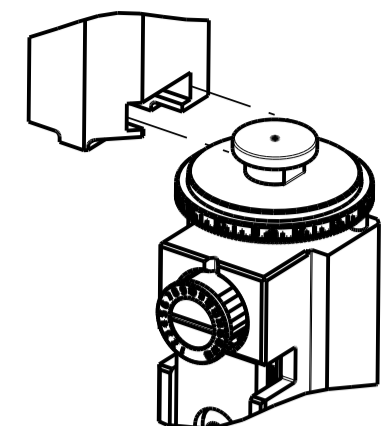


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150712-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150712-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150712-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150712-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150712-7	A	CRIMP TOOLING KIT	-

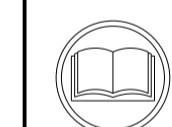
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.90 mm [.114]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H(Lear) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: END WIRE HOUSING TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.10-8.90 mm [.319-.350 IN]		∅2.00-2.70 mm [.079-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	25128 Rev 3		
TERMINALS APPLIED			
TE TERMINAL	G&H(Lear) TERMINAL	TE TERMINAL	G&H(Lear) TERMINAL
2303651-1	25128.112.178	2303651-2	25128.112.009
2303651-3	25128.417.131	2303651-4	25128.411.131
2303651-5	25128.213.111	2303651-6	25128.213.009

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 0.5mm <sup>2</sup>	1.35+/-0.05 [.053+/-0.002]	7.1
1.00mm <sup>2</sup>	1.35+/-0.05 [.053+/-0.002]	7.8
0.75mm <sup>2</sup>	1.25+/-0.05 [.049+/-0.002]	8.6
0.50mm <sup>2</sup>	1.15+/-0.05 [.045+/-0.002]	10.1



- 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.
  - 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.
  - STRIPPER IN FRONT OF THE INSUALTION CRIMPER. SET UP ON PRE-FEED.
  - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

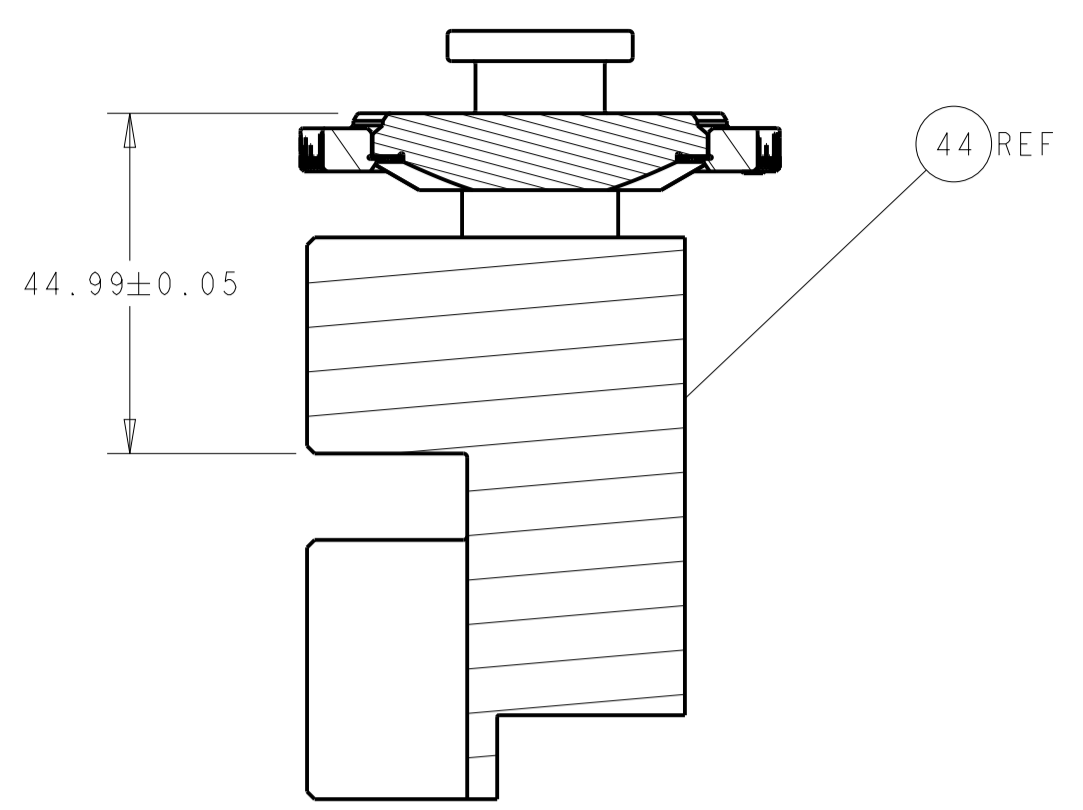
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	A	03OCT2016	LG	TE	
		B	29JUN2018	KH	GB	
		C	28DEC2020	FJ	TE	
		D	25FEB2021	FJ	TE	

