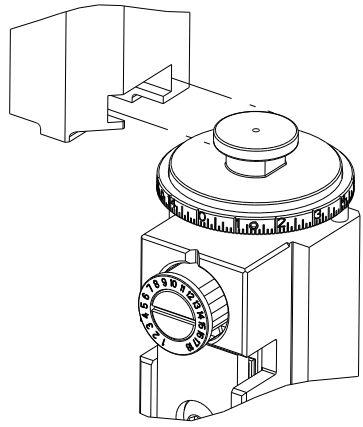


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150214-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150214-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150214-7	A	CRIMP TOOLING KIT	-

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 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 - -	
TERMINALS APPLIED		(B)114-15003 - -	
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.

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

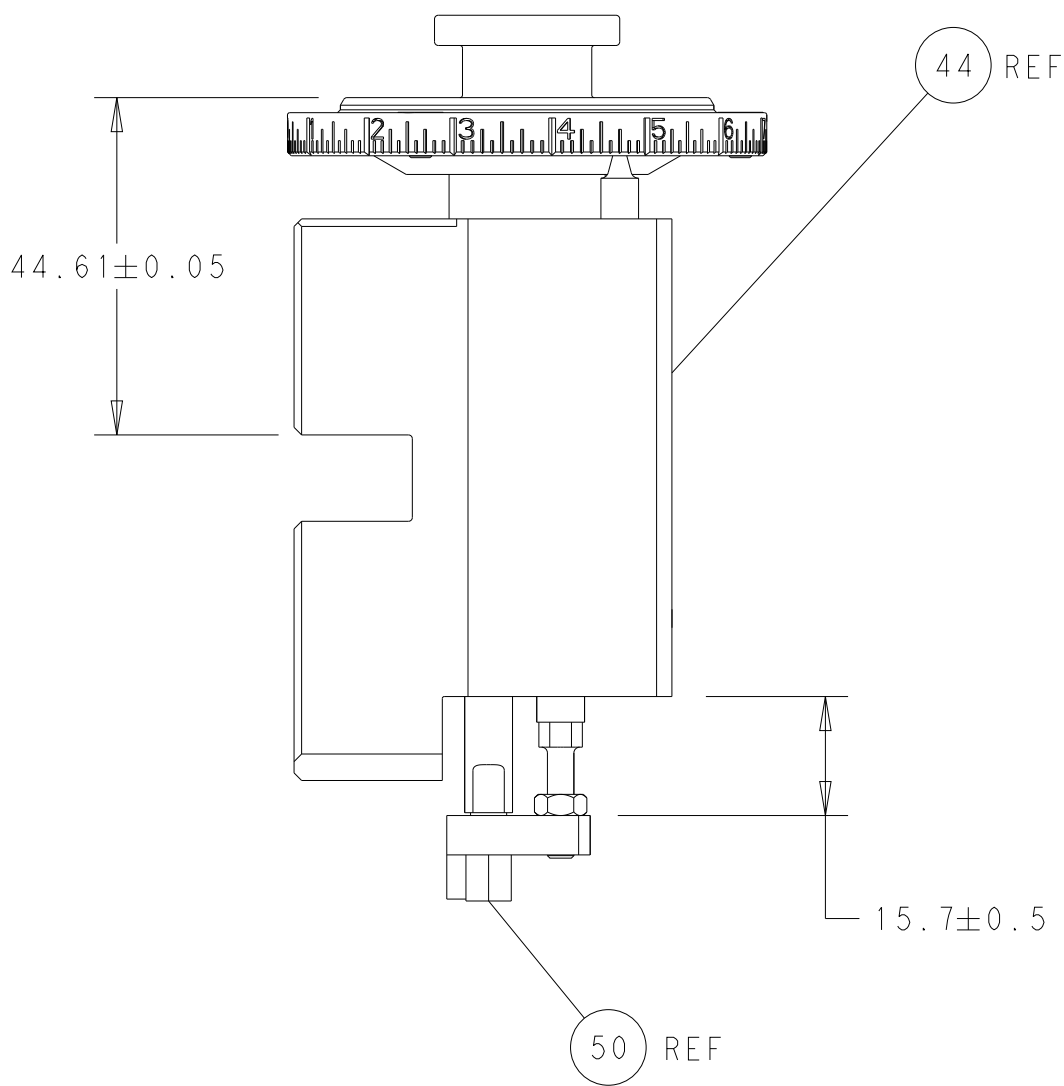
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		B		REVISED ECR-12-010723			13JUN2012	CC	SX
		C		ECR-15-000050			05JAN2015	JH	TE
		D		ECR-22-160252			05DEC2022	FZ	TE

