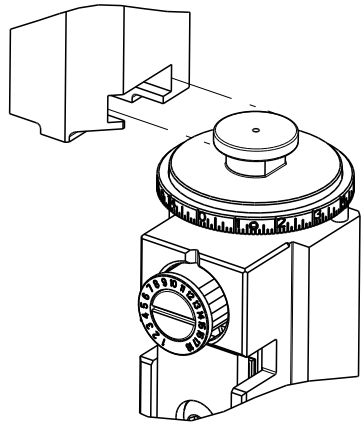


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150299-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH 5.20-6.00 mm [.205-.236 IN]		INSULATION DIAMETER RANGE Ø1.50-2.00 mm [.059-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 5			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
1.00mm2		1.95+/-0.05 [.077+/- .002]		4.0
0.75mm2		1.85+/-0.05 [.073+/- .002]		5.3
0.50mm2		1.80+/-0.05 [.071+/- .002]		5.8
0.35mm2		1.73+/-0.05 [.068+/- .002]		6.0



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25209 REVISION 12	-	-
TERMINALS APPLIED 5			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
2x 0.50		1.90+/-0.05 [.075+/- .002]		4.5
1.00mm2		1.80+/-0.05 [.071+/- .002]		5.8
0.75mm2		1.75+/-0.05 [.069+/- .002]		6.3
2x 0.35		1.70+/-0.05 [.067+/- .002]		6.7
0.50mm2		1.70+/-0.05 [.067+/- .002]		6.7

*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)

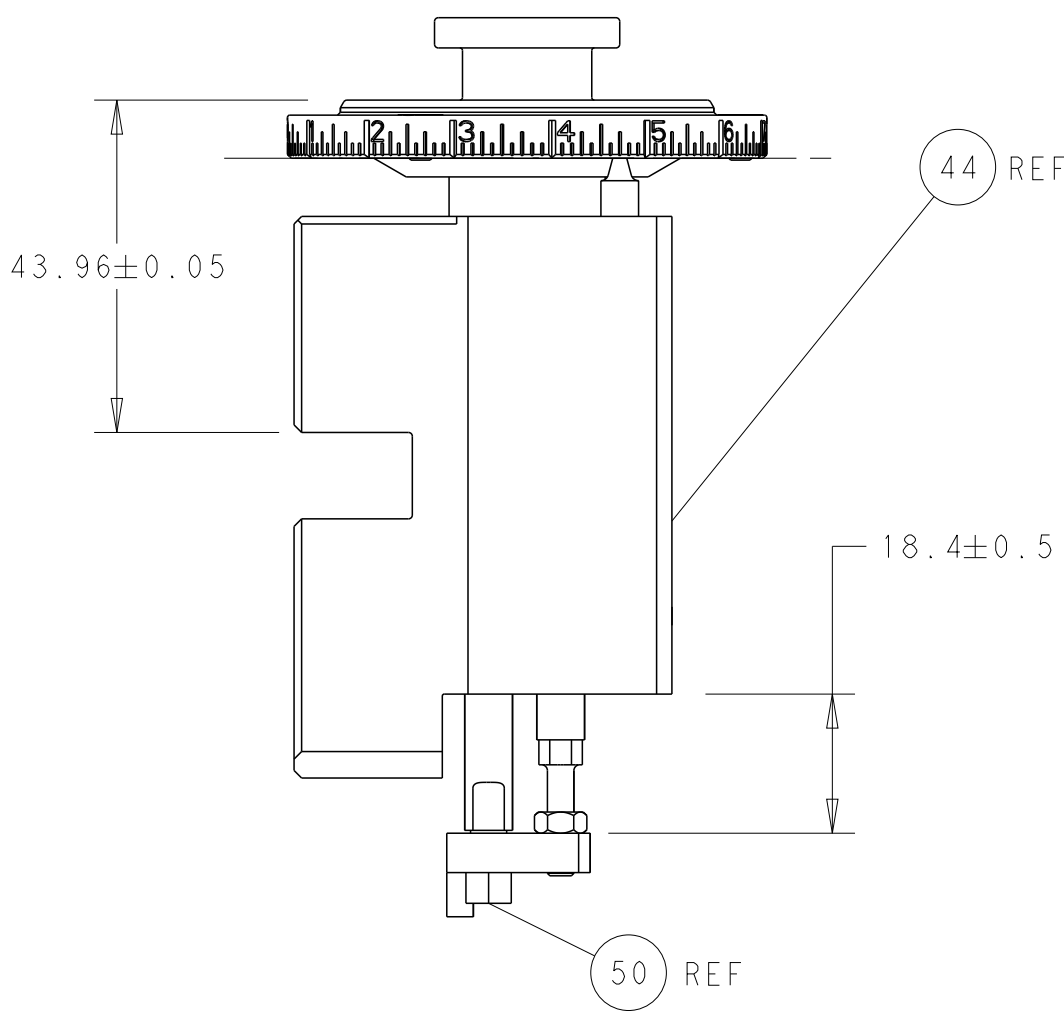
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LOC	DIST	REVISIONS					
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		B		ECR-14-017572	24NOV2014	RK	GB
		B1		ECR-16-005465	14APR2016	RS	LZ
		C		ECR-19-005818	11APR2019	TB	CT

