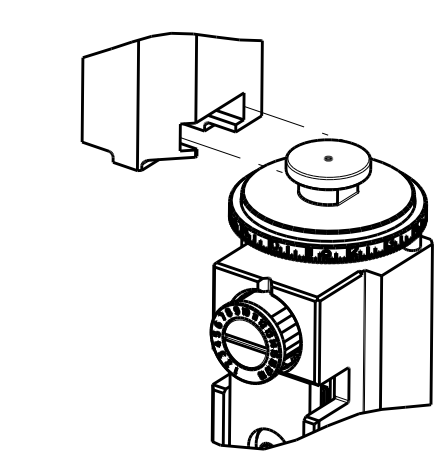


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150636-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150636-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150636-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150636-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150636-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.40-5.16 mm [.173-.203 IN]	Ø1.20-1.90 mm [.047-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140825-1	140825-2	42068-1	42068-2
42236-1	60118-1	60118-3	60118-4
60118-5	60197-1	60197-2	60197-3
60415-1	60415-2	60415-6	60577-1
60577-2	140717-1	140717-2	140717-4
140717-5	140717-6	140717-7	140928-2
141058-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.40-5.16 mm [.173-.203 IN]	Ø1.20-1.90 mm [.047-.075 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
18 AWG OR 0.75mm2	1.24+/-0.05 [.049+/-0.002]	5.0
20 AWG OR 0.50mm2	1.09+/-0.05 [.043+/-0.002]	6.6
22 AWG OR 0.35mm2	1.02+/-0.05 [.040+/-0.002]	7.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.91+/-0.05 [.036+/-0.002]	7.6

- 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 ITEMS 180. 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-2. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN-WALL (FRL) INSULATION. THE INSULATION CRIMP AND APPLICABLE INSULATION RANGE MAY NOT CONFORM TO THE PARAMETER LISTED IN THE APPLICATION SPEC.
- 8. 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.

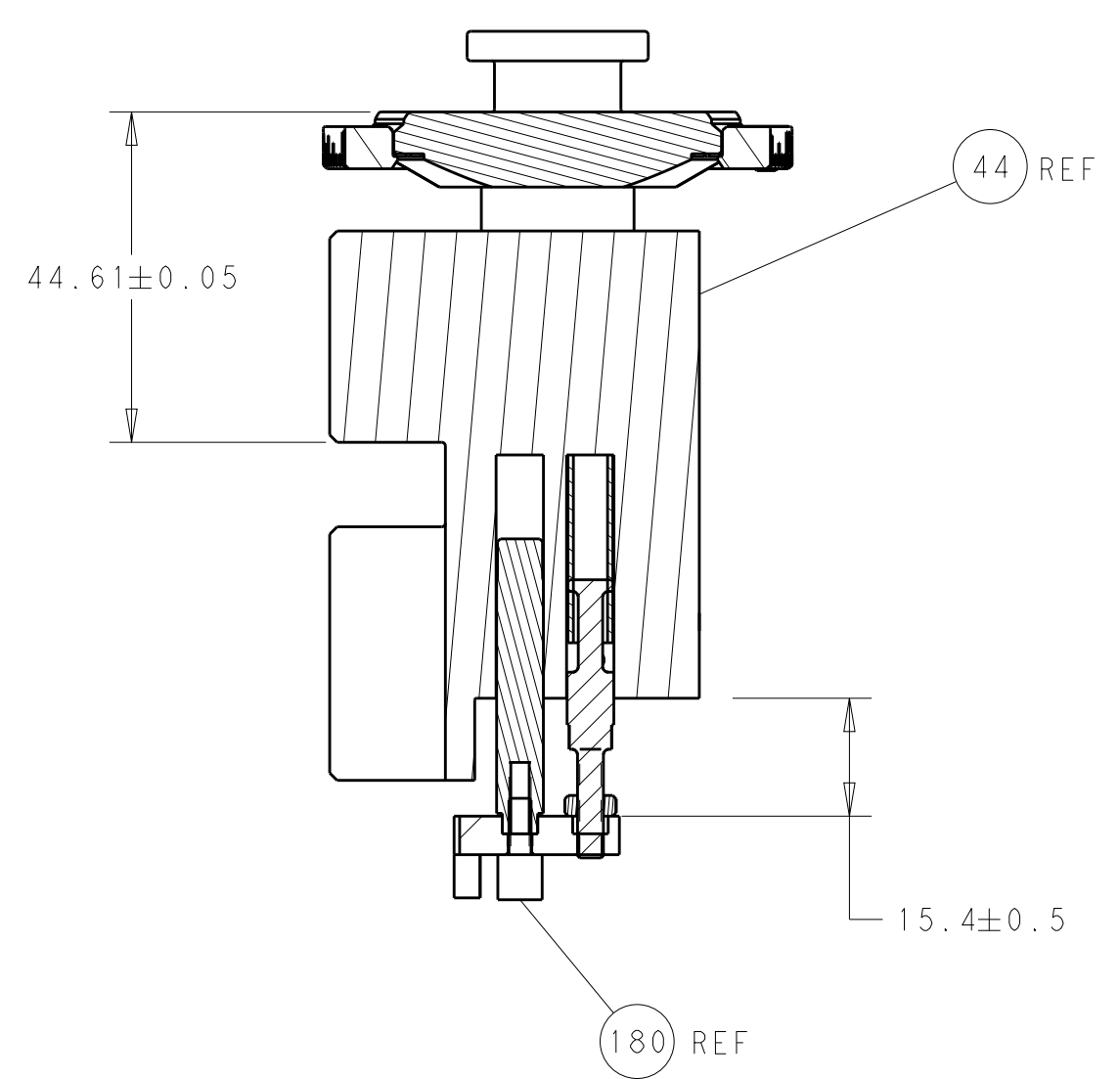
LOC	DIST	REVISIONS					
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		A1		ECR-16-015151	31OCT2016	RS	LZ
		B		ECR-18-018134	20NOV2018	MZ	KZ
		B1		ECR-19-006117	16APR2019	FL	GB

