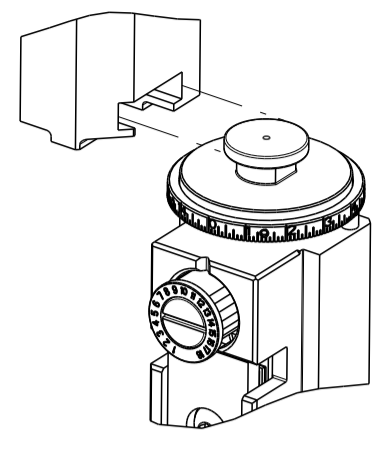


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150072-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150072-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150072-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150072-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES RECEPTACLE FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		Ø1.02-1.78 mm [.040-.070 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
342368-1	60573-1	62181-1	
342368-2	60573-2	62187-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.22 +/- 0.05 [.048 +/- .002]	4.8
22 AWG	1.09 +/- 0.05 [.043 +/- .002]	6.4
24 AWG	1.02 +/- 0.05 [.040 +/- .002]	7.2

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.

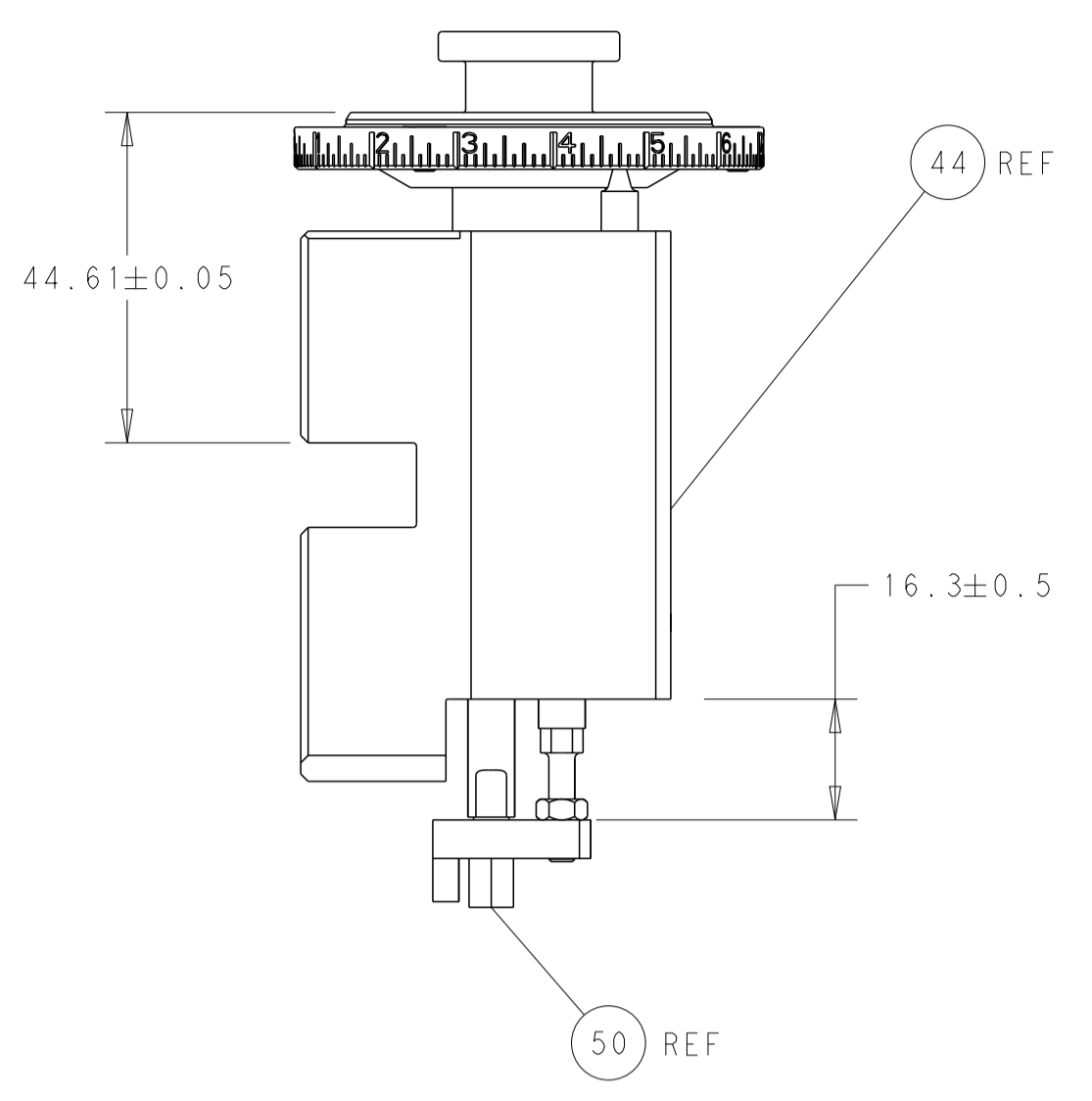
SET UP GAUGE		LOC	DIST	REVISIONS					
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				1		DEVELOPMENT	16JAN2013	YY	SX
				A		RELEASED	12APR2013	YY	UG
				B		ECR-18-015273	25SEP2018	TB	TE
				C		ECR-22-130891	28FEB2022	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	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	
-	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	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	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	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	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	
-	1	-	1	-	2063961-9	FEED FINGER	51	
	-	1	1	1	1-1752354-1	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	
-	7	7	7	7	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	240639-3	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	4-240641-9	SPACER	16	
	-	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	4-690495-7	PLATE, FRONT SHEAR	9	
	1	2	2	1	1333213-4	ANVIL, COMBINATION	8	
	-	1	1	1	4-690474-1	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
	1	2	2	1	1	1-456402-6	CRIMPER, WIRE PREMIUM	1
	-77-72-71	-2	-1		PART NO	DESCRIPTION	ITEM NO	

