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20		20	
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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	-

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

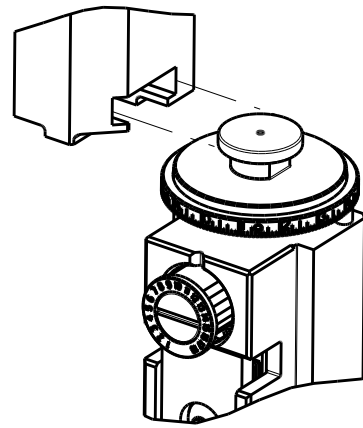
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140825-1	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			

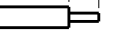
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2		1.24+/-0.05 [.049+/- .002]		5.0
20 AWG OR 0.50mm2		1.09+/-0.05 [.043+/- .002]		6.6
22 AWG OR 0.35mm2		1.02+/-0.05 [.040+/- .002]		7.3



- 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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		 INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-2036 - -	
TERMINALS APPLIED			
TE TERMINAL 2238095-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

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

*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.

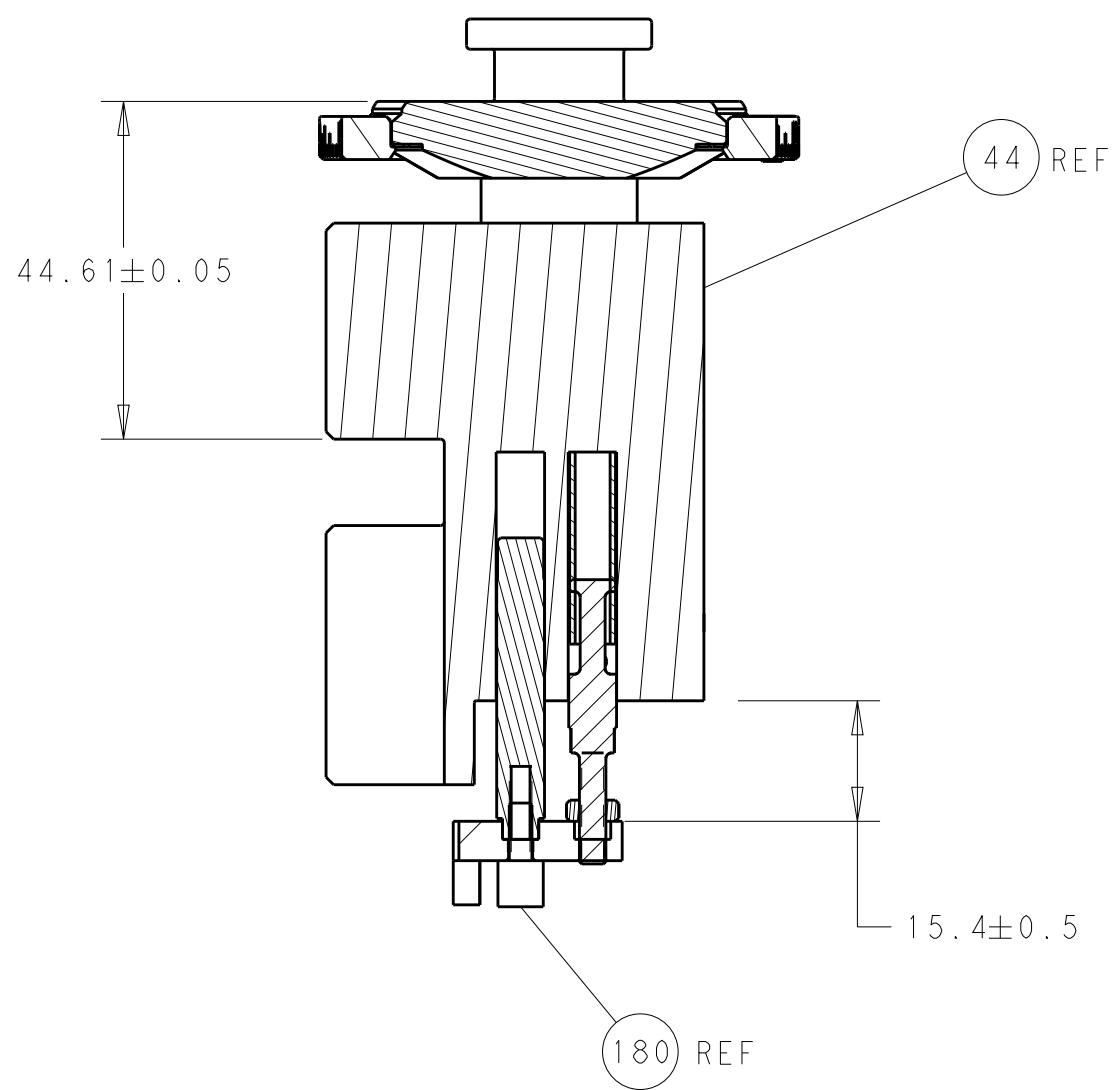
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISONS			
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					A	RELEASED	08FEB2016
					A1	ECR-16-015151	31OCT2016
					B	ECR-18-018134	20NOV2018
					B1	ECR-19-006117	16APR2019
							MR
							CT
							LZ
							KZ
							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	-	PART NO	DESCRIPTION	ITEM NO

