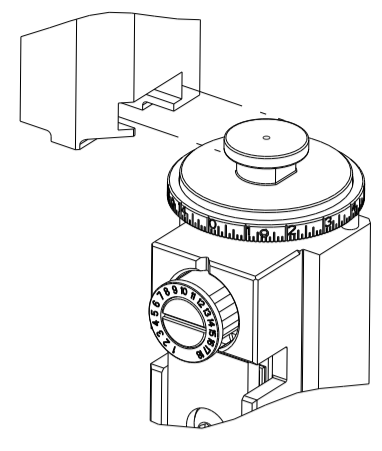


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150049-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150049-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150049-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150049-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150049-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



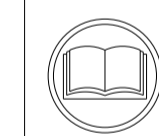
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .110 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.96-4.37 mm [.156-.172 IN]	Ø1.52-2.54 mm [.060-.100 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42068-1	60118-4	60415-3	140717-7
42068-2	60118-5	60415-6	140928-2
42236-1	60197-1	140717-1	141058-1
60577-1	60197-2	140717-2	140825-1
60577-2	60197-3	140717-4	140825-2
60118-1	60415-1	140717-5	
60118-3	60415-2	140717-6	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .110 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.96-4.37 mm [.156-.172 IN]	Ø1.52-2.54 mm [.060-.100 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238095-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.91+/-0.05 [.036+/- .002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.24+/-0.05 [.049+/- .002]	2.6
20 AWG OR 0.50mm2	1.09+/-0.05 [.043+/- .002]	4.1
22 AWG OR 0.35mm2	1.02+/-0.05 [.040+/- .002]	4.8



- 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 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.
- WHEN INSTALLING ON A TERMINATOR WITH A STRIPPING MODULE IF INTERFERENCE WITH THE HOLD DOWN (ITEM #23) EXISTS, REMOVE THE HOLD DOWN. REMOVAL OF THE HOLD DOWN DOES NOT AFFECT THE OPERATIONAL ASPECT OF APPLICATOR
- 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.

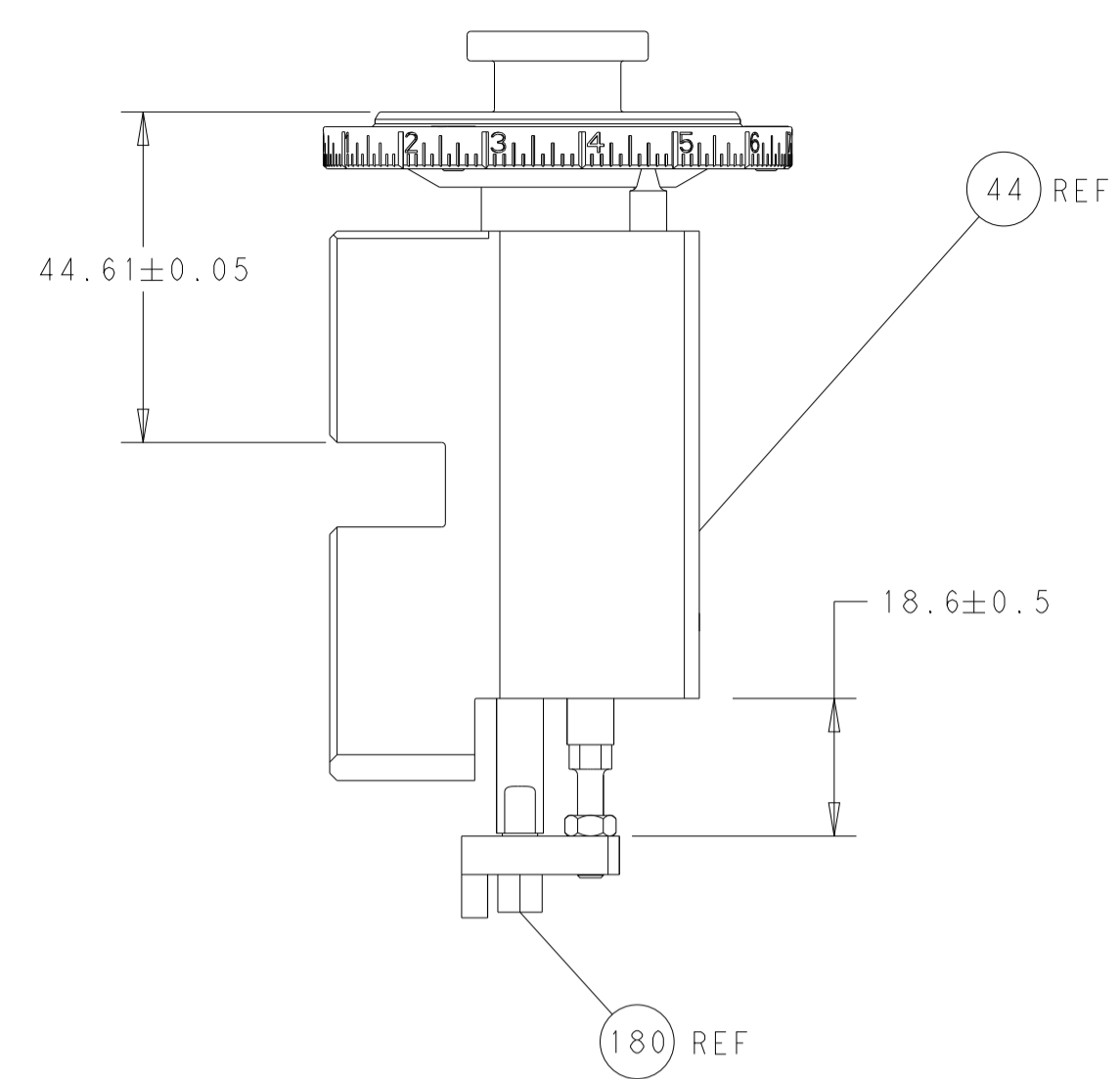
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		E1	15APR2019	FL	GB
		F	19APR2021	JWC	RK
		G	15FEB2022	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	1752354-5	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	1	1	2119791-5	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	1-2063961-0	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	-	1-2063961-0	FEED FINGER	51	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-4	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	240825-4	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	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	1-690482-8	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1338673-4	ANVIL, COMBINATION	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	1	1	1	1	240641-8	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1803017-8	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	2	1	1-456403-5	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)

