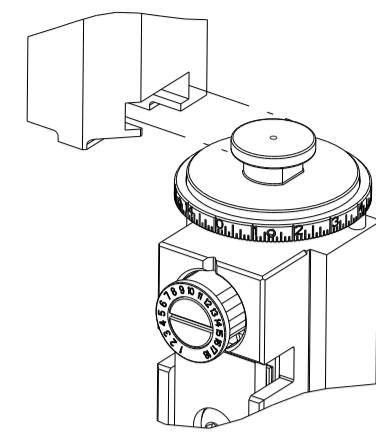


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150447-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150447-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150447-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150447-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150447-7	A	CRIMP TOOLING KIT	-

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
1742087-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27+/-0.05 [.050+/-0.002]	5.4
20 AWG	1.14+/-0.05 [.045+/-0.002]	6.7
22 AWG	1.06+/-0.05 [.042+/-0.002]	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.

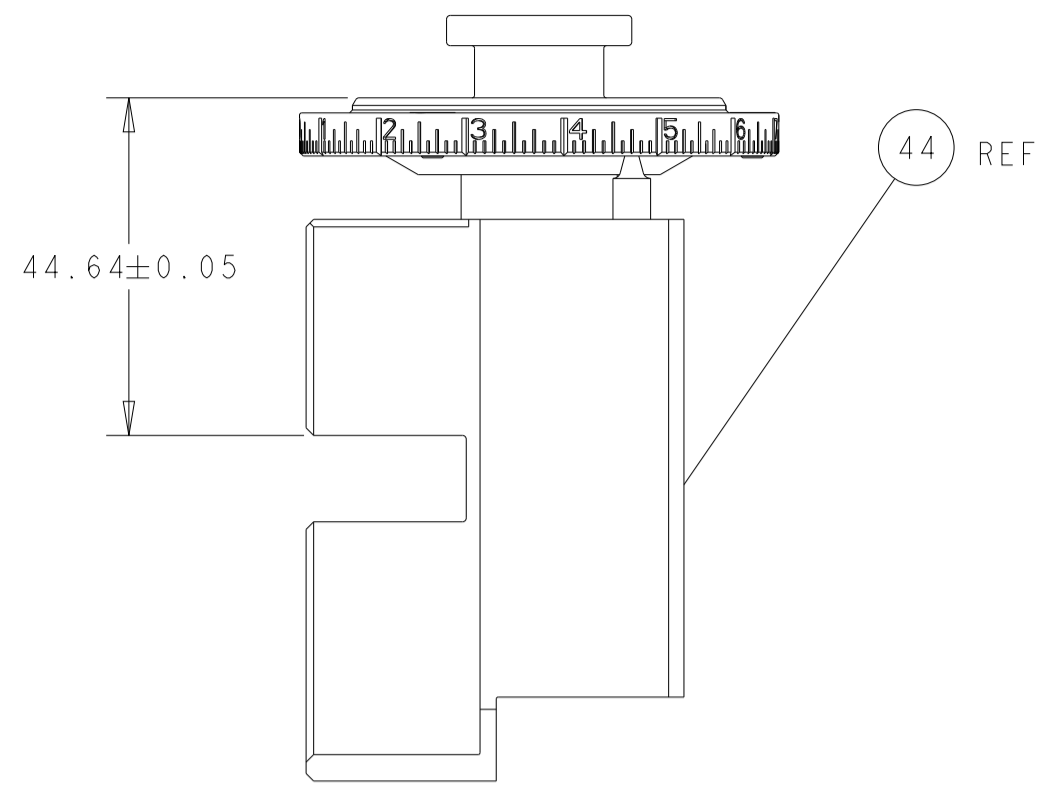
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	D		ECR-19-005053	28MAR2019	TB	GB
		D1		ECR-20-017908	17DEC2020	JWC	GB
		E		ECR-21-006510	27JUN2021	TB	RK
		E1		ECR-22-160690	08DEC2022	FZ	JAH

-	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	-	2844940-3	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
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	1803607-4	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	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	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	-	2161924-1	FEED FINGER	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	
1	-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	1	455961-5	PLATE, FRONT SHEAR	11	
1	-	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