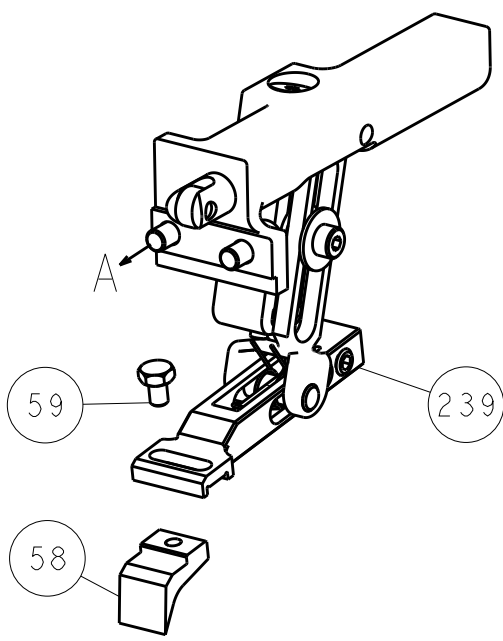
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				CHK	L. ZHANG	28DEC2015				
				APVD	J. GUO	28DEC2015	NAME			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean End Feed Applicator - SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2150636 - Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV B				
mm		0 PLC ±.001		APPLICATION SPEC						
		1 PLC ±.001								
		2 PLC ±.001								
		3 PLC ±.001								
		4 PLC ±.001								
		ANGLES								
		FINISH								
MATERIAL		FINISH		WEIGHT						
-		-		-						

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

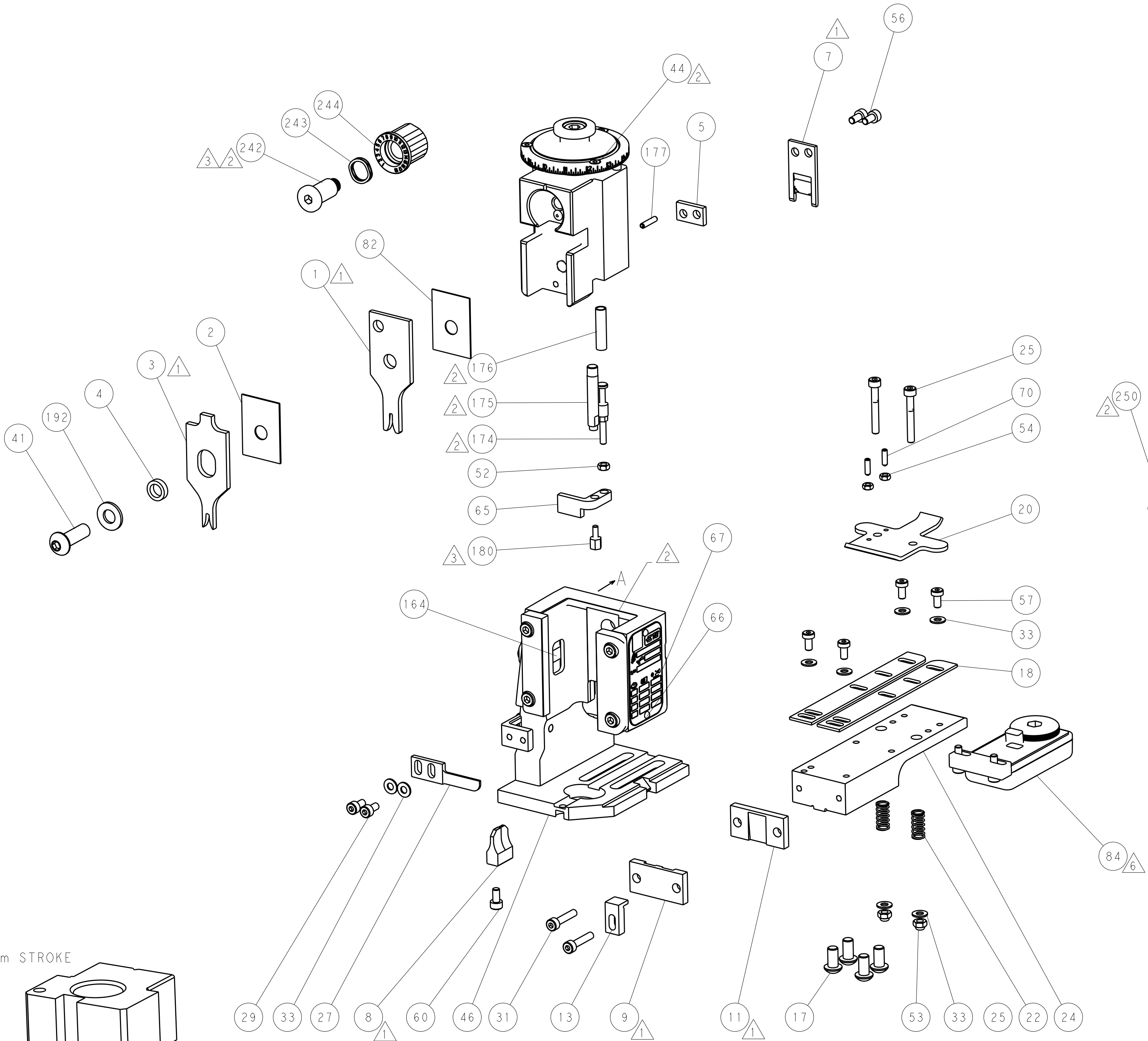
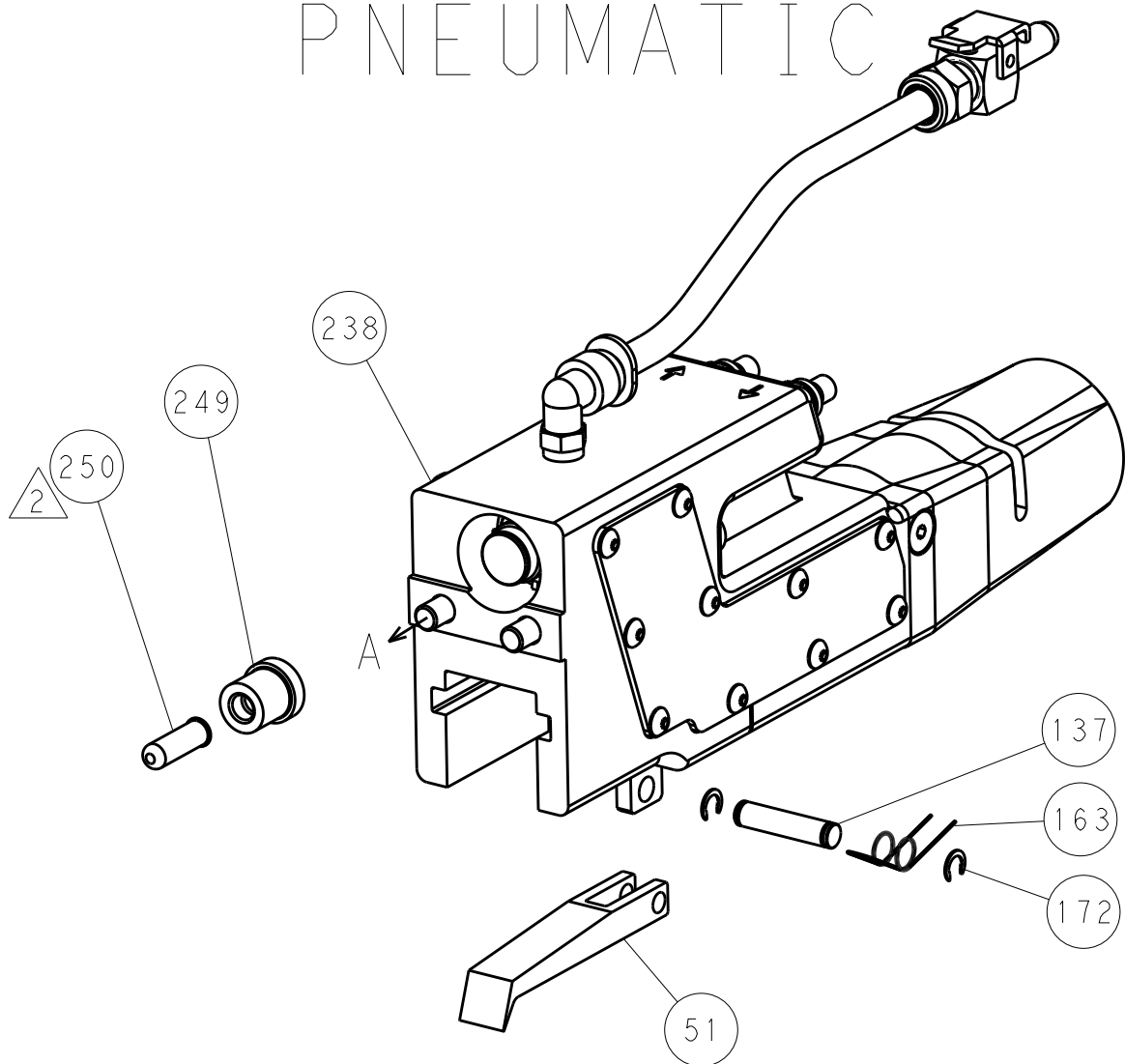


