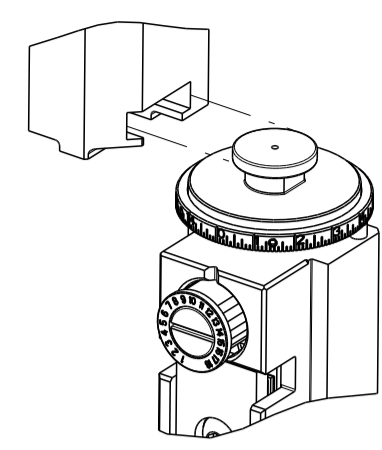


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150832-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150832-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150832-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	CONVERT FROM
7-2150832-8	A	APPLICATOR CONVERSION KIT	2150007-X
7-2150832-9	A	APPLICATOR CONVERSION KIT	2150312-X

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	SP
INSUL	3.80 mm [.150]	OV

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON, .187 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.75-5.51 mm [.187-.217 IN]	1.41-3.46 mm [.056-.136 IN]

TERMINAL APPLICATION SPECIFICATION 114-143088

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238174-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57+/-0.05 [.062+/- .002]	5.1
16 AWG	1.37+/-0.05 [.054+/- .002]	6.9
18 AWG	1.22+/-0.05 [.048+/- .002]	8.5
20 AWG	1.12+/-0.05 [.044+/- .002]	9.5
22 AWG	1.07+/-0.05 [.042+/- .002]	10.3
24 AWG	1.02+/-0.05 [.040+/- .002]	11.1

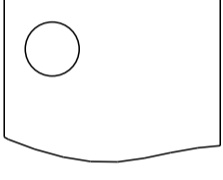
- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

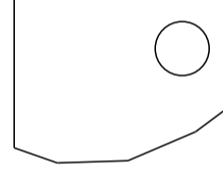
ACTION LIST

ADD	ADD	180
ADD	ADD	177
ADD	ADD	176
ADD	ADD	175
ADD	ADD	174
ADD	ADD	154
ADD	ADD	85
ADD	-	84
-	REPLACE #82	82
CHANGE QUANTITY	CHANGE QUANTITY	73
ADD	ADD	65
REMOVE	REMOVE	64
CHANGE QUANTITY	CHANGE QUANTITY	57
-	REPLACE #56	56
REMOVE	REMOVE	55
ADD	ADD	52
CHANGE QUANTITY	CHANGE QUANTITY	33
REPLACE #29	REPLACE #29	29
REPLACE #25	REPLACE #25	25
-	REPLACE #24	24
REMOVE	REMOVE	23
REPLACE #20	REPLACE #20	20
ADD	ADD	19
REPLACE #18	REPLACE #18	18
-	REMOVE	16
REPLACE #11	REPLACE #11	11
REPLACE #9	REPLACE #9	9
REPLACE #8	REPLACE #8	8
REPLACE #7	REPLACE #7	7
ADD	ADD	6
REPLACE #5	REPLACE #5	5
REPLACE #4	REPLACE #4	4
REPLACE #3	REPLACE #3	3
ADD	ADD	2
REPLACE #1	REPLACE #1	1
-79 ACTION	-78 ACTION	ITEM NO

ASSEMBLE THE FIRST WIRE CRIMPER AS BELOW.



ASSEMBLE THE SECOND WIRE CRIMPER AS BELOW.



REPLACE ITEM # IN ORIGINAL APPLICATOR.

APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 85.

CUT TO LENGTH AT ASSEMBLY.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	A1	14AUG2018	FZ	KZ	
		B	04FEB2020	JWC	GB	
		B1	12FEB2020	JWC	GB	
		C	01MAR2023	JWC	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	2844940-3	AIR FEED MODULE	238
1	1	-	1	1	1752354-3	STANDOFF, HOLD-DOWN	180
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
1	1	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
1	1	-	1	1	1803613-4	CRIMPER, WIRE, OVERLAP, 2D	154
2	2	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	85
1	-	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	-	1	1	455888-4	SPACER, CRIMPER	82
1	1	-	2	2	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	1	1901681-5	HOLDDOWN, TERMINAL	65
-	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	-	-	2	2	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	1	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	-	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	1	2063961-1	FEED FINGER	51
-	-	-	2	2	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
1	1	-	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	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	-	-	1	1	240639-1	STRIPPER (MACHINING)	27
2	2	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	-	2	1	1752371-5	PLATE, STRIP GUIDE	24
-	-	-	2	2	2-22281-3	SPRING, COMPRESSION	22
1	1	-	1	1	1803292-4	DRAG	20
1	1	-	1	1	1803152-4	STRIP GUIDE, REAR	19
1	1	-	1	1	1803151-4	STRIP GUIDE, FRONT	18
-	-	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	1	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	1	-	1	1	690482-1	PLATE, FRONT SHEAR	9
1	1	1	2	1	7-1803074-0	ANVIL, COMBINATION, END FEED	8
1	1	-	1	1	2217206-1	BLADE, SLUG	7
1	1	-	1	1	1-2119757-6	DEPRESSOR, SHEAR	6
1	1	-	1	1	240641-8	SPACER	5
1	1	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	2	1	3-1803199-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
1	1	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	2	1	1803726-2	CRIMPER, WIRE, OVERLAP, 2D	1
-79-78-77-72-2					PART NO	DESCRIPTION	ITEM NO

