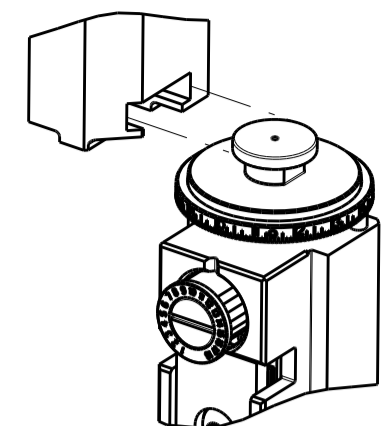


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150047-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150047-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150047-7	A	CRIMP TOOLING KIT	-

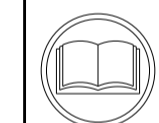
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 187 SERIES POSITIVE LOCK EX			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		Ø1.30-3.60 mm [.051-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5114		
	(B)114-5125		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173722-1	(B) 175032-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.04+/-0.05 [.041+/-0.002]	7.0
22 AWG OR 0.30mm2	1.01+/-0.05 [.040+/-0.002]	7.2
24 AWG OR 0.20mm2	0.94+/-0.05 [.037+/-0.002]	8.0
26 AWG OR 0.15mm2	0.90+/-0.05 [.035+/-0.002]	8.5



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.
- LOCATE THE FEED FINGER AT THE END OF THE INSULATION BARREL TO PROPERLY FEED THE TERMINAL.

***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.

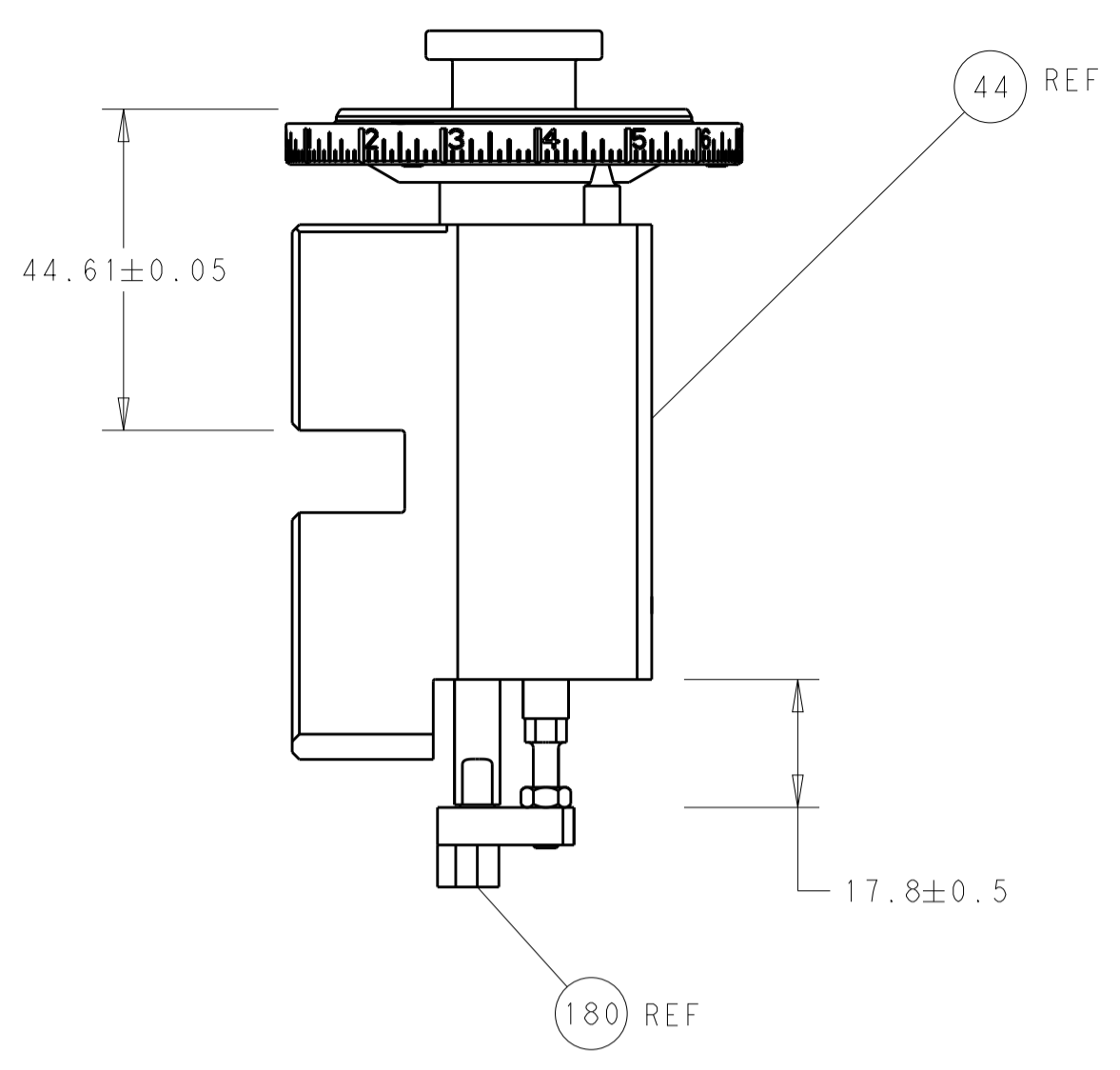
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	24DEC2014	KH	TE
				ECR-19-014235	11SEP2019	FJ	TE
				ECR-19-015781	16OCT2019	MZ	YY

