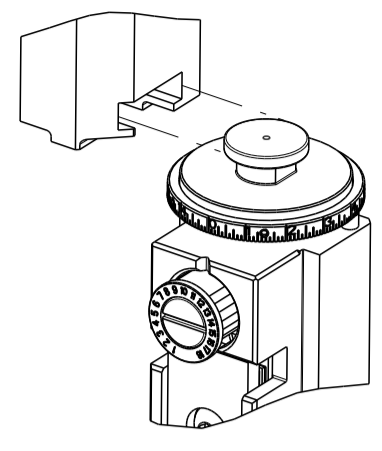


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150072-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150072-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150072-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150072-7	A	CRIMP TOOLING KIT	-

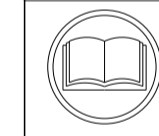
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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



- 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.
- 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.

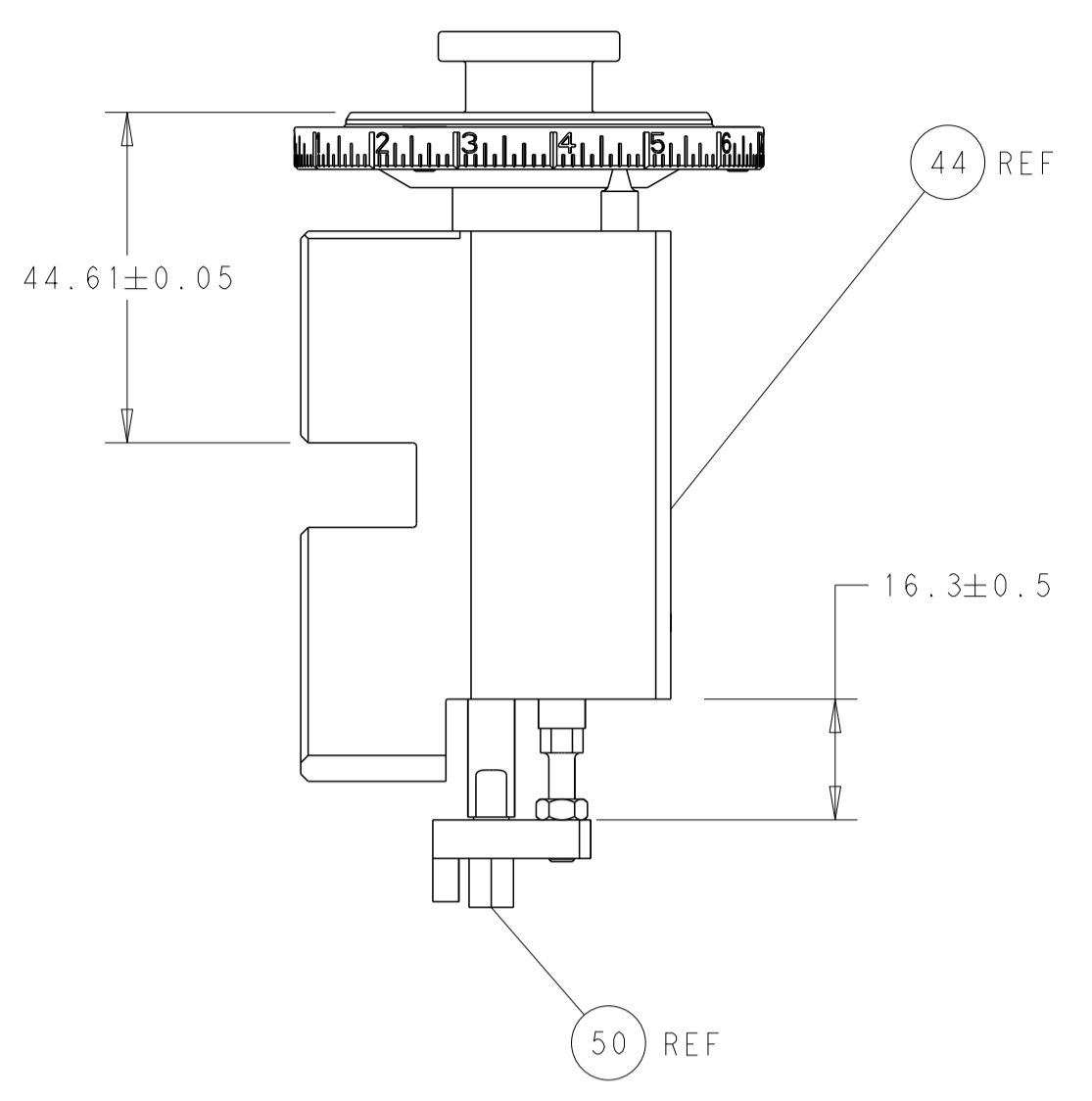
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
			1		DEVELOPMENT	16JAN2013	YY	SX
			A		RELEASED	12APR2013	YY	UG
			B		ECR-18-015273	25SEP2018	TB	TE
			C		ECR-22-130891	28FEB2022	TB	RK

