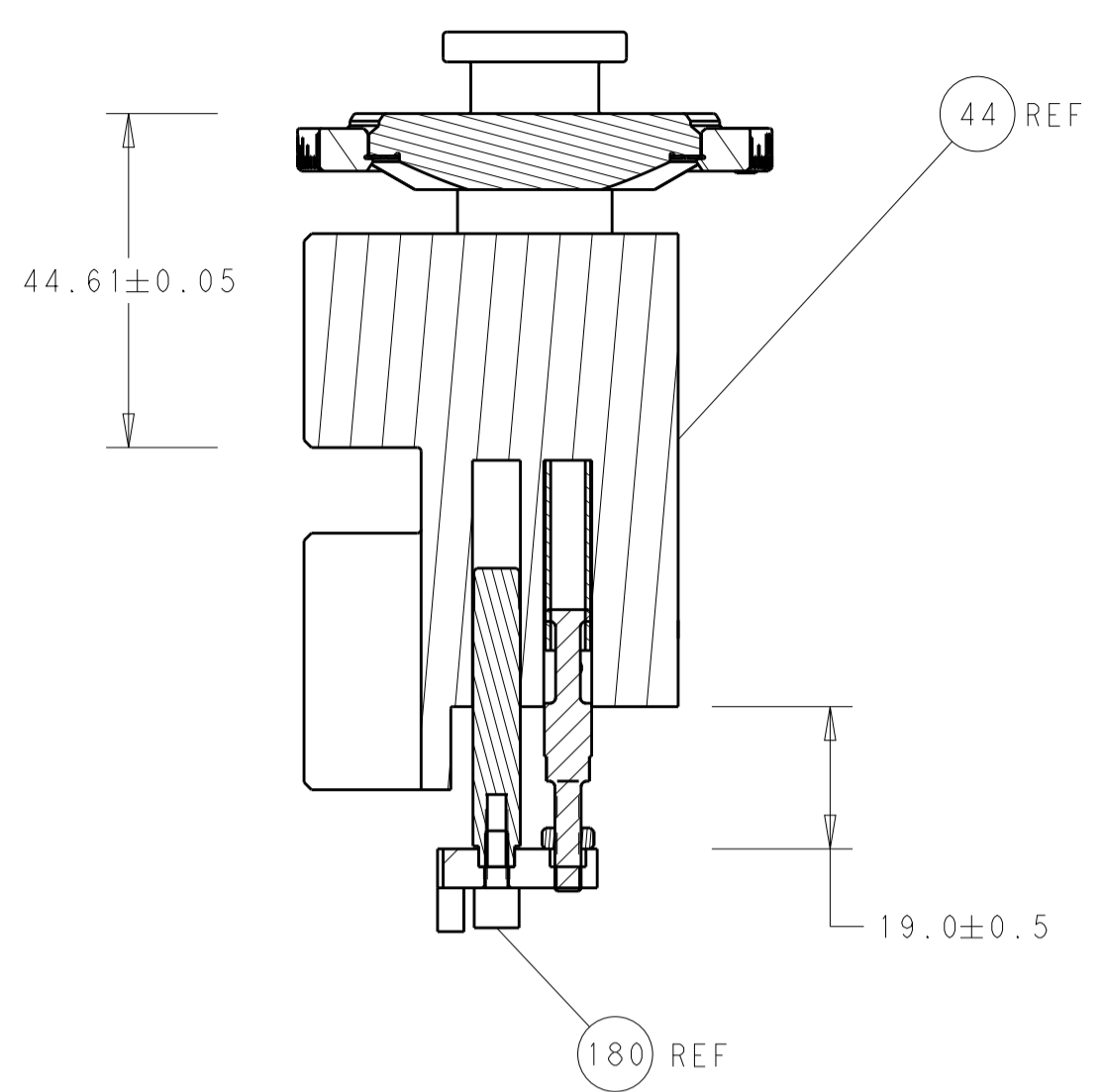
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	2		PRE-RELEASE	13JUL2015	BH	BH
		A		RELEASED	03AUG2015	BH	BH
		B		ECR-20-003277	05MAR2020	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	
-	1	1	1	1	1752354-6	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	
-	1	1	1	1	455888-4	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	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2168083-9	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	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1803257-1	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	3-240641-0	SPACER	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	4-1633961-9	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	2-1633305-4	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