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1752354-8	STANDOFF, HOLD-DOWN	180
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-1	FEED FINGER	51
-	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
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	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	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	-	1	690482-6	PLATE, FRONT SHEAR	9
	1	2	1333214-3	ANVIL, EF .062	8
	-	1	2217206-4	BLADE, SLUG	7
-	1	1	3-240641-5	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	1803017-9	CRIMPER, INSULATION F	3
-	1	1	455888-6	SPACER, CRIMPER	2
	1	2	3-456403-4	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	
-				DESCRIPTION	ITEM NO

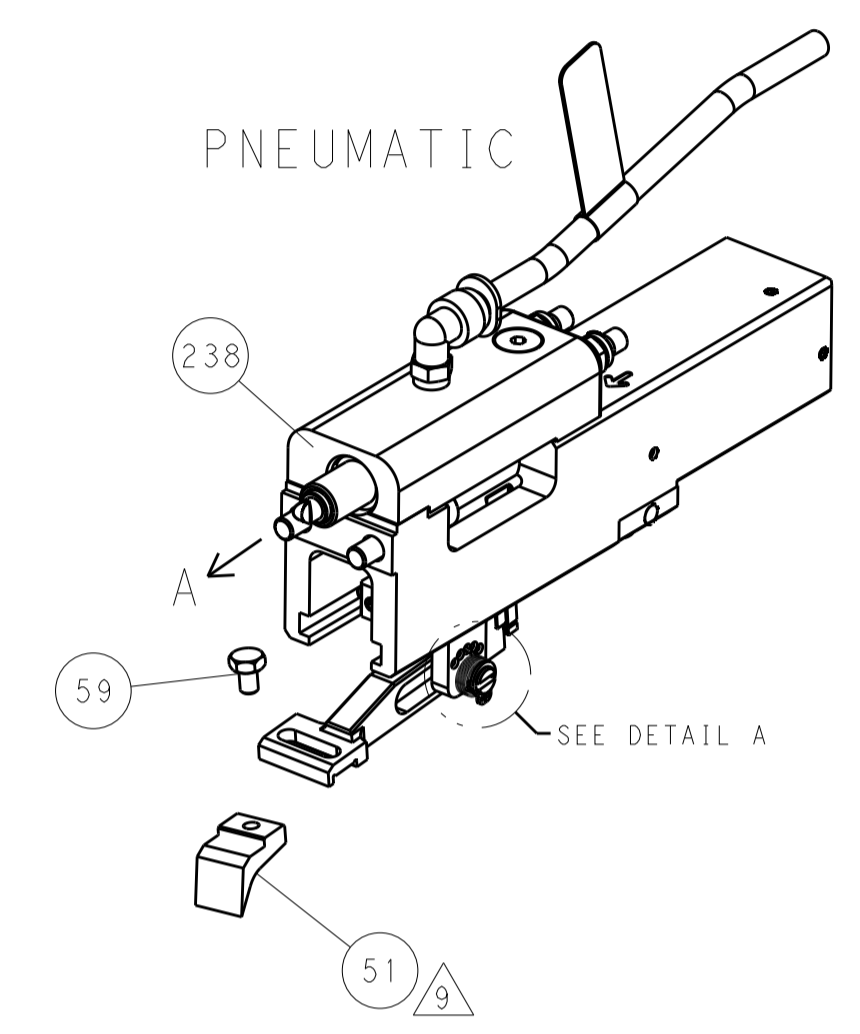
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					
Customer Accessible Production Drawing		SCALE	1:1	SHEET	1 OF 4