-	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	
	-	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	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	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	1803607-4	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	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	-	2063961-9	FEED FINGER	51	
	-	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	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	4-690495-7	PLATE, FRONT SHEAR	9	
	1	2	2	1	1333213-4	ANVIL, COMBINATION	8	
	-	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	2	2	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
	1	2	2	1	1	1-456402-6	CRIMPER, WIRE PREMIUM	1
	-77-72-71	-2	-1		PART NO	DESCRIPTION	ITEM NO	

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

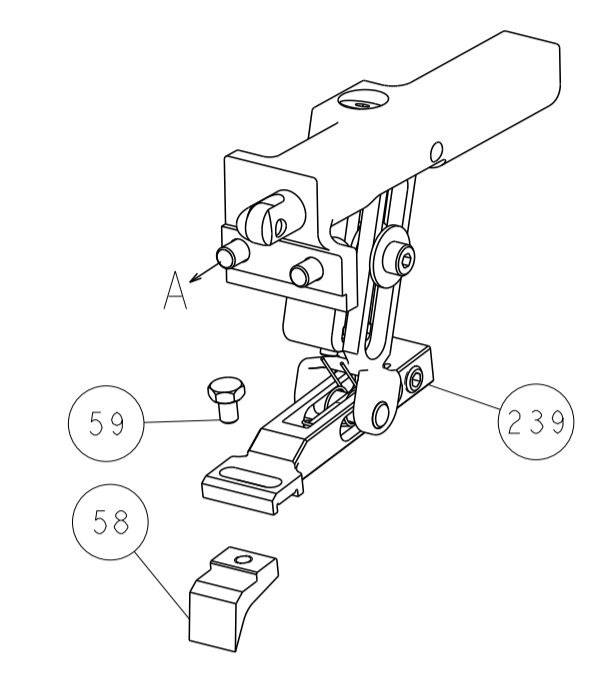
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME					
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Y. YIN	16JAN2012	G. BAILEY	16JAN2012	STE TE Connectivity Harrisburg, PA 17105-3608					
	ANGLES ±	FINISH ±							Ocean End Feed Applicator						
MATERIAL										SIZE	CAGE CODE	DRAWING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