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	1-455888-0	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	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	1	-	2063961-1	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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-2	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-7	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-1	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	1901259-5	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	
-	2	2	2	2	240645-2	SPACER, SHEAR PLATE	10	
-	1	1	1	1	690619-6	PLATE, RETAINING	9	
-	1	2	2	1	1	7-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1	1	3-459722-0	BLADE, SHEAR	7	
-	1	1	1	1	1213862-3	ANVIL, INSUL	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	3-1803187-0	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-459736-4	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

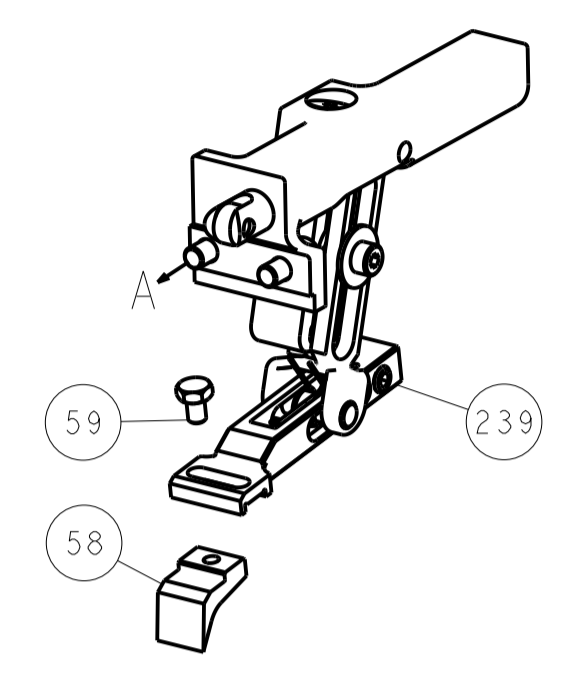
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 25AUG2016		CHK: L.ZHANG 25AUG2016		APVD: L.ZHANG 25AUG2016		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	9 PLC ±	10 PLC ±
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET 1 OF 4		REV D	

