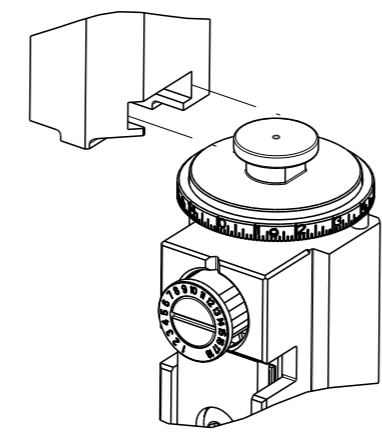


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150581-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150581-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150581-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150581-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150581-7	A	CRIMP TOOLING KIT	-

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: GROTE & HARTMAN/LEAR TERMINAL GROTE & HARTMAN CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, 2.8 RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.60-4.40 mm [.142-.173 IN]	∅ 2.00-2.70 mm [.079-.106 IN]		
TERMINAL APPLICATION SPECIFICATION	25415 Rev 11/12/93		
TERMINALS APPLIED			
TE TERMINAL	GROTE & HARTMAN/LEAR TERMINAL	TE TERMINAL	GROTE & HARTMAN/LEAR TERMINAL
1949059-1	25415.123.211	1949059-5	25415.213.004
1949059-4	25415.213.011	1949059-6	25415.417.031

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X FLRY 0.5mm <sup>2</sup>	1.20 +/- 0.05 [.047 +/- .002]	5.9
FLRY 1mm <sup>2</sup>	1.20 +/- 0.05 [.047 +/- .002]	5.9
FLRY 0.75mm <sup>2</sup>	1.10 +/- 0.05 [.043 +/- .002]	6.9
FLRY 0.5mm <sup>2</sup>	1.05 +/- 0.05 [.041 +/- .002]	7.4

- 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.
- 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.

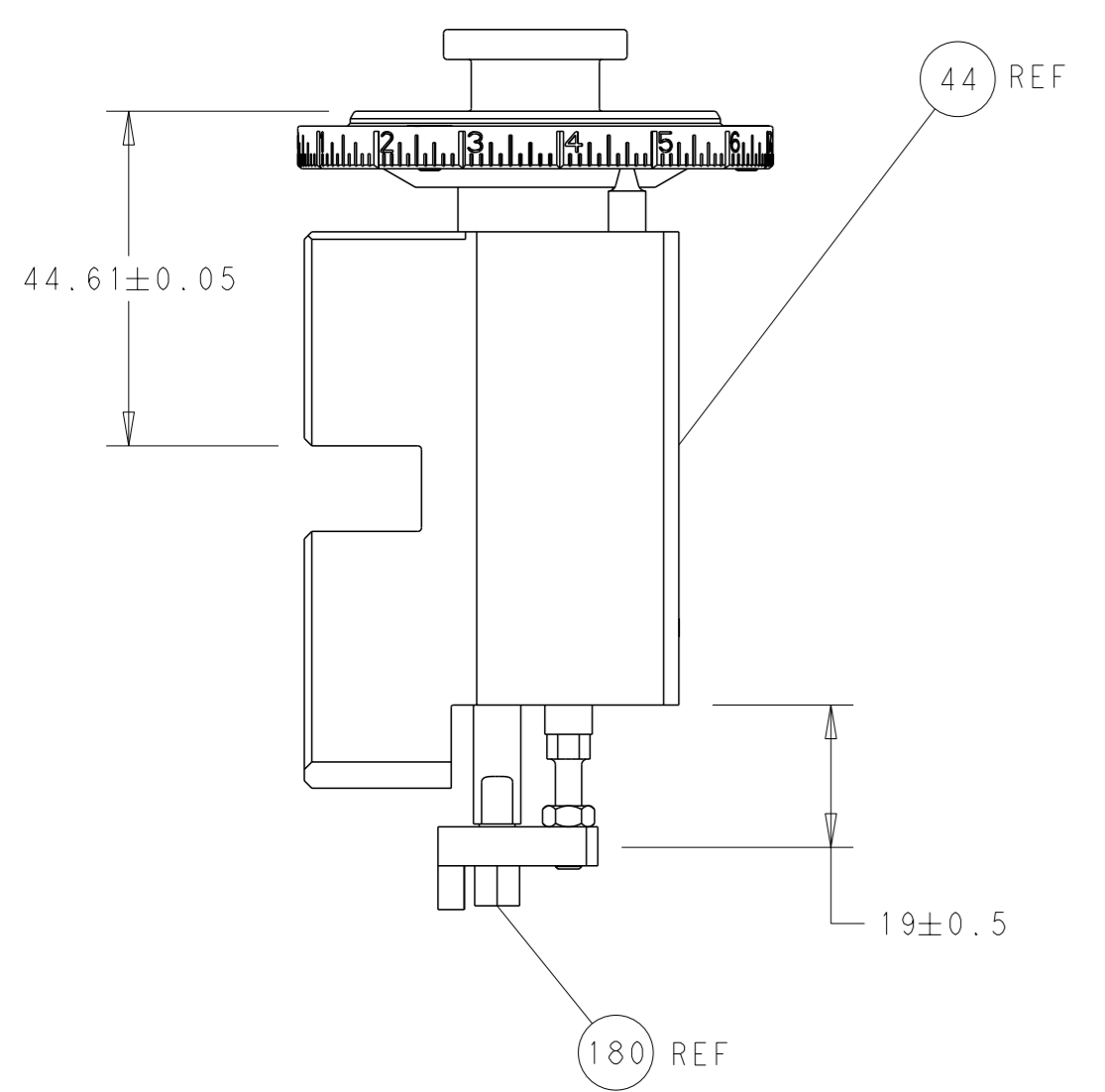
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	21AUG2015	MR	GB
		B		ECR-20-012707	10SEP2020	FZ	TE
		C		ECR-20-015073	22OCT2020	JAH	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	-	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	6-9931111-6	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	-	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	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	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	240639-3	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	1803257-2	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	455888-5	SPACER, CRIMPER	2	
-	1	2	2	1	2-1803188-7	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

