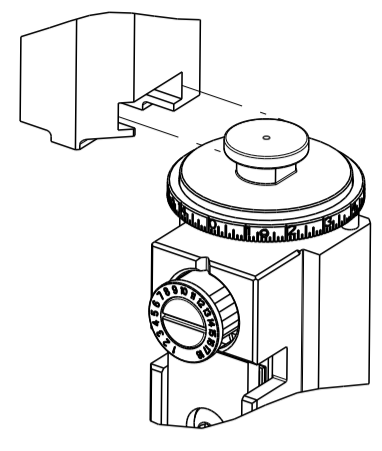


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150072-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150072-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150072-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150072-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F

APPL INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .187 SERIES RECEPTACLE FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.16 mm [.173-.203 IN]	Ø1.02-1.78 mm [.040-.070 IN]

TERMINAL APPLICATION SPECIFICATION 114-2036

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
342368-1	60573-1	62181-1	
342368-2	60573-2	62187-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.22 +/- 0.05 [.048 +/- .002]	4.8
22 AWG	1.09 +/- 0.05 [.043 +/- .002]	6.4
24 AWG	1.02 +/- 0.05 [.040 +/- .002]	7.2

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.

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

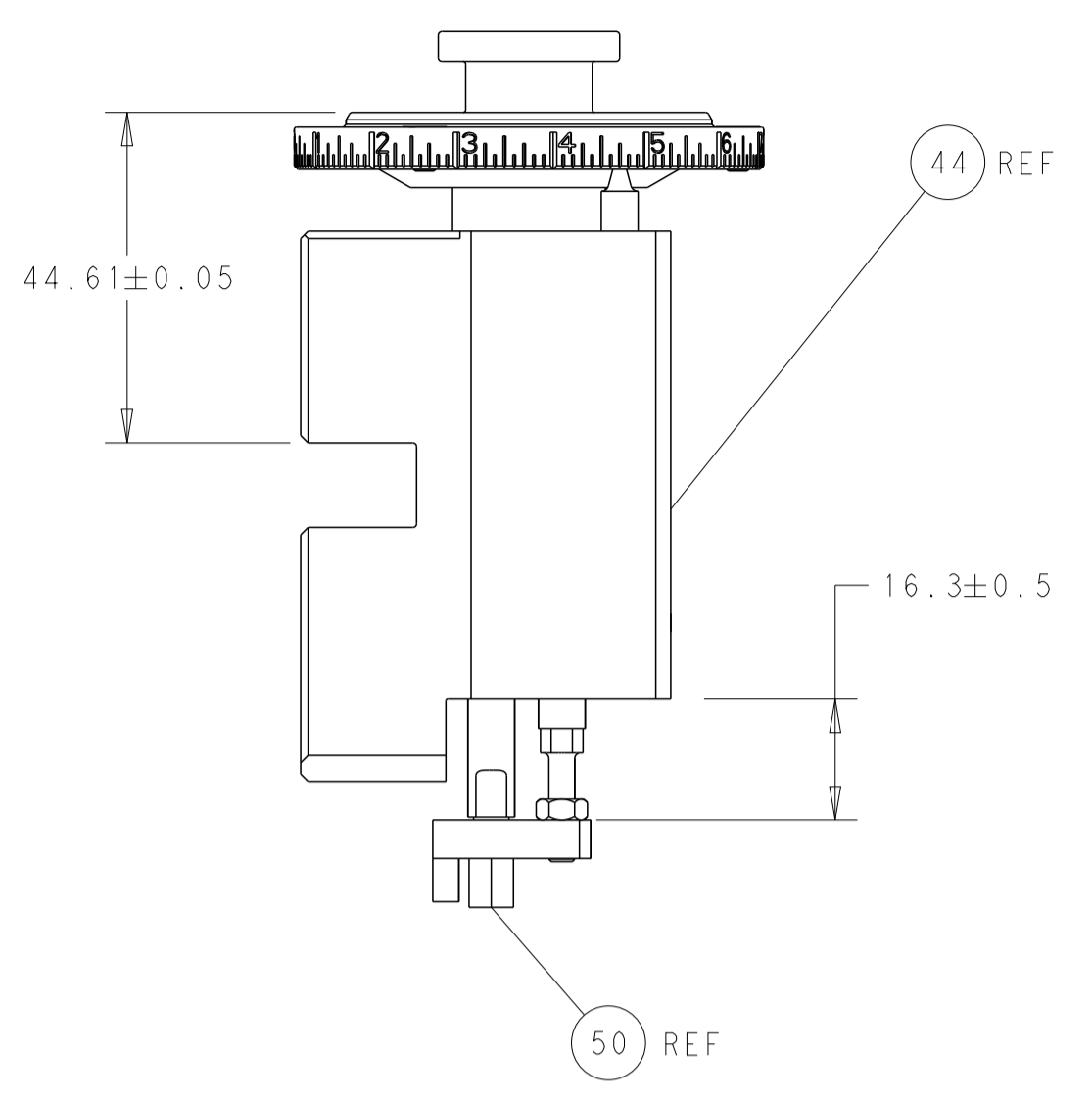
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			1		DEVELOPMENT	16JAN2013	YY	SX
			A		RELEASED	12APR2013	YY	UG
			B		ECR-18-015273	25SEP2018	TB	TE