-	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	1338686-1	ANVIL, COMBINATION	8
-	1	1	690474-5	BLADE, SLUG	7
-	1	1	5-240641-5	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	456418-2	CRIMPER, WIRE, .070 "F"	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

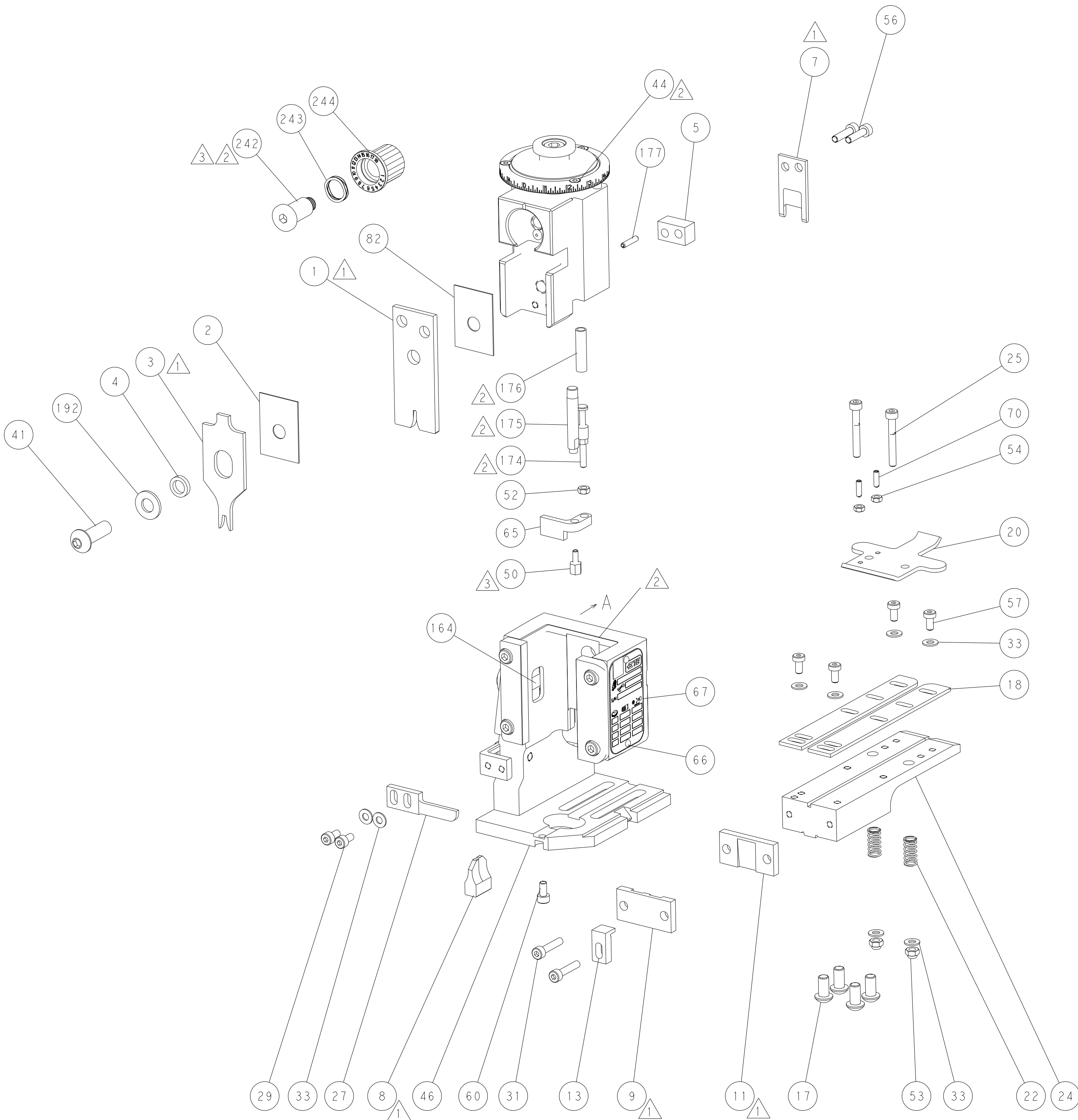
THIS DRAWING IS A CONTROLLED DOCUMENT AND THE FOLLOWING INFORMATION IS SUBJECT TO COMPANY'S CONFIDENTIALITY POLICY. IT IS SUBJECT TO COMPANY'S CONFIDENTIALITY POLICY AND THE FOLLOWING INFORMATION SHOULD BE CONTROLLED FOR THE LATEST EDITION.		DWN T. YIN 23MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 23MAR2012	NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD S. XI 23MAR2012	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			SIZE CASE CODE DRAWING NO	
			RESTRICTED TO	
			Customer Accessible Production Drawing	
			SCALE 1:1 SHEET 1 OF 4 REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