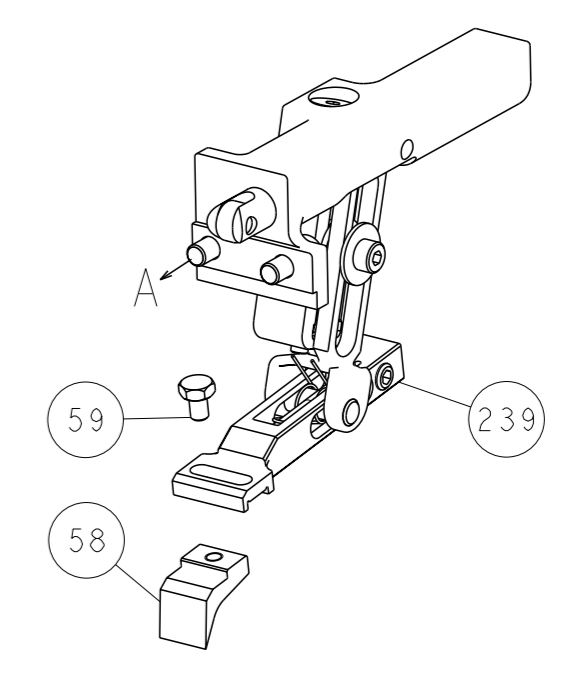
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN BOB HIGMAN 07JUL2015 CHK T. ELBIN 07JUL2015 APVD T. ELBIN 07JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME <b>STE</b> TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150581 SCALE 1:1 SHEET 1 OF 4 REV C	
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LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