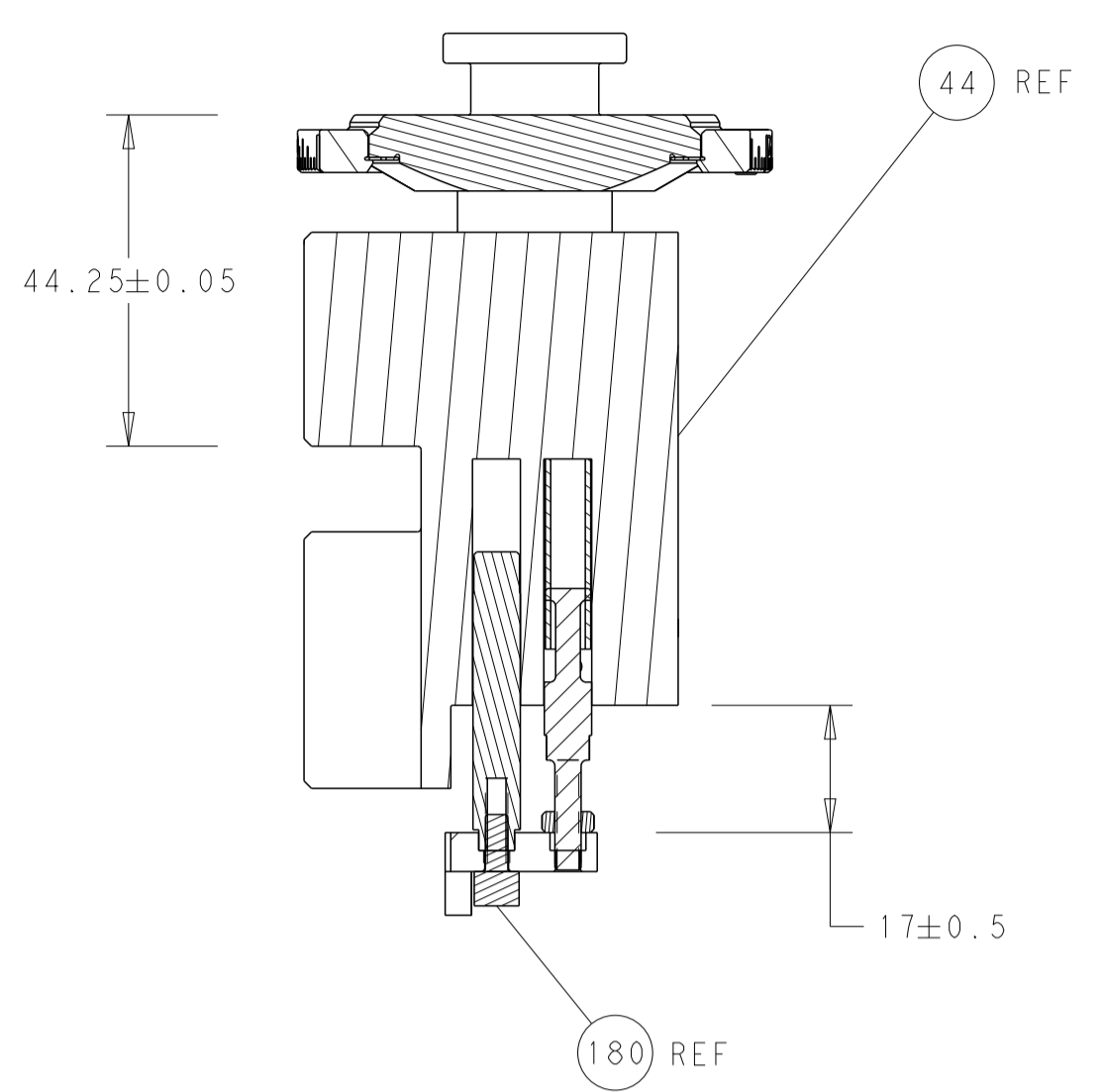
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	CHK	APPV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	16AUG2017	H. HUANG	Y. YIN	L. ZHANG
MATERIAL:					

