

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4150086-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150086-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4150086-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	5.25 mm [.207]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK 187 SERIES			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.68-4.45 mm [.145-.175 IN]		Ø 2.56-3.11 mm [.101-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238279-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.45+/-0.05 [.057+/-0.002]	4.6
2X 20 AWG	1.37+/-0.05 [.054+/-0.002]	5.4
18 AWG	1.27+/-0.05 [.050+/-0.002]	6.5
2X 22 AWG	1.22+/-0.05 [.048+/-0.002]	7.1
20 AWG	1.14+/-0.05 [.045+/-0.002]	7.5

- RECOMMENDED SPARE PARTS.
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 180.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.
- MAX INSULATION DIAMETER FOR DOUBLE 20 AWG WIRE IS (2)2.56mm.
- MAX INSULATION DIAMETER FOR DOUBLE 22 AWG WIRE IS (2)2.38mm.

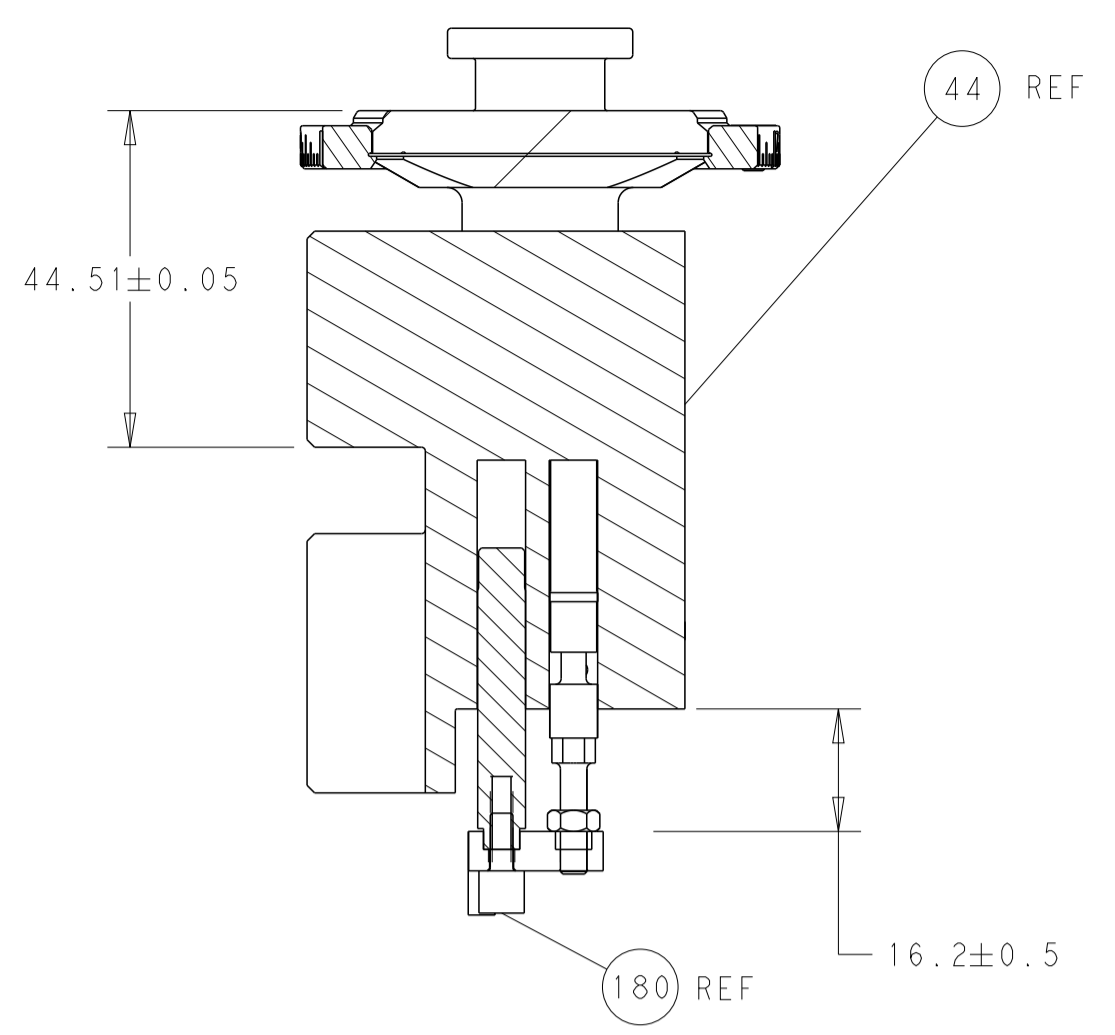
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66	1		DEVELOPMENT	20JAN2021	TB	GB
		2		DEVELOPMENT	01FEB2021	TB	GB
		A		RELEASED	10MAR2021	TB	GB
		B		ECR-23-193881	30NOV2023	FZ	TE

