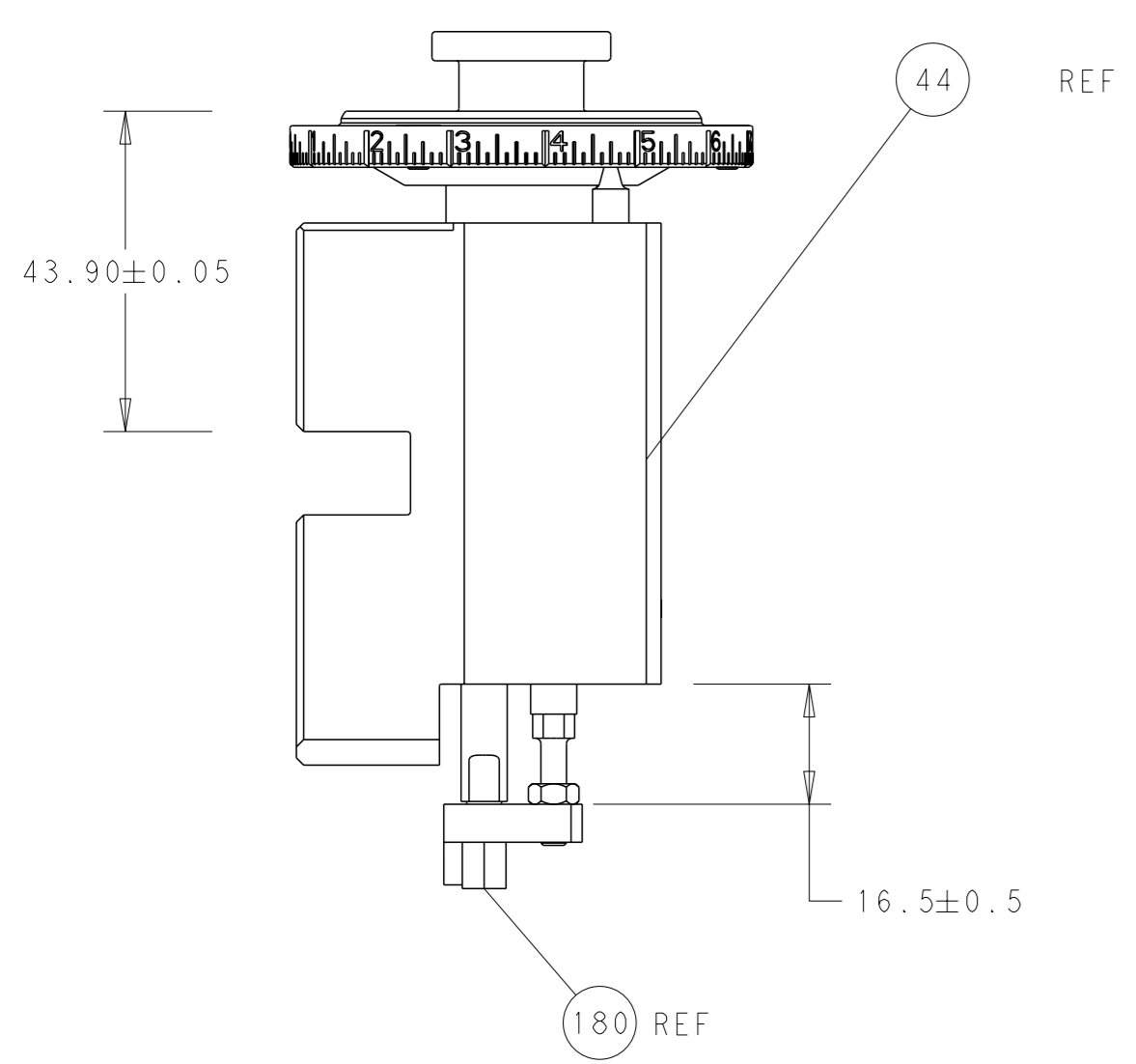
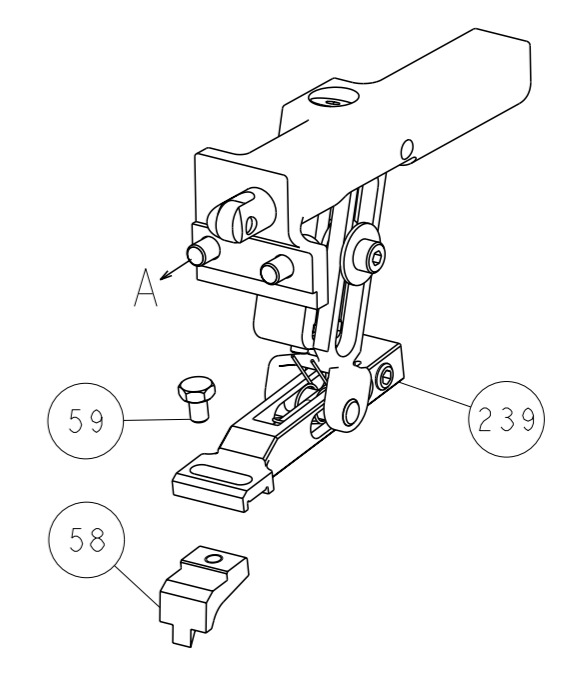