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

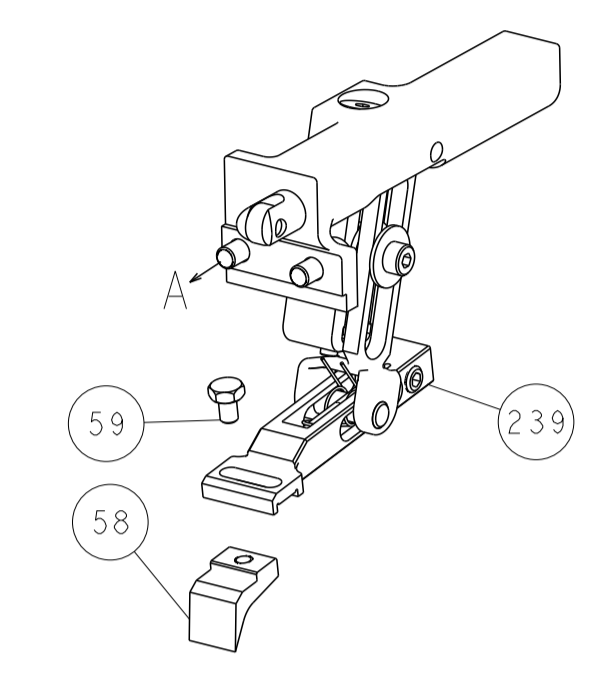
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Y. YIN	16JAN2012	G. BAILEY	16JAN2012	STE TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		FINISH		CAGE CODE		DRAWING NO		RESTRICTED TO		Customer Accessible Production Drawing	
				A1		00779		SCALE 1:1		SHEET 1 OF 4	