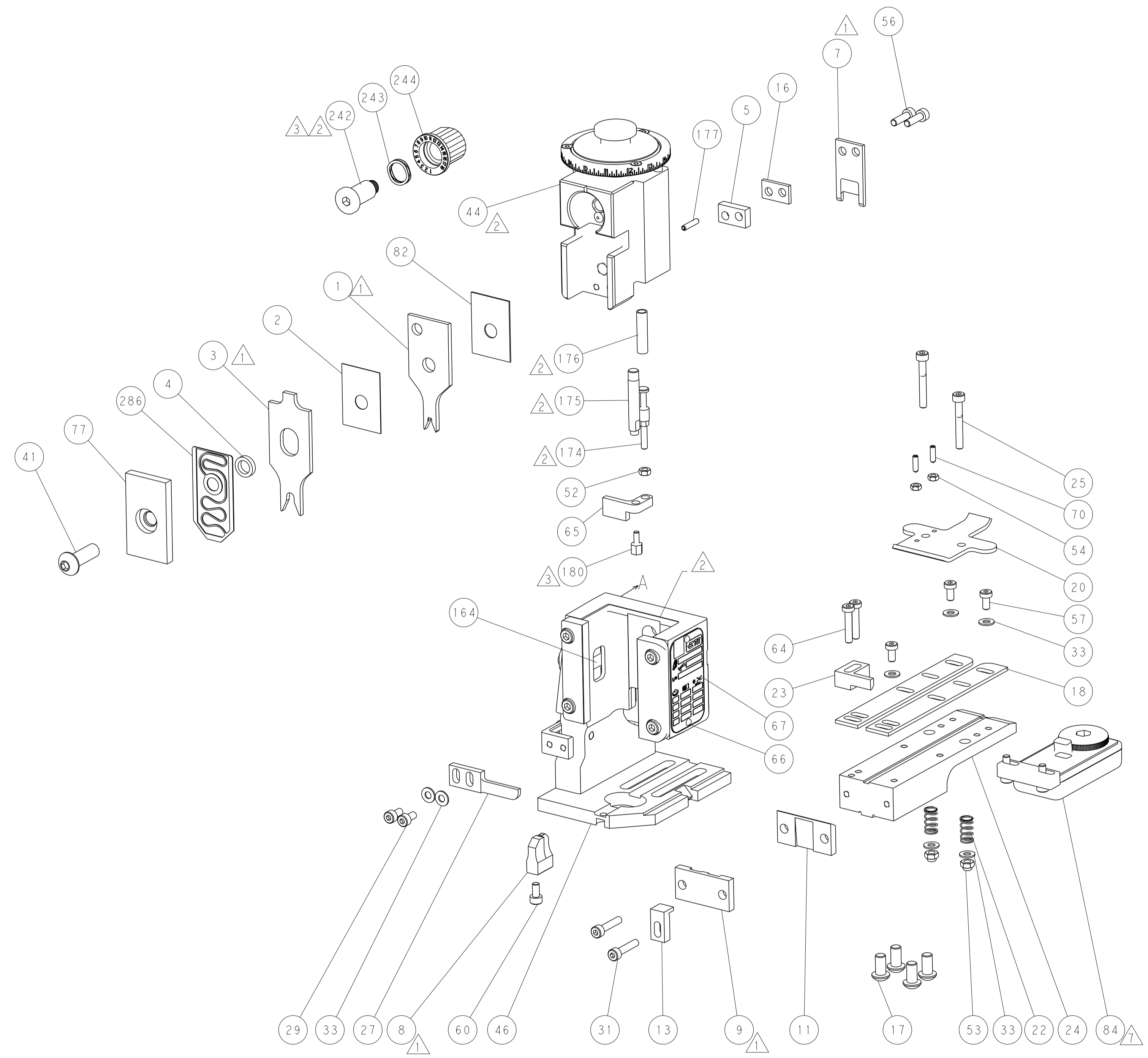
-	1	1	1-2119791-4	DEPRESSOR, WIRE	286	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	AIR FEED MODULE	238	
	1	1	1752354-7	STANDOFF, HOLD-DOWN	180	
-	1	1	6-9931111-6	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-6	SPACER, CRIMPER -	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	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	1901681-9	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-1	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	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	4-1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-9	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	1	240833-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	6-690482-0	PLATE, FRONT SHEAR	9	
	1	2	1	3-1803711-1	ANVIL, COMBINATION, END FEED -	8
	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-9	SPACER	5
-	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	2	1	7-1803365-1	CRIMPER, INSULATION 0	3
-	1	1	1	455888-3	SPACER, CRIMPER -	2
	1	2	1	9-1803224-1	CRIMPER, WIRE	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		A 00779 C=4150086	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4		REV B	

