

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150936-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150936-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150936-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150936-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150936-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	-	-

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: GH/LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLIP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.20-6.70 mm [.244-.264 IN]		∅1.67-2.22 mm [.066-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	25258 Rev 6	-	-
TERMINALS APPLIED			
TE TERMINAL	GH/LEAR TERMINAL	TE TERMINAL	GH/LEAR TERMINAL
2113399-1	25258.123.178	2113399-2	25258.411.131
2113399-3	25258.211.111	2113399-4	25258.123.111

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.70 +/- 0.05 [.067 +/- .002]	7.9
1 mm + 0.75 mm2	1.50 +/- 0.05 [.059 +/- .002]	9.8
1.50mm2	1.40 +/- 0.05 [.055 +/- .002]	10.9
16 AWG	1.35 +/- 0.05 [.053 +/- .002]	11.2

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 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.
- 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.

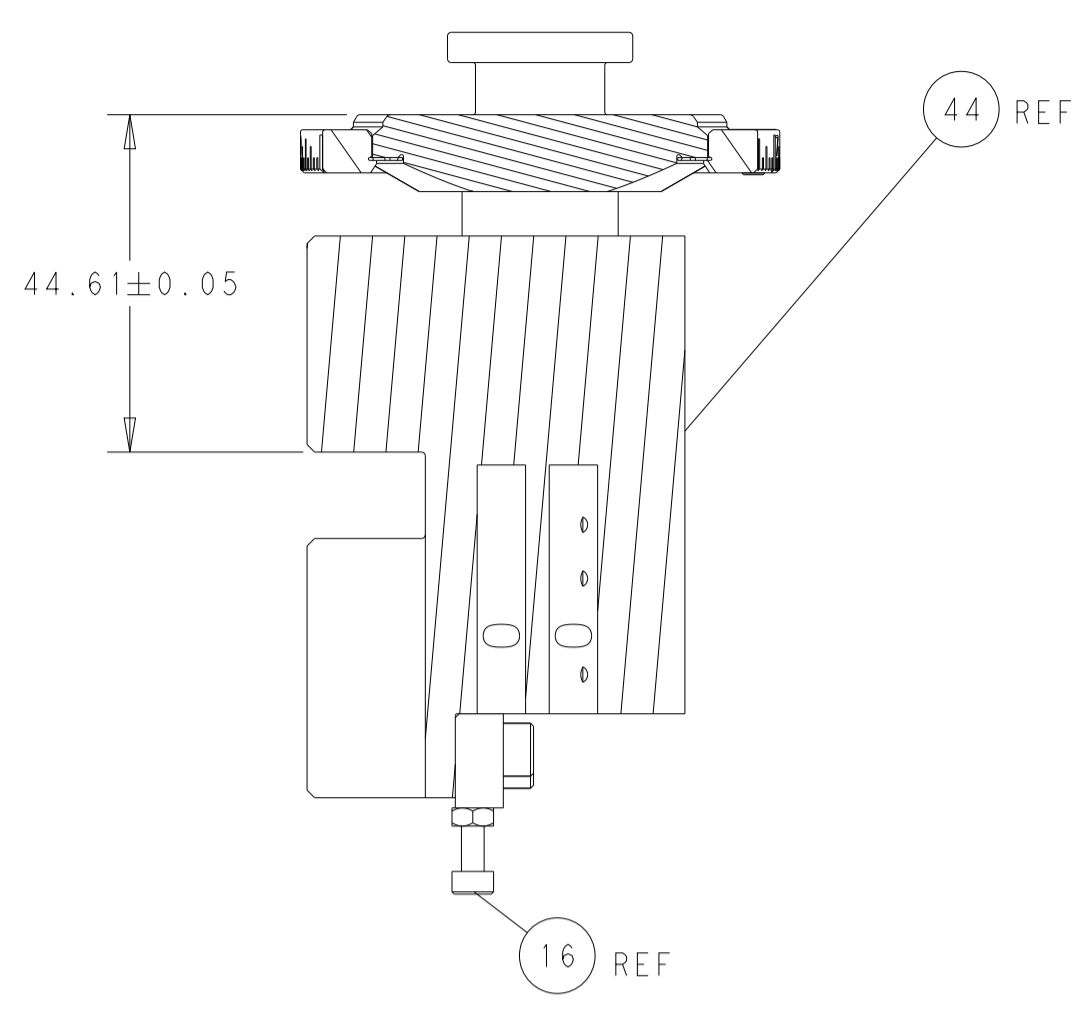
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	17JUL2018	KH	LZ
		A		RELEASED	24AUG2018	TB	TE
		B		ECR-21-121622	22NOV2021	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1803008-3	FLOATING SHEAR HOLDER	206	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	191	
-	2	2	2	2	2-22280-0	SPRING, COMPRESSION	179	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	1	1	1	1	1-356885-7	STOP, SHEAR	177	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	3-455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	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	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	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	468281-6	STRIPPER	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-1	DRAG, STOCK	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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	-	-	-	-	-	-	11	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	1	2	2	1	1	7-690618-9	ANVIL, SPLICE TYPE	8
-	1	1	1	1	1	1803009-2	SHEAR BLADE	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	3-1803454-4	CRIMPER, WIRE	1
-	77	72	71	2	-	PART NO	DESCRIPTION	ITEM NO