3	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-8	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	1	2063440-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	6-9931111-6	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	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	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1	2119792-2	PAWL, EF, AIR	51	
3	-	1	1	1752354-1	STANDOFF,HOLD-DOWN	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	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	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
7	-	1	1	1-1901696-5	STRIP GUIDE, REAR	19
7	-	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	6-240641-6	SPACER	16	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10	
1	-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	2	1	2-1803000-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-6	SPACER	5
-	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	1-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	1	4-1633664-7	CRIMPER, WIRE	1
-	77-72	-2		PART NO	DESCRIPTION	ITEM NO

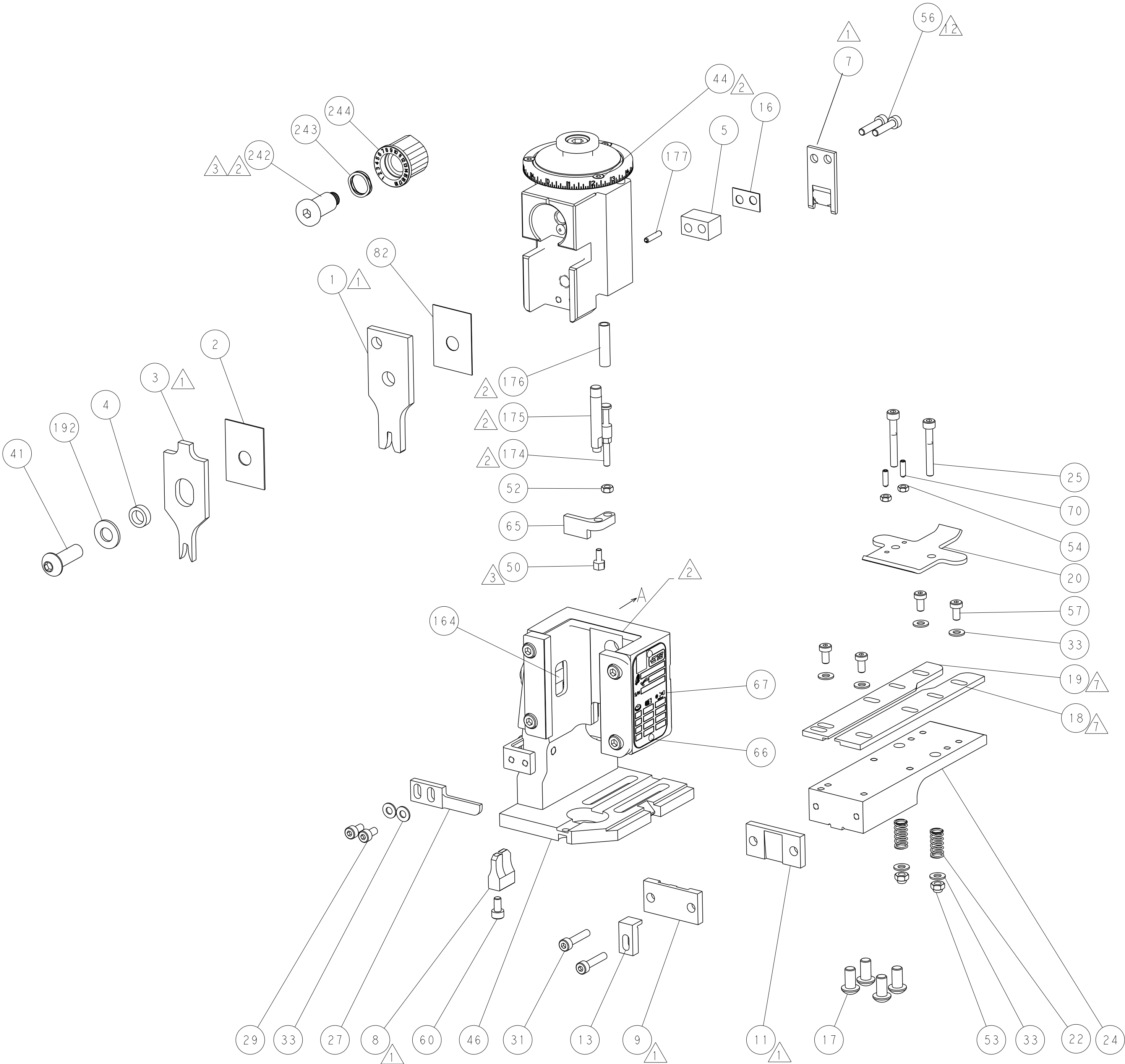
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CHK G. BAILEY 28NOV2012				APVD T. ELBIN 28NOV2012	NAME Ocean End Feed Applicator			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC				
		0 PLC ±	1 PLC ±	APPLICATION SPEC				
		2 PLC ±	3 PLC ±	SIZE				
		4 PLC ±	ANGLES ±	CAGE CODE				
MATERIAL		FINISH	WEIGHT	DRAWING NO				
-		-	-	RESTRICTED TO				
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 OF 4		
				REV C		REV C		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