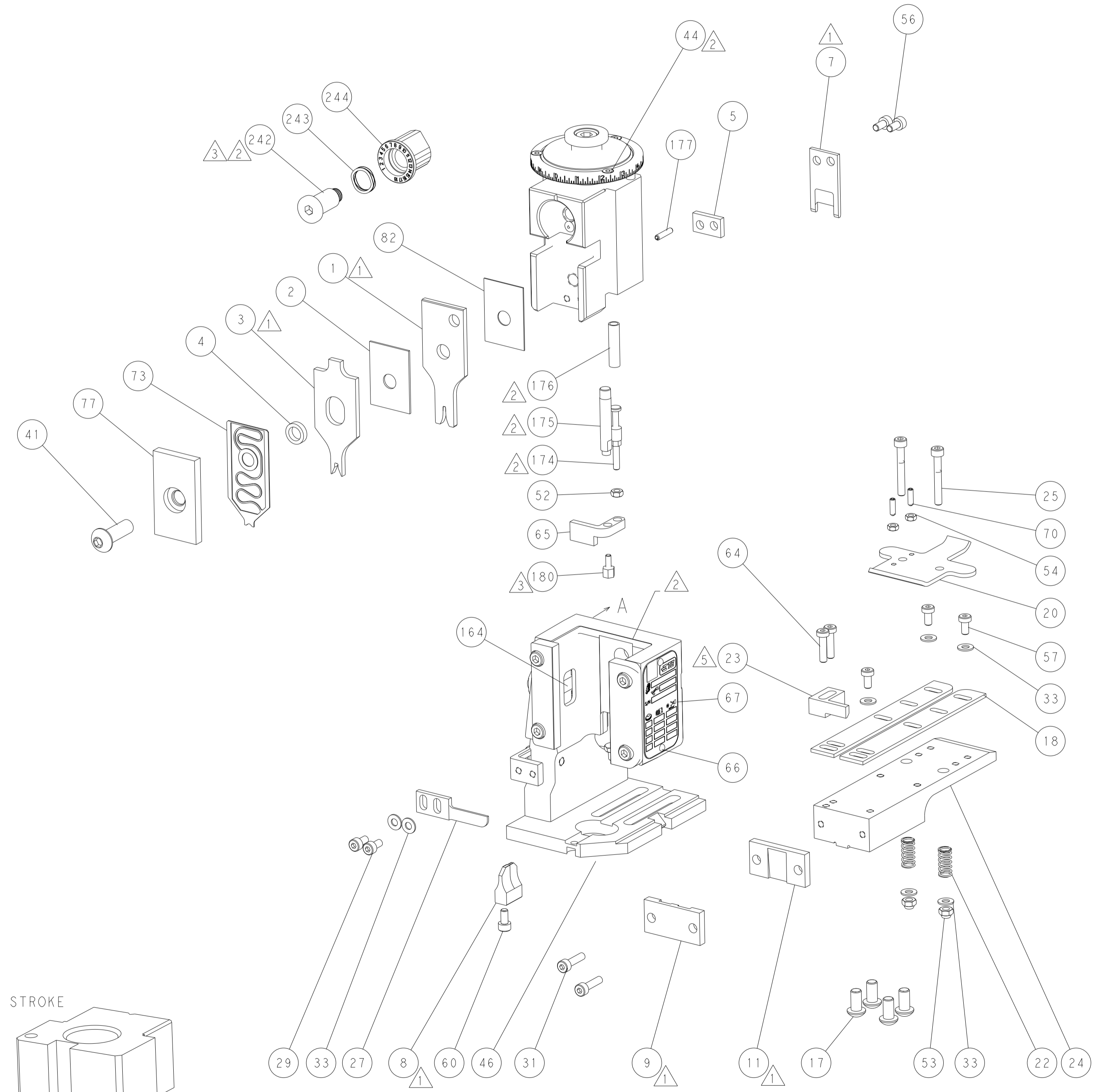
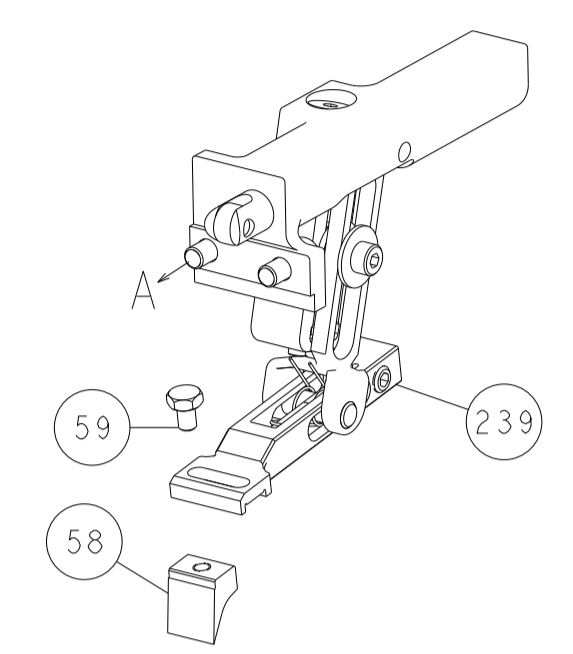
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: L. ZHANG 31JAN2012		CHK: L. ZHANG 31JAN2012		APVD: S. XI 31JAN2012		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES ±	FINISH	WEIGHT	SCALE: 1:1	SHEET 1 OF 4
MATERIAL:	Customer Accessible Production Drawing		DRAWING NO: 00779		C=2150049		RESTRICTED TO:		REV G		