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

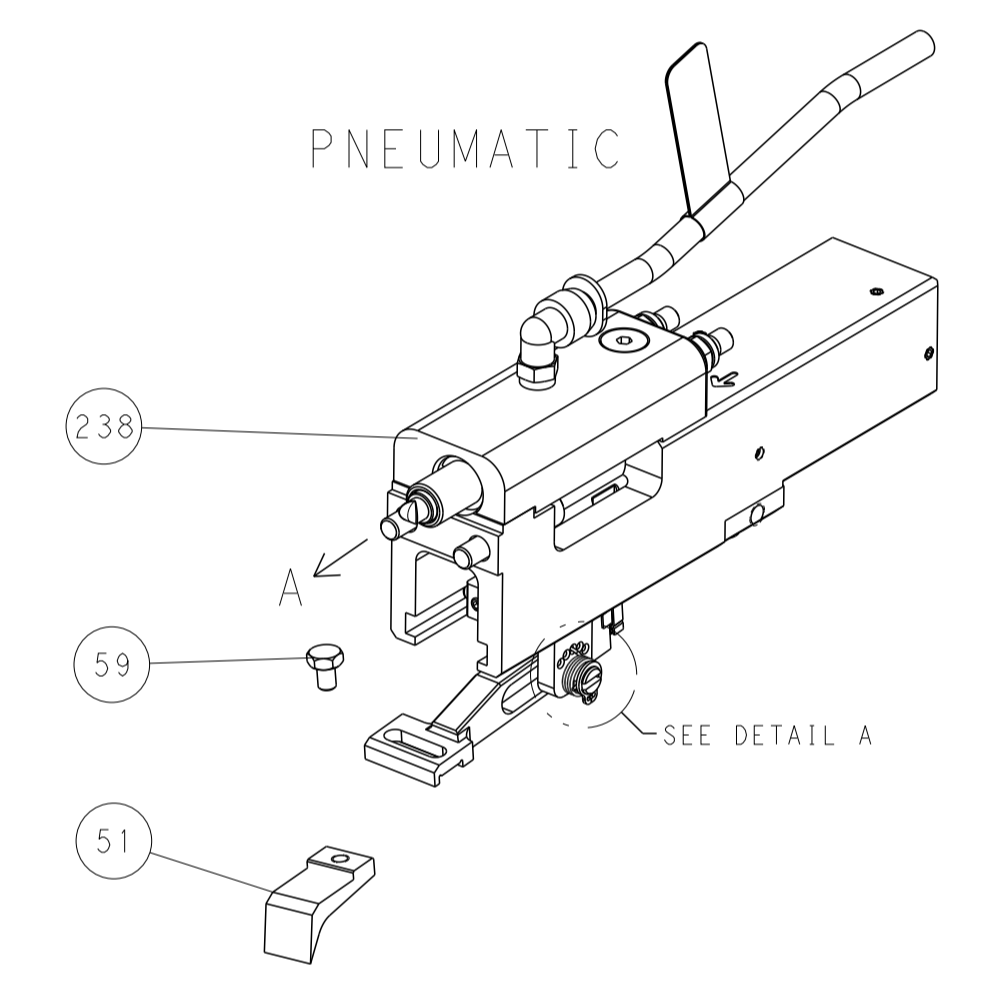


RAM AND HOLDDOWN SET-UP

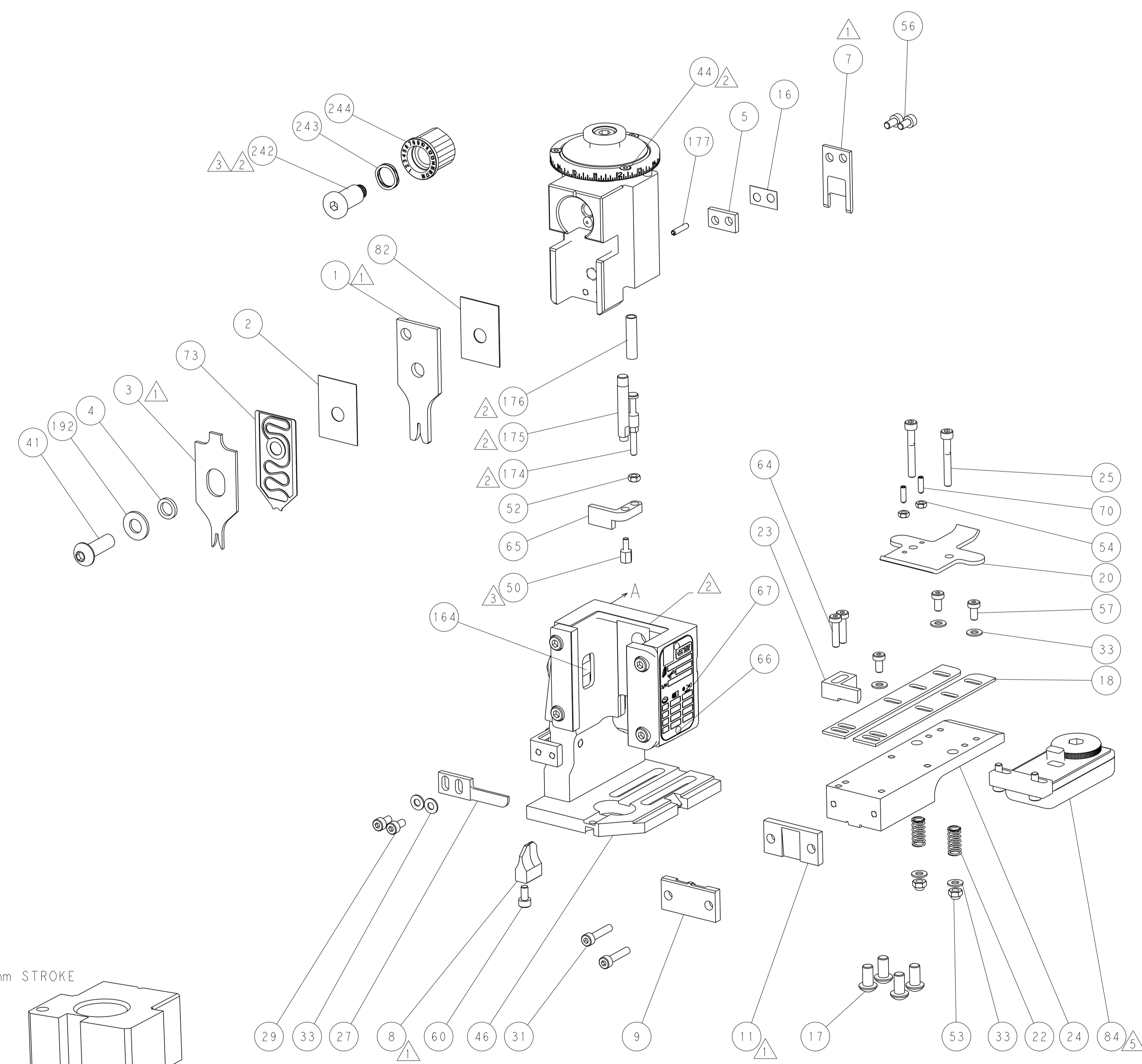
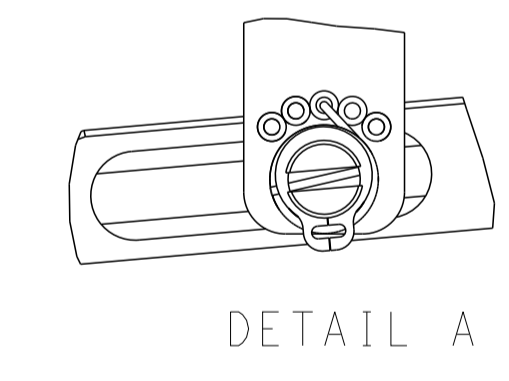
FEED TYPE  
MECHANICAL



