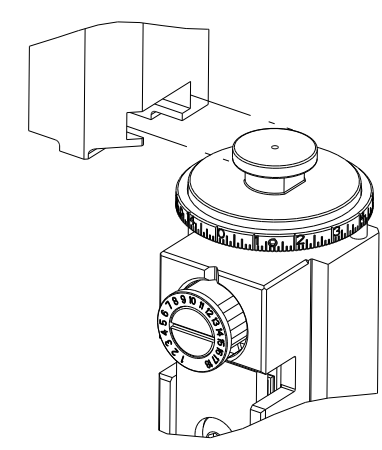


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150214-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150214-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150214-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE M.I.C. IV			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.58-4.59 mm [.180-.181 IN]		Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-15036		
	(B)114-15003		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 144180-1	(B) 142183-2	(B) 142183-5	(B) 3-142183-1
(A) 142647-1	(B) 142183-3	(B) 1-142183-1	
(B) 142183-1	(B) 142183-4	(B) 2-142183-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48+/-0.050 [.058+/-0.002]	6.9
0.35+0.6	1.48+/-0.050 [.058+/-0.002]	6.9
0.75mm2	1.41+/-0.050 [.056+/-0.002]	7.5
0.35+0.35	1.36+/-0.050 [.054+/-0.002]	8.1
0.60mm2	1.32+/-0.050 [.052+/-0.002]	8.5
0.50mm2	1.27+/-0.050 [.050+/-0.002]	9.1
0.35mm2	1.21+/-0.050 [.048+/-0.002]	9.7

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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)

