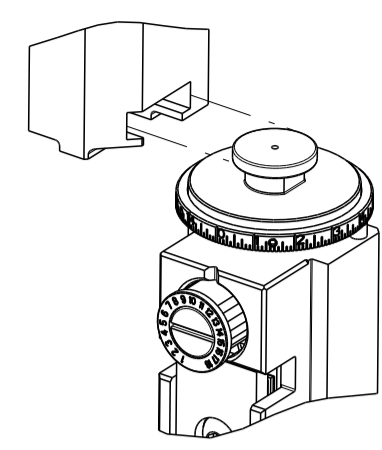


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150397-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150397-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150397-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150397-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150397-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON FLAG .187 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.39-5.16 mm [.173-.203 IN]	Ø1.52-2.79 mm [.060-.110 IN]

TERMINAL APPLICATION SPECIFICATION 114-2079

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742086-1	1742086-2	1742087-1	1742087-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27 +/- 0.05 [.050 +/- .002]	4.7
20 AWG	1.14 +/- 0.05 [.045 +/- .002]	6.2
22 AWG	1.06 +/- 0.05 [.042 +/- .002]	7.1

- 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.
  - TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC: A DIST: 66

REV	DATE	BY	CHKD
A	14FEB2014	BH	TE
A1	17JUL2015	KH	UG
B	11APR2016	RK	GB
C	30JUN2019	TB	GB

-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	188
-	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
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	82
-	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	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	2161924-1	FEED FINGER	58
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	-	2161920-1	NARROW PAWL, EF, AIR	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	30
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	469633-1	BLOCK, SUPPORT	28
-	1	1	1	1	468281-8	STRIPPER	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	2161922-4	PLATE, STRIP GUIDE	24
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	23
-	2	2	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	1	464452-4	DRAG, STOCK	20
-	1	1	1	1	5-1901696-7	STRIP GUIDE, REAR	19
-	1	1	1	1	3-1901695-1	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	455961-5	PLATE, FRONT SHEAR	11
	-	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10
	-	1	1	1	461160-3	PLATE, REAR SHEAR	9
	1	2	2	1	4-1803000-0	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	2161927-1	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	2
	1	2	2	1	1803006-6	CRIMPER, WIRE	1
-	-	-	-	-	-	-	-

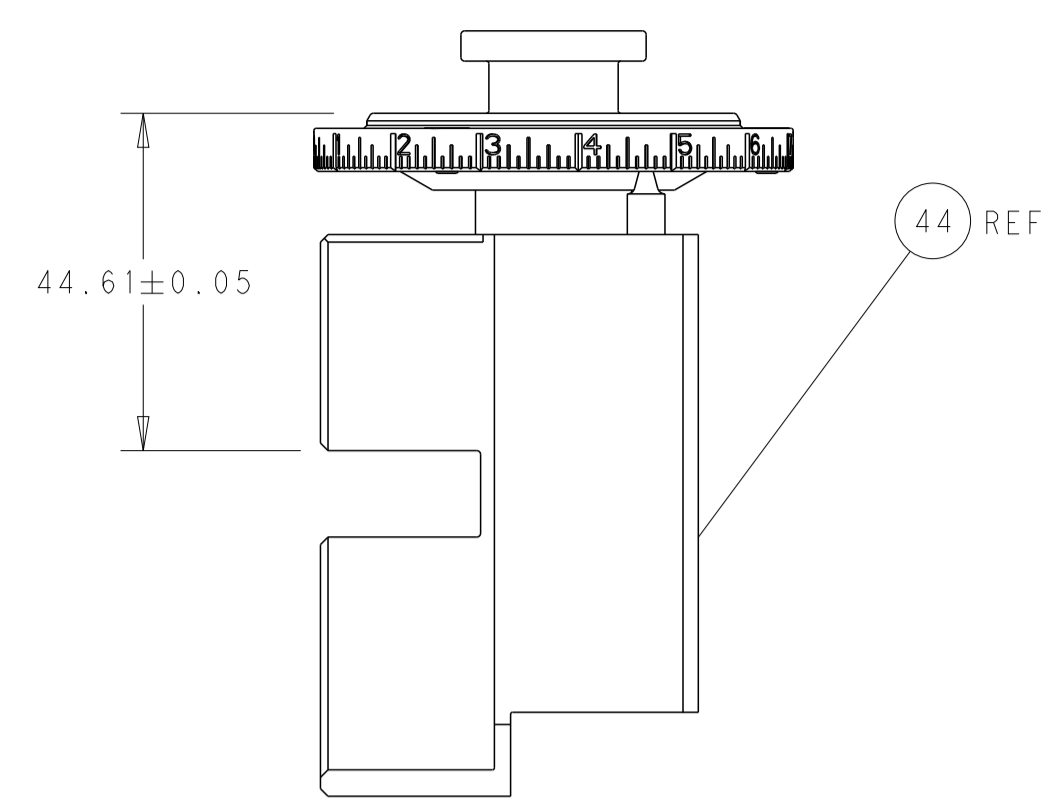
\*WARNING  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

THIS IS A CONTROL DRAWING. THE DIMENSIONS ARE IN MILLIMETERS. TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES: ±0.5°; FINISH: -

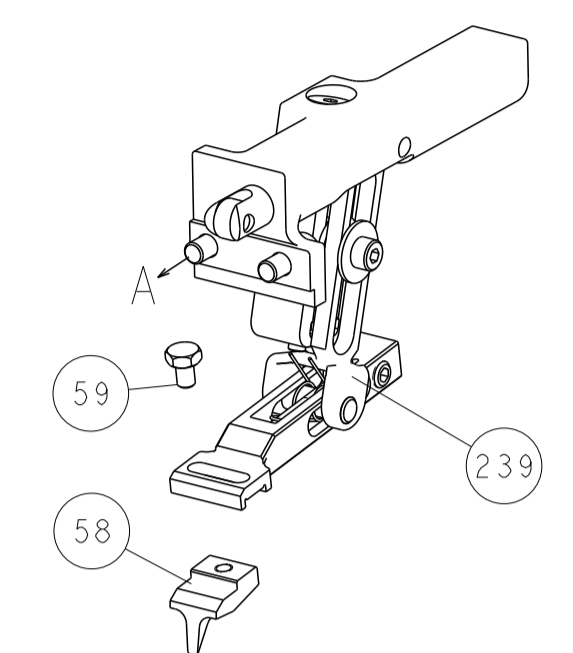
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.15; 1 PLC ±.10; 3 PLC ±.08; 4 PLC ±.07; ANGLES ±0.5°; FINISH -	OWN: BOB HIGMAN 09DEC2013 CHK: T. ELBIN 09DEC2013 APVD: M. CLIFFORD 09DEC2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
MATERIAL: -	FINISH: -	PRODUCT SPEC: -	APPLICATION SPEC: -
WEIGHT: -	CAGE CODE: A1100779	DRAWING NO: C=2150397	RESTRICTED TO: -
Customer Accessible Production Drawing			SCALE: 1:1 SHEET 1 OF 4 REV: C

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

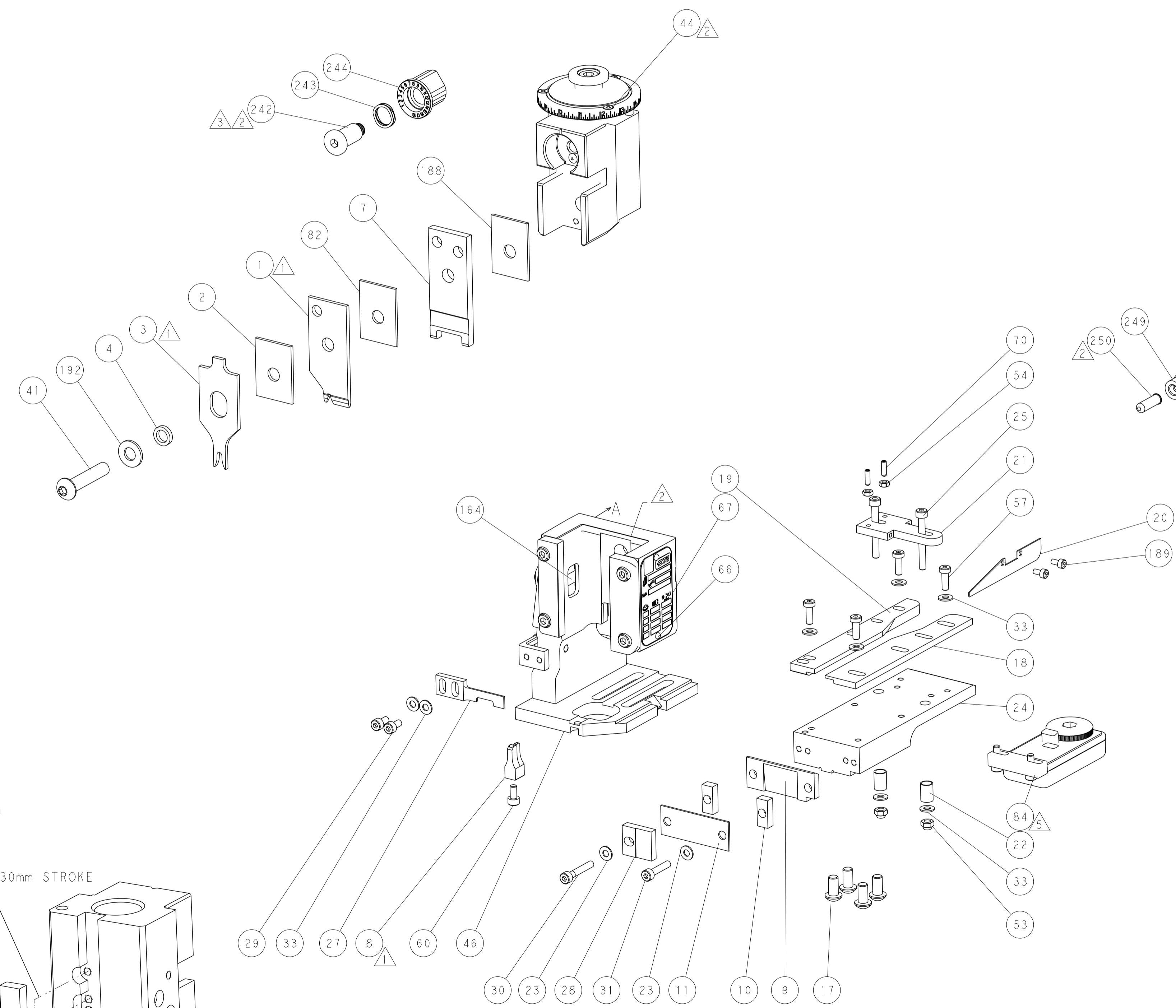
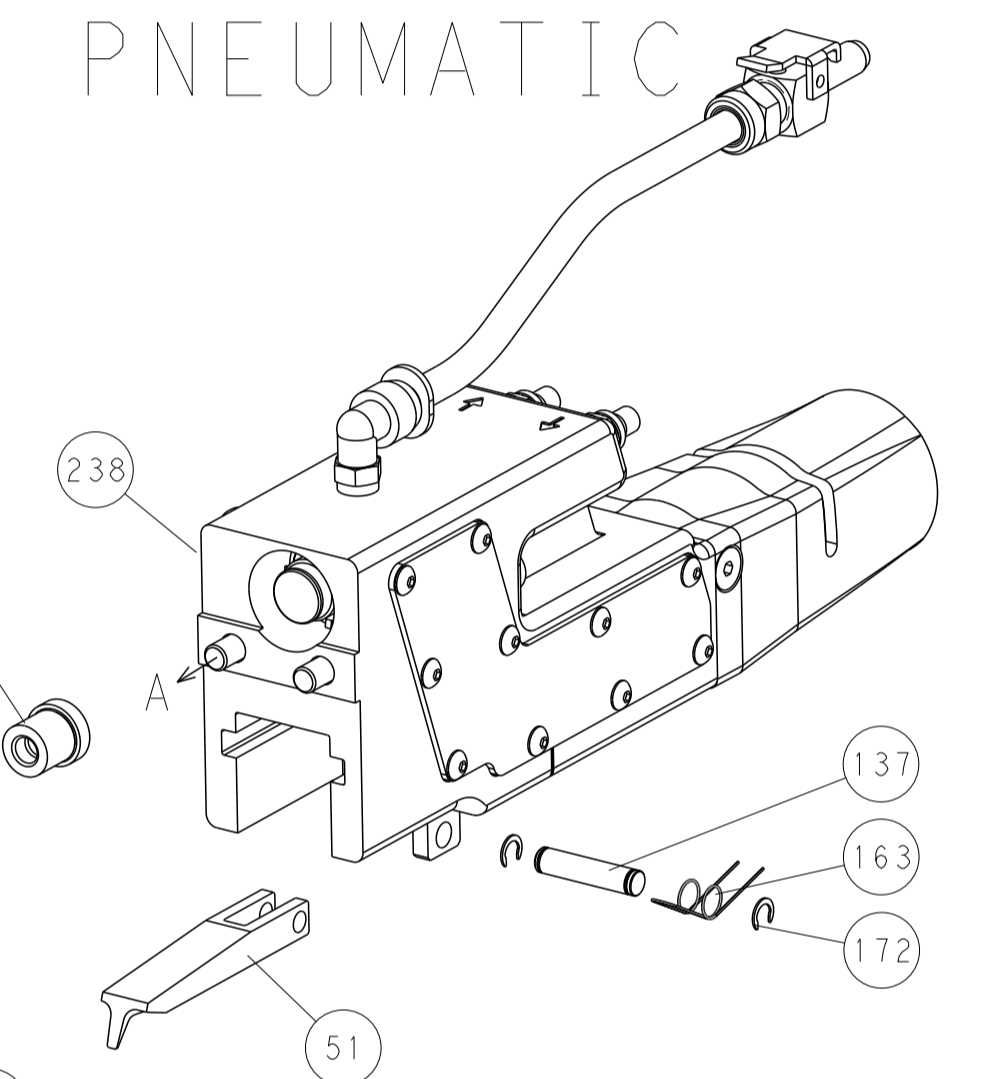


RAM SET-UP

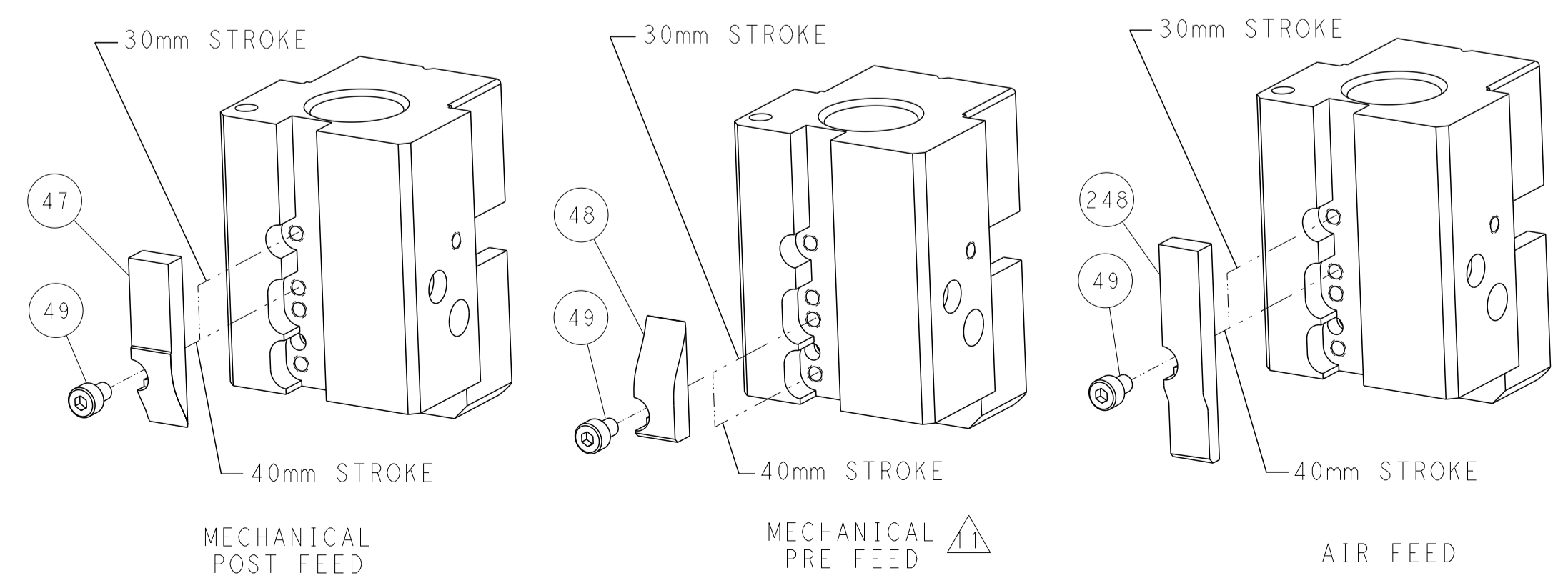
FEED TYPE  
MECHANICAL



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB_HIGMAN 09DEC2013 CHK T_ELFIN 09DEC2013 APVD M_CLIFFORD 09DEC2013	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 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150397 SHEET 2 OF 4 REV C
MATERIAL:		RESTRICTED TO:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150397-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150397-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150397-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	3.56 mm (.140)	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON FLAG .187 SERIES			
WIRE STRIP LENGTH 4.39-5.16 mm (.173-.203 IN)		INSULATION DIAMETER RANGE Ø1.52-2.79 mm (.060-.110 IN)	
TERMINAL APPLICATION SPECIFICATION 114-2079			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742086-1	1742086-2	1742087-1	1742087-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27+/-0.05 [.050+/-0.002]	4.7
20 AWG	1.14+/-0.05 [.045+/-0.002]	6.2
22 AWG	1.06+/-0.05 [.042+/-0.002]	7.1

- 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.
- 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.

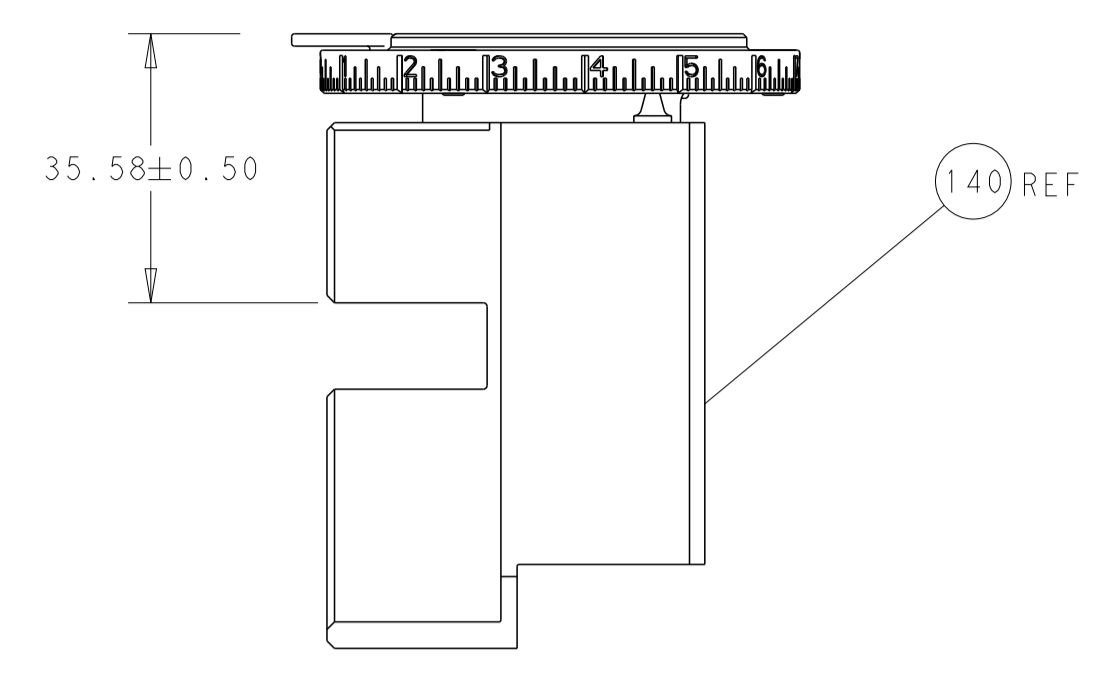
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-9	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	-	2063440-1	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	1	1	1-455888-5	SPACER, CRIMPER	188
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REFREF	-	994970-2	COUNTER, MAGNETIC	164
-	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1-455888-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2161924-1	FEED FINGER	58
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2161920-1	NARROW PAWL, EF, AIR	51
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	30
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	469633-1	BLOCK, SUPPORT	28
-	1	1	468281-8	STRIPPER	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-4	PLATE, STRIP GUIDE	24
-	2	2	1-18028-2	WASHER, FLAT, REG M4	23
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	464452-4	DRAG, STOCK	20
-	1	1	5-1901696-7	STRIP GUIDE, REAR	19
-	1	1	3-1901695-1	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	1	1	455961-5	PLATE, FRONT SHEAR	11
	2	2	1-240645-9	SPACER, SHEAR PLATE	10
	1	1	461160-3	PLATE, REAR SHEAR	9
	1	1	4-1803000-0	ANVIL, COMBINATION, END FEED	8
	1	1	2161927-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1-455888-7	SPACER, CRIMPER	2
	1	1	1803006-6	CRIMPER, WIRE	1
-	77-22-21	-	PART NO	DESCRIPTION	ITEM NO

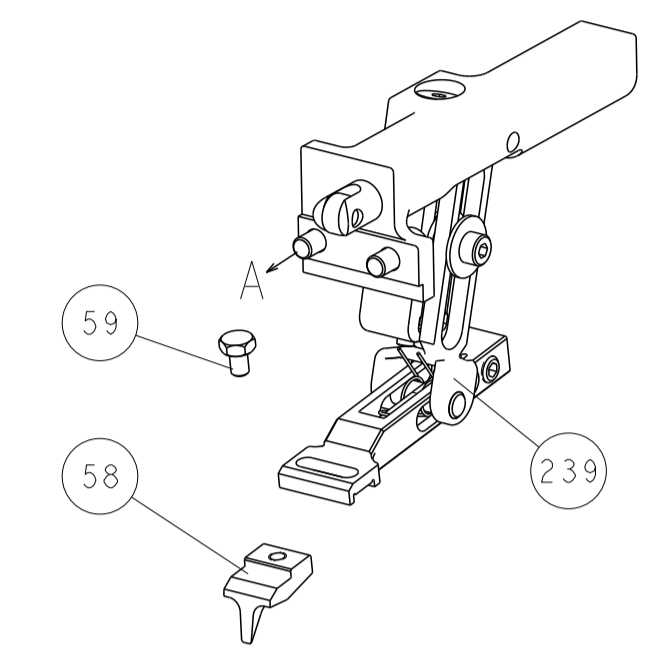
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 09DEC2013		CHK: T. ELBIN 09DEC2013		NAME: M. CLIFFORD 09DEC2013		APVD: M. CLIFFORD 09DEC2013	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APPLICATION SPEC		SIZE: A1		CAGE CODE: 00779	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 3 OF 4		REV: C	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

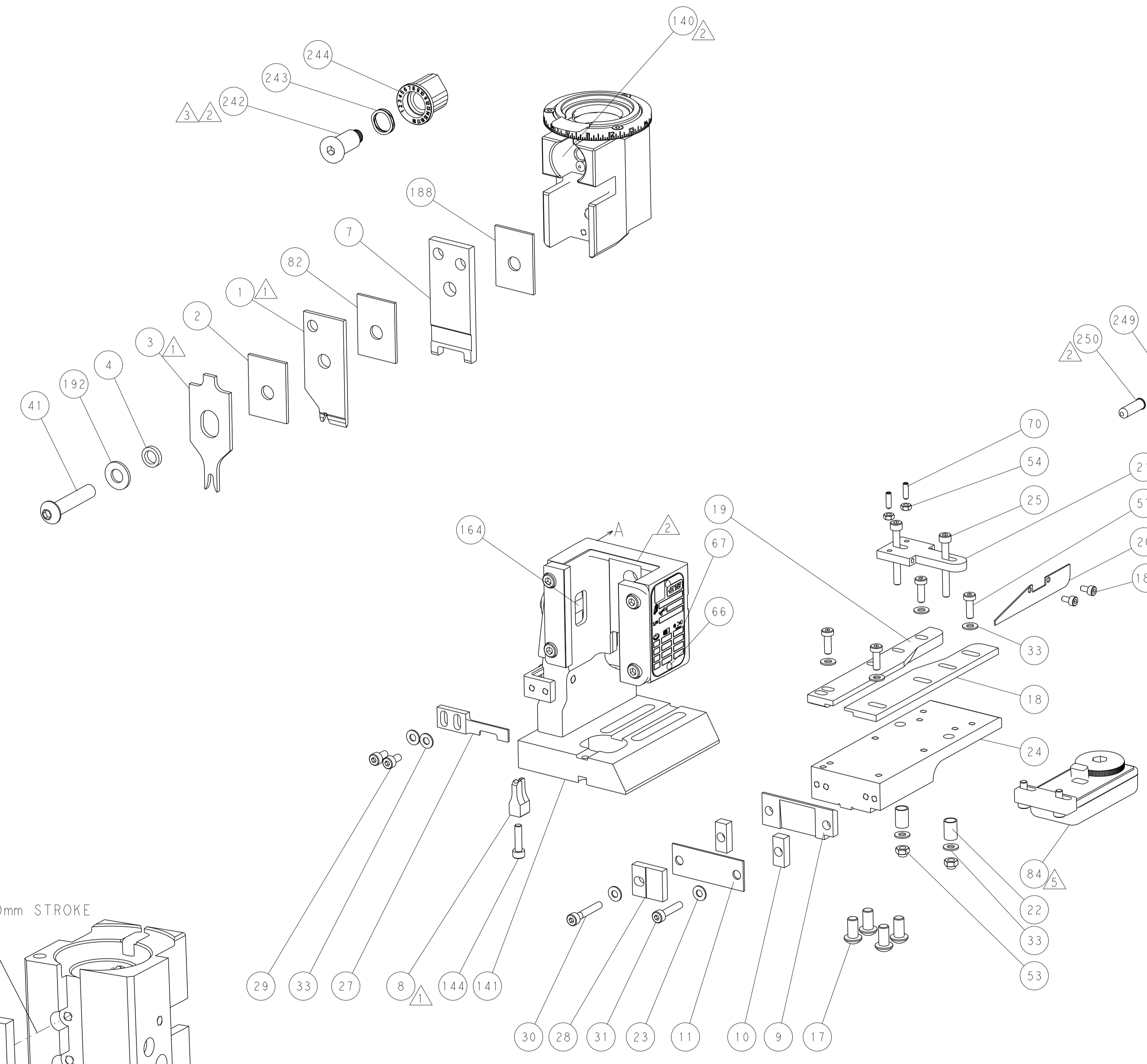
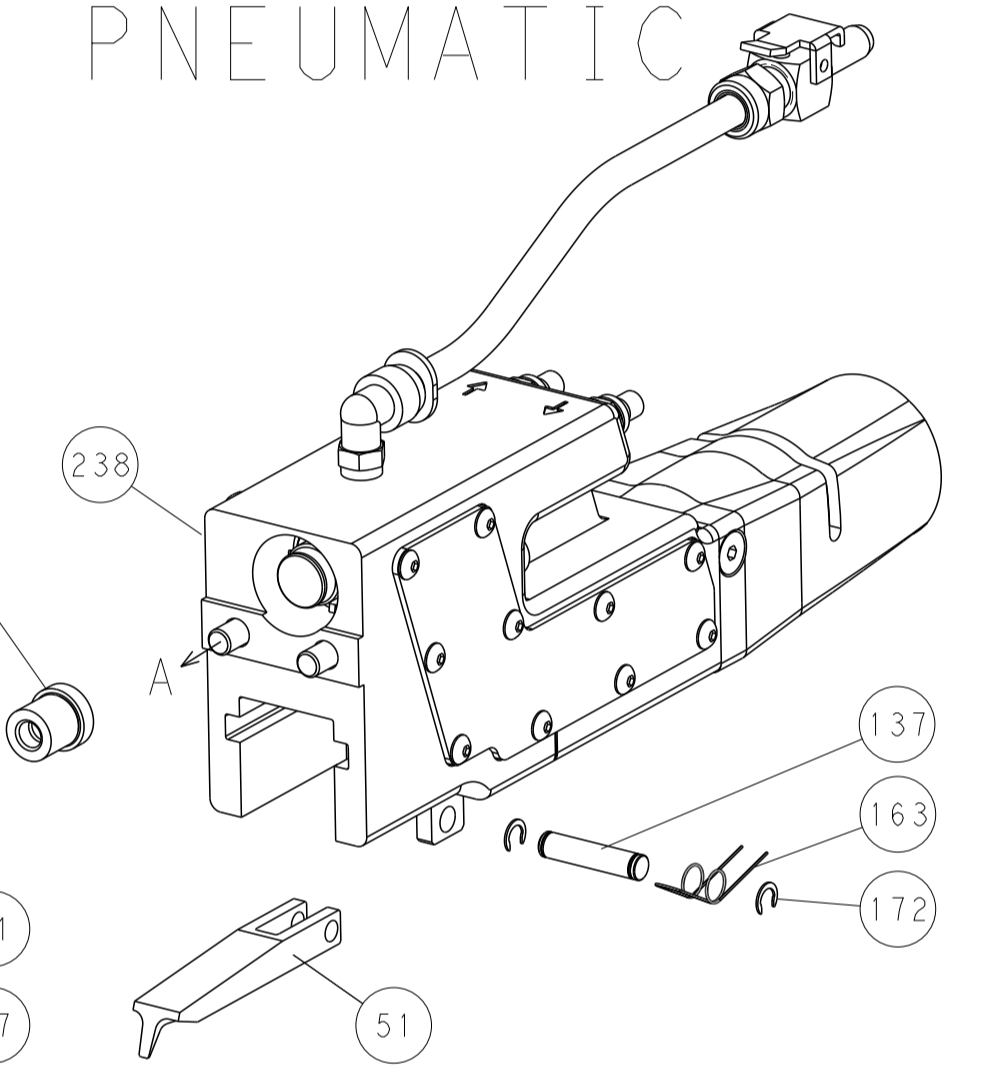