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

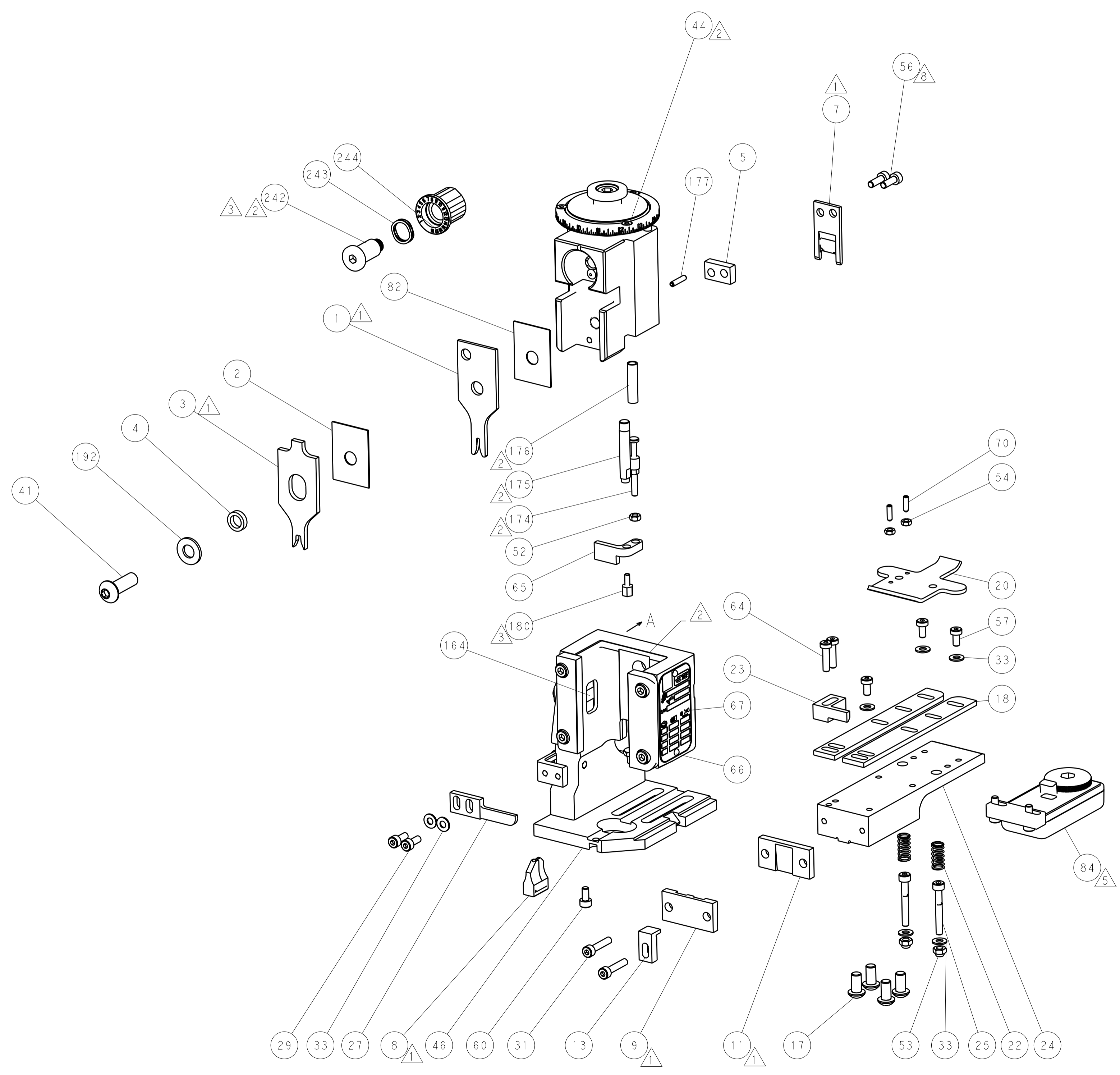
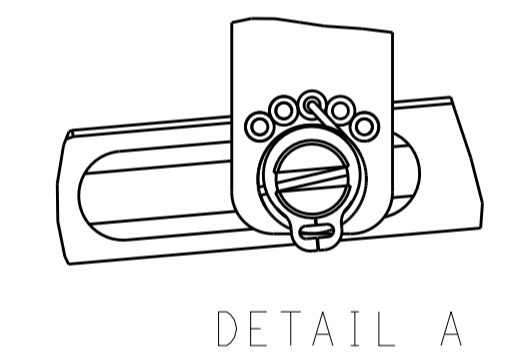