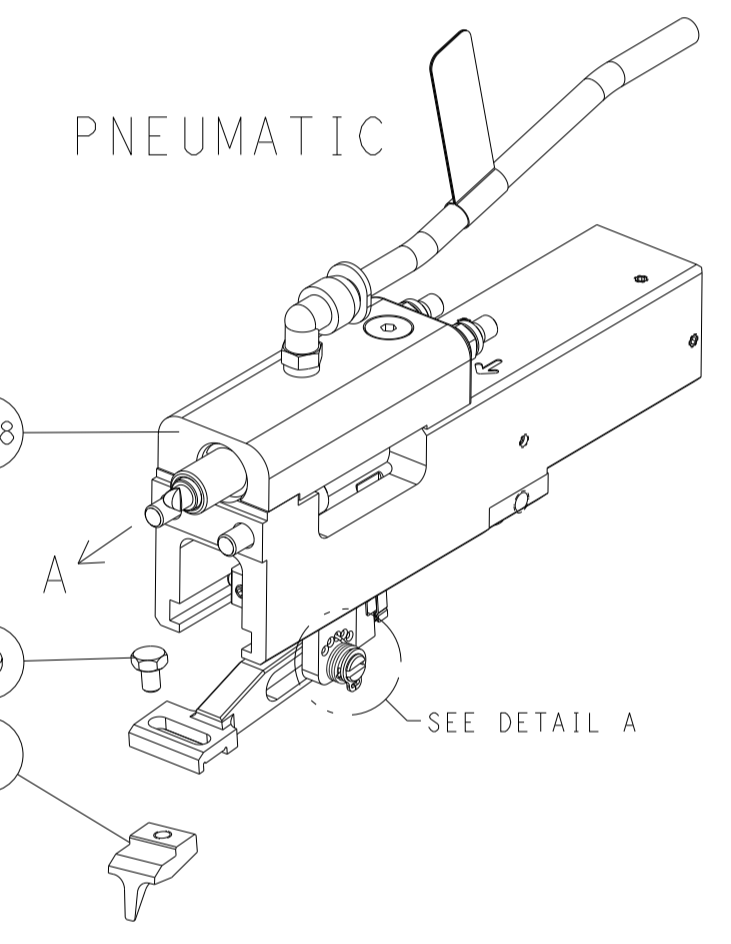
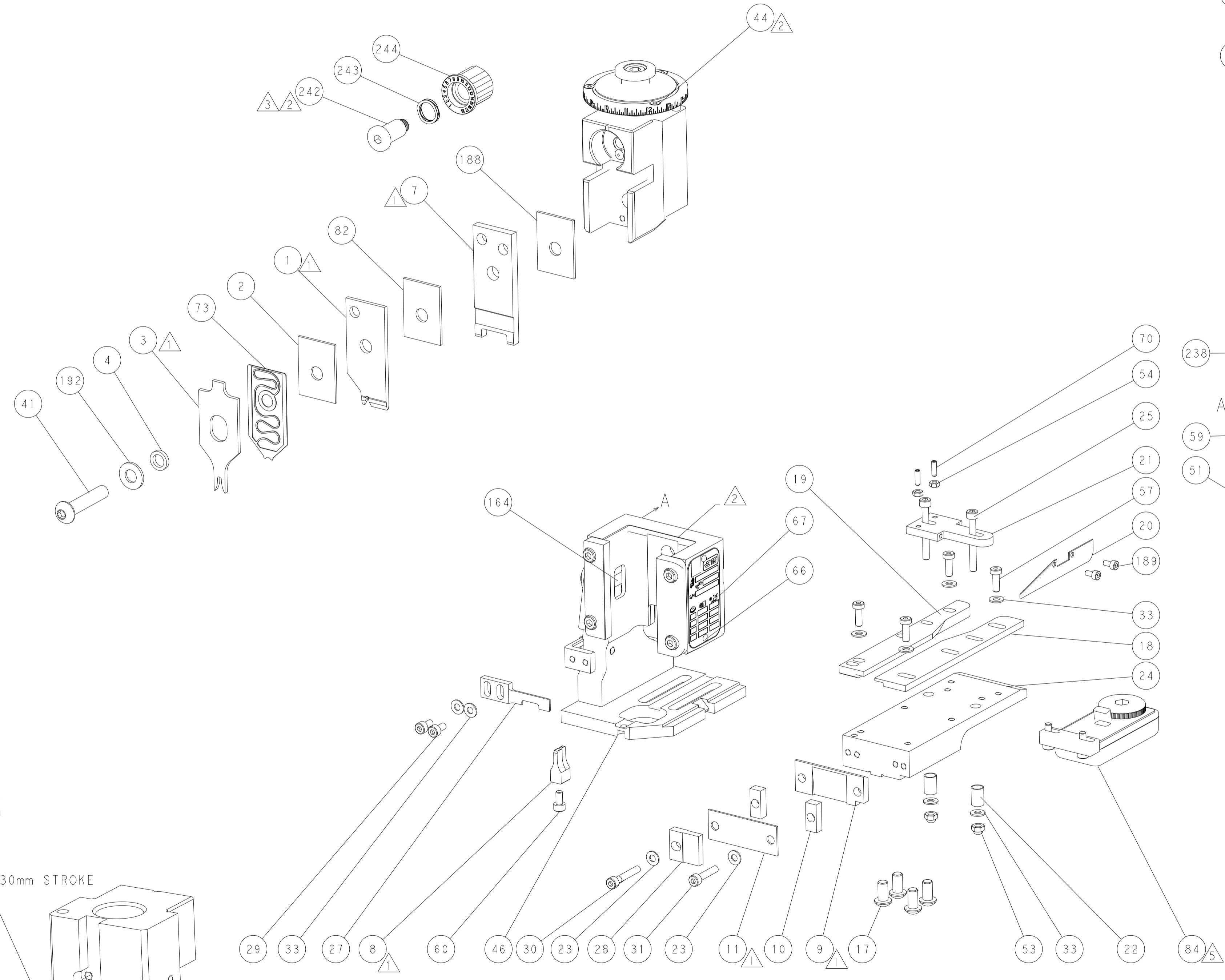
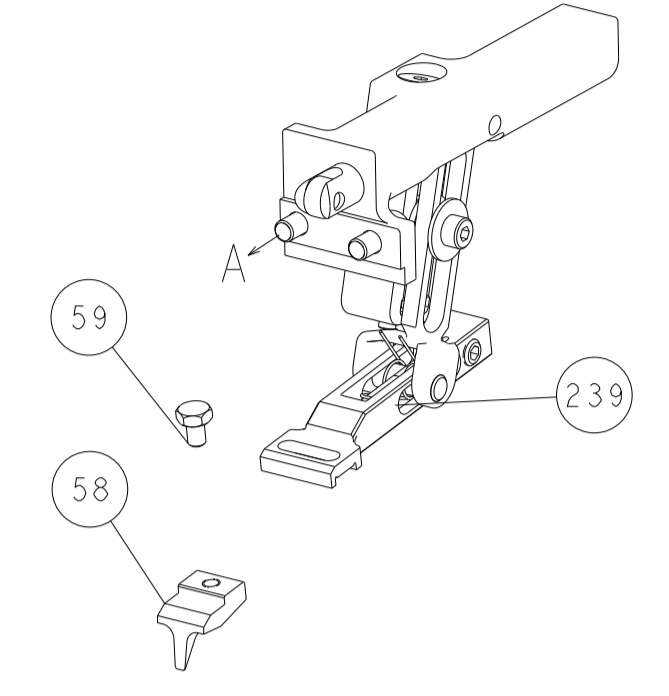
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	Customer Accessible Production Drawing	SCALE 1:1
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	