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1	1	1752354-9	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	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	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	1-1901681-3	HOLDDOWN, TERMINAL	65	
-	1	1	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	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	4	4	4	4	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	-	2119792-1	PAWL, EF, AIR	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	
-	8	8	8	8	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	240639-4	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	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	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
1	2	2	1	1	9-1803001-8	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-5	SPACER	5	
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	8-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	2	2	1	1	1-456403-9	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)

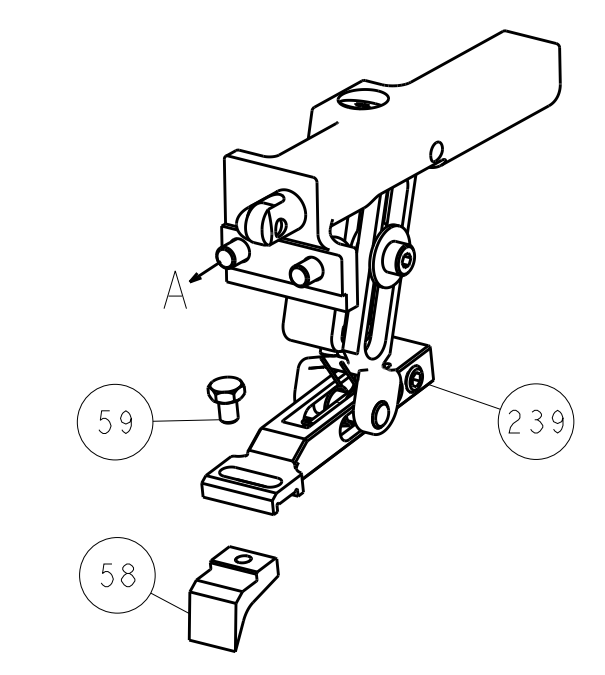
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL:		FINISH:		WEIGHT:		SCALE:	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 1 OF 4		REV: B1	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