-	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	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	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	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	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	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	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-2	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	
-	1	1	1	1	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	-	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	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	-	2119792-2	PAWL, EF, AIR	51	
3	-	1	1	1	1-1752354-1	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	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-3	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-9	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	1901259-3	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	4-240641-9	SPACER	16	
1	-	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	4-690495-7	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1333213-4	ANVIL, COMBINATION	8	
1	-	1	1	1	4-690474-1	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456402-6	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS A PRELIMINARY DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. DIMENSIONS SHOULD BE COMPARED TO THE LATEST REVISION.

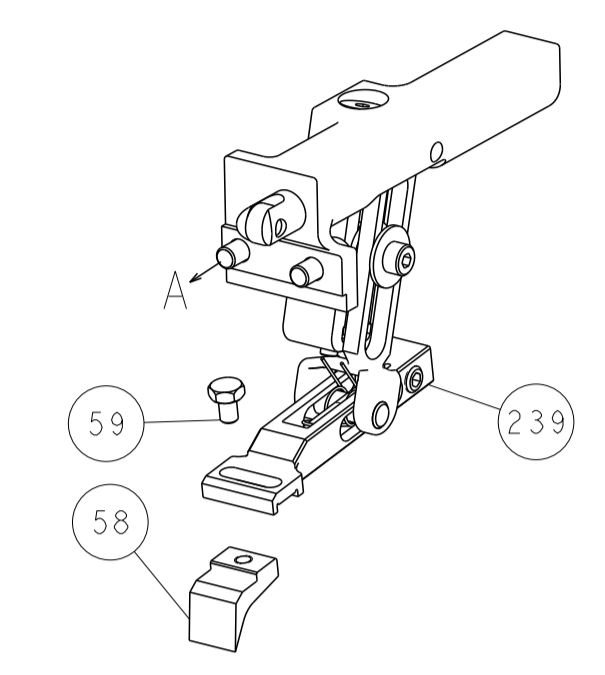
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	16JAN2012	TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	CHK	Y. YIN		
	1 PLC ±	APVD	G. BAILEY		
	2 PLC ±	DATE	16JAN2012		
	3 PLC ±	NAME	Ocean End Feed Applicator		
	4 PLC ±	PRODUCT SPEC			
	ANGLES ±	APPLICATION SPEC			
MATERIAL	FINISH	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
		WT	A1	00779	©=2150072
Customer Accessible Production Drawing			SCALE	1:1	SHEET 1 OF 4