RAM AND HOLDDOWN SET-UP

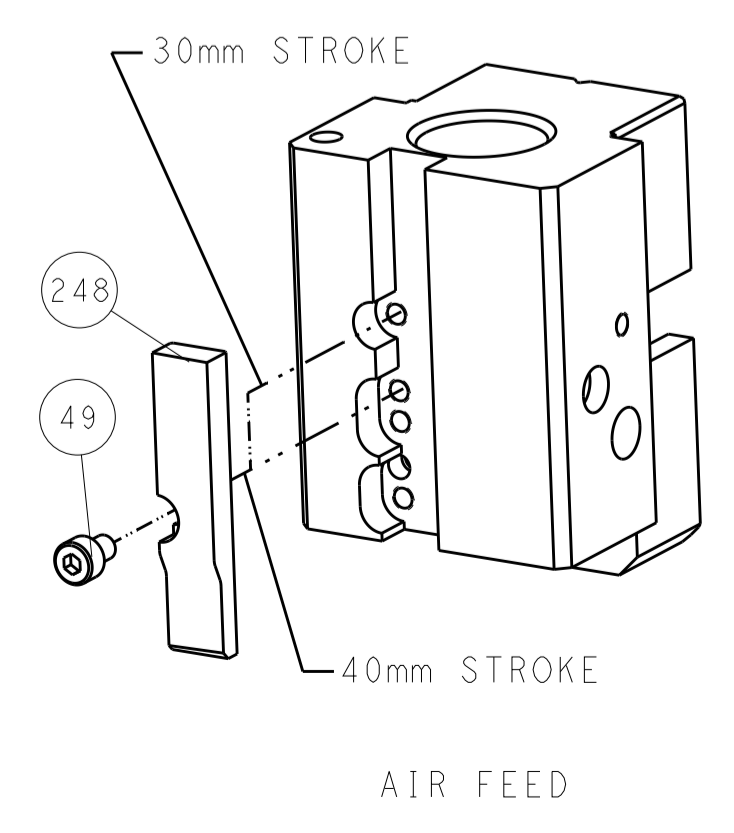
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