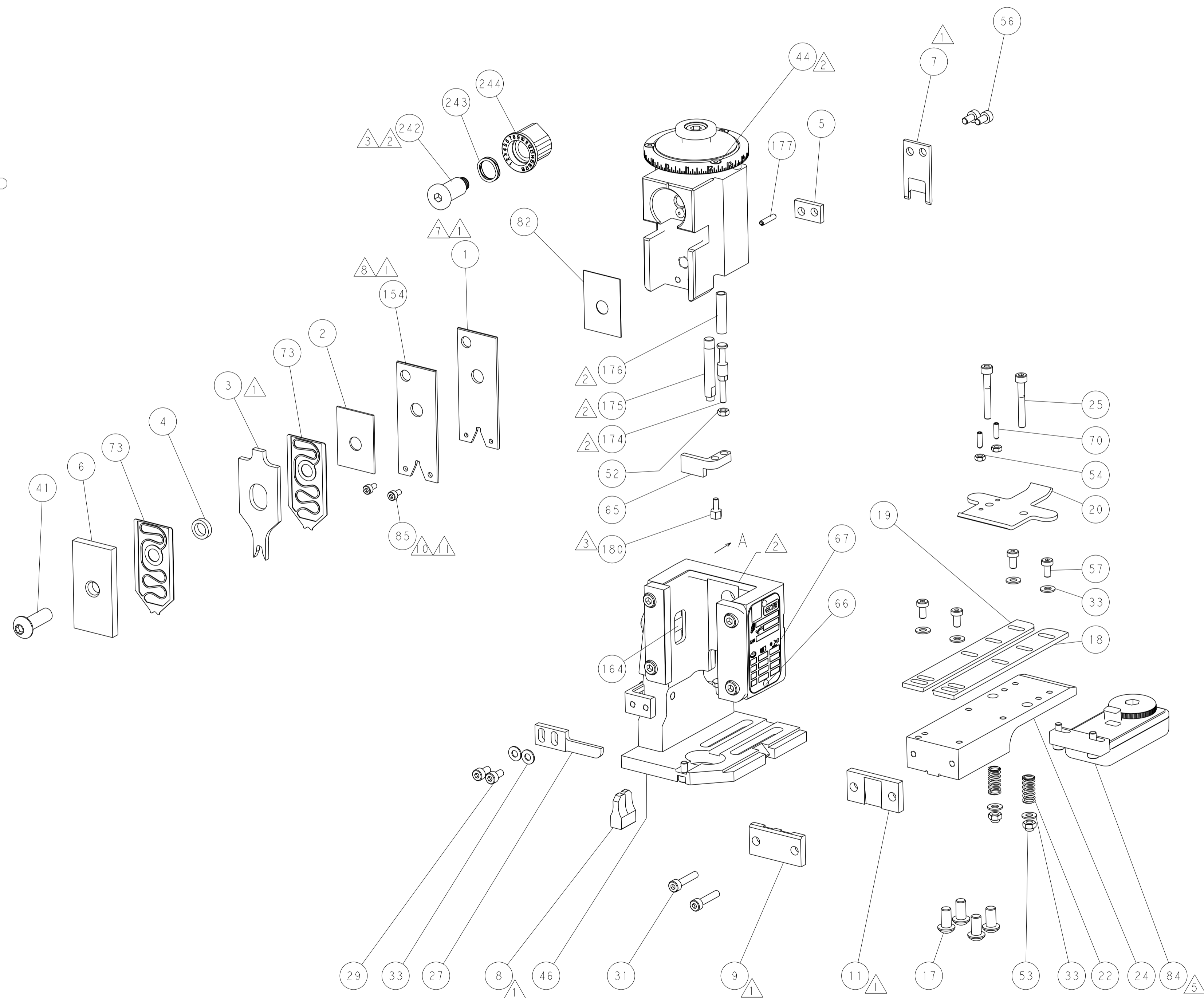
Customer Accessible Production Drawing

Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV C

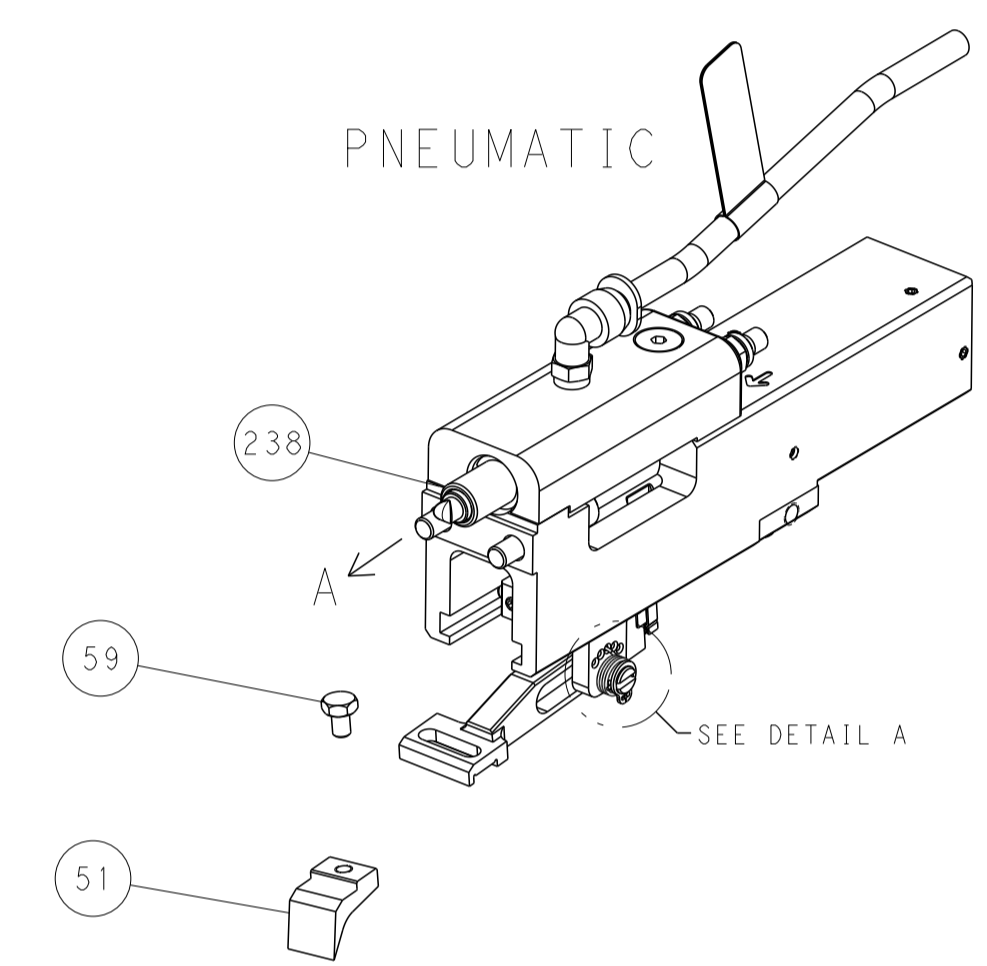