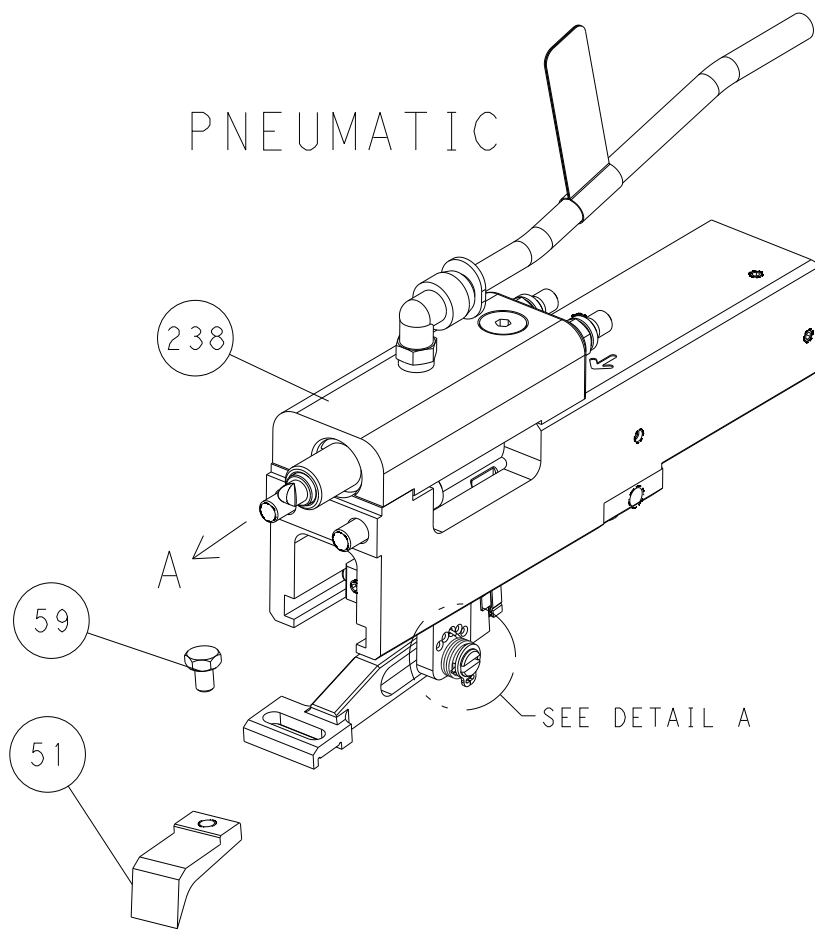
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



