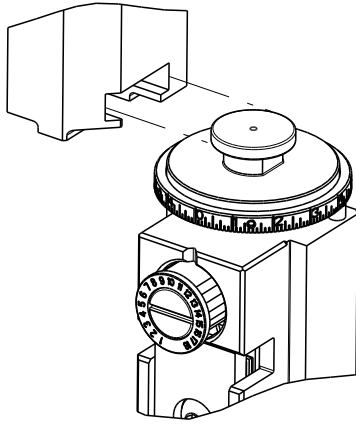


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150058-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150058-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150058-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150058-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150058-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.08 mm [.200]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK EX RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø1.90-4.40 mm [.075-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5114	-	-
	(B)114-5125	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 173724-1	TE TERMINAL (A) 173724-5	TE TERMINAL (A) 3-173724-2	TE TERMINAL (B) 175034-1
(B) 1-175034-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.49+/-0.05 [.059+/- .002]	4.3
16 AWG OR 1.25mm2	1.35+/-0.05 [.053+/- .002]	5.7
18 AWG OR 0.75mm2	1.19+/-0.05 [.047+/- .002]	7.5
20 AWG OR 0.50mm2	1.09+/-0.05 [.043+/- .002]	8.6



- 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. 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.

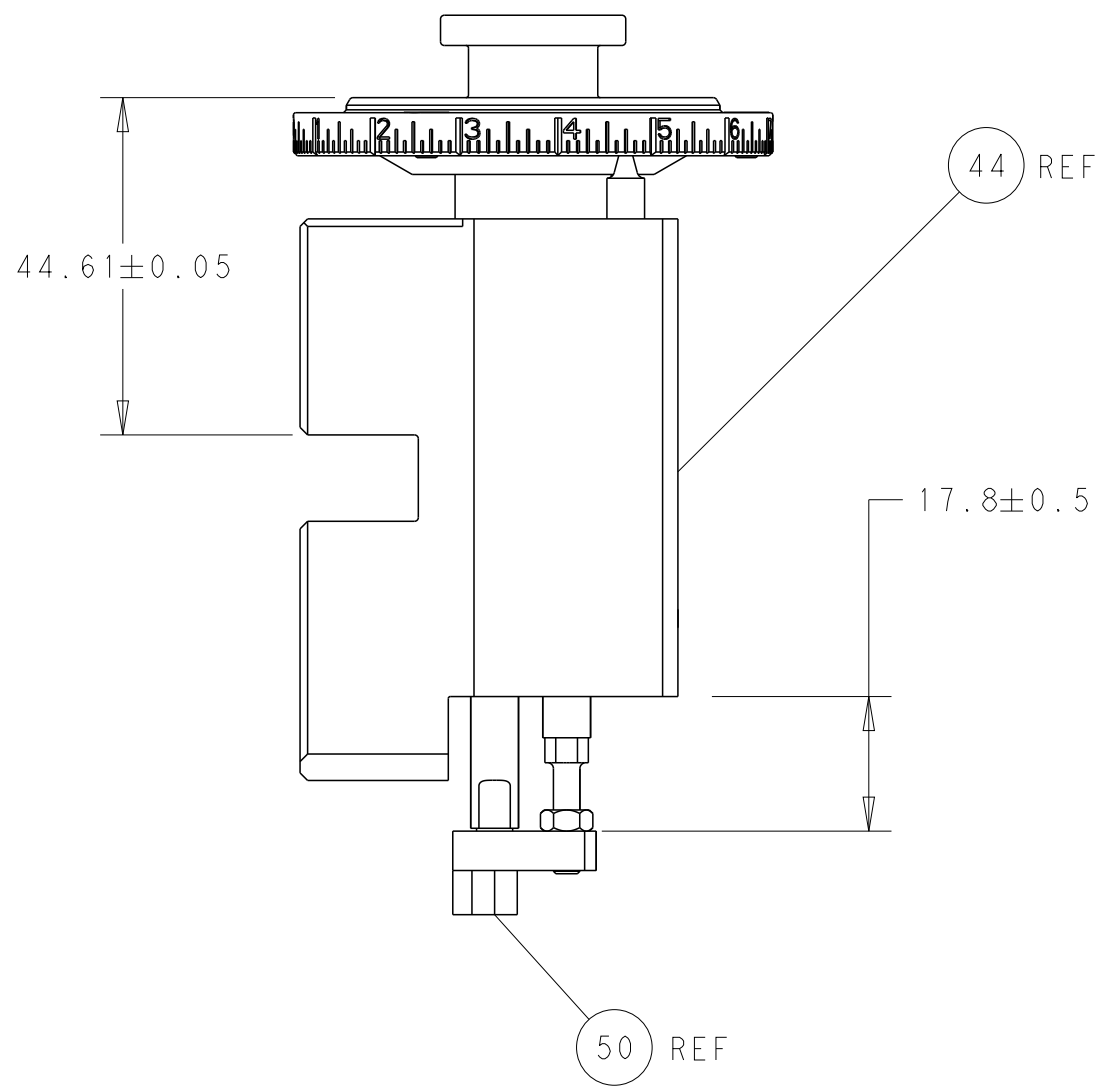
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		2		UPDATE	14MAY2013	CC	UG
		A		RELEASE	28APR2014	JH	TE
		B		ECR-18-014457	12SEP2018	TB	TE

