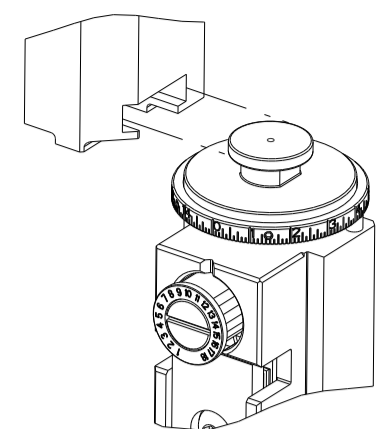


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150032-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150032-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150032-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]		
TERMINAL APPLICATION SPECIFICATION	114-5041	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1	170325-5	173691-1	175179-1
170325-3	170325-6	173691-2	175179-2

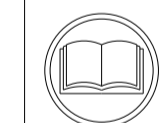
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]		
TERMINAL APPLICATION SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1			

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]		
TERMINAL APPLICATION SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
173691-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.50+/-0.05 [.059+/-0.002]	4.2
0.75mm2	1.32+/-0.05 [.052+/-0.002]	6.3
0.50mm2	1.19+/-0.05 [.047+/-0.002]	7.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.35 mm ²	1.25+/-0.05 [.049+/-0.002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5mm ²	1.50+/-0.05 [.049+/-0.002]	4.2



- 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 50. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

***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.

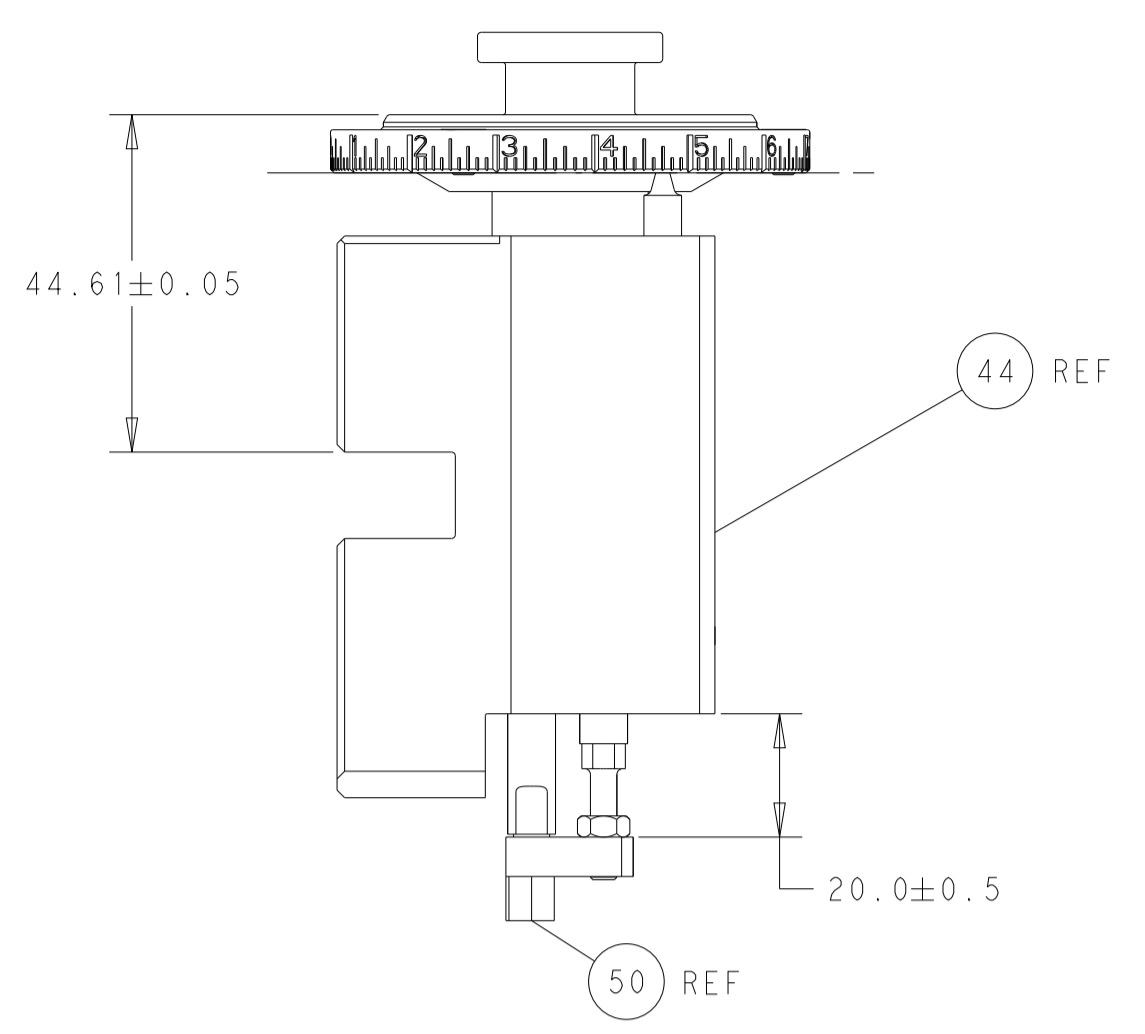
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	E		ECR-21-001039	26JAN2021	JWC	TE
		E1		ECR-21-122427	29NOV2021	JWC	GB
		F		ECR-22-126203	11JAN2022	FJ	RK
		G		ECR-22-129847	17FEB2022	FZ	TE