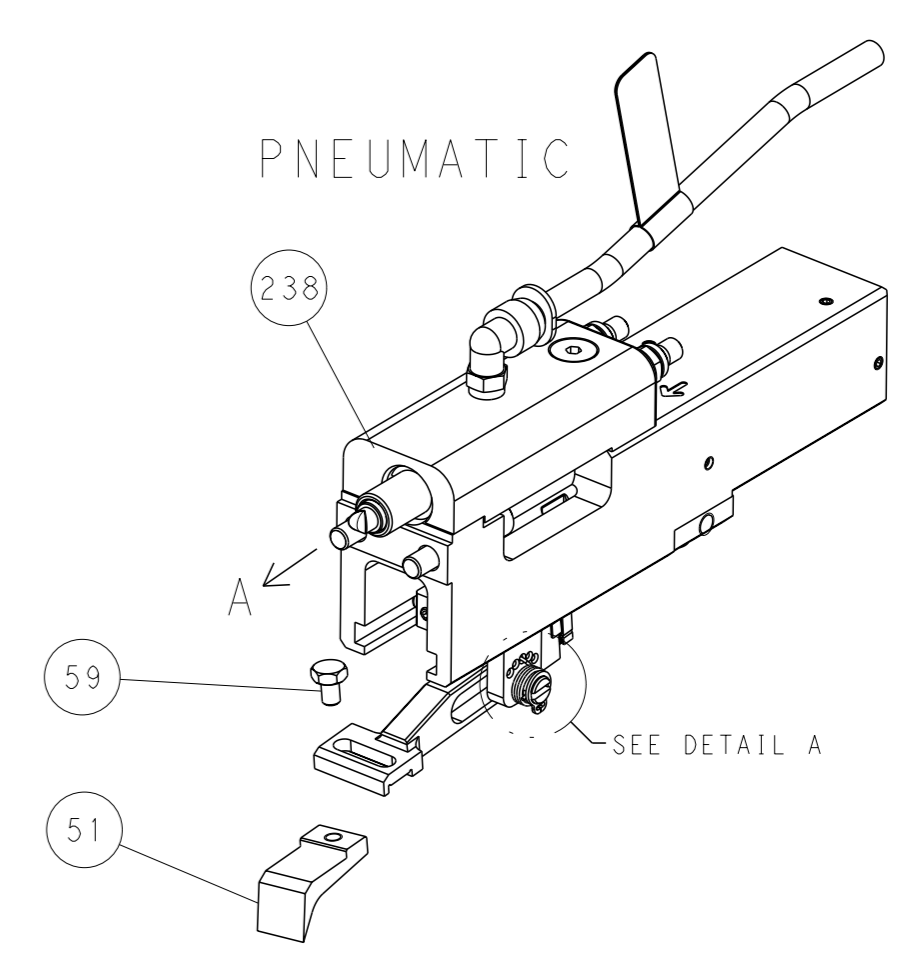


RAM AND HOLDDOWN SET-UP

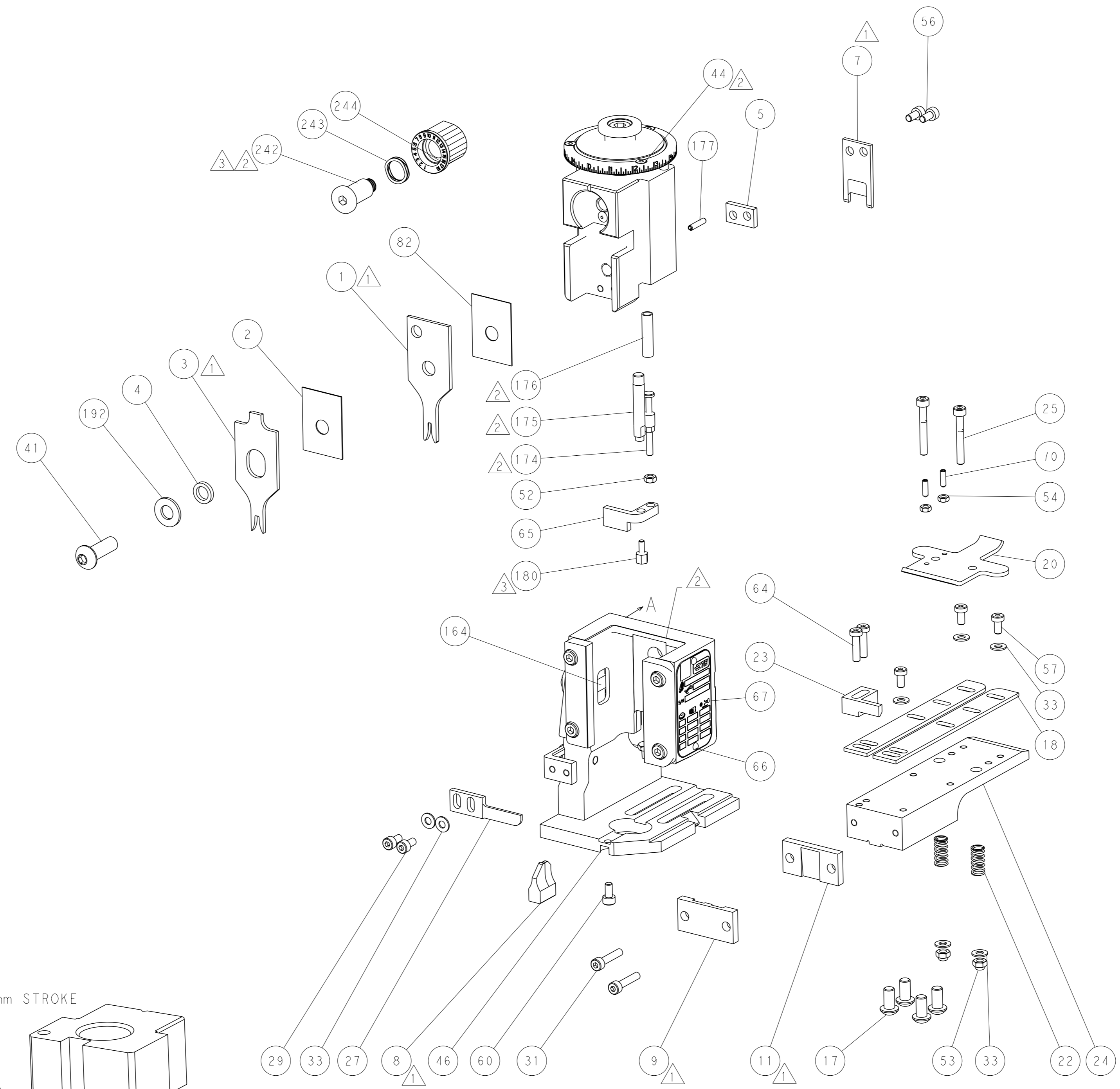
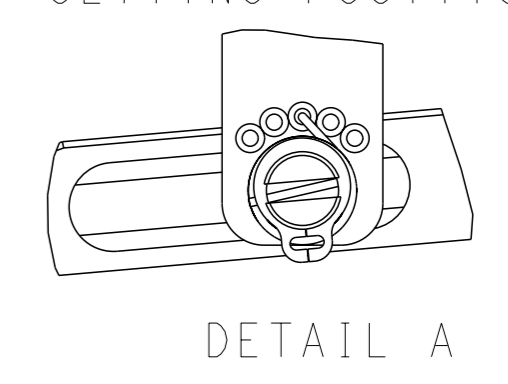
FEED TYPE  
MECHANICAL