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

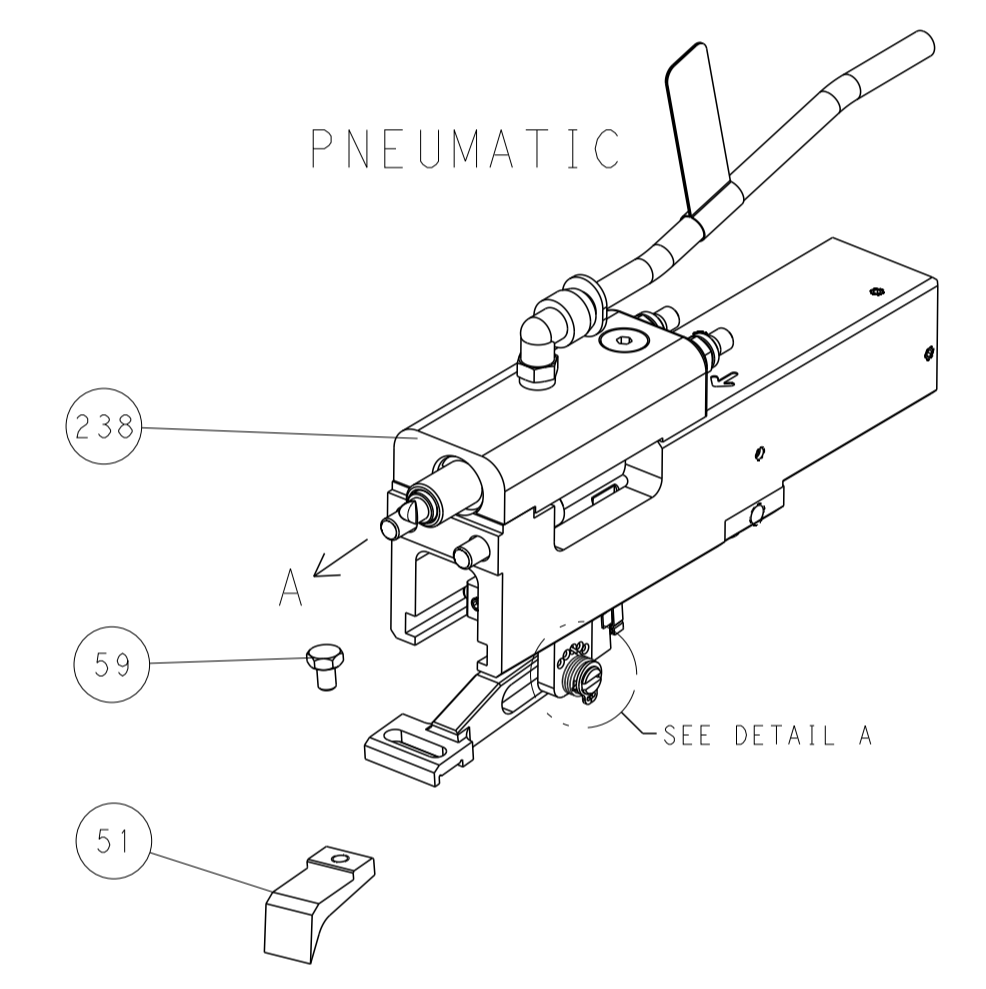


RAM AND HOLDDOWN SET-UP

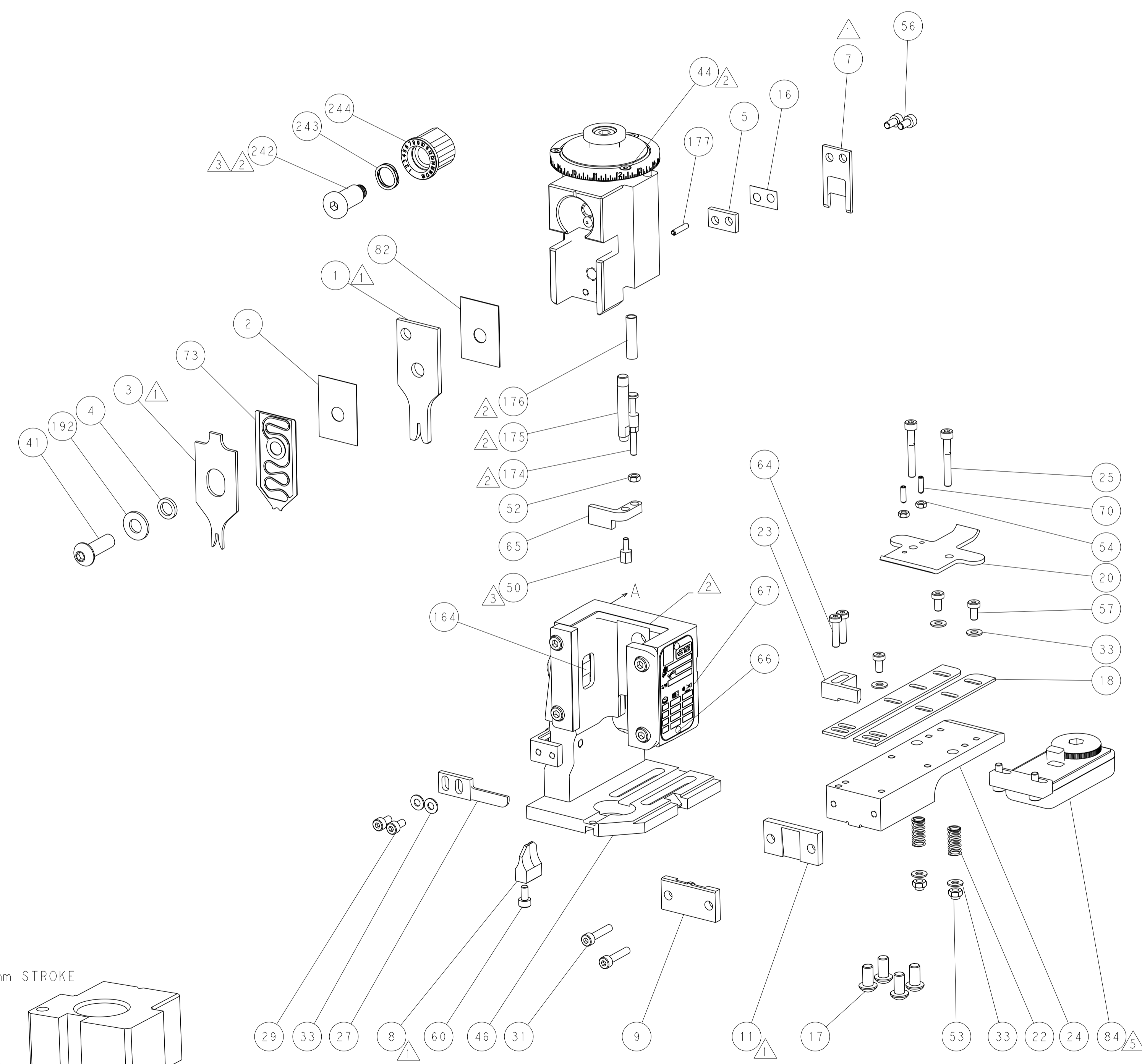
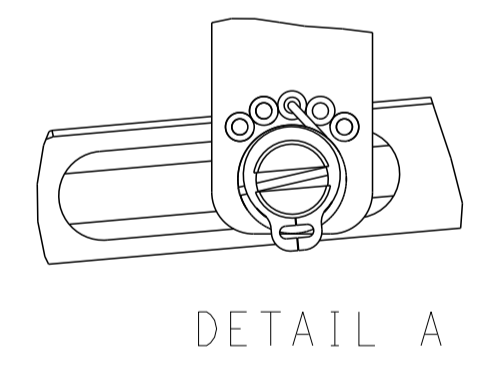
FEED TYPE  
MECHANICAL