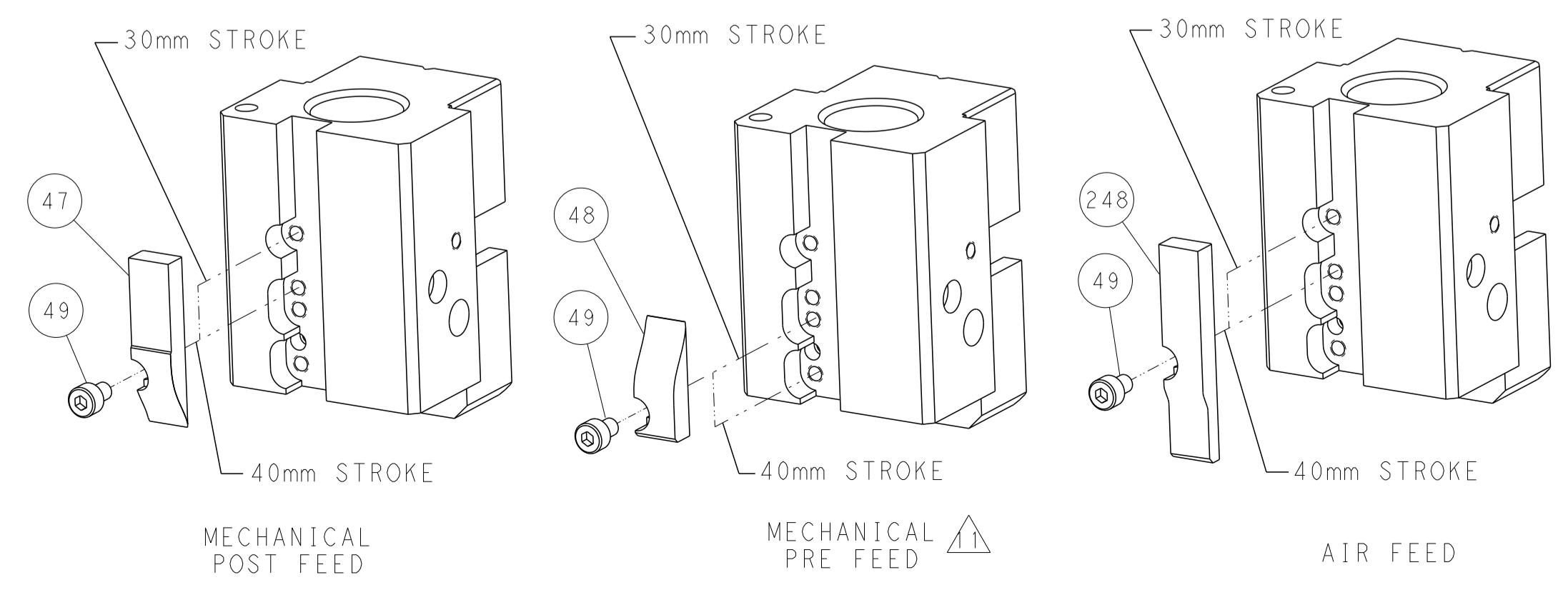
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

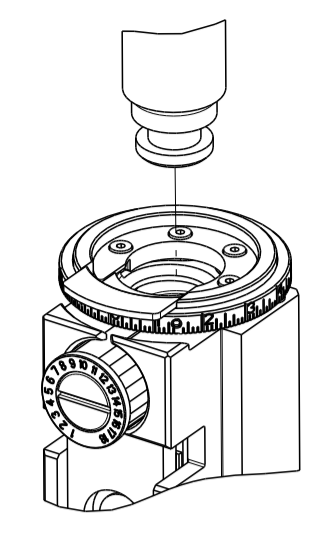


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150072-2	C	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+/-0.002]	4.8
22 AWG	1.09+/-0.05 [.043+/-0.002]	6.4
24 AWG	1.02+/-0.05 [.040+/-0.002]	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.