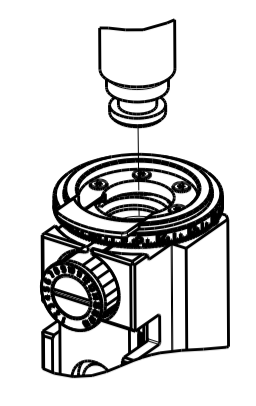


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE CONTAINED AND CONTROLLED BY THE USER'S ORGANIZATION. IT IS TO BE RELEASED TO THE PUBLIC ONLY BY THE USER'S ORGANIZATION.</small>		DWN K. HUANG 07FEB2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK S. XI 07FEB2012	NAME Ocean End Feed Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. XI 07FEB2012	PRODUCT SPEC APPLICATION SPEC
MATERIAL FINISH		WEIGHT A11 00779 ©=2150047	RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150047-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150047-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.56 mm [.140]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 187 SERIES POSITIVE LOCK EX

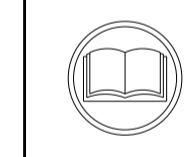
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.50-4.50 mm [.138-.177 IN]	∅1.30-3.60 mm [.051-.142 IN]

TERMINAL APPLICATION SPECIFICATION (A)114-5114 (B)114-5125

TERMINALS APPLIED 5 6

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173722-1	(B) 175032-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	1.04 +/- 0.05 [.041 +/- .002]	7.0
22 AWG OR 0.30mm ²	1.01 +/- 0.05 [.040 +/- .002]	7.2
24 AWG OR 0.20mm ²	0.94 +/- 0.05 [.037 +/- .002]	8.0
26 AWG OR 0.15mm ²	0.90 +/- 0.05 [.035 +/- .002]	8.5



- 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 ITEMS 180. 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 CUT TO LENGTH AT ASSEMBLY.
- 9 LOCATE THE FEED FINGER AT THE END OF THE INSULATION BARREL TO PROPERLY FEED THE TERMINAL.