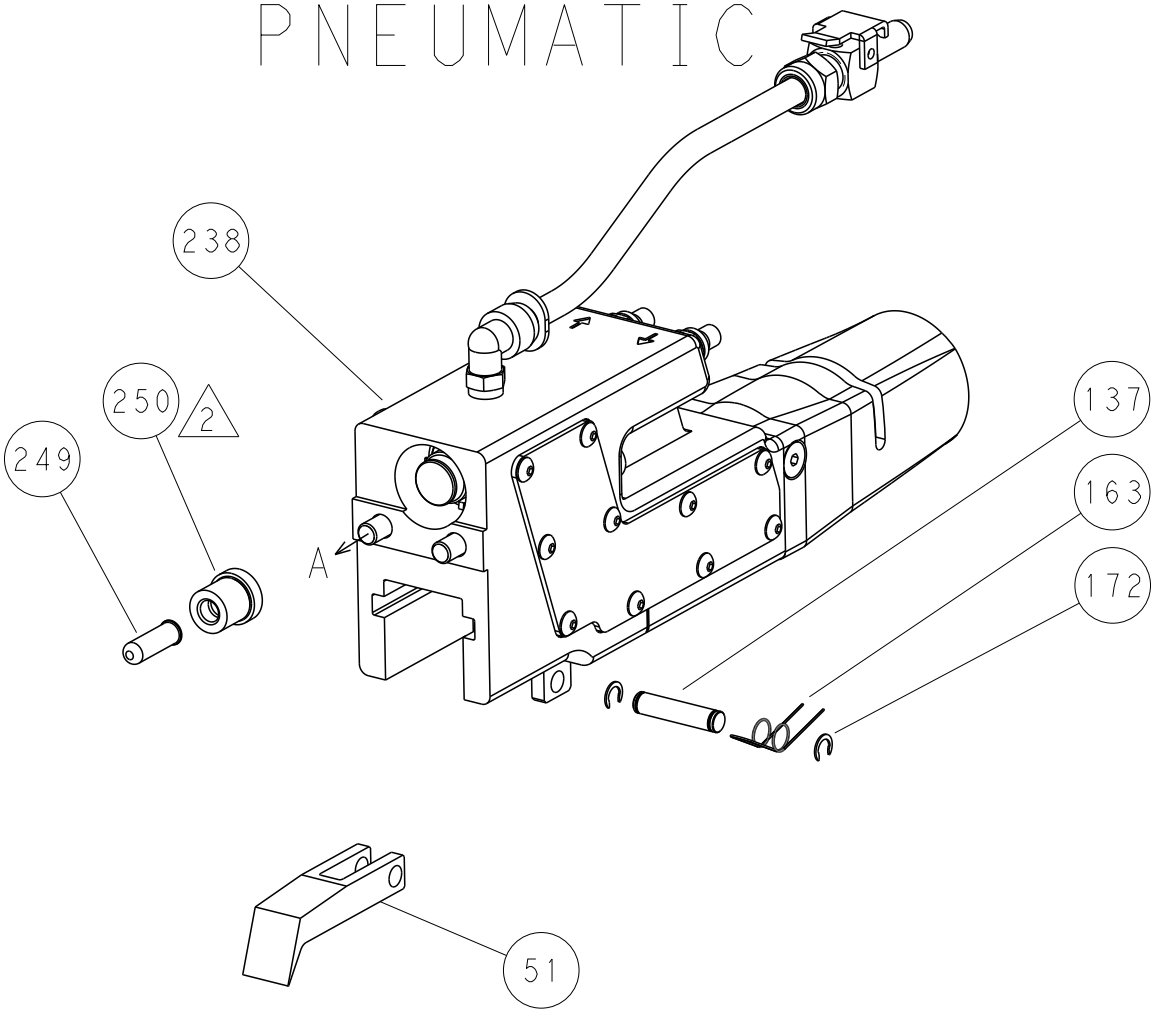
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