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

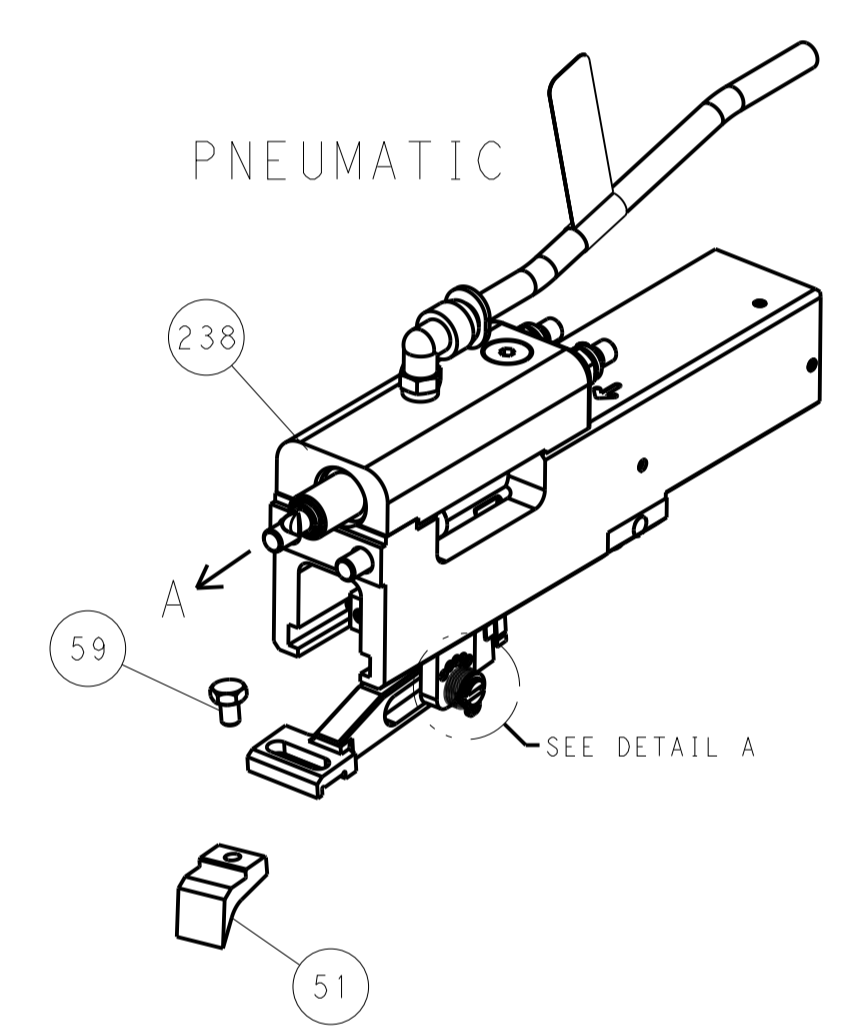


RAM SET-UP

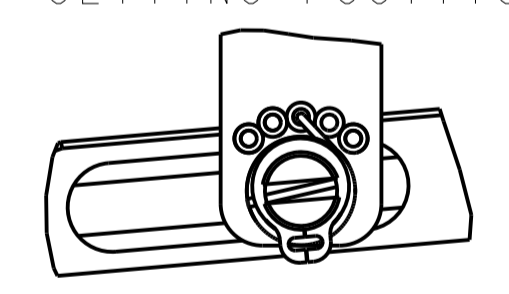
FEED TYPE  
MECHANICAL



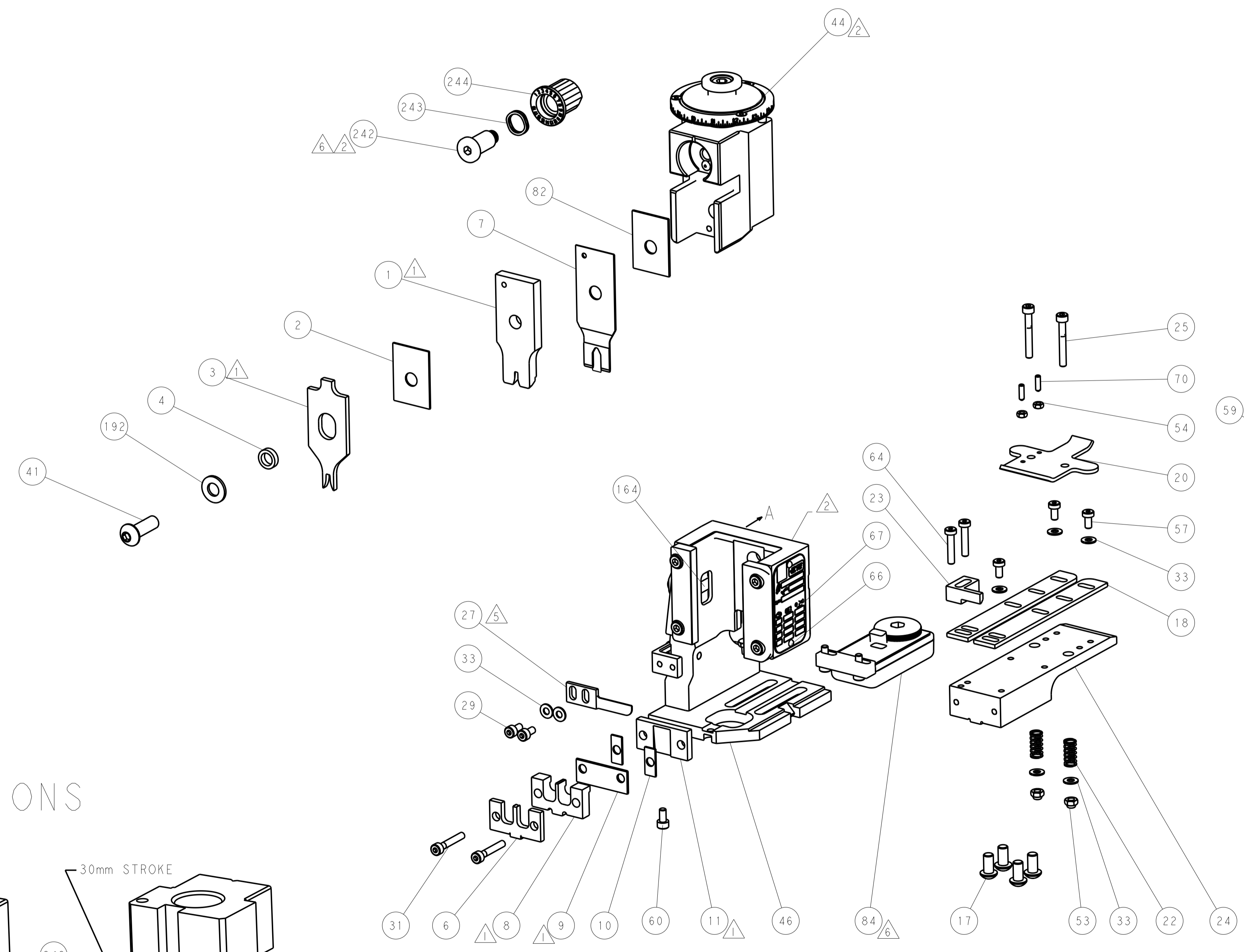
PNEUMATIC



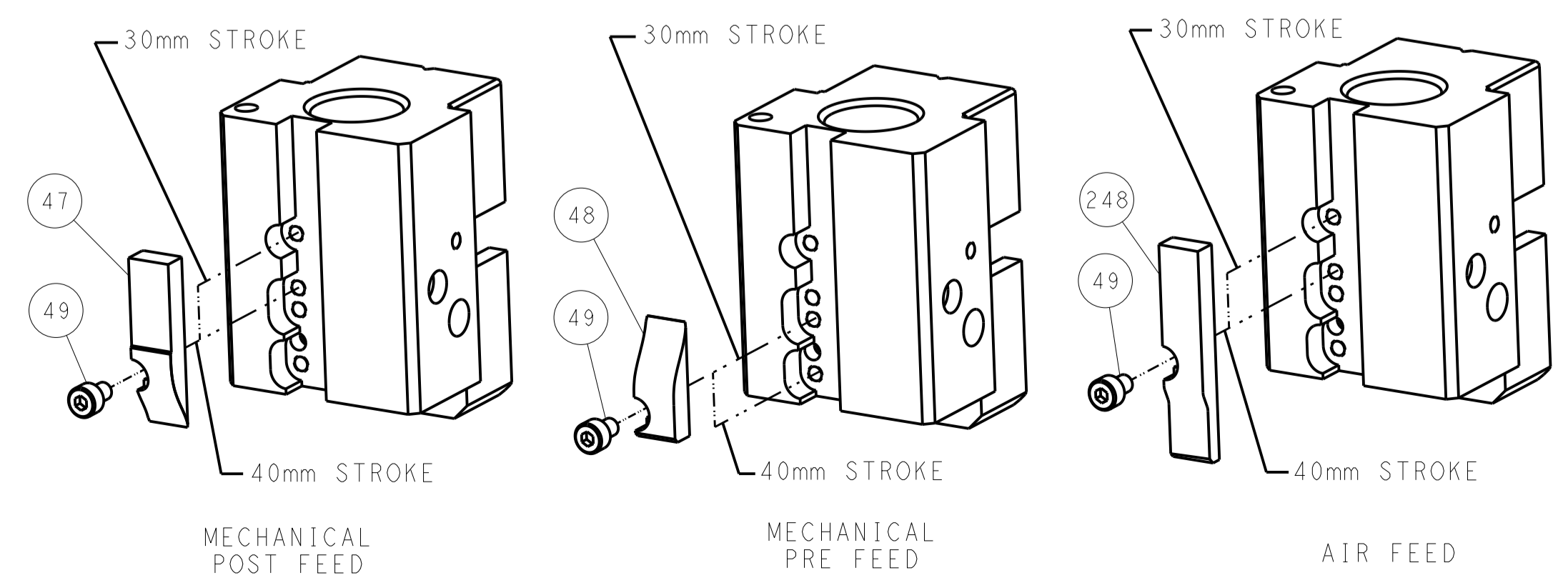
FEED SPRING  
SETTING POSITION



DETAIL A



CAM POSITIONS

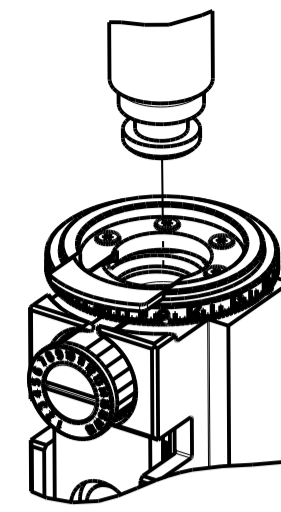


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 25AUG2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±			CHK L. ZHANG 25AUG2016		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		APVD L. ZHANG 25AUG2016		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				PRODUCT SPEC		A11 00779 ©=2150712	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:1 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150712-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150712-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150712-7	A	CRIMP TOOLING KIT	-