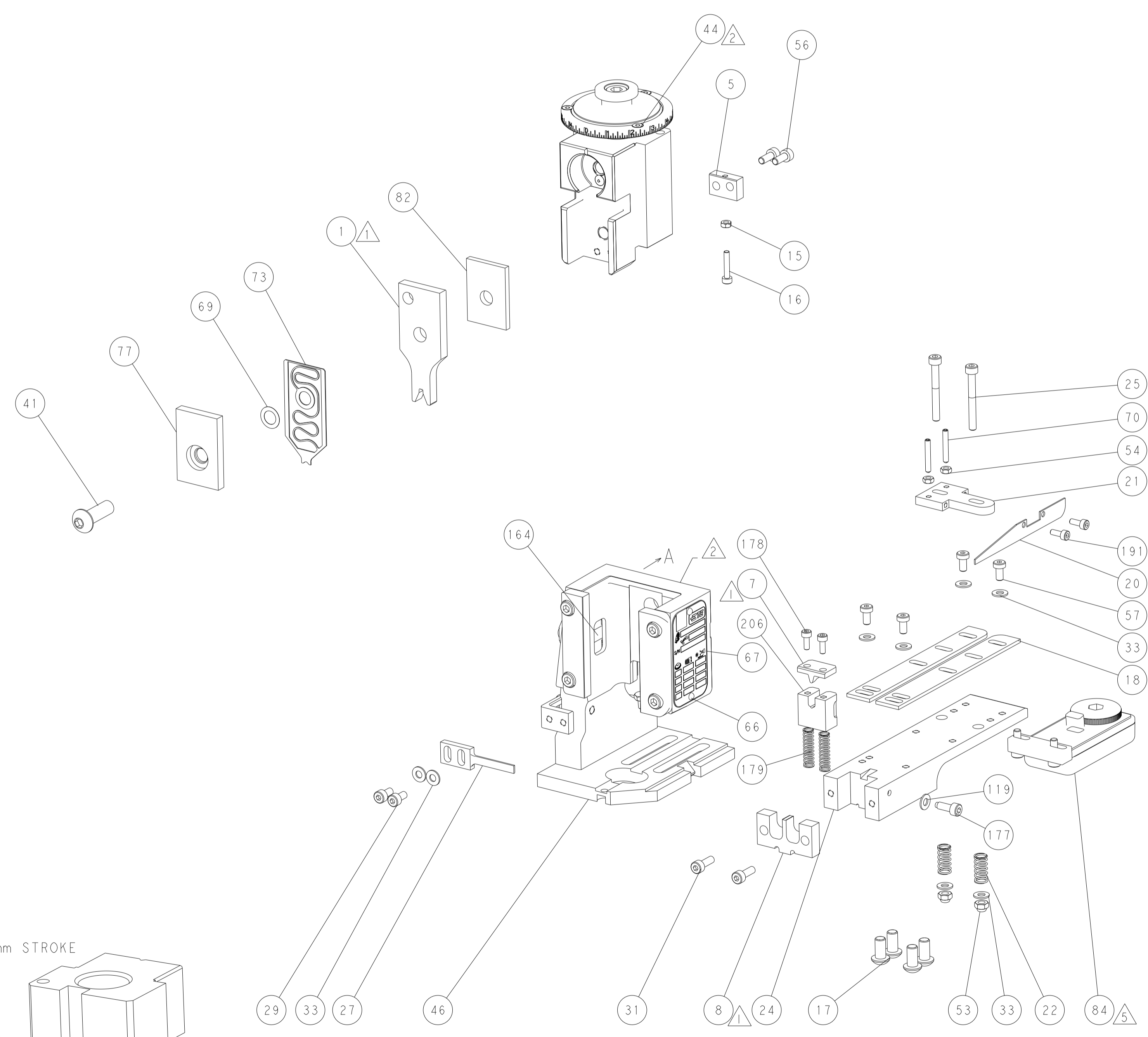
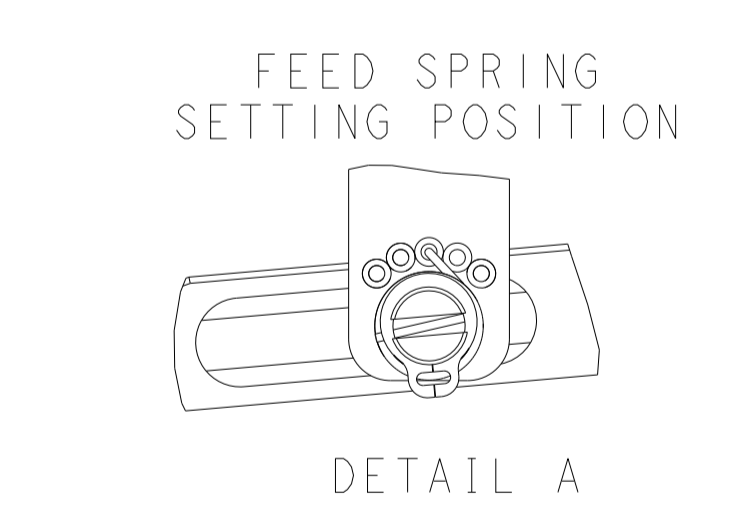
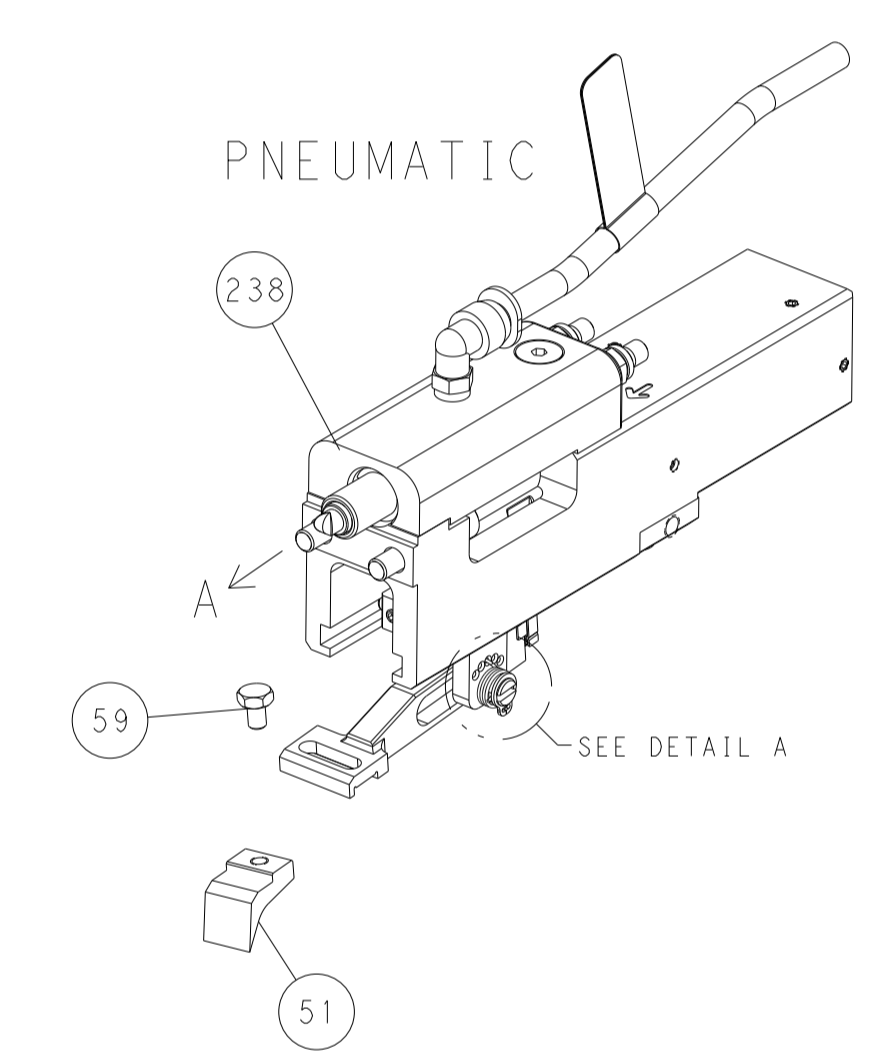
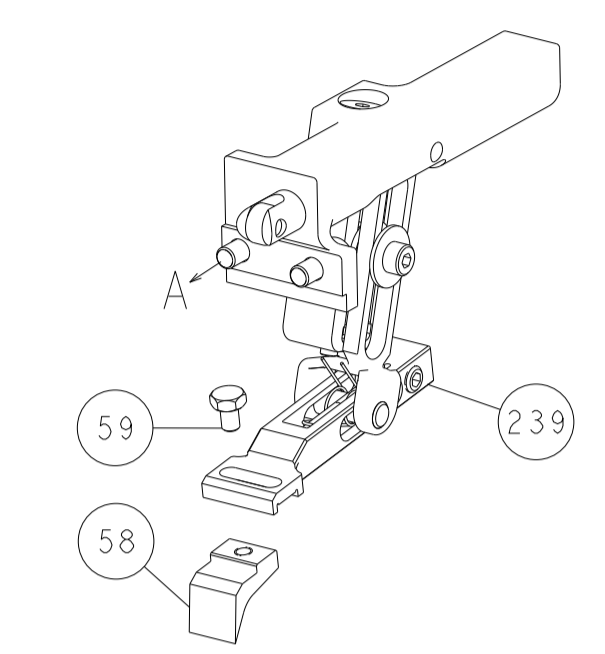
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG CHK L. ZHANG APVD L. ZHANG PRODUCT SPEC		NAME Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SIZE A1	CAGE CODE 00779
	ANGLES	FINISH		APPLICATION SPEC		DRAWING NO C=2150936	RESTRICTED TO
MATERIAL				WEIGHT		SCALE 1:1	SHEET 1 OF 4
Customer Accessible Production Drawing						REV B	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