LOC		DIST		REVISIONS			
P	LY#	DESCRIPTION	DATE	OWN	APVD		
A	66	SEE SHEET 1					

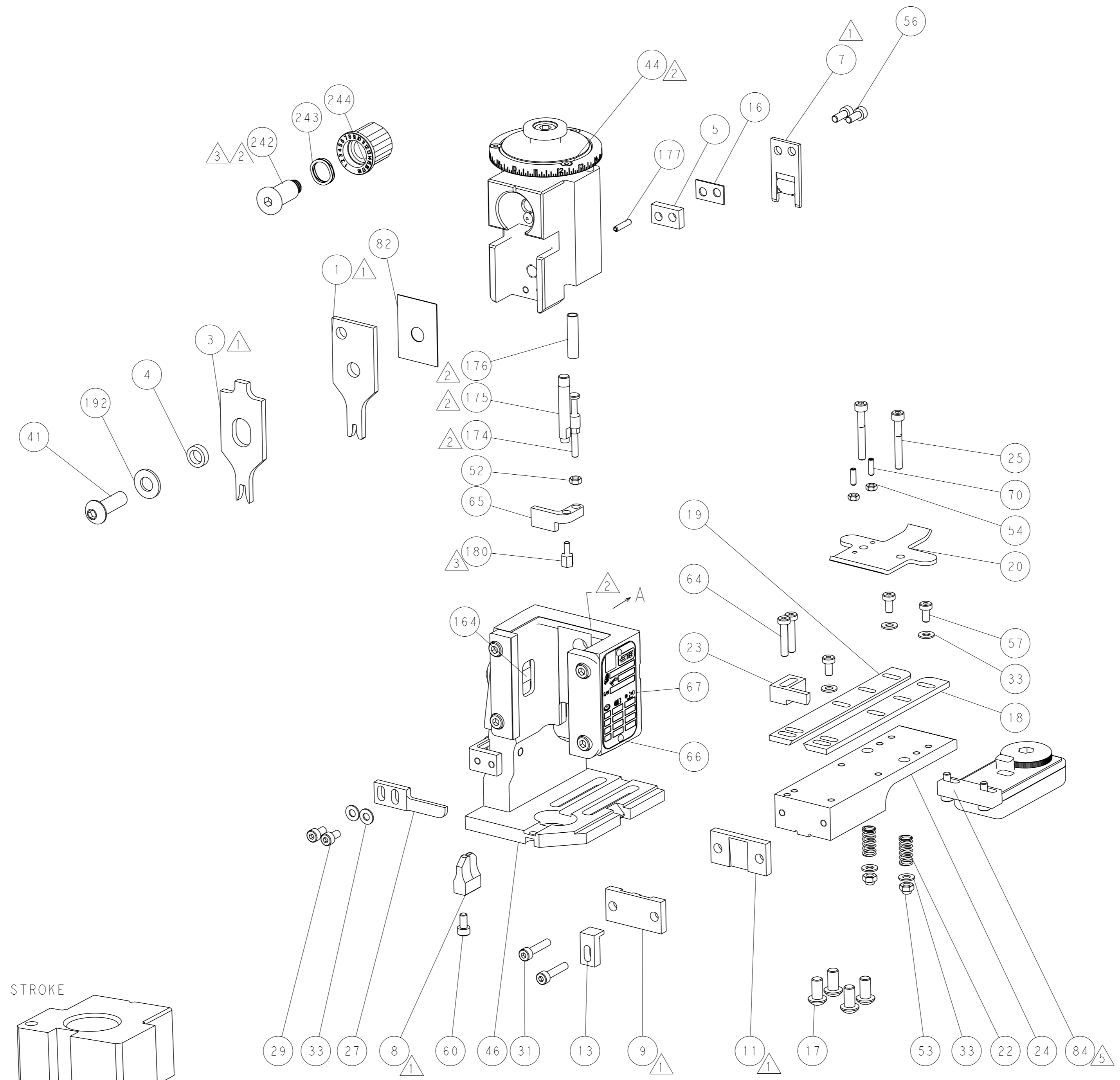
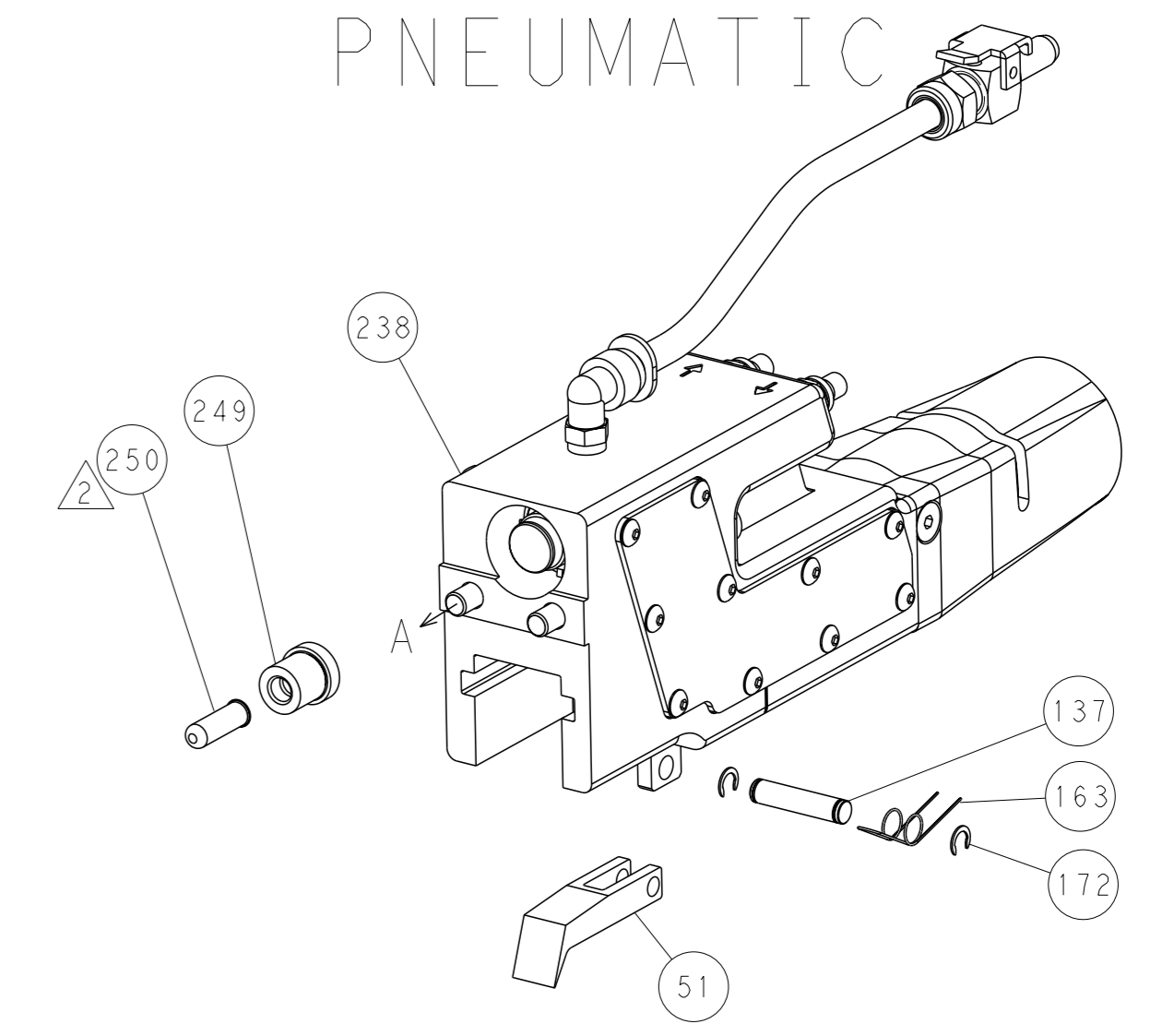