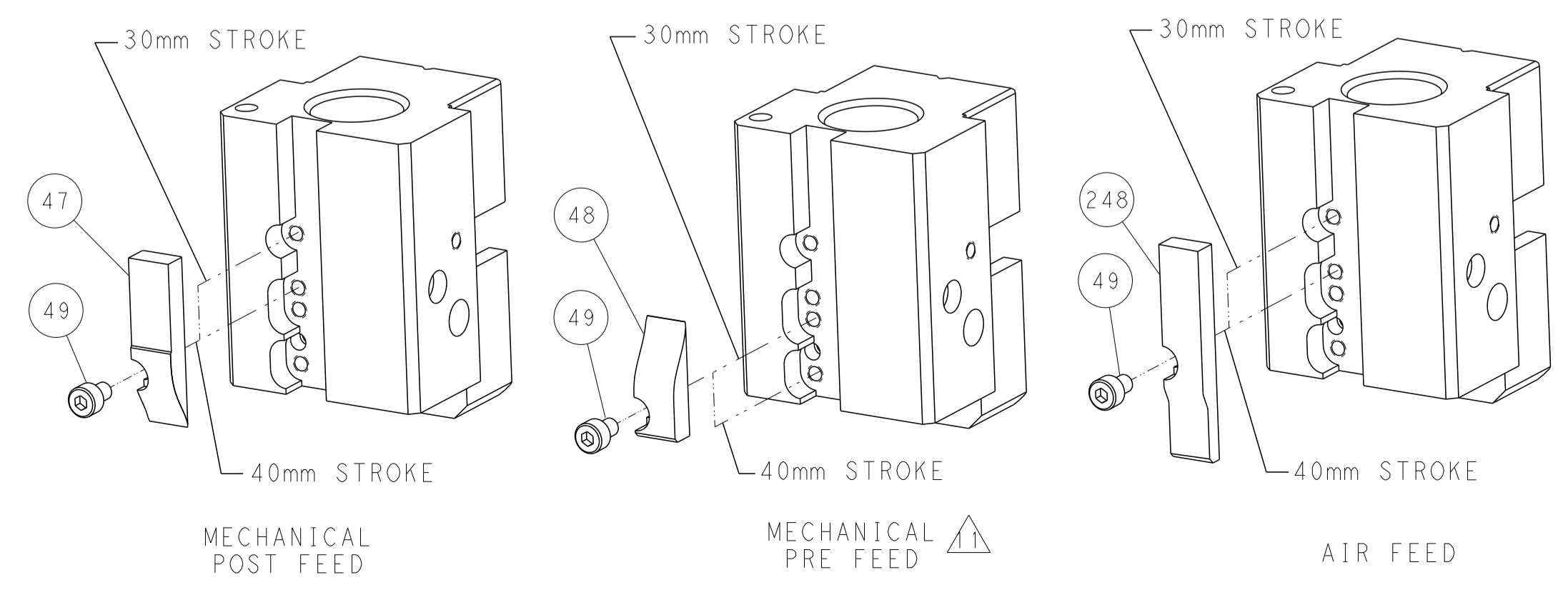
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

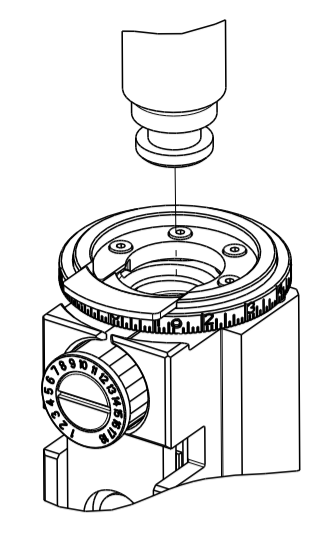


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC	±		Y. YIN	16JAN2012	Harrisburg, PA 17105-3608	
	1 PLC	±		CHK	G. BAILEY	NAME	
	2 PLC	±		S. XI	16JAN2012	Ocean End Feed	
	3 PLC	±		APVD		Applicator	
	4 PLC	±				-	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				A1	00779
MATERIAL						DRAWING NO	©=2150072
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:1
						SHEET 2 of 4	REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150072-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150072-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150072-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F