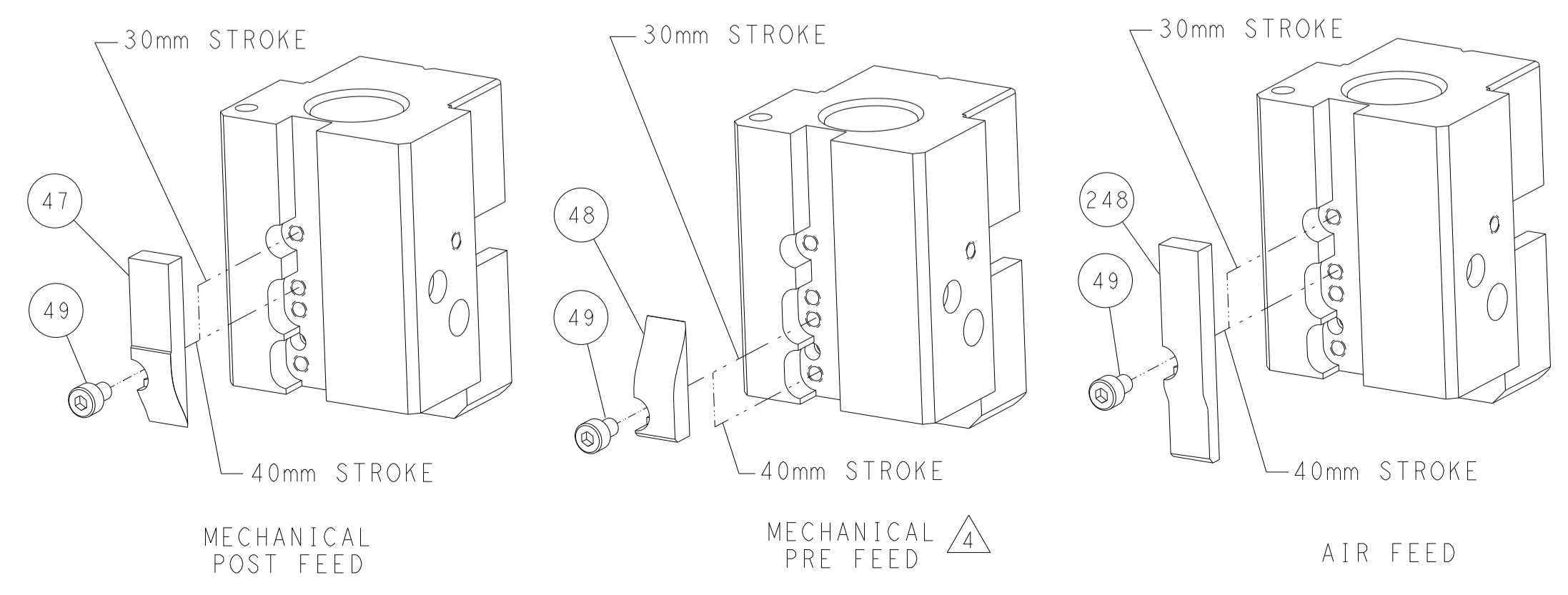


RAM AND HOLD-DOWN SET-UP

FEED TYPE MECHANICAL



CAM POSITIONS

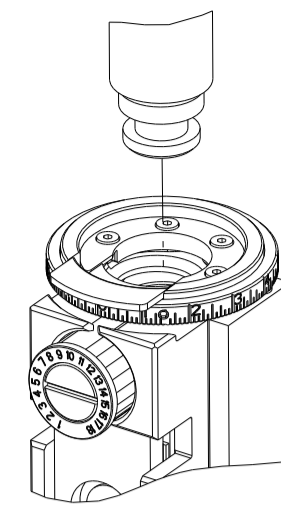


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 17JUL2018 CHK L. ZHANG 17JUL2018 APVD L. ZHANG 17JUL2018 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 ©=2150936 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV B	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150936-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150936-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150936-7	A	CRIMP TOOLING KIT	-

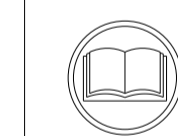
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm (.104)	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: GH/LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLIP TERMINAL			
WIRE STRIP LENGTH 6.20-6.70 mm (.244-.264 IN)		INSULATION DIAMETER RANGE Ø1.67-2.22 mm (.066-.087 IN)	
TERMINAL APPLICATION SPECIFICATION	25258 Rev 6	-	-
TERMINALS APPLIED			
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2113399-1	25258.123.178	2113399-2	25258.411.131
2113399-3	25258.211.111	2113399-4	25258.123.111

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.70+/-0.05 [.067+/-0.002]	7.9
1 mm + 0.75 mm2	1.50+/-0.05 [.059+/-0.002]	9.8
1.50mm2	1.40+/-0.05 [.055+/-0.002]	10.9
16 AWG	1.35+/-0.05 [.053+/-0.002]	11.2



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
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***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.