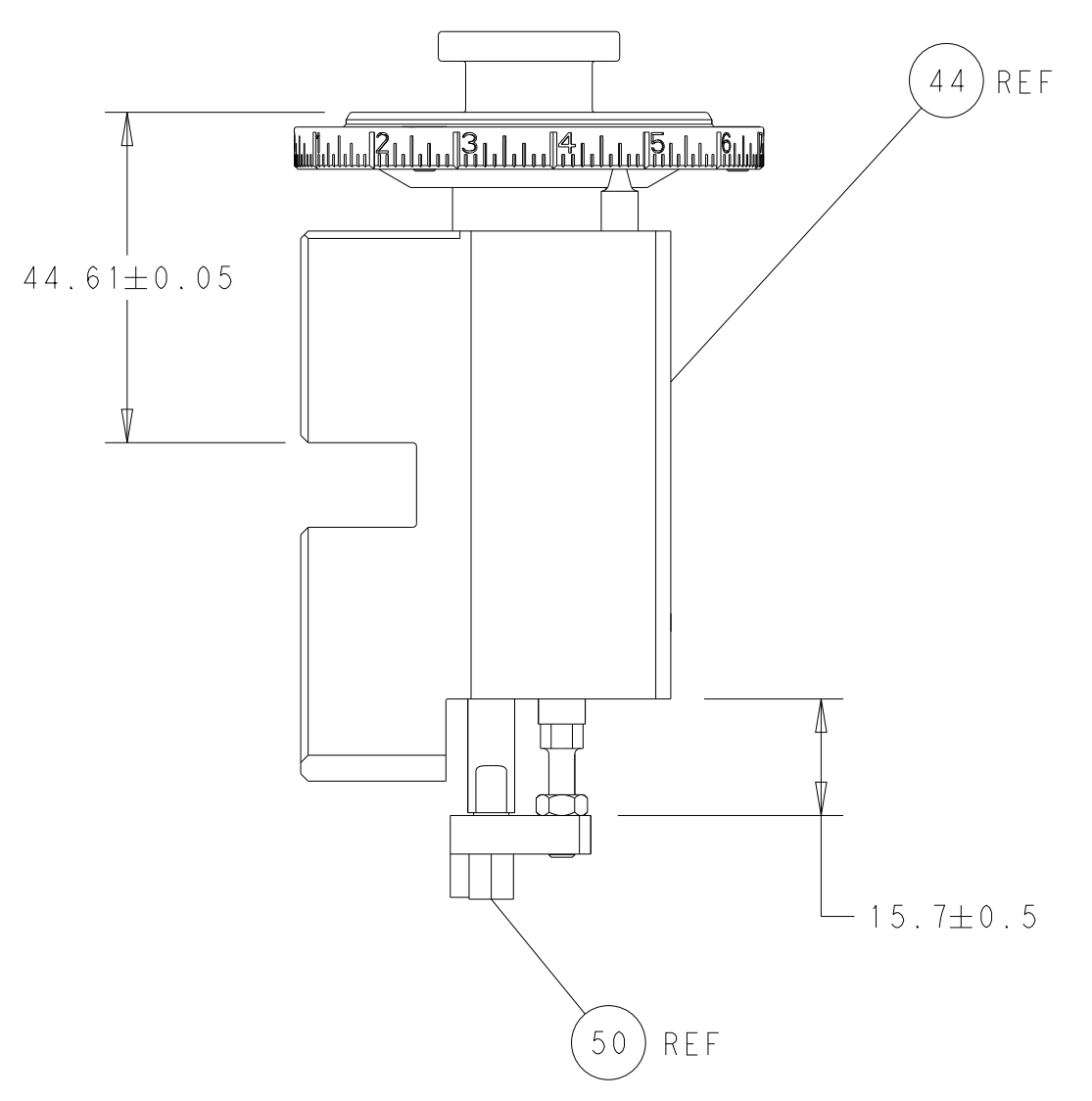
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		A		RELEASED	07JUN2012	YY	SX
		B		REVISED ECR-12-010723	13JUN2012	CC	SX
		C		ECR-15-000050	05JAN2015	JH	TE
		D		ECR-22-160252	05DEC2022	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	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	1	2844940-4	AIR FEED MODULE	238		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
-	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	1	455888-5	SPACER, CRIMPER	82		
-	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	1901681-1	HOLDDOWN, TERMINAL	65		
-	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		
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1	2063961-9	FEED FINGER	51		
-	1	1	1752354-9	STANDOFF,HOLD-DOWN	50		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46		
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44		
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	8	8	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	240639-1	STRIPPER (MACHINING)	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	2-1752371-0	PLATE, STRIP GUIDE	24		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-1	DRAG	20		
-	2	2	1901259-4	GUIDE, LOWER STRIP	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	1752360-1	SPACER,HOLD-DOWN	13		
-	1	1	240644-1	PLATE, REAR SHEAR	11		
-	1	1	690482-5	PLATE, FRONT SHEAR	9		
-	1	2	1	1338686-1	ANVIL, COMBINATION	8	
-	1	1	1	690474-5	BLADE, SLUG	7	
-	1	1	1	5-240641-5	SPACER	5	
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	1	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	455888-5	SPACER, CRIMPER	2	
-	1	2	1	456418-2	CRIMPER, WIRE, .070 "F"	1	
-	77	72	2	PART NO			
-				DESCRIPTION			ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES FINISH
MATERIAL				WEIGHT			