RAM AND HOLDDOWN SET-UP

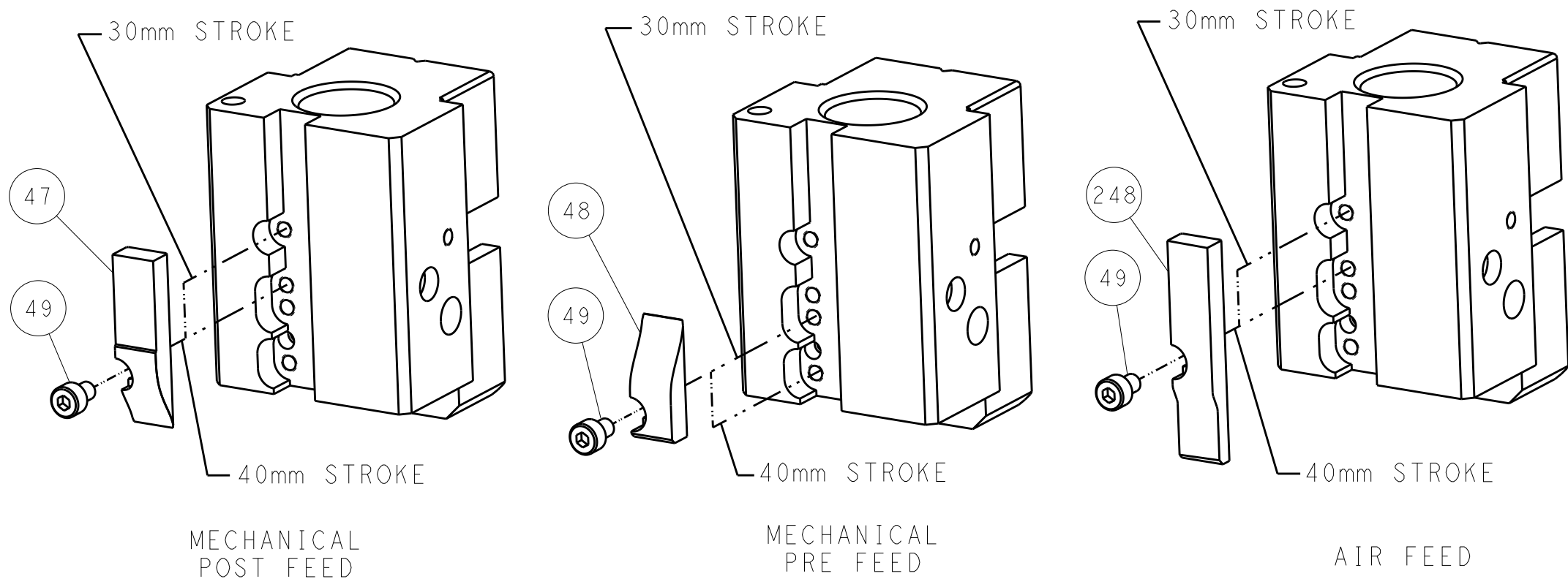
FEED TYPE
MECHANICAL



PNEUMATIC



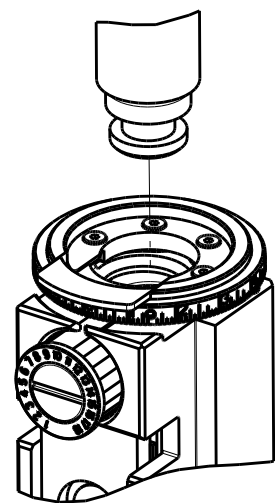
CAM POSITIONS



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

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DIMENSIONS:				J. HOU				28DEC2015			
mm				L. ZHANG				28DEC2015			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				U. GUO				28DEC2015			
0 PLC				PRODUCT SPEC				NAME			
1 PLC				APPLICATION SPEC				SIZE			
2 PLC				WEIGHT				CAGE CODE			
3 PLC				Customer Accessible Production Drawing				DRAWING NO			
4 PLC				SCALE				00779			
ANGLES				1:1				SHEET			
FINISH				2				OF			
MATERIAL				REV				B1			

8		7	
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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	-



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 4.40-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
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			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2			1.24+/-0.05 [0.049+/-0.002]		5.0
20 AWG OR 0.50mm2			1.09+/-0.05 [0.043+/-0.002]		6.6
22 AWG OR 0.35mm2			1.02+/-0.05 [0.040+/-0.002]		7.3



- 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.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTON .110 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL 2238095-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG			0.91+/-0.05 [0.36+/-0.002]		7.6