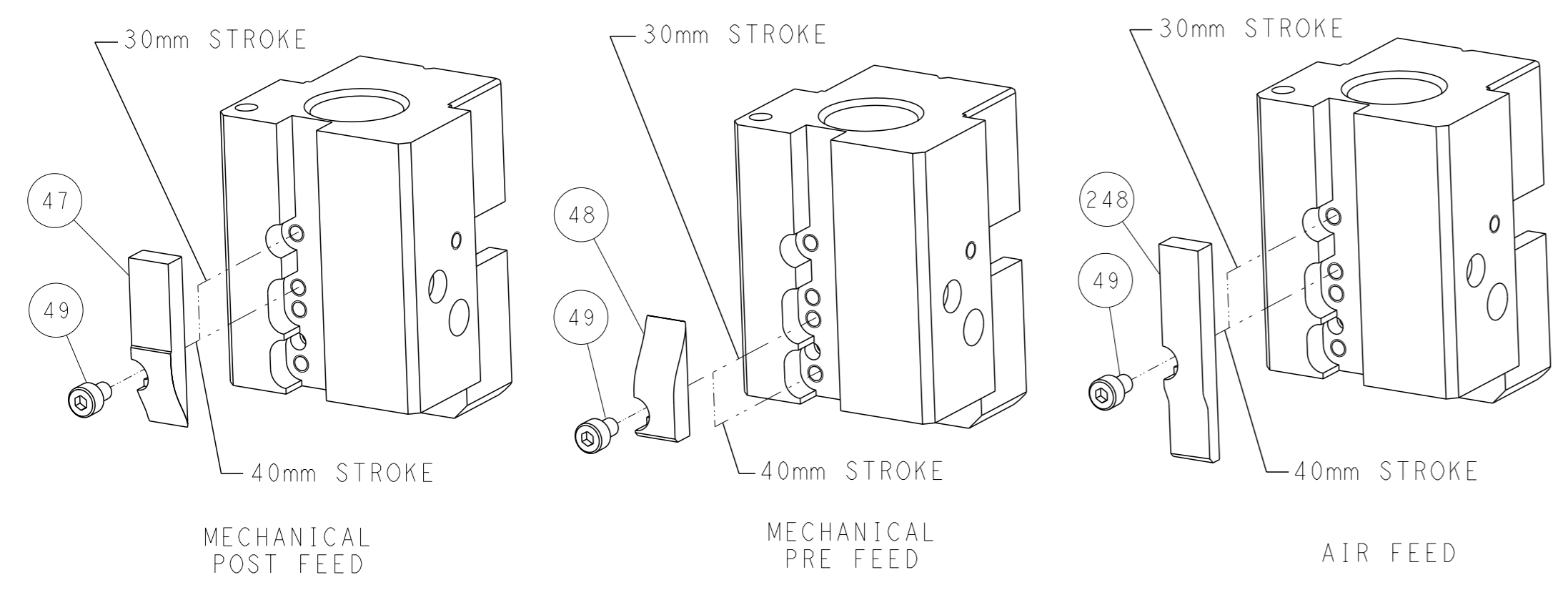
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