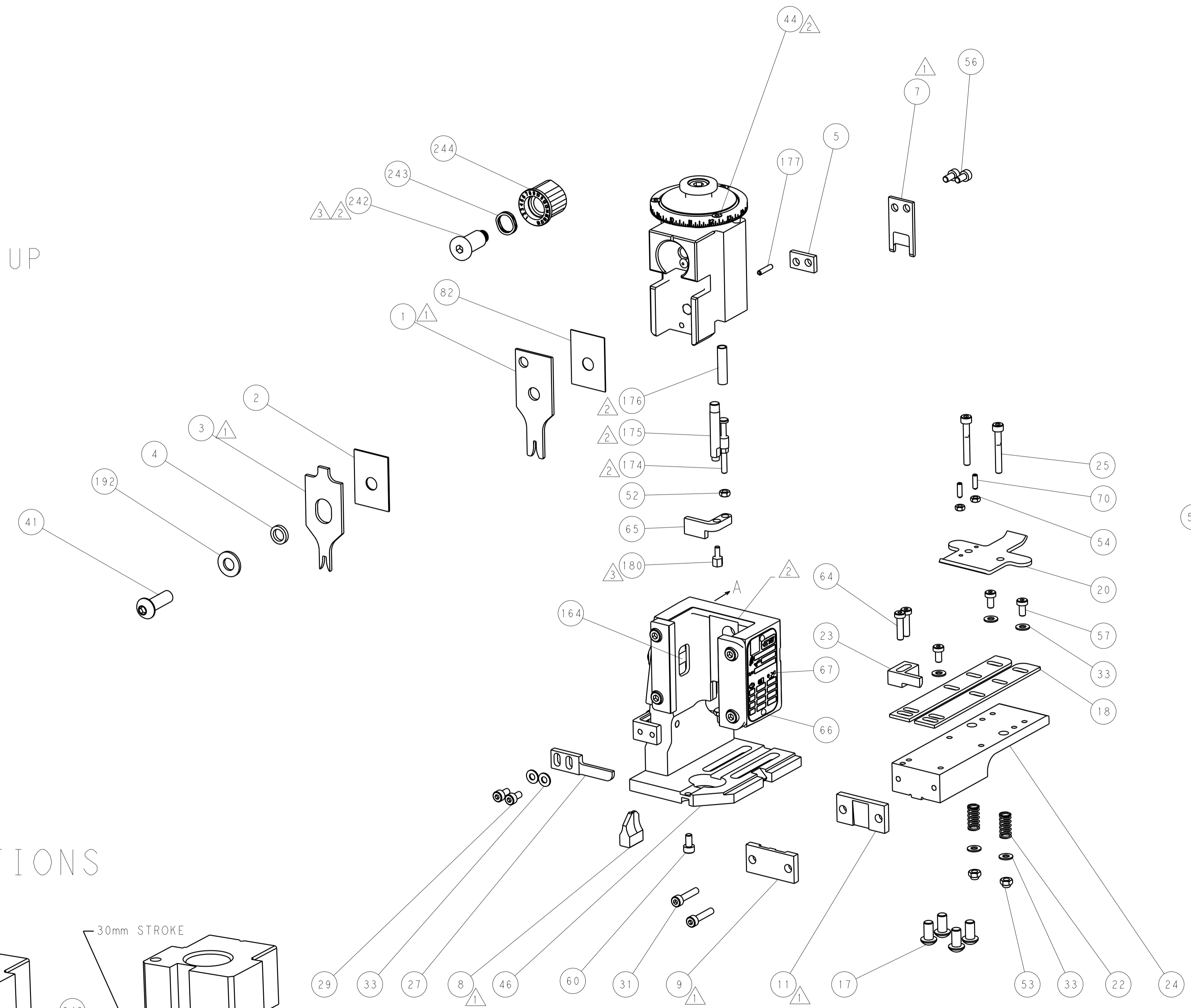
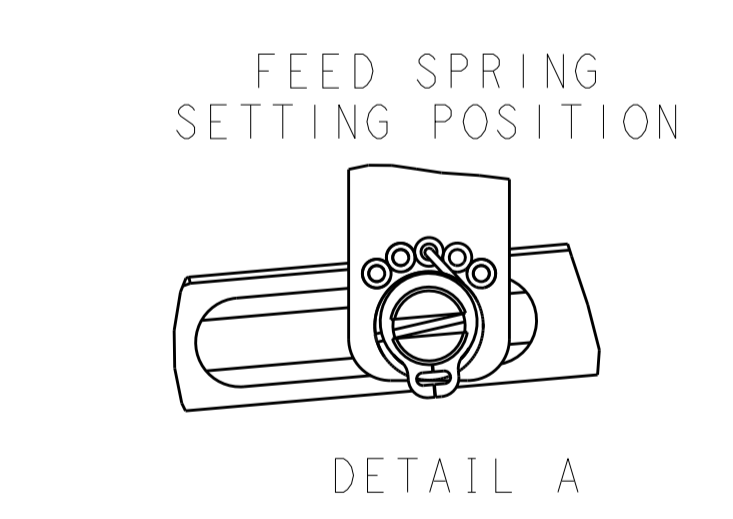
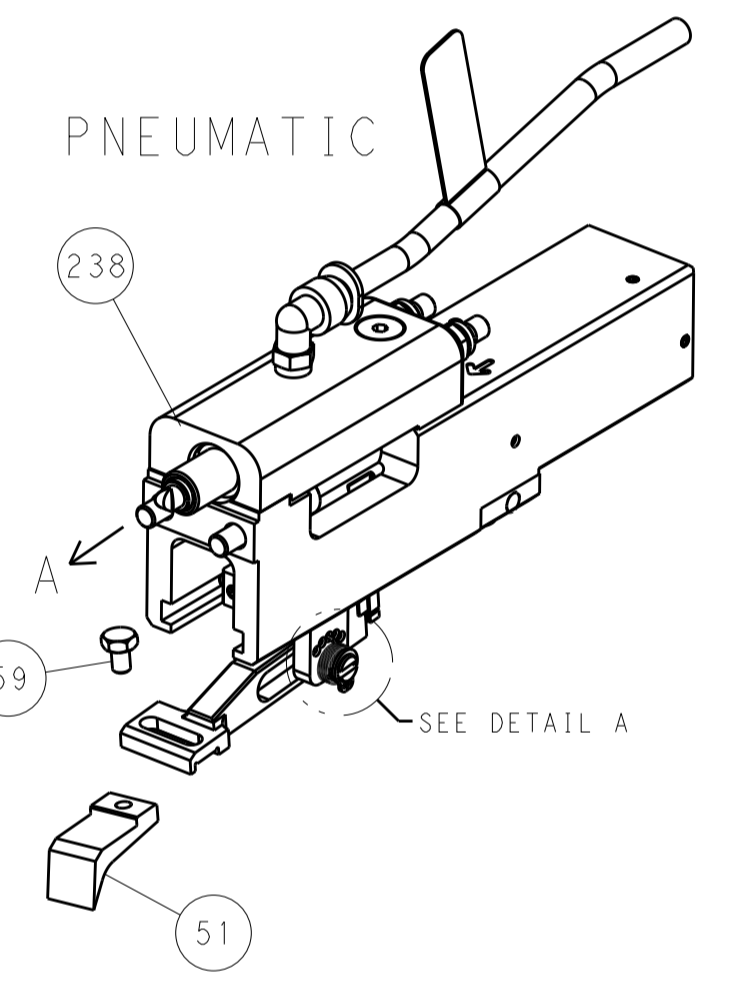
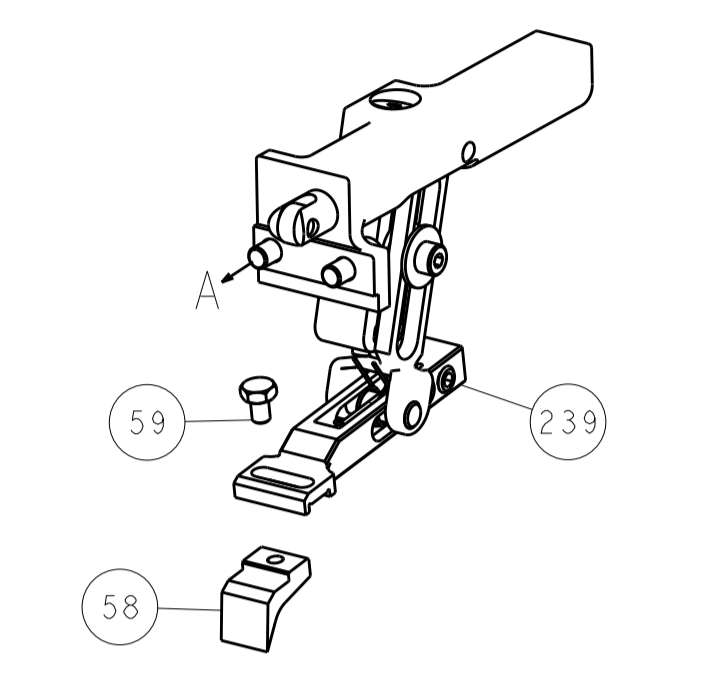
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	07JUL2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	07JUL2015	
	3 PLC ±	4 PLC ±	ANGLES ±	APPV	07JUL2015	NAME
	FINISH					Product Spec
MATERIAL						APPLICATION SPEC
						SIZE
						CAGE CODE
						DRAWING NO
						RESTRICTED TO
						WEIGHT
						A1 00779 C=2150578
						CUSTOMER DRAWING
						SCALE
						SHEET
						OF
						REV
						B