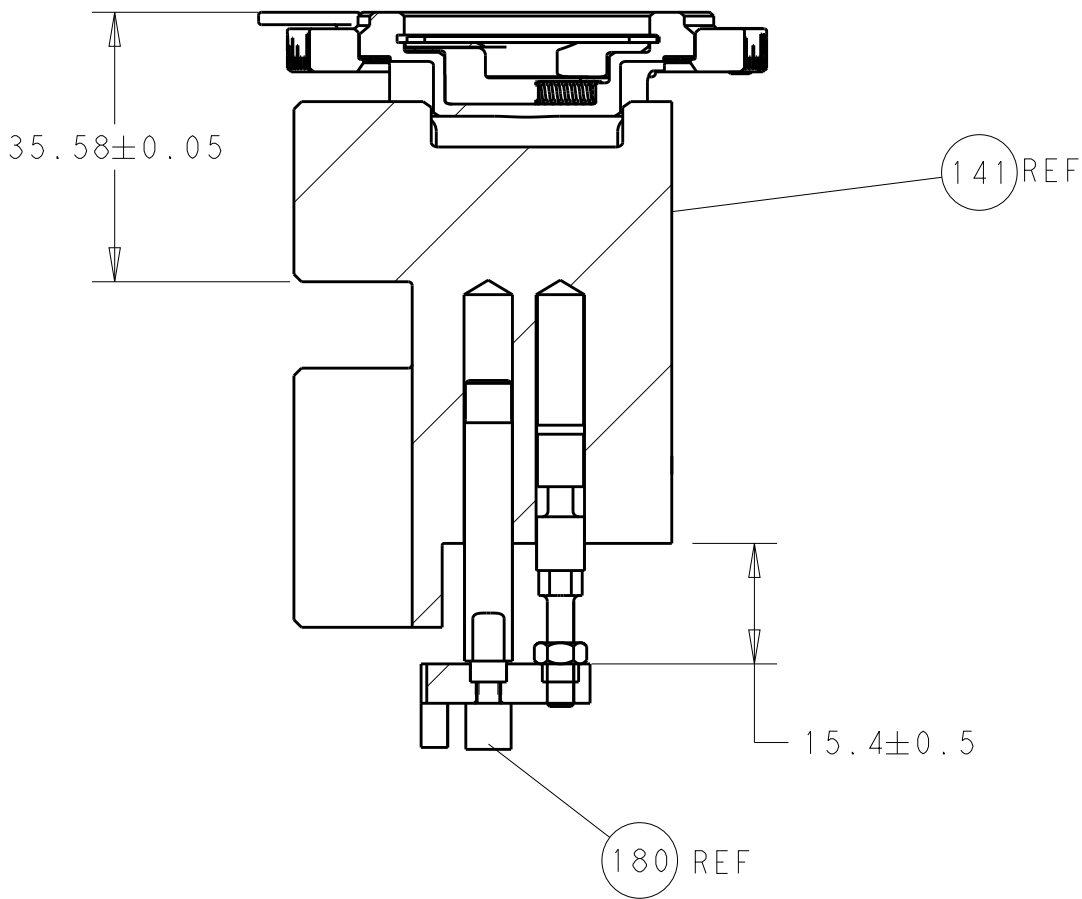
* WARNING

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

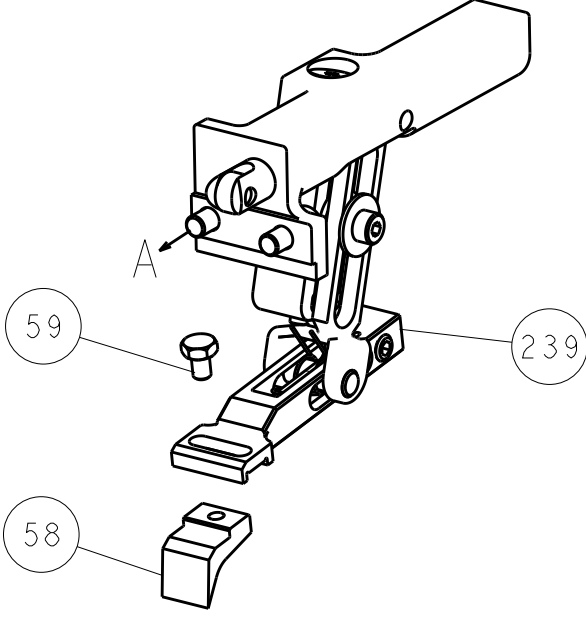
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