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

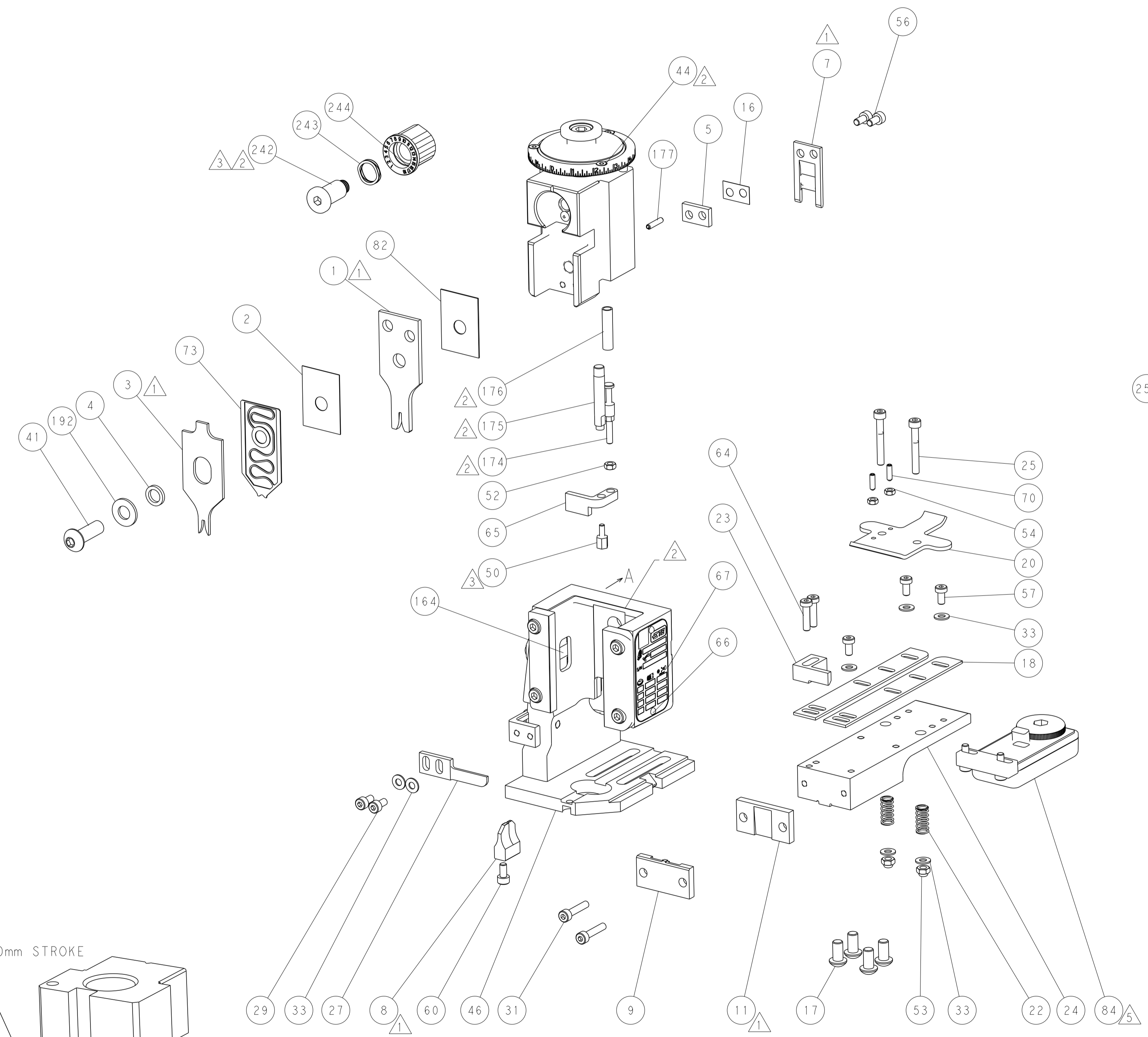
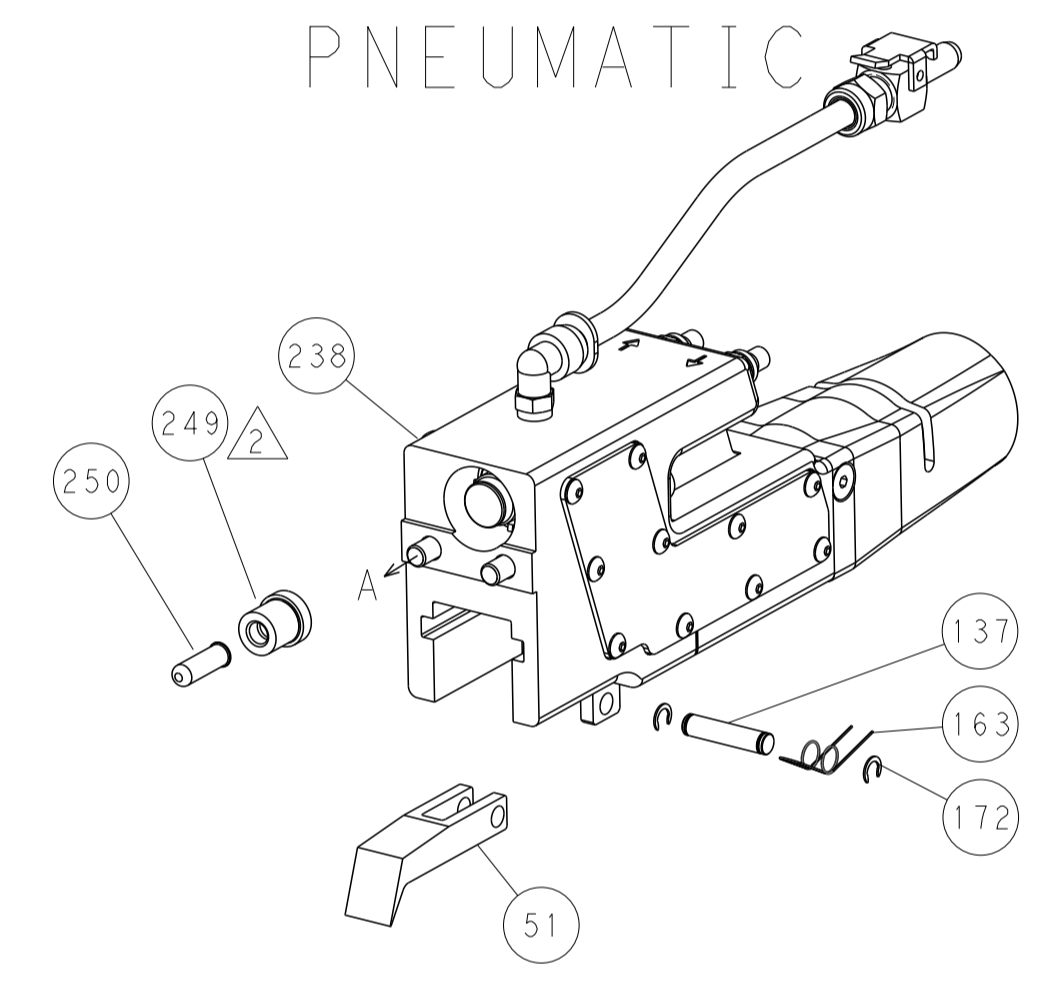