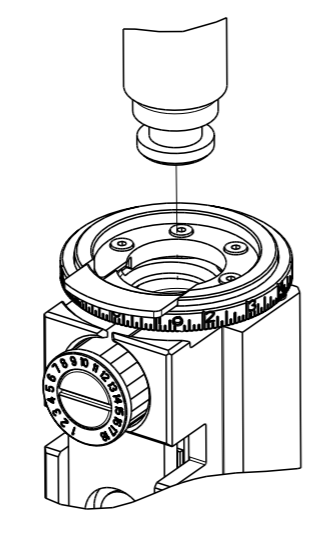


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 07JUL2015 CHK: T. ELBIN 07JUL2015 APVD: T. ELBIN 07JUL2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150581	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150581-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150581-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150581-7	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: GROTE & HARTMAN/LEAR TERMINAL GROTE & HARTMAN CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, 2.8 RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.60-4.40 mm [.142-.173 IN]	2.00-2.70 mm [.079-.106 IN]

TERMINAL APPLICATION SPECIFICATION: 25415 Rev 11/12/93

TERMINALS APPLIED

TE TERMINAL	GROTE & HARTMAN/LEAR TERMINAL	TE TERMINAL	GROTE & HARTMAN/LEAR TERMINAL
1949059-1	25415.123.211	1949059-5	25415.213.004
1949059-4	25415.213.011	1949059-6	25415.417.031

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X FLY 0.5mm <sup>2</sup>	1.20 +/- 0.05 [.047 +/- .002]	5.9
FLRY 1mm <sup>2</sup>	1.20 +/- 0.05 [.047 +/- .002]	5.9
FLRY 0.75mm <sup>2</sup>	1.10 +/- 0.05 [.043 +/- .002]	6.9
FLRY 0.5mm <sup>2</sup>	1.05 +/- 0.05 [.041 +/- .002]	7.4

- 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.
- 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.

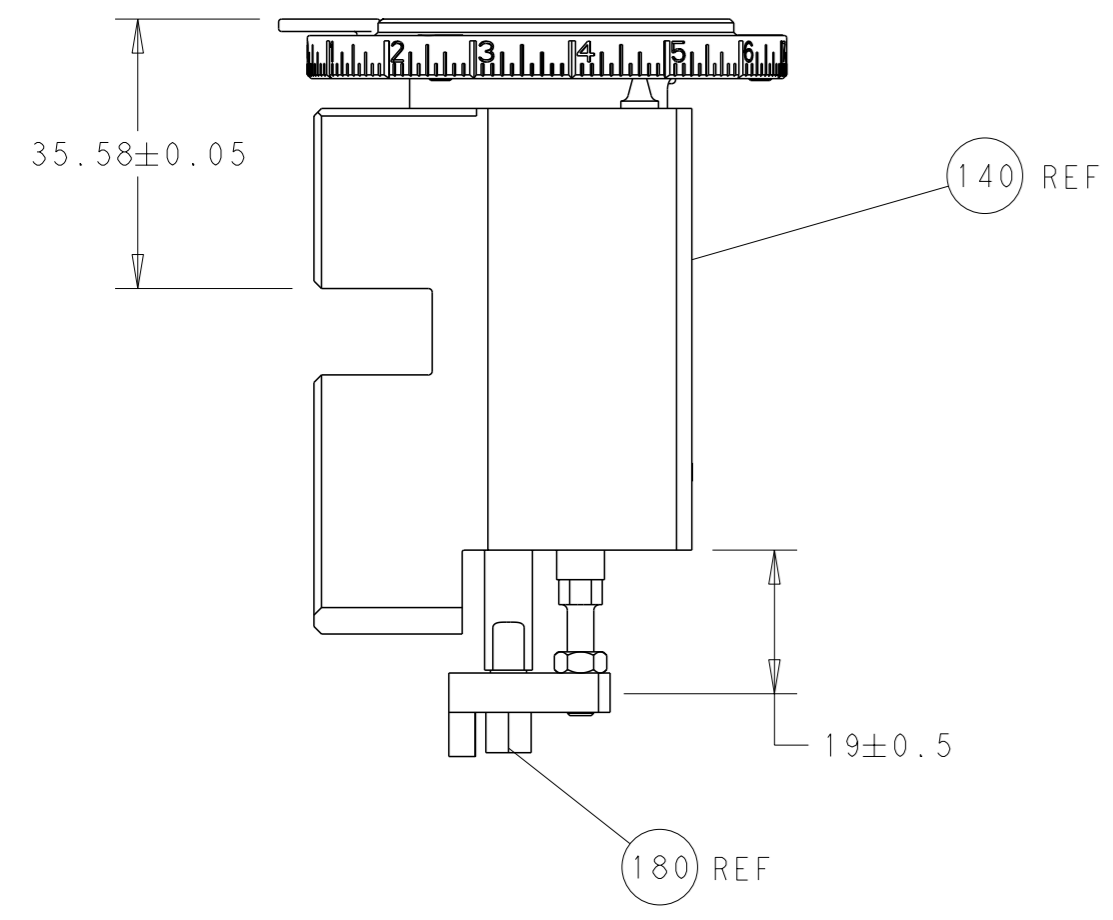
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	OWN	APPV
-	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
-	REF	REF	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	240639-3	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	1803257-2	ANVIL, COMBINATION, END FEED	8
1	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	455888-5	SPACER, CRIMPER	2
1	1	1	2-1803188-7	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

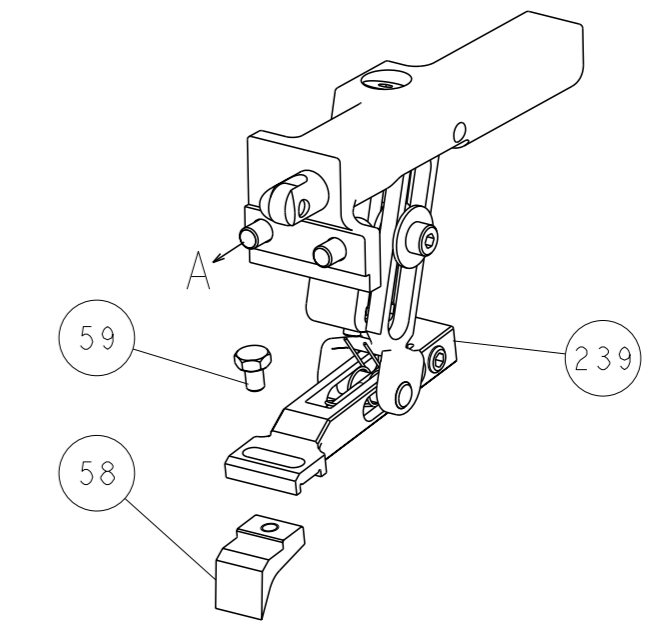
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: BOB HIGMAN 07JUL2015 CHK: T. ELBIN 07JUL2015 APPV: T. ELBIN 07JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150581 SHEET 3 OF 4	
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LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

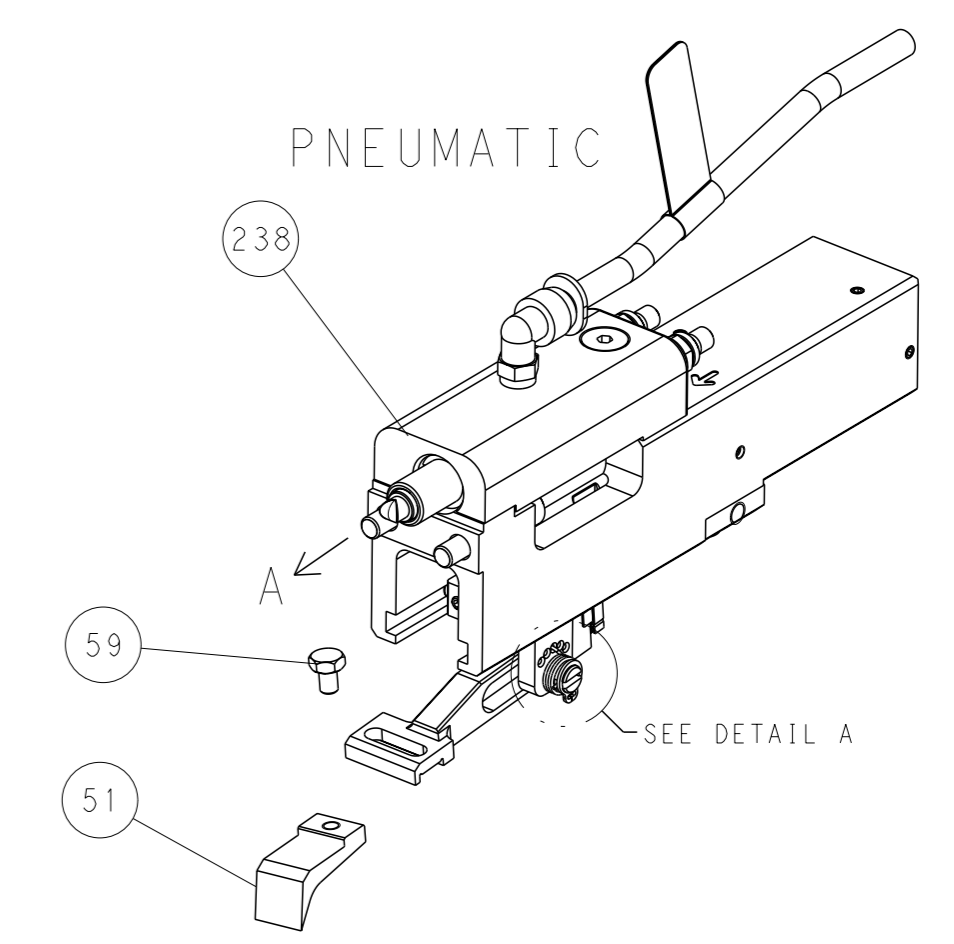


RAM AND HOLDDOWN SET-UP

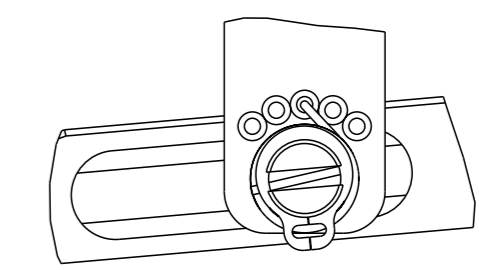
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MECHANICAL