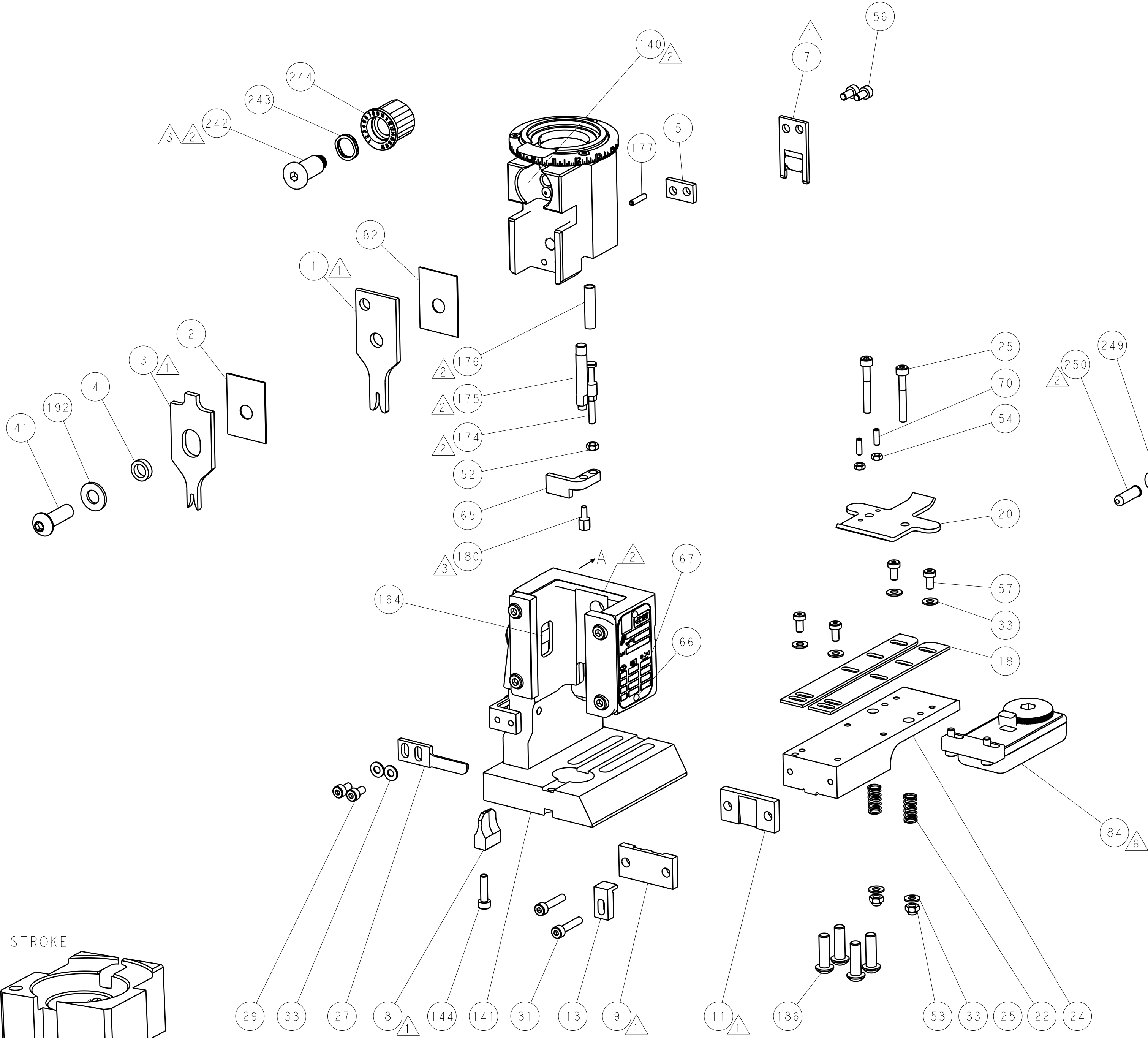
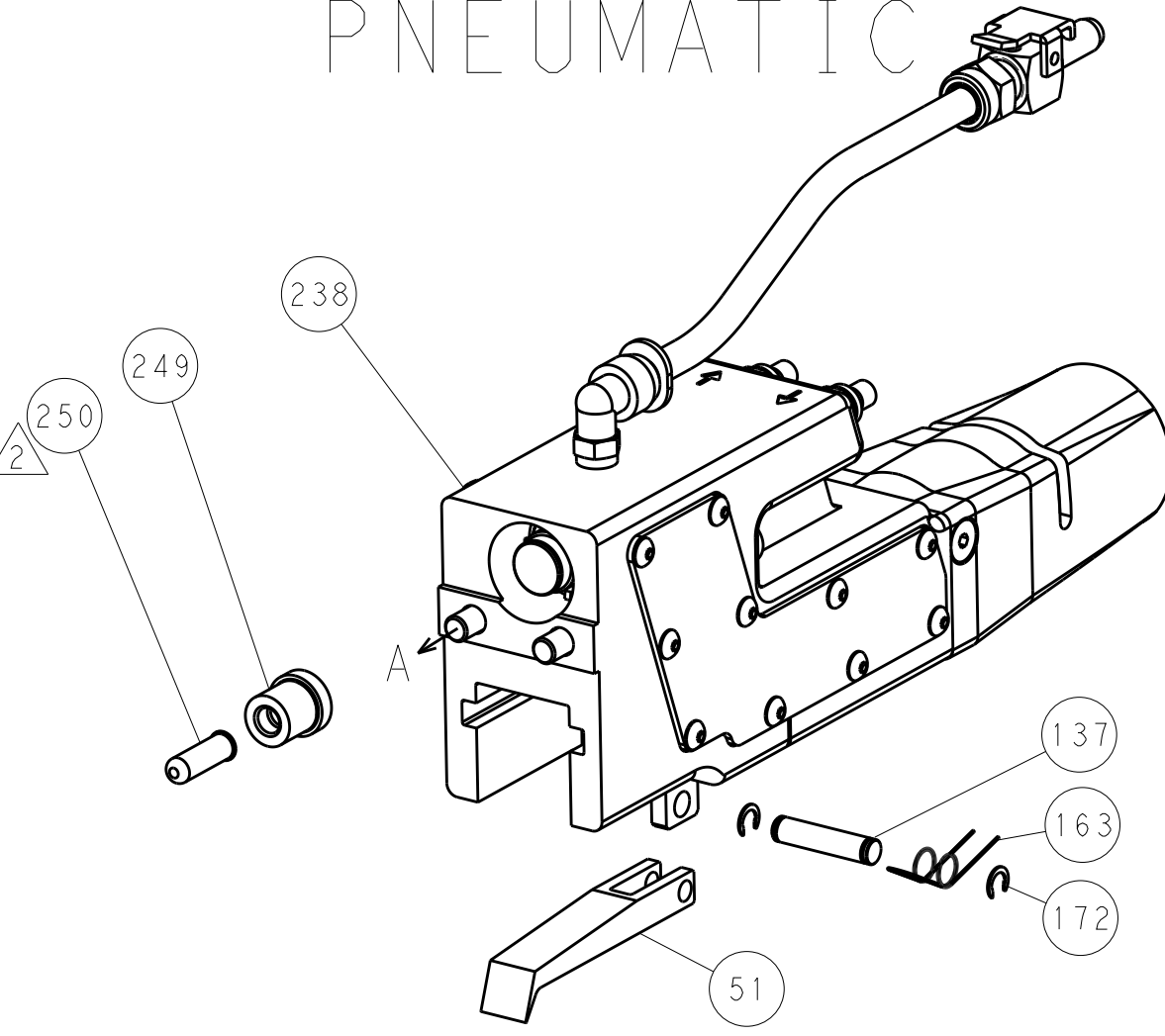