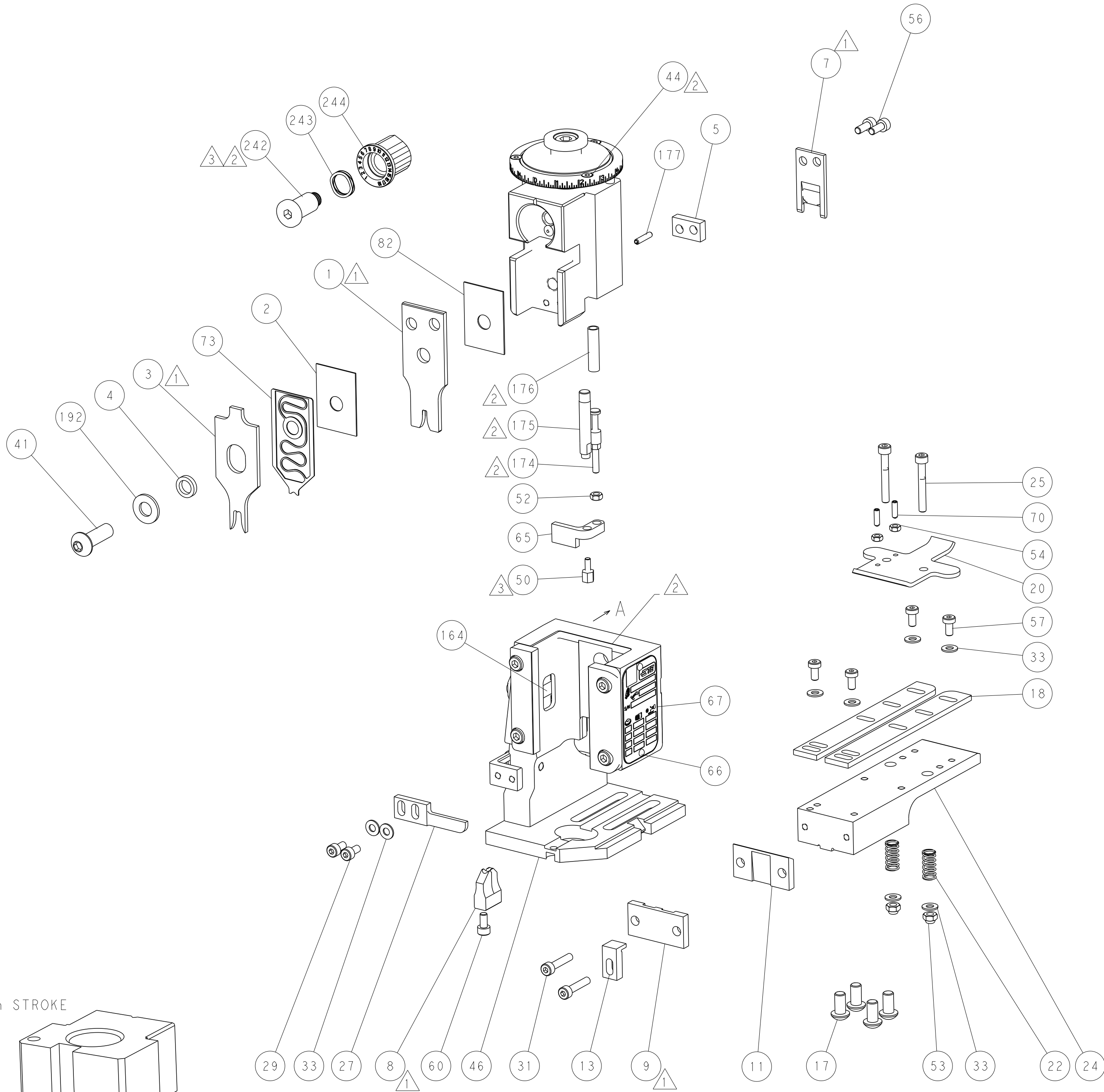
3	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	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
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-5	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
3	-	1	-	1	-	2119792-2	PAWL, EF, AIR	51
	-	1	1	1	1	1752354-8	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	2168083-9	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	240639-1	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	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	1	-	1	1	1	1	240833-7	PLATE, REAR SHEAR
-		-	-	-	-	-	-	10
1	-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9
	1	2	2	1	1	3-1333219-6	ANVIL, COMBINATION	8
1	-	1	1	1	1	2217206-4	BLADE, SLUG	7
	-	1	1	1	1	2-240641-9	SPACER	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	3-1633961-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	2	2	1	1	456408-1	CRIMPER, WIRE PREMIUM	1
	-	77-72-71	-	2	-	1	PART NO	DESCRIPTION

