

8

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1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

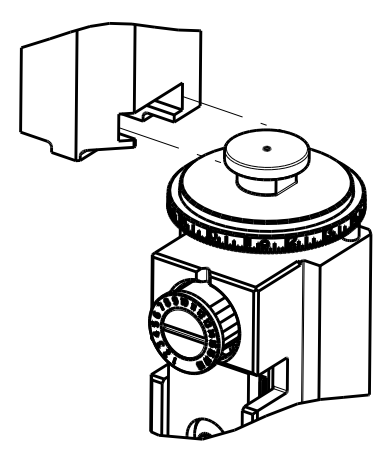
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151079-1

C

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2151079-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

8-2151079-5

1901094-3

-

2168400-6 (QUANTITY 2)

2151079-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

5-18022-5

2119653-1

2119641-1

2119799-1

2063440-1

2151079-6

C

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

-

-

-

-

-

-

-

2151079-7

C

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2151079-7

B

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

3.30 mm [1.130]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 5MM POWER KEY CONNECTOR REC. CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.00-4.00 mm [.118-.157 IN]

Ø2.00-3.10 mm [.079-.122 IN]

TERMINAL APPLICATION SPECIFICATION

114-5292

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

1376347-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

16 AWG OR 1.27mm2

1.29+/-0.05 [.051+/- .002]

4.0

18 AWG OR 0.76mm2

1.15+/-0.05 [.045+/- .002]

5.5

20 AWG OR 0.51mm2

1.05+/-0.05 [.041+/- .002]

6.5

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: 8-2151079-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151079-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151079-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151079-6

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.

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2119957-2

APPLICATOR SHIM PACK

260

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1

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1

1

1

8-21084-0

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

252

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-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-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

B

ECR-12-007493

23APR2012

XZ

GB

C

ECR-13-007006

25APR2013

KH

TE

-

-

-

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1

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2079988-1

BUSHING, LCH5-12, MISUMI

249

-

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1

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2119641-1

FEED CAM, AIR FEED

248

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1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

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1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

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2119758-1

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

245

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1

1

1

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1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

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1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

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1

1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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2

2

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2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

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2119580-1

MECHANICAL FEED ASSEMBLY

239

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2063440-1

AIR FEED MODULE

238

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1

1

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2119740-2

TAG,IDENTIFICATION

213

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1

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1901094-3

SPACER, FEEDER

198

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1

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1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

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1

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1

8-22280-7

SPRING, COMPRESSION

176

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1

1752353-2

GUIDE PIN,HOLDDOWN

175

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1

1

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1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

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-

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

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1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

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REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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1

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240638-1

SPRING, FEED FINGER

163

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3-23627-7

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

137

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2119799-1

HOLDER,FEED FINGER, AF

136

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1633743-1

SERVO FEED LATCH ASM

133

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1-18028-2

WASHER, FLAT, REG M4

119

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REF

REF

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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1-455888-0

SPACER, CRIMPER

82

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1

1

1

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1

2119956-1

DOCUMENTATION PACKAGE

71

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1

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1

1

2119740-1

TAG,IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

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3

3

3

992763-5

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

62

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

1338685-1

PAWL, FEED

56

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4

4

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2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

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1901681-5

HOLDDOWN, TERMINAL

51

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1-1752354-8

STANDOFF,HOLD-DOWN

50

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18023-9

SCR, SKT HD CAP M4 X 6.0

49

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1

2119652-1

FEED CAM, PRE FEED

48

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2119653-1

FEED CAM, POST FEED

47

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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2119957-1

APPLICATOR SHIM PACK

39

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2119644-1

RAM WASHER, PRECISION

38

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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1752356-3

SUPPORT, TERMINAL

34

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2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

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1-1320908-0

SPACER, STRIP GUIDE

30

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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2-455888-0

SPACER, CRIMPER

28

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1320928-2

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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2119805-1

