	THIS DRAWING IS UNPUBLIS	8 Shed.	RELEASED FOR PUBLICATION		7		6
	© COPYRIGHT 20 PART NUMBER	by tyco electron	DESCRIPTION		FEED TYPE		ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER
	2150861-2 7-2150861-2 7-2150861-7	B B A	FINE CRIMP HEIGHT PNEUMATIC AND CR TOOLING KIT CRIMP TOOLING I	IMP	PNEUMATIC PNEUMATIC -		
D							
	CRIMP S WIRE 2.79 mr		TA TYPE F F				
С	TERMINAL DATA TERMINAL NAME WIRE STRIP 4.80-5.60 mr TERMINAL APPLICATION TERMINALS TERMINALS TE TERMINAL 626279-1	E: RING LENGTH n [.189220 114 APPLIED TETE	TONGUE INSULATI INJ 2084 - - - - - - - - - - - - -	ON DIAME 5 mm [.070	PECIFICATION TER RANGE 0120 IN] - - TE TERMINAL 626279-4		
B	1.50mm2 1.00mm2 0.75mm2 0.50mm2	2.00+/ 1.85+/ 1.77+/ 1.70+/ ENDED SPAR TO SUPPLIE	-0.05 [.079+/002] -0.05 [.073+/002] -0.05 [.070+/002] -0.05 [.067+/002] E PARTS D INSTRUCTION SHEET		NCE SETTING 5.1 7.0 7.9 8.6	ON AND	*WARNING ON INSTAL SETTING F SETTINGS THE CRIMP PROPER SE
	APPLY A APPLY F APPLICA CRIMP A APPLICA NECESSA 5 TERMIN, 6. UNLESS	ART NUMBER HEIGHT REF TOR WAS QU RY WHEN RU AL PITCH N	R 2-23419-6 LOCTITE R 1-23419-5 LOCTITE JALIFIED AT THE FACTO JNNING APPLICATOR IN OT COMPATIBLE WITH M OTHERWISE TORQUE VAN	TO THREA HE SETTI DRY. ADJ THE FIE ECHANICA	DS OF ITEM 180. NG USED WHEN THE USTMENT MAY BE LD. L FEED.	E	
А							

AMP 4805 REV 31MAR2000

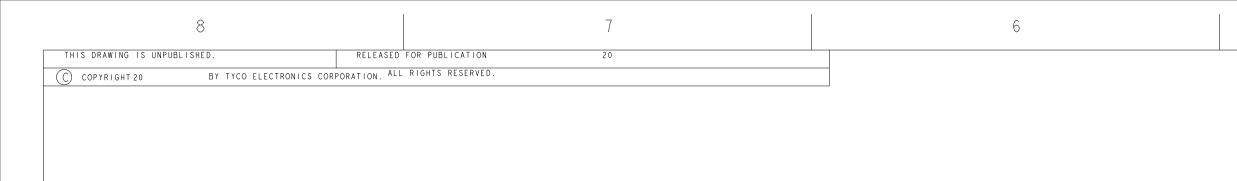
ALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE S GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO MP TOOLING. REFER TO THE INSTRUCTION SHEET FOR SETUP AND ADJUSTMENTS.

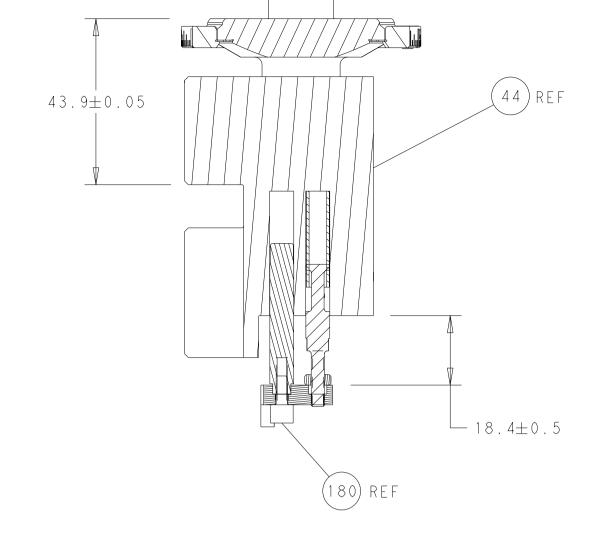
ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

- 1 1 2	2119641-1	FEED CAM, AIR FEED	248	
	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	2119083-1	RETAINER, INSULATION DIAL	242	
	2844940-4	AIR FEED MODULE	238	
- 1 1 1	-18028-0	WASHER, FLAT, REG M8	192	
3 - 1 1 1	752354-4	STANDOFF, HOLD-DOWN	180	
- 1 1 6	-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
- 1 1 8	3-22280-7	SPRING, COMPRESSION	176	
- 1 1 1	752353-2	GUIDE PIN, HOLDDOWN	175	
- 1 1 1	901680-2	GUIDE PIN, HOLDDOWN	174	
- REFREF	994970-2	COUNTER, MAGNETIC	164	С
- 1 1	455888-4	SPACER, CRIMPER	82	C
- 1 1 2	2119791-5	DEPRESSOR, WIRE	73	
- 1 1 1	803607-4	DOCUMENTATION PACKAGE	71	
- 2 2 2	2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	
- 1 1 2	2119740-1	TAG, IDENTIFICATION	67	
- 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
- 1 1 1	901681-1	HOLDDOWN, TERMINAL	65	
- 1 1 2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
- 1 1 5	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
- 4 4 2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
- 2 2 2	2168083-9	SCR, SKT HD CAP, R∘HS, M4 X 20	56	
- 2 2 5	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 2	2063961-1	FEED FINGER	51	
- 1 1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
- 1 1 2	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
- 1 1 1	803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
- 1 1 1	803602-1	SCR, BHSC, Rohs (M8 X 25)	41	
- 8 8 1	-18028-2	WASHER, FLAT, REG M4	33	
- 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
- 2 2 2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	В
- 1 1	240639-1	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	
- 2 2 2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
- 1 1 1	803292-4	DRAG	20	
- 1 1 1-	- 1 9 0 1 6 9 6 - 1	STRIP GUIDE, REAR	19	
- 1 1 1-	- 1 9 0 1 6 9 5 - 1	STRIP GUIDE, FRONT	18	
- 4 4 1-	-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
- 1 1 2	-240641-3	SPACER	16	
	752360-1	SPACER, HOLD-DOWN	13	
	240644-5	PLATE, REAR SHEAR	11	
	-240645-4	SPACER, SHEAR PLATE	10	
	- 2 4 0 6 4 2 - 1	PLATE, FRONT SHEAR	9	
	803615-5	ANVIL, COMBINATION, END FEED	8	
	-240651-1	BLADE, SLUG	7	
	-	-	6	
	-240641-5	SPACER	5	
	238011-2	BLOCK, CRIMPER SPACER	4	
	- 1633961 - 6	CRIMPER, INSULATION F PREMIUM	3	
	455888-5	SPACER, CRIMPER	2	
	- 456408-2	CRIMPER, WIRE PREMIUM		
-77-72-2 F	PART NO	DESCRIPTION	I TEM NO	А
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGLERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.	dwn 30NOV <u>K.HUANG</u> 30NOV			
DIMENSIONS: TOLERANCES UNLESS OTHERWISE SPECIFIED:	L.ZHANG APVD 30NOV	2017 NAME		
0 PLC ±-	L.ZHANG product spec	Ocean End Feed		
PLC ±- 2 PLC ±-	-	Applicator		
3 PLC ±- 4 PLC ±- 4 PLC ±-	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO RES	STRICTED TO	
ANGLES ±- MATERIAL FINISH		$A \mid 00779 \bigcirc 2150861$	-	
	Customer Accessib	ole Production Drawing SCALE 1:1 SHEET 0F 4	REVB	
1		3 & 4 ARF NOT REQUIRED FOR ATLANTIC V		

DIST			REVISIONS			
66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		А	RELEASED	14DEC2017	ΤВ	GB
		В	ECR-23-171334	04APR2023	ТB	R K



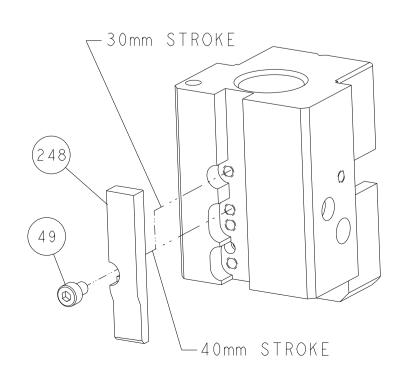


RAM AND HOLDDOWN SET-UP

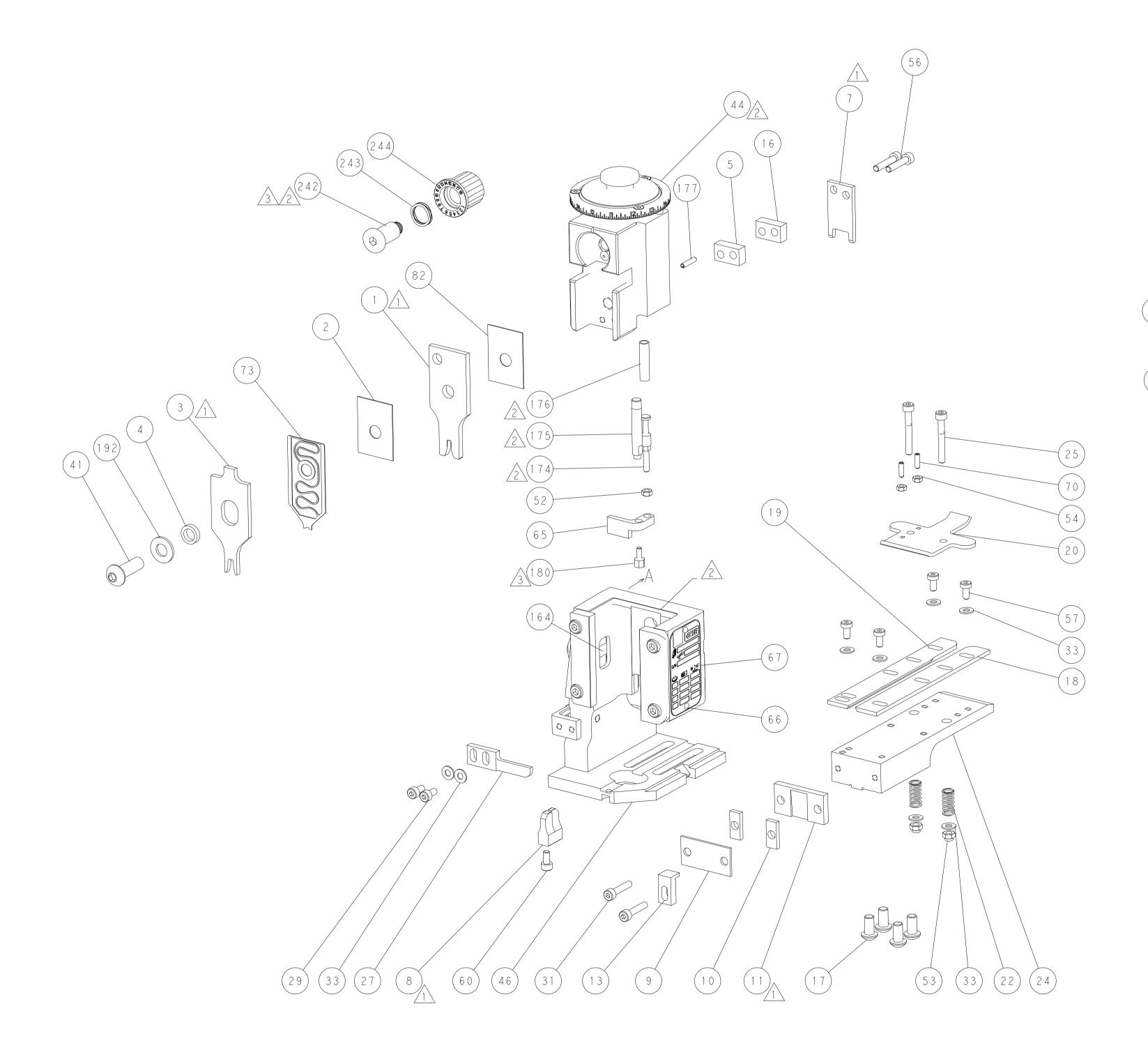
В

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CAM POSITION



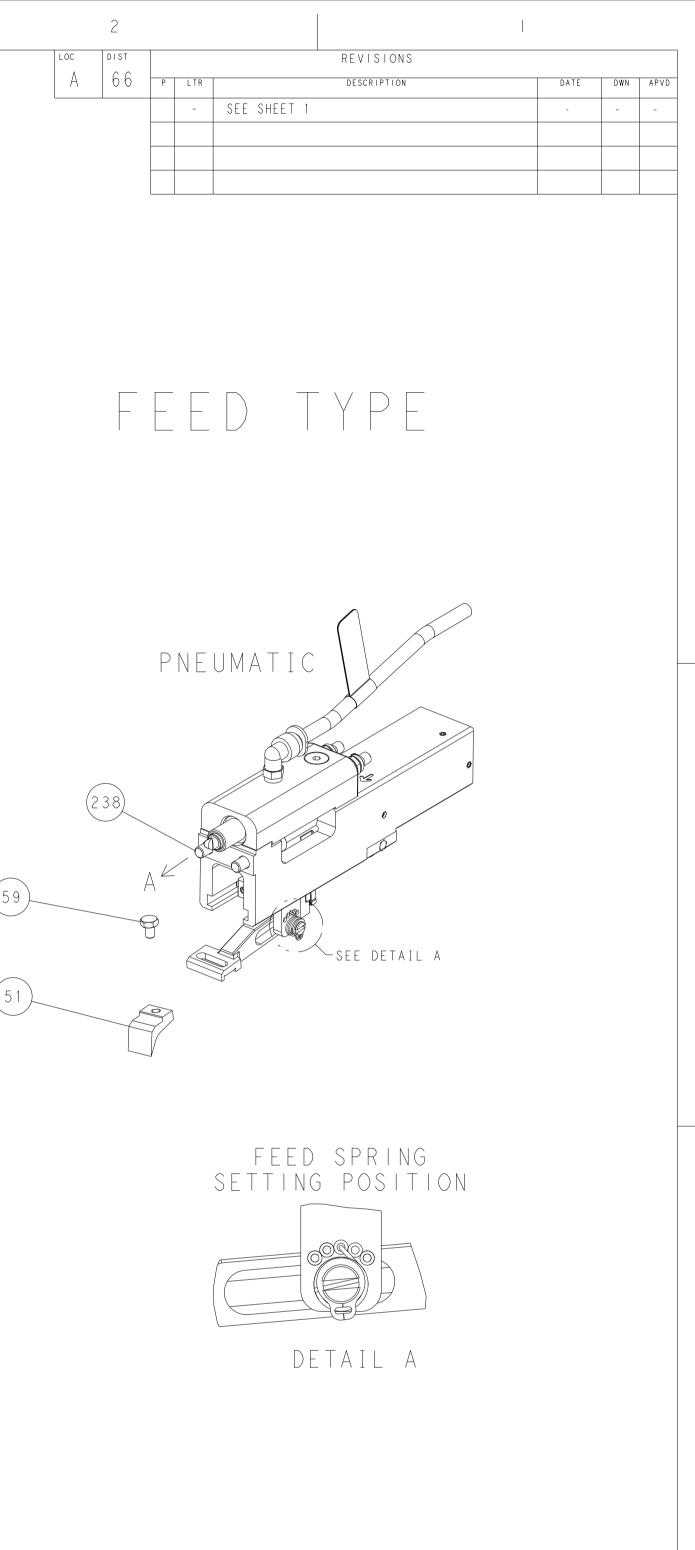
AIR FEED



4

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

3



	MENT FOR TYCO ELECTRONICS CORPORATION CONTROLLING ENGINEERING ORGANIZATION FOR THE LATEST REVISION.	dwn K.HUANG	30NOV2017				TE Connecti	vity		
	1	снк L.ZHANG	30NOV2017	. (Harrisburg,	PA 171	05-3608	
	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD L.ZHANG	30NOV2017	NAME		Ocea	n End Fe	ed		
	0 PLC ±- 1 PLC ±-	PRODUCT SPEC					plicator			
1	2 PLC ±- 3 PLC ±-	- APPLICATION SPE	.c				-			
,	4 PLC ±- ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO				RESTRICTED TO
	FINISH -	WEIGHT _		A	00779	C - 21	50861			-
	-	Customer Ac	cessible Pr	oduct	ion Draw	ing	scale 1:1	SHEET	2 ^{of} 4	REV B

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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C COPYRIGHT 20		ICS CORPORATION. ALL		
PART NUMBER	REVISION	DES	SCRIPTION	FEED TYPE
2-2150861-2	В	FINE CRIM	IP HEIGHT ADJ	UST PNEUMATIC
7-2150861-7	А	CRIMP	TOOLING KIT	-
APPLICA CRIMP S WIRE 2.79 mm INSUL 4.06 mm APPL INSTRU 408-350	I Z E [.110] [.160] JC T I ON S	TA TYPE F F		
TERMINAL DATA TERMINAL NAME WIRE STRIP	: RING	MINAL Tongue		MP SPECIFICATION DIAMETER RANGE

7

8

WIRE SIZE 🛞 🕇	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 4 REFERENCE SETTING
1.50mm2	2.00+/-0.05 [.079+/002]	5.1
1.00mm2	1.85+/-0.05 [.073+/002]	7.0
0.75mm2	1.77+/-0.05 [.070+/002]	7.9
0.50mm2	1.70+/-0.05 [.067+/002]	8.6

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1 RECOMMENDED SPARE PARTS

REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

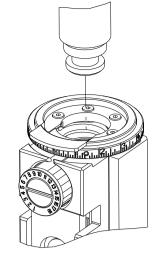
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.

A 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*WAF	RN I I	NG
ON I	NS	TALL
SETT	- I N (G FO
SETT	- I N (GS G
ΤΗΕ	CR	ΙMΡ
PROF	PER	SET



PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

LATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE OR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO TOOLING. REFER TO THE INSTRUCTION SHEET FOR TUP AND ADJUSTMENTS.

4

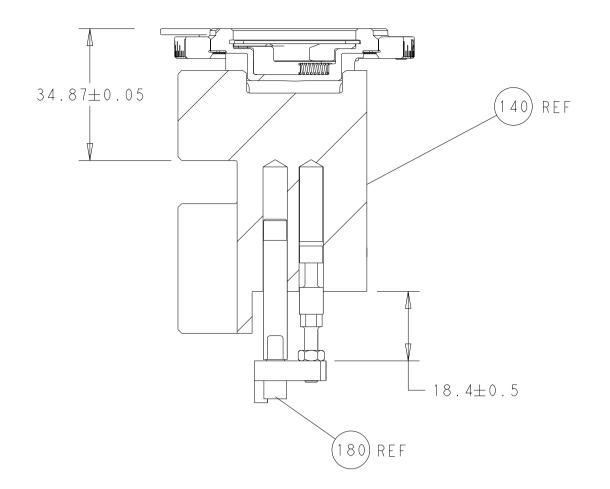
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

	-		2119082-4	CAM, SNAIL, INSULATION ADJUSIMENT	244	
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
<u>/</u> 3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
	-	1	2844940-4	AIR FEED MODULE	238	
	-		1 - 1 8 0 2 8 - 0	WASHER, FLAT, REG M8	192	
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
/3	-	1	1752354-4	STANDOFF, HOLD-DOWN	180	
	-	1	6 - 9 9 3 1 1 1 - 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	
	- R	EF	994970-2	COUNTER, MAGNETIC	164	С
	-	1	2119641-2	FEED CAM, AIR FEED	152	0
	-	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	455888-4	SPACER, CRIMPER	82	
	-	1	2119791-5	DEPRESSOR, WIRE	73	
	-	1	1803607-4	DOCUMENTATION PACKAGE	71	
	-	2	2 - 1 8 0 3 2 - 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	1901681-1	HOLDDOWN, TERMINAL	65	
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	FEED FINGER	51	
	_	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	_	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1	
	_	8	1 - 18028 - 2	WASHER, FLAT, REG M4	33	
	_	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
	_	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	В
	_	1	240639-1	STRIPPER (MACHINING)	27	
	_	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
	_	1	1 - 1 7 5 2 3 7 1 - 2	PLATE, STRIP GUIDE	24	
	_	2	2 - 22281 - 3	SPRING, COMPRESSION	22	
	_	1	1803292-4	DRAG	20	
	_	1	1-1901696-1	STRIP GUIDE, REAR	19	
	_	1	1 - 1 9 0 1 6 9 5 - 1	STRIP GUIDE, FRONT	18	
	_	1	2 - 2 4 0 6 4 1 - 3	SPACER	16	
	_	1	1752360-1	SPACER, HOLD-DOWN	13	
\bigwedge	_	1	240644-5	PLATE, REAR SHEAR		
$\angle 1$		2	1 - 2 4 0 6 4 5 - 4	SPACER, SHEAR PLATE	1 0	
\wedge		<u> </u>	1 - 2 4 0 6 4 2 - 1	PLATE, FRONT SHEAR	9	
	1	1	1803615-5	ANVIL, COMBINATION, END FEED	8	
		1	9 - 240651 - 1	BLADE, SLUG	7	
$\angle 1$			9-240031-1	DLADE, SLUG	1	
	_	1	- 4 - 2 4 0 6 4 1 - 5	- SPACER	6	
	-	1			5	
	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
$\angle 1$		1	7-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
\wedge	-	1	455888-5	SPACER, CRIMPER	2	
$\angle 1$			7 - 456408 - 2	CRIMPER, WIRE PREMIUM		
	- 7 7 -	22	PART NO	DESCRIPTION	I T E M N O	А
THIS DRAWING IS A CONTROLLED DOCUMENT FO IT IS SUBJECT TO CHANGE AND THE CONTROL SHOULD BE CONTACTED FOR THE	DR TYCO ELECTR	ONICS CORPORATION ORGANIZATIO	on dwn 30NOV	/2017 TE Connectivity		
SHOULD BE CONTACTED FOR THE	NEVIX		снк ЗОНОУ			
DIMENSIONS: C	TOLERANC DTHERWISE	ES UNLESS SPECIFIED:	L.ZHANG APVD 30NOV	/2017 NAME		
0 PL	_C ±	-	L.ZHANG product spec	Ocean End Feed		
	_C ± _C ±	-	-	Applicator		
3 PL 4 PL	_C ± _C ±	-	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO RE	STRICTED TO	
ANGL MATERIAL FINI		<u>±-</u>		$A \mid 00779 \bigcirc 2150861$	_	
-	-		Customer Accors	ble Production Drawing SCALE 1.1 SHEET 3 OF 2	REV R	
					B	
			SHEETS	1 & 2 ARE NOT REQUIRED FOR PACIFIC V	ERSION	

2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT

244

8		7	6
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RAM AND HOLDDOWN SET-UP

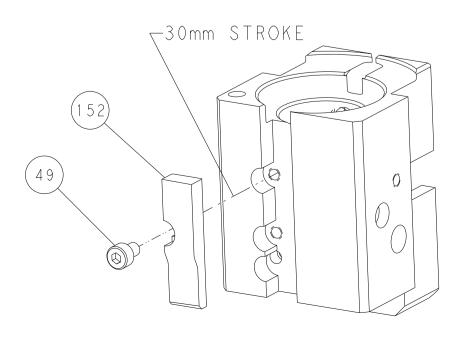


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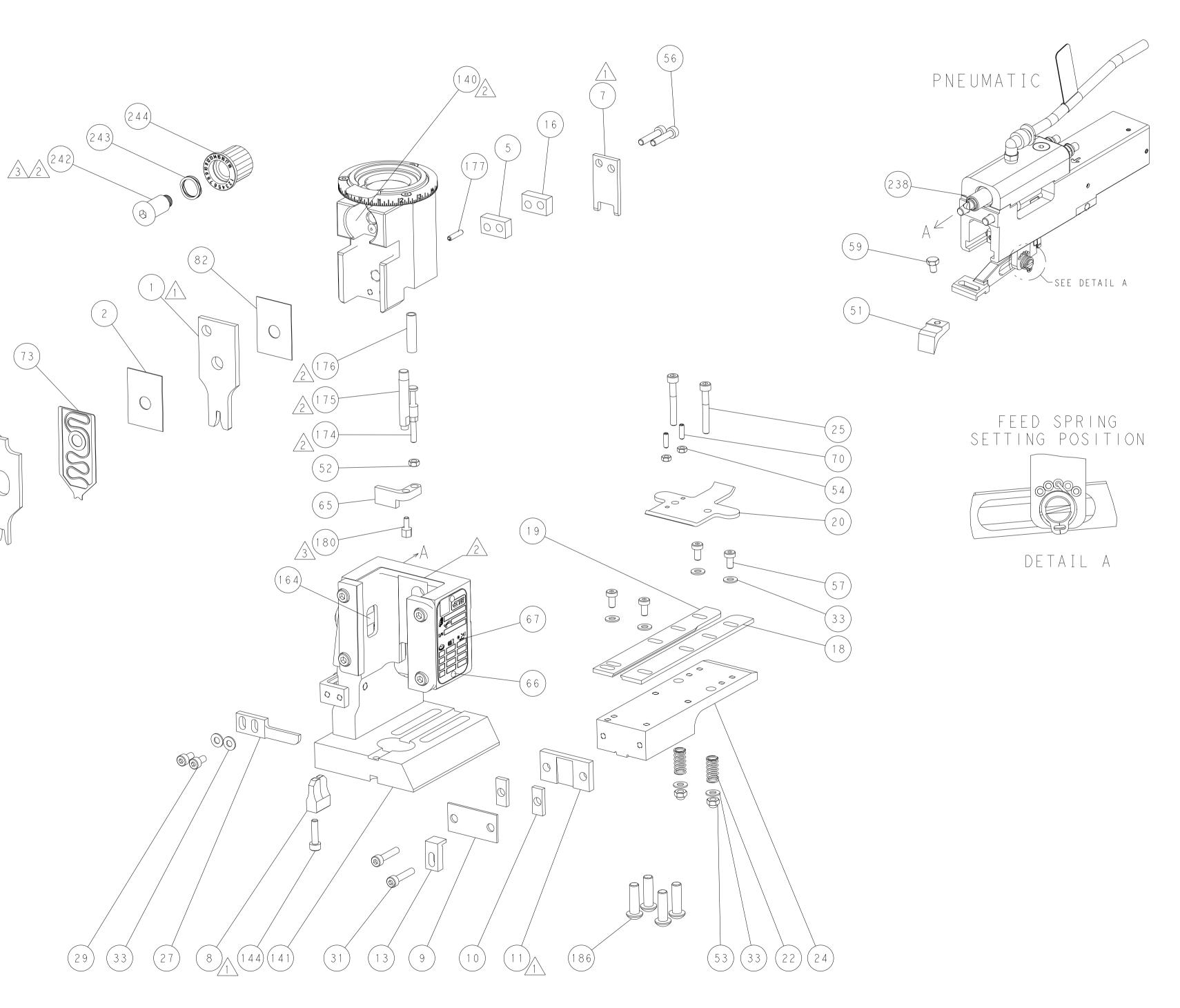
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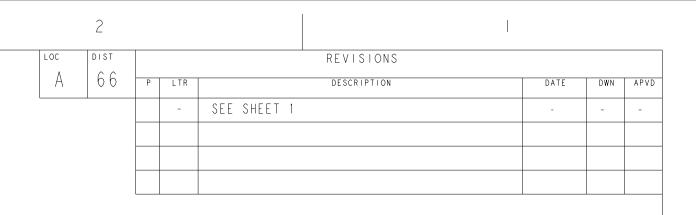
AIR FEED



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FEED TYPE

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SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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