***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.

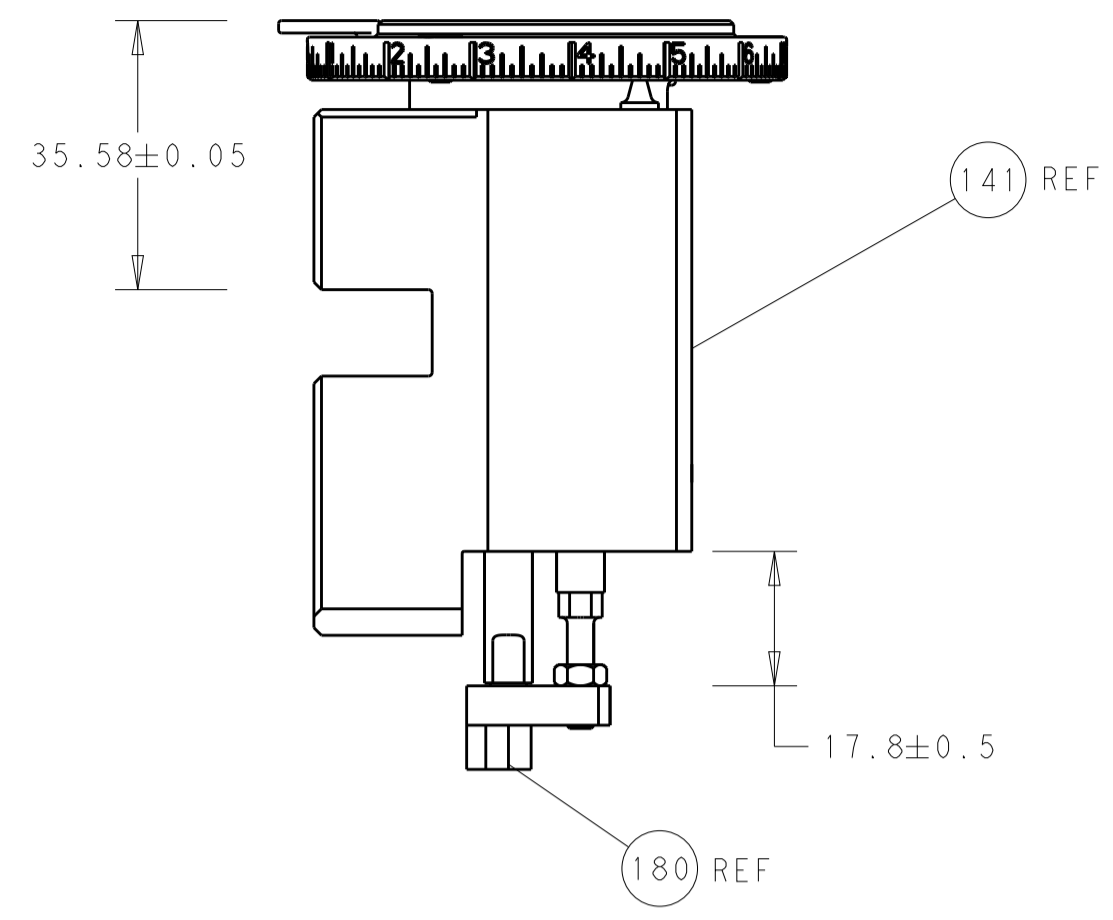
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APP'D
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APP'D
-	1	2119082-3			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-3			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	1752354-8			180
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	2119955-2			84
-	1	455888-5			82
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-1			65
-	2	2168400-8			64
-	-	5-18022-5			59
-	3	2168400-4			57
-	2	2168083-3			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-1			51
-	1	18023-9			49
-	1	1803602-1			41
-	7	1-18028-2			33
-	2	2168083-9			31
-	2	1-2168083-0			29
-	1	240639-1			27
-	2	1-2168083-5			25
-	1	1752371-5			24
-	1	240825-1			23
-	2	2-22281-3			22
-	1	1803292-4			20
-	2	1901259-6			18
-	1	1752360-1			13
-	1	240644-1			11
-	-	-			10
-	1	690482-6			9
1	1	1333214-3			8
-	1	2217206-4			7
-	1	3-240641-5			5
-	1	238011-2			4
1	1	1803017-9			3
-	1	455888-6			2
1	1	3-456403-4			1
-	77-22	PART NO			ITEM NO

