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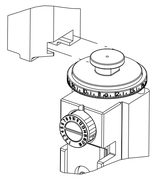
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	P	ECR-19-006524	23APR2019	TB	GB
	P1	ECR-20-008874	22JUN2020	JWC	GB
	R	ECR-21-005935	01JUN2021	FJ	TE
	R1	ECR-22-148911	10AUG2022	FZ	JAH

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150289-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150289-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150289-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150289-2	R	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150289-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: BERG TERMINAL		BERG CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL, MINI PV		
WIRE STRIP LENGTH 3.76-4.27 mm [.148-.168 IN]		INSULATION DIAMETER RANGE ∅0.91-2.62 mm [.036-.103 IN]
TERMINAL APPLICATION SPECIFICATION	BERG	- -
	-	- -

TERMINALS APPLIED

TE TERMINAL	BERG TERMINAL	TE TERMINAL	BERG TERMINAL
286512-1	47649-000(LF)	1-1572173-1	48049-001(LF)
286512-2	47565-000(LF)	1572173-6	48049-000(LF)
286512-3	47565-001(LF)	1572173-7	48049-002(LF)
286512-4	47565-002(LF)	1-356085-5	48245-001(LF)
286512-5	48051-000(LF)	356085-1	47439-000(LF)
286512-6	48051-002(LF)	356085-2	47439-001(LF)
286512-7	48248-000(LF)	356085-3	47439-002(LF)
286512-8	48248-002(LF)	1-356085-6	47216-002(LF)
1572173-1	47457-000(LF)	356085-5	48245-000(LF)
1572173-2	47457-001(LF)	356085-6	48245-002(LF)
1572173-3	47457-002(LF)	356085-7	48046-000(LF)
1572173-4	48242-000(LF)	356085-8	48046-002(LF)
286512-9	47649-001(LF)	356085-9	47216-000(LF)
1-286512-0	47649-002(LF)	1-356085-0	47216-001(LF)
1-286512-1	48051-001(LF)	1-356085-1	48046-001(LF)
1-286512-2	48248-001(LF)	1-356085-2	75691-004
1572173-9	48242-001(LF)	1-356085-3	75691-005
1-1572173-0	48242-002(LF)	1-356085-4	75691-006

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4
22 AWG	0.86+/-0.03 [.034+/-.001]	8.8
24 AWG	0.84+/-0.03 [.033+/-.001]	9.0
26 AWG	0.81+/-0.03 [.032+/-.001]	9.2

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 ITEM 50. 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. 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)

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	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
3 -	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	6-993111-6	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	455888-1	SPACER, CRIMPER	82
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1	1	1-2119791-8	DEPRESSOR, WIRE	73
-	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	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	2-1901681-8	HOLDDOWN, TERMINAL	65
-	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
-	4	4	4	4	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	-	2063961-1	FEED FINGER	51
3 -	1	1	1	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	240639-2	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
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	1	1	1	1	4-1901696-9	STRIP GUIDE, REAR	19
-	1	1	1	1	5-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1 -	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	2-240645-7	SPACER, SHEAR PLATE	10
1 -	1	1	1	1	1-240642-1	PLATE, FRONT SHEAR	9
1	2	2	1	1	1803042-3	ANVIL, COMBINATION	8
1 -	1	1	1	1	8-240651-6	BLADE, SLUG	7
-	1	1	1	1	3-240641-4	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	7-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1803087-4	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1 PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±, 1 PLC ±, 2 PLC ±, 3 PLC ±, 4 PLC ±, ANGLES ±
MATERIAL -
FINISH -

DWN	C.CHEN	20SEP2012
CHK	S.XI	20SEP2012
APVD	I.CRUZ	20SEP2012

PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150289	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 1 OF 4 | REV R1

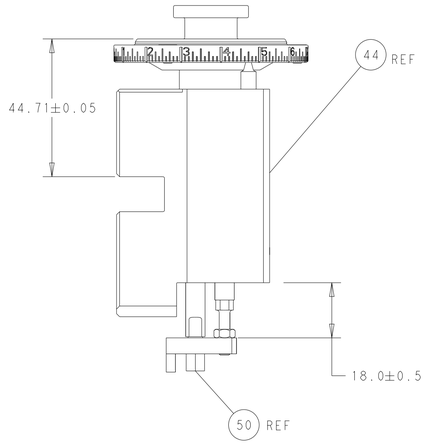
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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LOC	DIST
A	66