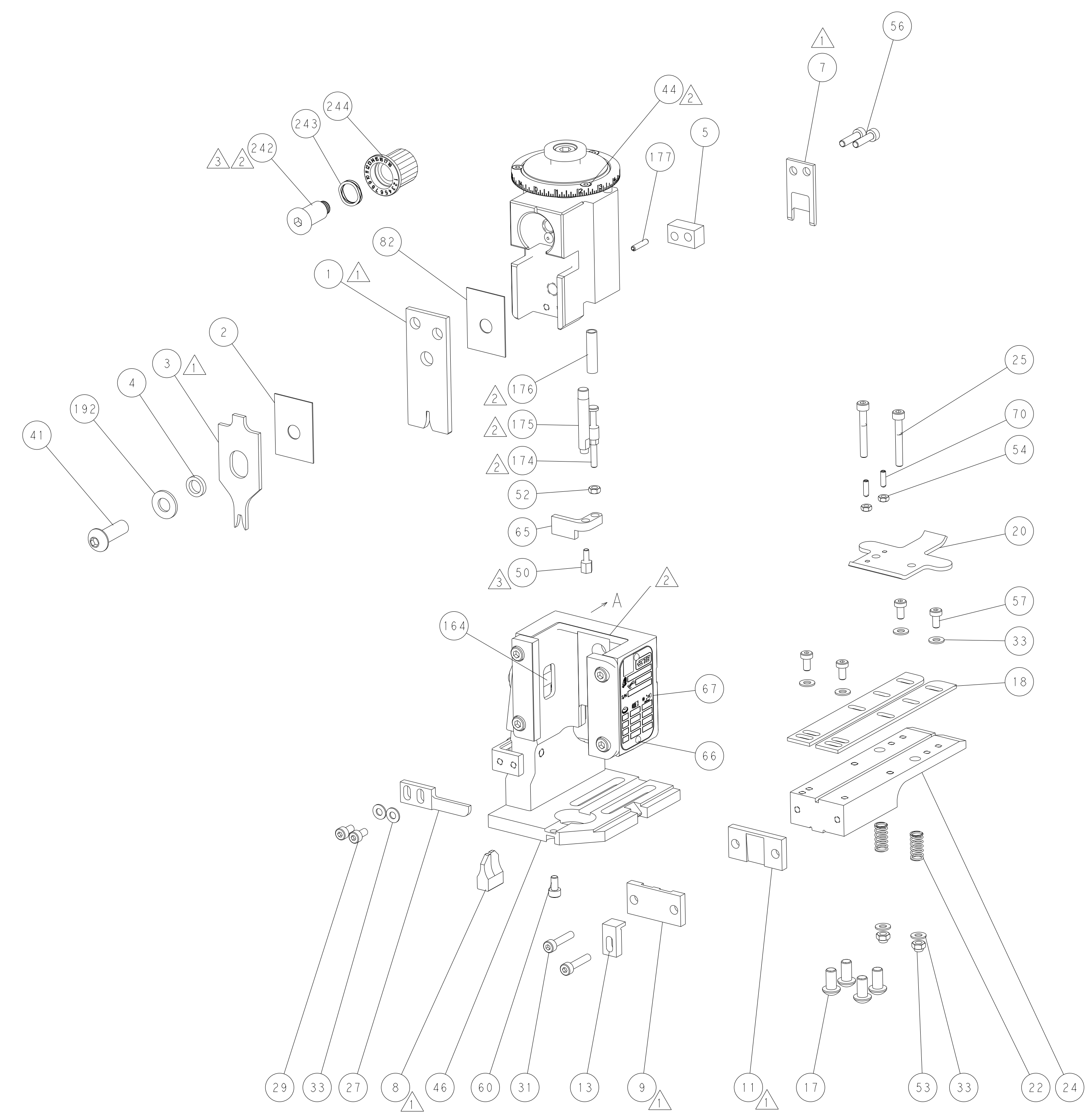
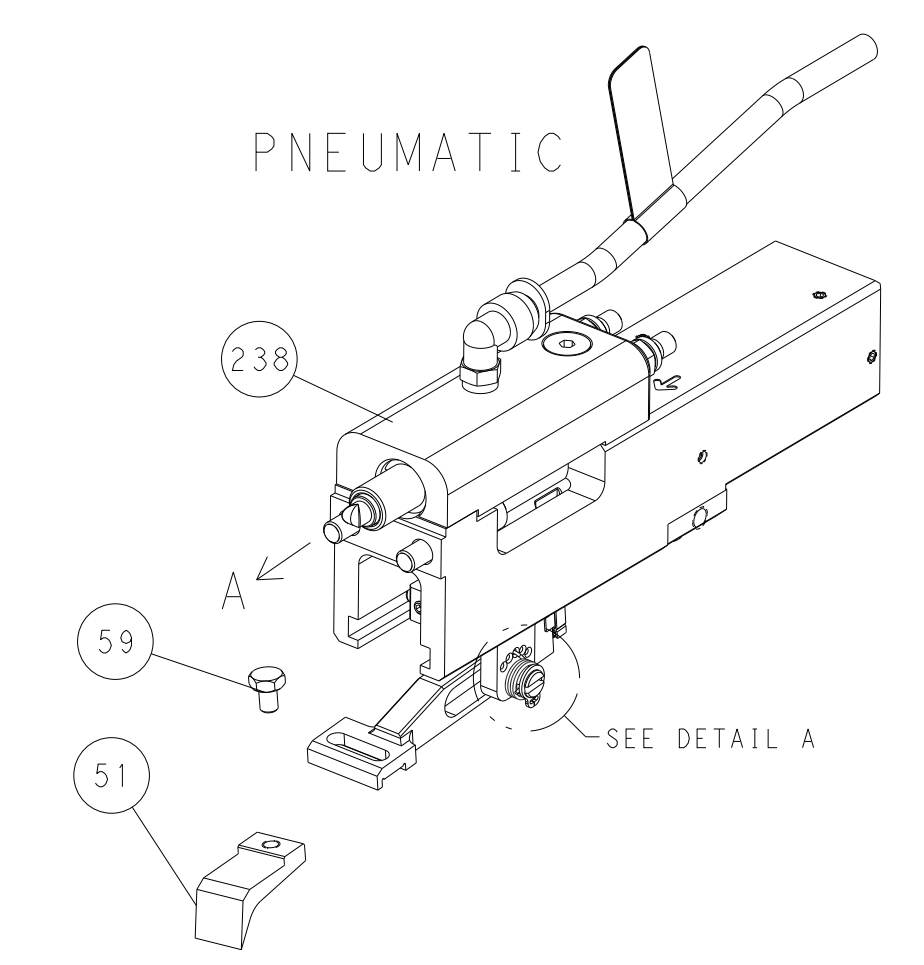
CHK	Y. YIN	23MAR2012	
CHK	G. BAILEY	23MAR2012	
APVD	S. XI	23MAR2012	
NAME	Ocean End Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150214	
Customer Accessible Production Drawing		SCALE	SHEET 1 of 4
		1:1	REV D