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

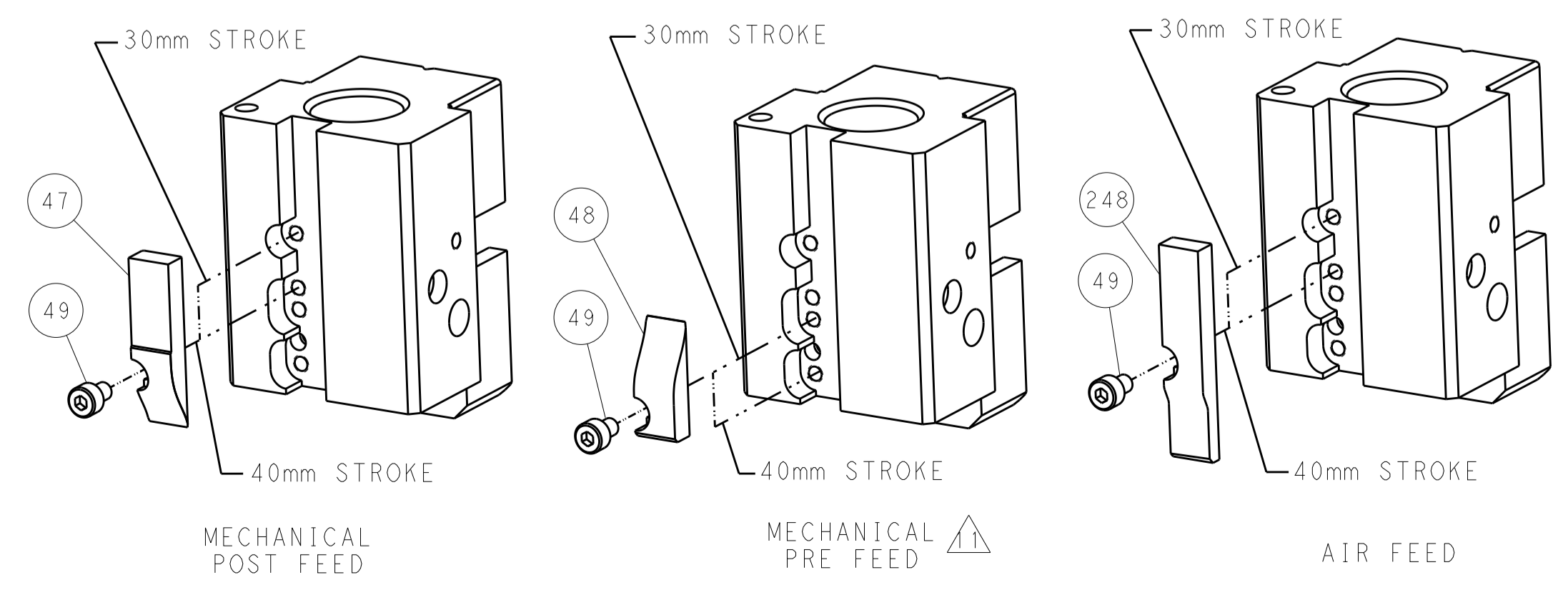


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

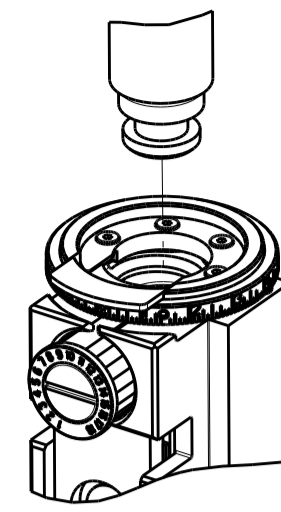


ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 07JUL2015		TE Connectivity	
mm		0 PLC ±		CHK: T_ELBIN 07JUL2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: T_ELBIN 07JUL2015		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150578	
ANGLES		FINISH		CUSTOMER DRAWING		SCALE: 1:1 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150578-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150578-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150578-7	A	CRIMP TOOLING KIT	-

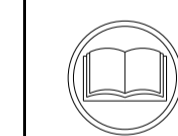
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.82 mm [.072]	F
INSUL	2.90 mm [.114]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA:	LEAR TERMINAL	GROTE & HARTMAN CRIMP SPECIFICATION	
TERMINAL NAME:	TERMINAL		
WIRE STRIP LENGTH	3.60-4.40 mm [.142-.173 IN]	INSULATION DIAMETER RANGE 1.60-2.10 mm [.063-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	25365 Rev 3/1/95	-	
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572989-1	25365.213.211	1572989-3	25365.213.011
1572989-2	25365.123.204	1572989-4	25365.213.004

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY 1mm <sup>2</sup>	1.20 +/- 0.05 [.047 +/- .002]	5.6
FLRY 0.75mm <sup>2</sup>	1.10 +/- 0.05 [.043 +/- .002]	6.7
FLRY 0.5mm <sup>2</sup>	1.05 +/- 0.05 [.041 +/- .002]	7.2



- 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 ITEMS 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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.