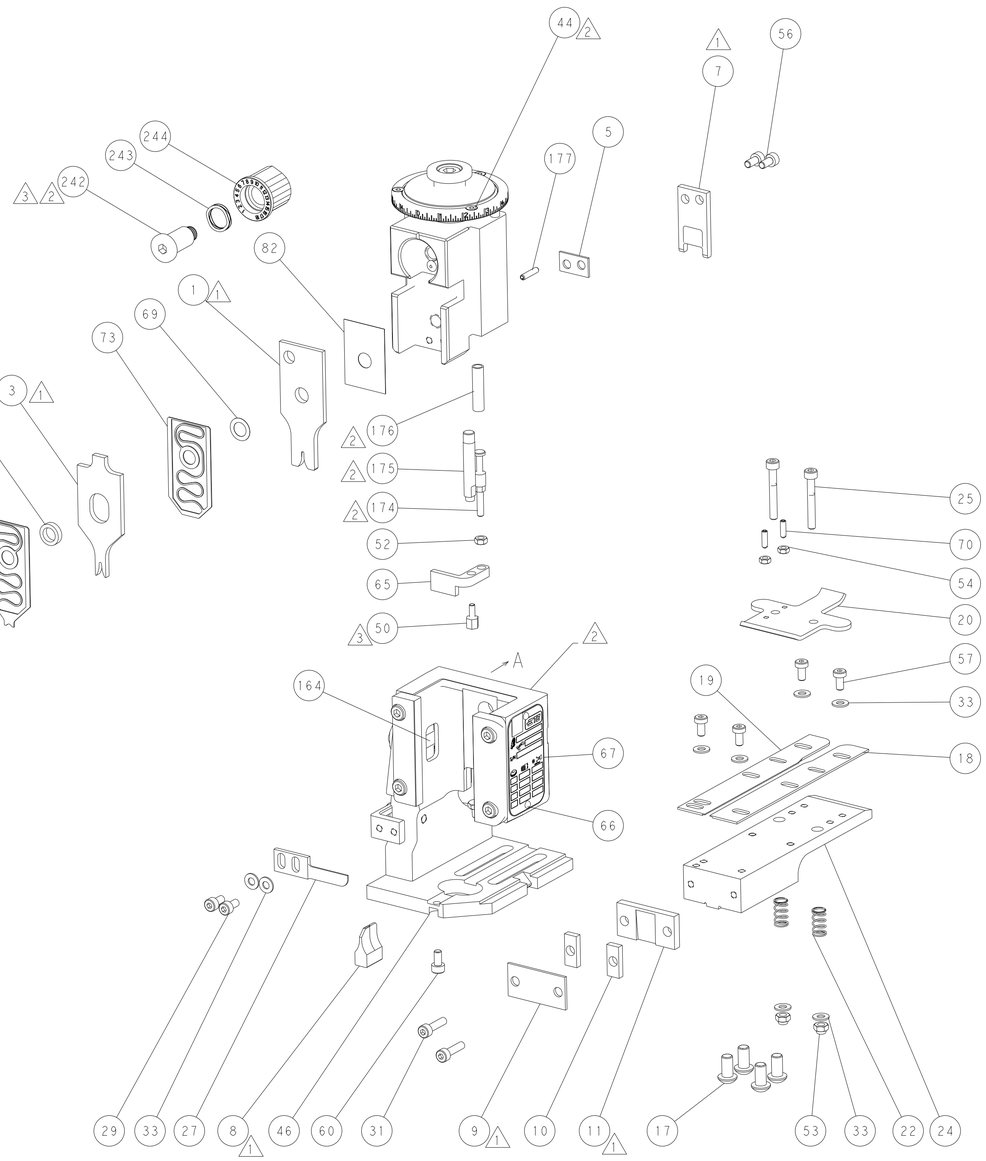
REVISIONS

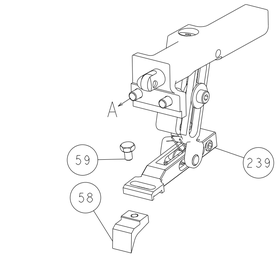
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-