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

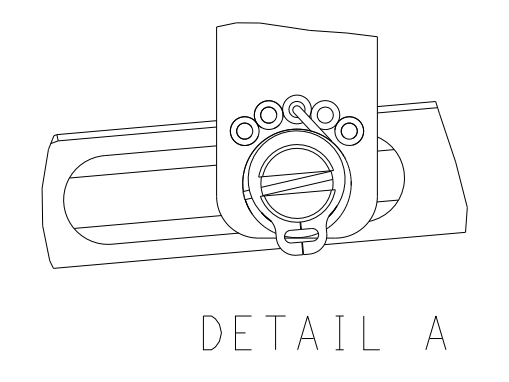


RAM AND HOLDDOWN SET-UP

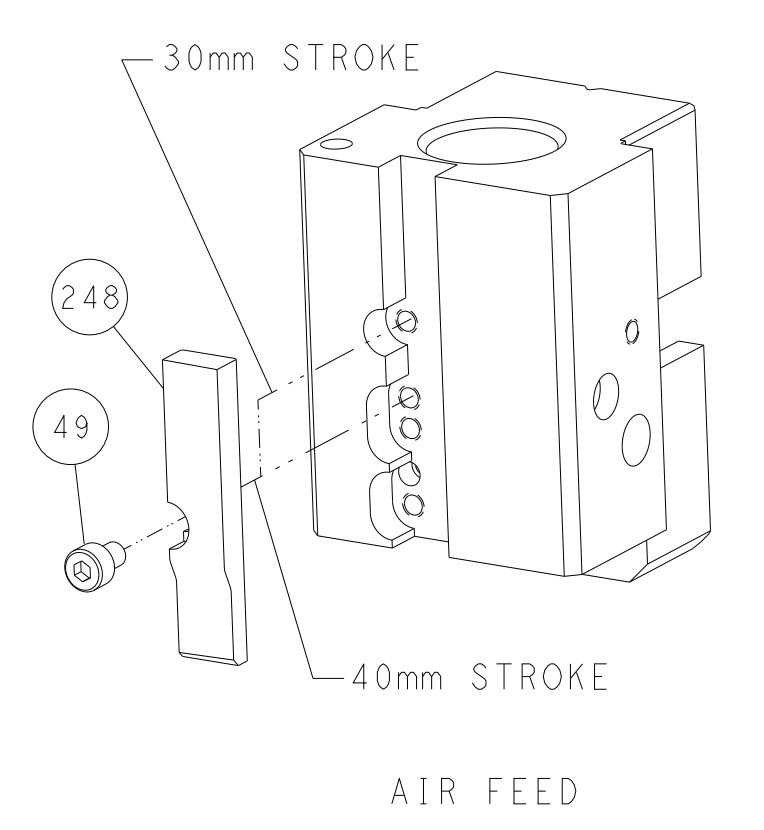
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