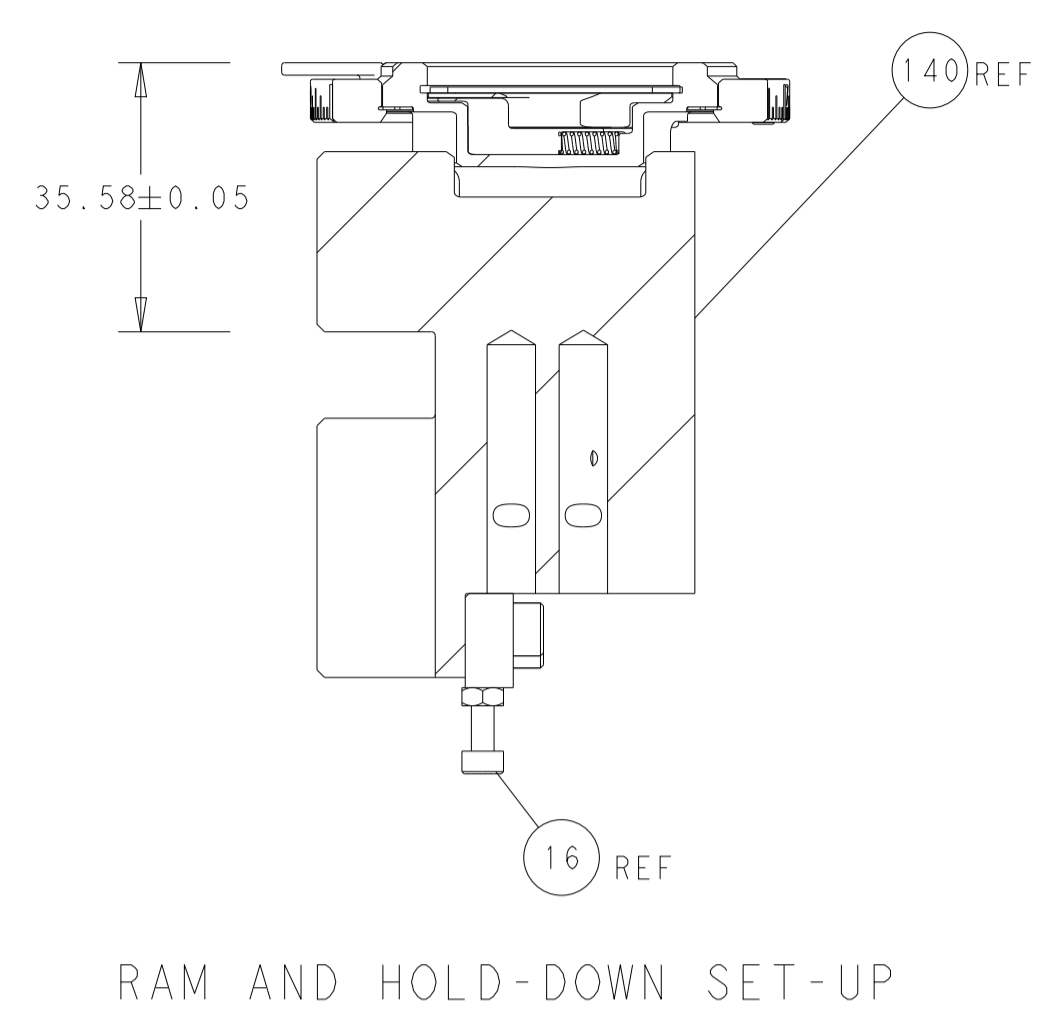
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

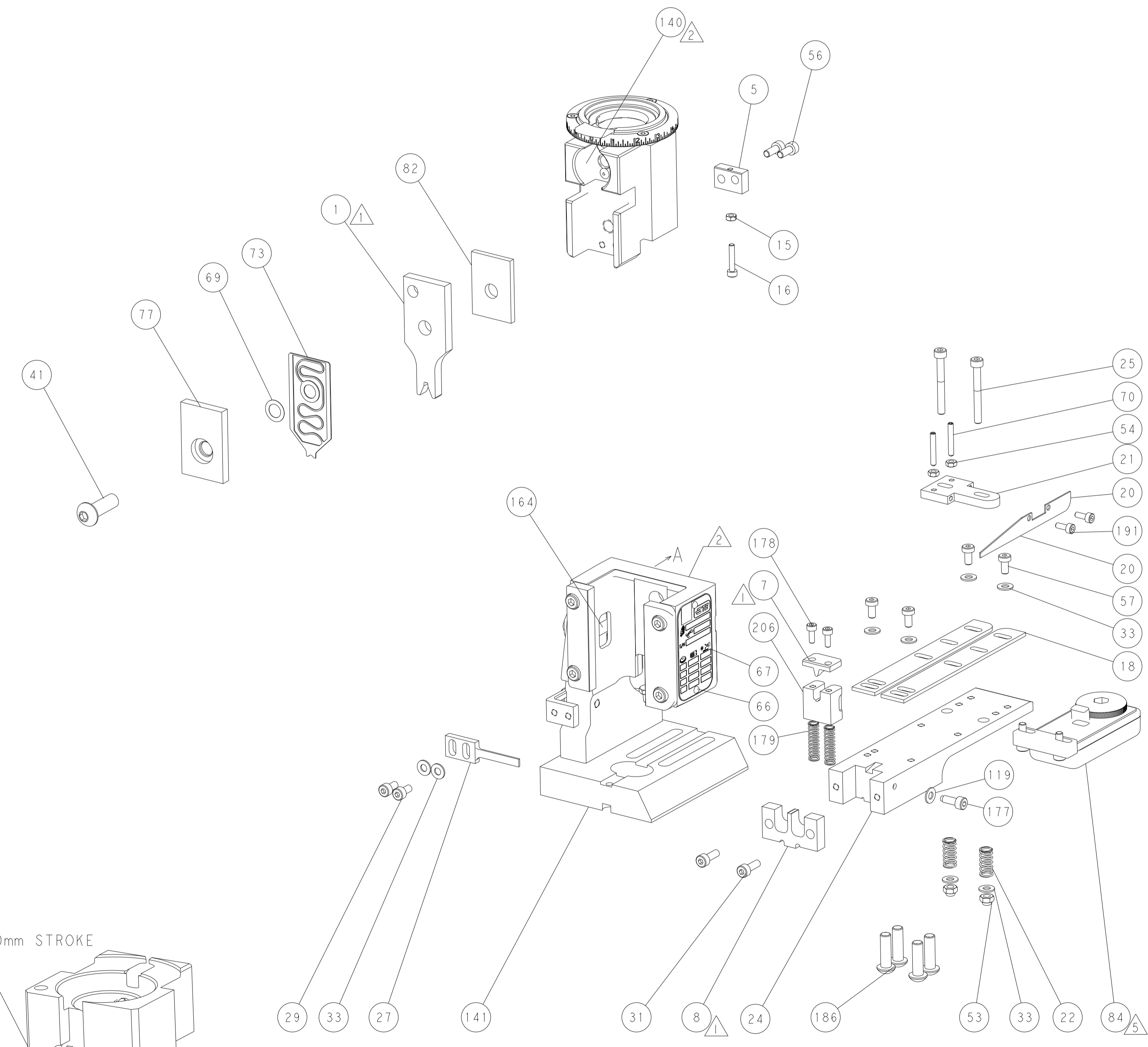
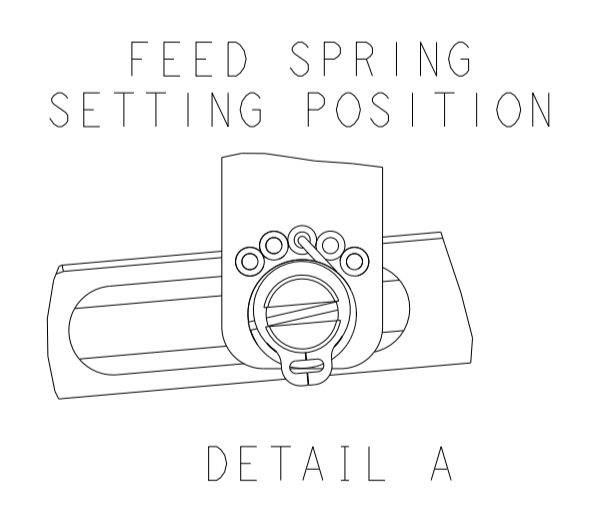
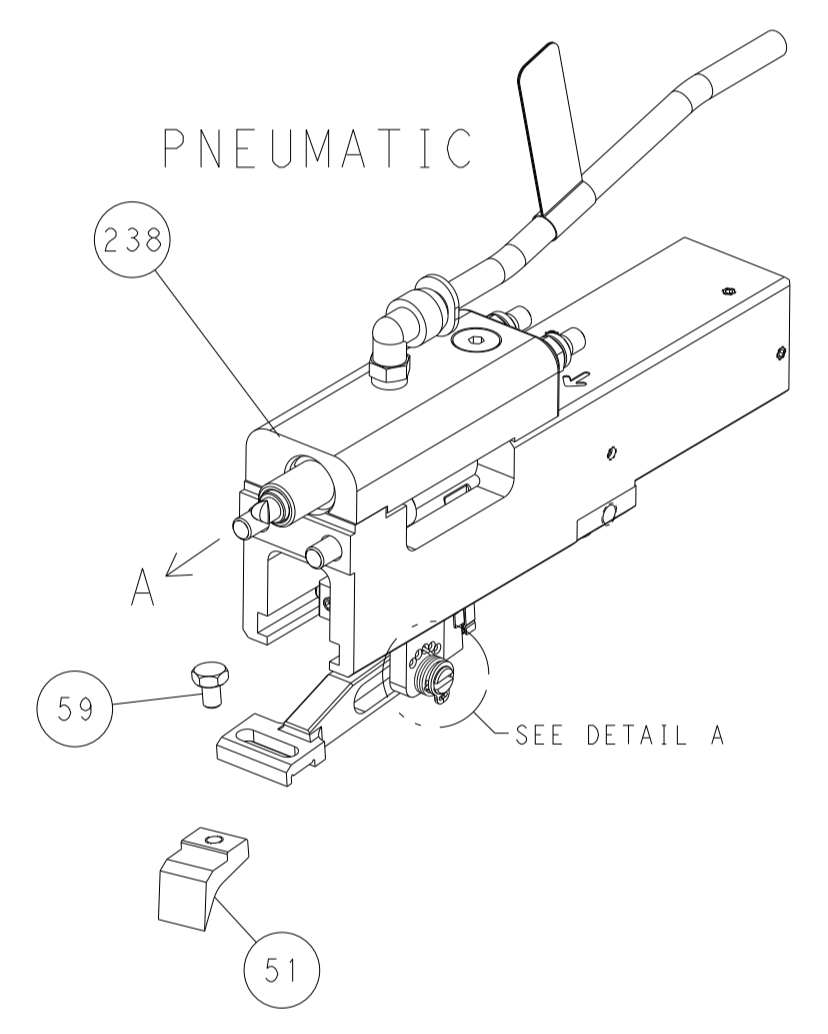
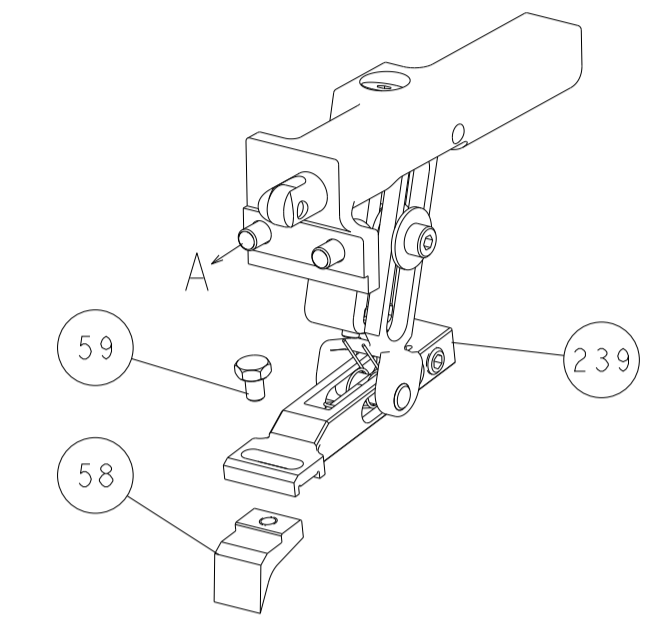
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1803008-3	FLOATING SHEAR HOLDER	206	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	191	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	2	2	2-22280-0	SPRING, COMPRESSION	179	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	1	1	1-356885-7	STOP, SHEAR	177	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	3-455888-7	SPACER, CRIMPER	82	
-	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77	
-	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	4	4	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	-	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	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	468281-6	STRIPPER	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	464452-1	DRAG, STOCK	20	
-	2	2	1901259-4	GUIDE, LOWER STRIP	18	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	-	-	-	-	11	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	1	1	1	7-690618-9	ANVIL, SPLICE TYPE	8
-	1	1	1	1803009-2	SHEAR BLADE	7
-	-	-	-	-	6	
-	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
-	1	1	1	3-1803454-4	CRIMPER, WIRE	1