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

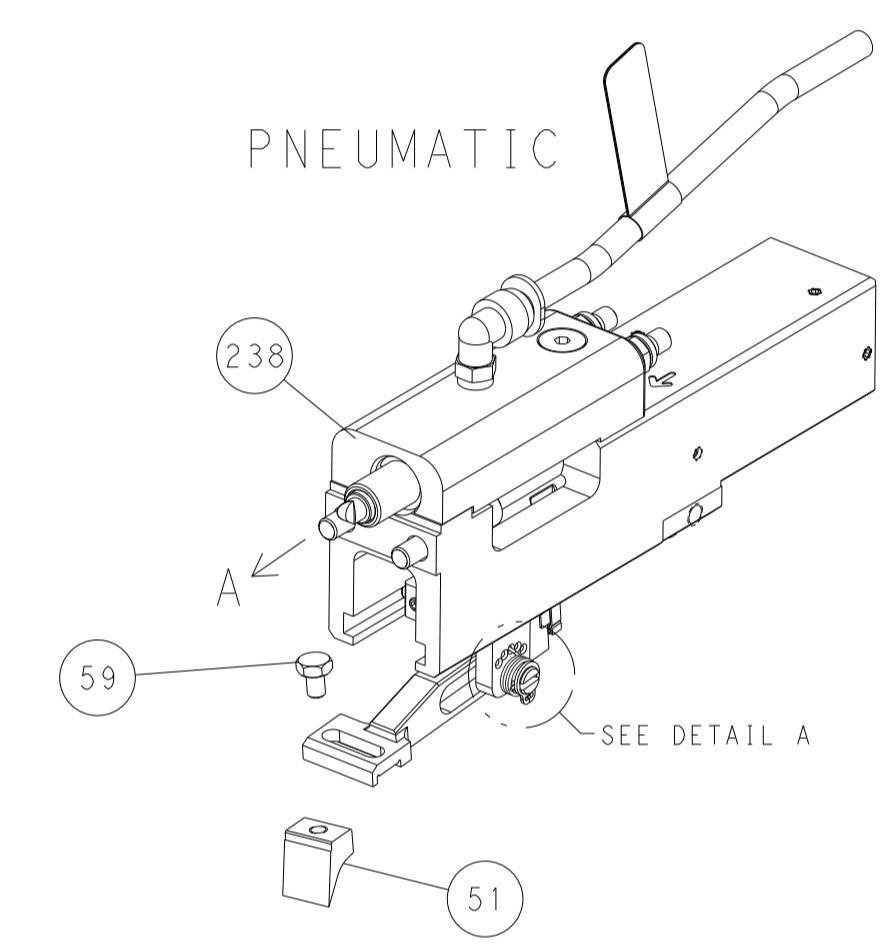


RAM AND HOLDDOWN SET-UP

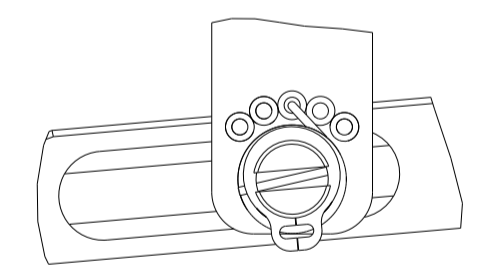
FEED TYPE  
MECHANICAL



PNEUMATIC

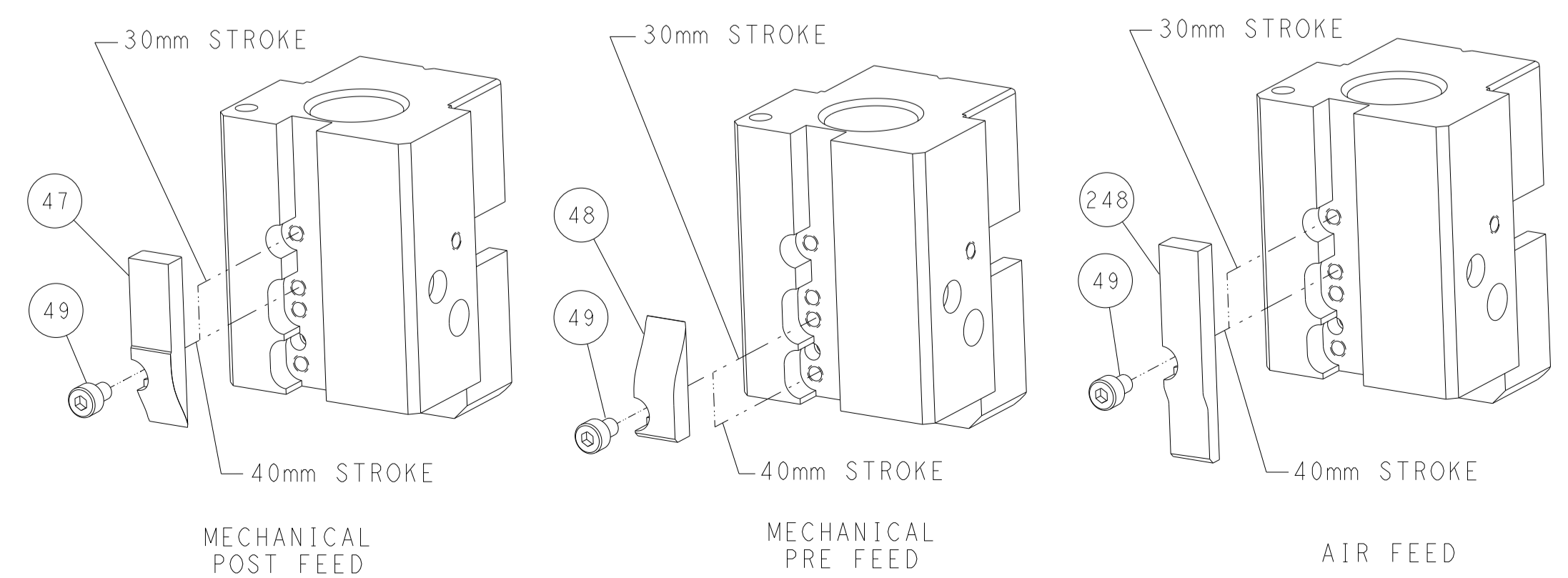


FEED SPRING  
SETTING POSITION



DETAIL A

CAM POSITIONS

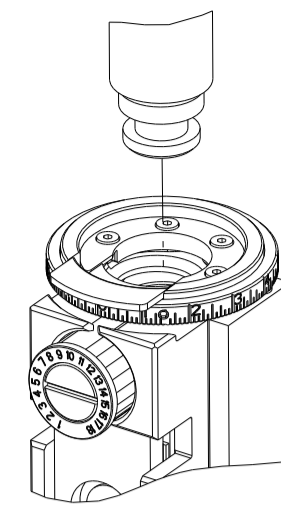


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN L. ZHANG 31 JAN 2012 CHK L. ZHANG 31 JAN 2012 APVD S. XI 31 JAN 2012	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: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150049 SCALE: 1:1 SHEET: 2 of 4 REV: G
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150049-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150049-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150049-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