RAM AND HOLDDOWN SET-UP

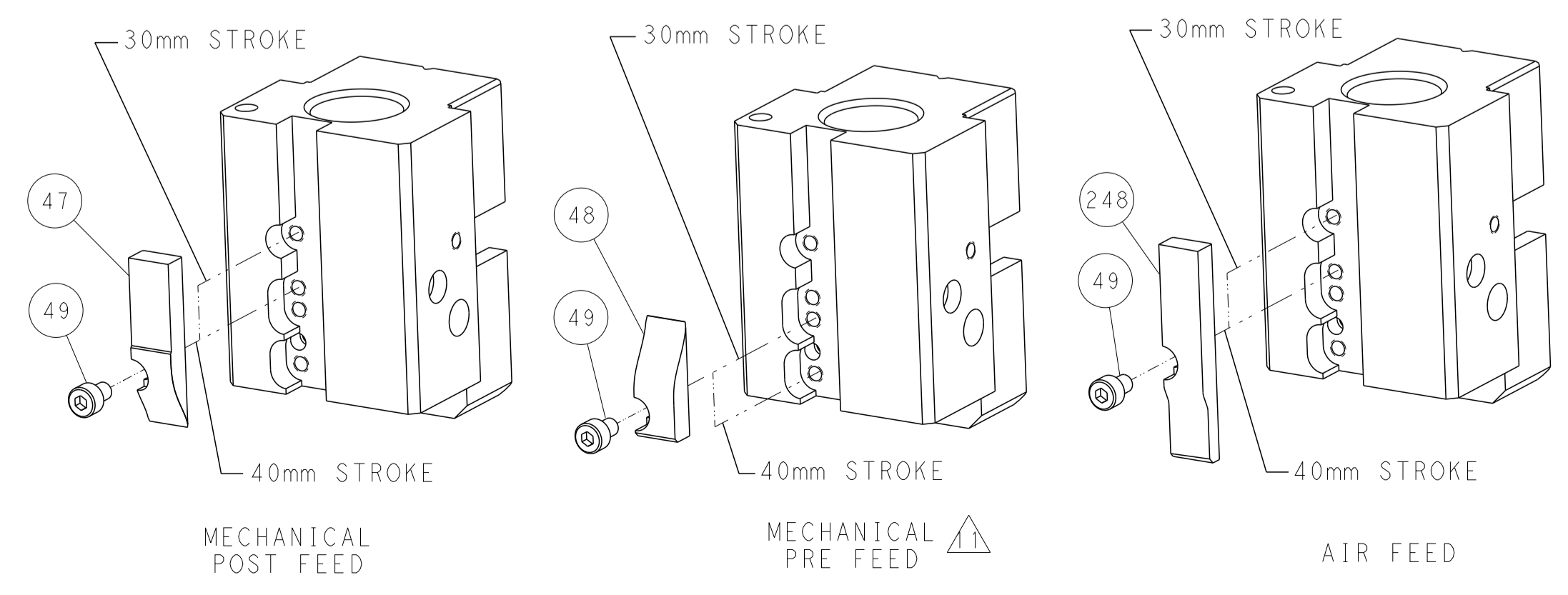
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

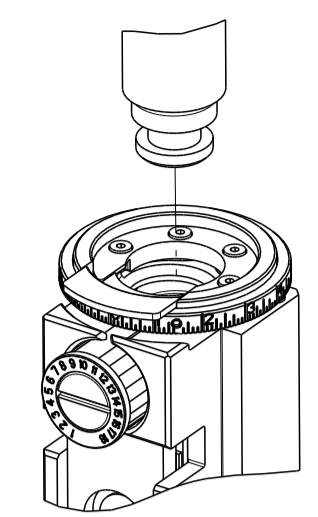


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 16JAN2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 16JAN2012		NAME: Ocean End Feed Applicator	
				APVD: S. XI 16JAN2012		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2150072	
				WEIGHT:		SCALE: 1:1	
				Customer Accessible Production Drawing		SHEET 2 OF 4	
						REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150072-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150072-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F

APPL INSTRUCTIONS
 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .187 SERIES RECEPTACLE FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.16 mm [.173-.203 IN]	1.02-1.78 mm [.040-.070 IN]

TERMINAL APPLICATION SPECIFICATION 114-2036

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
342368-1	60573-1	62181-1	
342368-2	60573-2	62187-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.22+/-0.05 [.048+/- .002]	4.8
22 AWG	1.09+/-0.05 [.043+/- .002]	6.4
24 AWG	1.02+/-0.05 [.040+/- .002]	7.2

- 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 LUBRICANT IS RECOMMENDED.
- 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.