SHEAR HOLDER, FRONT

10

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454276-5

FLOATING SHEAR, FRONT

9

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2-1633131-2

ANVIL, COMBINATION .080

8

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2119757-4

DEPRESSOR, SHEAR

5

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238011-7

BLOCK, CRIMPER SPACER

4

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2119582-1

CRIMPER, INSULATION F PREMIUM

3

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455888-3

SPACER, CRIMPER

2

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3-456405-0

CRIMPER, WIRE PREMIUM

1

-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)

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DWN

A. HUANG

26AUG2011

CHK

S. XI

26AUG2011

DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

DRAWING NO

00779

©=2151079

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

C

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

8

7

6

5

4

3

2

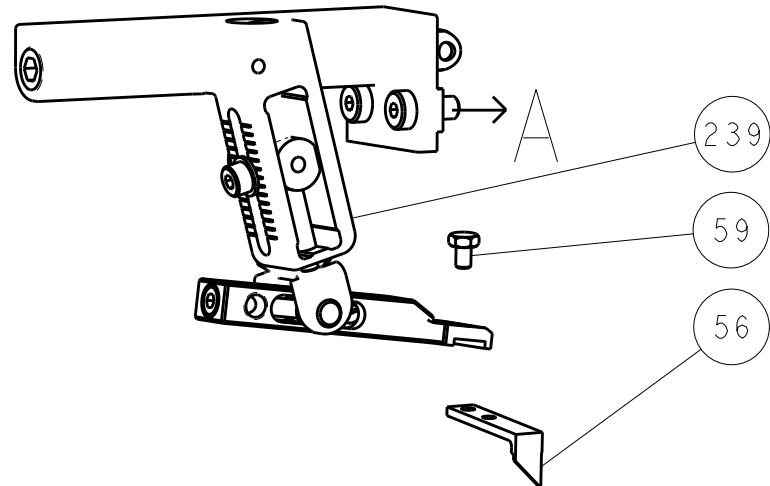
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AMP 4805 REV 31MAR2000

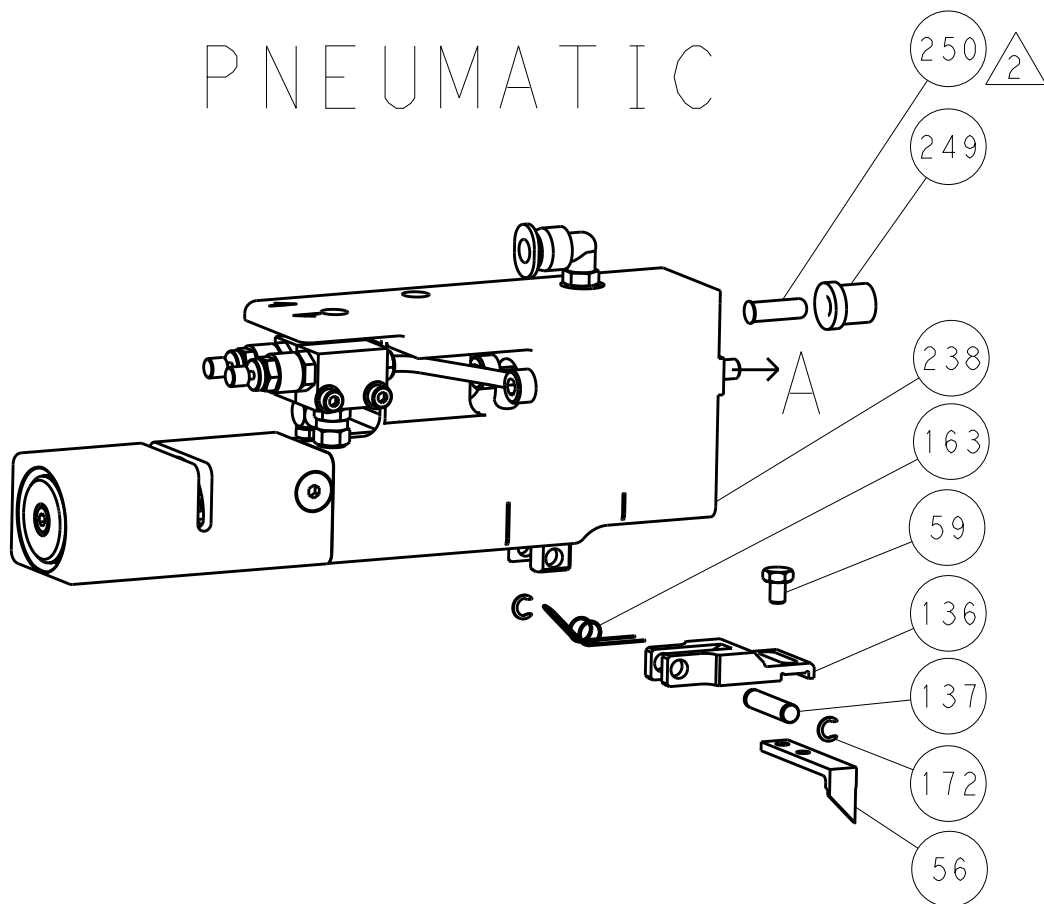
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION		DATE	OWN
		-	-	SEE SHEET 1		-	-