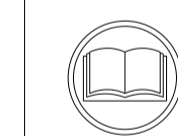
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [0.062]	F
INSUL	2.29 mm [0.090]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .110 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.96-4.37 mm [0.156-.172 IN]		Ø1.52-2.54 mm [0.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42068-1	60118-4	60415-3	140717-7
42068-2	60118-5	60415-6	140928-2
42236-1	60197-1	140717-1	141058-1
60577-1	60197-2	140717-2	140825-1
60577-2	60197-3	140717-4	140825-2
60118-1	60415-1	140717-5	
60118-3	60415-2	140717-6	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .110 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.96-4.37 mm [0.156-.172 IN]		Ø1.52-2.54 mm [0.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238095-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.91+/-0.05 [0.036+/-0.002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm <sup>2</sup>	1.24+/-0.05 [0.049+/-0.002]	2.6
20 AWG OR 0.50mm <sup>2</sup>	1.09+/-0.05 [0.043+/-0.002]	4.1
22 AWG OR 0.35mm <sup>2</sup>	1.02+/-0.05 [0.040+/-0.002]	4.8



- 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 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.
- WHEN INSTALLING ON A TERMINATOR WITH A STRIPPING MODULE IF INTERFERENCE WITH THE HOLD DOWN (ITEM #23) EXISTS, REMOVE THE HOLD DOWN. REMOVAL OF THE HOLD DOWN DOES NOT AFFECT THE OPERATIONAL ASPECT OF APPLICATOR
- 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.

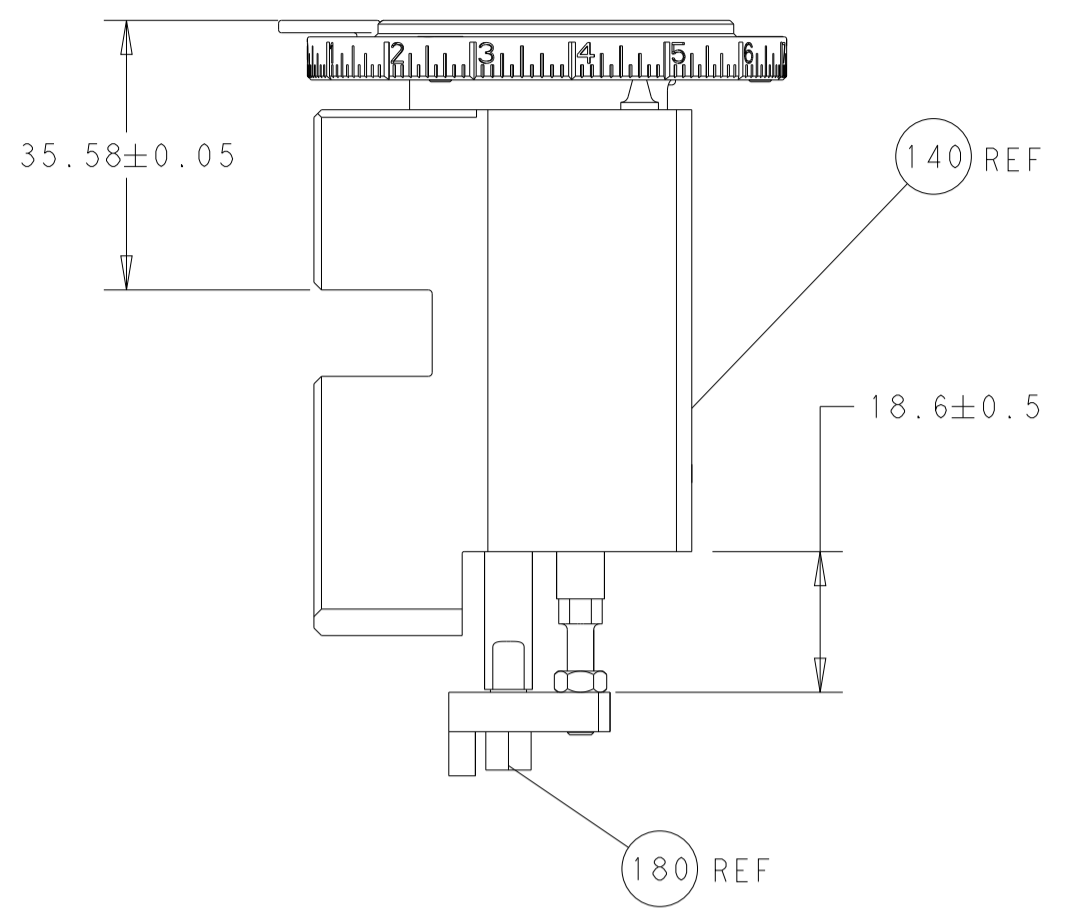
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-9	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	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
3	-	1	1752354-5	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	-	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	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	2119791-5	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	1-2063961-0	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	-	1-2063961-0	FEED FINGER	51	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-4	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	
5	-	1	240825-4	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-4	GUIDE, LOWER STRIP	18	
1	-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	1-690482-8	PLATE, FRONT SHEAR	9	
1	1	1	1338673-4	ANVIL, COMBINATION	8	
1	-	1	2217206-7	BLADE, SLUG	7	
-	1	1	240641-8	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	1-1803017-8	CRIMPER, INSULATION F	3	
-	1	1	455888-9	SPACER, CRIMPER	2	
1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