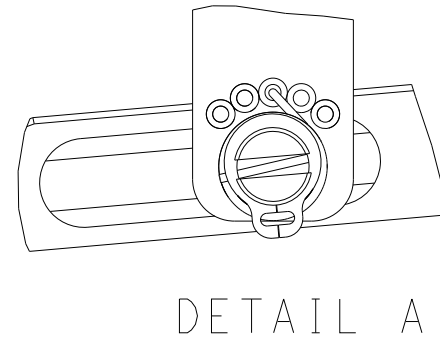
RAM AND HOLDDOWN SET-UP



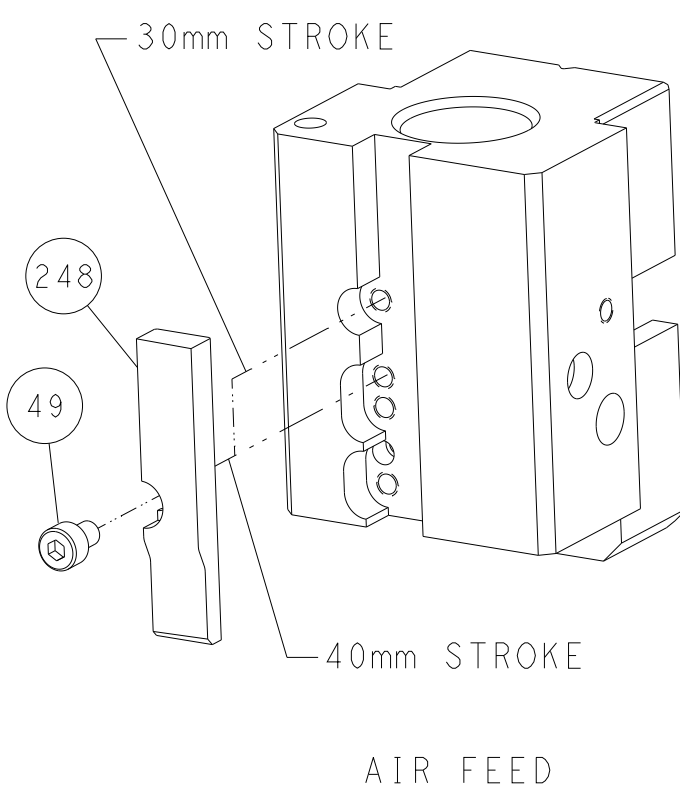
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

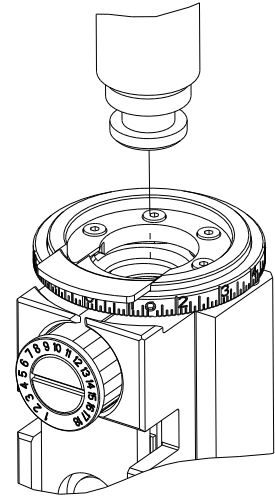
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY AND CUSTOMER CONTROL AND END-USERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN Y. YIN	23MAR2012	 TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean End Feed Applicator -
DIMENSIONS: mm				CHK G. BAILEY	23MAR2012		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.02 2 PLC ±.03 3 PLC ±.04 4 PLC ±.05 ANGLES ±.01 FINISH -				APVD S. XI	23MAR2012		
MATERIAL -				PRODUCT SPEC APPLICATION SPEC WEIGHT -			
				SIZE A1	CAGE CODE 00779	DRAWING NO. C=2150214	RESTRICTED TO -
Customer Accessible Production Drawing				SCALE 1:1	SHEET 2	OF 4	REV D

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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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



- 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 ITEM 50.
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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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)