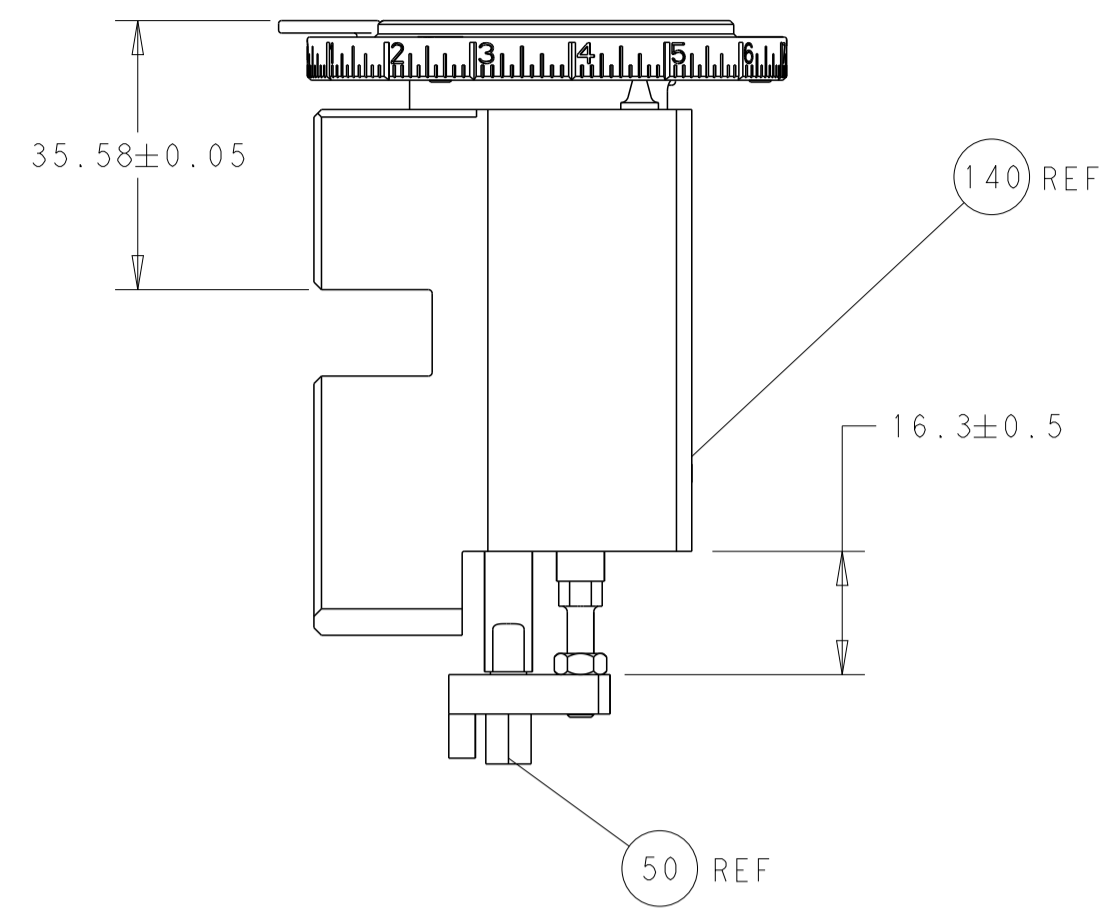
**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2		A	66	REV	DATE	BY	APPD
-	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	-	2844940-3	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
-	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
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	1803607-4	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	-	2063961-9	FEED FINGER			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)