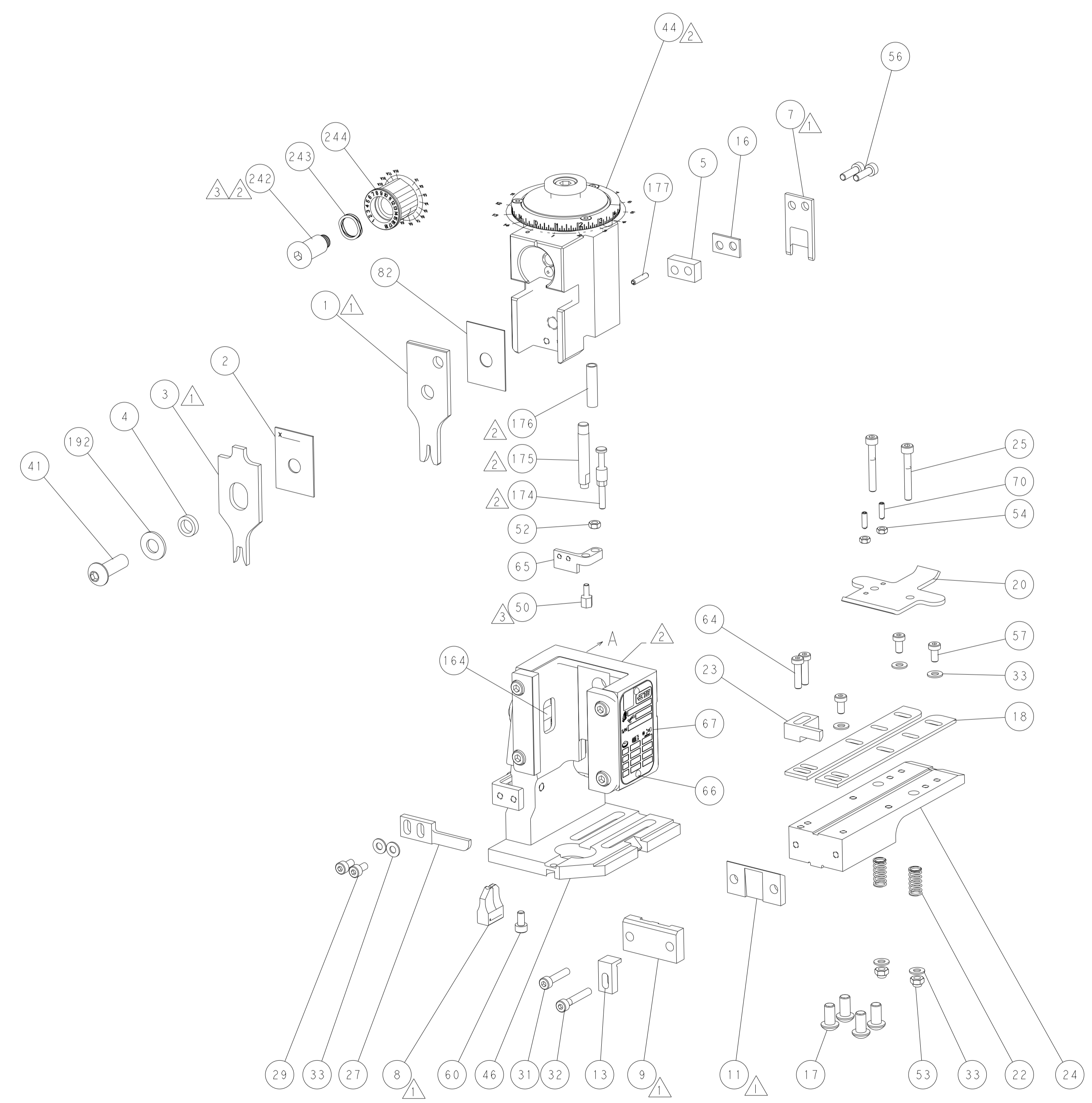
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	6-993111-6	PIN, SLOTTED 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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	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	2-1901681-2	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2063961-9	FEED FINGER	51	
-	1	1	1752354-8	STANDOFF,HOLD-DOWN	50	
-	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	
-	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	32	
-	1	1	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	4-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	240825-2	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	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	6-240641-3	SPACER	16	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240833-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	9-690482-3	PLATE, FRONT SHEAR	9	
-	1	2	1	2-1333217-1	ANVIL, EF .090	8
-	1	1	1	4-690474-5	BLADE, SLUG	7
-	1	1	1	2-240641-3	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1	2-456406-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	DATE
	ANGLES FINISH						
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	©=2150032	
Customer Accessible Production Drawing				SCALE	1:1	SHEET	1 OF 4
				REV	G		