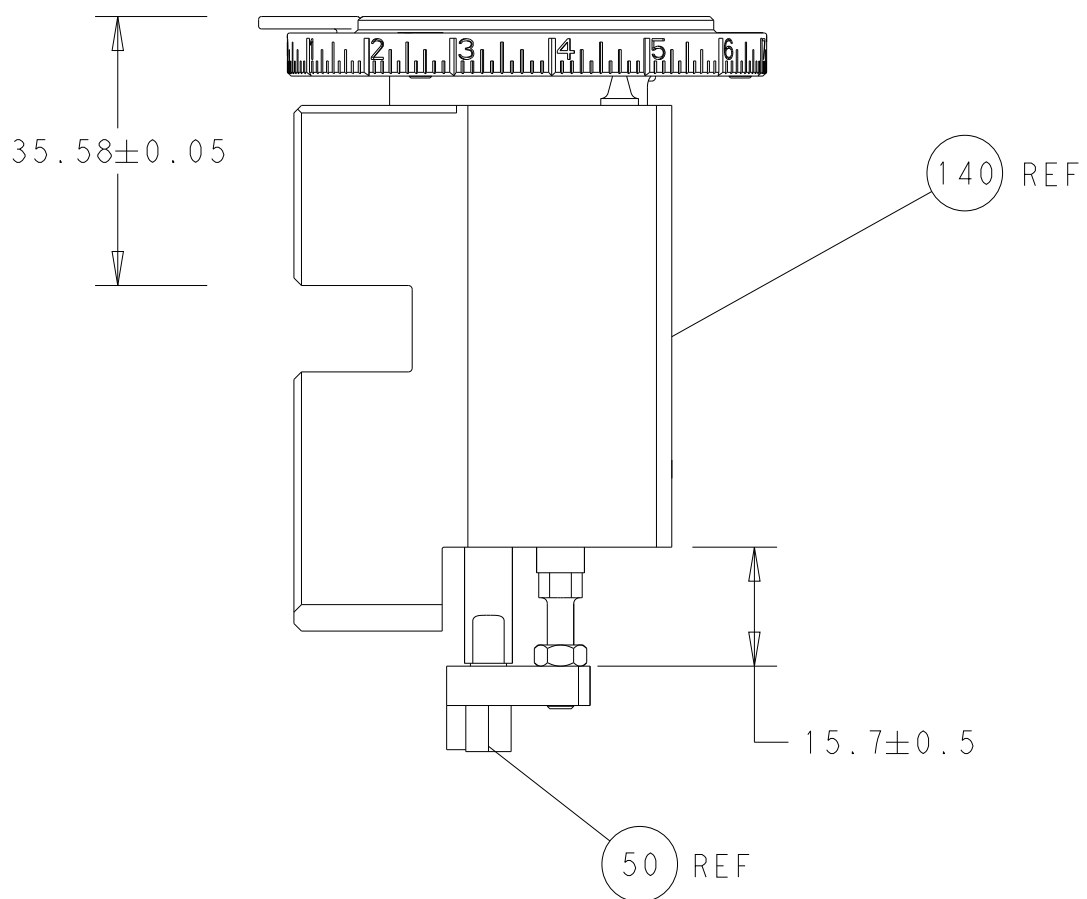
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	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	-	1	240644-1	PLATE, REAR SHEAR	11
1	-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1	1338686-1	ANVIL, COMBINATION	8
1	-	1	690474-5	BLADE, SLUG	7
1	-	1	5-240641-5	SPACER	5
1	-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3
1	-	1	455888-5	SPACER, CRIMPER	2
1	1	1	456418-2	CRIMPER, WIRE, .070 "F"	1
-77-22	PART NO		DESCRIPTION	ITEM NO	