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1			



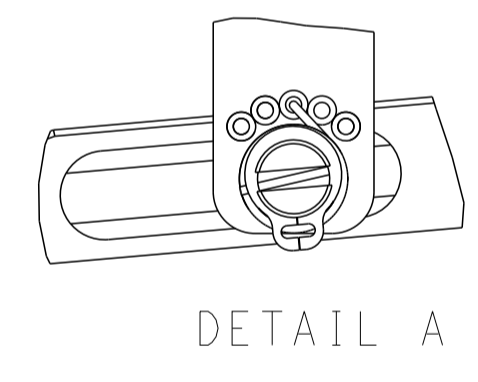
RAM AND HOLDDOWN SET-UP



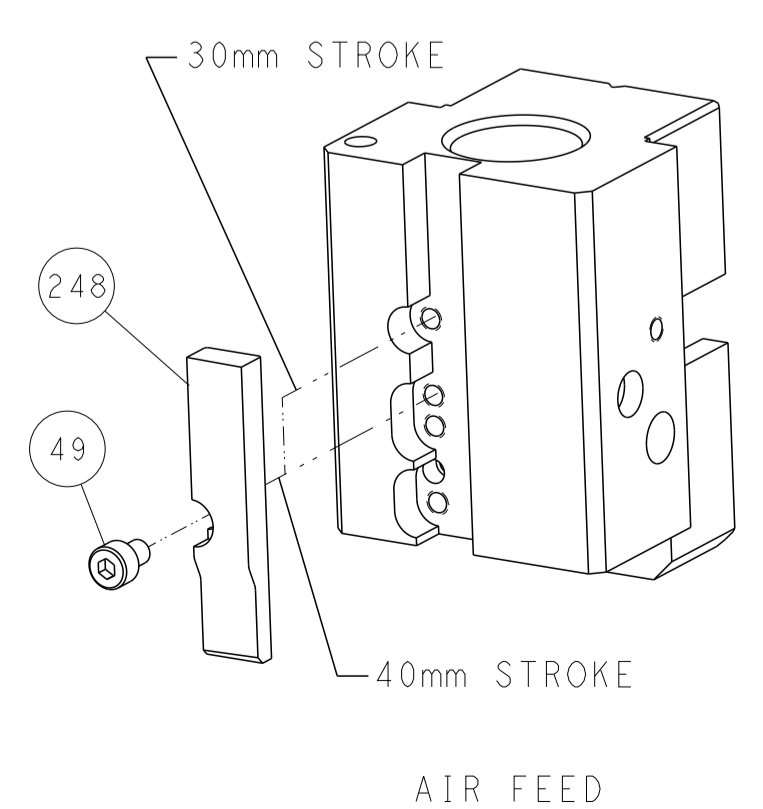
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