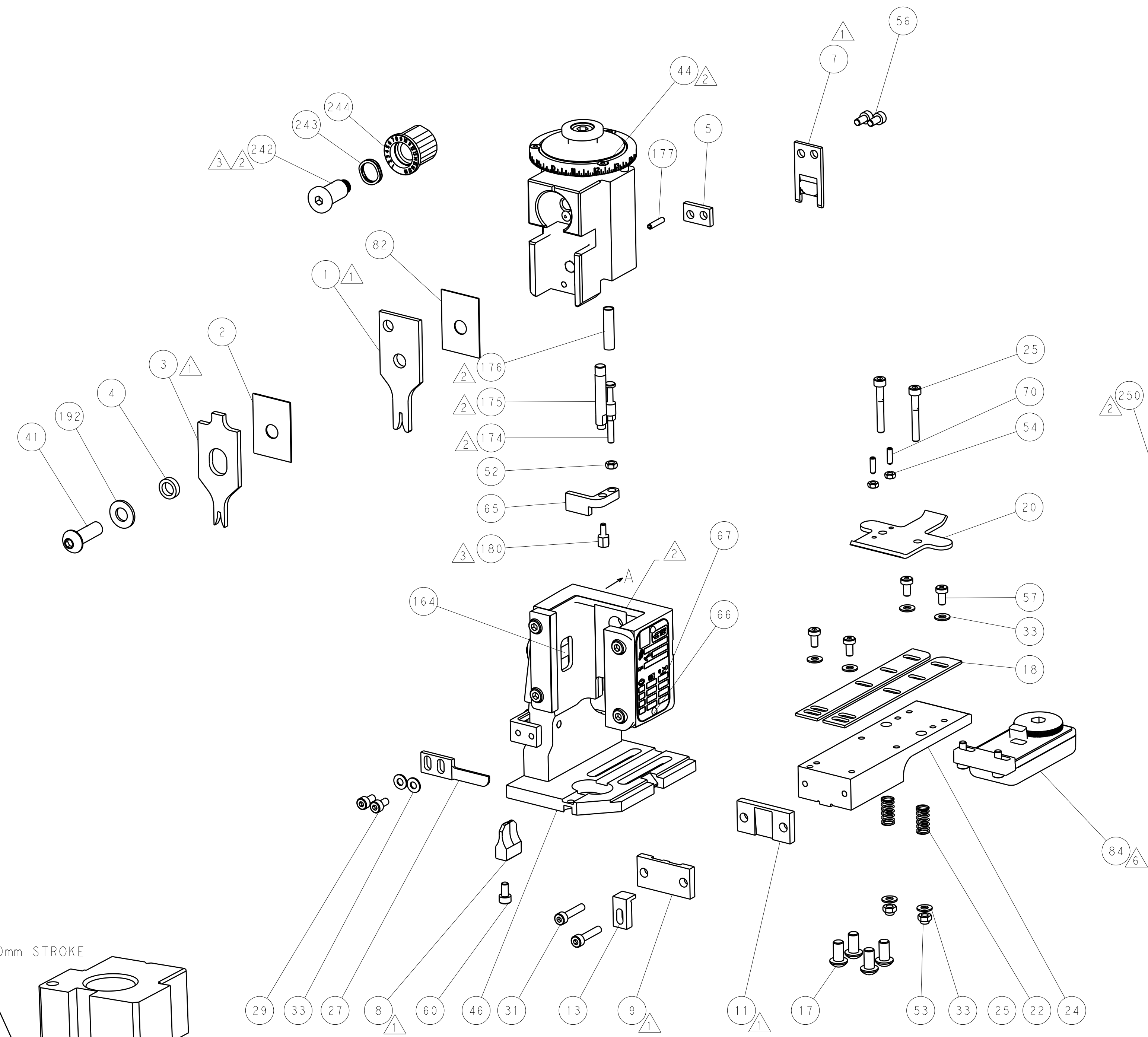
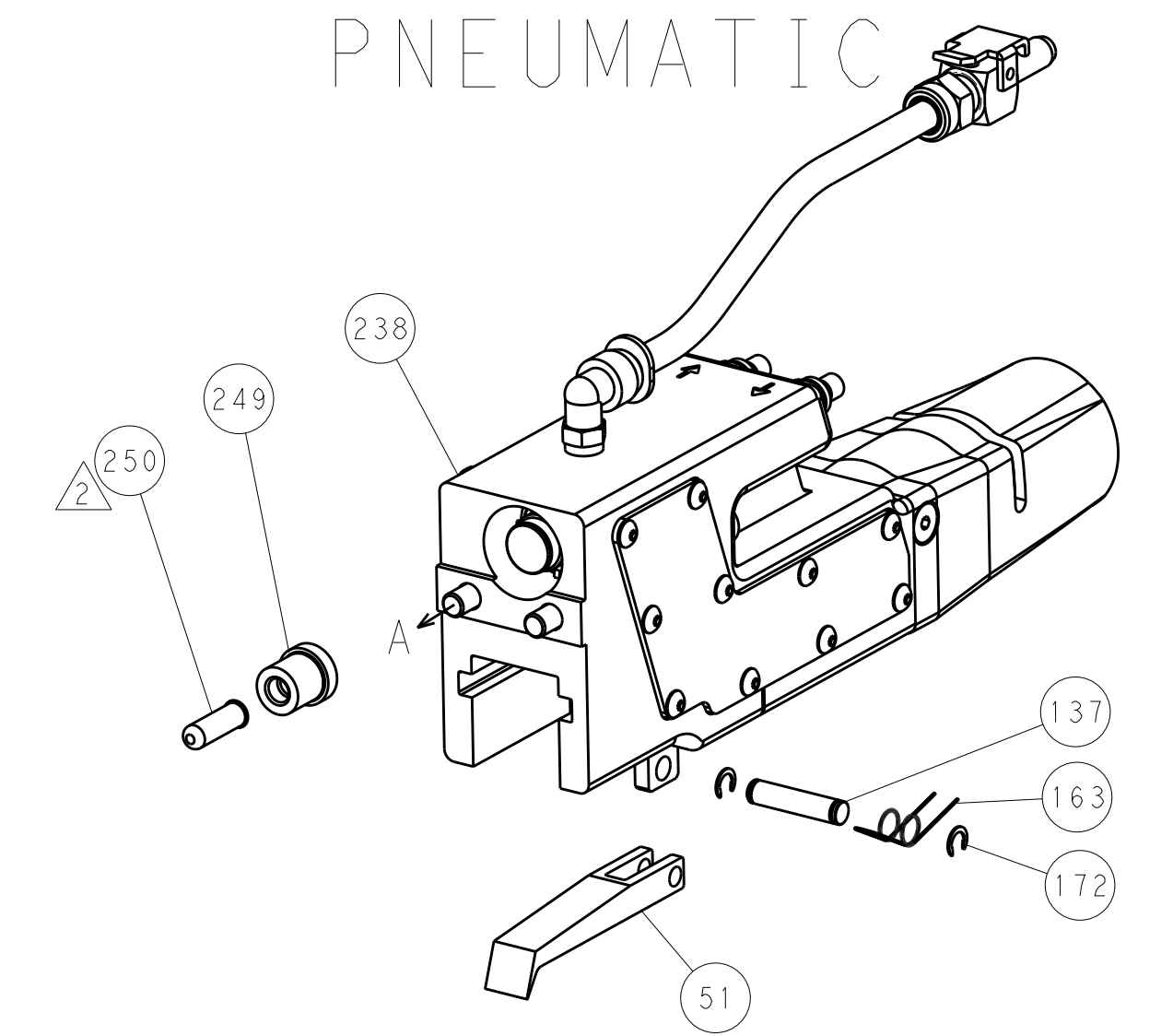


