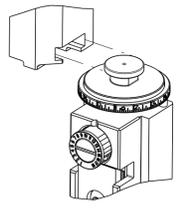


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150447-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150447-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150447-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150447-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150447-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	OV

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]	5.4
20 AWG	1.14 +/- 0.05 [.045 +/- .002]	6.7
22 AWG	1.06 +/- 0.05 [.042 +/- .002]	7.6

- 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.
- 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.

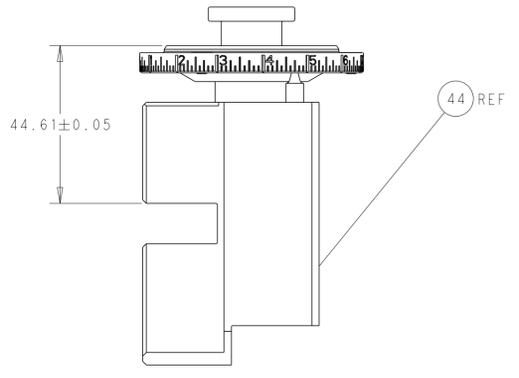
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-15-007055	06MAY2015	MR	TE
		C		ECR-19-002971	24FEB2019	TB	CT
		D		ECR-19-005053	28MAR2019	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	2119082-4	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					
-	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					
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84					
-	1	1	1	1	1-455888-6	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	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	469633-5	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	1	455961-5	PLATE, FRONT SHEAR	11					
-	2	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10					
1	-	1	1	1	461160-1	PLATE, REAR SHEAR	9					
1	1	2	2	1	1	5-1803000-1	ANVIL, COMBINATION, END FEED	8				
1	-	1	1	1	1	2161927-1	BLADE, SLUG	7				
-	-	-	-	-	-	-	6					
-	-	-	-	-	-	-	5					
-	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4				
1	1	2	2	1	1	1-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3				
-	1	1	1	1	1	1-455888-4	SPACER, CRIMPER	2				
1	1	2	2	1	1	1803006-6	CRIMPER, WIRE	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

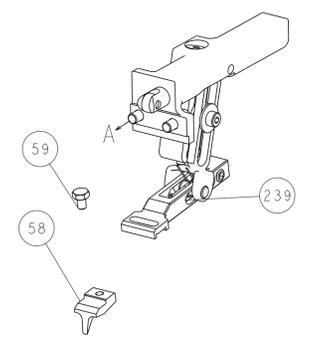
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:		
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:1	SHEET	1	OF	4
APPROVED:		DATE:		DRAWING NO:		CAGE CODE:		DRAWING NO:		SCALE:		SHEET:		REV:		
CHK: J. HOU		18 JUNE 2014		00779		C=2150447		1:1		1		4		D		