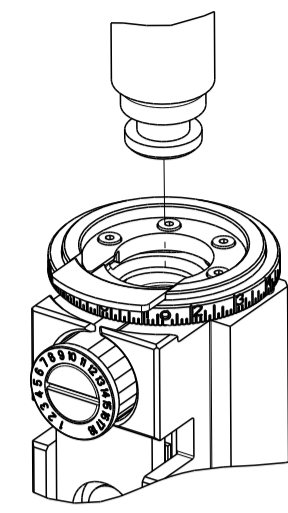


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2017 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2017 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2017 BY TYCO ELECTRONICS CORPORATION.</small>		DMN: K. HUANG 16AUG2017 CHK: Y. YIN 16AUG2017 APVD: L. ZHANG 16AUG2017	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: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150832 WEIGHT: - SCALE: 1:1 SHEET: 2 OF 4 REV: C	RESTRICTED TO: -
MATERIAL: - FINISH: -		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
2-2150832-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150832-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	SP
INSUL	3.80 mm [.150]	OV
APPL INSTRUCTIONS 408-35043		

PART NUMBER	REVISION	DESCRIPTION	CONVERT FROM
7-2150832-8	A	APPLICATOR CONVERSION KIT	2150007-X
7-2150832-9	A	APPLICATOR CONVERSION KIT	2150312-X

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE, FASTON, .187 SERIES		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.75-5.51 mm [.187-.217 IN]		Ø1.41-3.46 mm [.056-.136 IN]
TERMINAL APPLICATION SPECIFICATION	114-143088	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2238174-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57 +/- 0.05 [.062 +/- .002]	5.1
16 AWG	1.37 +/- 0.05 [.054 +/- .002]	6.9
18 AWG	1.22 +/- 0.05 [.048 +/- .002]	8.5
20 AWG	1.12 +/- 0.05 [.044 +/- .002]	9.5
22 AWG	1.07 +/- 0.05 [.042 +/- .002]	10.3
24 AWG	1.02 +/- 0.05 [.040 +/- .002]	11.1

- 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.
- 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.

- ASSEMBLE THE FIRST WIRE CRIMPER AS BELOW.
- ASSEMBLE THE SECOND WIRE CRIMPER AS BELOW.
- REPLACE ITEM # IN ORIGINAL APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 85.
- CUT TO LENGTH AT ASSEMBLY.

***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.

ACTION LIST		
ADD	ADD	180
ADD	ADD	177
ADD	ADD	176
ADD	ADD	175
ADD	ADD	174
ADD	ADD	154
ADD	ADD	85
ADD	-	84
-	REPLACE #82	82
CHANGE QUANTITY	CHANGE QUANTITY	73
ADD	ADD	65
REMOVE	REMOVE	64
CHANGE QUANTITY	CHANGE QUANTITY	57
-	REPLACE #56	56
REMOVE	REMOVE	55
ADD	ADD	52
CHANGE QUANTITY	CHANGE QUANTITY	33
REPLACE #29	REPLACE #29	29
REPLACE #25	REPLACE #25	25
-	REPLACE #24	24
REMOVE	REMOVE	23
REPLACE #20	REPLACE #20	20
ADD	ADD	19
REPLACE #18	REPLACE #18	18
-	REMOVE	16
REPLACE #11	REPLACE #11	11
REPLACE #9	REPLACE #9	9
REPLACE #8	REPLACE #8	8
REPLACE #7	REPLACE #7	7
ADD	ADD	6
REPLACE #5	REPLACE #5	5
REPLACE #4	REPLACE #4	4
REPLACE #3	REPLACE #3	3
ADD	ADD	2
REPLACE #1	REPLACE #1	1
-79 ACTION	-78 ACTION	ITEM NO