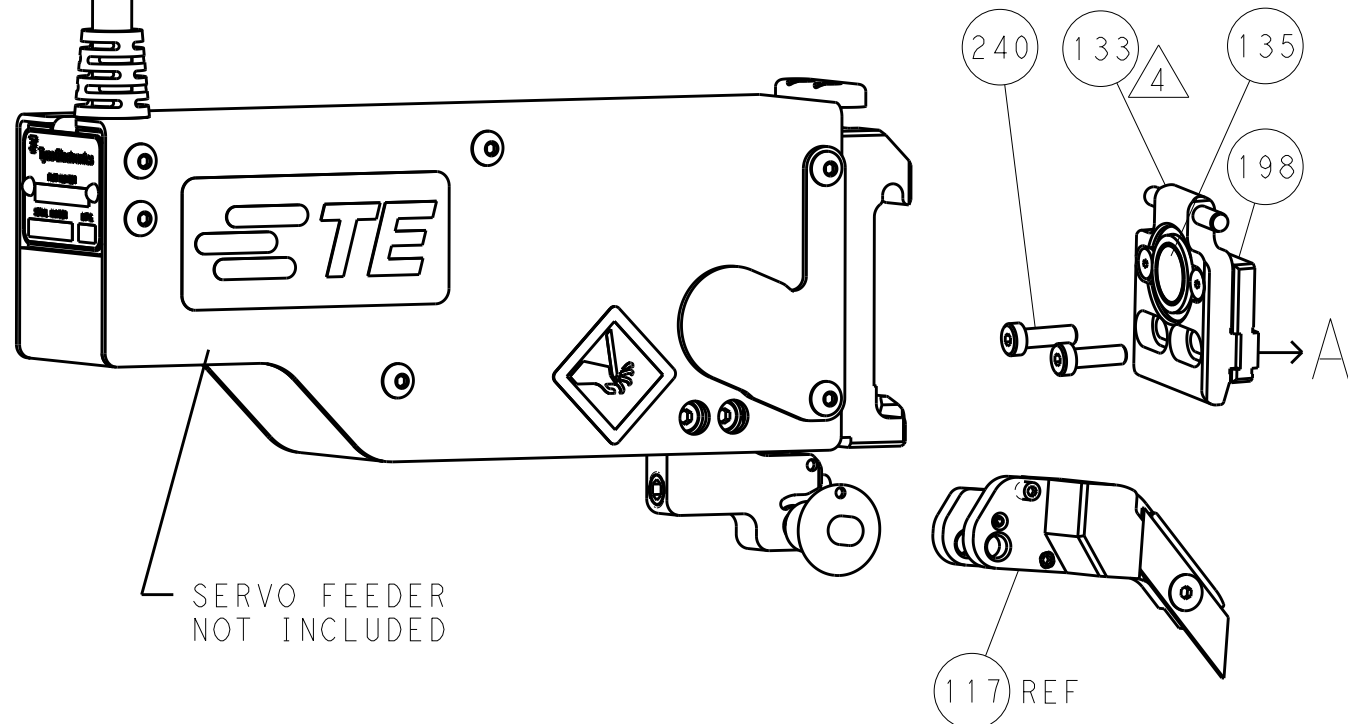
FEED TYPE MECHANICAL