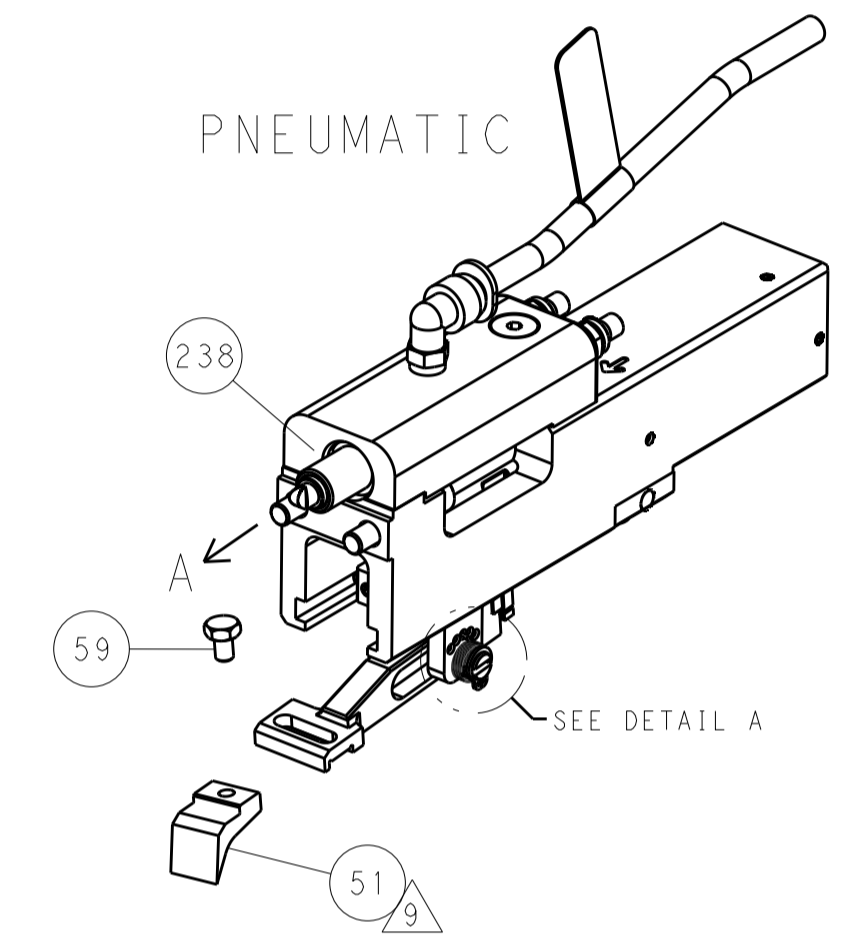
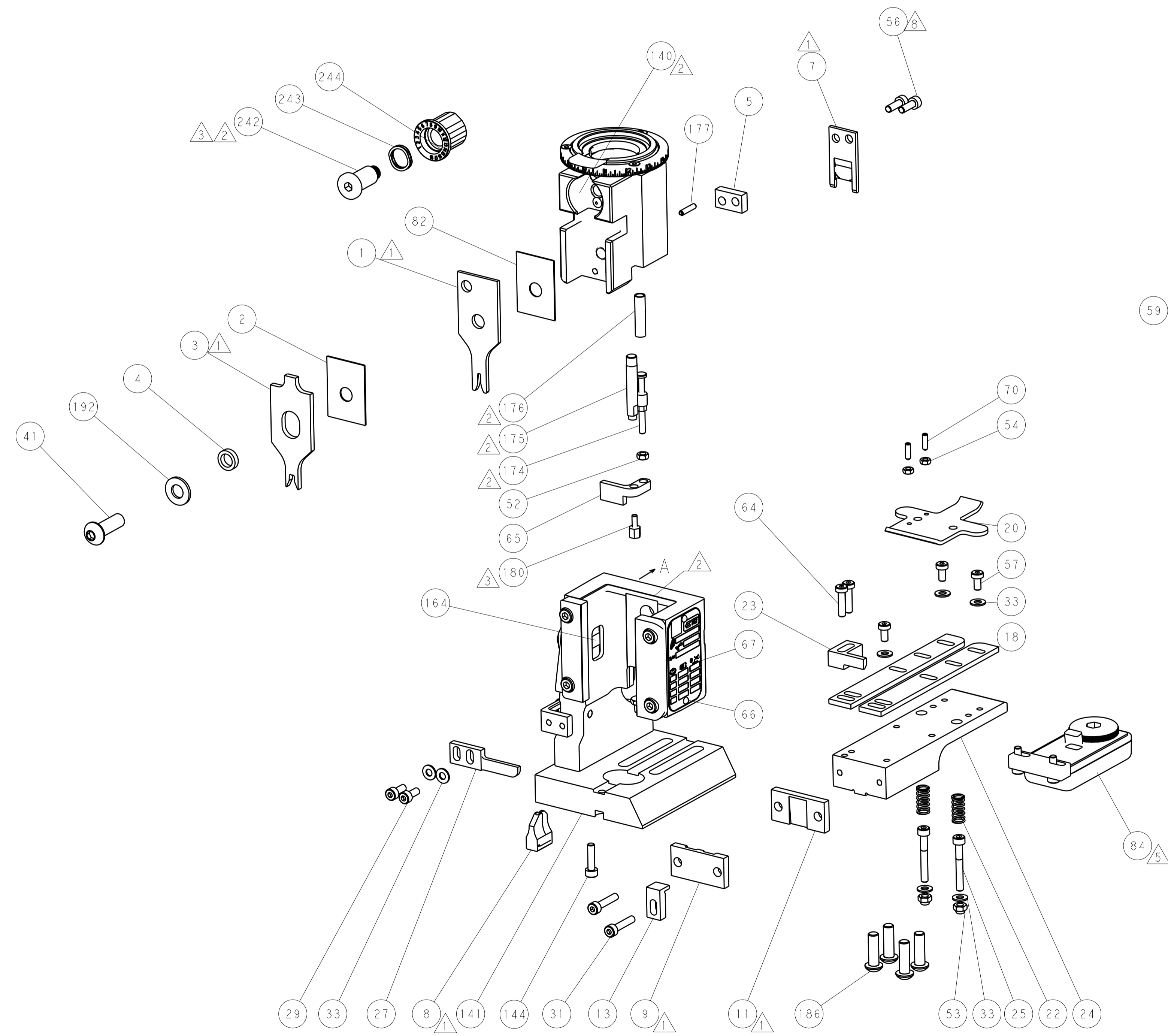
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APP'D	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	07FEB2012	H. HUANG	S. XI	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	07FEB2012	S. XI	07FEB2012	Ocean End Feed Applicator
Customer Accessible Production Drawing		SCALE	1:1	SHEET 3 OF 4	REV C