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

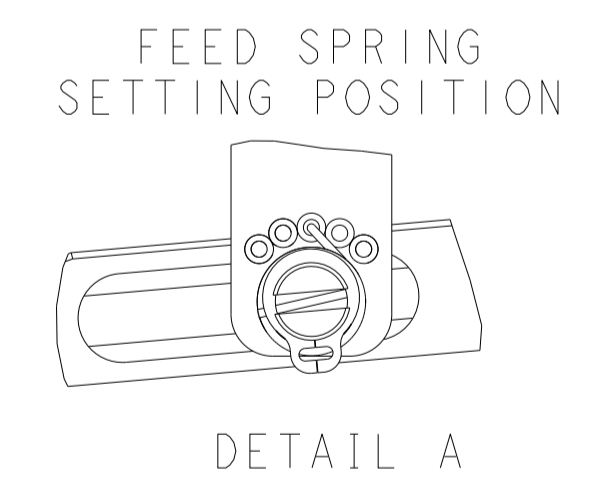


RAM SET-UP

FEED TYPE  
MECHANICAL



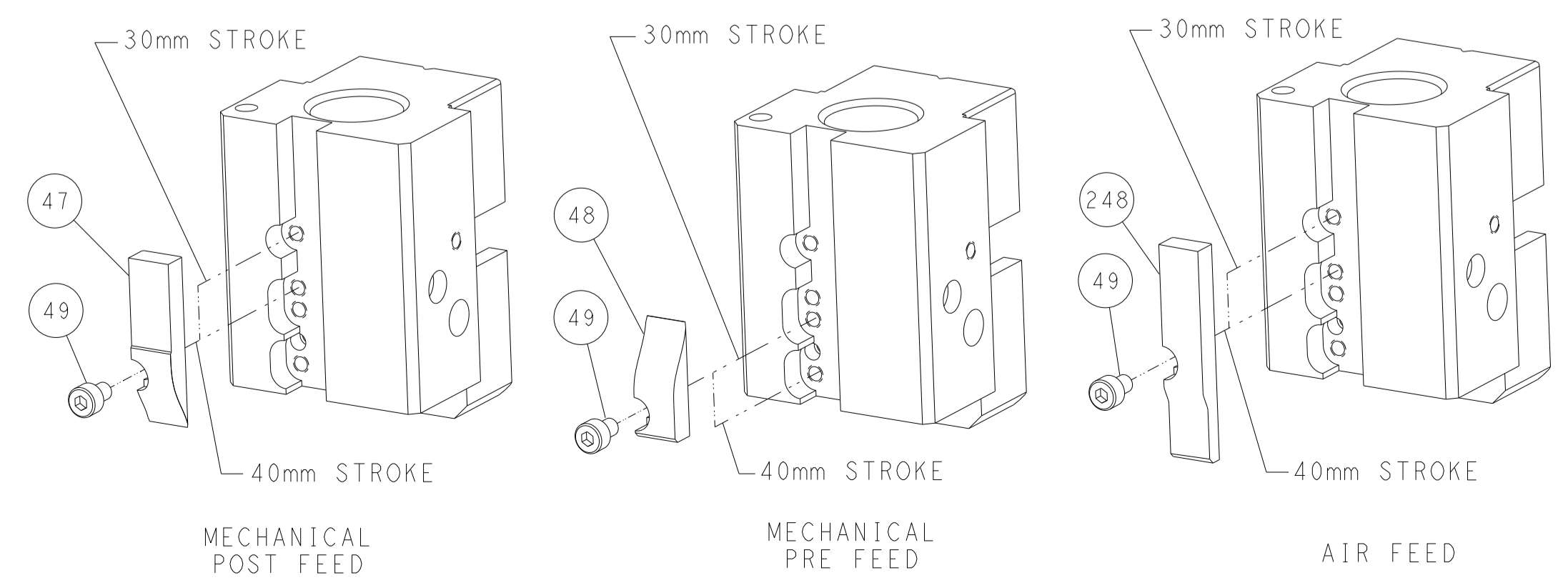
PNEUMATIC



FEED SPRING SETTING POSITION

DETAIL A

CAM POSITIONS

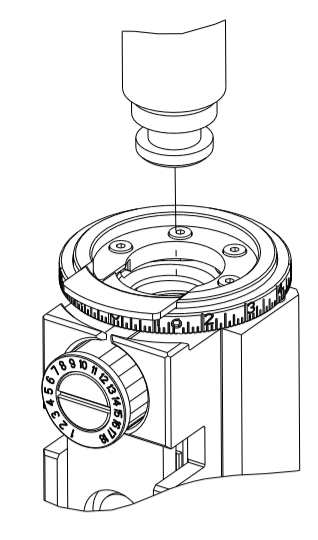


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150447	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: E1
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150447-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150447-2	E	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 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
1742087-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27+/-0.05 [.050+/-0.002]	5.4
20 AWG	1.14+/-0.05 [.045+/-0.002]	6.7
22 AWG	1.06+/-0.05 [.042+/-0.002]	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.

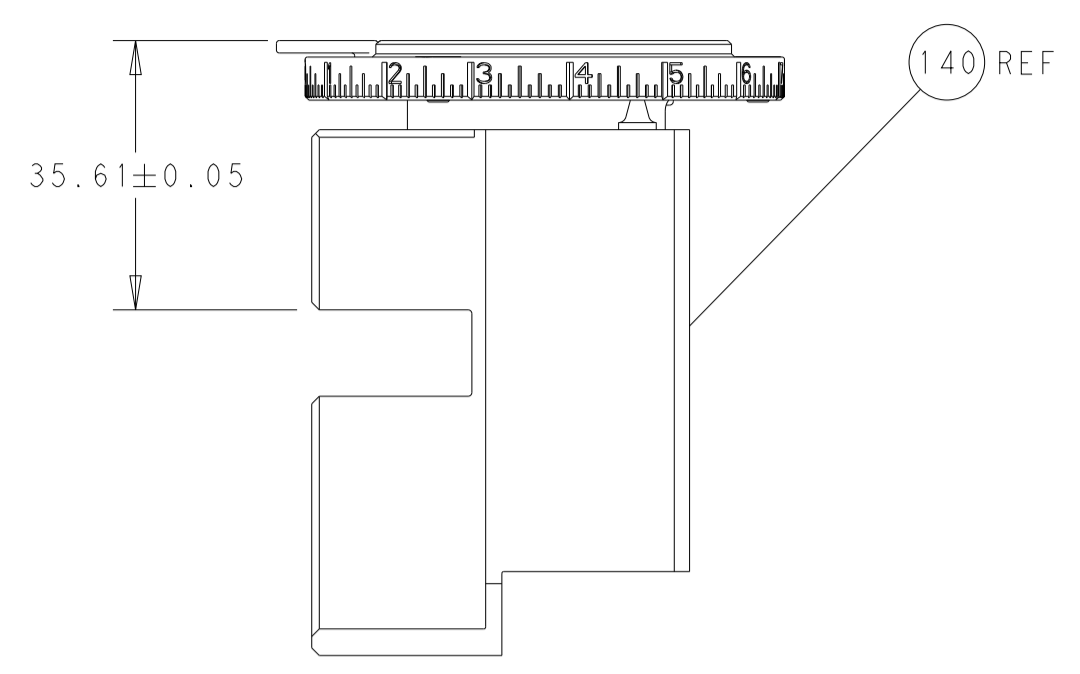
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	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	-	2844940-3	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	
-	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140	
-	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	1803607-4	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	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	-	2161924-1	FEED FINGER	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