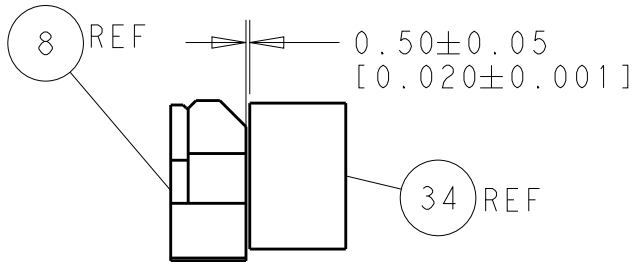
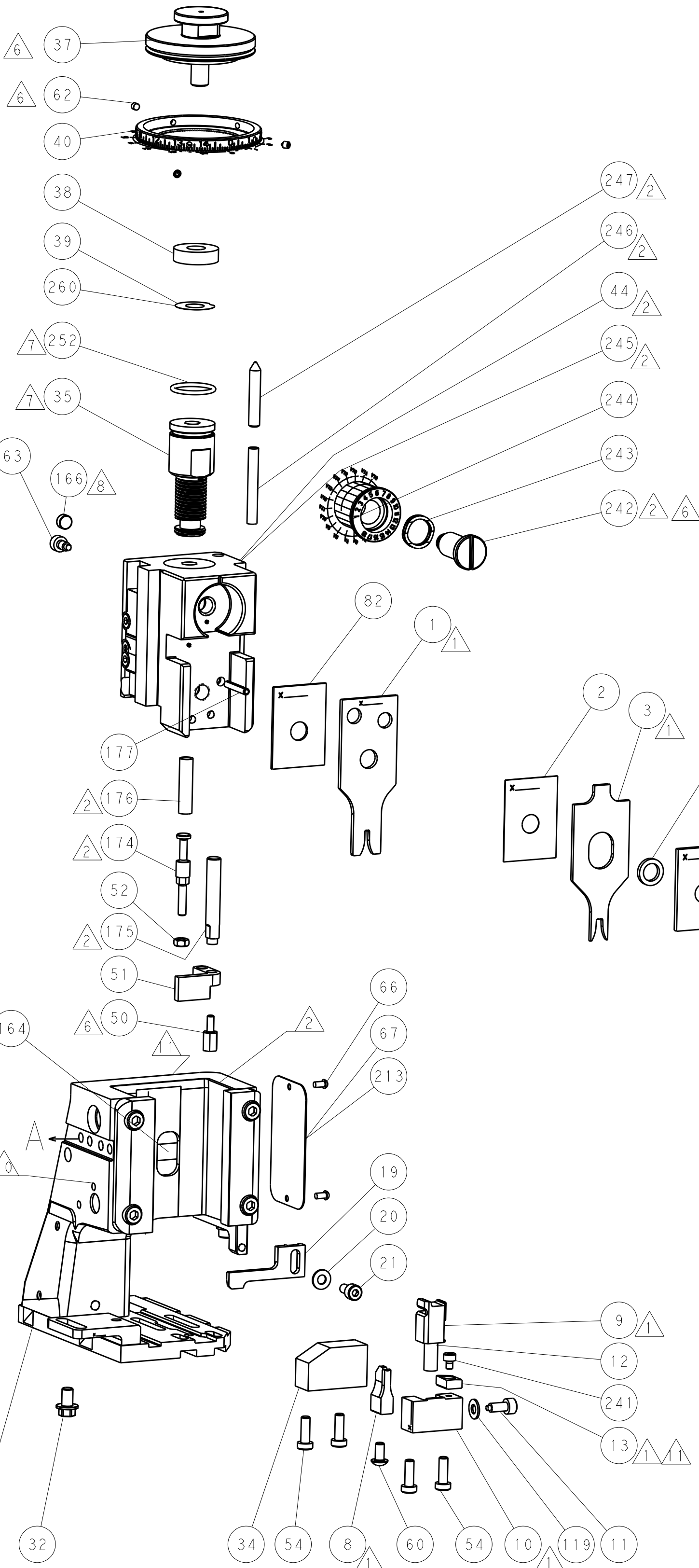