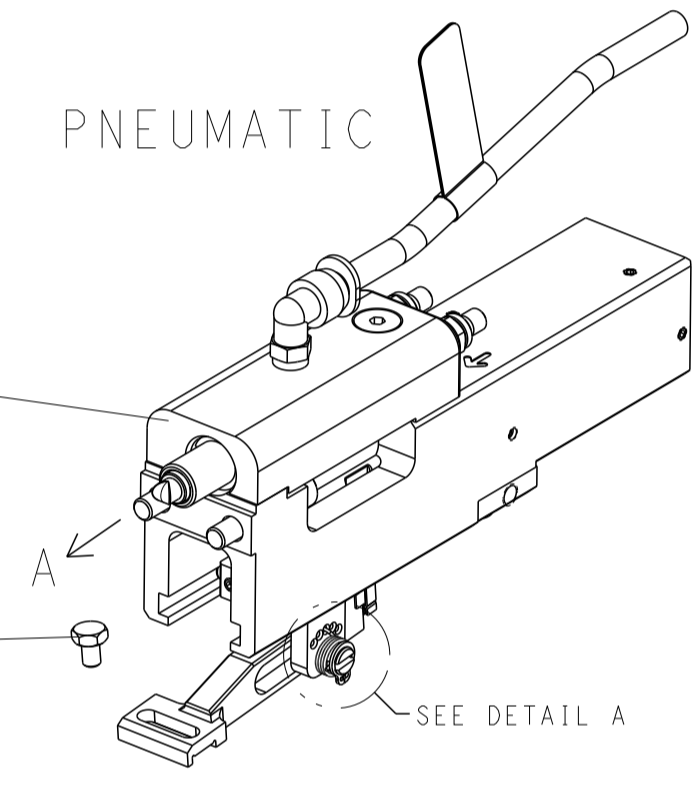
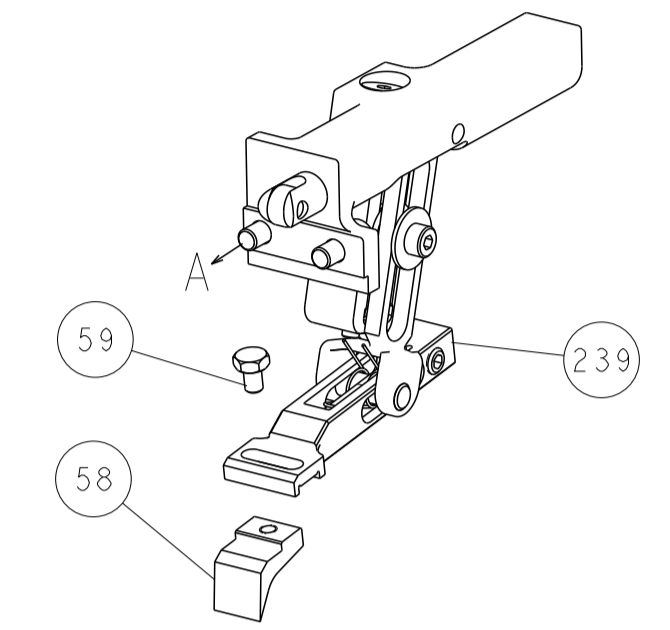
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 16JAN2012		CHK: G. BAILEY 16JAN2012		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		APVD: S. XI 16JAN2012		PRODUCT SPEC		SIZE: A1	
2 PLC ±		3 PLC ±		APPLICATION SPEC		CAGE CODE: 00779		DRAWING NO: 2150072	
4 PLC ±		ANGLES ±		WEIGHT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