APPL INSTRUCTIONS  
 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .187 SERIES RECEPTACLE FASTON

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.16 mm [.173-.203 IN]	Ø1.02-1.78 mm [.040-.070 IN]

TERMINAL APPLICATION SPECIFICATION 114-2036

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
342368-1	60573-1	62181-1	
342368-2	60573-2	62187-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.22+/-0.05 [.048+/-0.002]	4.8
22 AWG	1.09+/-0.05 [.043+/-0.002]	6.4
24 AWG	1.02+/-0.05 [.040+/-0.002]	7.2



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

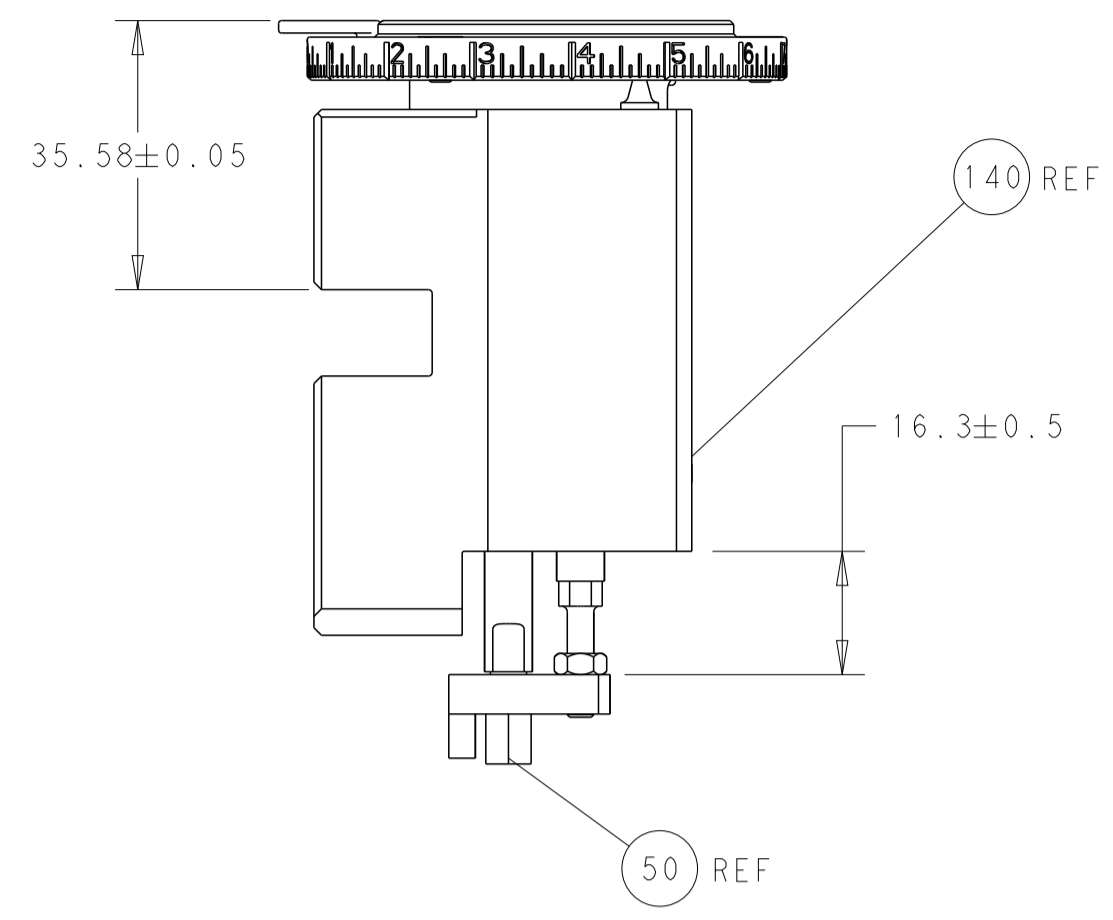
**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2		A	66	REV	DATE	BY	APPD
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	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		
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186		
-	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	-	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141		
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140		
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	455888-5	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	1-1901681-8	HOLDDOWN, TERMINAL	65		
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64		
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	-	1	2063961-1	FEED FINGER	58		
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	2063961-9	FEED FINGER	51		
3	-	1	1-1752354-1	STANDOFF,HOLD-DOWN	50		
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	-	1	2119652-1	FEED CAM, PRE FEED	48		
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	240639-3	STRIPPER (MACHINING)	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24		
-	1	1	240825-9	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	2	2	1901259-3	GUIDE, LOWER STRIP	18		
-	1	1	4-240641-9	SPACER	16		
1	-	1	240644-5	PLATE, REAR SHEAR	11		
-	-	-	-	-	10		
1	-	1	4-690495-7	PLATE, FRONT SHEAR	9		
1	1	1	1333213-4	ANVIL, COMBINATION	8		
1	-	1	4-690474-1	BLADE, SLUG	7		
-	-	-	-	-	6		
-	1	1	240641-5	SPACER	5		
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4		
1	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM	3		
-	1	1	455888-3	SPACER, CRIMPER	2		
1	1	1	1-456402-6	CRIMPER, WIRE PREMIUM	1		
-	77-22-21		PART NO	DESCRIPTION	ITEM NO		