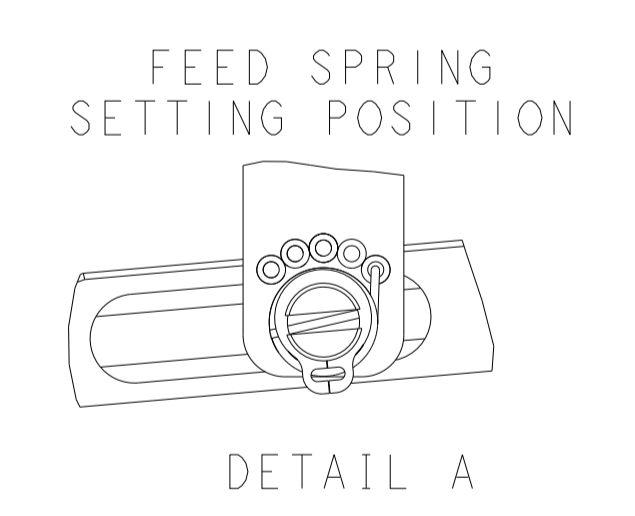
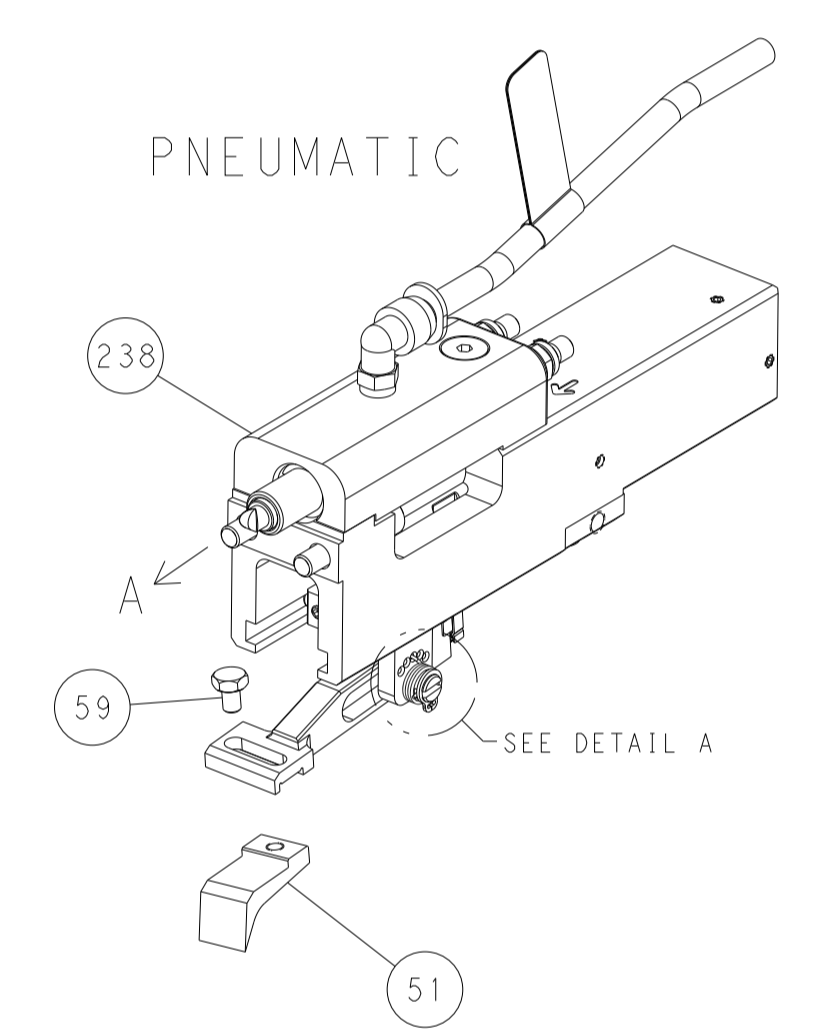
LOC	DIST	REVISIONS					
		P	LTH	DESCRIPTION	DATE	DWN	APVD
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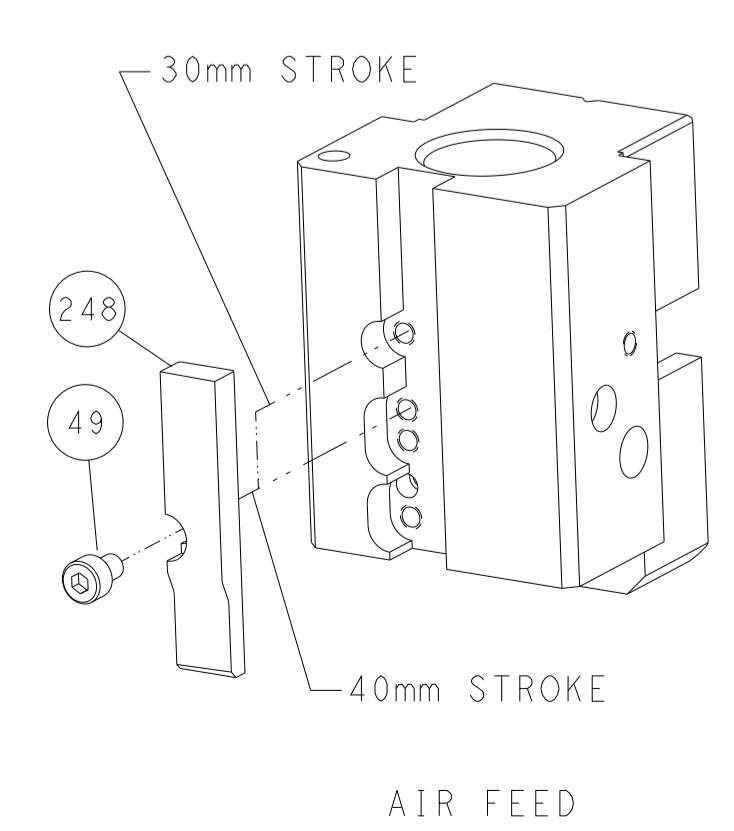
RAM AND HOLDDOWN SET-UP



FEED TYPE



CAM POSITION

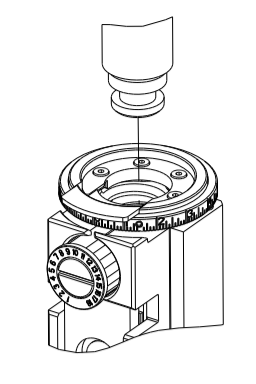


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. KNEPPER 26MAR2012 CHK: T. ELBIN 26MAR2012 APVD: M. CLIFFORD 26MAR2012	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150032	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ° ±. MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ° ±. MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SHEET 2 OF 4 REV G	RESTRICTED TO: -

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150032-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150032-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]

TERMINAL APPLICATION SPECIFICATION 114-5041

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1	170325-5	173691-1	175179-1
170325-3	170325-6	173691-2	175179-2

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1			

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-5.20 mm [.165-.205 IN]	Ø1.90-3.40 mm [.075-.134 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
173691-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.50+/-0.05 [.059+/-0.002]	4.2
0.75mm ²	1.32+/-0.05 [.052+/-0.002]	6.3
0.50mm ²	1.19+/-0.05 [.047+/-0.002]	7.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.35 mm ²	1.25+/-0.05 [.049+/-0.002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5mm ²	1.50+/-0.05 [.049+/-0.002]	4.2

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					

REV	DATE	DESCRIPTION	DATE	BY	CHKD	APVD
-	-	SEE SHEET 1	-	-	-	-

REV	DATE	DESCRIPTION	ITEM NO	
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	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
-	1	455888-5	SPACER, CRIMPER	82
-	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	2-1901681-2	HOLDDOWN, TERMINAL	65
-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-9	FEED FINGER	51
-	1	1752354-8	STANDOFF,HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	32
-	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	4-1752371-2	PLATE, STRIP GUIDE	24
-	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	6-240641-3	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240833-7	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	9-690482-3	PLATE, FRONT SHEAR	9
-	1	2-1333217-1	ANVIL, EF .090	8
-	1	4-690474-5	BLADE, SLUG	7
-	1	2-240641-3	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
-	1	2-456406-3	CRIMPER, WIRE PREMIUM	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 50. 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

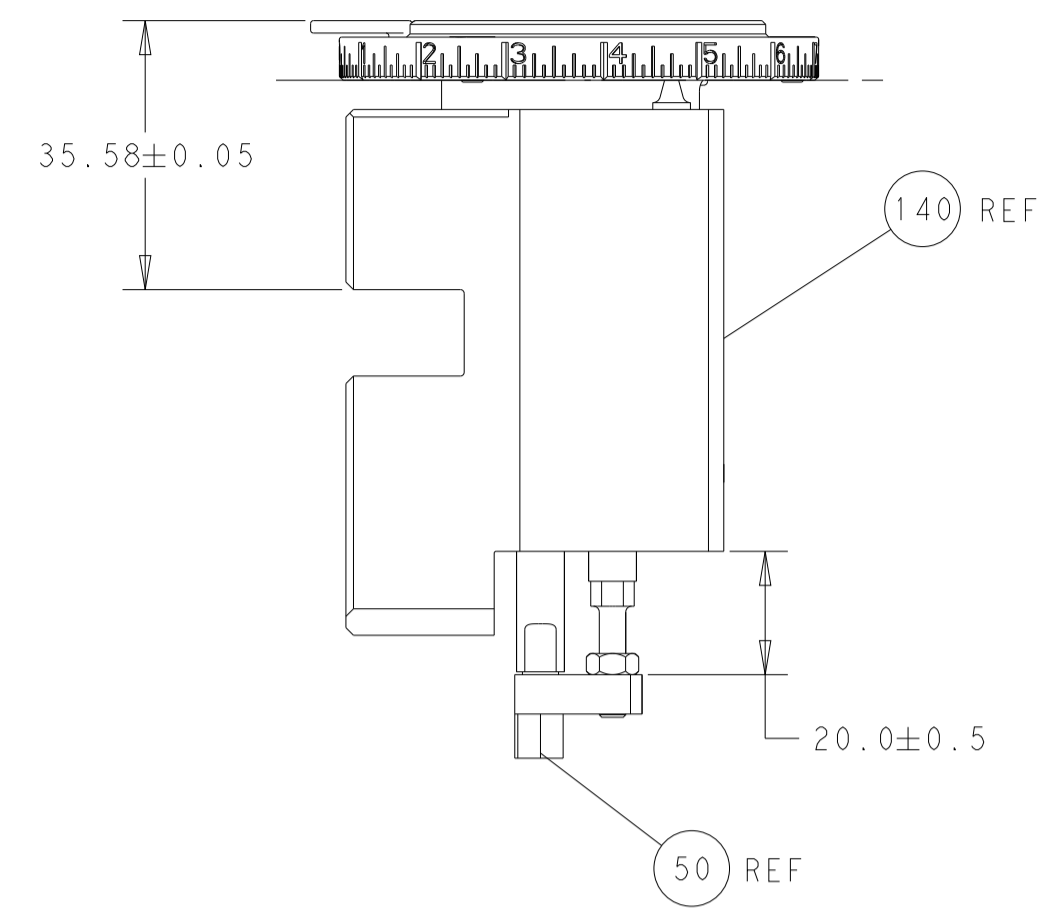
***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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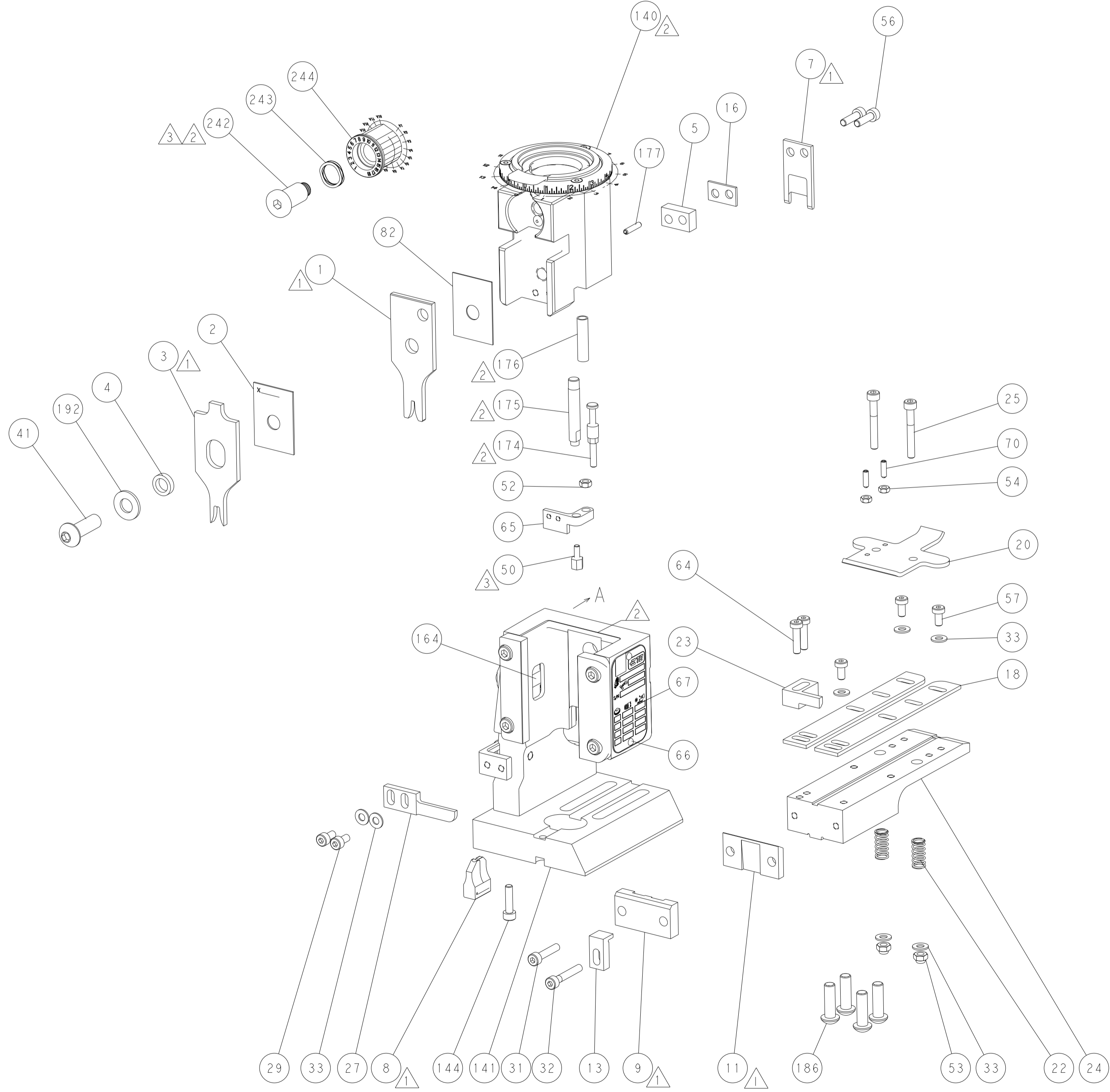
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	R. KNEPPER	26MAR2012	TE Connectivity Harrisburg, PA 17105-3608	A	00779	2150032	Customer Accessible Production Drawing
		T. ELBIN	26MAR2012	Ocean End Feed Applicator	SCALE 1:1		SHEET 3 OF 4	REV G
MATERIAL:	FINISH:	APVD	DATE	PRODUCT SPEC	SCALE		SHEET	REV
		M. CLIFFORD	26MAR2012		1:1		3 OF 4	G

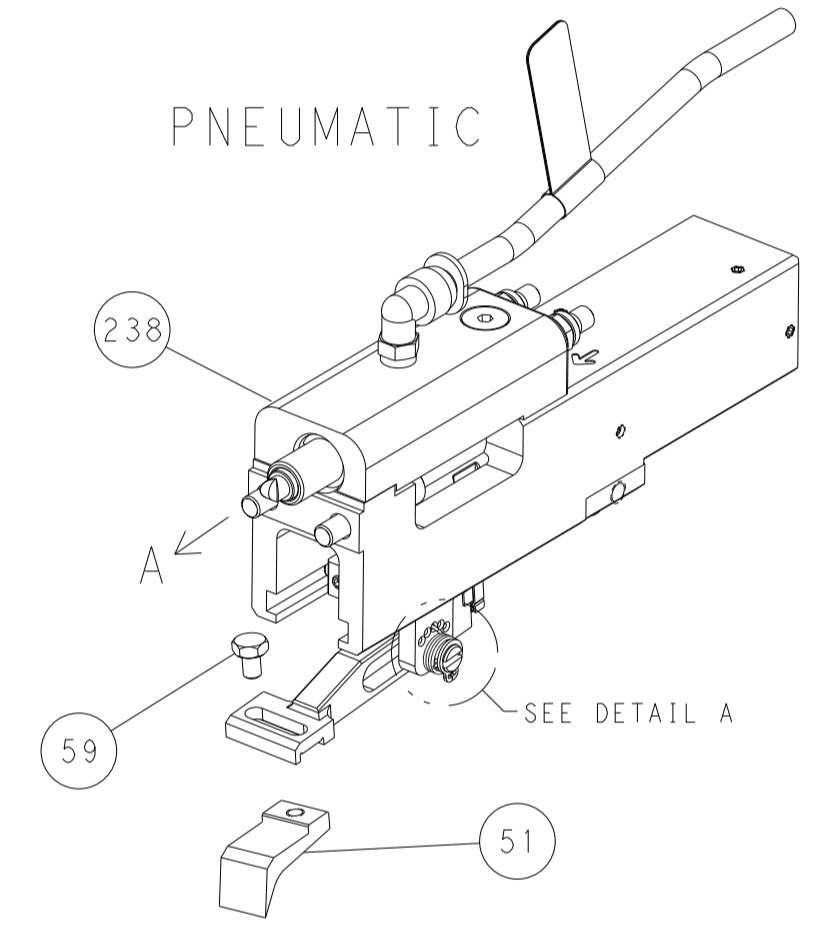
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