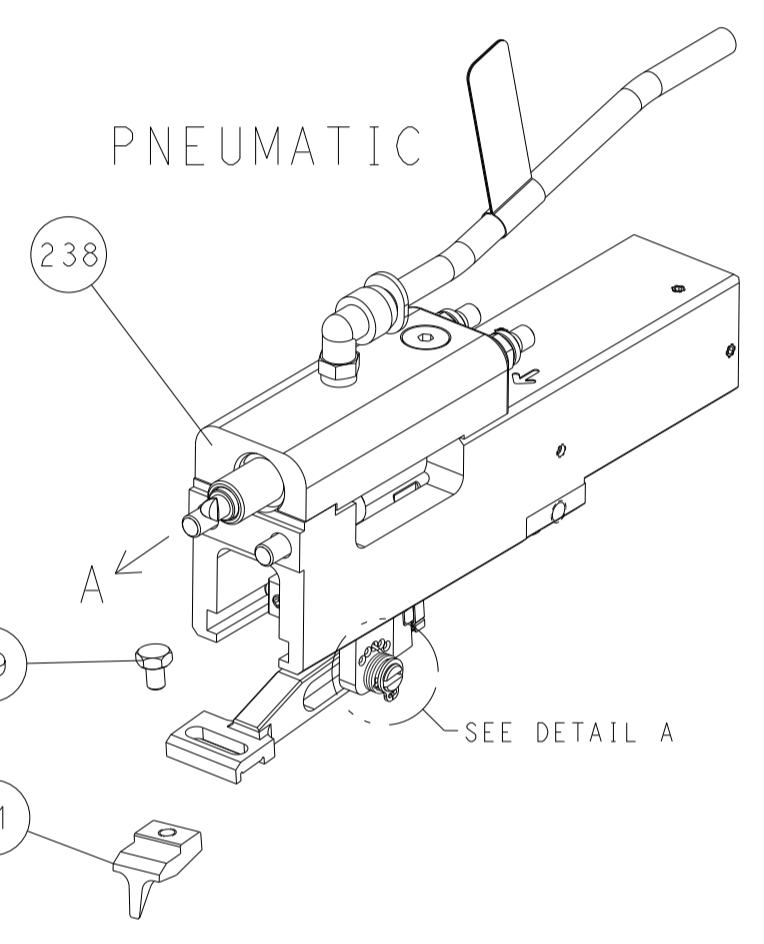
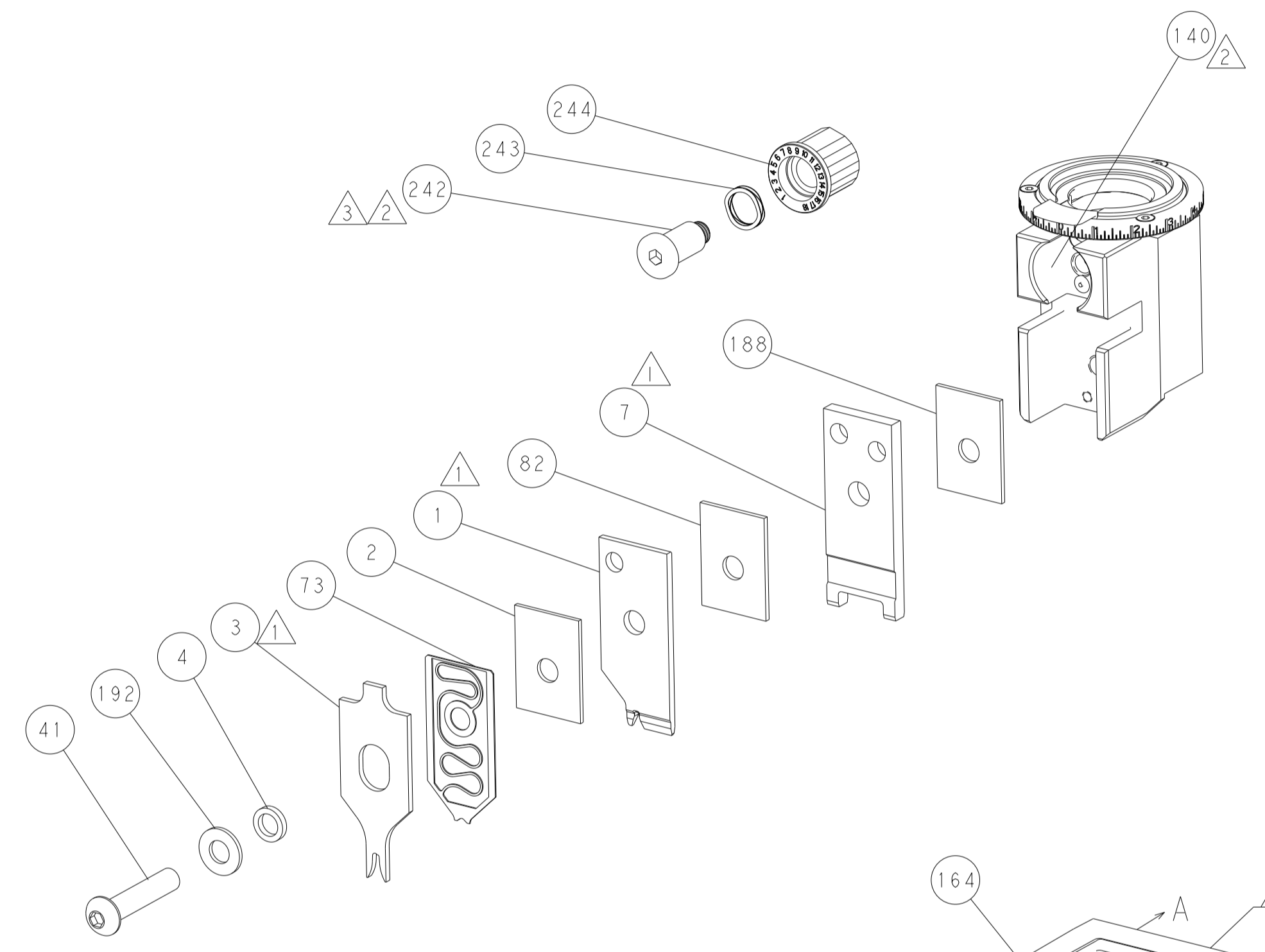
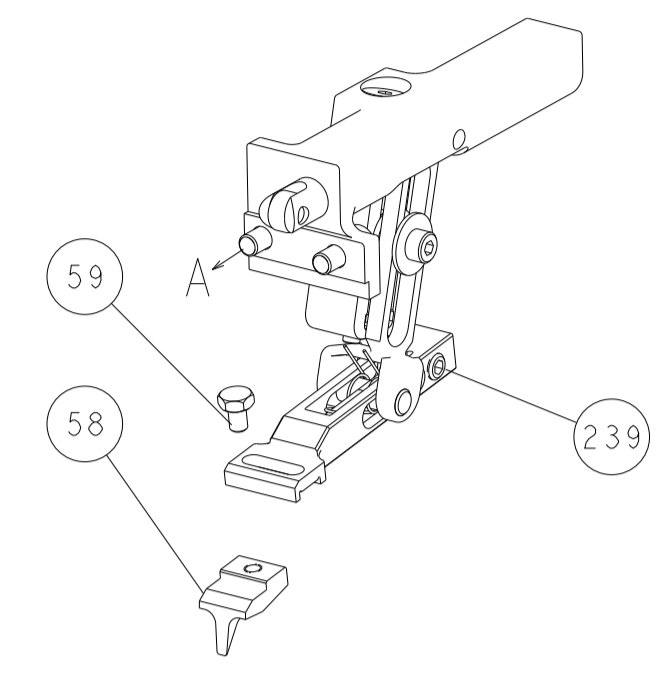
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 18JUNE2014		CHK: L. ZHANG 18JUNE2014		APVD: U. GUO 18JUNE2014		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET 3 OF 4		REV E1	
MATERIAL				Customer Accessible Production Drawing		SCALE: 1:1		SHEET 3 OF 4		REV E1	