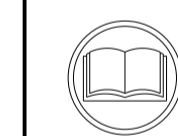
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm (.078)	F
INSUL	2.90 mm (.114)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H(Lear) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: END WIRE HOUSING TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
8.10-8.90 mm (.319-.350 IN)	∅2.00-2.70 mm (.079-.106 IN)		
TERMINAL APPLICATION SPECIFICATION	25128 Rev 3	-	-
TERMINALS APPLIED			
TE TERMINAL	G&H(Lear) TERMINAL	TE TERMINAL	G&H(Lear) TERMINAL
2303651-1	25128.112.178	2303651-2	25128.112.009
2303651-3	25128.417.131	2303651-4	25128.411.131
2303651-5	25128.213.111	2303651-6	25128.213.009

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 0.5mm <sup>2</sup>	1.35+/-0.05 [.053+/-0.002]	7.1
1.00mm <sup>2</sup>	1.35+/-0.05 [.053+/-0.002]	7.8
0.75mm <sup>2</sup>	1.25+/-0.05 [.049+/-0.002]	8.6
0.50mm <sup>2</sup>	1.15+/-0.05 [.045+/-0.002]	10.1



- 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.
  - 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 STRIPPER IN FRONT OF THE INSULATION CRIMPER. SET UP ON PRE-FEED.
  - 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

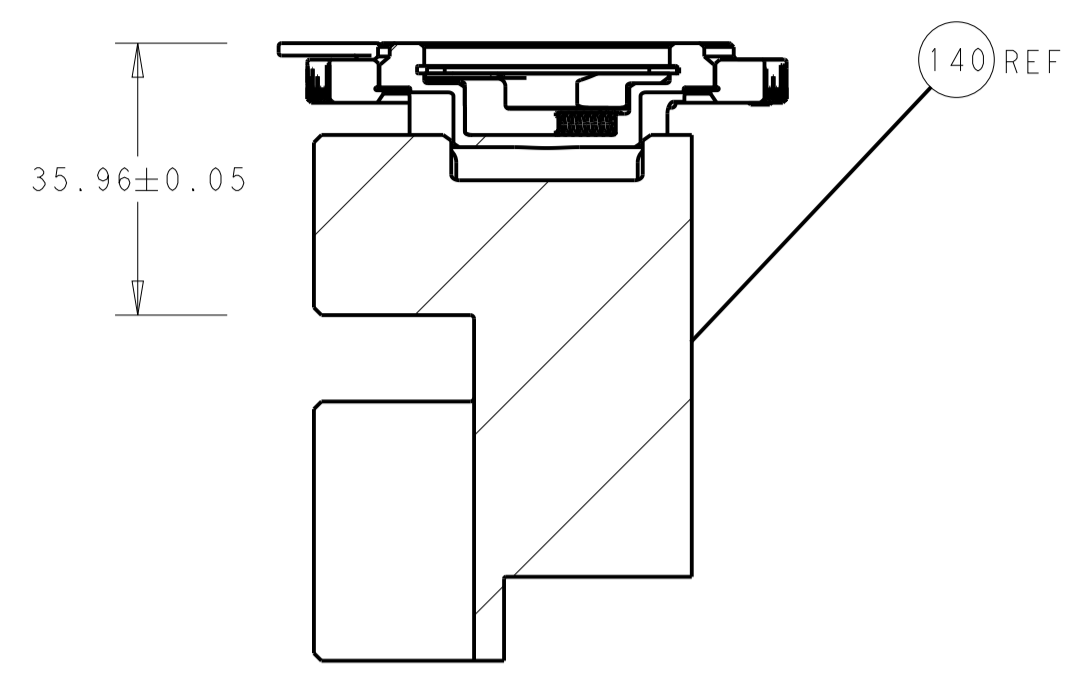
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
-	-	-	SEE SHEET 1	-	-
-	1	1	2119082-7	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	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
-	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1-455888-0	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
-	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	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2063961-1	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-7	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-1	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	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	240645-2	SPACER, SHEAR PLATE	10
-	1	1	690619-6	PLATE, RETAINING	9
-	1	1	7-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	3-459722-0	BLADE, SHEAR	7
-	1	1	1213862-3	ANVIL, INSUL	6
-	-	-	-	-	5
-	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
-	1	1	3-1803187-0	CRIMPER, INSULATION F	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	5-459736-4	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