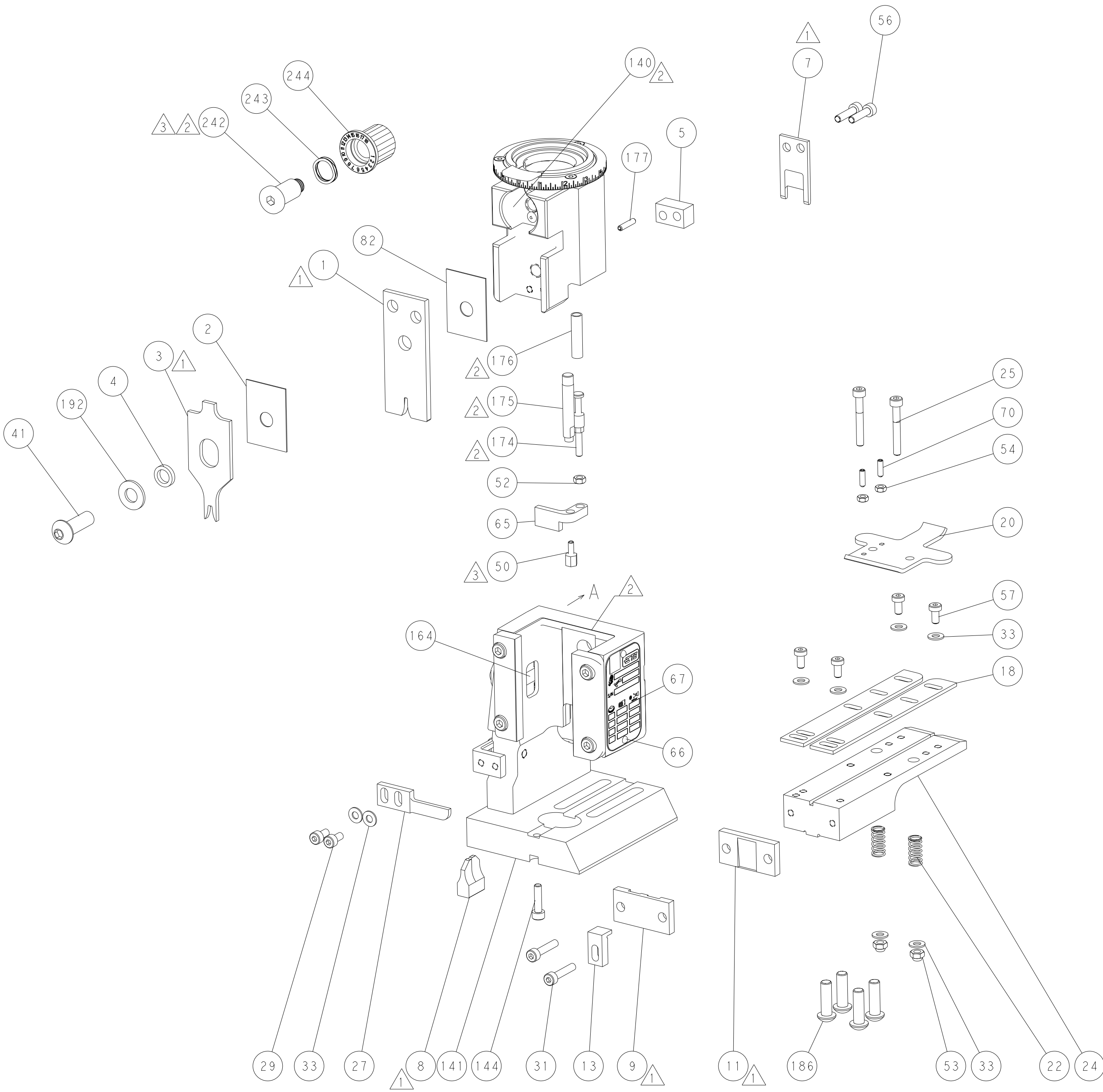
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TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK G. BAILEY 23MAR2012					
DIMENSIONS:		mm		APVD S. XI 23MAR2012		NAME		Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC - APPLICATION SPEC -		SIZE A		CAGE CODE 00779	DRAWING NO ©=2150214
MATERIAL -		-		WEIGHT -		RESTRICTED TO -		Customer Accessible Production Drawing	
				SCALE 1:1		SHEET 3		OF 4	
						REV D			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