RAM AND HOLDDOWN SET-UP

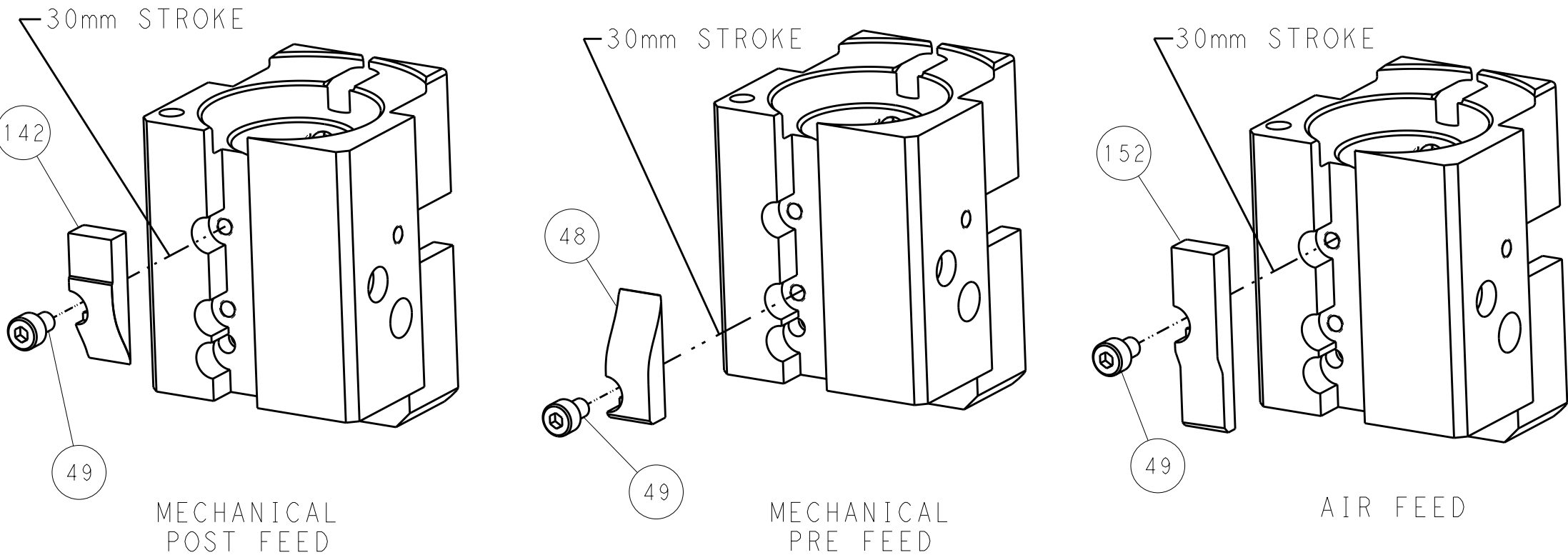
FEED TYPE
MECHANICAL



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)

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DIMENSIONS: mm		CHK L. ZHANG 28DEC2015	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD H. GUO 28DEC2015	SIZE A1	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO C=2150636	
		WEIGHT	RESTRICTED TO	
		Customer Accessible Production Drawing	SCALE 1:1	
			SHEET 4 OF 4	
			REV B1	

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Authorized Distributor

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[TE Connectivity:](#)

[2150636-2](#)