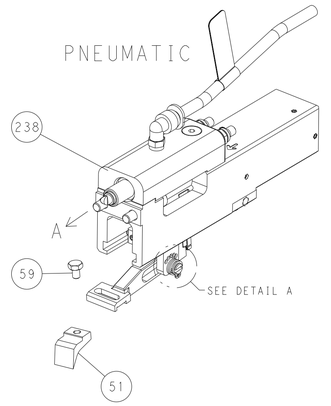
RAM AND HOLDDOWN SET-UP

FEED TYPE MECHANICAL

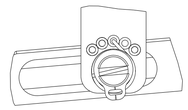




PNEUMATIC

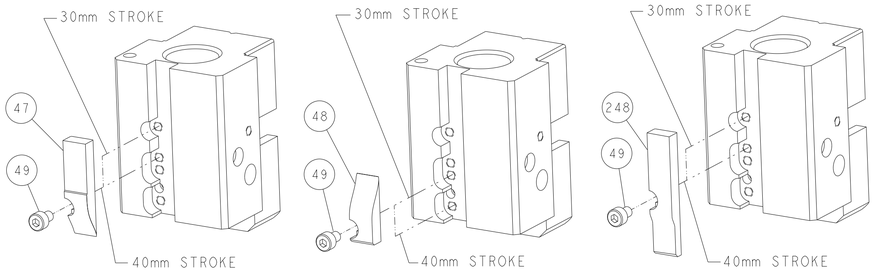


FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL -
FINISH -

DWN C.CHEN 20SEP2012
CHK S.XI 20SEP2012
APVD I.CRUZ 20SEP2012
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150289	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 2 OF 4 | REV R1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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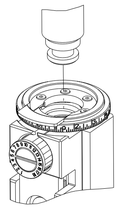
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150289-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150289-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150289-7	L	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: BERG TERMINAL		BERG CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL, MINI PV		
WIRE STRIP LENGTH 3.76-4.27 mm [.148-.168 IN]		INSULATION DIAMETER RANGE ∅0.91-2.62 mm [.036-.103 IN]
TERMINAL APPLICATION SPECIFICATION	BERG	- -
	-	- -

TERMINALS APPLIED

TE TERMINAL	BERG TERMINAL	TE TERMINAL	BERG TERMINAL
286512-1	47649-000(LF)	1-1572173-1	48049-001(LF)
286512-2	47565-000(LF)	1572173-6	48049-000(LF)
286512-3	47565-001(LF)	1572173-7	48049-002(LF)
286512-4	47565-002(LF)	1-356085-5	48245-001(LF)
286512-5	48051-000(LF)	356085-1	47439-000(LF)
286512-6	48051-002(LF)	356085-2	47439-001(LF)
286512-7	48248-000(LF)	356085-3	47439-002(LF)
286512-8	48248-002(LF)	1-356085-6	47216-002(LF)
1572173-1	47457-000(LF)	356085-5	48245-000(LF)
1572173-2	47457-001(LF)	356085-6	48245-002(LF)
1572173-3	47457-002(LF)	356085-7	48046-000(LF)
1572173-4	48242-000(LF)	356085-8	48046-002(LF)
286512-9	47649-001(LF)	356085-9	47216-000(LF)
1-286512-0	47649-002(LF)	1-356085-0	47216-001(LF)
1-286512-1	48051-001(LF)	1-356085-1	48046-001(LF)
1-286512-2	48248-001(LF)	1-356085-2	75691-004
1572173-9	48242-001(LF)	1-356085-3	75691-005
1-1572173-0	48242-002(LF)	1-356085-4	75691-006

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT △4 REFERENCE SETTING
22 AWG	0.86+/-0.03 [.034+/-.001]	8.8
24 AWG	0.84+/-0.03 [.033+/-.001]	9.0
26 AWG	0.81+/-0.03 [.032+/-.001]	9.2