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

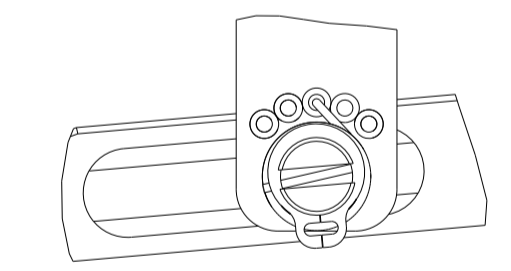


RAM SET-UP

FEED TYPE  
MECHANICAL

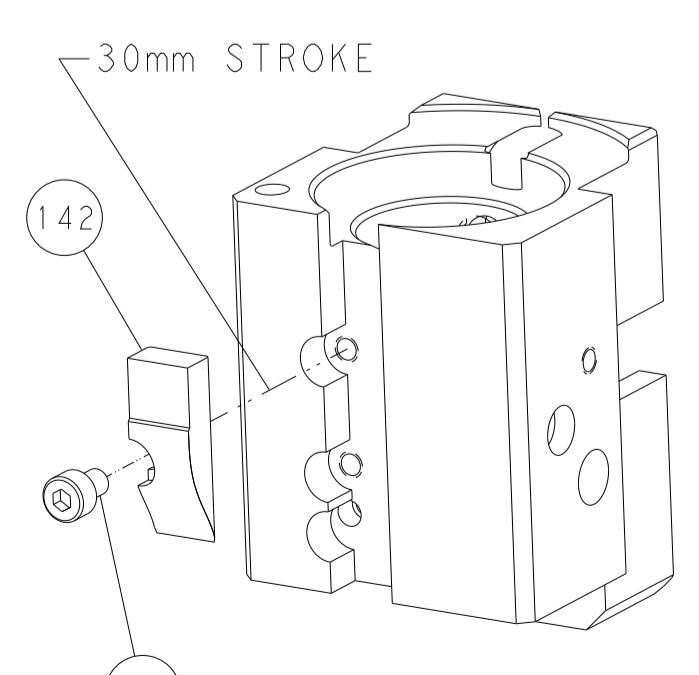


FEED SPRING  
SETTING POSITION

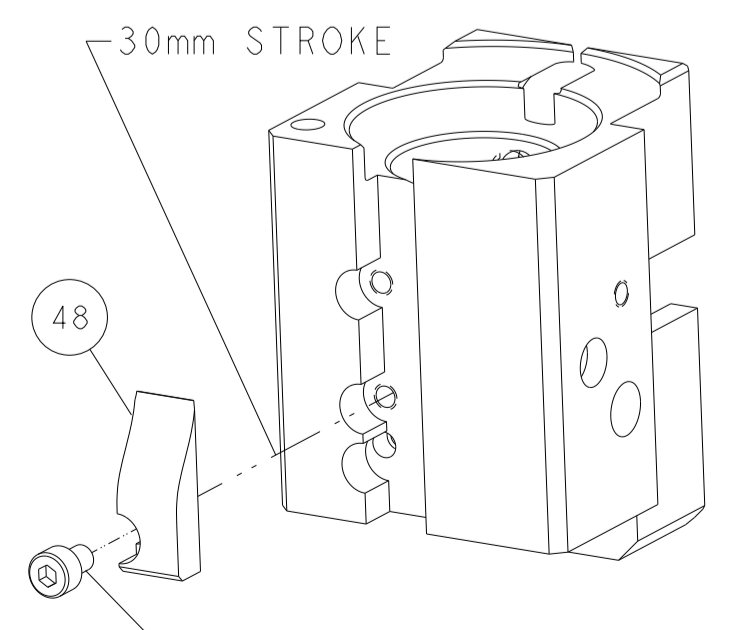


DETAIL A

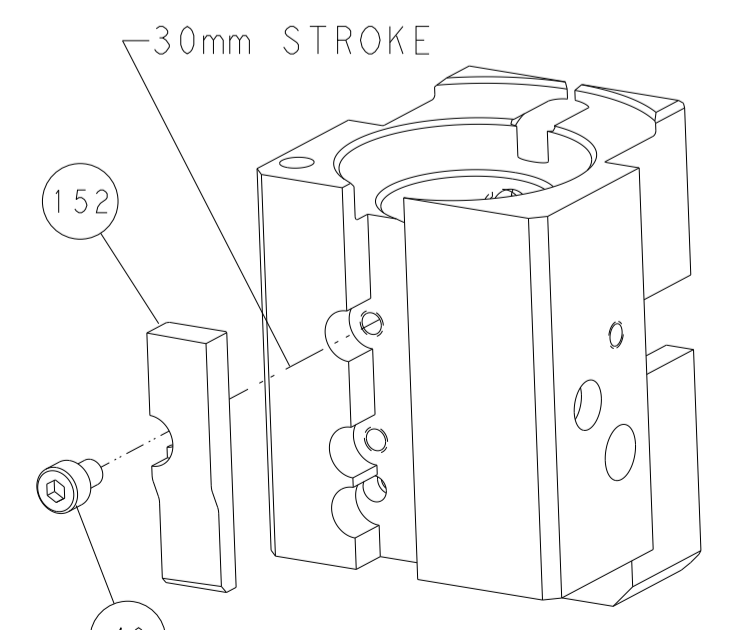
CAM POSITIONS



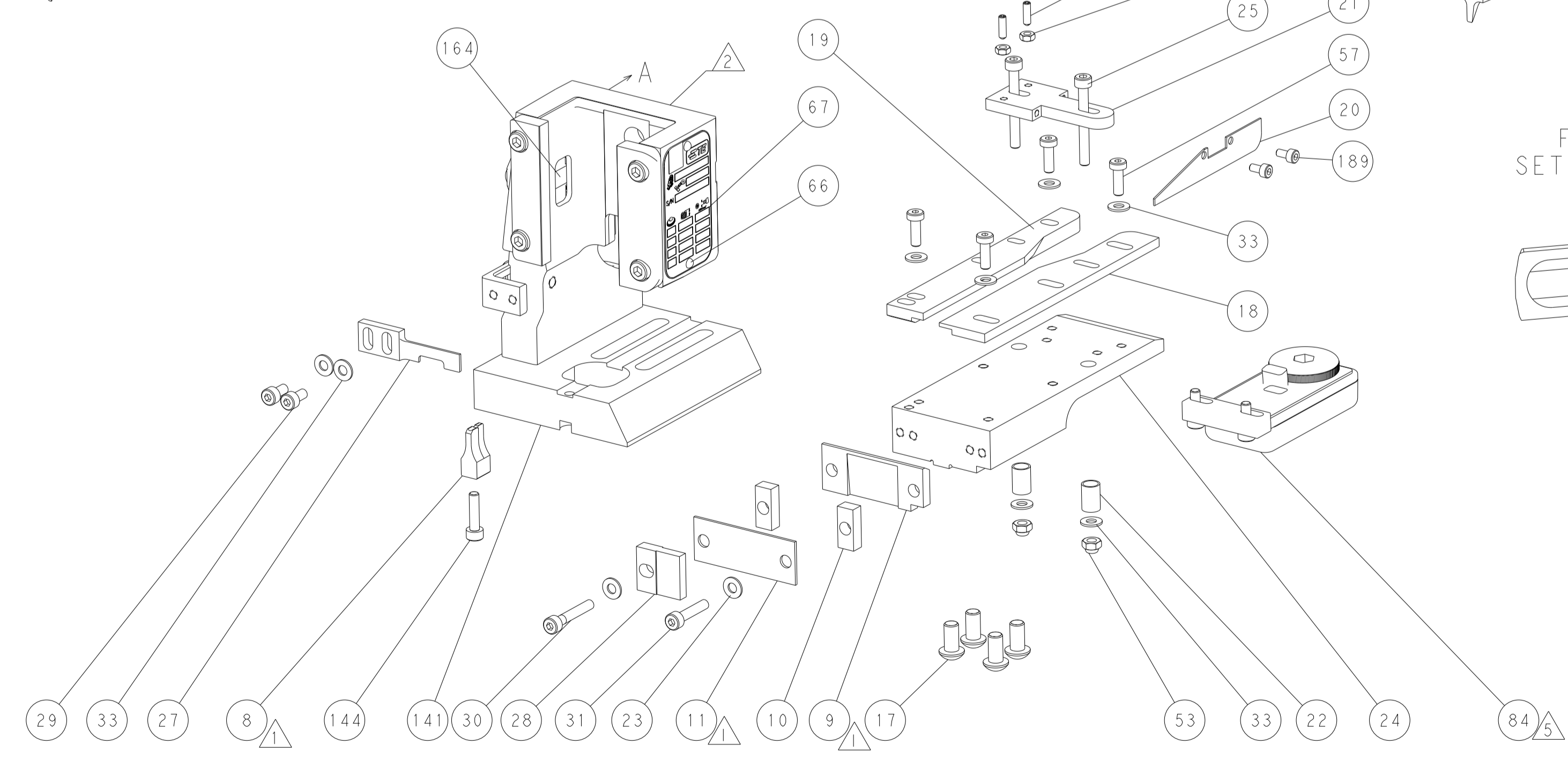
MECHANICAL  
POST FEED



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: J. HOU 18JUNE2014		CHK: L. ZHANG 18JUNE2014		APVD: J. GUO 18JUNE2014		NAME: Ocean End Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
	1 PLC	±		SCALE	A1	00779	©=2150447				
	2 PLC	±		WEIGHT							
	3 PLC	±		Customer Accessible Production Drawing		SCALE	1:1	SHEET	4	OF	4
	4 PLC	±						REV	E1		
	ANGLES	±									
	FINISH										