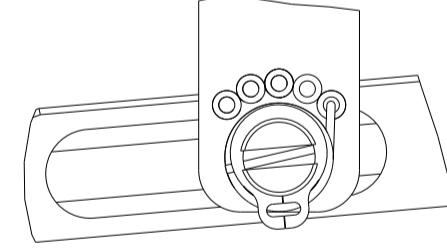
RAM AND HOLDDOWN SET-UP



FEED TYPE

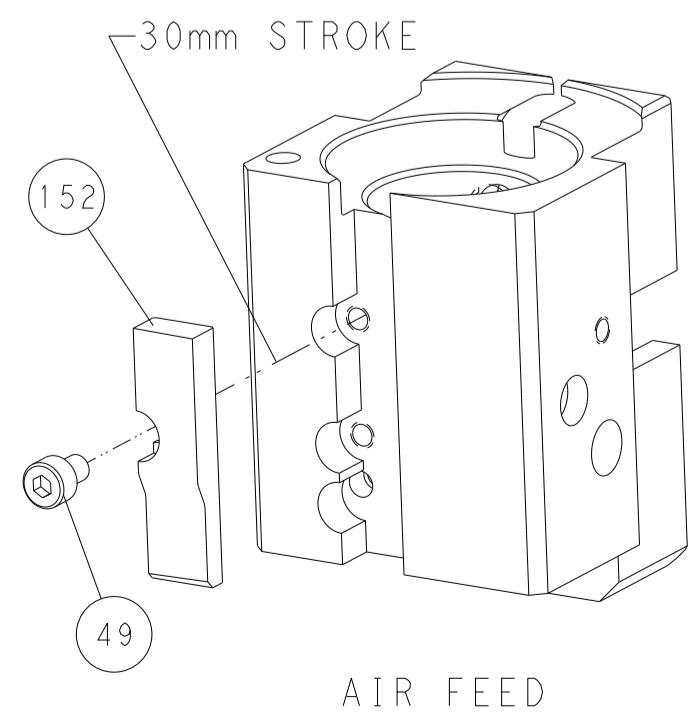


FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE CAGE CODE DRAWING NO A 00779 C=2150032	RESTRICTED TO G
MATERIAL:		WEIGHT:	SCALE 1:1 SHEET 4 OF 4 REV G