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST EDITION. SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN C.CHEN CHK S.XI APVD J.CRUZ	10FEB2012 10FEB2012 10FEB2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH		NAME Ocean End Feed Appliator	
MATERIAL -		WEIGHT -		SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:1	
		SHEET 1		REV B	

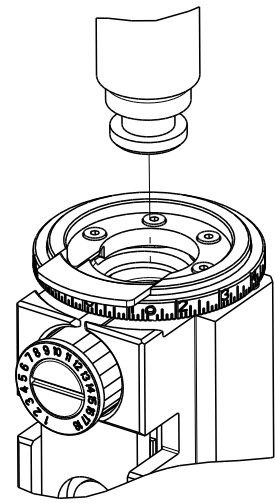
LOC		DIST	REVISONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD
-	-	SEE SHEET 1		-	-	-



RAM AND HOLDDOWN SET-UP



8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150058-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150058-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150058-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.08 mm [.200]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 187 SERIES POSITIVE LOCK EX RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø1.90-4.40 mm [.075-.173 IN]	
			
TERMINAL APPLICATION SPECIFICATION	(A) 114-5114	-	-
	(B) 114-5125	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1-175324-1	(A) 173724-5	(A) 3-173724-2	(B) 175034-1
(B) 1-175034-1			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG OR 2.00mm2			1.49+/-0.05 [.059+/- .002]		4.3
16 AWG OR 1.25mm2			1.35+/-0.05 [.053+/- .002]		5.7
18 AWG OR 0.75mm2			1.19+/-0.05 [.047+/- .002]		7.5
20 AWG OR 0.50mm2			1.09+/-0.05 [.043+/- .002]		8.6

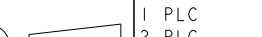


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. 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.

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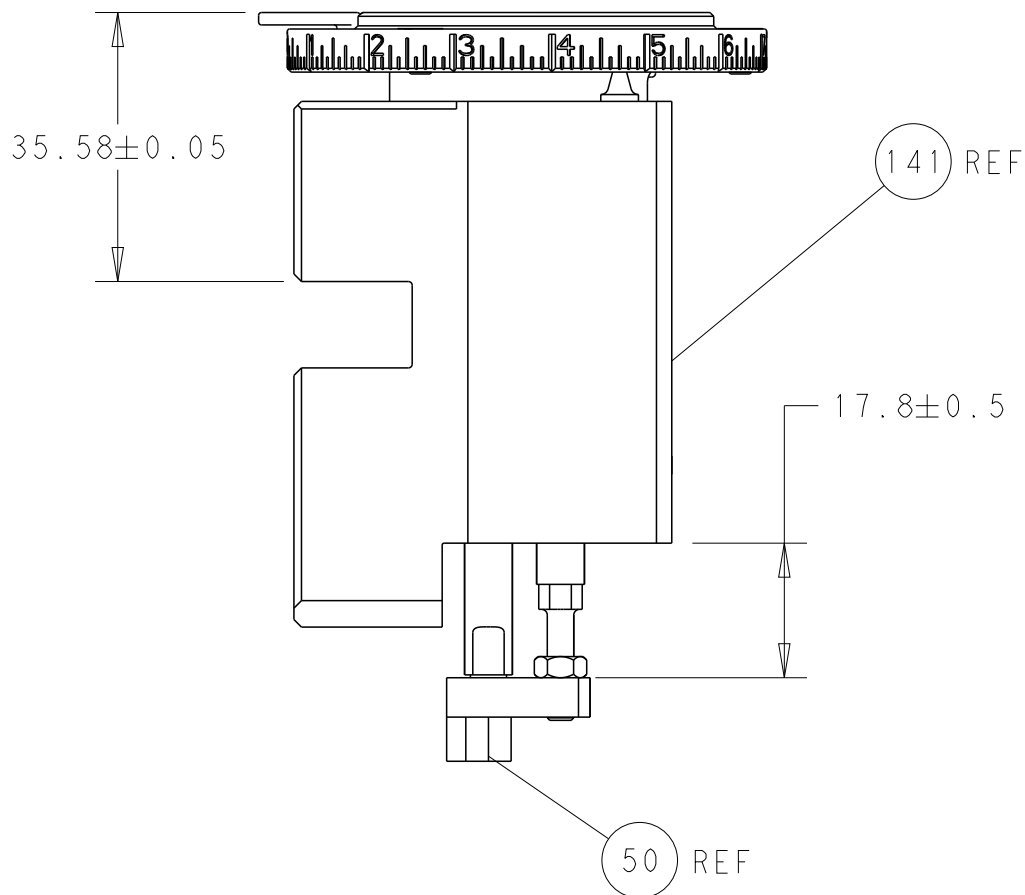
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	OWN CHEN 10FEB2012	APVD CRUZ 10FEB2012	Ocean End Feed Appliator	
		PRODUCT SPEC		SIZE	
		APPLICATION SPEC		CAGE CODE	
MATERIAL		WEIGHT		DRAWING NO	
FINISH		A1		00779	
		C=2150058		RESTRICTED TO	
		Customer Accessible Production Drawing		SCALE 1:1	
				SHEET 3 OF 4	
				REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

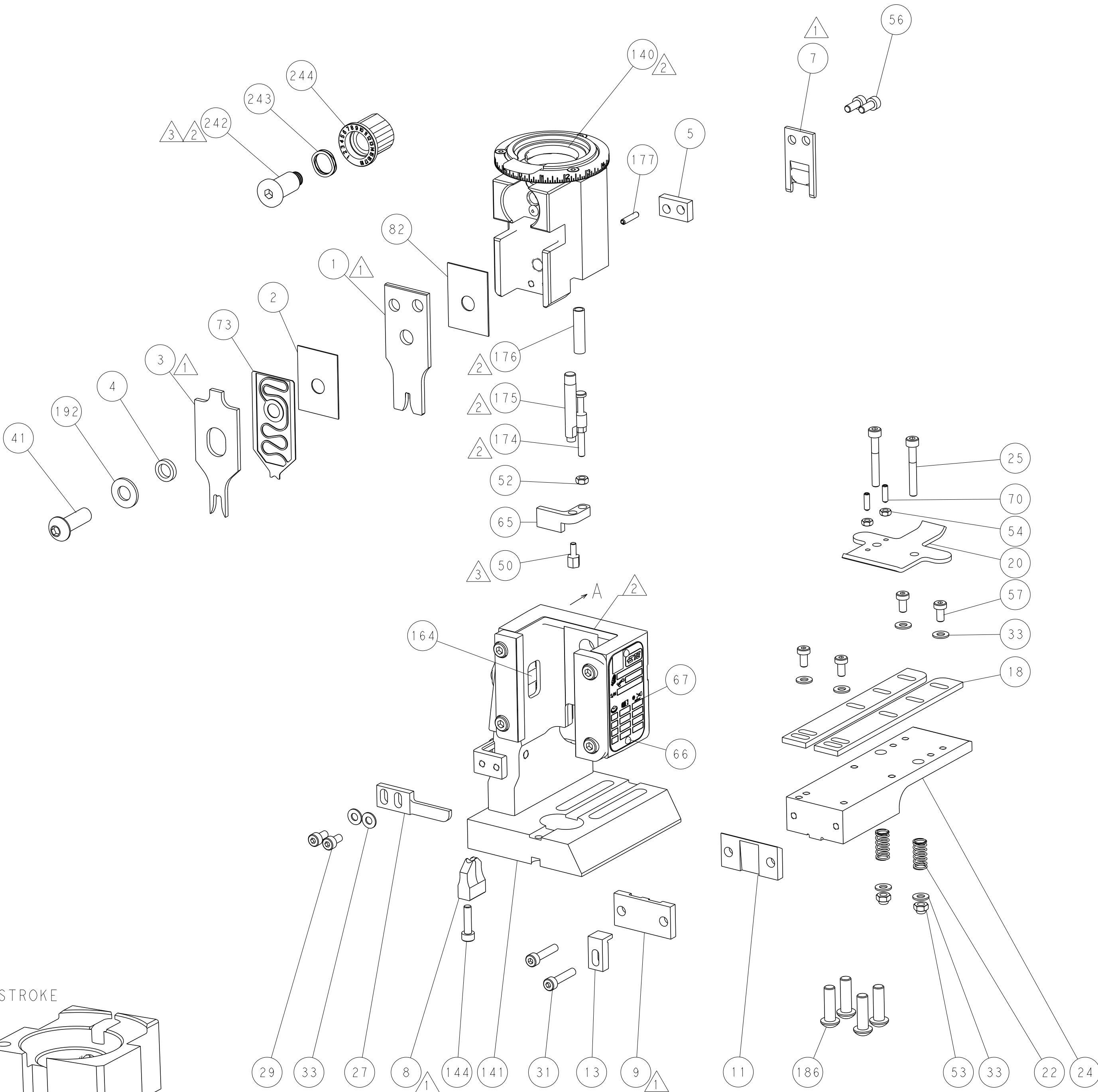
AMP 4805 REV 31MAR2000

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

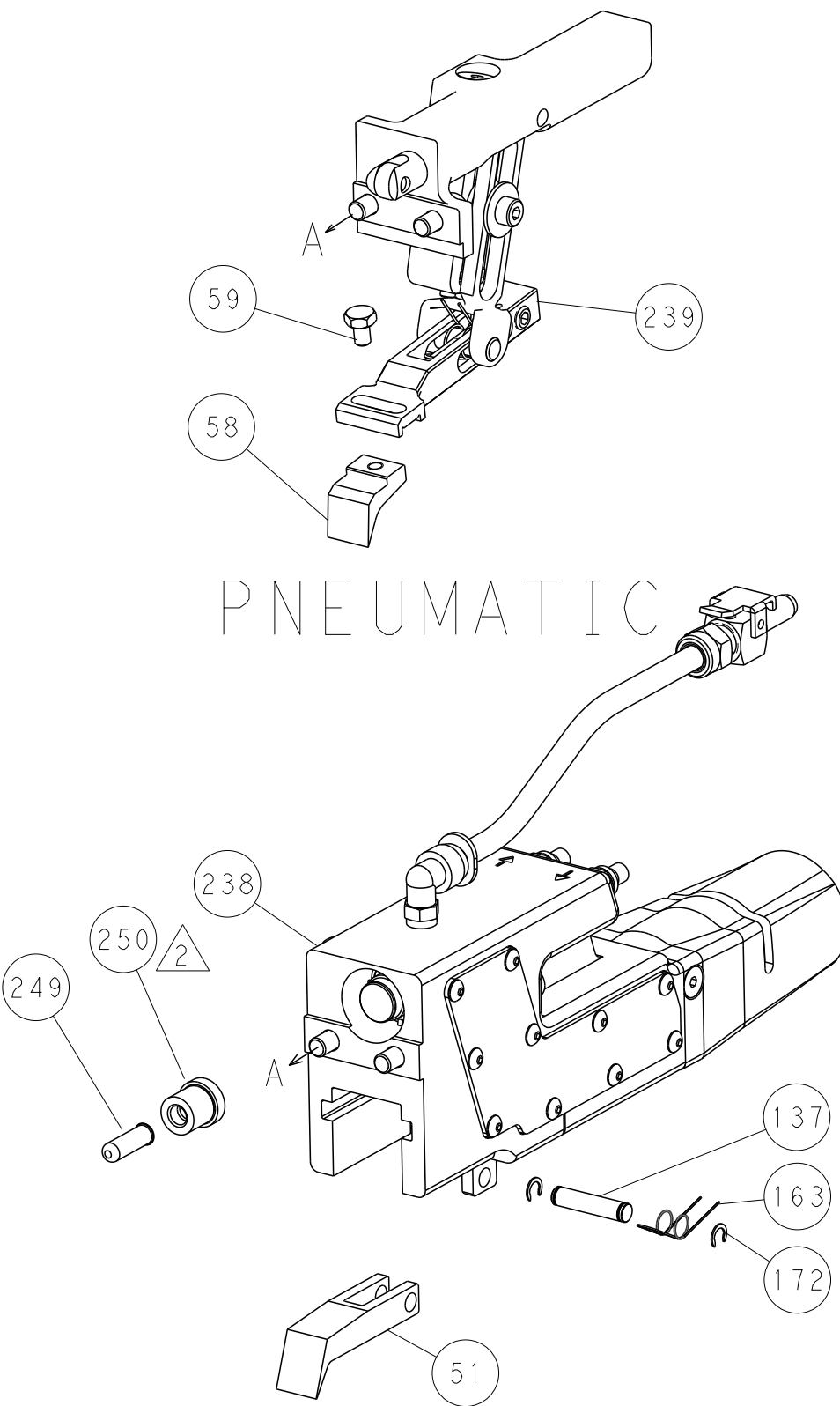
LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	-	SEE SHEET 1		-	-	-	