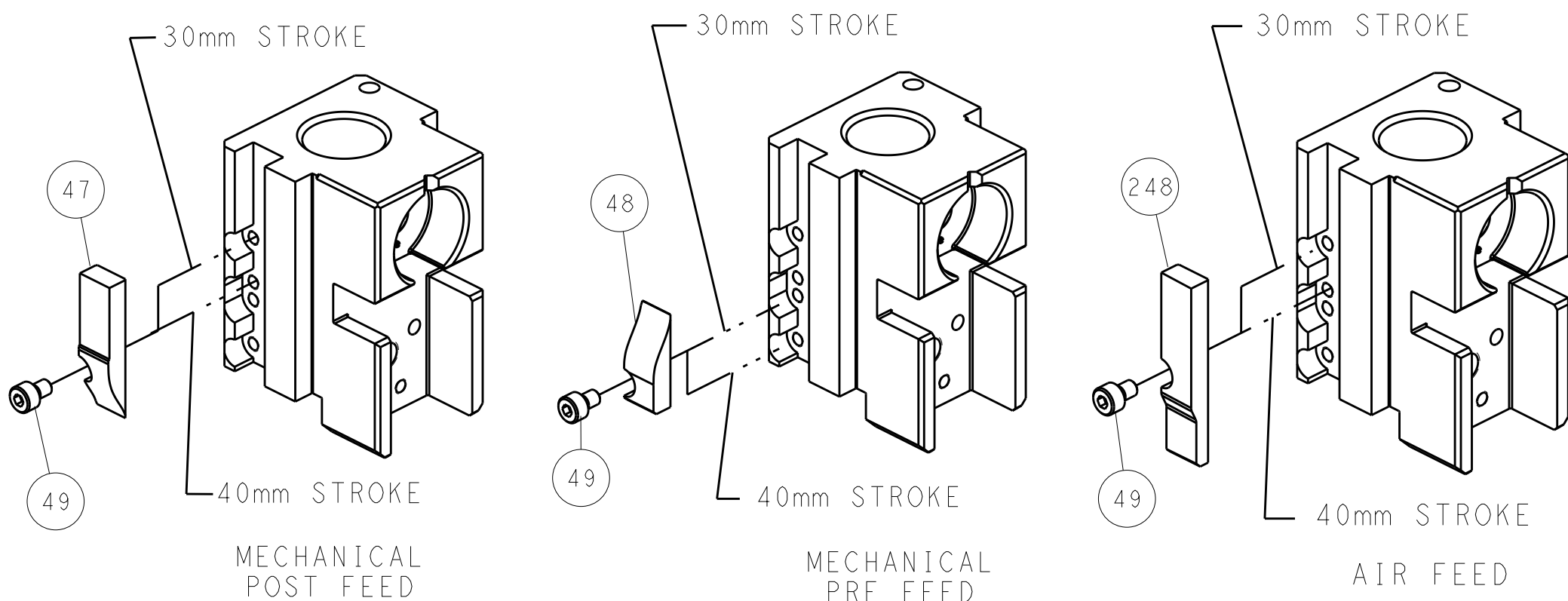
PNEUMATIC