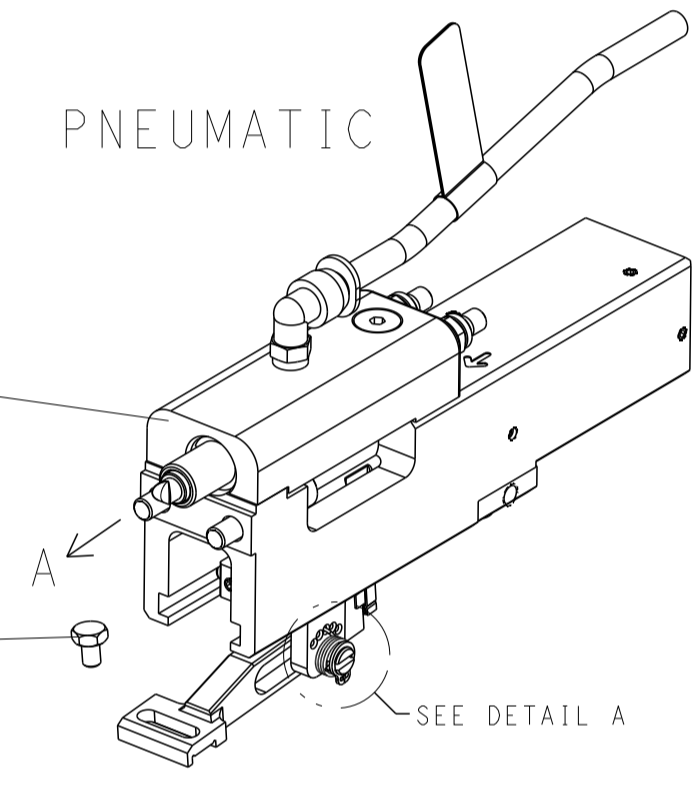
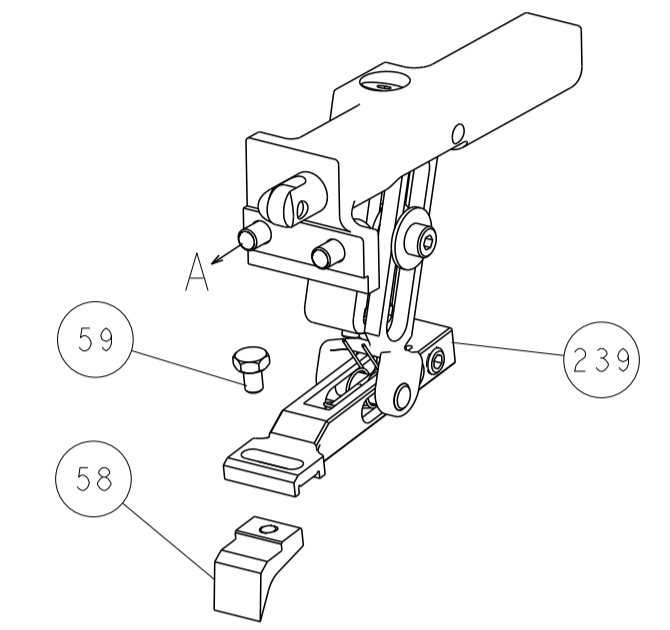
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 16JAN2012		CHK G. BAILEY 16JAN2012		APVD S. XI 16JAN2012		NAME	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		PRODUCT SPEC	
ANGLES		FINISH		WEIGHT		SCALE		SHEET		REV	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		A1 00779		C=2150072		-	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4		REV C					