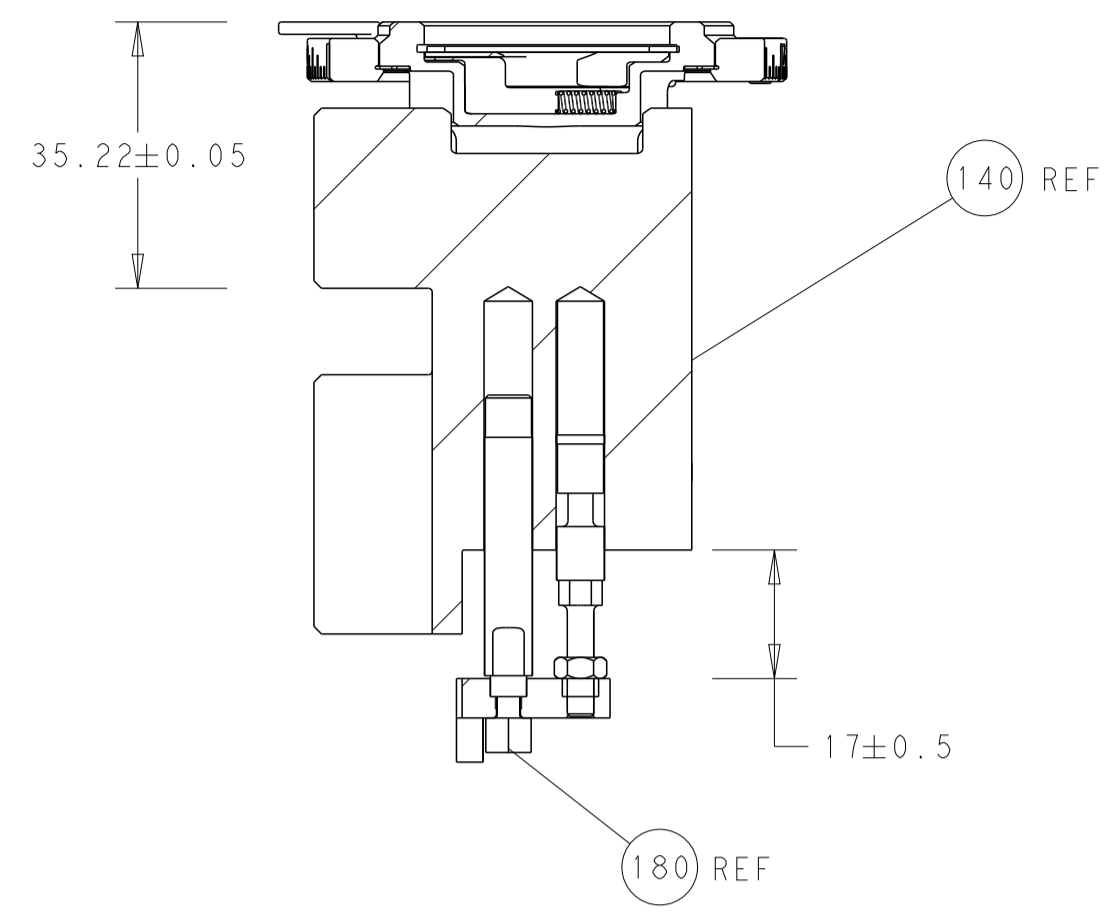
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	-	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	1	2844940-3	AIR FEED MODULE	238
-	-	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	1	1	-	1752354-3	STANDOFF, HOLD-DOWN	180
1	1	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
1	1	-	1	8-22280-7	SPRING, COMPRESSION	176
1	1	-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
1	1	-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	REF	994970-2	COUNTER, MAGNETIC	164
1	1	-	1	1803613-4	CRIMPER, WIRE, OVERLAP, 2D	154
-	-	-	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
	2	2	-	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	85
	1	-	-	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	-	1	455888-4	SPACER, CRIMPER	82
1	1	-	2	2119791-9	DEPRESSOR, WIRE	73
-	-	-	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	1	-	1	1901681-5	HOLDDOWN, TERMINAL	65
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	1	-	4	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	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	-	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
1	1	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	2063961-1	FEED FINGER	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
1	1	-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	-	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
2	2	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	-	-	1	240639-1	STRIPPER (MACHINING)	27
2	2	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	-	1	1752371-5	PLATE, STRIP GUIDE	24
-	-	-	2	2-22281-3	SPRING, COMPRESSION	22
1	1	-	1	1803292-4	DRAG	20
1	1	-	1	1803152-4	STRIP GUIDE, REAR	19
1	1	-	1	1803151-4	STRIP GUIDE, FRONT	18
	1	1	-	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
	1	1	-	690482-1	PLATE, FRONT SHEAR	9
	1	1	1	7-1803074-0	ANVIL, COMBINATION, END FEED	8
	1	1	-	2217206-1	BLADE, SLUG	7
1	1	-	1	1-2119757-6	DEPRESSOR, SHEAR	6
1	1	-	1	240641-8	SPACER	5
1	1	-	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	3-1803199-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
1	1	-	1	455888-9	SPACER, CRIMPER	2
	1	1	1	1803726-2	CRIMPER, WIRE, OVERLAP, 2D	1

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:		OWN	16AUG2017	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	16AUG2017	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	16AUG2017	NAME
	FINISH	FINISH	FINISH	L. ZHANG		Ocean End Feed Applicator
MATERIAL	FINISH	FINISH	FINISH	PRODUCT SPEC	APPLICATION SPEC	SIZE
				WEIGHT	SCALE	CAGE CODE
					00779	DRAWING NO
					©=2150832	RESTRICTED TO
					Customer Accessible Production Drawing	SHEET 3 OF 4