RAM AND HOLDDOWN SET-UP

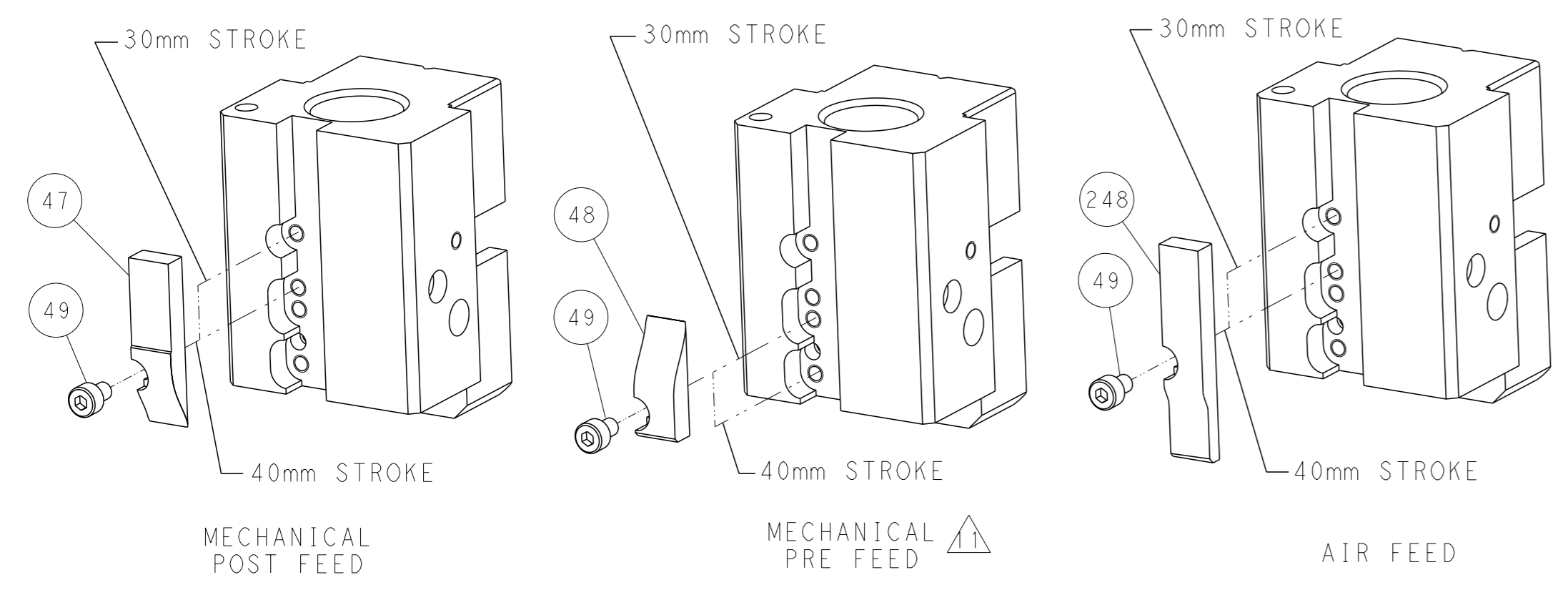
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

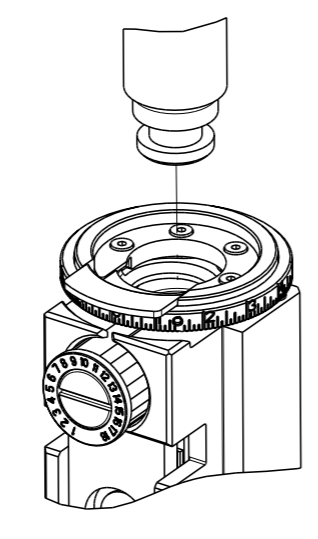


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		OWN M. ZHAO 12APR2017 CHK K. ZHANG 12APR2017 APVD K. ZHANG 12APR2017 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2150801 RESTRICTED TO	
Customer Accessible Production Drawing				SHEET 2 of 4		REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150801-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150801-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150801-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.80 mm [.150]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL UTILUX CRIMP SPECIFICATION

TERMINAL NAME: UTILUX H25905 TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.80-5.20 mm [1.89-.205 IN]	Ø2.20-2.80 mm [1.087-.110 IN]

TERMINAL APPLICATION SPECIFICATION H25905 Rev 2

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-1659252-0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.65+/-0.025 [.065+/- .001]	8.4
0.75mm2	1.55+/-0.025 [.061+/- .001]	9.5
0.50mm2	1.50+/-0.025 [.059+/- .001]	10.1

- 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 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.