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

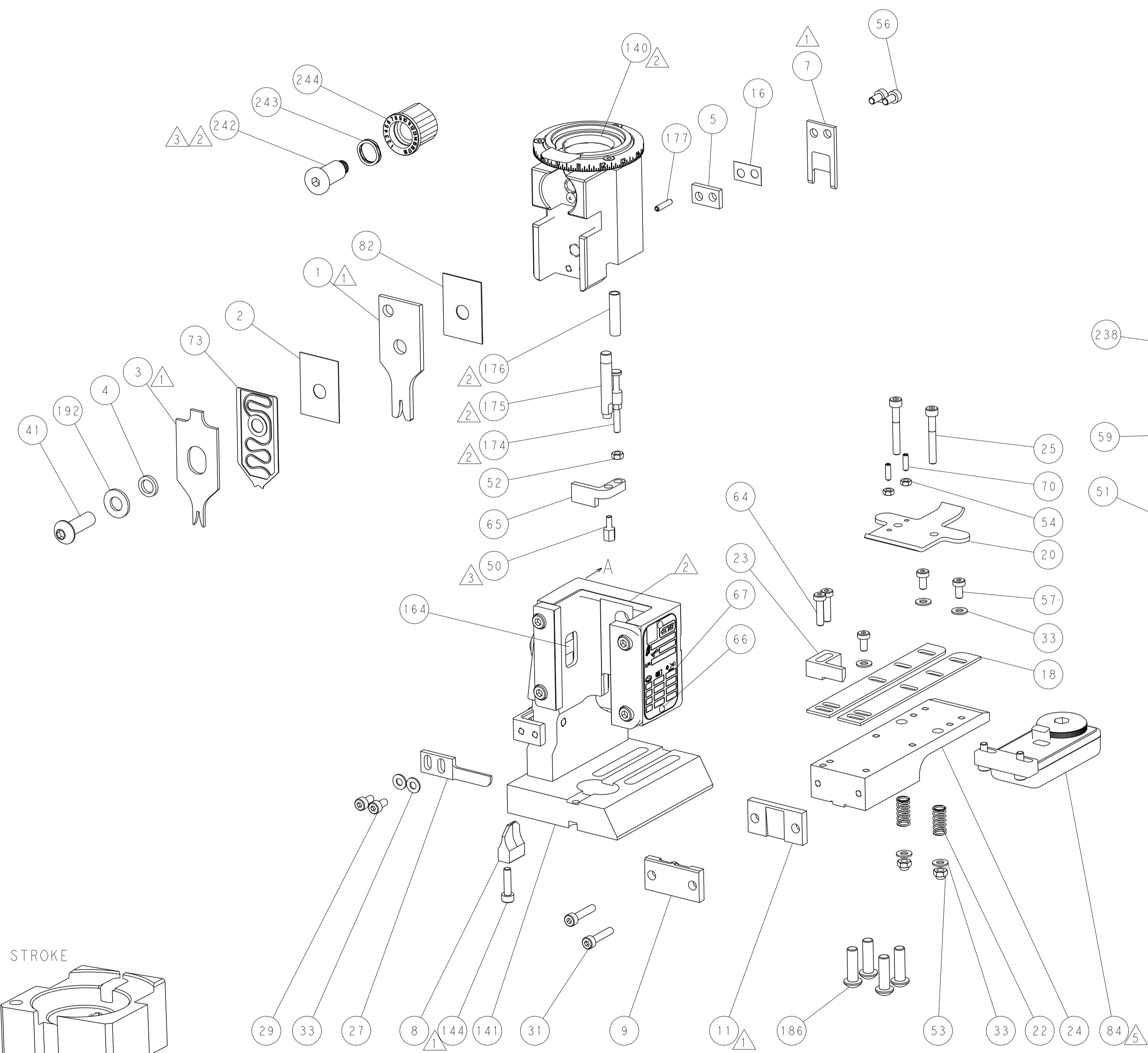
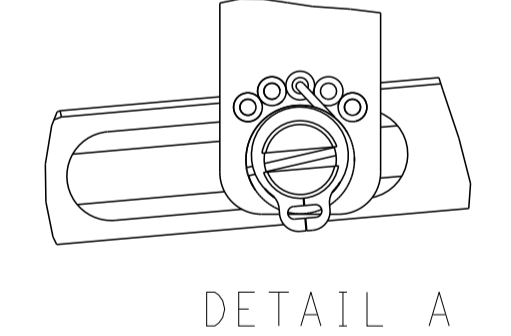