△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 ITEM 50. 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. 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)

			-77-22-21 PART NO	DESCRIPTION	ITEM NO
-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△3 -	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	455888-1	SPACER, CRIMPER	82
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1-2119791-8	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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	2-1901681-8	HOLDDOWN, TERMINAL	65
-	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	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	-	2063961-1	FEED FINGER	51
△3 -	1	1	1752354-7	STANDOFF,HOLD-DOWN	50
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-2	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	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	4-1901696-9	STRIP GUIDE, REAR	19
-	1	1	5-1901695-0	STRIP GUIDE, FRONT	18
△1 -	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2-240645-7	SPACER, SHEAR PLATE	10
△1 -	1	1	1-240642-1	PLATE, FRONT SHEAR	9
△1 1	1	1	1803042-3	ANVIL, COMBINATION	8
△1 -	1	1	8-240651-6	BLADE, SLUG	7
-	1	1	3-240641-4	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△1 1	1	1	7-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	2
△1 1	1	1	1803087-4	CRIMPER, WIRE	1

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±-

MATERIAL - -
FINISH - -

DWN C CHEN	20SEP2012	TE Connectivity Harrisburg, PA 17105-3608
CHK S XI	20SEP2012	
APVD I CRUZ	20SEP2012	NAME Ocean End Feed Applicator -
PRODUCT SPEC -		
APPLICATION SPEC -		SIZE A1 · CAGE CODE 00779 · DRAWING NO C-2150289 · RESTRICTED TO -
WEIGHT -		Customer Accessible Production Drawing · SCALE 1:1 · SHEET 3 OF 4 · REV R1

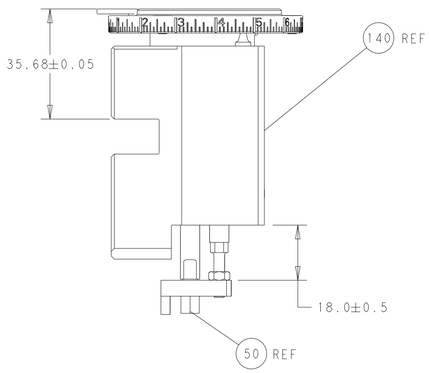
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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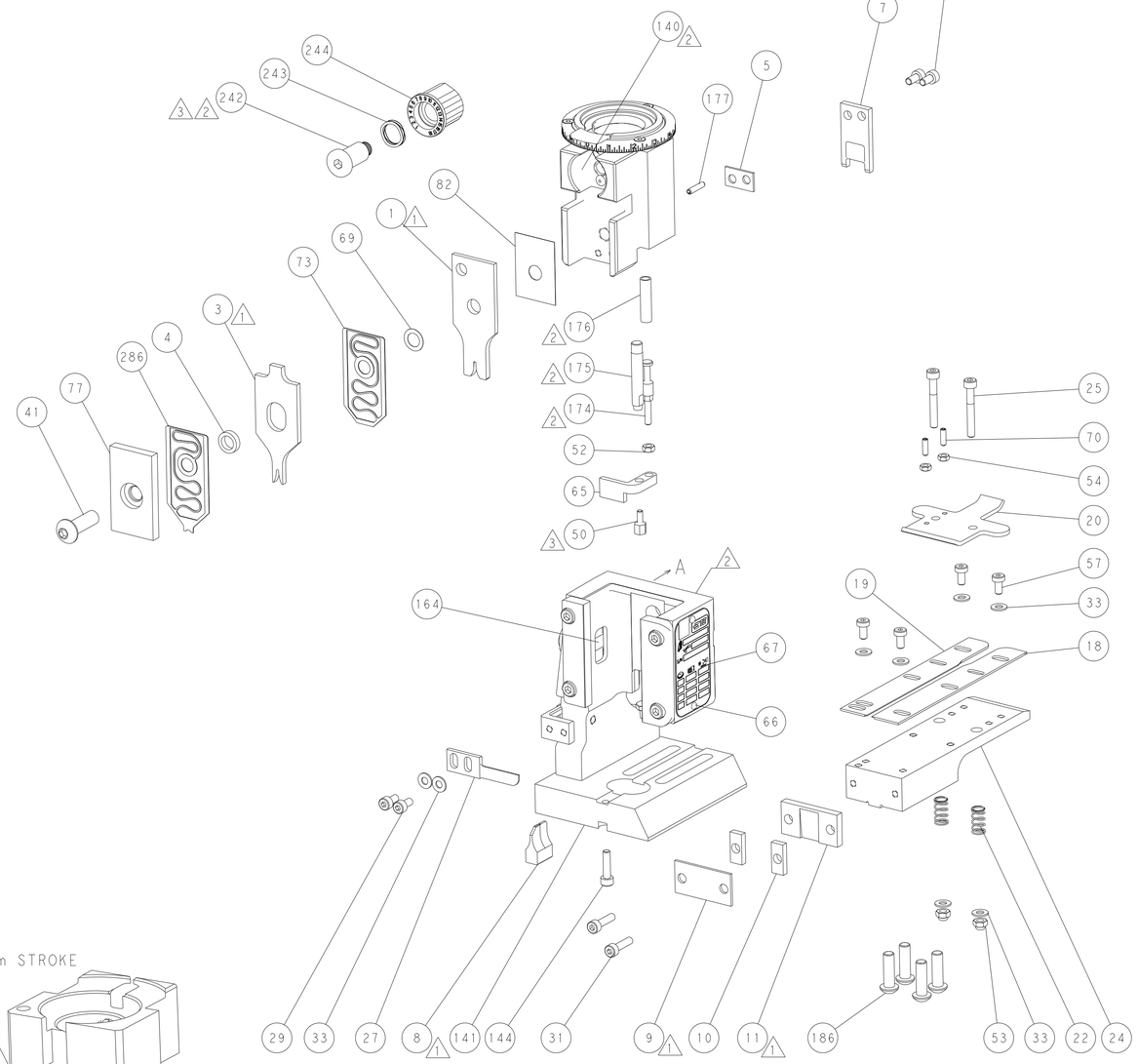
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