RAM AND HOLDDOWN SET-UP

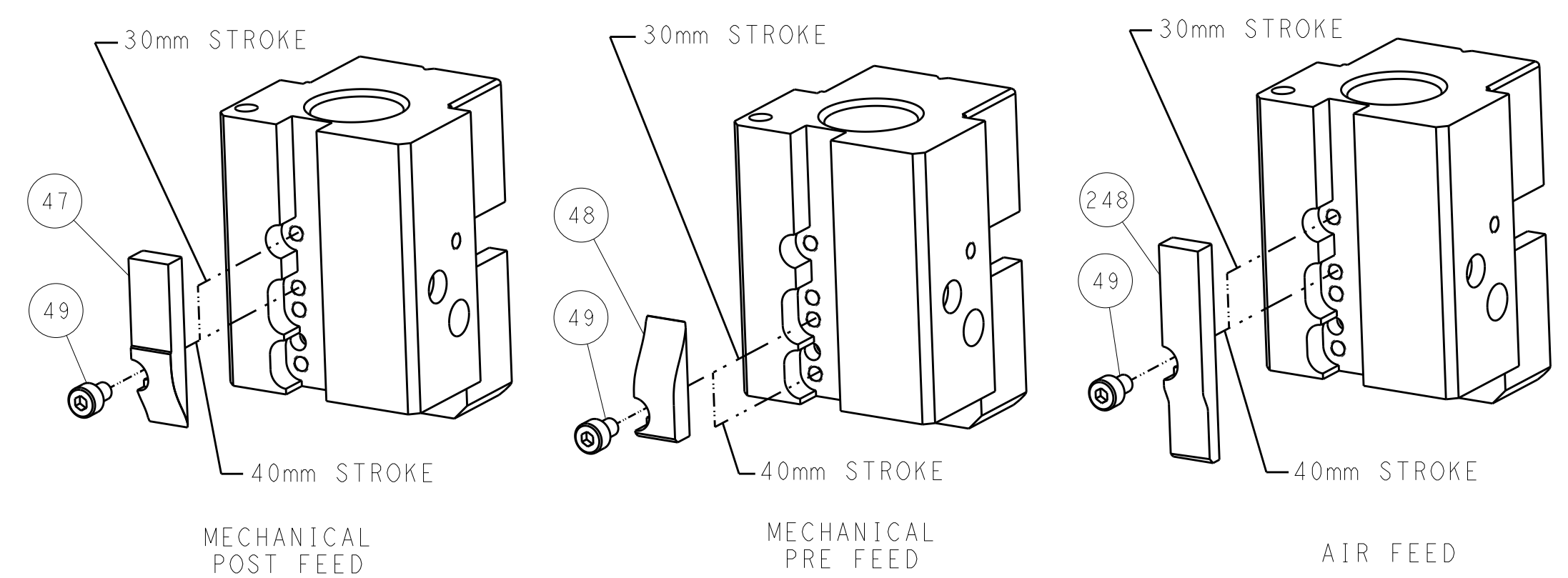
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