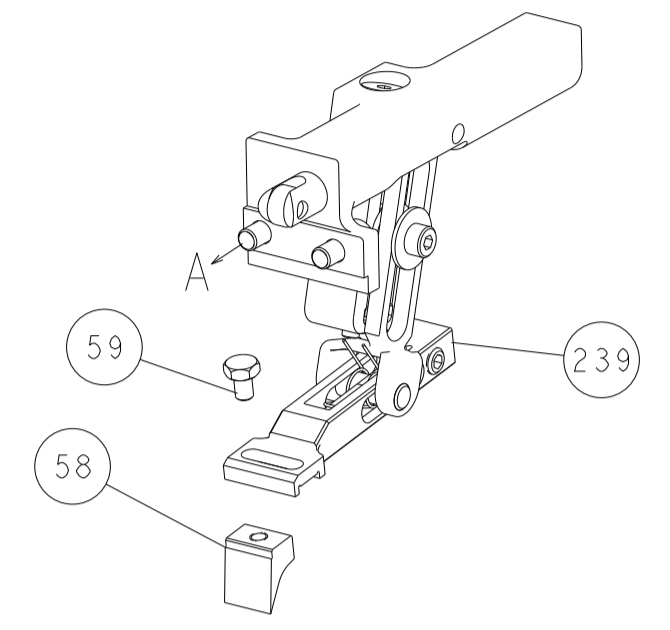
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
ANGLES	±	±	±	±	±	±	±
MATERIAL							
Customer Accessible Production Drawing				SCALE	1:1	SHEET	3 OF 4
Customer Accessible Production Drawing				SCALE	1:1	SHEET	3 OF 4