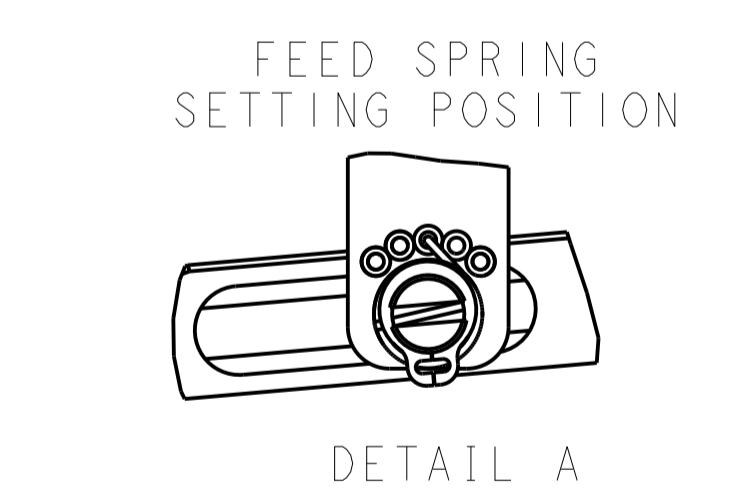
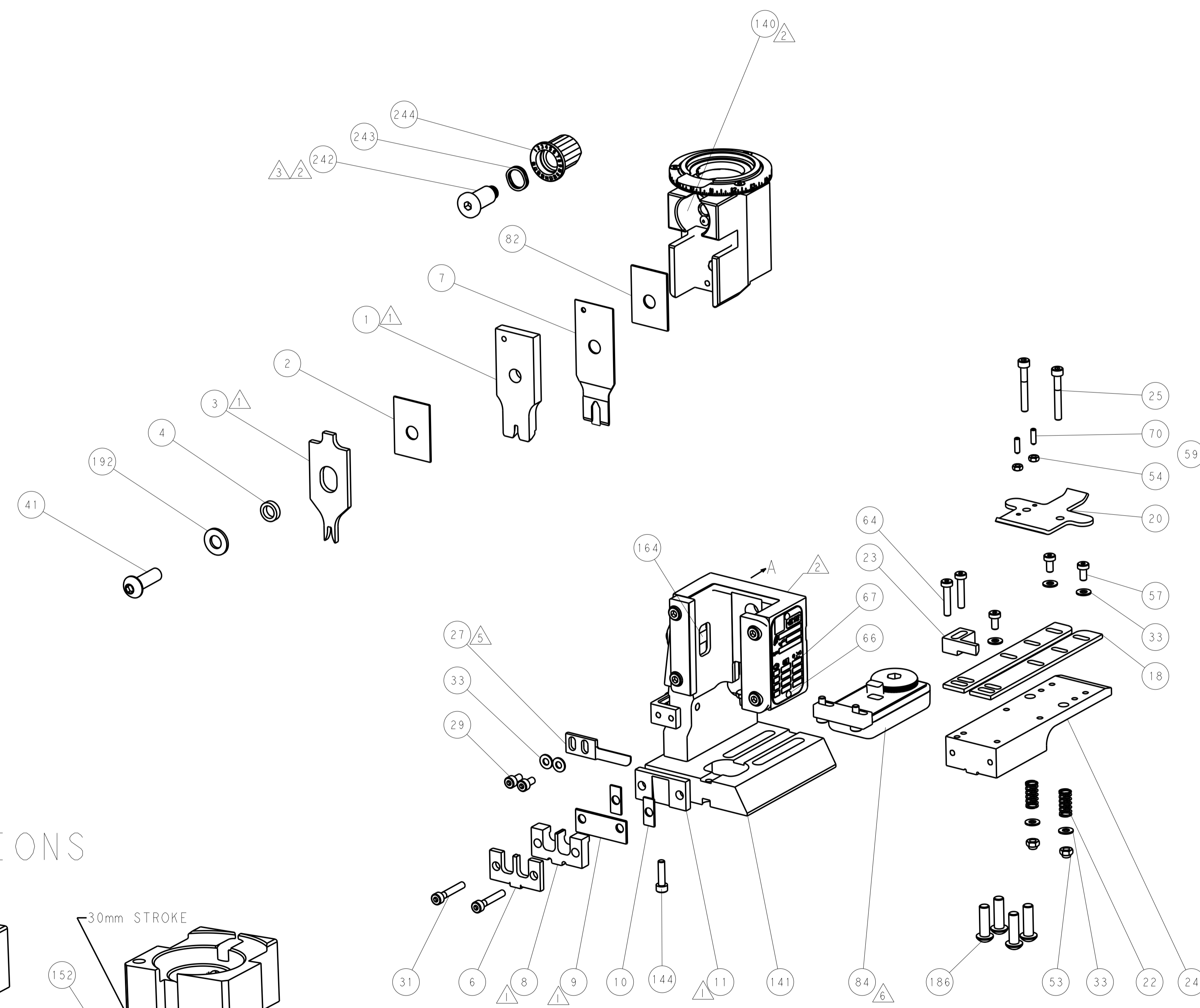
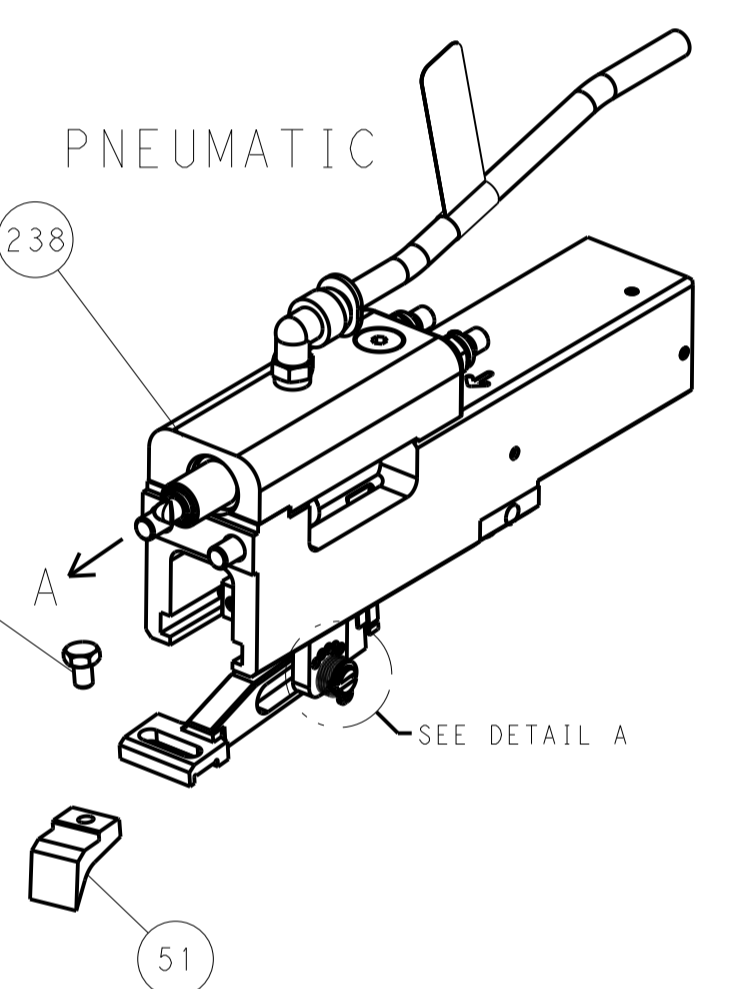
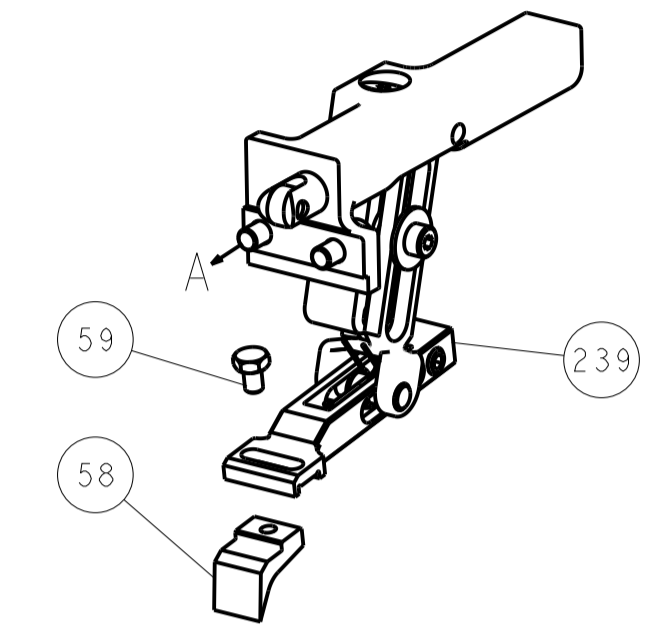
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	25AUG2016	25AUG2016
	3 PLC ±	4 PLC ±	ANGLES ±	CHK L. ZHANG	APPV L. ZHANG
	FINISH			25AUG2016	25AUG2016
MATERIAL		WEIGHT		NAME	
				Ocean End Feed Applicator	
				SIZE	CAGE CODE
				A1	00779
				SCALE	1:1
				SHEET	3 OF 4
				REV	D