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

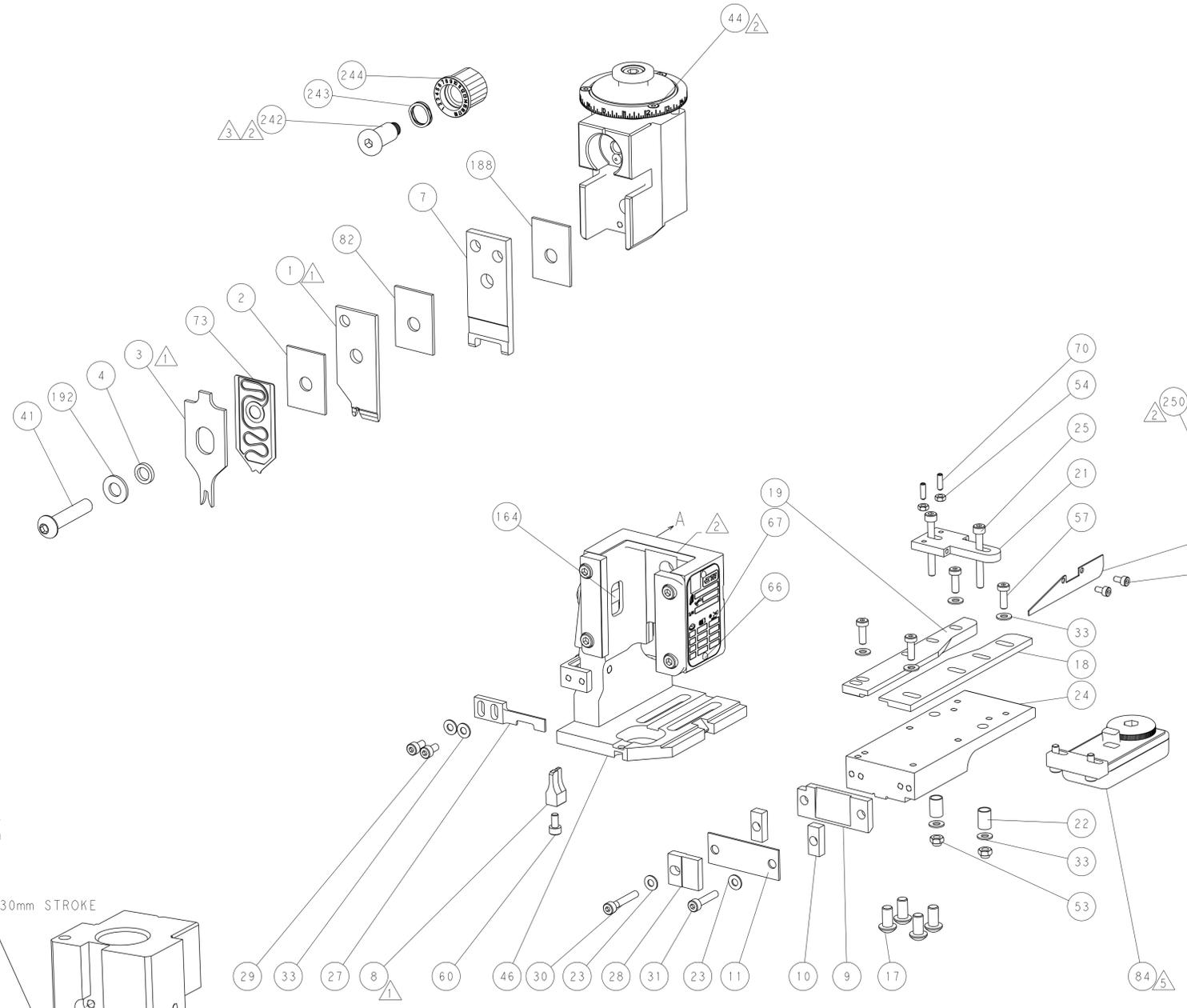
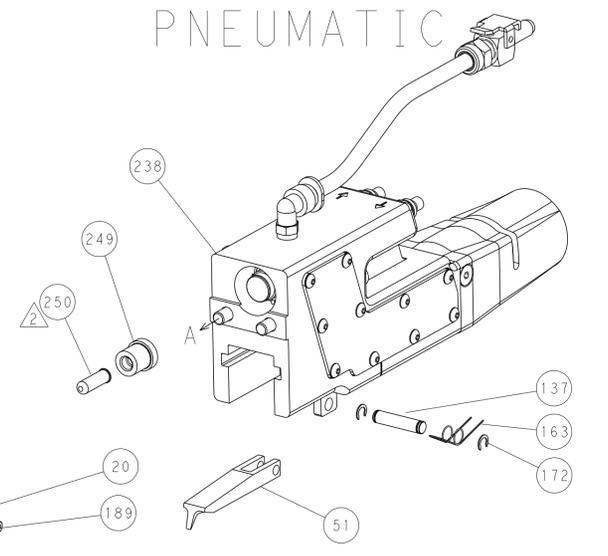


RAM SET-UP

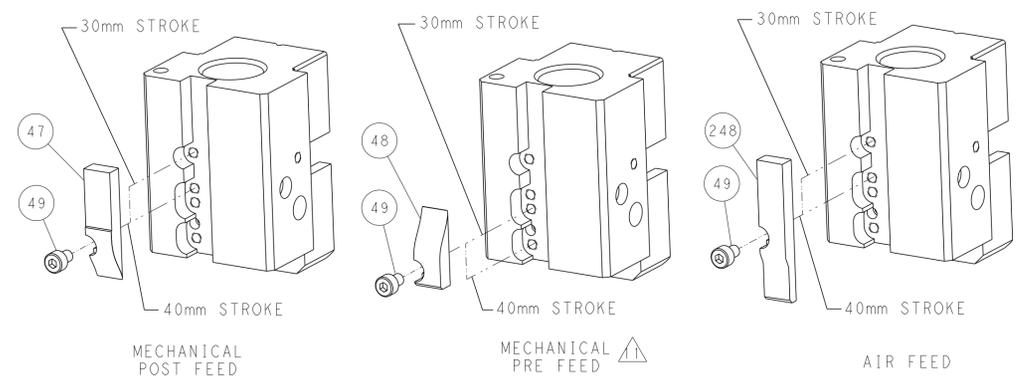
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

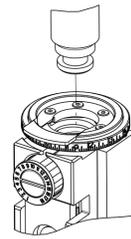


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J. HOU 18JUNE2014 CHK: L. ZHANG 18JUNE2014 APVD: H. GUO 18JUNE2014	TE Connectivity
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150447 RESTRICTED TO: -
MATERIAL: - FINISH: -		SCALE: 1:1 SHEET: 2 of 4 REV: D	Customer Accessible Production Drawing

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150447-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150447-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150447-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	2.79 mm (.110)	OV
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)		∅1.52-2.79 mm (.060-.110 IN)
TERMINAL APPLICATION SPECIFICATION	114-2079	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1742086-1	1742086-2	1742087-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27 +/- 0.05 [.050 +/- .002]	5.4
20 AWG	1.14 +/- 0.05 [.045 +/- .002]	6.7
22 AWG	1.06 +/- 0.05 [.042 +/- .002]	7.6

- 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.

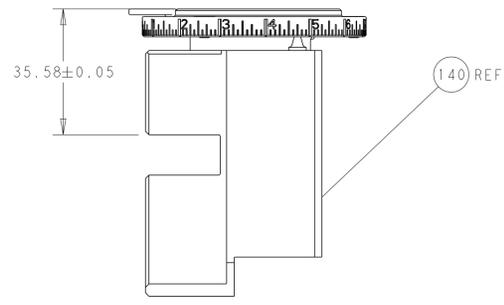
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	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	1-455888-6	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	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	469633-5	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	461160-1	PLATE, REAR SHEAR	9
-	1	1	5-1803000-1	ANVIL, COMBINATION, END FEED	8
-	1	1	2161927-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	1	1803006-6	CRIMPER, WIRE	1
-	77-22-21	-	PART NO	DESCRIPTION	ITEM NO

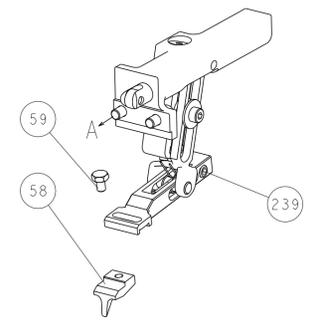
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2150447 Customer Accessible Production Drawing SCALE 1:1 SHEET 3 OF 4 REV D

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

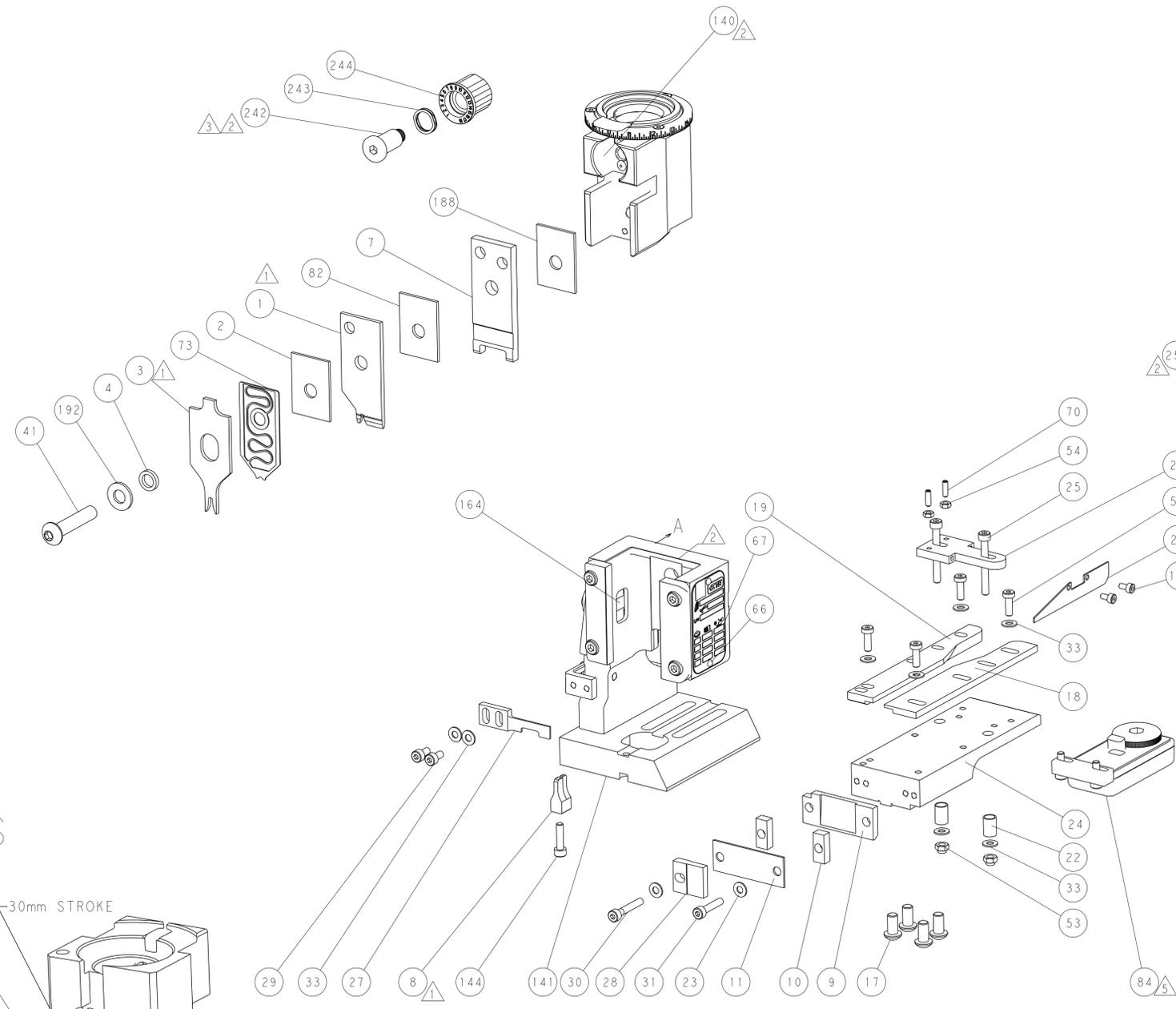
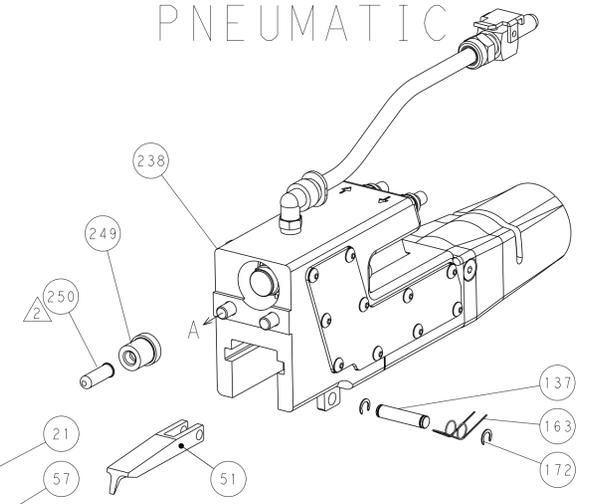


RAM SET-UP

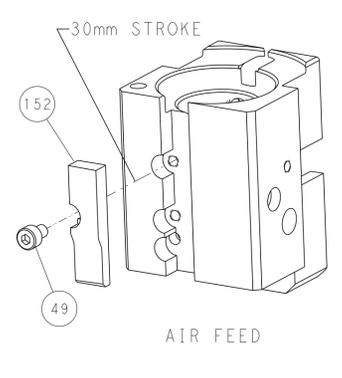
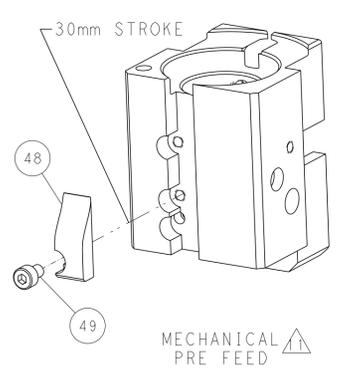
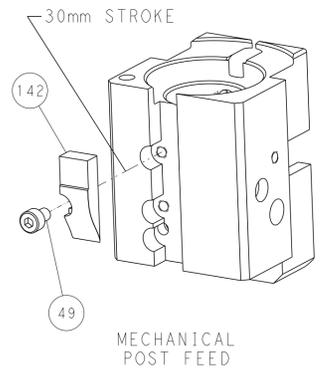
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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:		OWN		18 JUNE 2014		STE TE Connectivity	
mm	0 PLC	±		CHK	J. HOU	18 JUNE 2014		NAME	
	1 PLC	±		CHK	L. ZHANG	18 JUNE 2014		Ocean End Feed	
	2 PLC	±		APVD	J. GUO	18 JUNE 2014		Applicator	
	3 PLC	±		PRODUCT SPEC				SIZE	
	4 PLC	±		APPLICATION SPEC				CAGE CODE	
	ANGLES	±		WEIGHT				DRAWING NO	
	FINISH	±		MATERIAL				RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4	
						REV D			