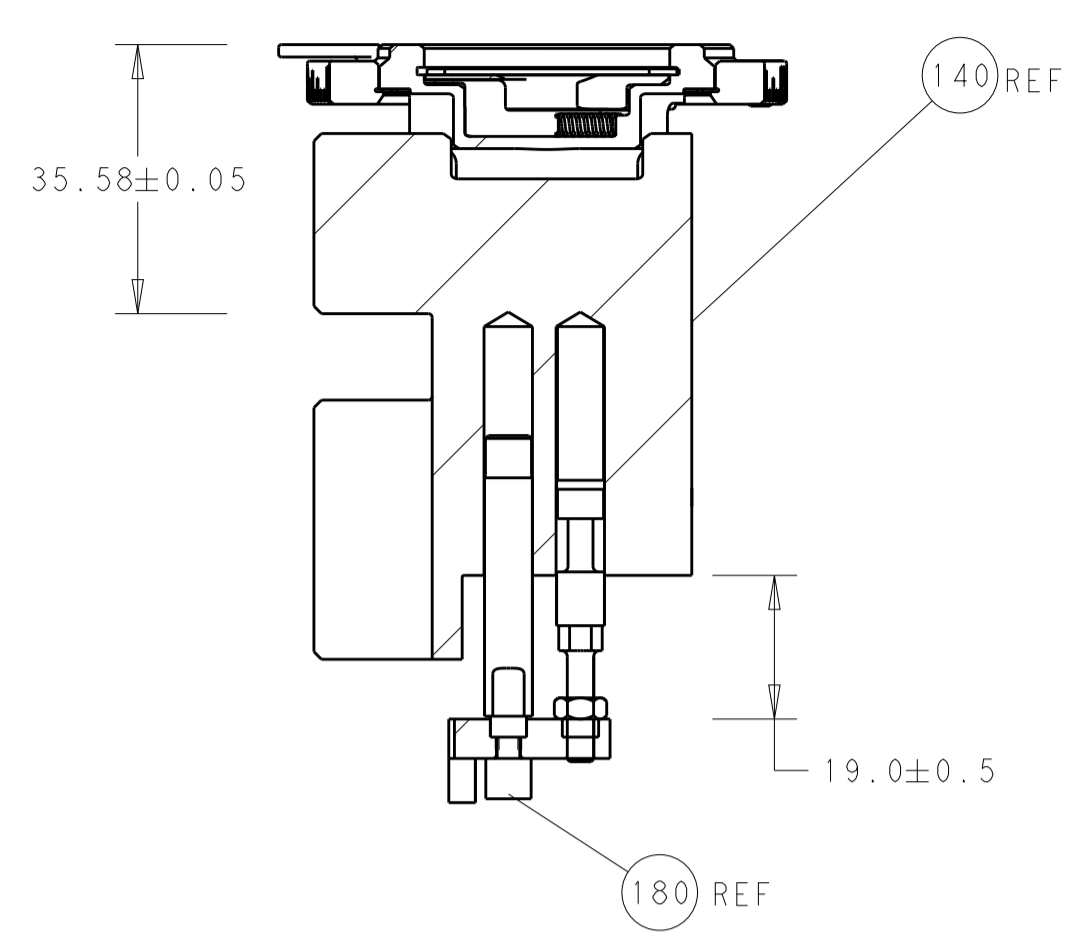
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-8	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	1752354-6	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	-	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	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	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2168083-9	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	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	690482-5	PLATE, FRONT SHEAR	9	
1	1	1	1803257-1	ANVIL, COMBINATION, END FEED	8	
1	-	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	3-240641-0	SPACER	5	
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
1	1	1	4-1633961-9	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-8	SPACER, CRIMPER	2	
1	1	1	2-1633305-4	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

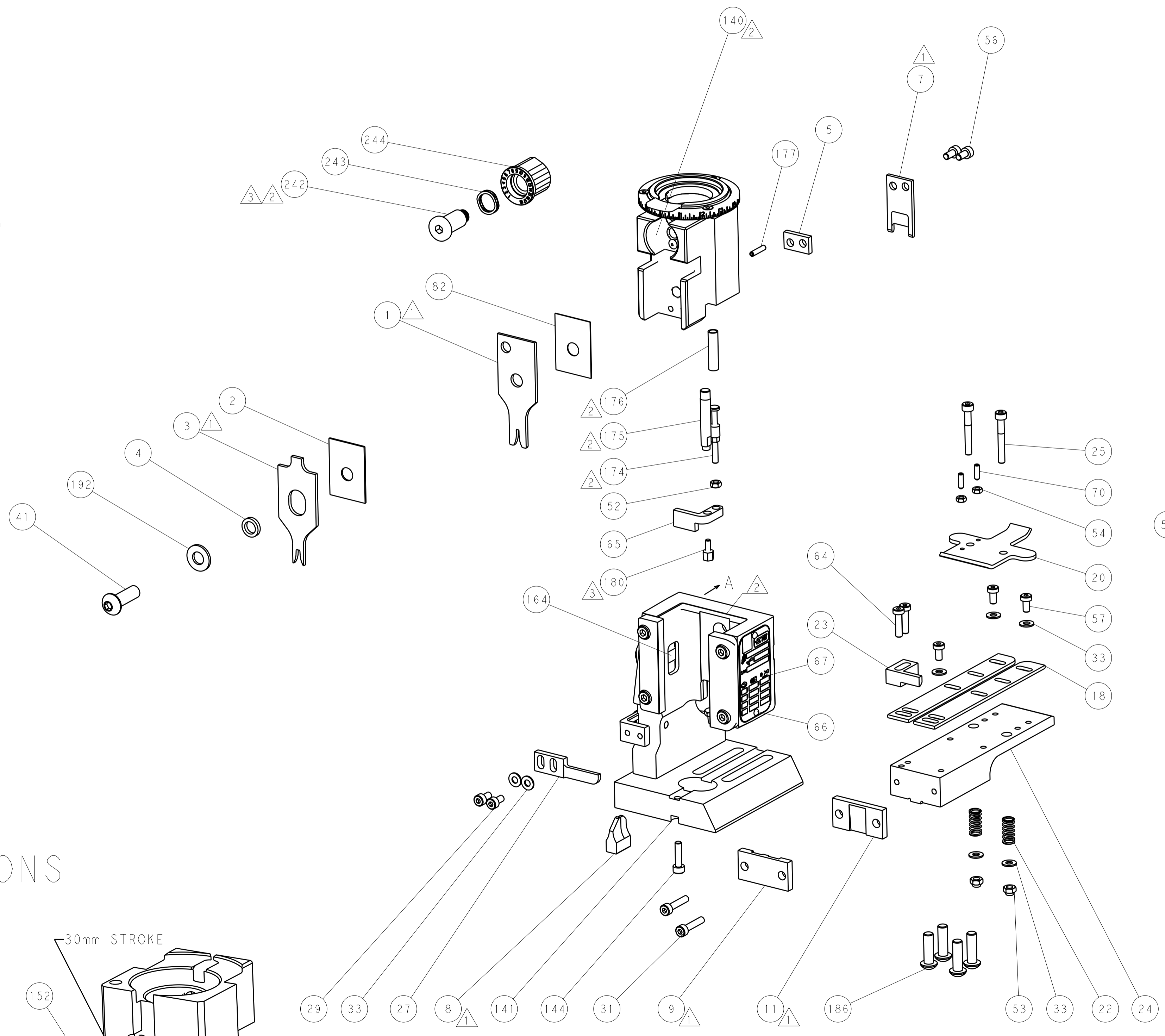
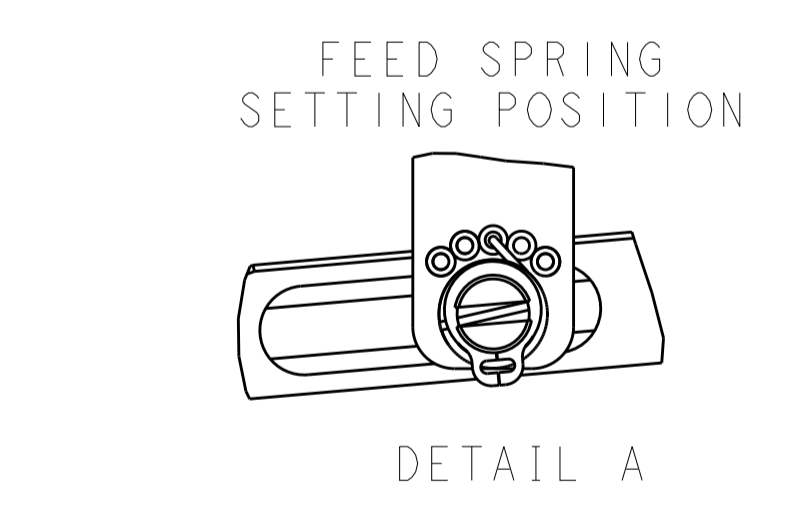
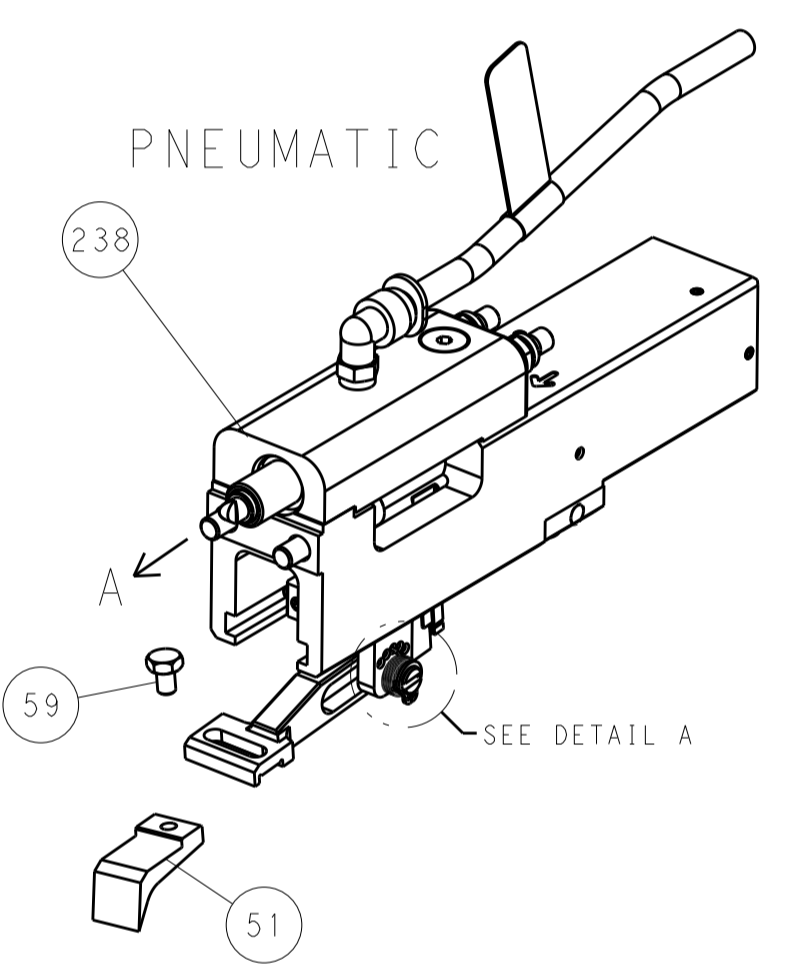
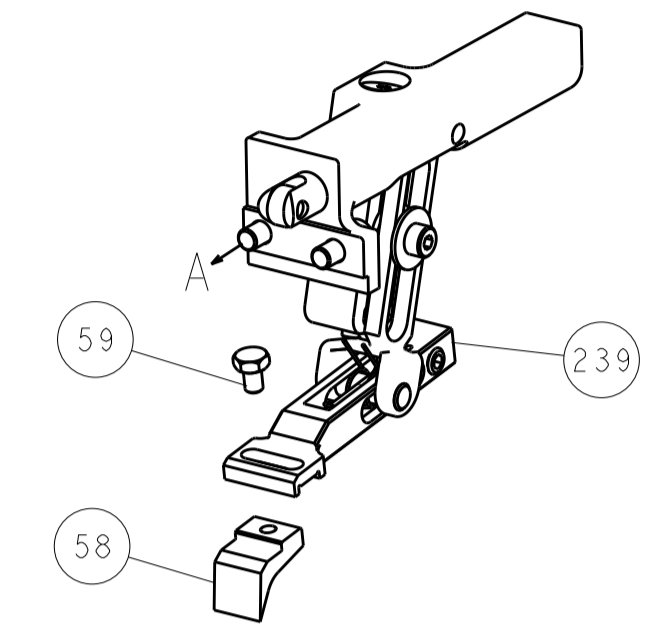
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB HIGMAN 07JUL2015		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK T. ELBIN 07JUL2015		NAME Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		APVD T. ELBIN 07JUL2015		SIZE CAGE CODE DRAWING NO	
4 PLC ±		ANGLES ±		PRODUCT SPEC		RESTRICTED TO	
FINISH		FINISH		APPLICATION SPEC		SCALE 1:1 SHEET 3 OF 4 REV B	
MATERIAL		MATERIAL		WEIGHT		CUSTOMER DRAWING	
-		-		A1 00779 C=2150578		SCALE 1:1 SHEET 3 OF 4 REV B	