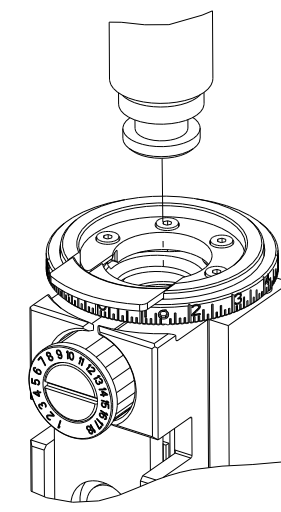


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: Y. YIN 23MAR2012 CHK: G. BAILEY 23MAR2012 APVD: S. XI 23MAR2012	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:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150214 SCALE: 1:1	RESTRICTED TO: SHEET 2 OF 4 REV D
Customer Accessible Production Drawing			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150214-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150214-7	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)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE M.I.C. IV			
WIRE STRIP LENGTH 4.58-4.59 mm (.180-.181 IN)		INSULATION DIAMETER RANGE Ø1.30-2.00 mm (.051-.079 IN)	
TERMINAL APPLICATION SPECIFICATION	(A)114-15036	-	-
	(B)114-15003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 144180-1	(B) 142183-2	(B) 142183-5	(B) 3-142183-1
(A) 142647-1	(B) 142183-3	(B) 1-142183-1	
(B) 142183-1	(B) 142183-4	(B) 2-142183-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48 +/- 0.050 [.058 +/- .002]	6.9
0.35+0.6	1.48 +/- 0.050 [.058 +/- .002]	6.9
0.75mm2	1.41 +/- 0.050 [.056 +/- .002]	7.5
0.35+0.35	1.36 +/- 0.050 [.054 +/- .002]	8.1
0.60mm2	1.32 +/- 0.050 [.052 +/- .002]	8.5
0.50mm2	1.27 +/- 0.050 [.050 +/- .002]	9.1
0.35mm2	1.21 +/- 0.050 [.048 +/- .002]	9.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

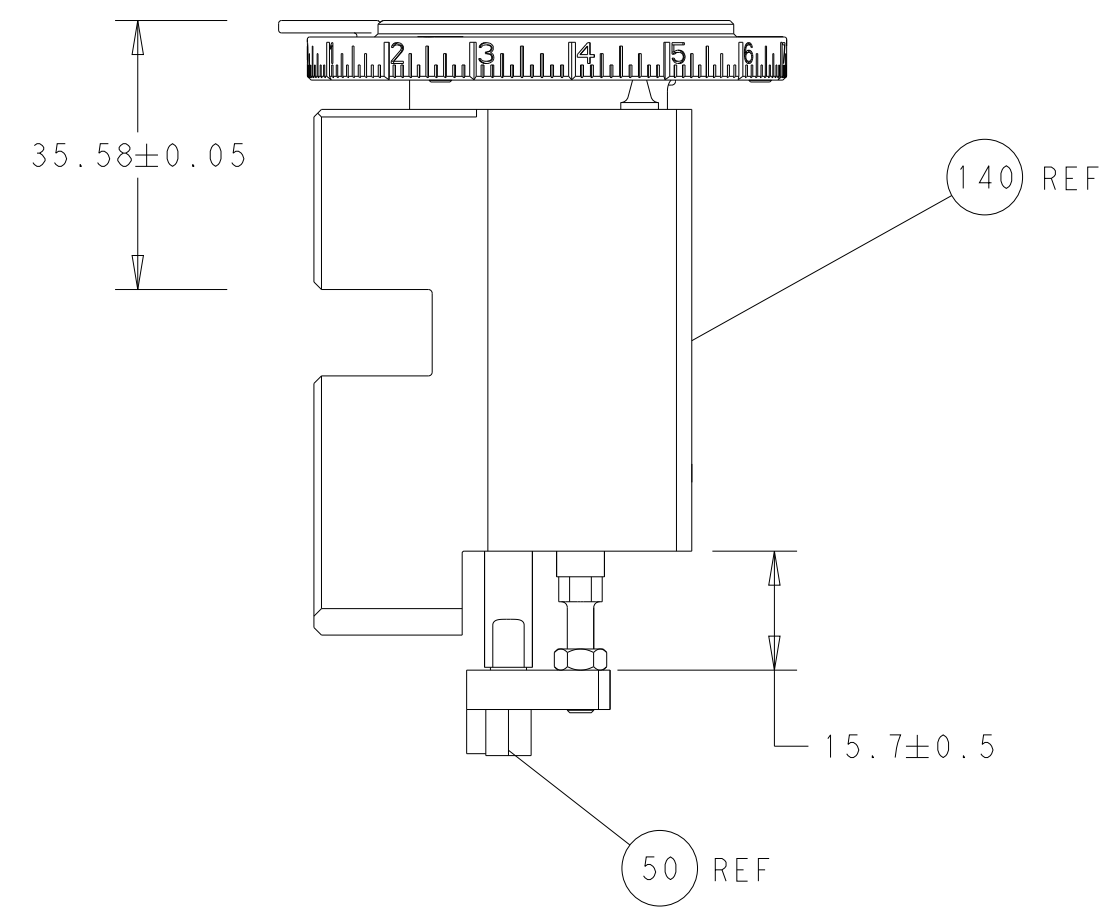
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-9	FEED FINGER	51
-	1	1752354-9	STANDOFF, HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-1	DRAG	20
-	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1338686-1	ANVIL, COMBINATION	8
-	1	690474-5	BLADE, SLUG	7
-	1	5-240641-5	SPACER	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	456418-2	CRIMPER, WIRE, .070 "F"	1