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

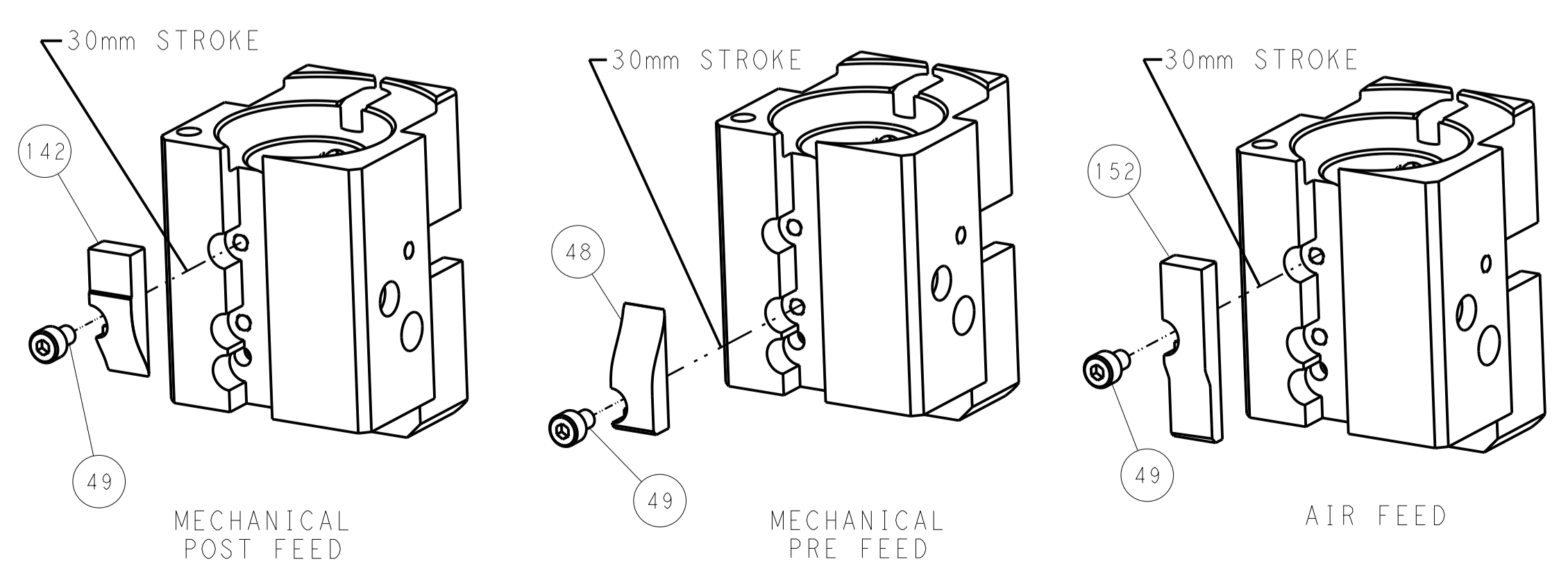


RAM SET-UP

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:		DWN		25AUG2016		STE TE Connectivity	
mm		0 PLC ±		CHK		25AUG2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		L. ZHANG		25AUG2016		NAME	
MATERIAL		2 PLC ±		L. ZHANG		25AUG2016		Ocean End Feed	
FINISH		3 PLC ±		APVD				Applicator	
		4 PLC ±		APVD				SIZE	
		ANGLES		APVD				CAGE CODE	
				APVD				DRAWING NO	
				APVD				A11 00779	
				APVD				SCALE	
				APVD				1:1	
				APVD				SHEET	
				APVD				4 OF 4	
				APVD				REV	
				APVD				D	