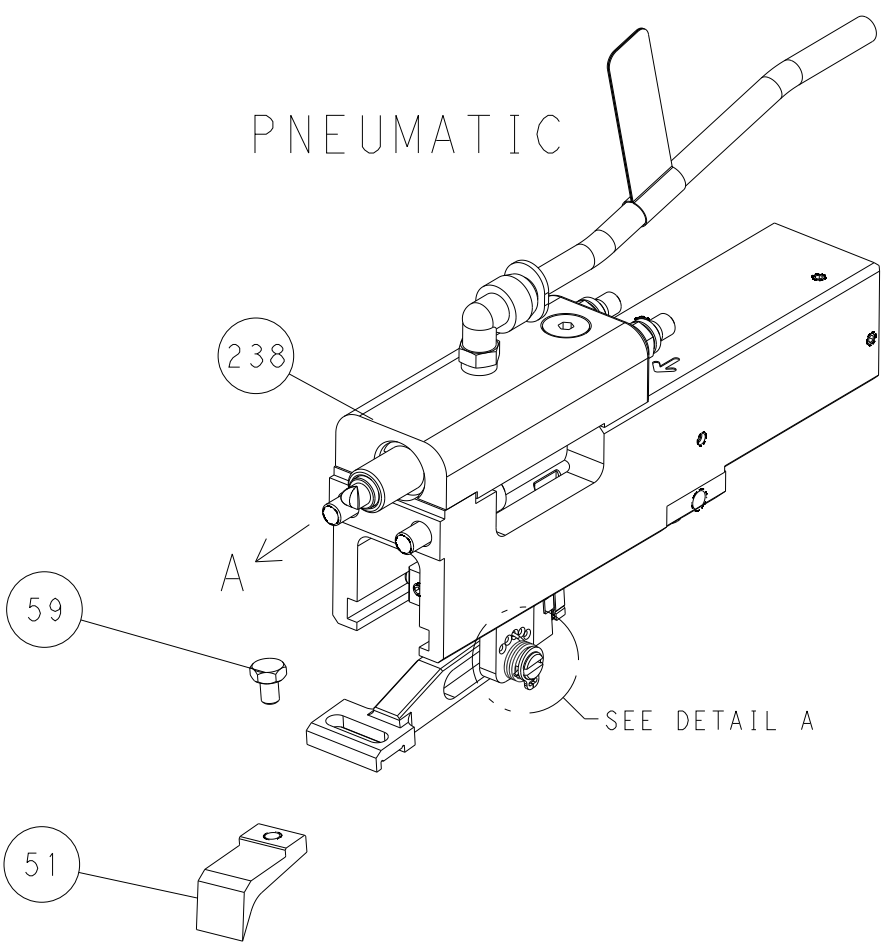
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A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
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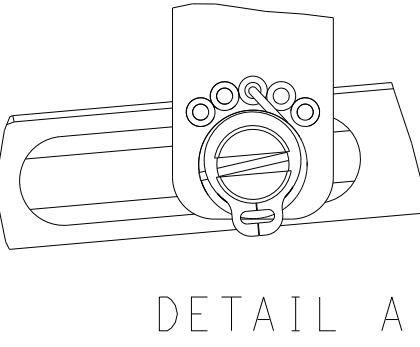
RAM AND HOLDDOWN SET-UP



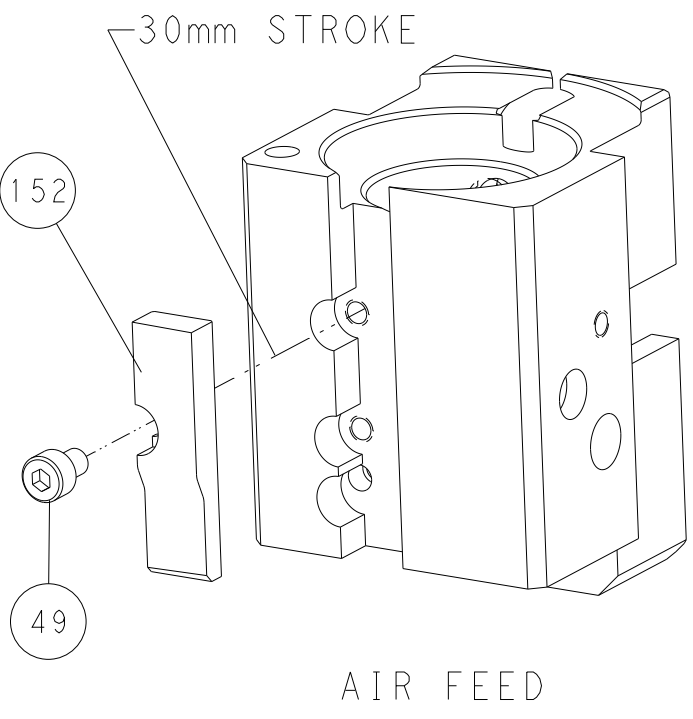
FEED TYPE



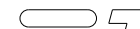
FEED SPRING SETTING POSITION



CAM POSITION



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CONTROLLED DOCUMENTATION AND INSPECTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN	Y. YIN	23MAR2012	 TE Connectivity Harrisburg, PA 17105-3608										
				CHK	G. BAILEY	23MAR2012											
				APVD	S. XI	23MAR2012											
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator -											
mm																	
		0 PLC	±														
		1 PLC	±														
		2 PLC	±														
		3 PLC	±														
4 PLC		±			APPLICATION SPEC												
ANGLES		±				WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
FINISH						-		A		00779		C=2150214		-			
MATERIAL								Customer Accessible Production Drawing		SCALE		1:1		SHEET 4 OF 4		REV D	