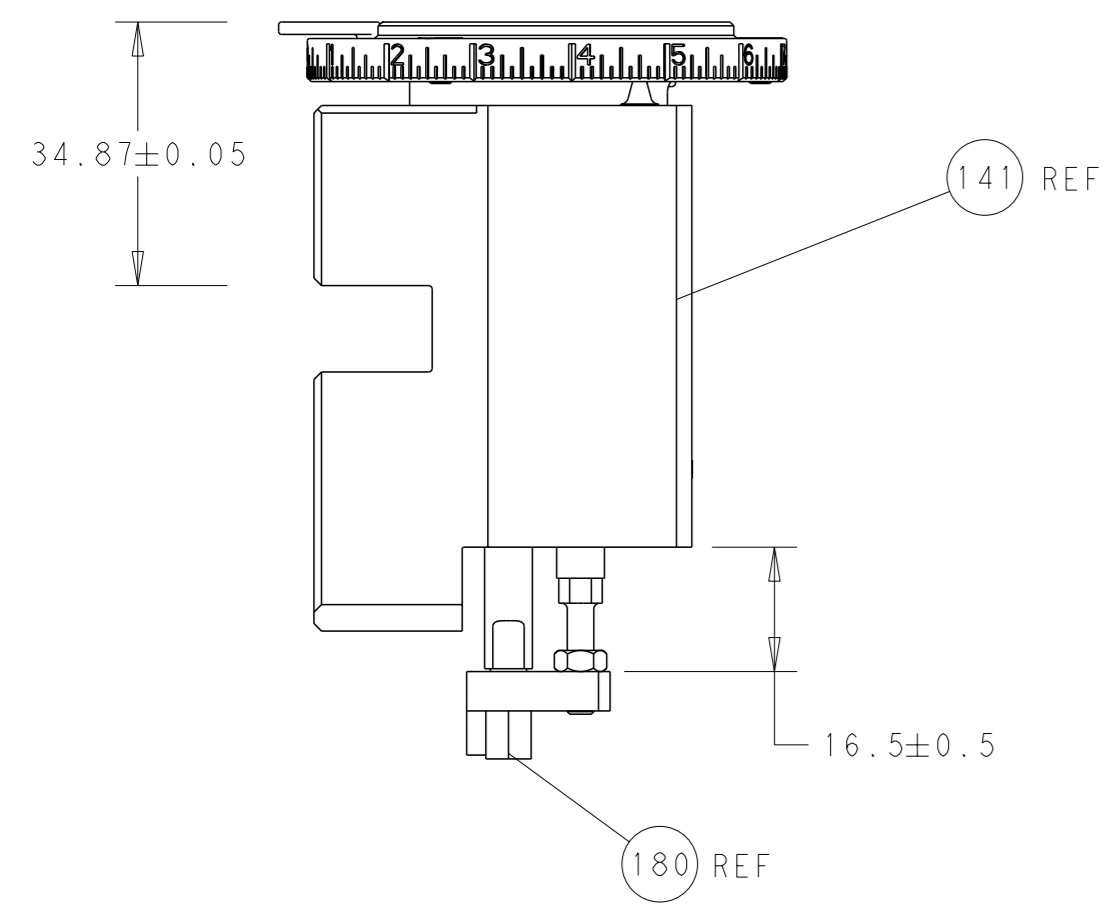
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	QTY	
-	1	1		2119640-1	PUSH ROD, AIR FEED	250
-	1	1		1803259-1	BUSHING, FLANGED	249
-	1	1		2119082-4	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	-		2063440-1	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		1-1752354-0	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
-	2	2		21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF		994970-2	COUNTER, MAGNETIC	164
-	1	1		240638-1	SPRING, FEED FINGER	163
-	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		3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1		2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1		455888-4	SPACER, CRIMPER	82
-	1	1		1803607-2	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
-	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		2063961-5	FEED FINGER	58
-	3	3		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-		2119792-2	PAWL, EF, AIR	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
-	1	1		1803152-1	STRIP GUIDE, REAR	19
-	1	1		1803151-1	STRIP GUIDE, FRONT	18
-	1	1		2-240641-8	SPACER	16
-	1	1		1752360-1	SPACER, HOLD-DOWN	13
1	-	1		240644-1	PLATE, REAR SHEAR	11
-	-	-		-	-	10
1	-	1		690482-5	PLATE, FRONT SHEAR	9
1	1	1		8-1803059-1	ANVIL, COMBINATION, END FEED	8
1	-	1		2217206-7	BLADE, SLUG	7
-	-	-		-	-	6
-	1	1		240641-3	SPACER	5
-	1	1		5-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1		7-1803187-1	CRIMPER, INSULATION F	3
-	-	-		-	-	2
1	1	1		6-456406-7	CRIMPER, WIRE PREMIUM	1
-	-	-		-	-	1

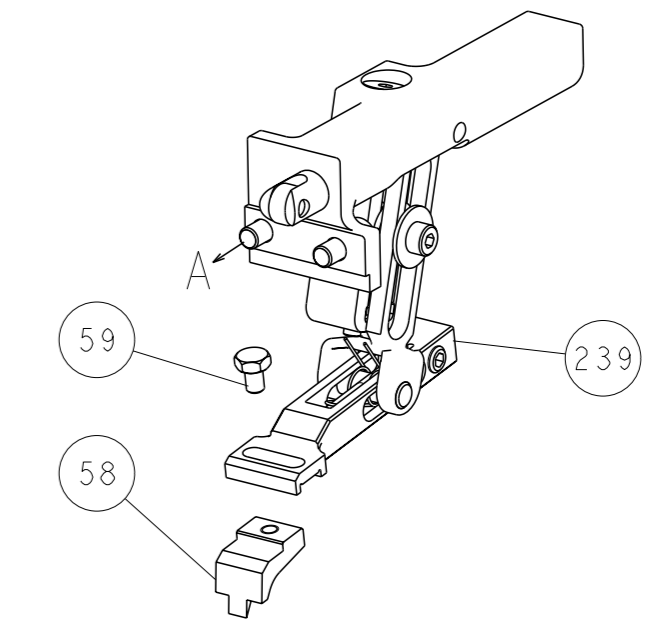
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWG M. ZHAO 12APR2017 CHK K. ZHANG 12APR2017 APVD K. ZHANG 12APR2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150801 3 OF 4 REV B	
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LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