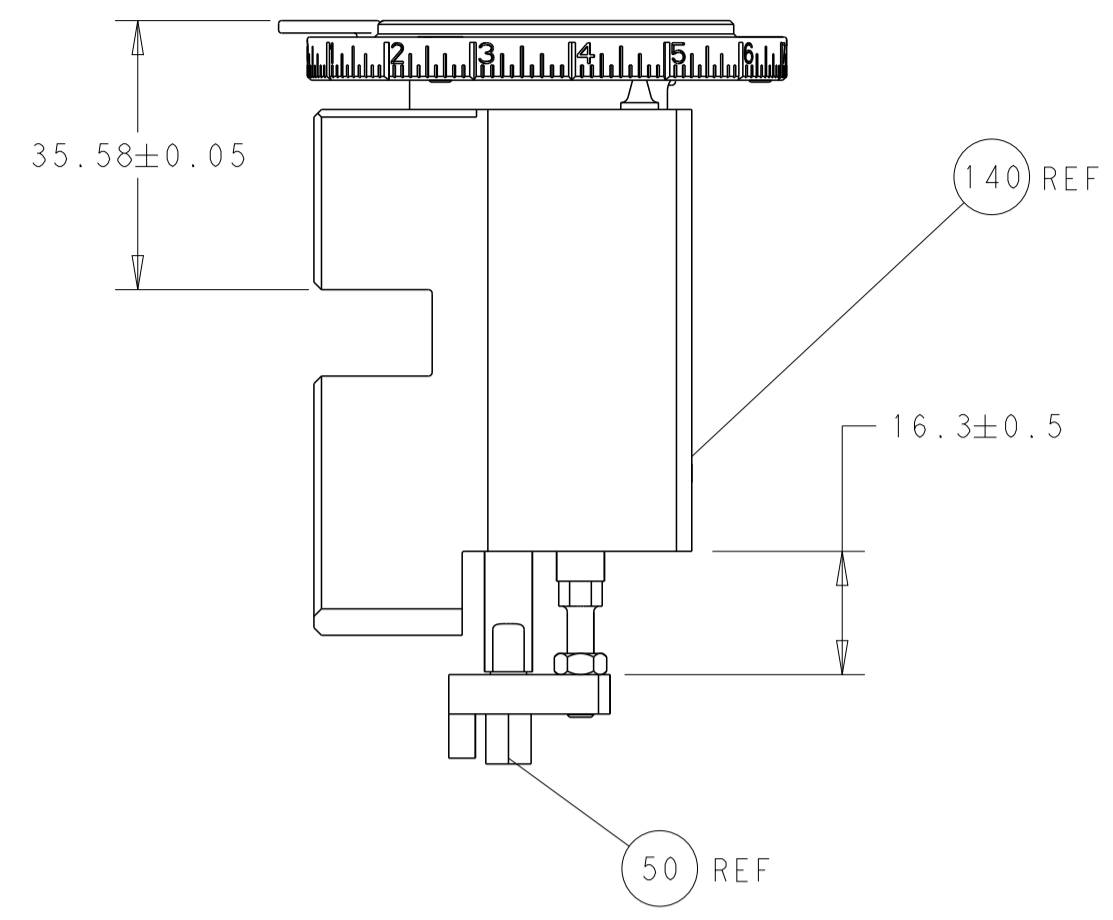
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-		SEE SHEET 1			

-	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1803259-1	BUSHING, FLANGED	249	
-	1	1	2119082-8	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	
-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	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	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	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	-	2119792-2	PAWL, EF, AIR	51	
3	-	1	1-1752354-1	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	
-	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	240639-3	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-3	GUIDE, LOWER STRIP	18	
-	1	1	4-240641-9	SPACER	16	
1	-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	4-690495-7	PLATE, FRONT SHEAR	9	
1	1	1	1333213-4	ANVIL, COMBINATION	8	
1	-	1	4-690474-1	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-5	SPACER	5	
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
1	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	1-456402-6	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