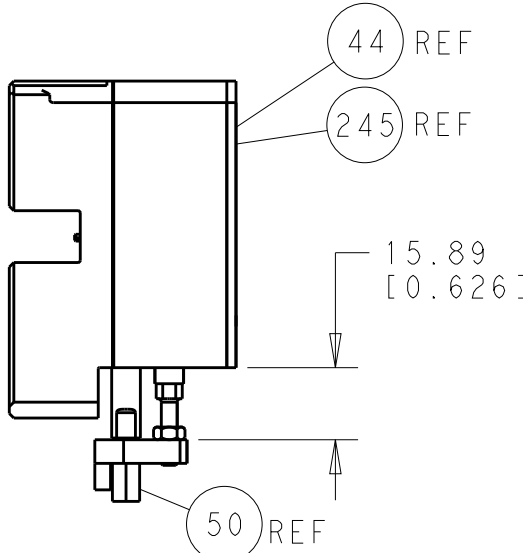
SERVO LATCH PLATE



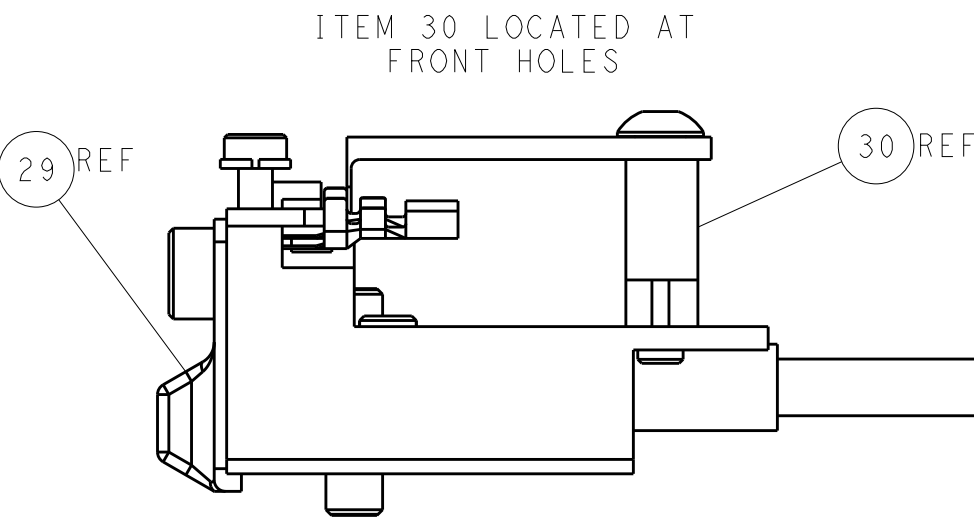
CAM POSITIONS



TERMINAL SUPPORT LOCATION

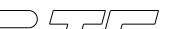


HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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DIMENSIONS: mm				CHK S. XI	26AUG2011	NAME	Ocean Side Feed Applicator						
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001				APVD S. XI	26AUG2011	PRODUCT SPEC							
				APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
MATERIAL -				WEIGHT -		A1	00779	C=2151079	-				
				Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 OF 4	REV	C

PNEUMATIC

This diagram shows the exploded view of a pneumatic cylinder assembly. The main components are the cylinder body, piston rod, piston, and end cap. The assembly is shown in a disassembled state, with the parts arranged in a way that shows their relative positions and how they fit together. The parts are numbered as follows:

- 250: End cap
- 249: O-ring
- 238: Piston rod
- 163: Piston
- 59: Piston rod seal
- 136: Piston rod seal
- 137: Piston rod seal
- 172: Piston rod seal
- 56: End cap