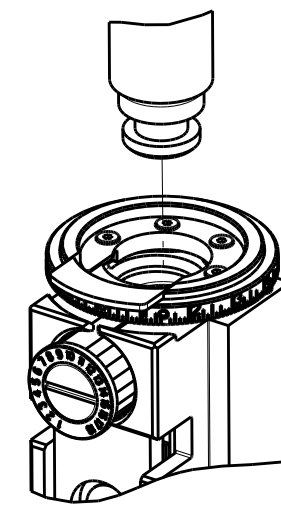


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOW 28DEC2015		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 28DEC2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: H. GUO 28DEC2015		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150636	
S		5 PLC ±		SCALE: 1:1		SHEET 2 OF 4	
T		6 PLC ±		REV: B1			
F		7 PLC ±		Customer Accessible Production Drawing			
FINISH		8 PLC ±					

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150636-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150636-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150636-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140825-1	140825-2	42068-1	42068-2
42236-1	60118-1	60118-3	60118-4
60118-5	60197-1	60197-2	60197-3
60415-1	60415-2	60415-6	60577-1
60577-2	140717-1	140717-2	140717-4
140717-5	140717-6	140717-7	140928-2
141058-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		Ø1.20-1.90 mm [.047-.075 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
18 AWG OR 0.75mm2	1.24+/-0.05 [.049+/- .002]	5.0
20 AWG OR 0.50mm2	1.09+/-0.05 [.043+/- .002]	6.6
22 AWG OR 0.35mm2	1.02+/-0.05 [.040+/- .002]	7.3

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

- 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 ITEMS 180. 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. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-2. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 7. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN-WALL (FRL) INSULATION. THE INSULATION CRIMP AND APPLICABLE INSULATION RANGE MAY NOT CONFORM TO THE PARAMETER LISTED IN THE APPLICATION SPEC.
- 8. 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.

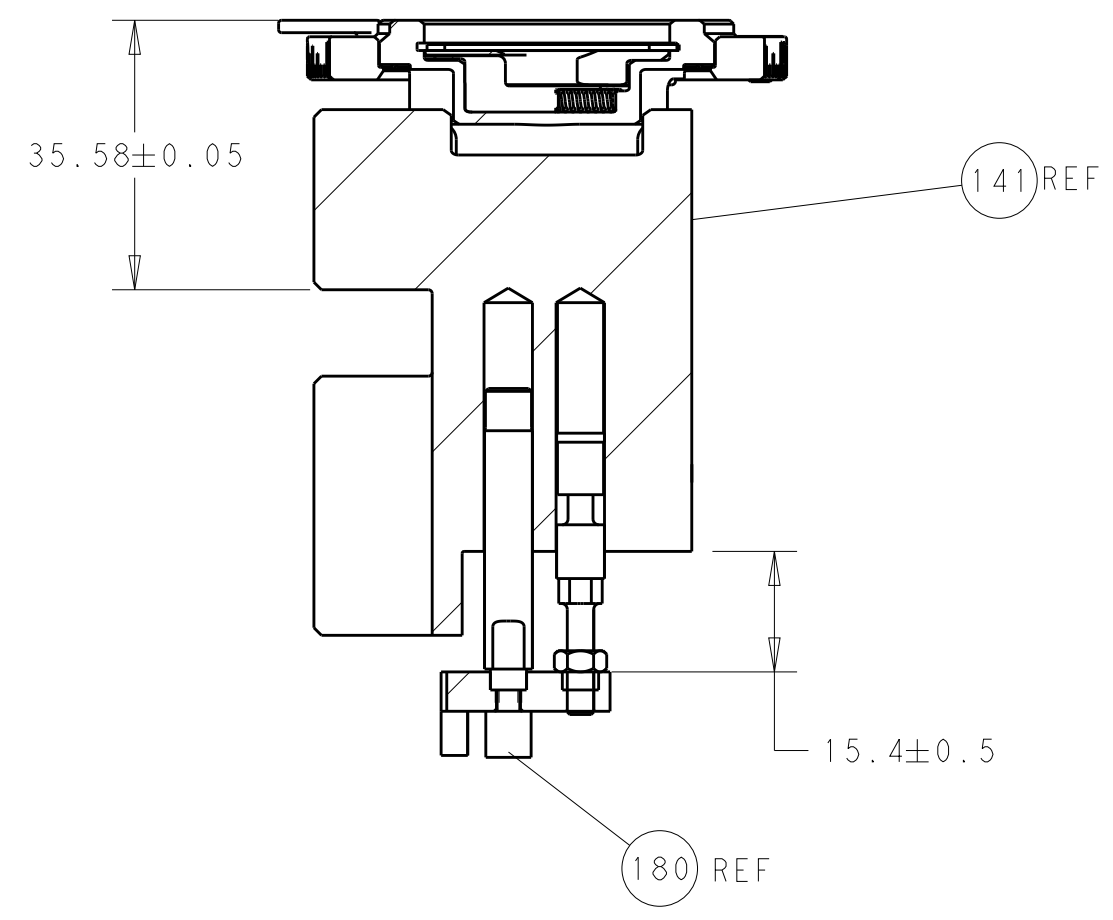
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	2119082-4	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	-	2063440-1	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
3	-	1	1752354-9	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
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
5	-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-2	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	1-1901681-3	HOLDDOWN, TERMINAL	65
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	4	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	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	-	2119792-1	PAWL, EF, AIR	51
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
5	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	240639-4	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1	9-1803001-8	ANVIL, COMBINATION, END FEED	8
1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-5	SPACER	5
-	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	8-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1-456403-9	CRIMPER, WIRE PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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