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

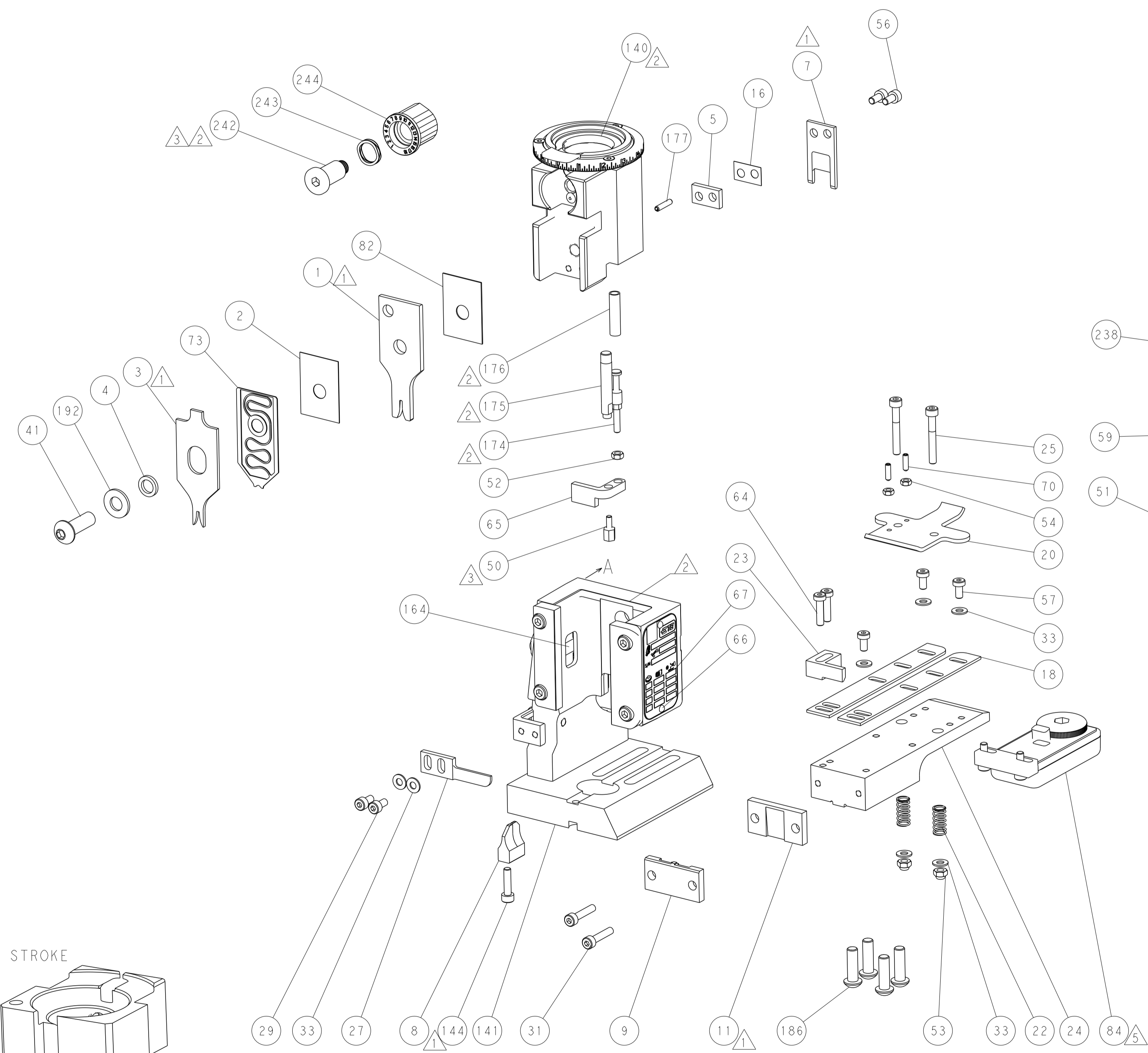
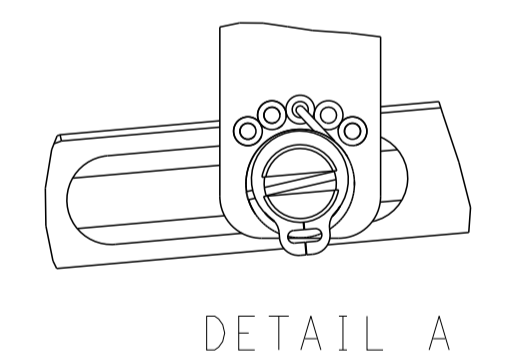