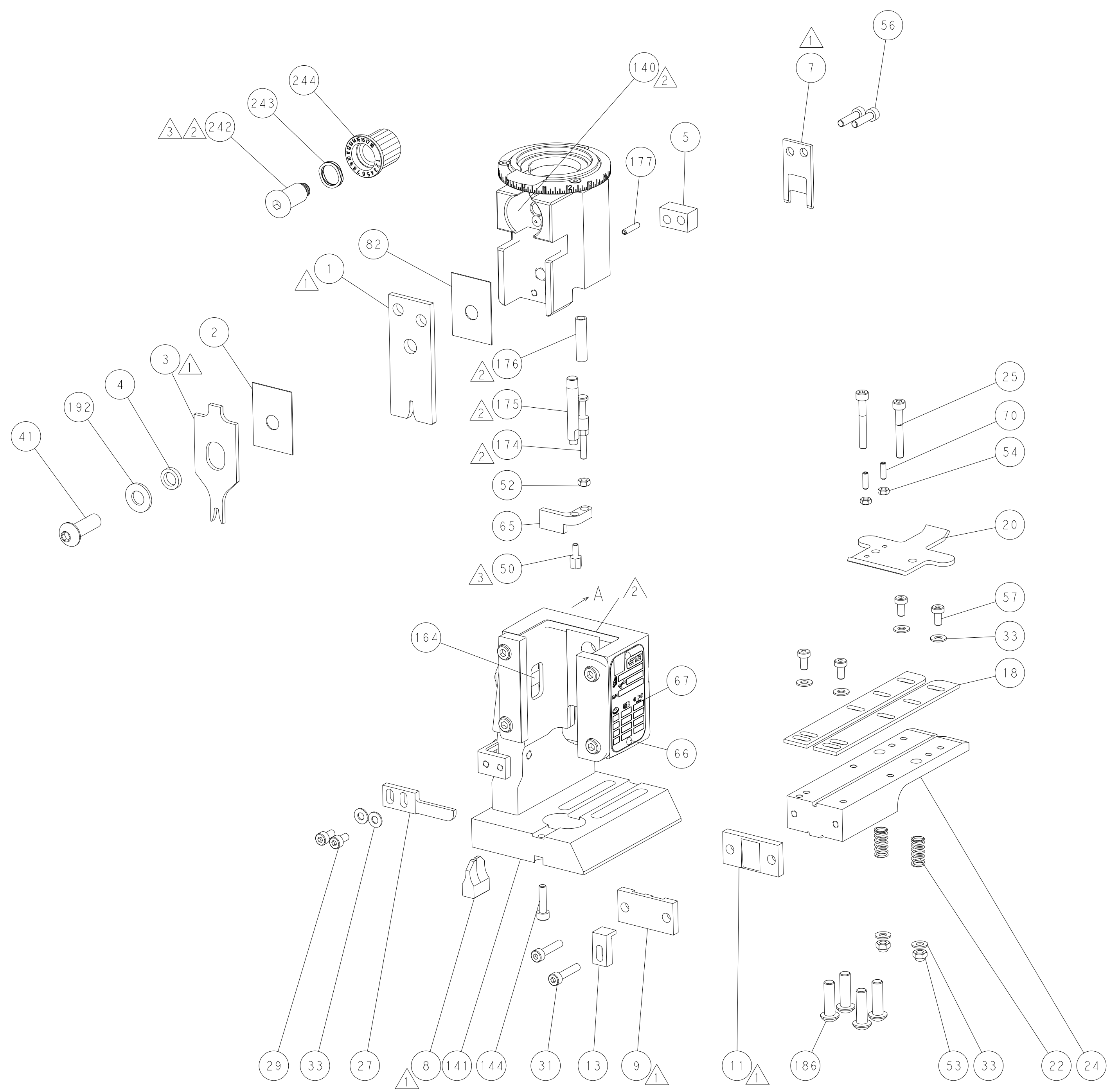
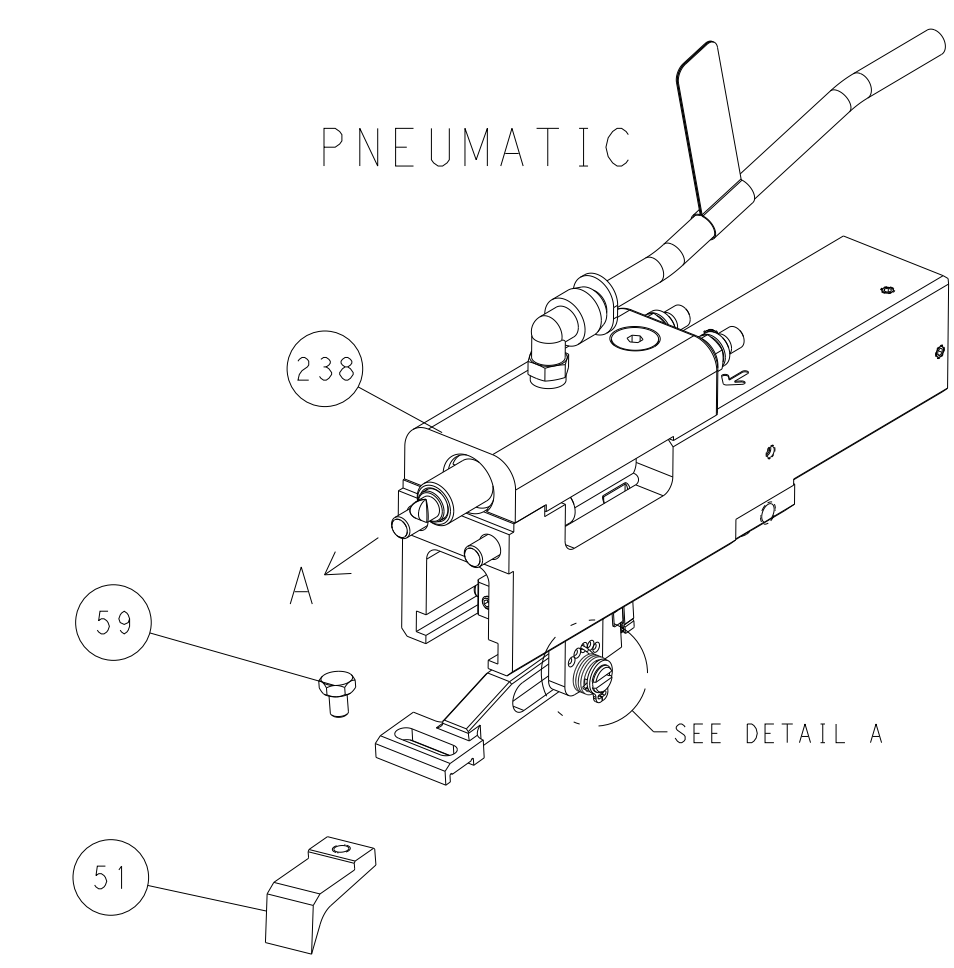
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		23MAR2012		TE Connectivity	
mm		0 PLC ±		CHK		23MAR2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		G. BAILEY				Ocean End Feed	
H		2 PLC ±		S. XI		23MAR2012		Applicator	
L		3 PLC ±		APVD					
R		4 PLC ±		S. XI					
T		5 PLC ±		PRODUCT SPEC					
A		6 PLC ±		APPLICATION SPEC					
B		7 PLC ±		WEIGHT					
C		8 PLC ±		SCALE		1:1		SHEET 3 OF 4	
D		9 PLC ±		RESTRICTED TO					
E		10 PLC ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING					
F		11 PLC ±		SCALE		1:1		REV D	
G		12 PLC ±		SCALE		1:1		REV D	
H		13 PLC ±		SCALE		1:1		REV D	
I		14 PLC ±		SCALE		1:1		REV D	
J		15 PLC ±		SCALE		1:1		REV D	
K		16 PLC ±		SCALE		1:1		REV D	
L		17 PLC ±		SCALE		1:1		REV D	
M		18 PLC ±		SCALE		1:1		REV D	
N		19 PLC ±		SCALE		1:1		REV D	
O		20 PLC ±		SCALE		1:1		REV D	
P		21 PLC ±		SCALE		1:1		REV D	
Q		22 PLC ±		SCALE		1:1		REV D	
R		23 PLC ±		SCALE		1:1		REV D	
S		24 PLC ±		SCALE		1:1		REV D	
T		25 PLC ±		SCALE		1:1		REV D	
U		26 PLC ±		SCALE		1:1		REV D	
V		27 PLC ±		SCALE		1:1		REV D	
W		28 PLC ±		SCALE		1:1		REV D	
X		29 PLC ±		SCALE		1:1		REV D	
Y		30 PLC ±		SCALE		1:1		REV D	
Z		31 PLC ±		SCALE		1:1		REV D	