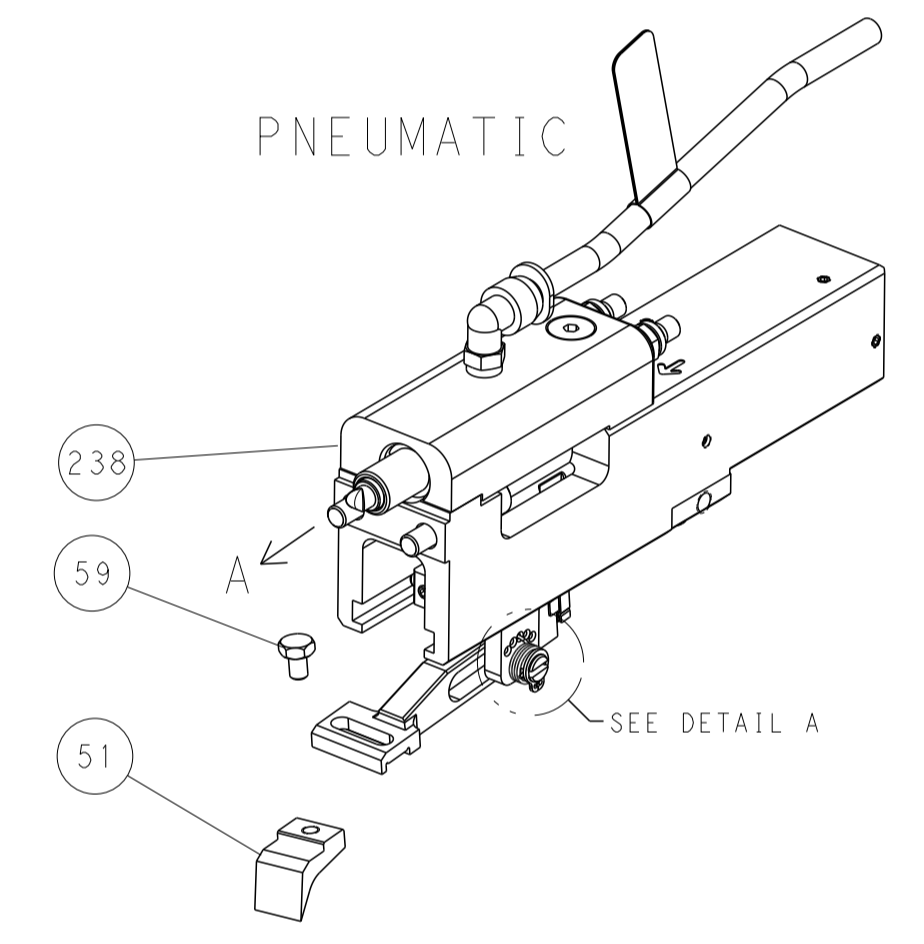
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