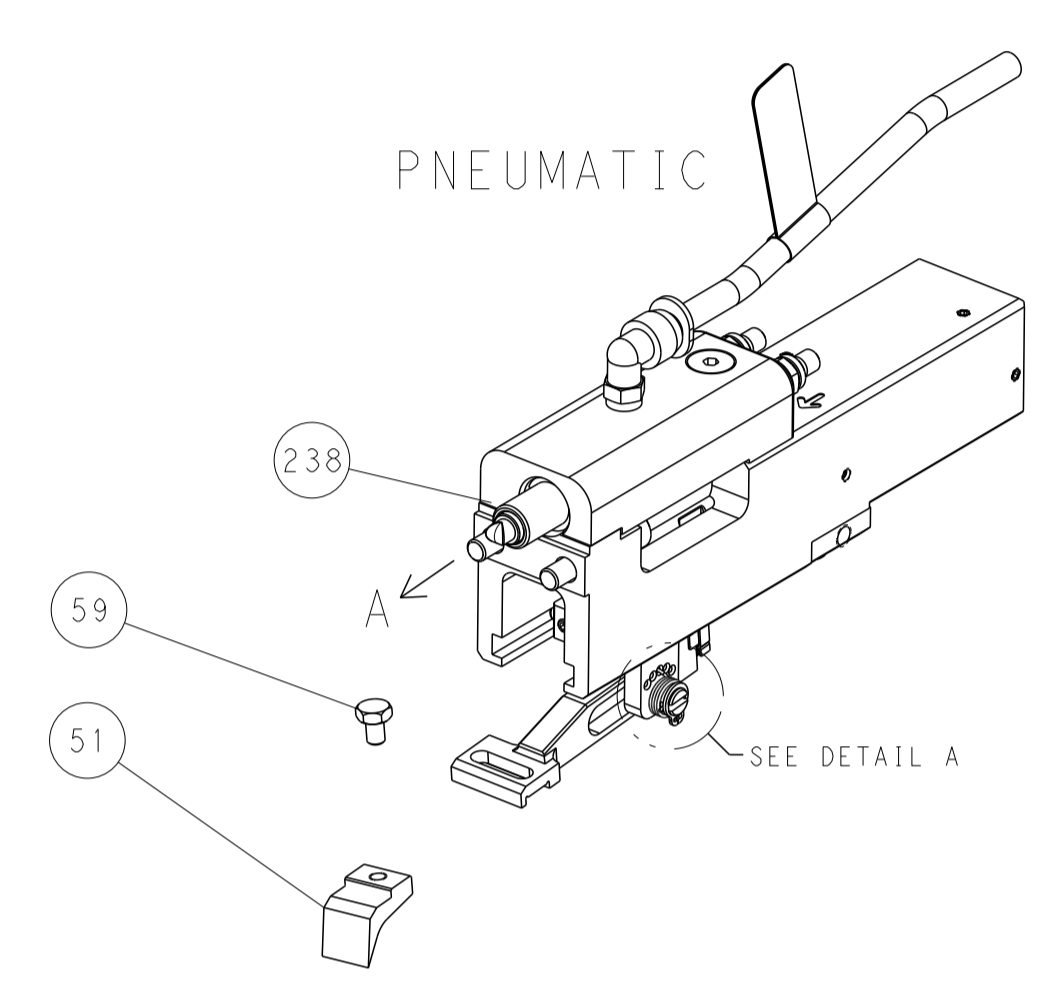
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