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

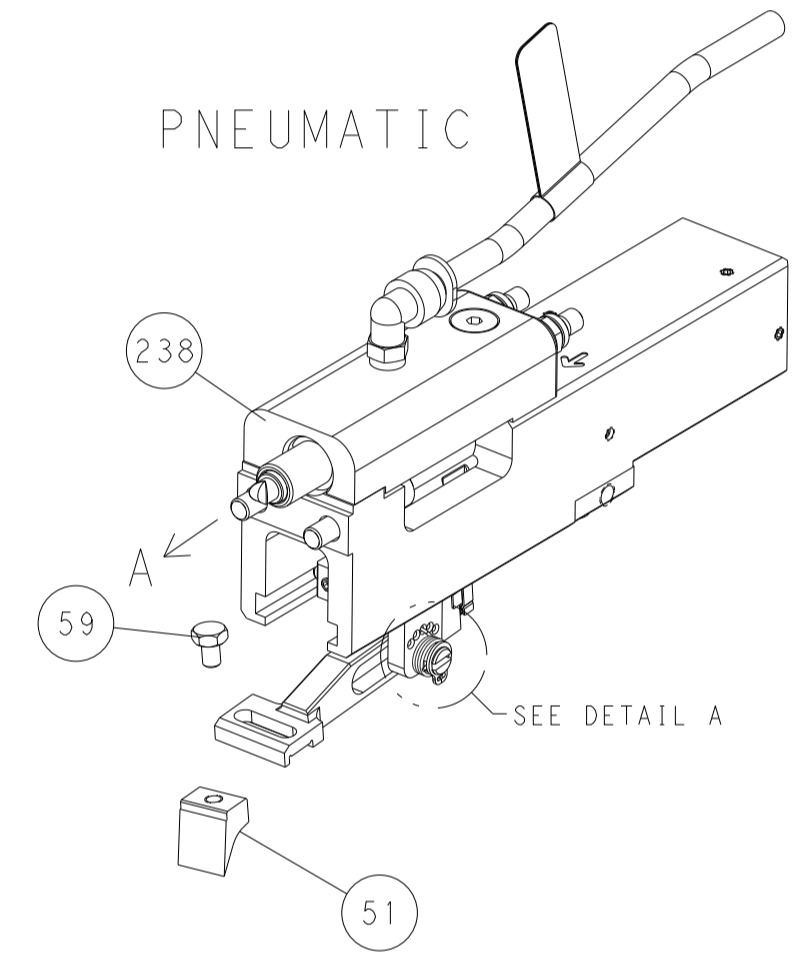


RAM AND HOLDDOWN SET-UP

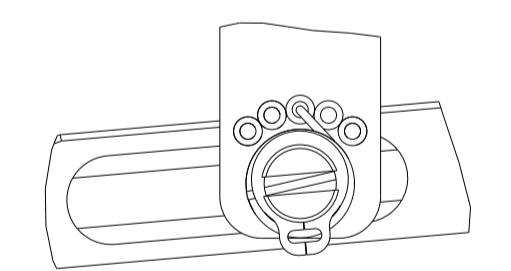
FEED TYPE  
MECHANICAL



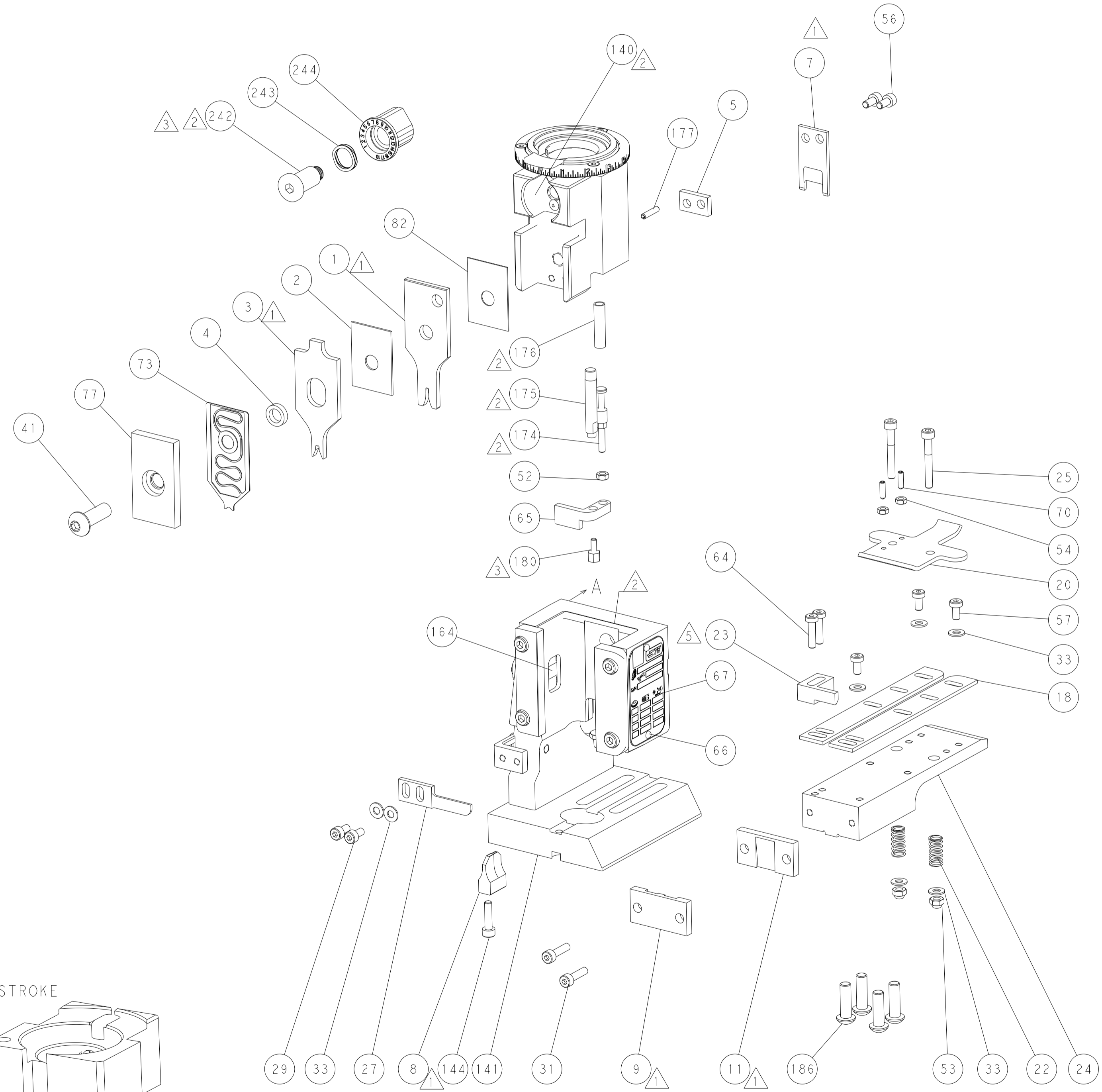
PNEUMATIC