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

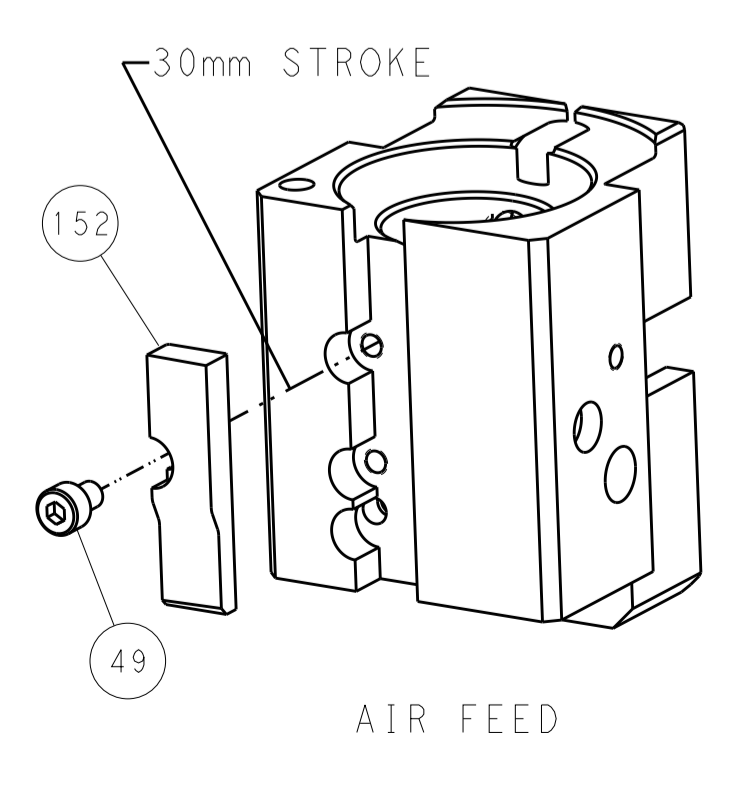
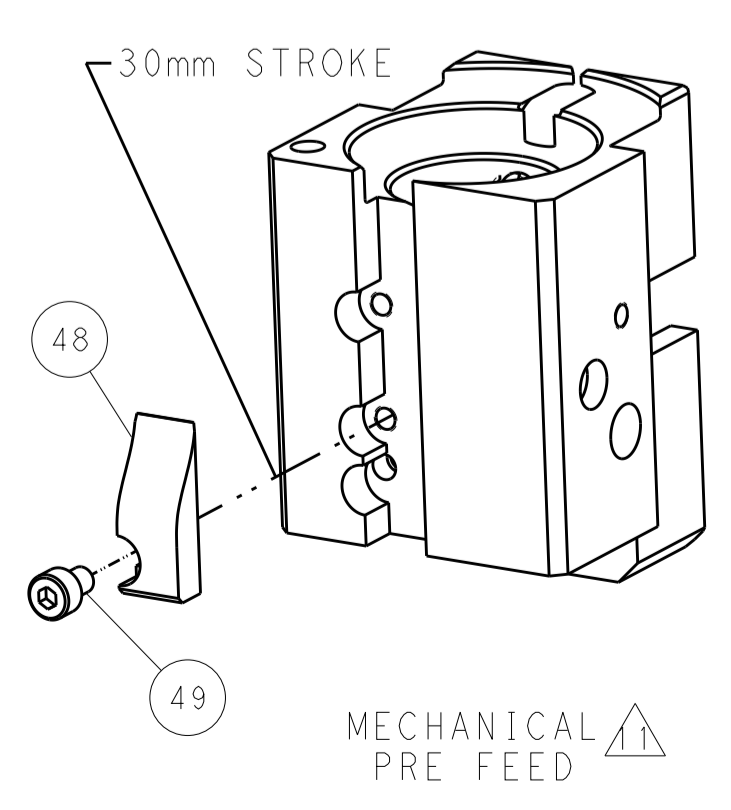
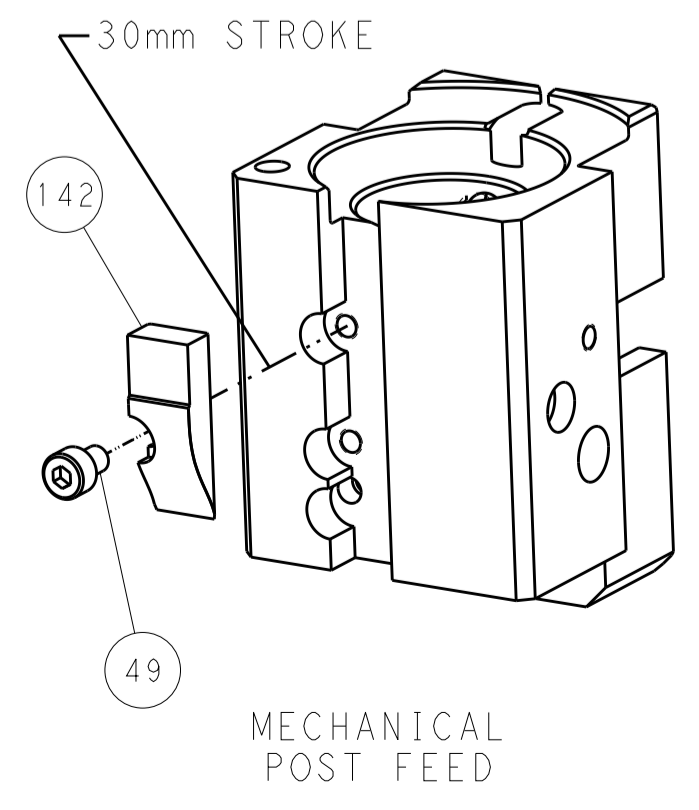


RAM AND HOLDDOWN SET-UP

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: BOB HIGMAN 07JUL2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: T. ELBIN 07JUL2015		NAME: Ocean End Feed Applicator	
CUSTOMER DRAWING		SCALE: 1:1		SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: C-2150578		RESTRICTED TO:	
				SHEET 4 OF 4		REV B	