RAM AND HOLDDOWN SET-UP

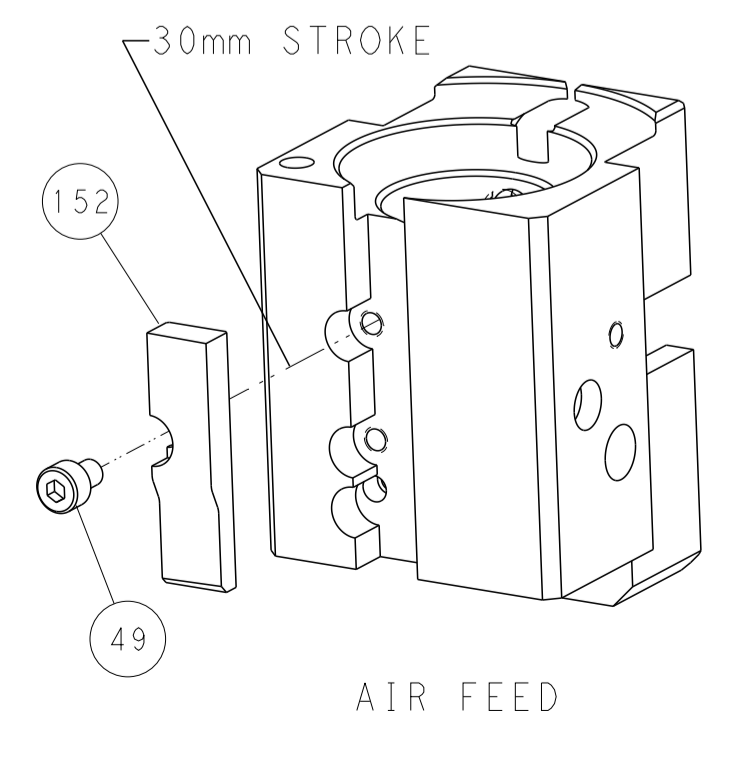
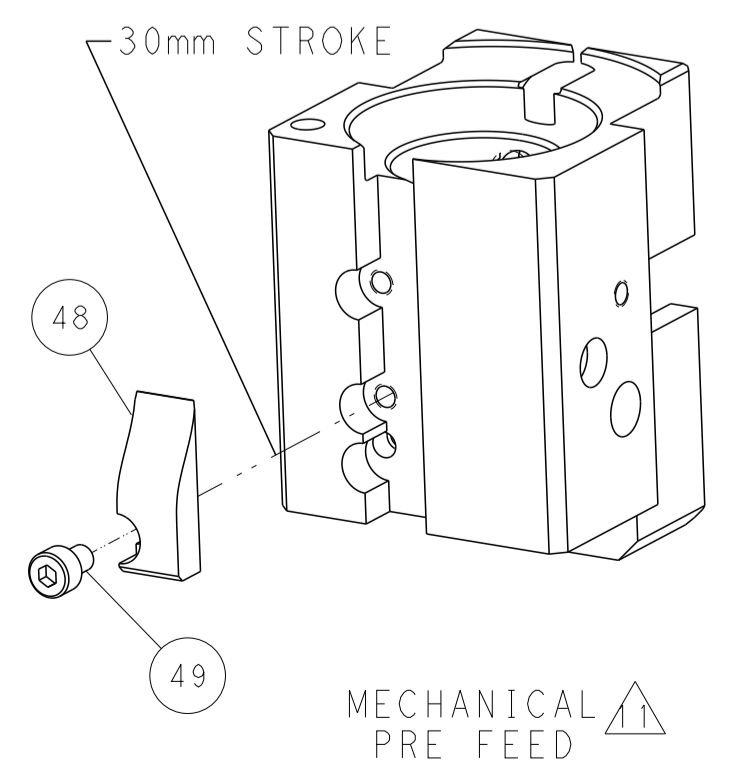
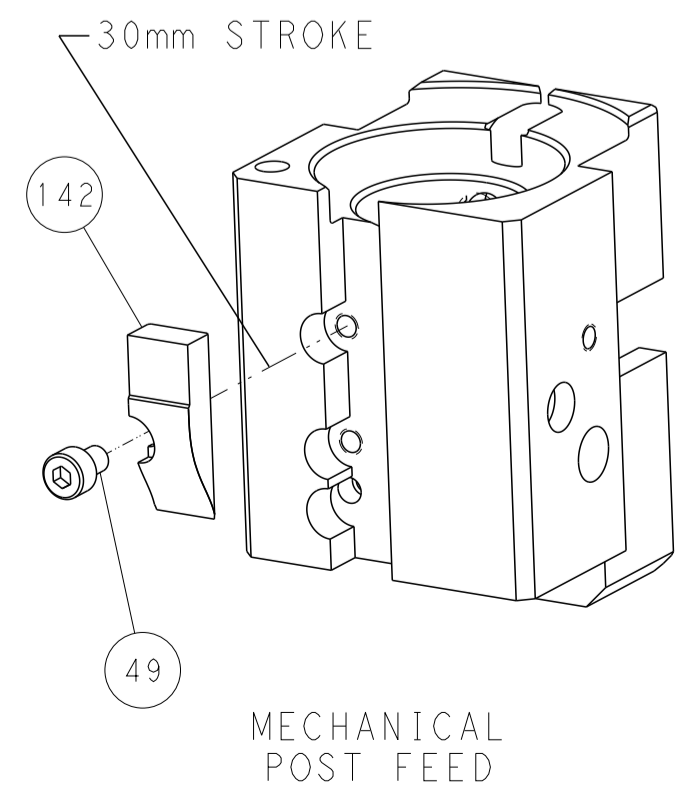
FEED TYPE  
MECHANICAL



FEED SPRING  
SETTING POSITION



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:		DWN Y. YIN 16JAN2012		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 G. BAILEY 16JAN2012	NAME	SIZE	CAGE CODE
MATERIAL				APVD S. XI 16JAN2012	PRODUCT SPEC	00779	2150072
				PRODUCT SPEC	APPLICATION SPEC	Customer Accessible Production Drawing	SCALE 1:1 SHEET 4 OF 4 REV C