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20</small> <small>BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN H. HUANG 17JUL2018 CHK L. ZHANG 17JUL2018 APVD L. ZHANG 17JUL2018	NAME Ocean End Feed Applicator - SIZE A1 CAGE CODE 00779 DRAWING NO C=2150936 RESTRICTED TO - SCALE 1:1 SHEET 3 OF 4 REV B
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	APPLICATION SPEC - WEIGHT - MATERIAL -	Customer Accessible Production Drawing

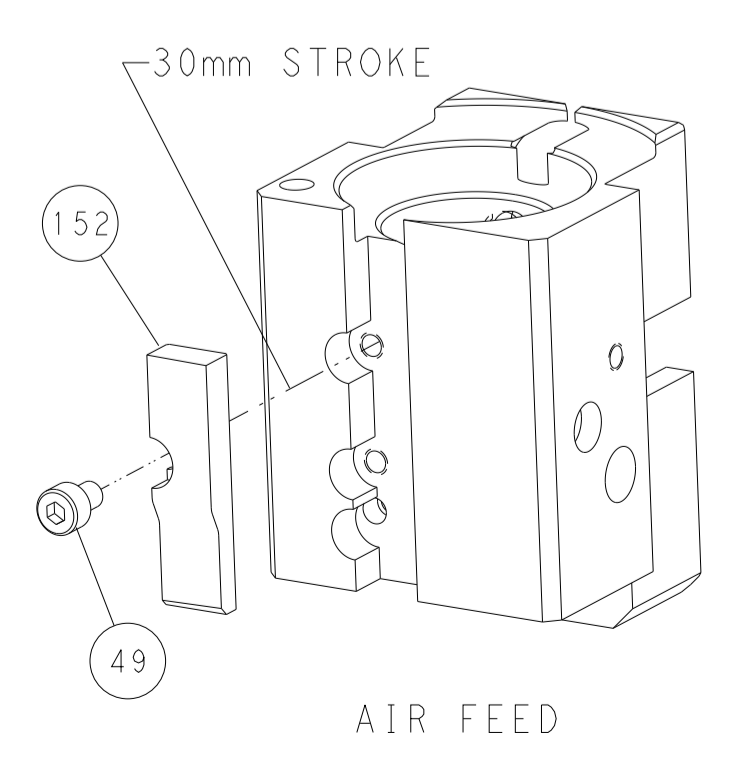
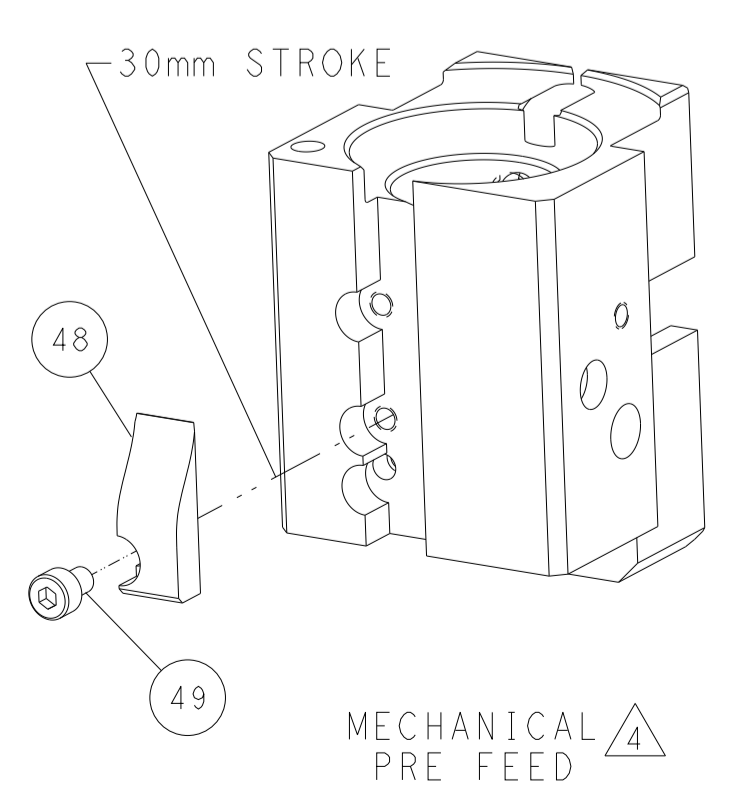
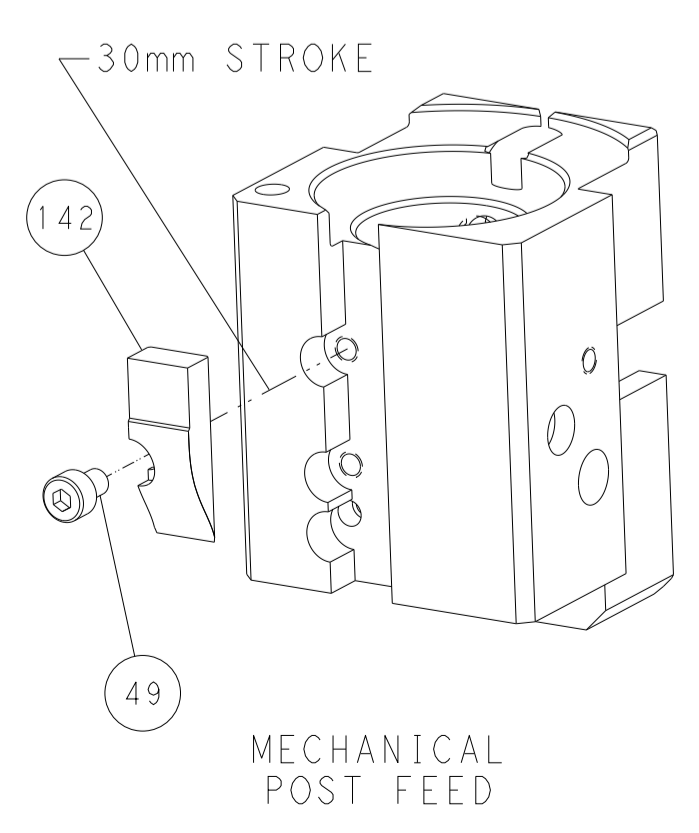
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1			



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 17JUL2018 CHK: L. ZHANG 17JUL2018 APVD: L. ZHANG 17JUL2018	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 APPLICATION SPEC: - PRODUCT SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150936 RESTRICTED TO: -
MATERIAL: - FINISH: -		SCALE: 1:1 SHEET: 4 OF 4 REV: B	Customer Accessible Production Drawing