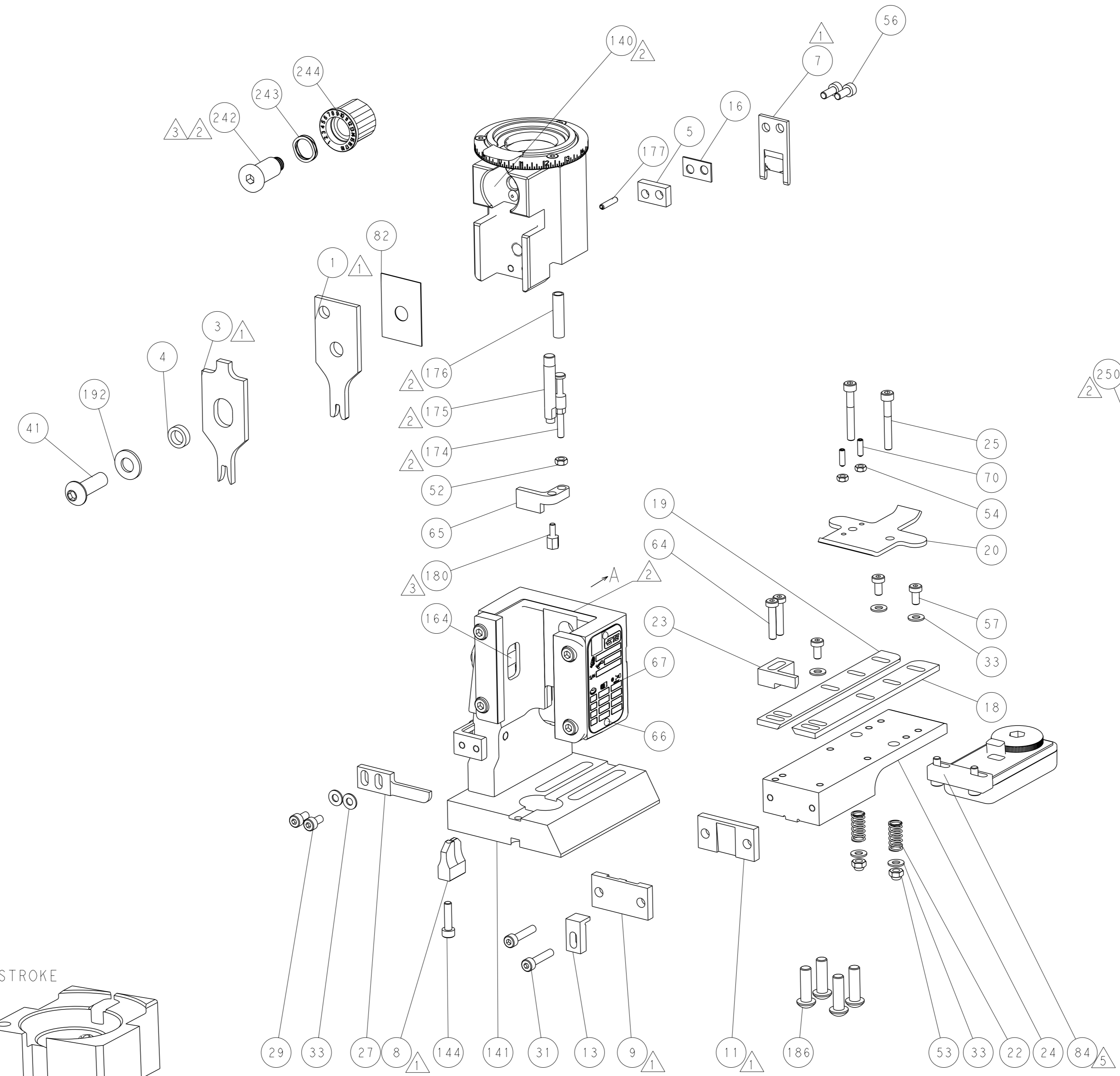