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

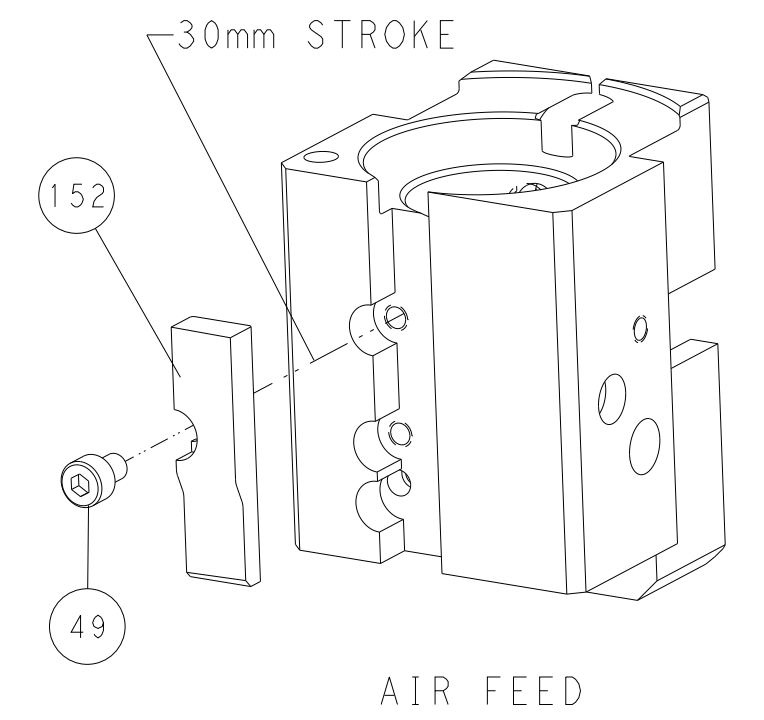


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



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 23MAR2012 CHK G. BAILEY 23MAR2012 APVD S. XI 23MAR2012 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		STE TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150214 RESTRICTED TO Customer Accessible Production Drawing	
MATERIAL				SHEET 4 OF 4		REV D	