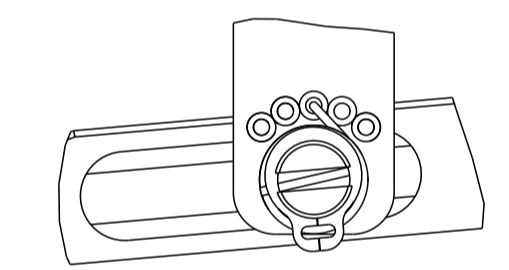
RAM AND HOLDDOWN SET-UP

FEED TYPE

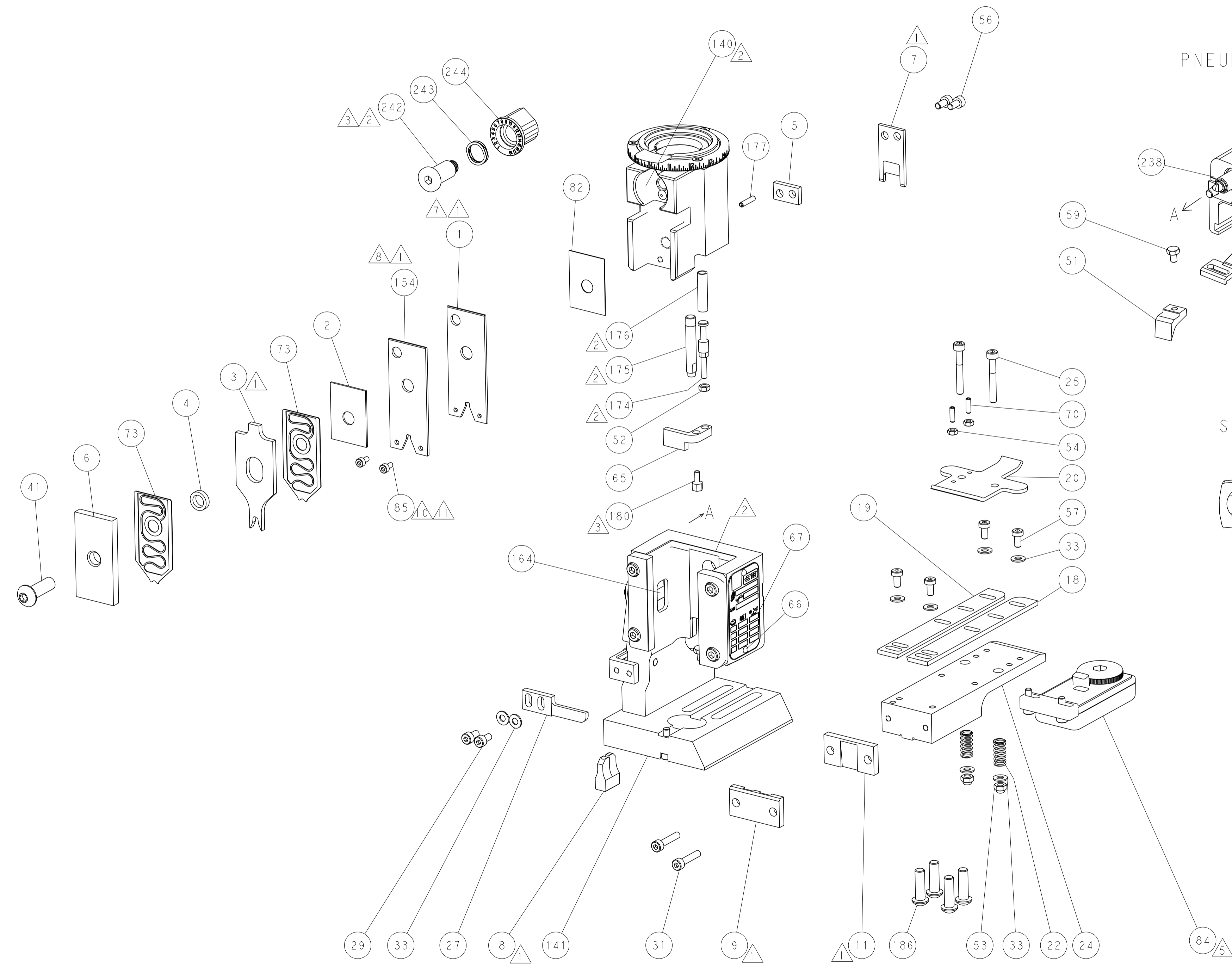
PNEUMATIC



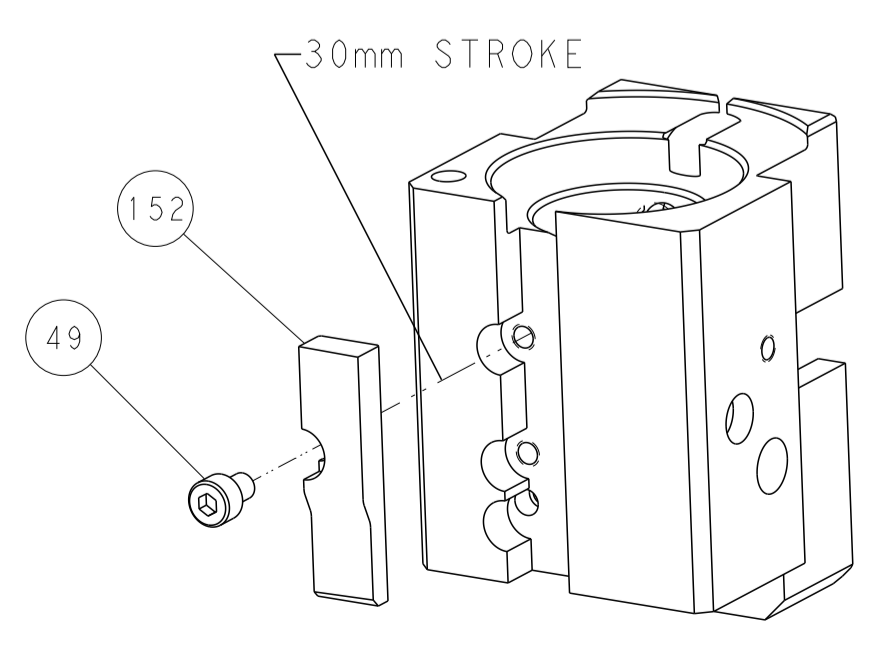
FEED SPRING SETTING POSITION



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 16AUG2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK Y. YIN 16AUG2017	NAME		
				APVD L. ZHANG 16AUG2017	PRODUCT SPEC		
					APPLICATION SPEC		
MATERIAL				WEIGHT	SIZE	CAGE CODE	DRAWING NO
					A1	00779	©=2150832
					RESTRICTED TO		
					Customer Accessible Production Drawing	SCALE	1:1 SHEET 4 OF 4 REV C