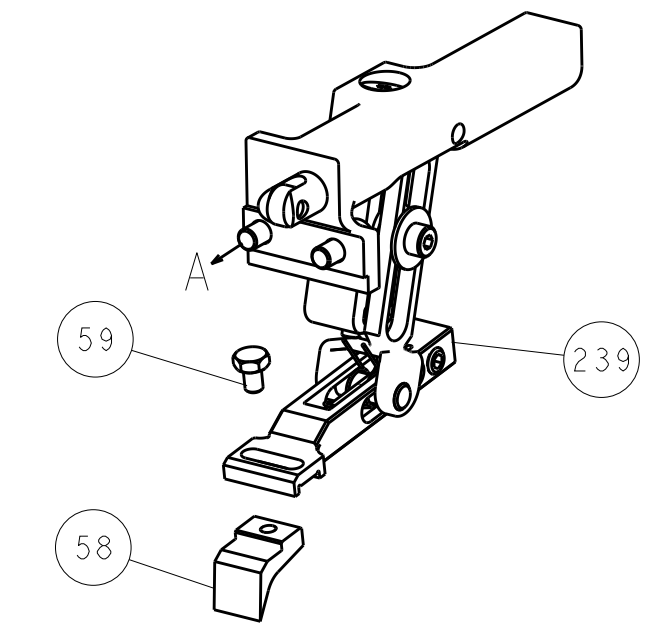
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CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1 SHEET 3 OF 4 REV B1		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator		A1 00779 ©=2150636	