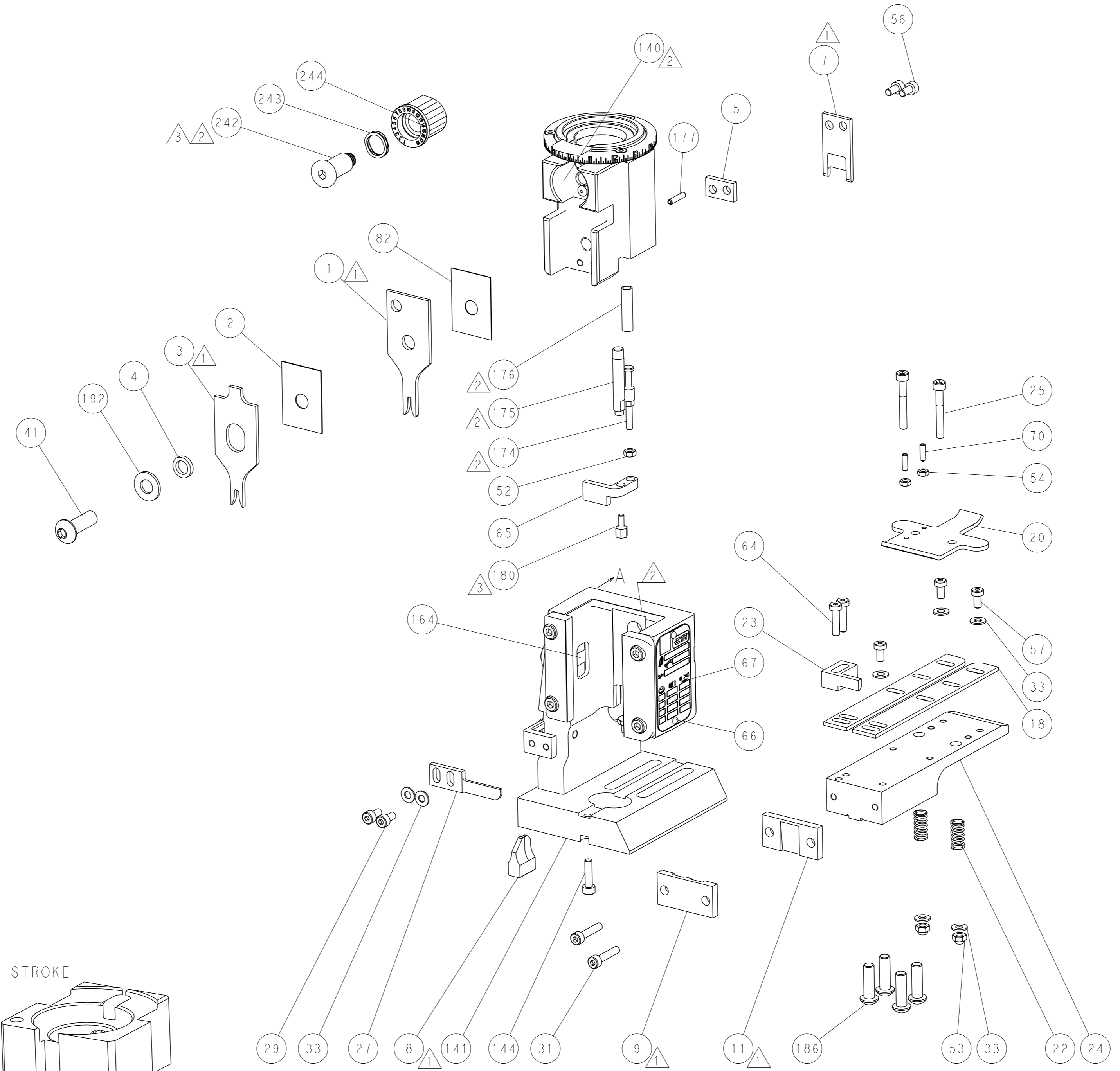
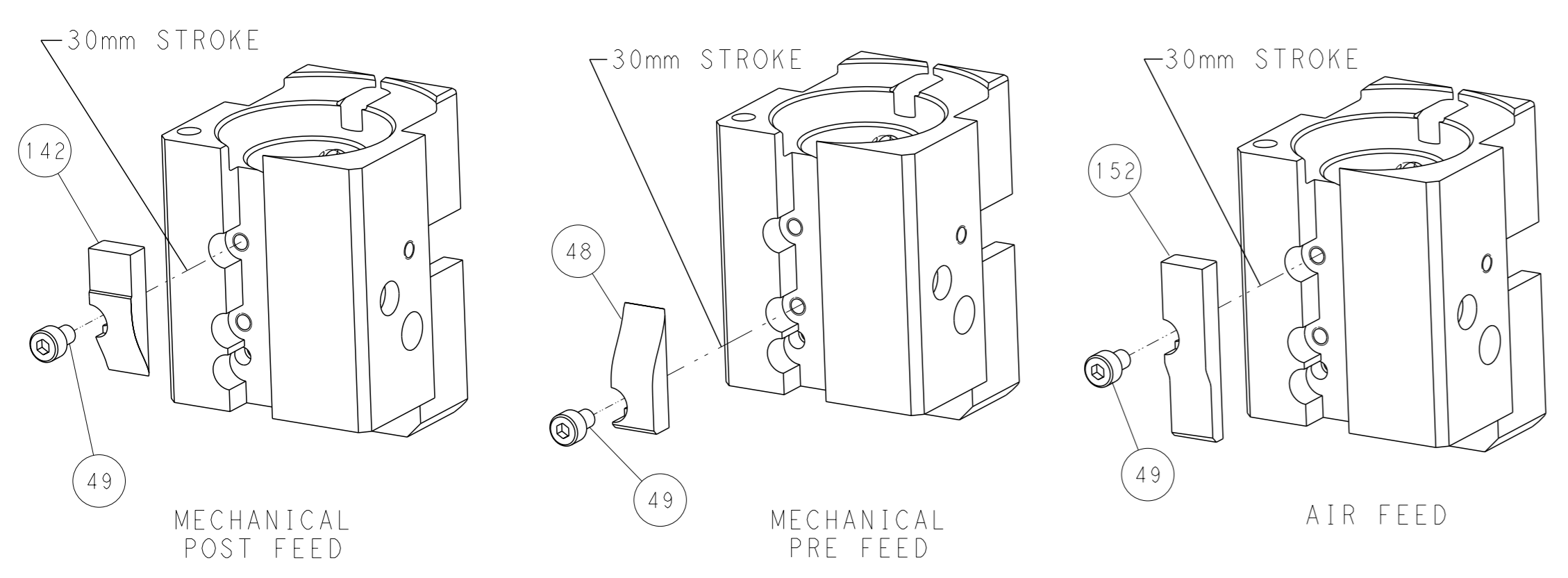
PNEUMATIC



FEED SPRING  
SETTING POSITION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		OWN BOB HIGMAN 07JUL2015 CHK T. ELBIN 07JUL2015 APVD T. ELBIN 07JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150581 SCALE 1:1 SHEET 4 OF 4 REV C		RESTRICTED TO	
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