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



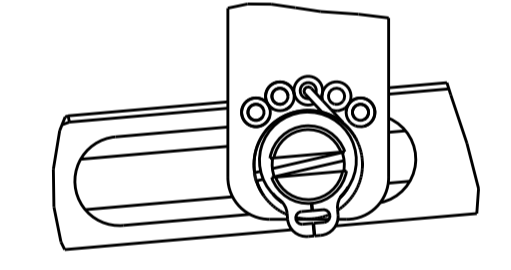
RAM AND HOLDDOWN SET-UP

FEED TYPE



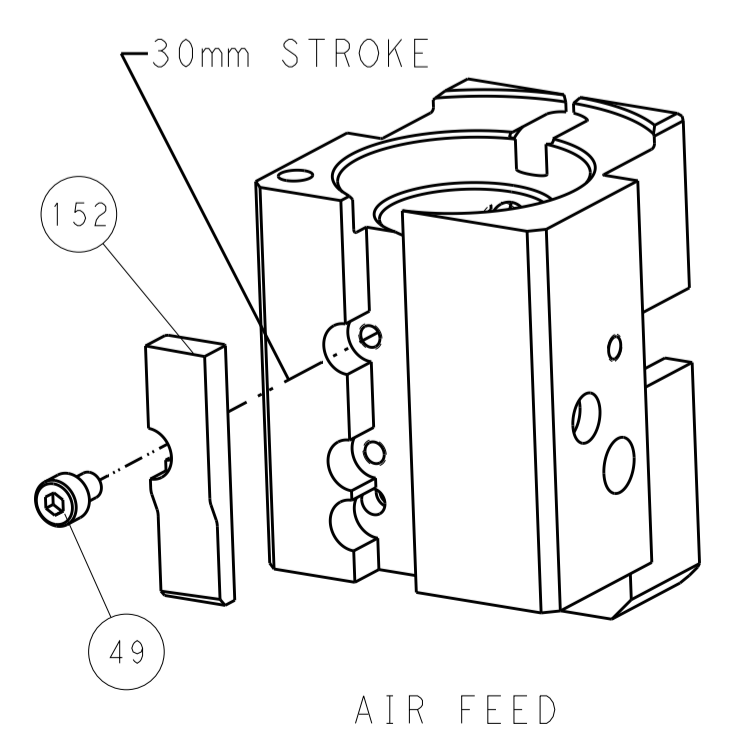
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



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:		DWN K. HUANG 07FEB2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH		CHK S.XI 07FEB2012	APVD S.XI 07FEB2012	NAME Ocean End Feed Applier	
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A	00779	©=2150047	
Customer Accessible Production Drawing				SCALE	1:1	SHEET	4 OF 4