

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

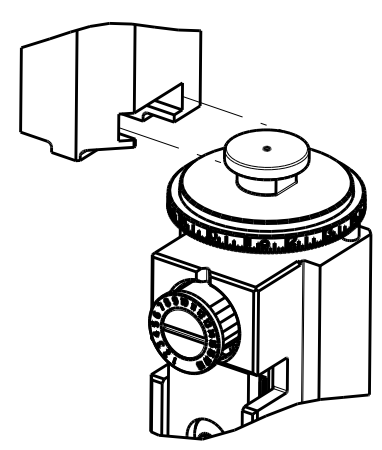
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151792-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

5-18022-5

8-2151792-5

8-2151792-4

2119641-1

2119799-1

2063440-1

2168400-6 (QUANTITY 2)

-

-

-

2151792-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

5-18022-5

8-2151792-5

8-2151792-4

2119653-1

-

-

-

2168400-6 (QUANTITY 2)

-

-

-

2151792-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

5-18022-5

2119653-1

2119641-1

2119799-1

2063440-1

-

-

-

2151792-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴¹²

-

-

-

-

-

-

-

-

-

-

2151792-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

-

-

-

7-2151792-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

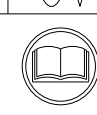
F

INSUL

3.94 mm [.155]

OV

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: STANDARD POWER TIMER KONTAKT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.10-4.86 mm [.161-.191 IN]

Ø2.00-2.80 mm [.079-.110 IN]

TERMINAL APPLICATION SPECIFICATION

114-18037

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

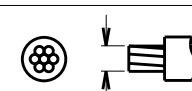
1862006-1

1862006-5

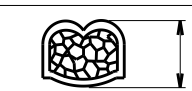
-

-

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.20mm2

1.49+/-0.05 [.059+/- .002]

9.9

0.80mm2

1.37+/-0.05 [.054+/- .002]

11.1



1

RECOMMENDED SPARE PARTS

2

GREASE BEARING SURFACES LIGHTLY

3.

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151792-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151792-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151792-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151792-6

5.

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9

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.

10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

*WARNING

ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

1

-

1

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

-

-

-

1

-

2119641-1

FEED CAM, AIR FEED

248

-77

-7

-6

-5

-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)

SET UP GAUGE
2119599-1

LOC
A

DIST
66

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

09JAN2013

RK

GB

-

1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

-

-

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

-

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

-

1

1

1

1

1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-

1

1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

-

-

2

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

-

1

2063440-1

AIR FEED MODULE

238

-

-

1

1

-

-

2119740-2

TAG, IDENTIFICATION

213

-

-

1

1

-

-

1901094-3

SPACER, FEEDER

198

-

1

1

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

-

-

-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

-

-

-

1

-

2119799-1

HOLDER,FEED FINGER, AF

136

-

-

REF

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

-

-

1

1

-

-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

-

1

-

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

-

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

1

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

-

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

1

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

1

1

1

1

1

1901681-2

HOLDDOWN, TERMINAL

51

-

1

1

1

1

1

1-1752354-1

STANDOFF,HOLD-DOWN

50

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

-

-

-

-

-

1

2119653-1

FEED CAM, POST FEED

47

-

1

1

1

1

1

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

-

1

-

1

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

-

1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

-

1

-

1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

-

1

1

1

2119957-1

APPLICATOR SHIM PACK

39

-

1

1

1

1

1

2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

-

1

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

1

1

1

1

1

1-1752356-1

SUPPORT, TERMINAL

34

-

2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

-

1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1

1-1320908-2

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1

1-455888-0

SPACER, CRIMPER

28

-

1

1

1

1

1

1320928-2

STRIP GUIDE

24

-

1

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

-

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

20

-

1

1

1

1

1

2119533-1

STRIPPER, SIDE FEED

19

-

1

1

1

1

1

2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

-

1

1

1

1

1

1-356885-4

STOP, SHEAR

11

-

1

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

1

1

462006-6

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

5-1633620-5

ANVIL, COMBINATION

8

-

-

-

-

-

-

-

-

7

-

-

-

-

-

-

-

-

6

-

1

1

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

238011-4

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

2-2119785-9

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

1

1

1

455888-3

SPACER, CRIMPER

2

-

1

1

1

1

1

456407-5

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE DRAWING ONLY. FOR THE LATEST REVISIONS, CONTACT THE ORGANIZATION THAT ISSUED THIS DRAWING. FOR THE LATEST REVISIONS, CONTACT THE ORGANIZATION THAT ISSUED THIS DRAWING.