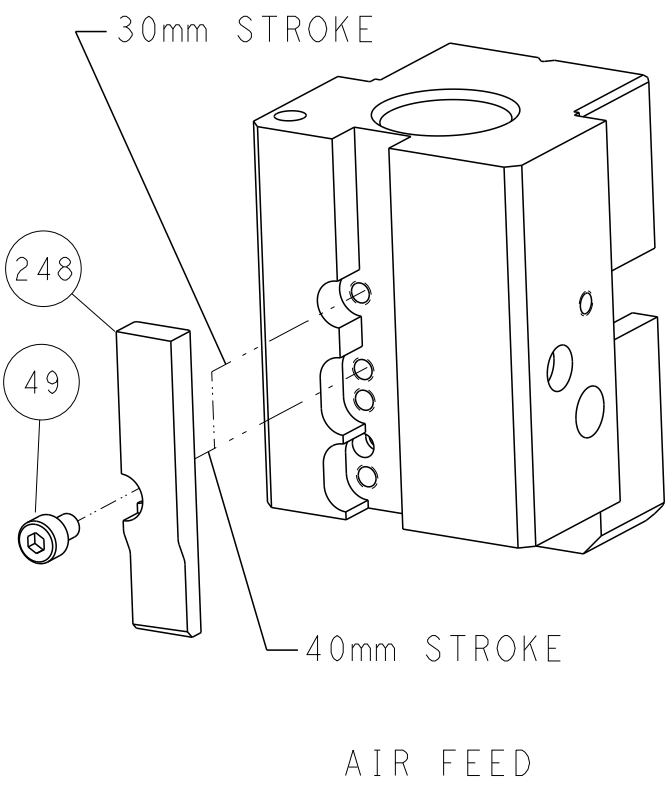
RAM AND HOLDDOWN SET-UP



FEED TYPE
PNEUMATIC



CAM POSITION

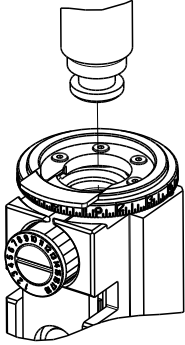


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

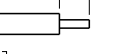
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				CHK G. BAILEY 28NOV2012	
				APVD T. ELBIN 28NOV2012	
				NAME	
				Product Spec	
				Application Spec	
				Size	
				Cage Code	
				Drawing No	
				RESTRICTED TO	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			
mm		0 PLC	±		
		1 PLC	±		
		2 PLC	±		
		3 PLC	±		
		4 PLC	±		
		ANGLES	±		
		FINISH	-		
MATERIAL	-	-	-	WEIGHT	-
				A1	00779
				C	2150299
Customer Accessible Production Drawing				SCALE	1:1
				SHEET	2
				OF	4
				REV	C

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COPYRIGHT 20			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150299-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150299-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.56 mm [.140]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.20-6.00 mm [.205-.236 IN]			Ø1.50-2.00 mm [.059-.079 IN]
TERMINAL APPLICATION SPECIFICATION		NONE	- -
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572432-1	25207.213.004	1572432-6	25207.123.009
1572432-2	25207.213.320	1572432-7	25207.213.011
1572432-3	25207.123.014	1572432-8	25207.122.XXX
1572432-4	25207.123.011	1572432-9	25207.212.179
1572432-5	25207.123.322	1572432-10	25207.411.131

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	4
1.00mm2		1.95+/-0.05 [.077+/- .002]		4.0	
0.75mm2		1.85+/-0.05 [.073+/- .002]		5.3	
0.50mm2		1.80+/-0.05 [.071+/- .002]		5.8	
0.35mm2		1.73+/-0.05 [.068+/- .002]		6.0	

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.00-6.00 mm [.197-.236 IN]			Ø1.30-2.10 mm [.051-.083 IN]
TERMINAL APPLICATION	LEAR DATA SHT 25209 REVISION 12	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949484-1	25209.123.009	1949484-3	25209.212.179
1949484-2	25209.123.011	1949484-4	25209.213.011

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	4
2x 0.50		1.90+/-0.05 [.075+/- .002]		4.5	
1.00mm2		1.80+/-0.05 [.071+/- .002]		5.8	
0.75mm2		1.75+/-0.05 [.069+/- .002]		6.3	
2x 0.35		1.70+/-0.05 [.067+/- .002]		6.7	
0.50mm2		1.70+/-0.05 [.067+/- .002]		6.7	



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- STRIP GUIDES ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

*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)

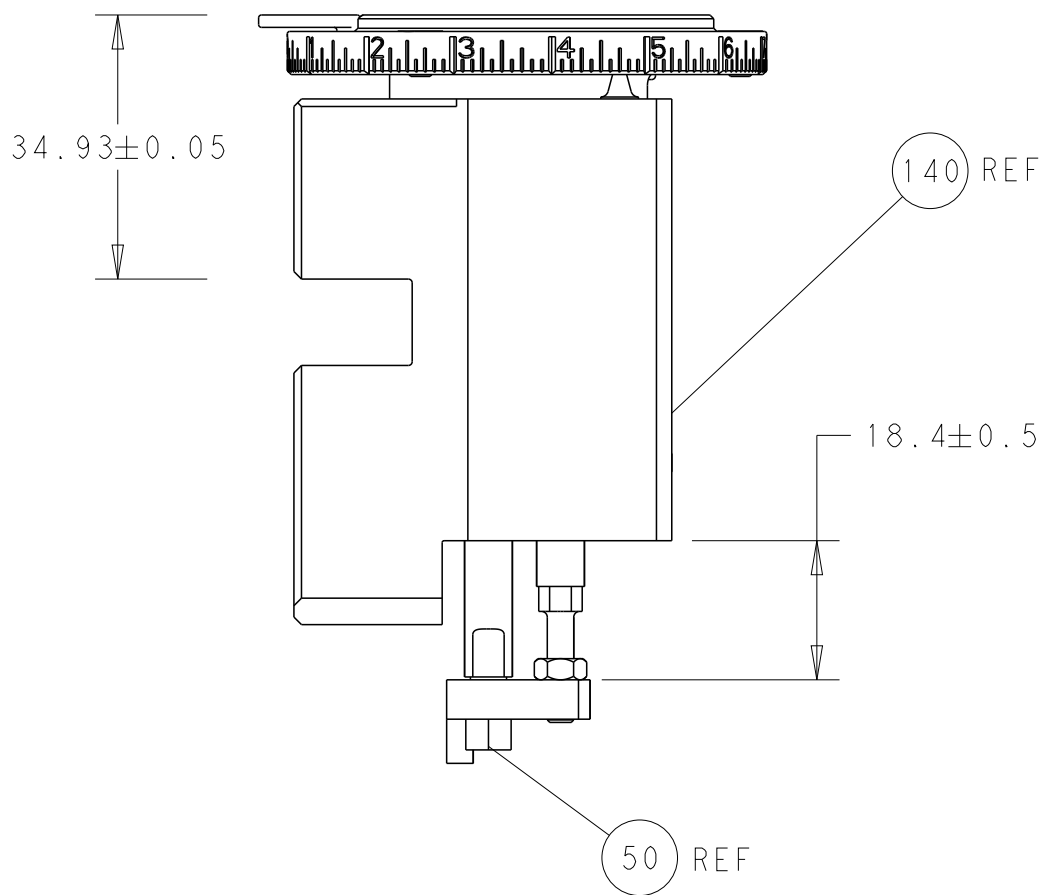
2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-2	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	455888-4	SPACER, CRIMPER	82
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2119792-2	PAWL, EF, AIR	51
-	1	1752354-1	STANDOFF,HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	1	6-240641-6	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-4	PLATE, FRONT SHEAR	9
1	1	2-1803000-3	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-6	SPACER	5
-	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-6	SPACER, CRIMPER	2
1	1	4-1633664-7	CRIMPER, WIRE	1
-77-22	PART NO		DESCRIPTION	ITEM NO