REV. NO.		REVISIONS			
LOC	DIST	DATE	BY	CHKD	APVD
A	66				

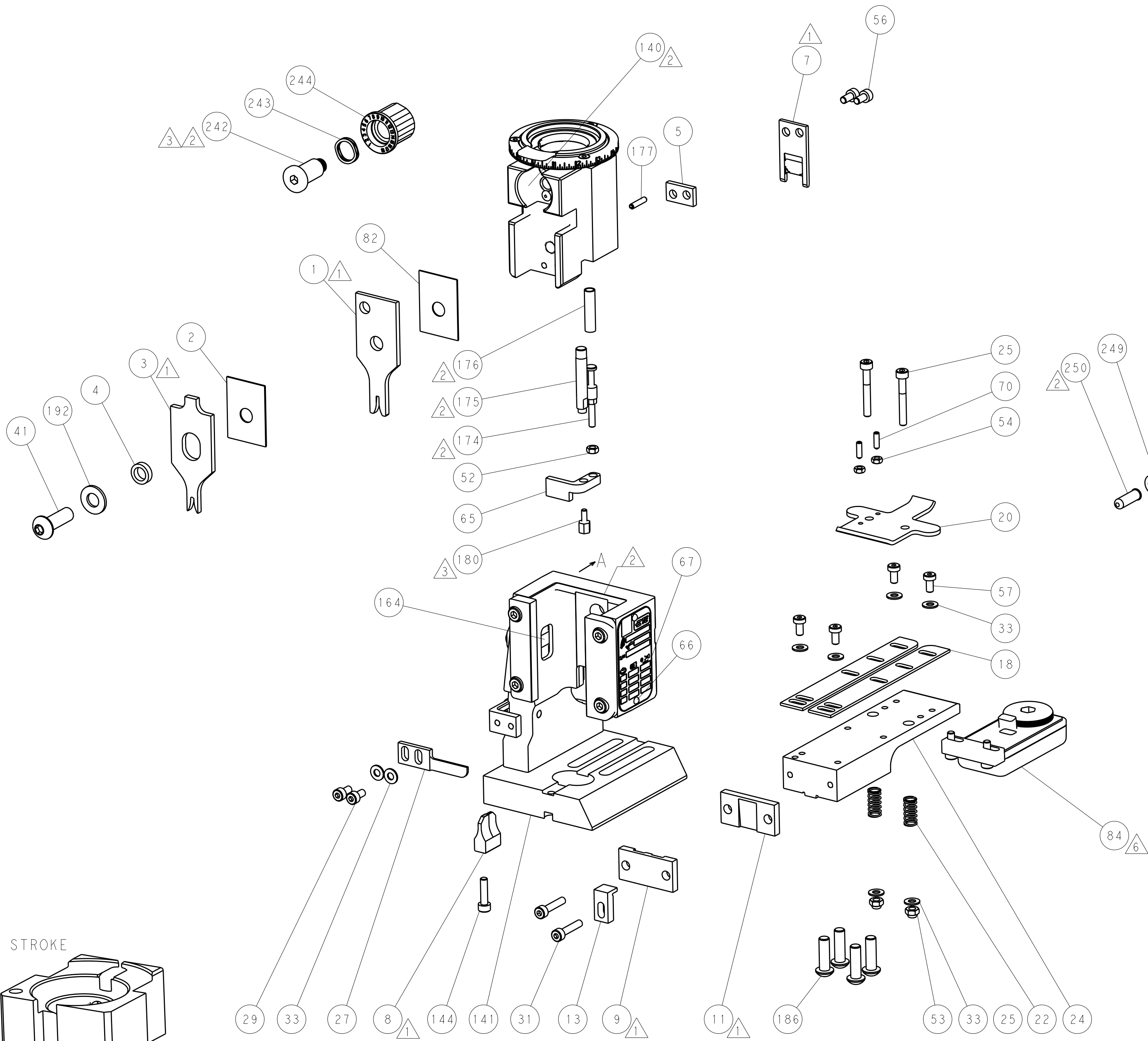
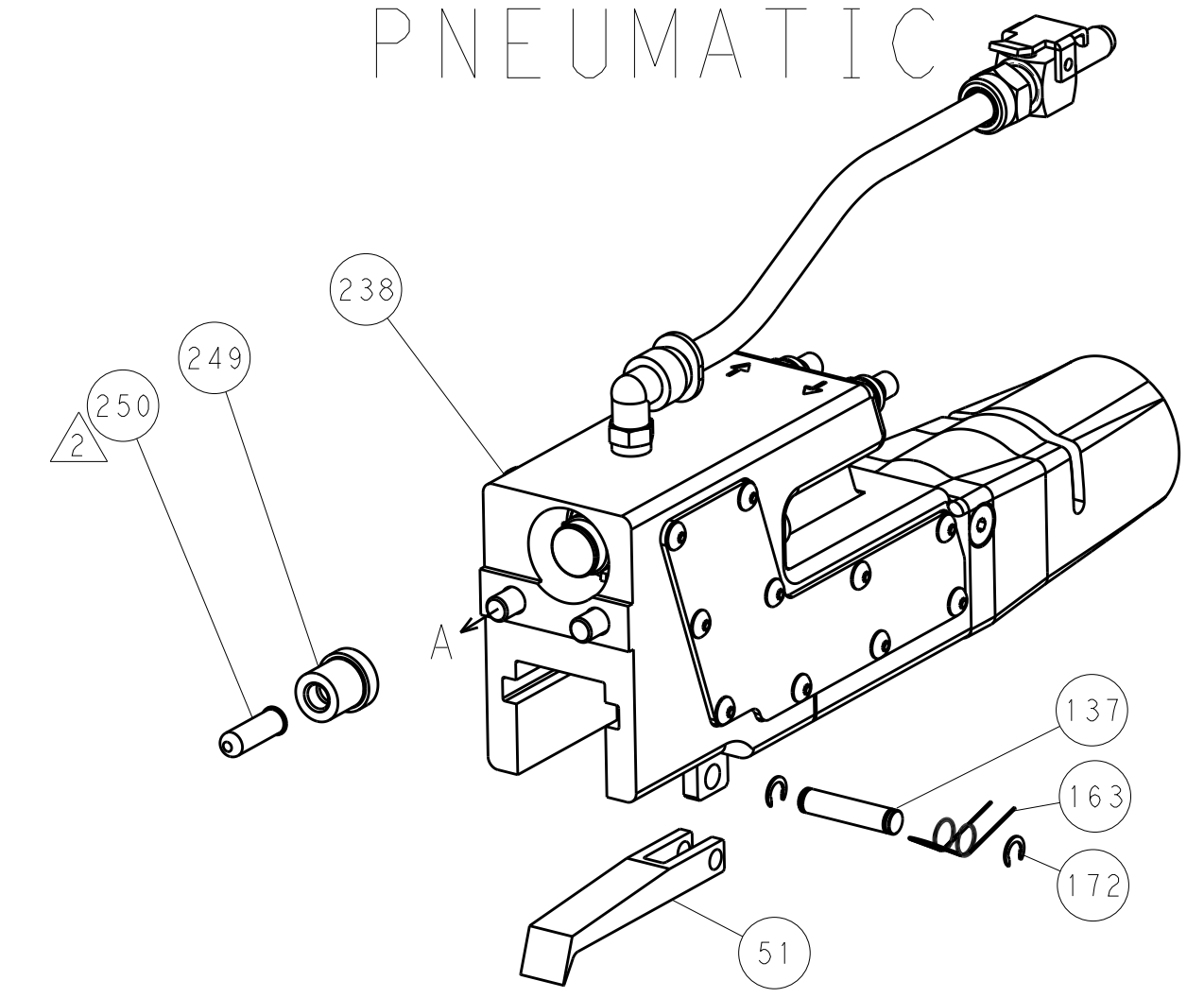