DIMENSIONS:
mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±.1
1 PLC ±0.1
2 PLC ±0.02
3 PLC ±0.005
4 PLC ±0.0005
ANGLES ±.1

MATERIAL:
-

DWN
T.YIN
CHK
G.BAILEY
S.XI
APVD
18OCT2012
18OCT2012
18OCT2012

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO.
©=2151792

RESTRICTED TO
-

Customer Accessible Production Drawing

SCALE
1:1

SHEET
1

OF
4

REV
A

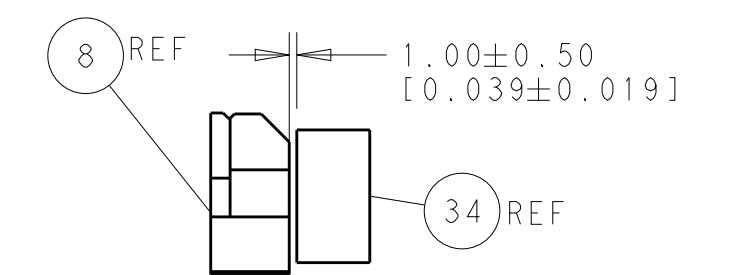
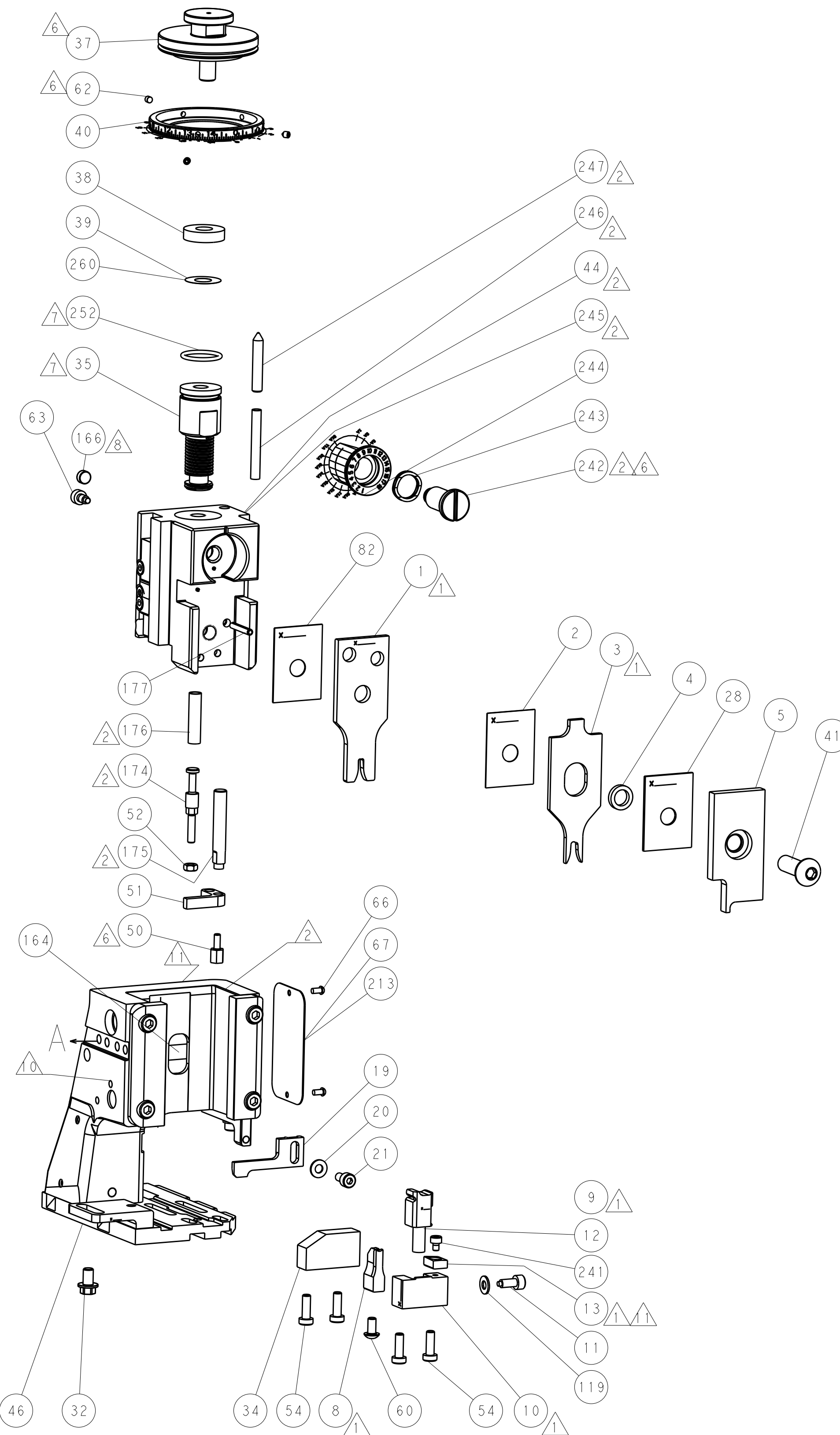
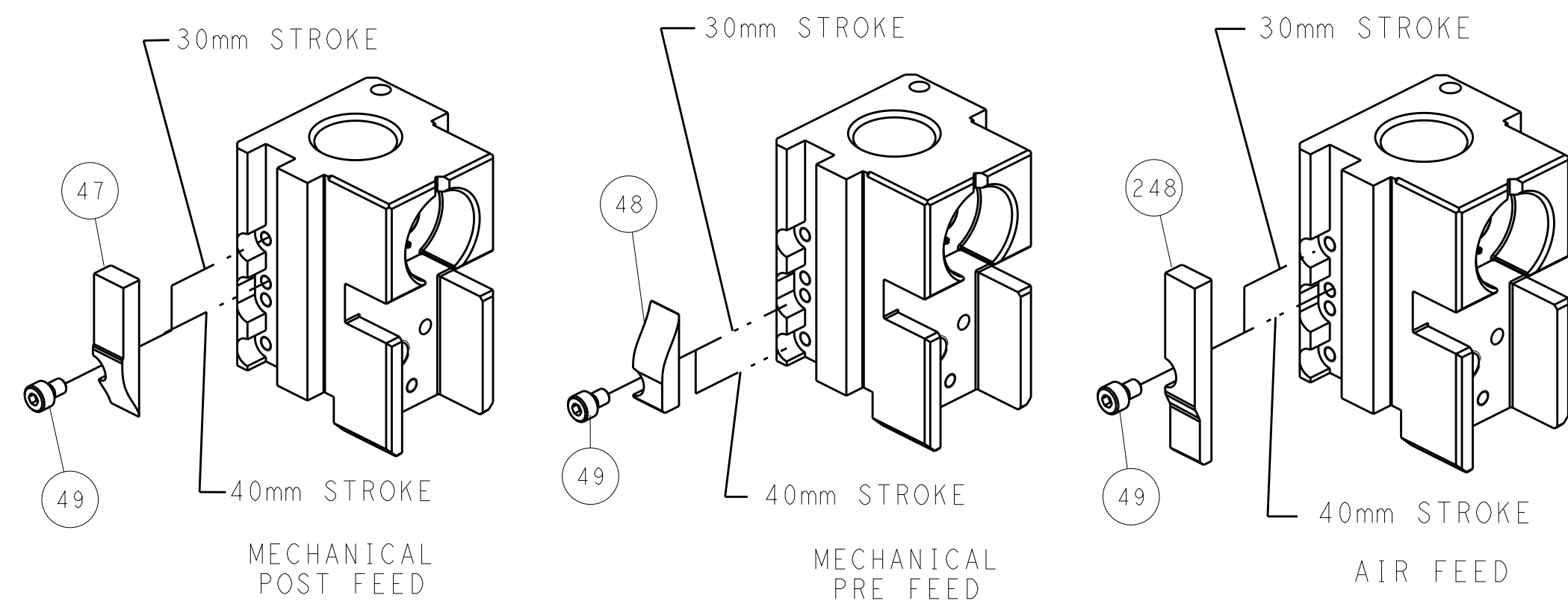
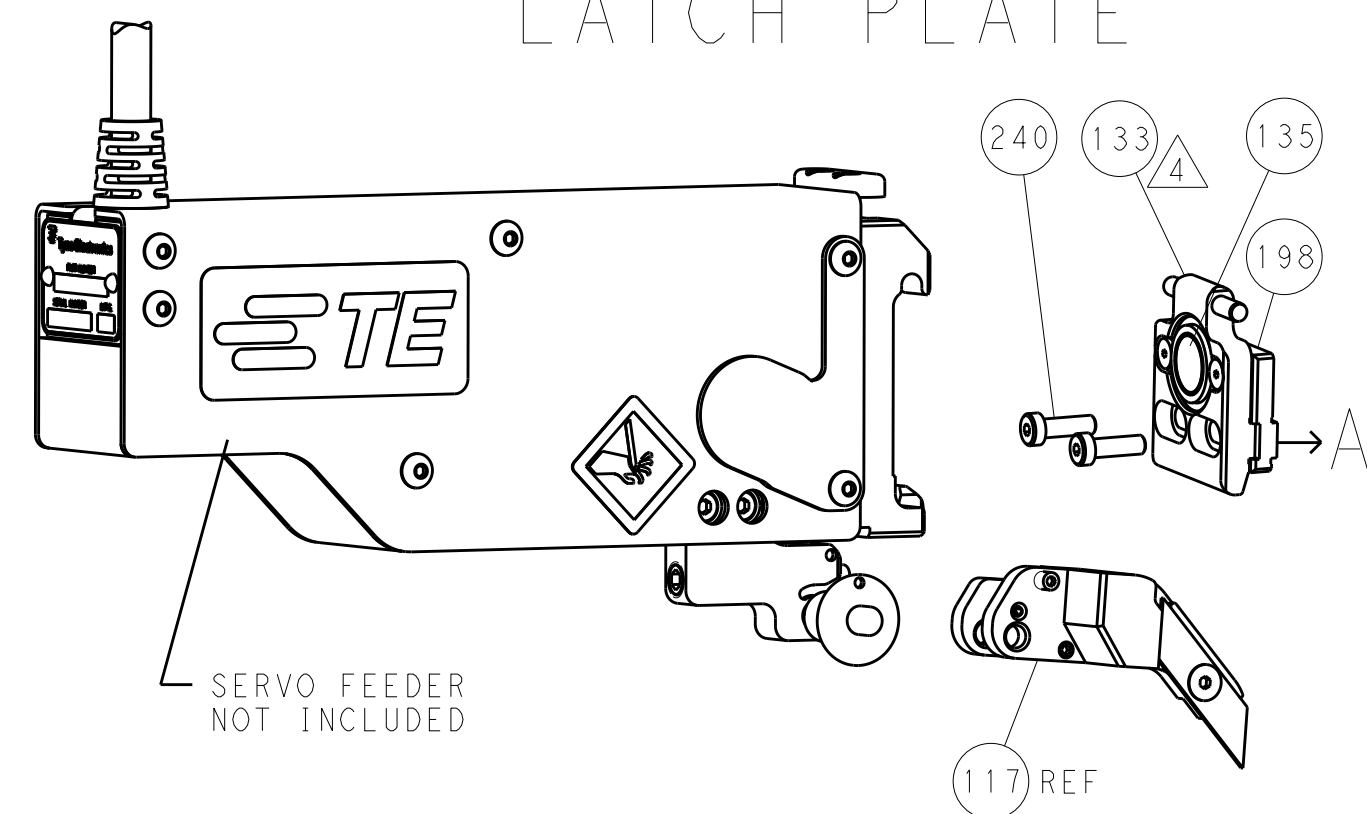
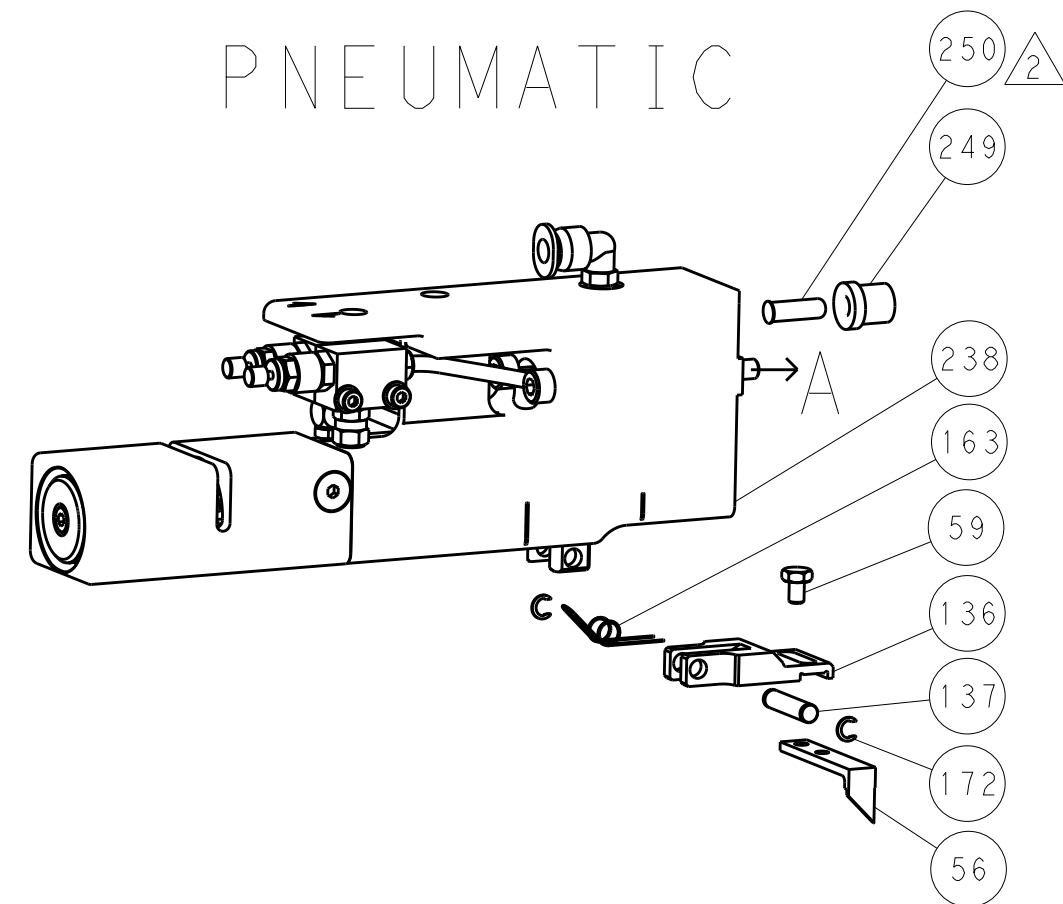
AMP 4805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