LATCH PLATE

SERVO FEEDER
NOT INCLUDED

240

133

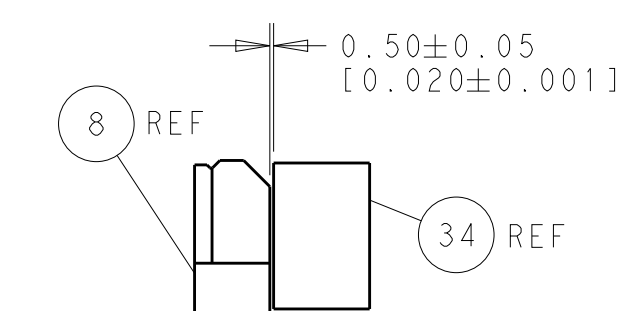
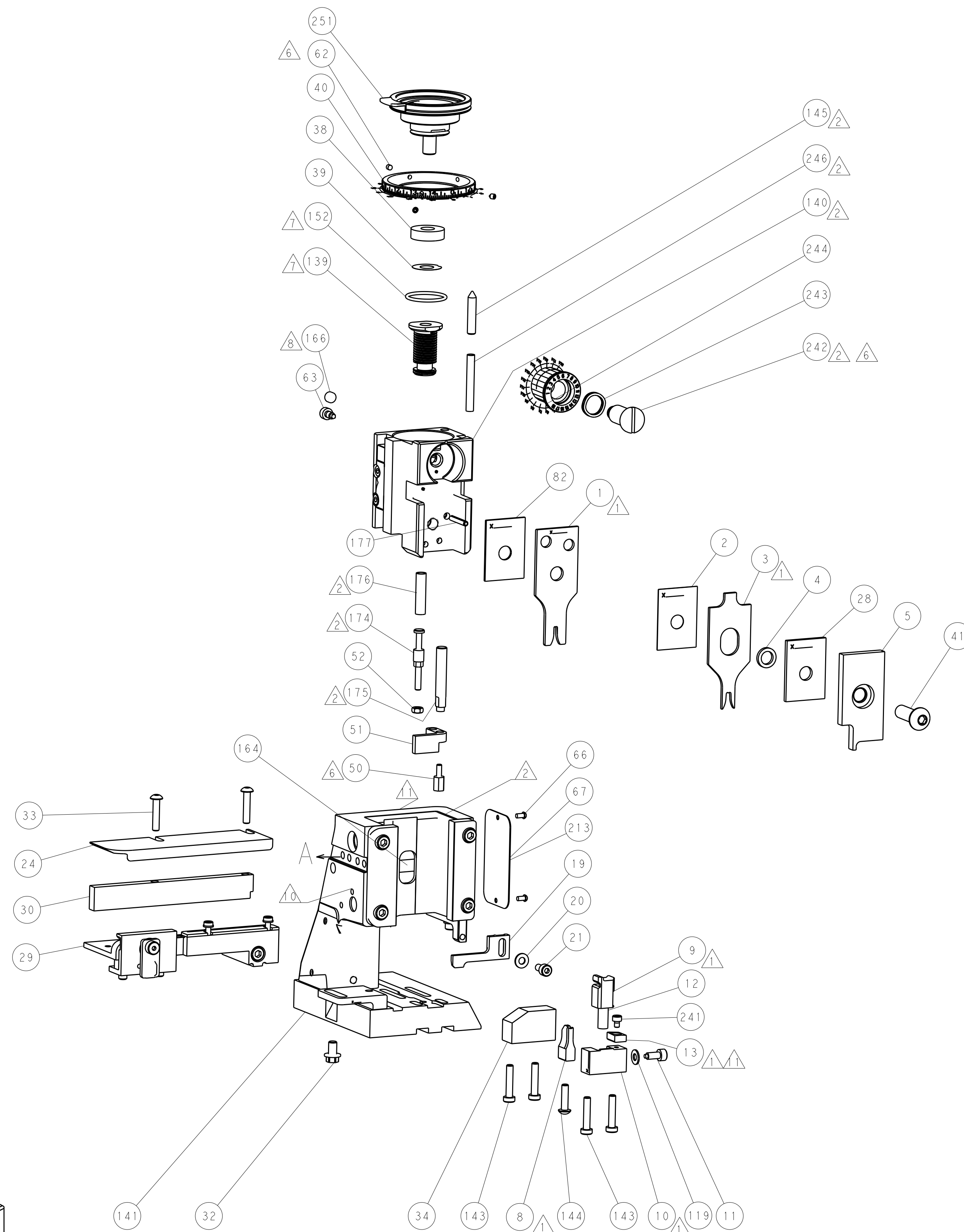
135