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

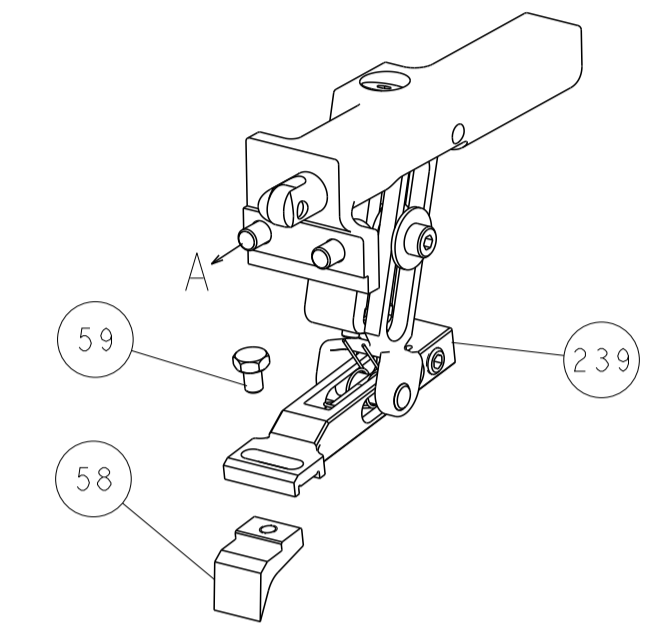
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	16 JAN 2012	CHK	16 JAN 2012
	3 PLC ±	4 PLC ±	ANGLES ±	G. BAILEY		APVD	16 JAN 2012
MATERIAL	FINISH	WEIGHT	SCALE	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150072 RESTRICTED TO: Customer Accessible Production Drawing			

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

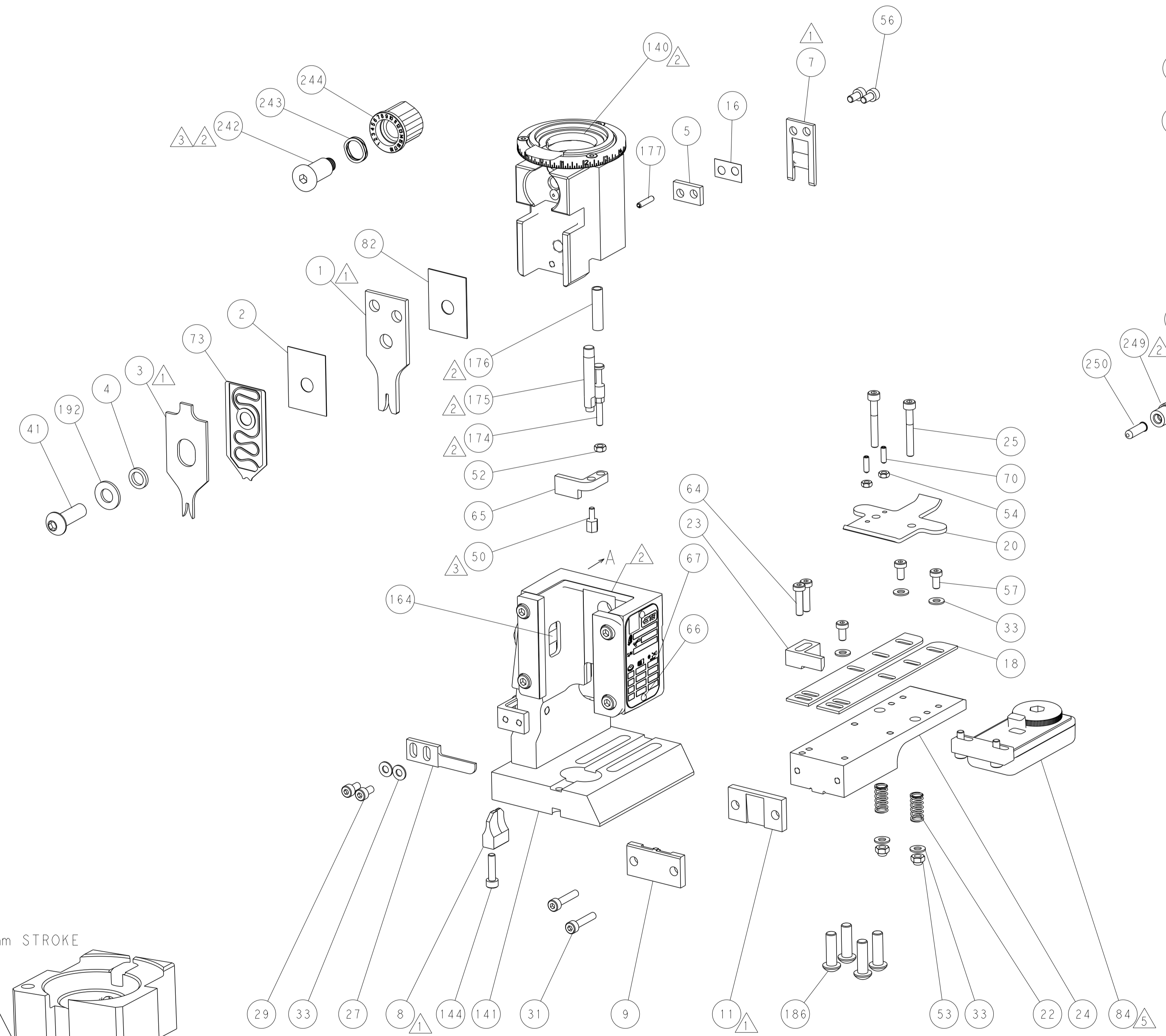
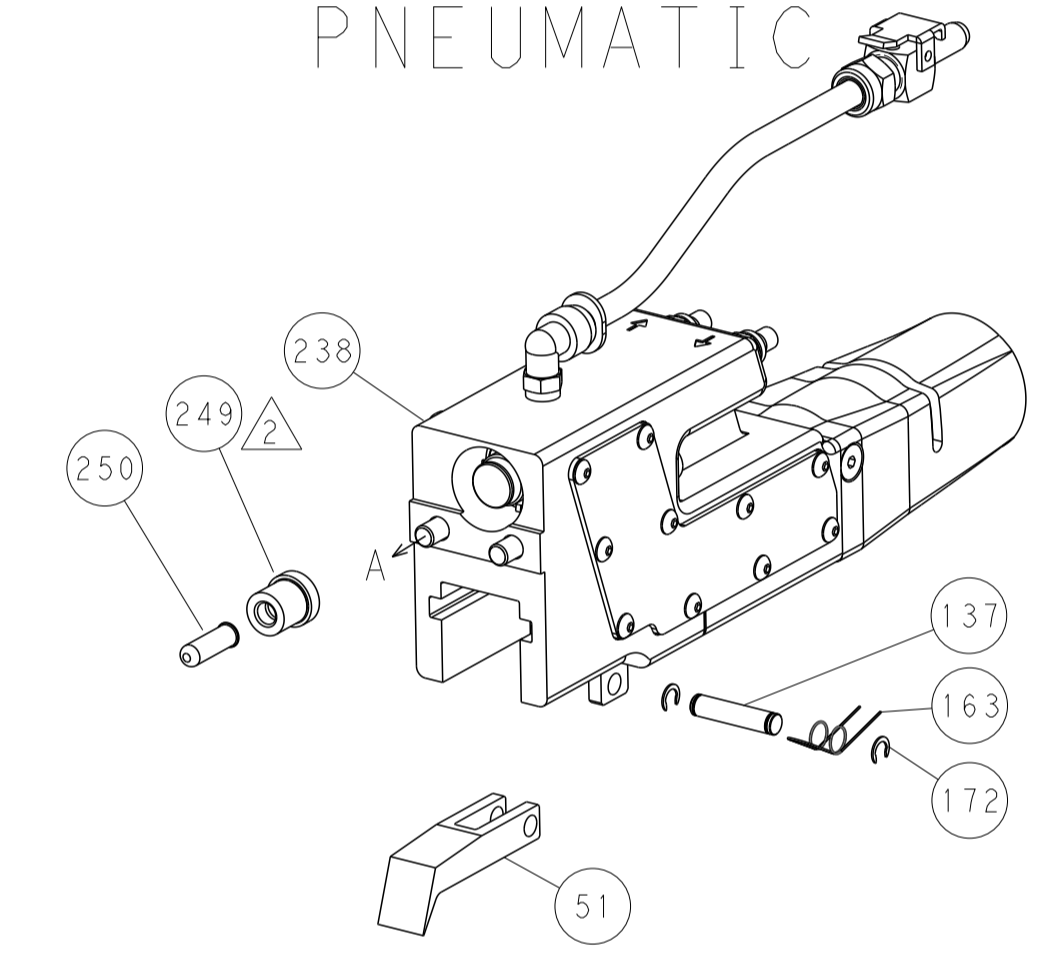


RAM AND HOLDDOWN SET-UP

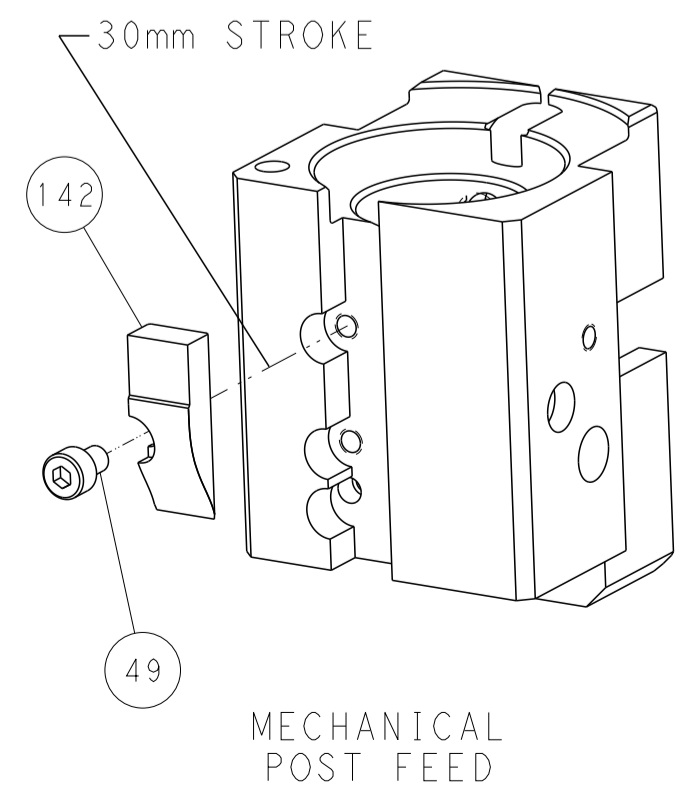
FEED TYPE
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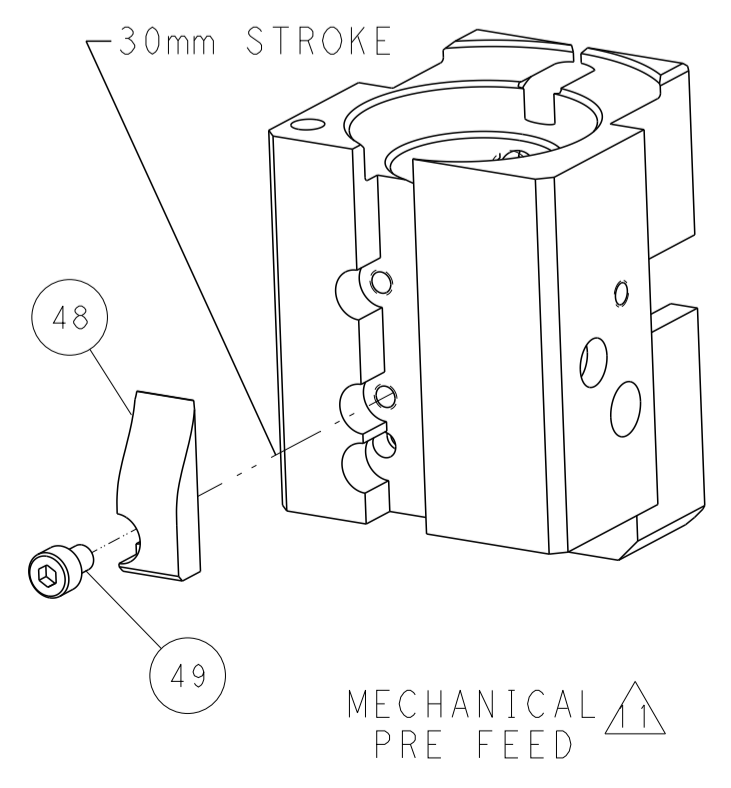
PNEUMATIC



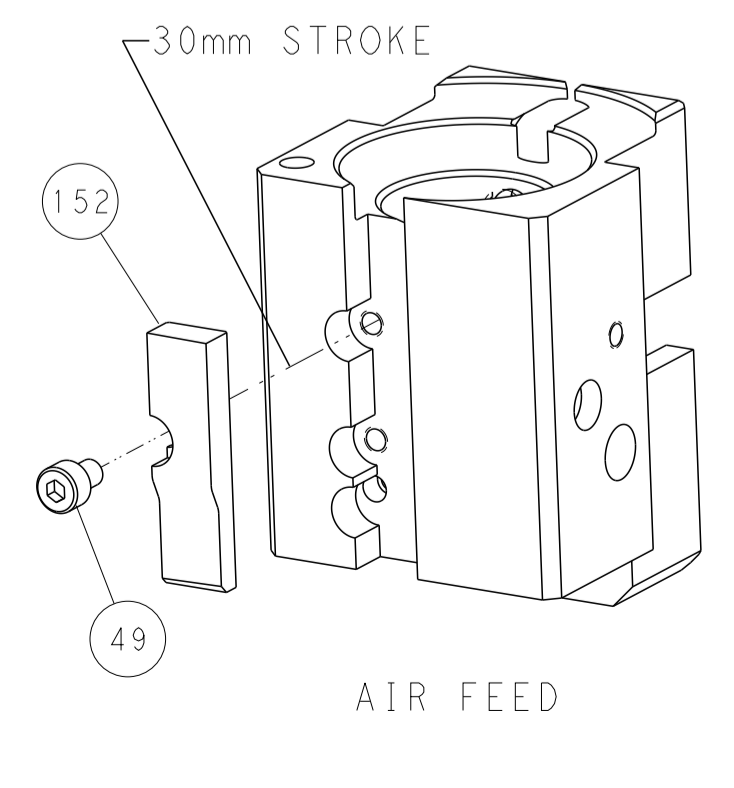
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN Y. YIN 16JAN2012 CHK G. BAILEY 16JAN2012 APVD S. XI 16JAN2012		NAME Ocean End Feed Applier	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150072		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV B	