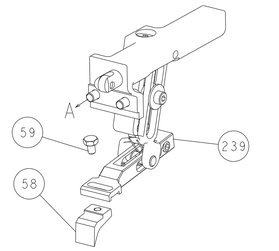


RAM AND HOLDDOWN SET-UP

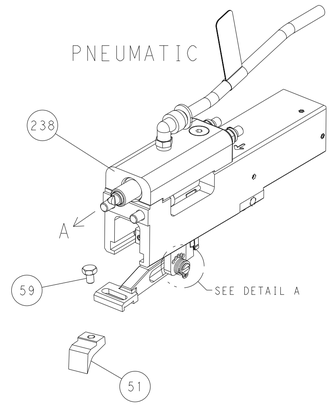


FEED TYPE

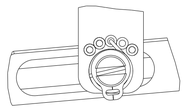
MECHANICAL



PNEUMATIC

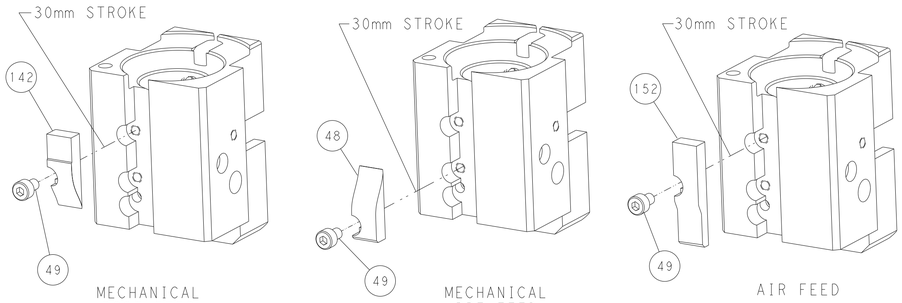


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



PACIFIC VERSION

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

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DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±-
MATERIAL - -
FINISH - -

DWN	C CHEN	20SEP2012
CHK	S XI	20SEP2012
APVD	I CRUZ	20SEP2012
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150289	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4 | REV R1

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