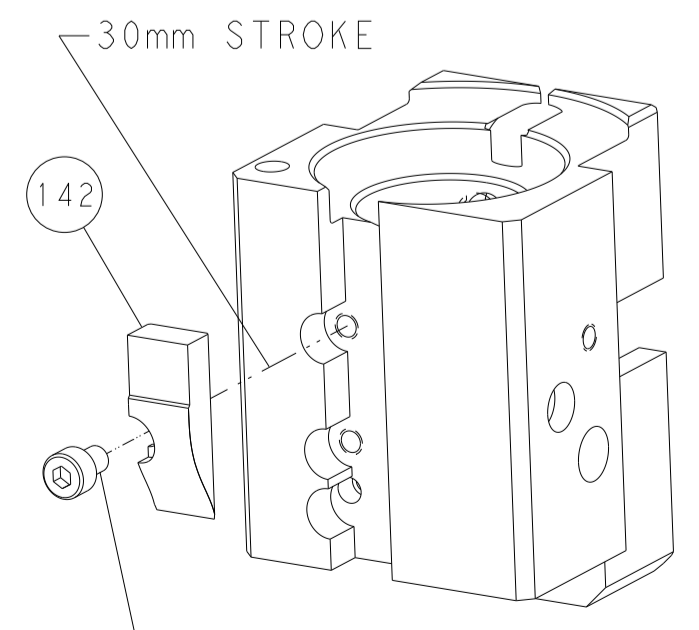
FEED SPRING  
SETTING POSITION



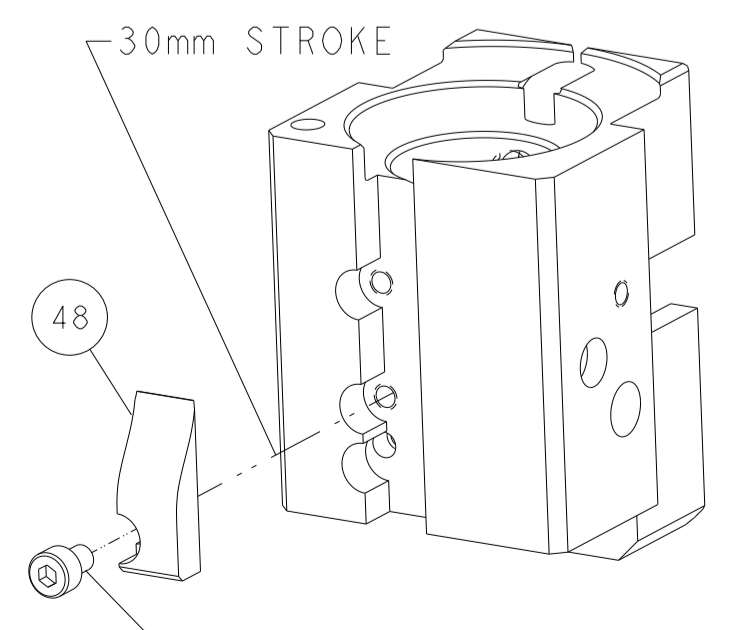
DETAIL A



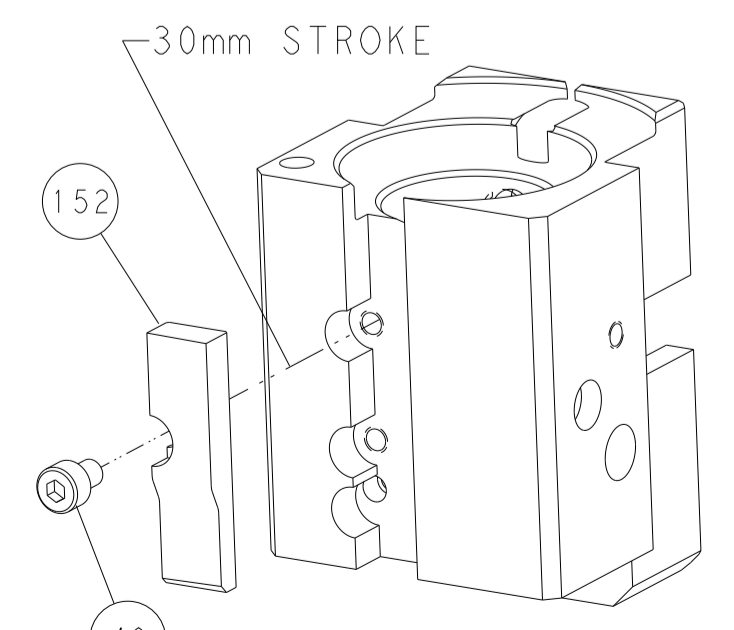
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. C-2150049	RESTRICTED TO SHEET 4 OF 4 REV G