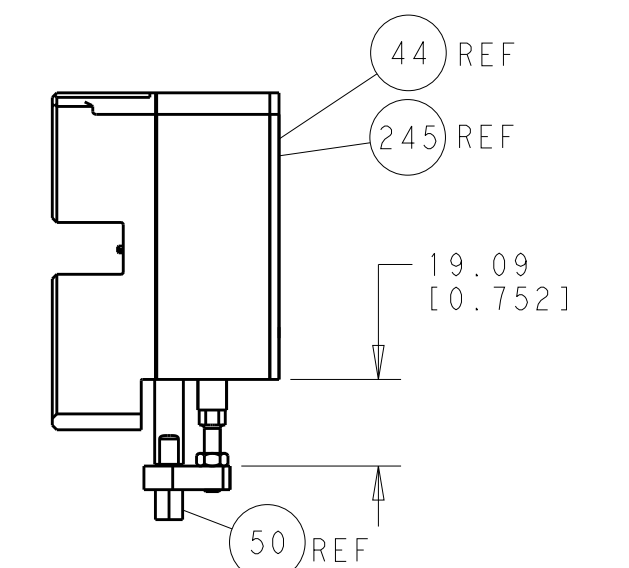
PNEUMATIC

SERVO
LATCH PLATE

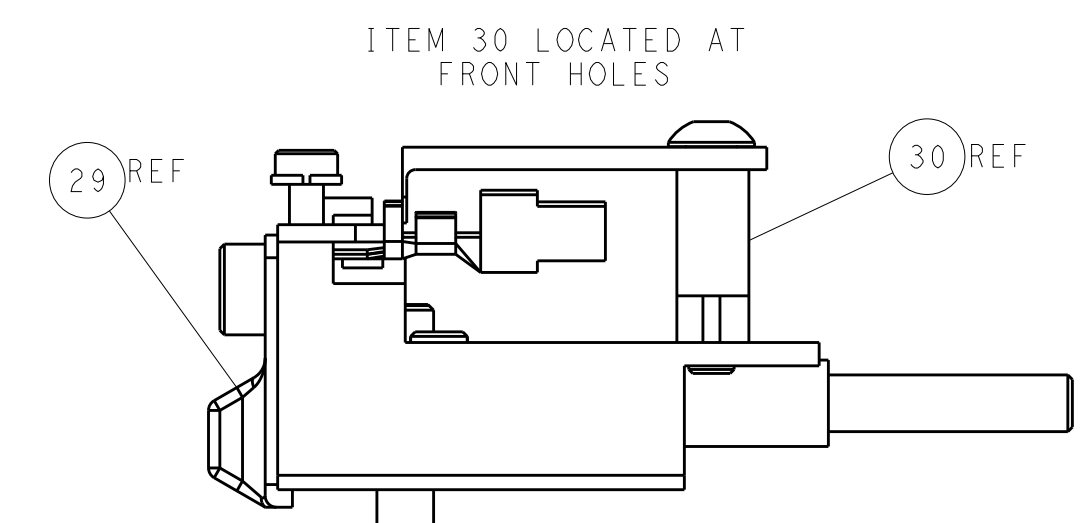
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TPO. TPO PRINTING CORPORATION IT IS SUBJECT TO THE TPO PRINTING CORPORATION'S POLICY. ANY ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 180C12012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK 180C12012			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		G. BIALEY 180C12012		NAME Ocean Side Feed Applicator	
mm		APVD 180C12012			
		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
		APPLICATION SPEC			
MATERIAL		WEIGHT		A 00779 ©=2151792 Customer Accessible Production Drawing	
FINISH		SCALE		1:1 SHEET 2 of 4 REV A	