RAM AND HOLDDOWN SET-UP

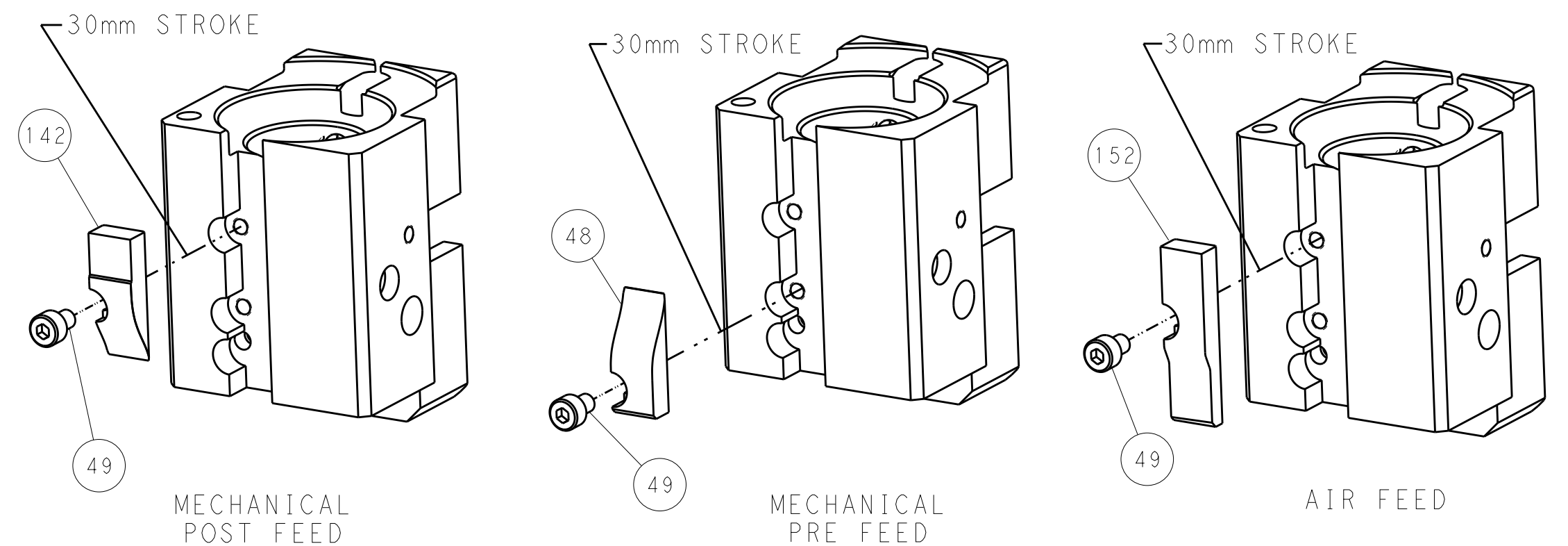
FEED TYPE  
MECHANICAL



PNEUMATIC



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: J. HOU 28DEC2015		CHK: L. ZHANG 28DEC2015		APVD: H. GUO 28DEC2015		NAME: Ocean End Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO.	RESTRICTED TO	STE TE Connectivity Harrisburg, PA 17105-3608			
	1 PLC	±		SCALE	1:1	SHEET 4 OF 4	REV B1				
	2 PLC	±		Customer Accessible Production Drawing							
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									
MATERIAL	FINISH										