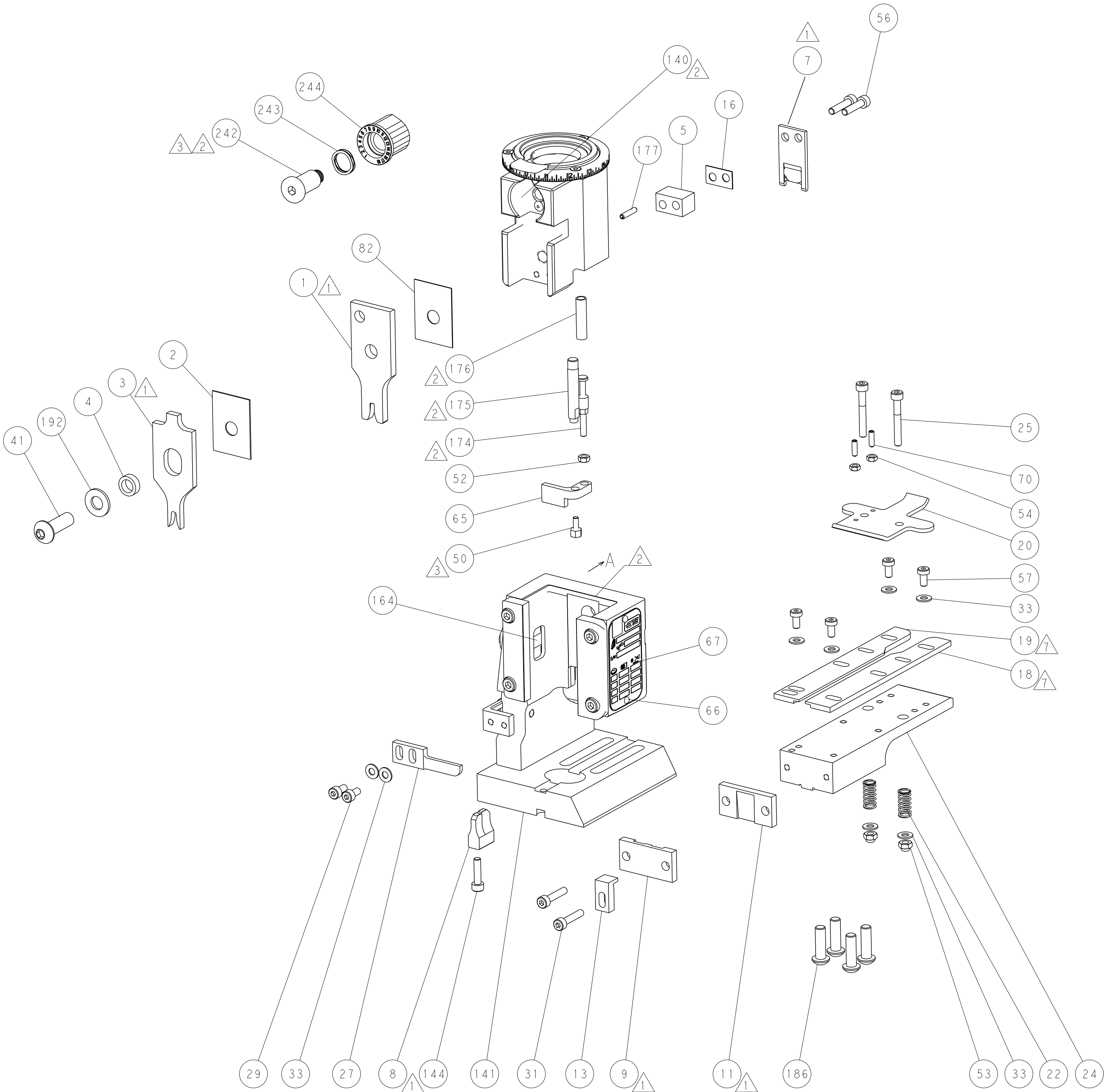
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CHK G. BAILEY 28NOV2012				NAME	Ocean End Feed Applicator			
APVD T. ELBIN 28NOV2012				PRODUCT SPEC				
APPLICATION SPEC				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
MATERIAL				WEIGHT	A1 00779		C=2150299	
Customer Accessible Production Drawing				SCALE	1:1		SHEET 3 OF 4	REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