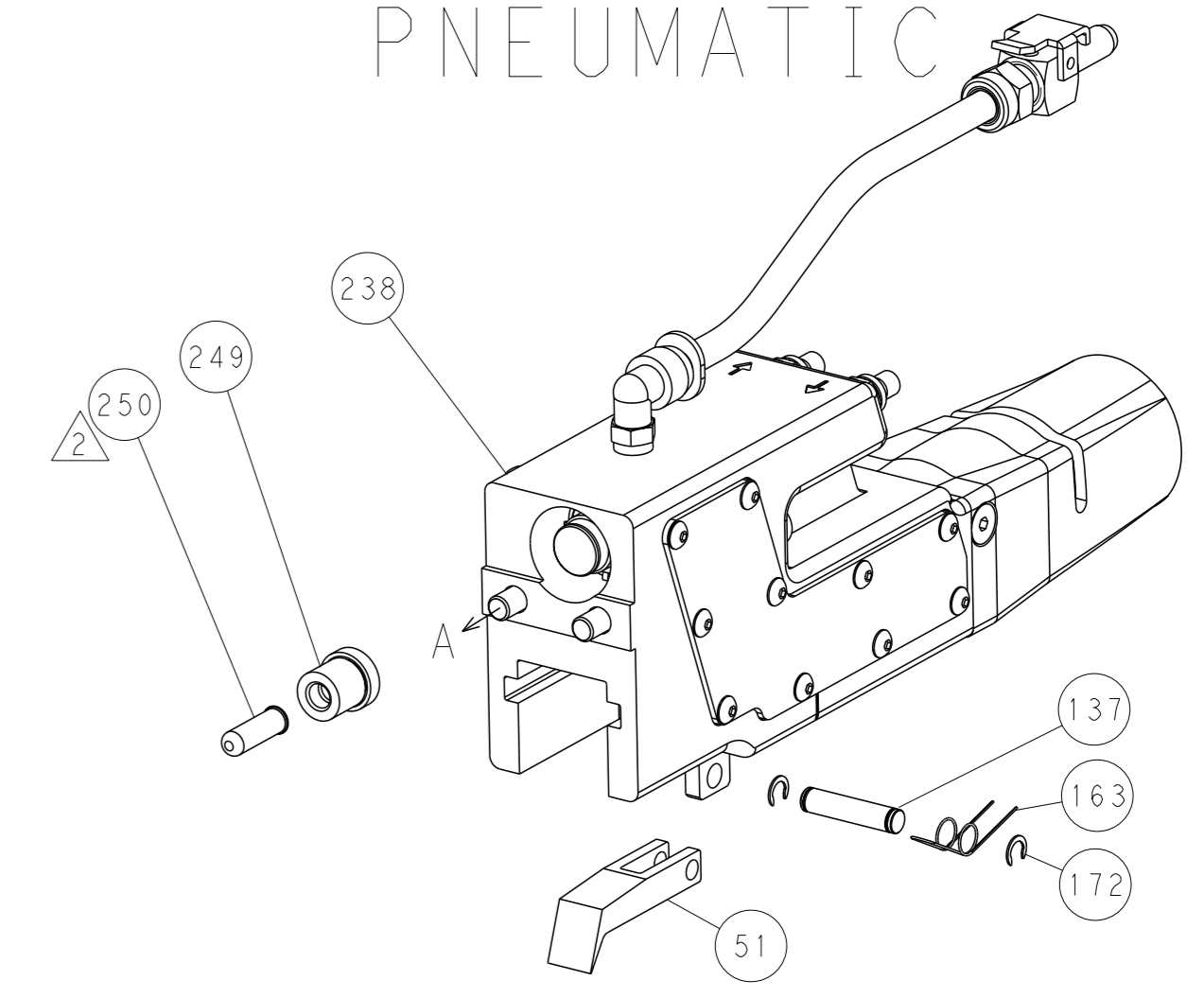