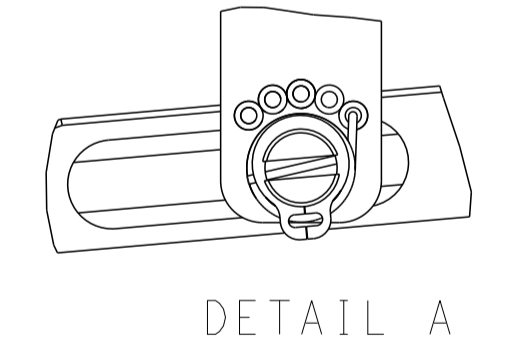
RAM AND HOLDDOWN SET-UP



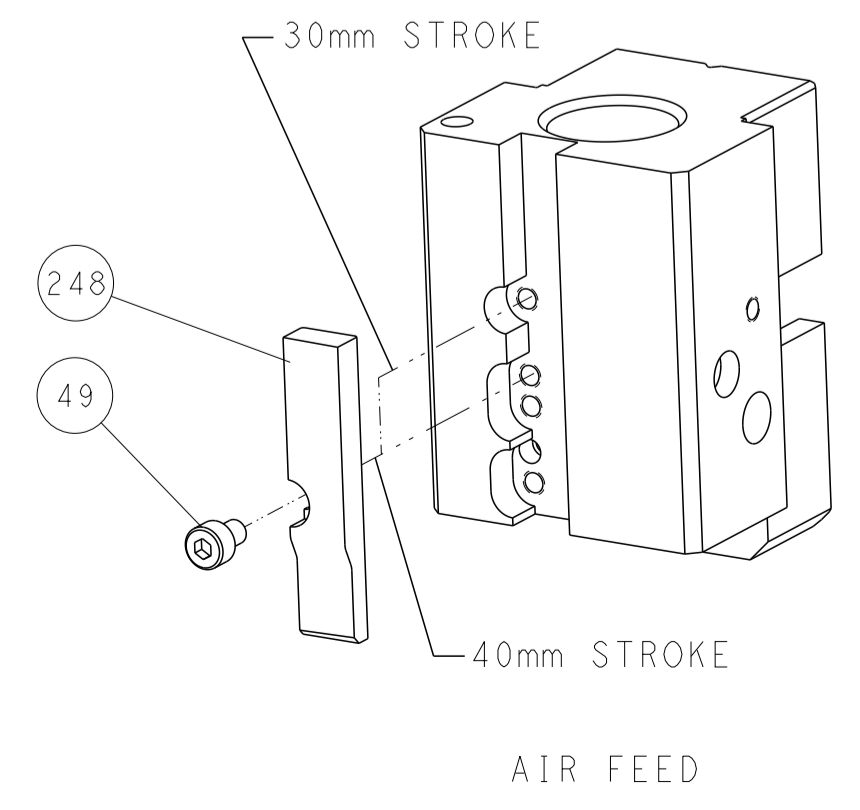
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		DWN T. BROOKENS 20JAN2021 CHK M. HERR 20JAN2021 APVD G. BAILEY 20JAN2021 PRODUCT SPEC APPLICATION SPEC WEIGHT - Customer Accessible Production Drawing		NAME OCEAN 2.0 End Feed Applicator SIZE CAGE CODE DRAWING NO A 00779 C=4150086 SCALE 1:1 SHEET 2 OF 4 REV B		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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