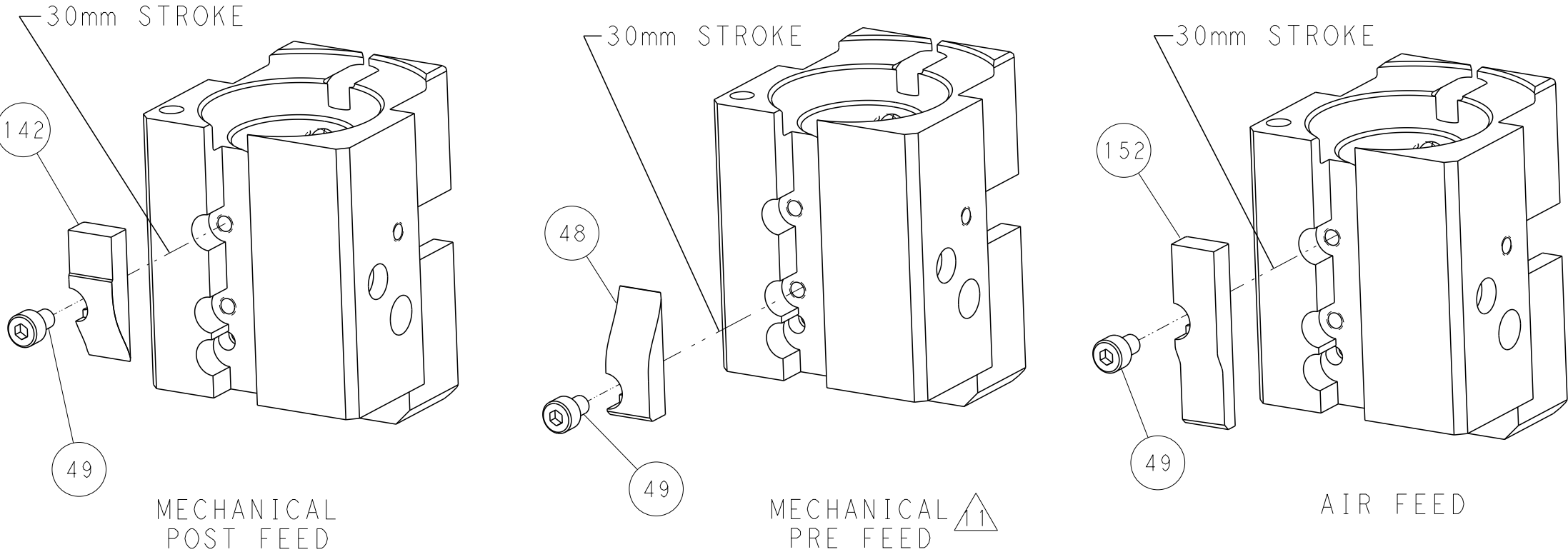
RAM AND HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



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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CHK S. XI 10FEB2012				NAME				Ocean End Feed Applicator			
APVD I. CRUZ 10FEB2012				PRODUCT SPEC				SIZE			
				APPLICATION SPEC				CAGE CODE			
				WEIGHT				DRAWING NO			
				MATERIAL				00779			
				Customer Accessible Production Drawing				SCALE			
				1:1				SHEET			
				4				OF			
				4				REV			
				B							