RAM SET-UP

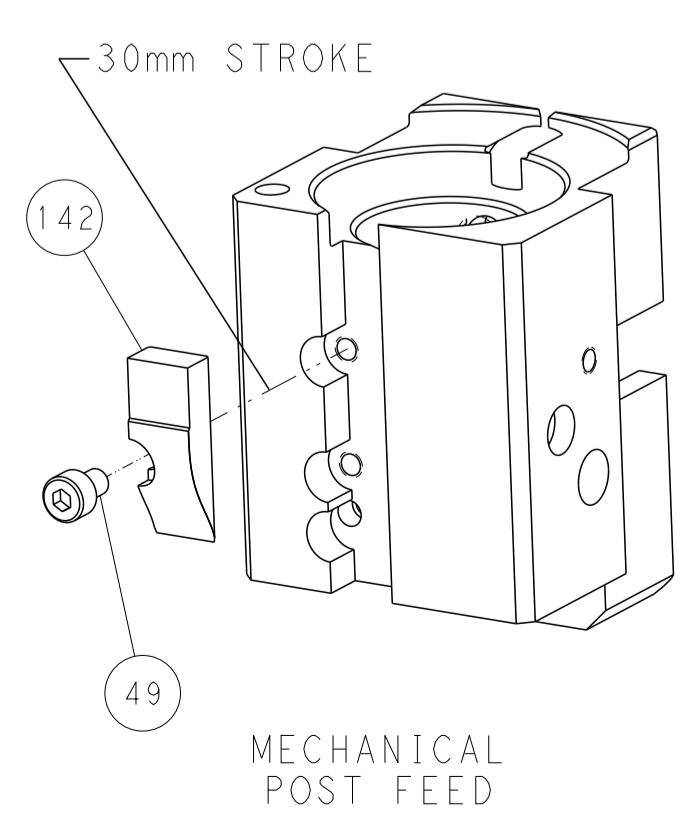
FEED TYPE  
MECHANICAL



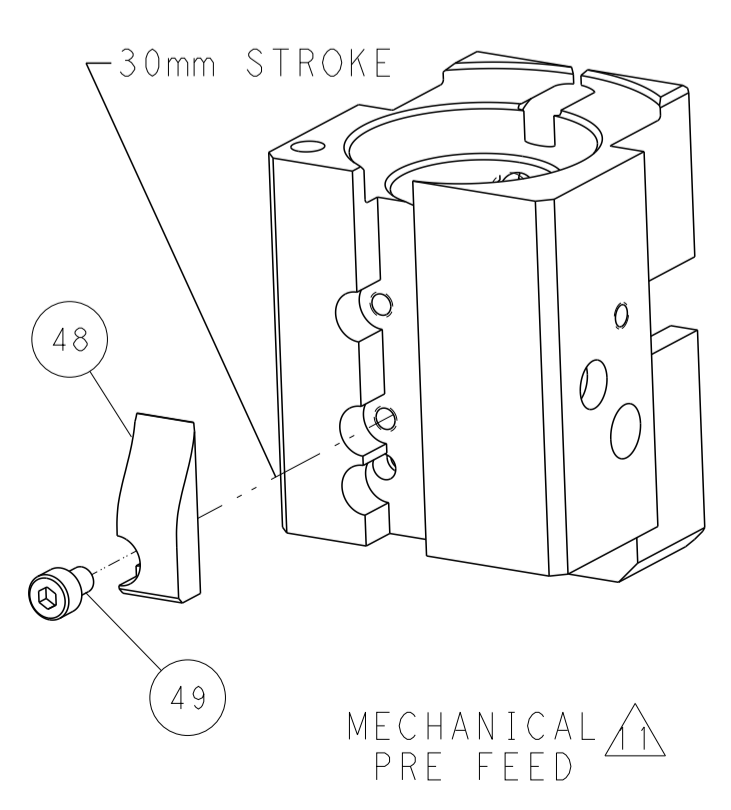
PNEUMATIC



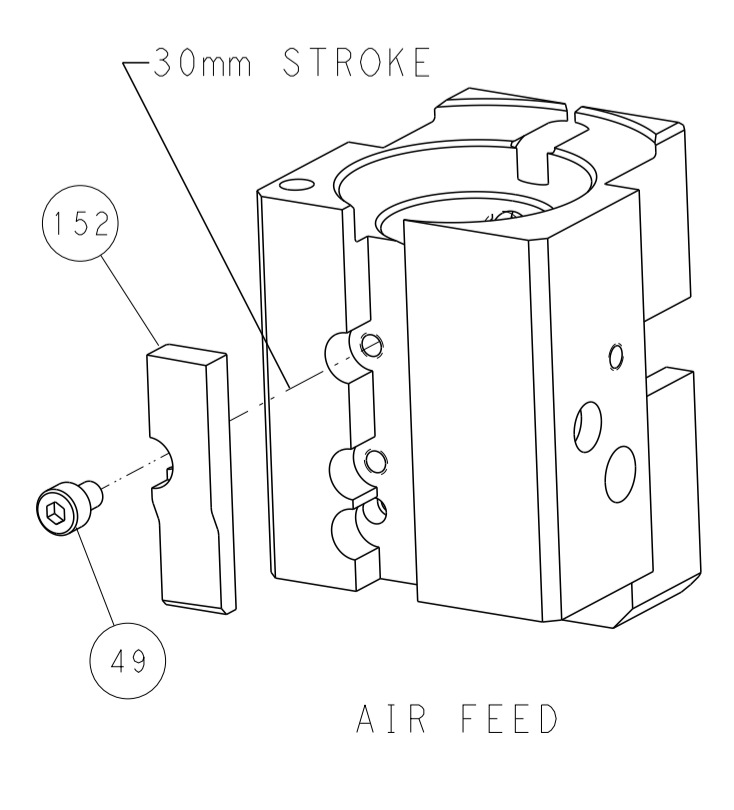
CAM POSITIONS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 09DEC2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: M. CLIFFORD 09DEC2013	NAME: Ocean End Feed Applier	SIZE: A	CAGE CODE: 00779
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SCALE: 1:1	DRAWING NO: 2150397
				WEIGHT:		SHEET: 4	OF 4 REV: C