RAM AND HOLDDOWN SET-UP

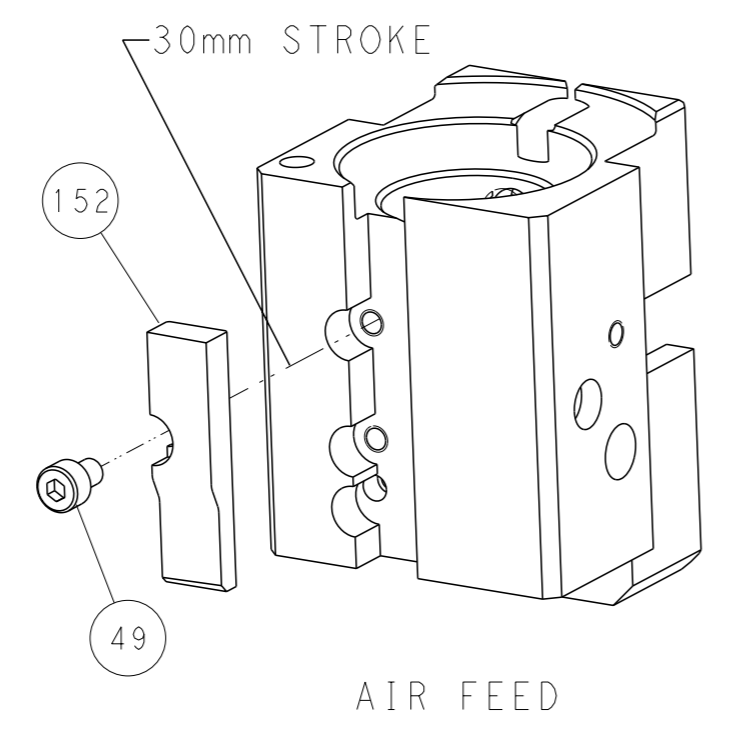
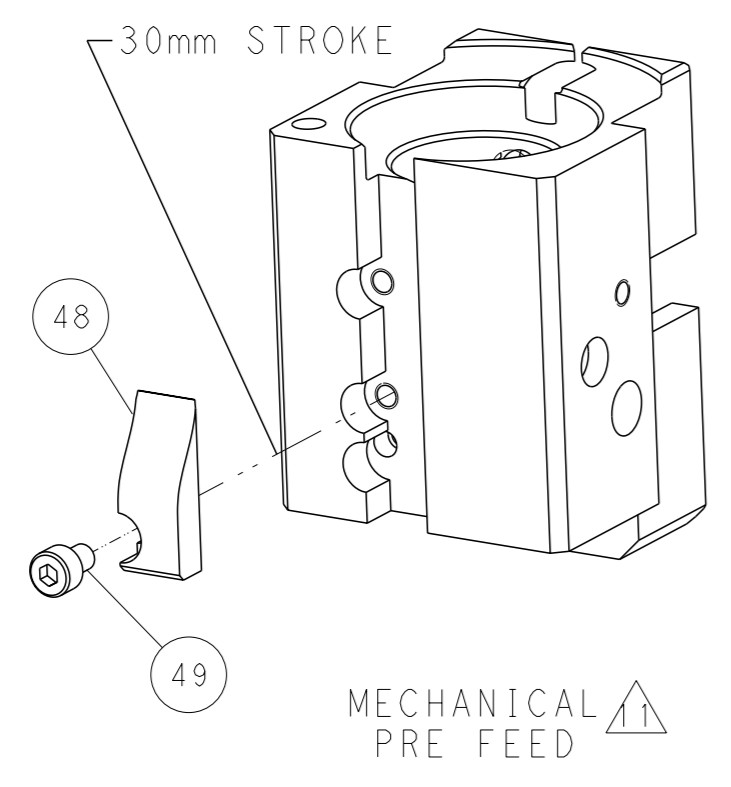
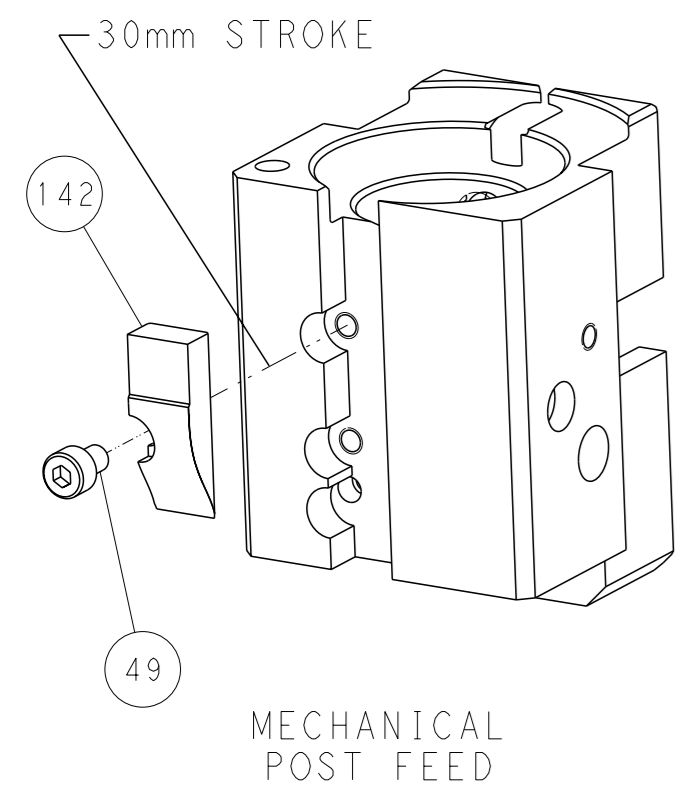
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROLING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. ZHAO 12APR2017 CHK: K. ZHANG 12APR2017 APVD: K. ZHANG 12APR2017	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	APPLICATION SPEC WEIGHT SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150801	RESTRICTED TO: B SHEET 4 OF 4 REV