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

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

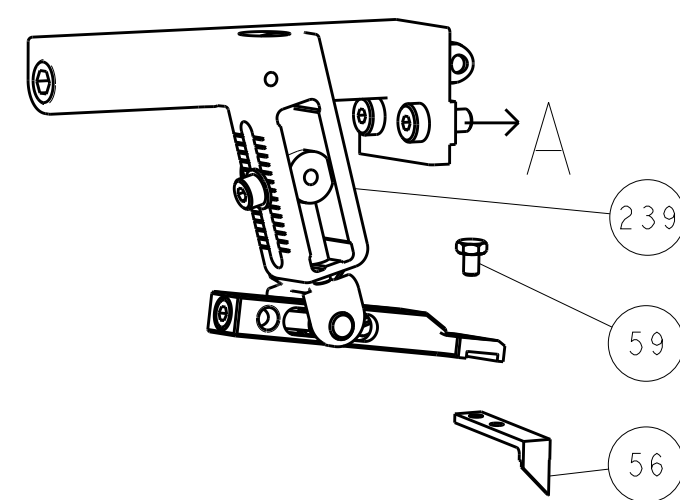
D

C

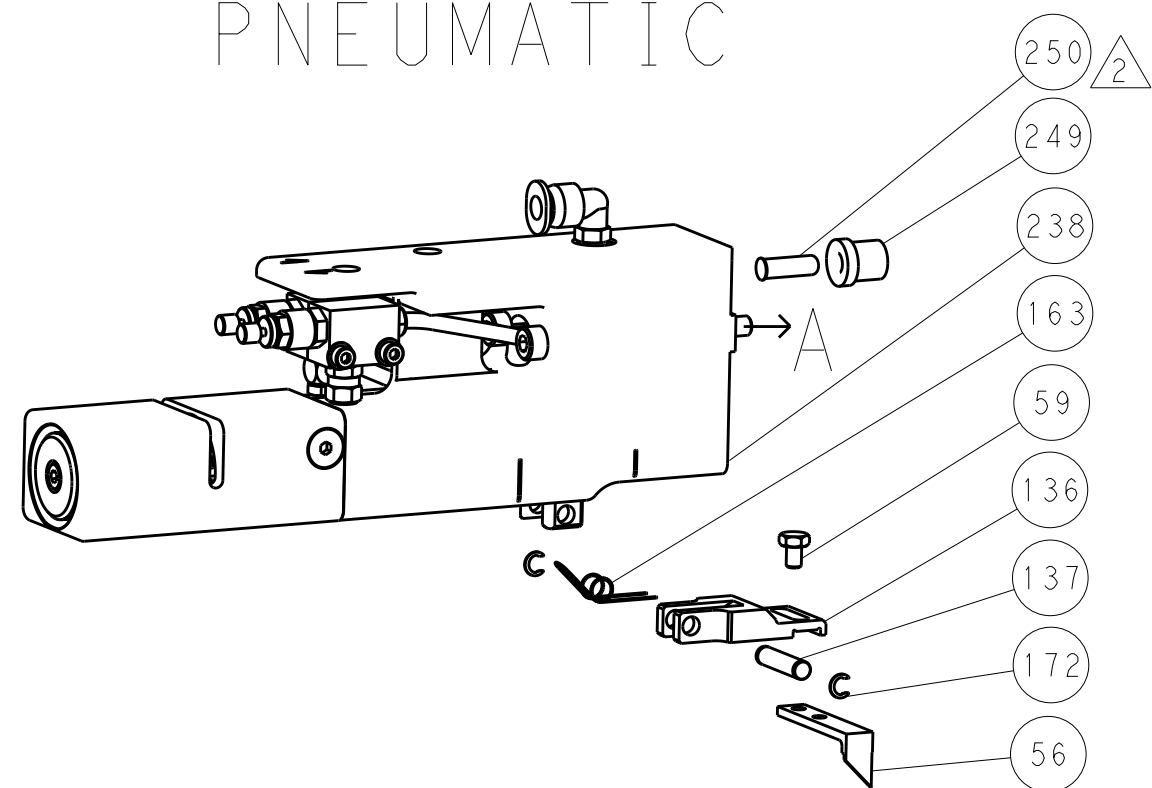
B

A

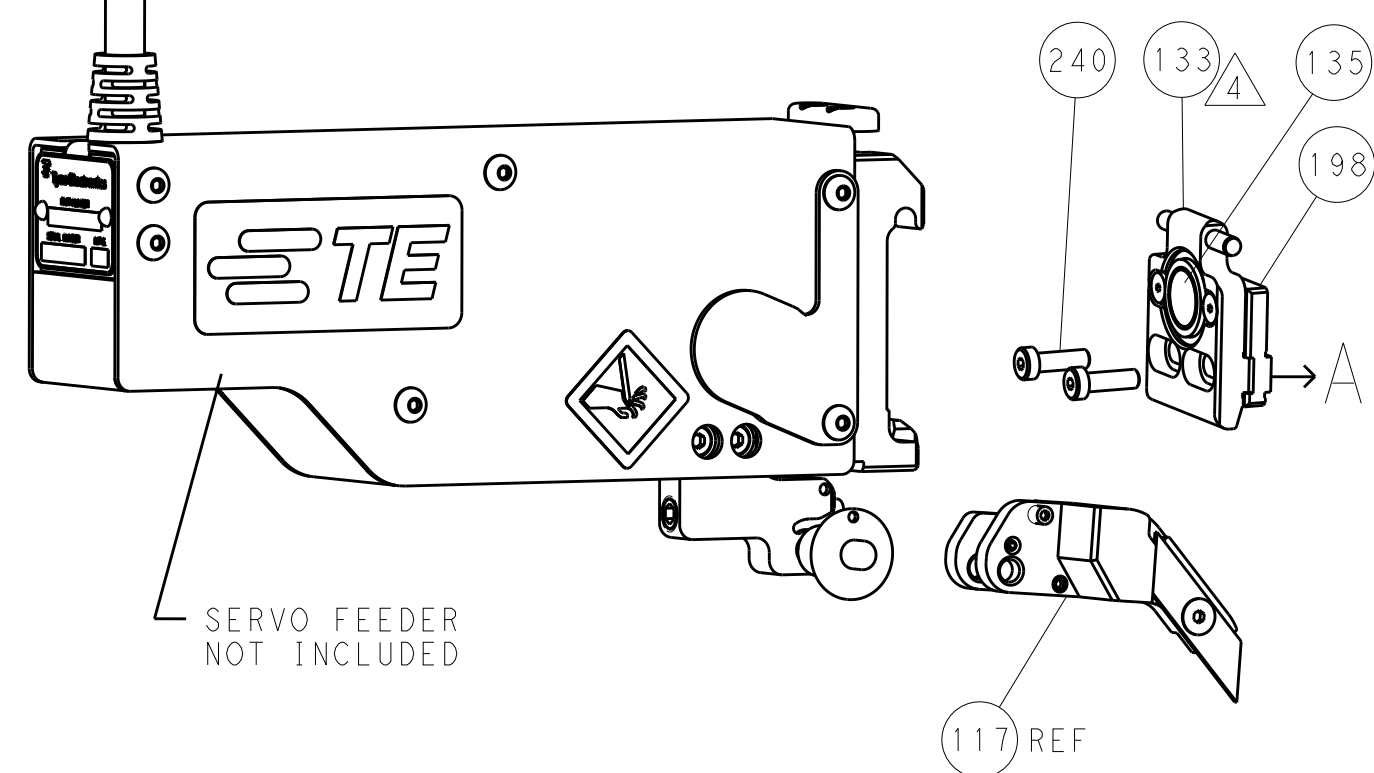
FEED TYPE MECHANICAL



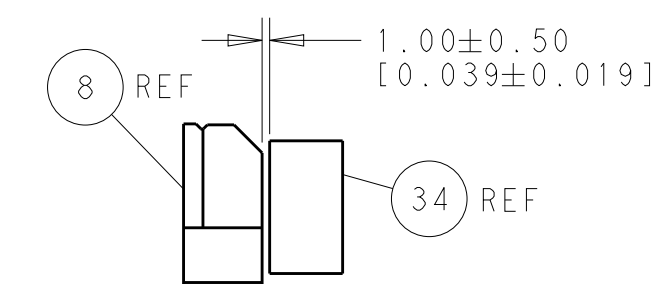
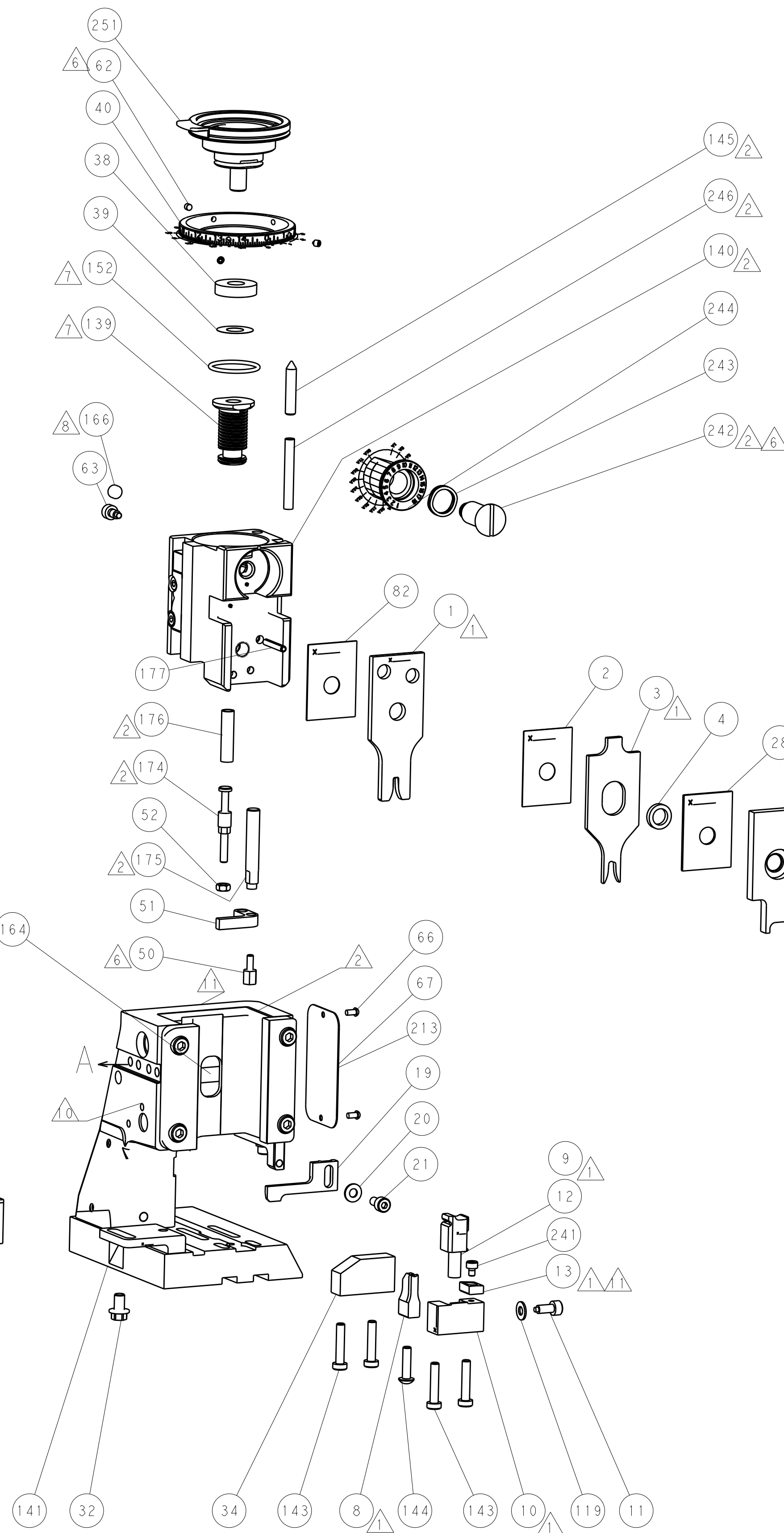
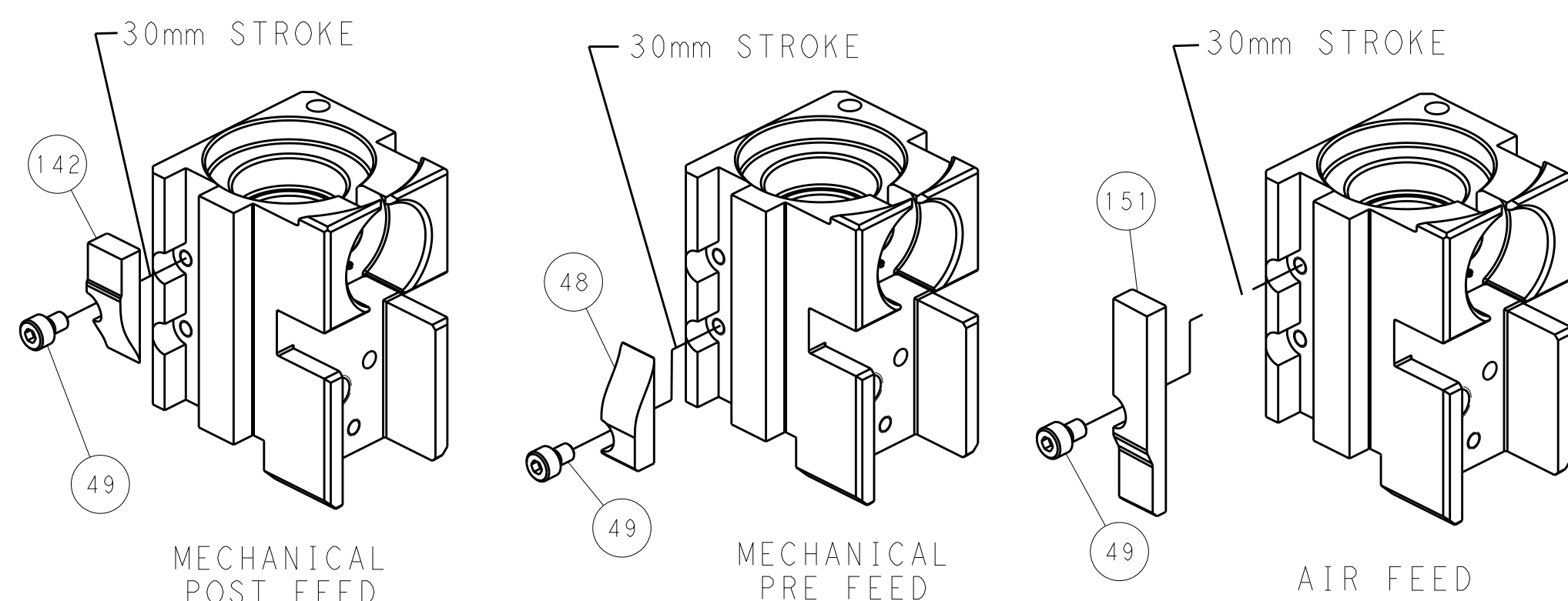
PNEUMATIC



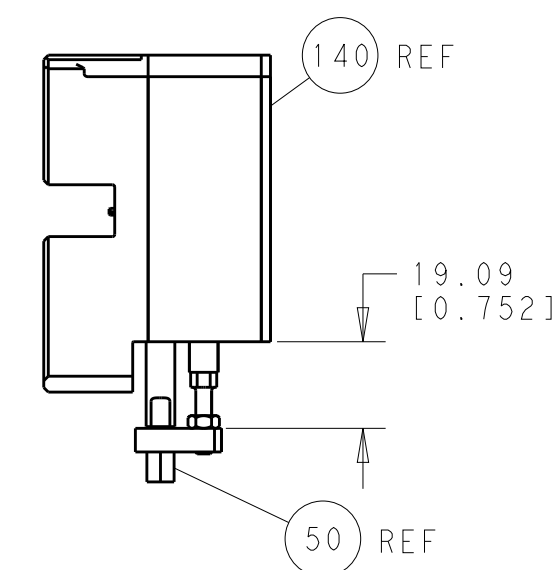
SERVO LATCH PLATE



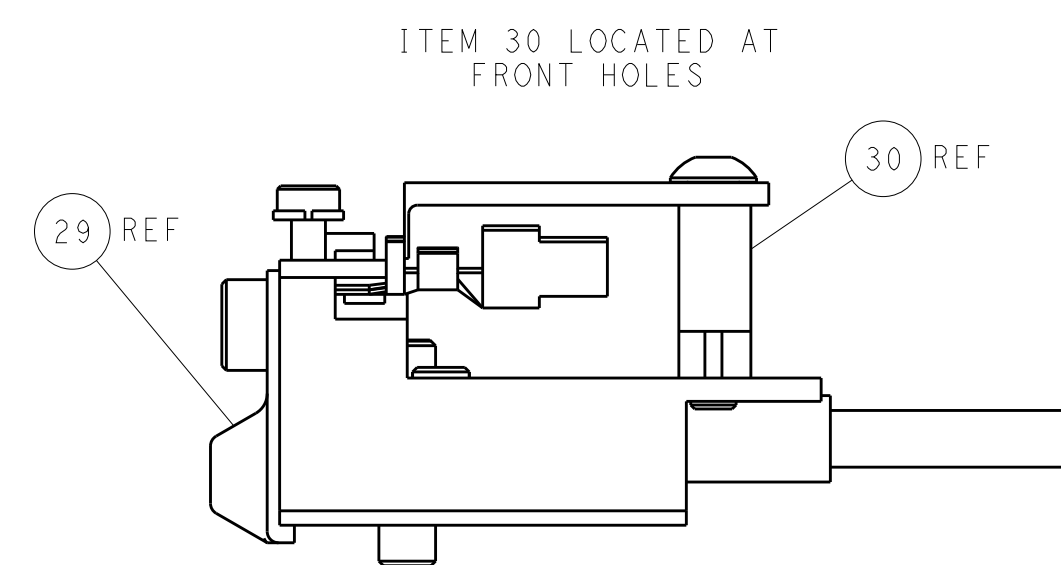
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE OCEAN ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION. FOR MORE INFORMATION, CONTACT THE OCEAN ELECTRONICS CORPORATION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN Y. YIN 18OCT2012	 TE Connectivity Harrisburg, PA 17105-3608	Ocean Side Feed Applicator			RESTRICTED TO -
		CHK G. BAILEY 18OCT2012					
		APVD S. XI 18OCT2012					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
mm		0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1		PRODUCT SPEC			
				APPLICATION SPEC			
MATERIAL		FINISH		SIZE			
-		-		CAGE CODE			
		WEIGHT		DRAWING NO			
		-		A1 00779			
		Customer Accessible Production Drawing		C=2151792			
				SCALE			
				1:1			
				SHEET			
				4 OF 4			
				REV			
				A			