198

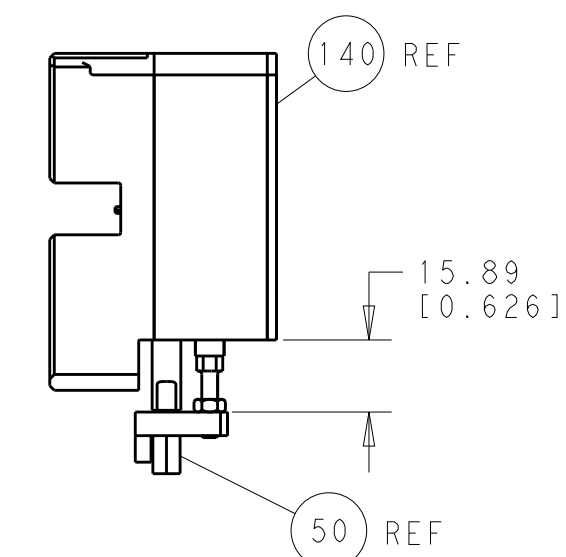
117 REF

The diagrams illustrate three types of mechanical feed systems:

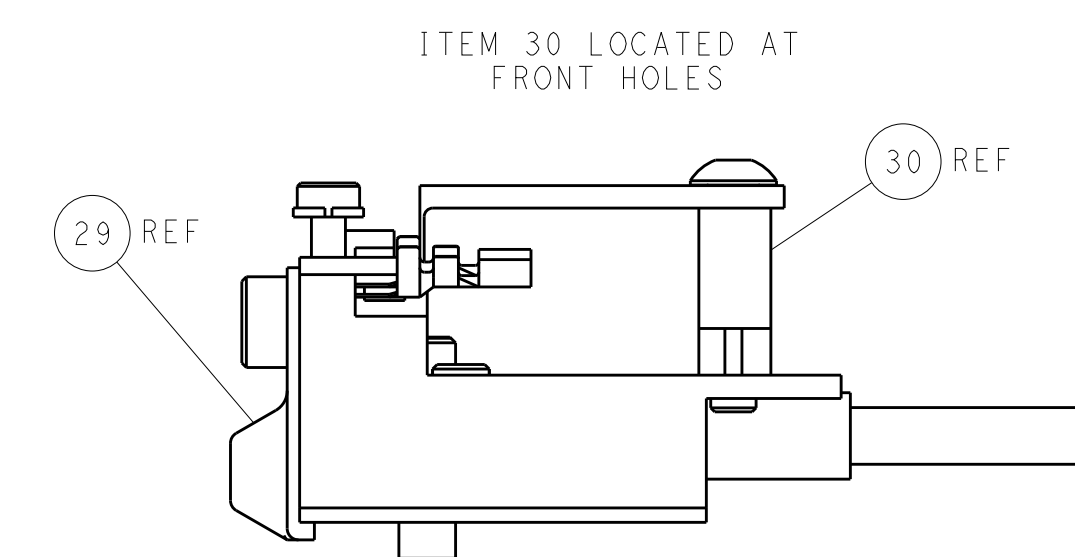
- MECHANICAL POST FEED:** Shows a 30mm STROKE and a 49mm distance from the tool tip to the feed mechanism.
- MECHANICAL PRE FEED:** Shows a 30mm STROKE and a 49mm distance from the tool tip to the feed mechanism.
- AIR FEED:** Shows a 30mm STROKE and a 151mm distance from the tool tip to the feed mechanism.



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 TFCO. TFCO SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION.		DWN 26AUG2011 CHK HUANG		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			
mm		0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME APID 26AUG2011 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151079 RESTRICTED TO	
		MATERIAL FINISH - -		Customer Accessible Production Drawing SCALE 1:2 SHEET A OF A REV C	