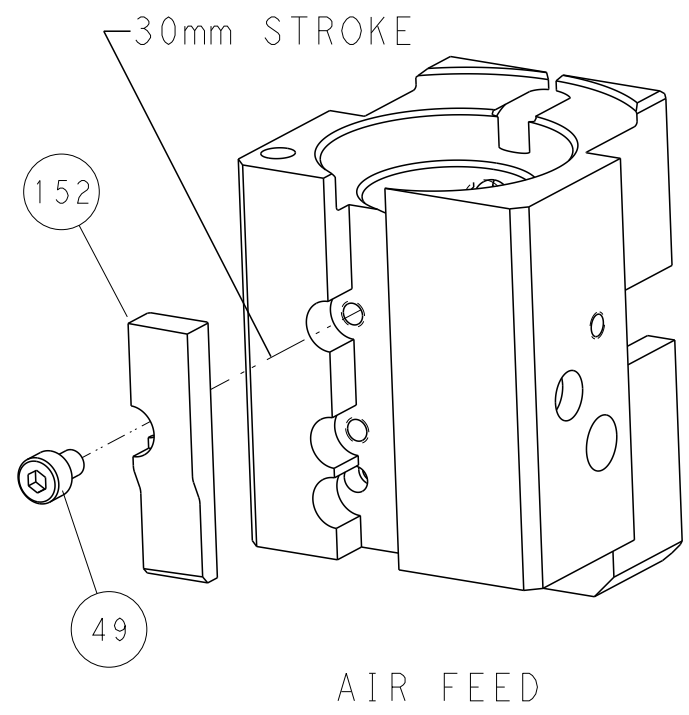
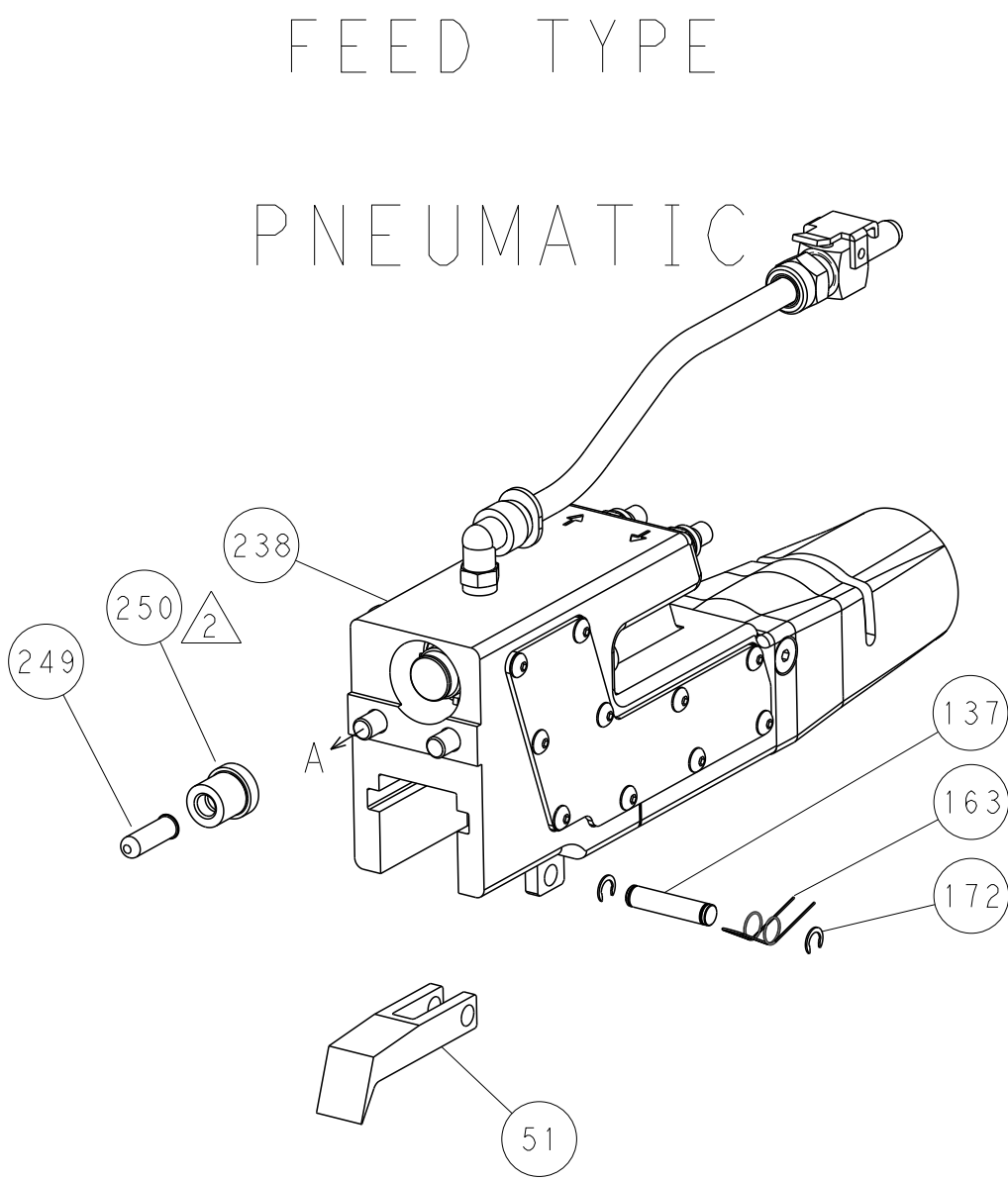
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



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



AIR FEED

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		CHK	G. BAILEY	28NOV2012							
		APVD	T. ELBIN	28NOV2012							
DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:			NAME	Ocean End Feed Applicator					
mm		0. PLC	±							PRODUCT SPEC	
		1. PLC	±								APPLICATION SPEC
		2. PLC	±								
		3. PLC	±		CASE CODE						
		4. PLC	±			DRAWING NO.					
		ANGLES	±				RESTRICTED TO				
		FINISH	-					A 00779 C=2150299			
MATERIAL	-	WEIGHT	-		Customer Accessible Production Drawing						
	-		-			SCALE 1:1					
							SHEET 4 of 4				
								REV C			