RAM AND HOLDDOWN SET-UP

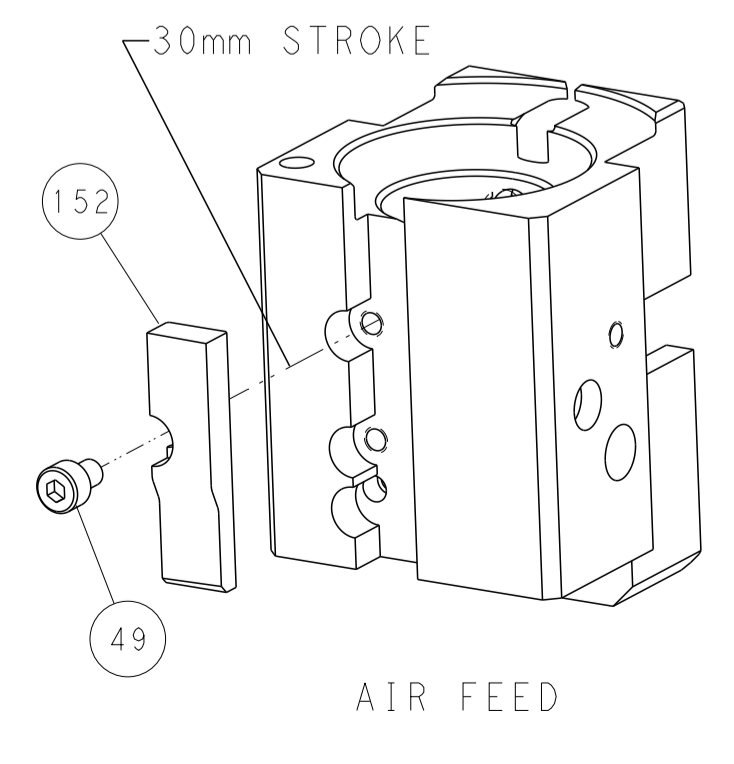
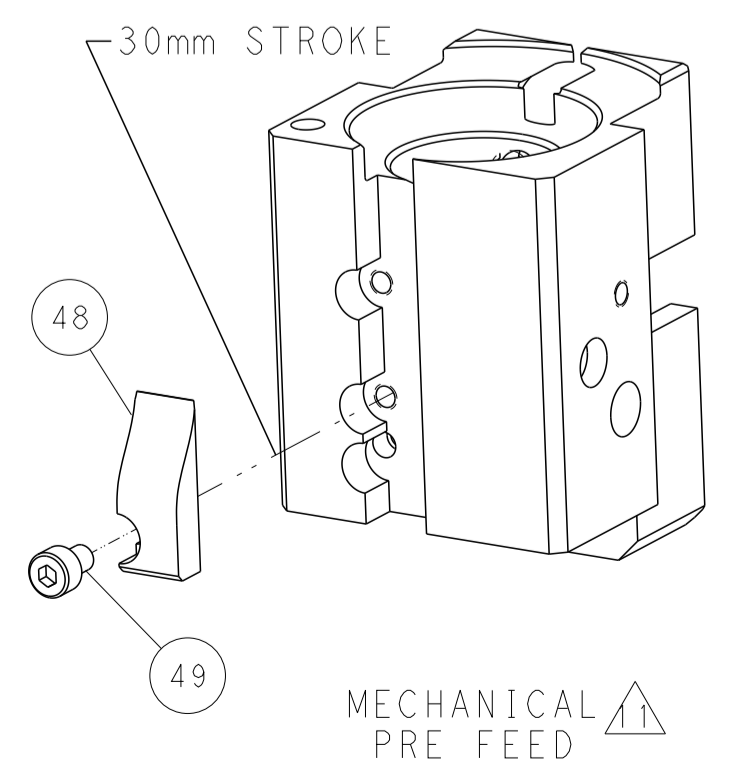
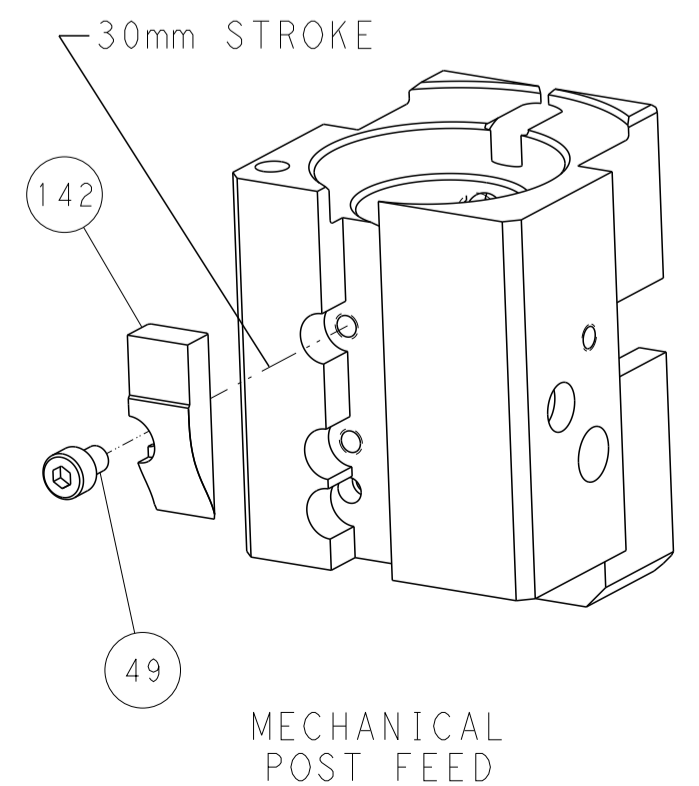
FEED TYPE  
MECHANICAL



FEED SPRING  
SETTING POSITION



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: Y. YIN CHK: G. BAILEY APVD: S. XI	DATE: 16JAN2012 DATE: 16JAN2012 DATE: 16JAN2012	NAME: Ocean End Feed Applier	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150072	RESTRICTED TO: C
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - SCALE: 1:1 SHEET: 4 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION		