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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

2151769-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151769-5

8-2151769-4

2119641-1

1901094-3

-

2119799-1

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151769-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151769-5

8-2151769-4

2119653-1

1901094-3

-

-

-

-

-

-

-

-

-

-

2151769-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

-

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

-

-

-

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-

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-

2151769-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

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2151769-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151769-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.00 mm [.079]

F

INSUL

3.20 mm [1.26]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: MOLEX TERMINAL

MOLEX CRIMP SPECIFICATION

TERMINAL NAME: SABRE 18-20AWG CRIMP FEM W/O TPA

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.96-5.54 mm [.156- .218 IN]

Ø2.54-2.85 mm [.100- .112 IN]

TERMINAL APPLICATION SPECIFICATION

ATS-639012600 Rev B

-

-

-

TERMINALS APPLIED

TE TERMINAL

MOLEX TERMINAL

TE TERMINAL

MOLEX TERMINAL

2113298-1

43374-2001

2113298-2

43375-2001

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING⁹

18 AWG OR 0.80mm2

1.21+/-0.05 [.048+/- .002]

5.5

20 AWG OR 0.50mm2

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

6.1

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: 8-2151769-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151769-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151769-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151769-6

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

13

CUT TO LENGTH AT ASSEMBLY.

*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

A

RELEASED

26NOV2012

RK

TE

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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

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-

1

-

-

-

2119758-1

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

245

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1

1

1

1

1

2119082-8

CAM, SNAIL, INSULATION ADJUSTMENT

244

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1

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1

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1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

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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

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

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-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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1

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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

1

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-

1901094-3

SPACER, FEEDER

198

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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1

-

240638-1

SPRING, FEED FINGER

163

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1

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3-23627-7

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

137

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1

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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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1

1

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1633743-1

SERVO FEED LATCH ASM

133

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1

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1

1

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

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1

455888-6

SPACER, CRIMPER

82

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1

1

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1

1

2119956-1

DOCUMENTATION PACKAGE

71

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1

1

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2119943-1

WASHER, SPACER

69

-

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

66

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1

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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

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1

1

1

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

1

1338685-1

PAWL, FEED

56

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4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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2

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

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1

1

1

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1

5018030-1

NUT, HEX, REG, RoHS, M3

52

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1

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

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1

1

1

1

1

690753-2

SPACER, TONKER

50

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1

2

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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1

2119653-1

FEED CAM, POST FEED

47

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

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1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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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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1

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1

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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1

1

1

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1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

1

1

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1320908-3

SPACER, STRIP GUIDE

30

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1

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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1-455888-0

SPACER, CRIMPER

28

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1

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1

1320928-2

STRIP GUIDE

24

-

1

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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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1

1

1

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3-22280-3

SPRING, COMPRESSION

12

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1

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1-356885-4

STOP, SHEAR

11

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1

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1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

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462006-6

FLOATING SHEAR, FRONT

9

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1

1

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1-1633928-0

ANVIL, COMBINATION

8

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4-240641-1

SPACER

7

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6

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2119757-8

DEPRESSOR, SHEAR

5

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1

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238011-9

BLOCK, CRIMPER SPACER

4

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1

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1-1803016-6

CRIMPER, INSULATION F

3

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1

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455888-6

SPACER, CRIMPER

2

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1

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1

4-1633664-2

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

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DWN
K. HUANG
19SEP2012

CHK
S. XI
19SEP2012

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
-

FINISH
-

DWN
K. HUANG
19SEP2012

CHK
S. XI
19SEP2012

PRODUCT SPEC
-

APPLICATION SPEC
-

SIZE
A

CAGE CODE
00779

DRAWING NO
©=2151769

RESTRICTED TO
-

Customer Accessible Production Drawing

SCALE
1:1

SHEET
1

OF
4

REV
A

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

8

7

6

5

4

3

2

1

AMP 4805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

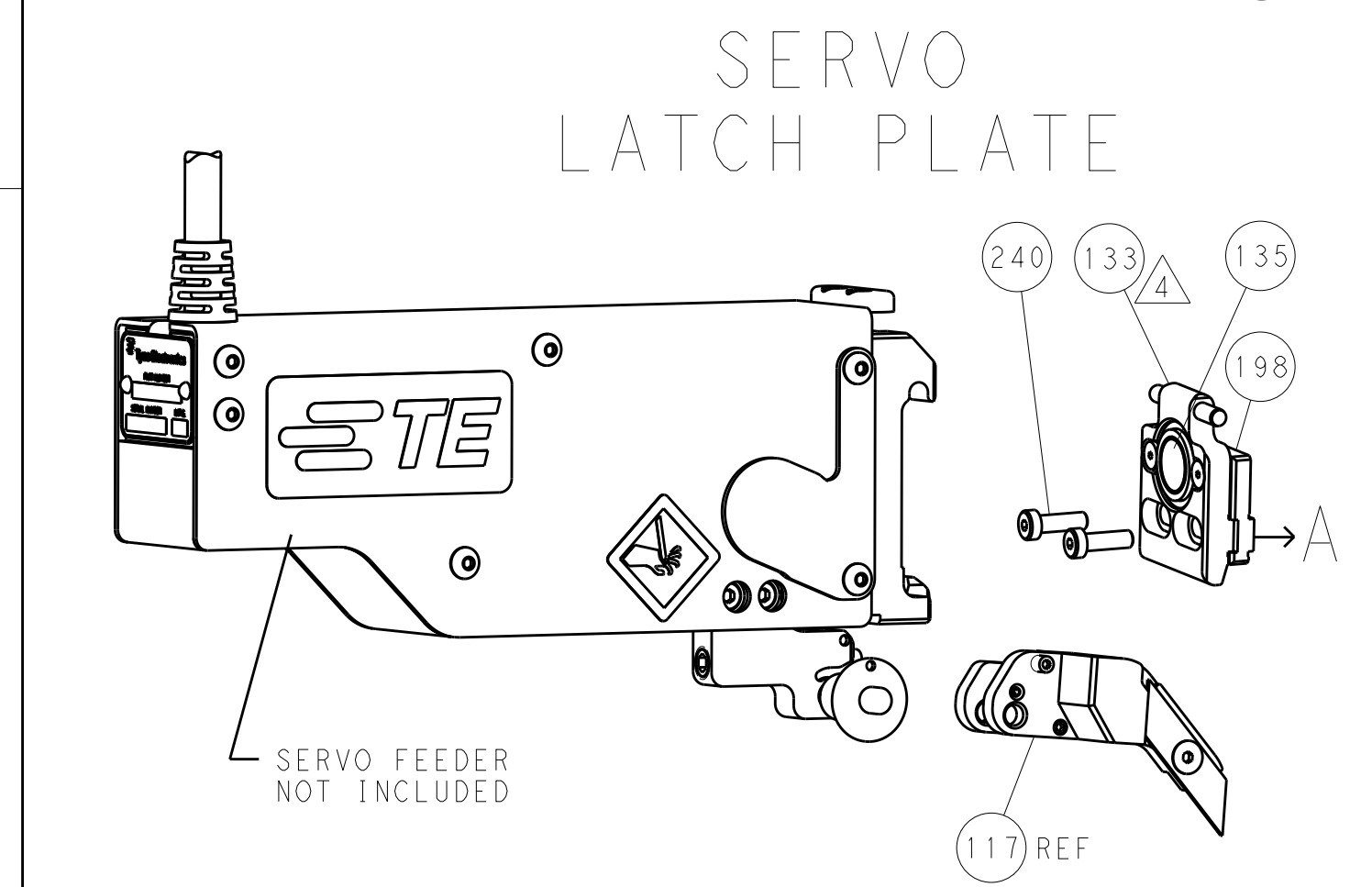
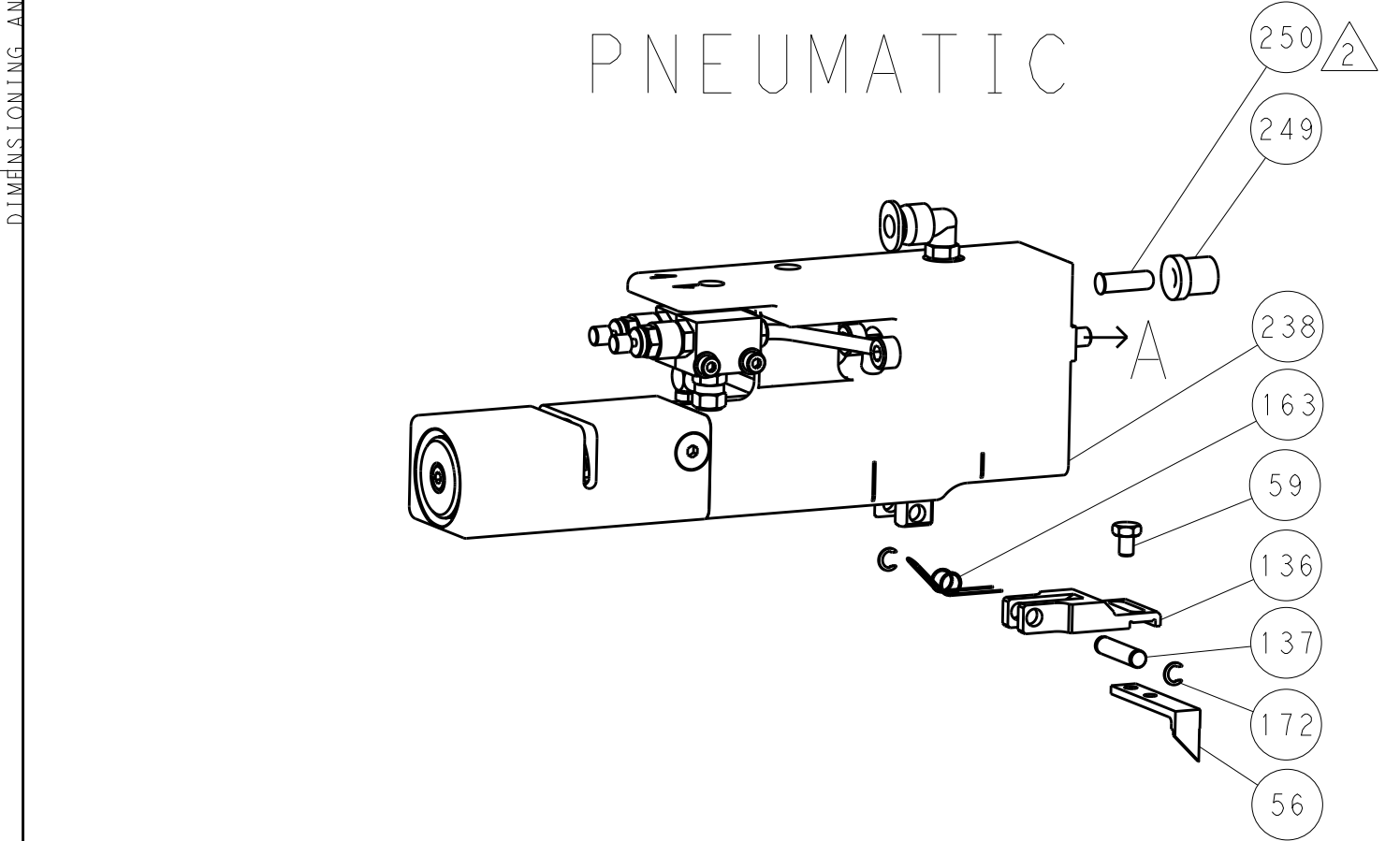
A

B

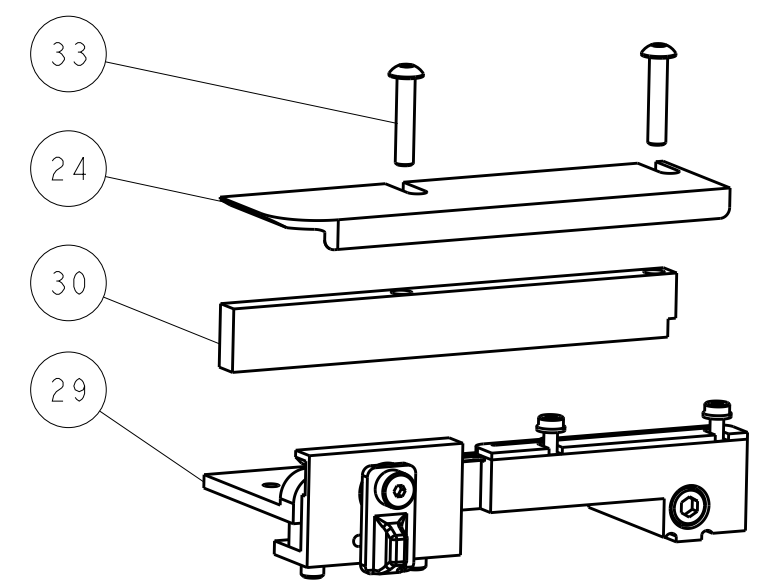
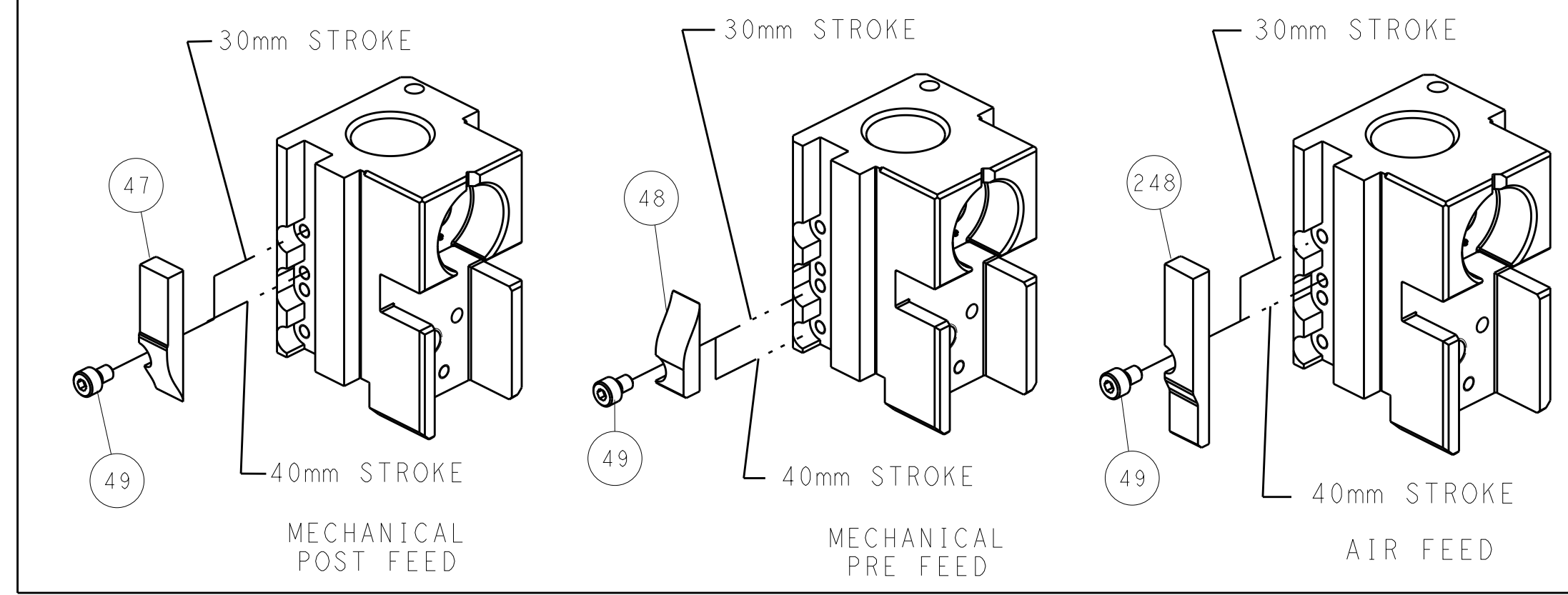
C

D

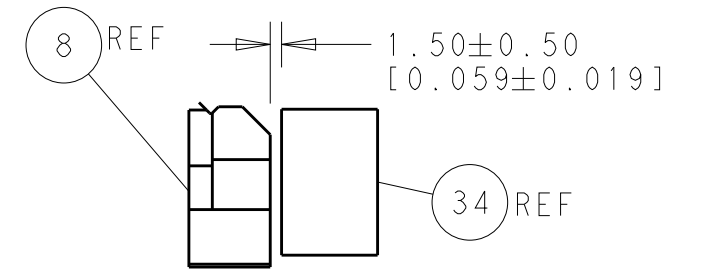
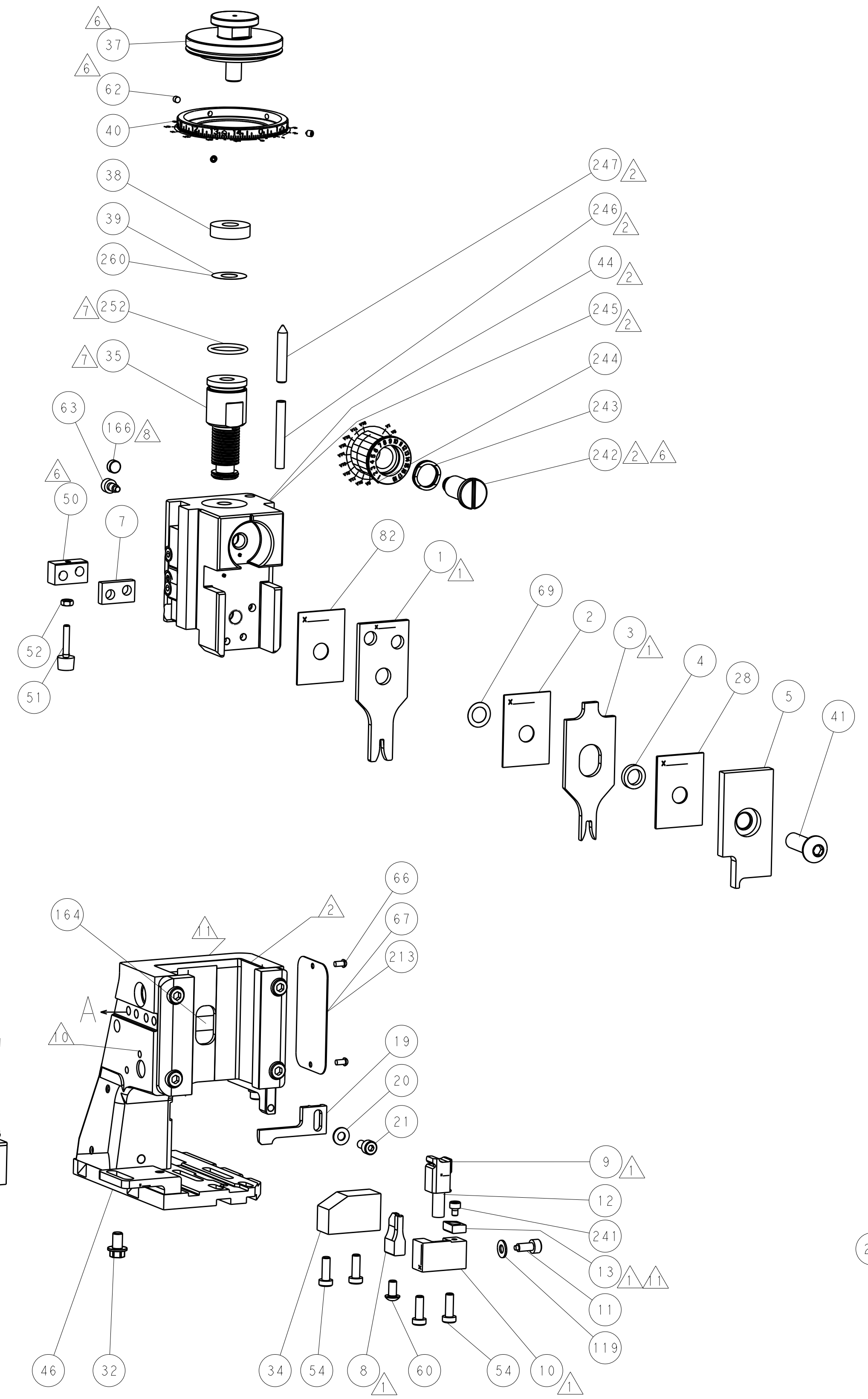
FEED TYPE MECHANICAL



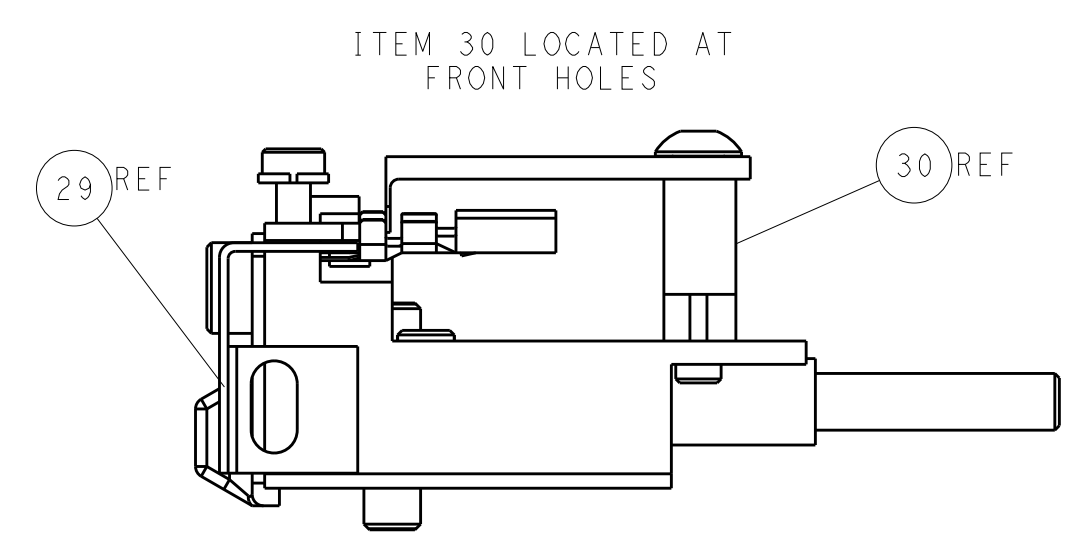
CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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				CHK	K. HUANG		
				APVD	S. XI		
				APVD	S. XI		
				PRODUCT SPEC		NAME	
				APPLICATION SPEC		Ocean Side Feed Applicator	
				WEIGHT		SIZE	
				Customer Accessible Production Drawing		A1 00779 C=2151769	
				SCALE		SHEET	
				1:1		2 of 4	
						REV	
						A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

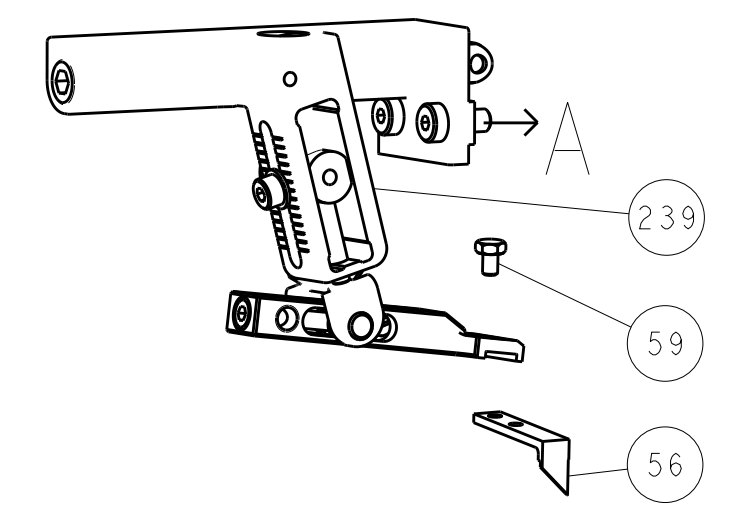
A

B

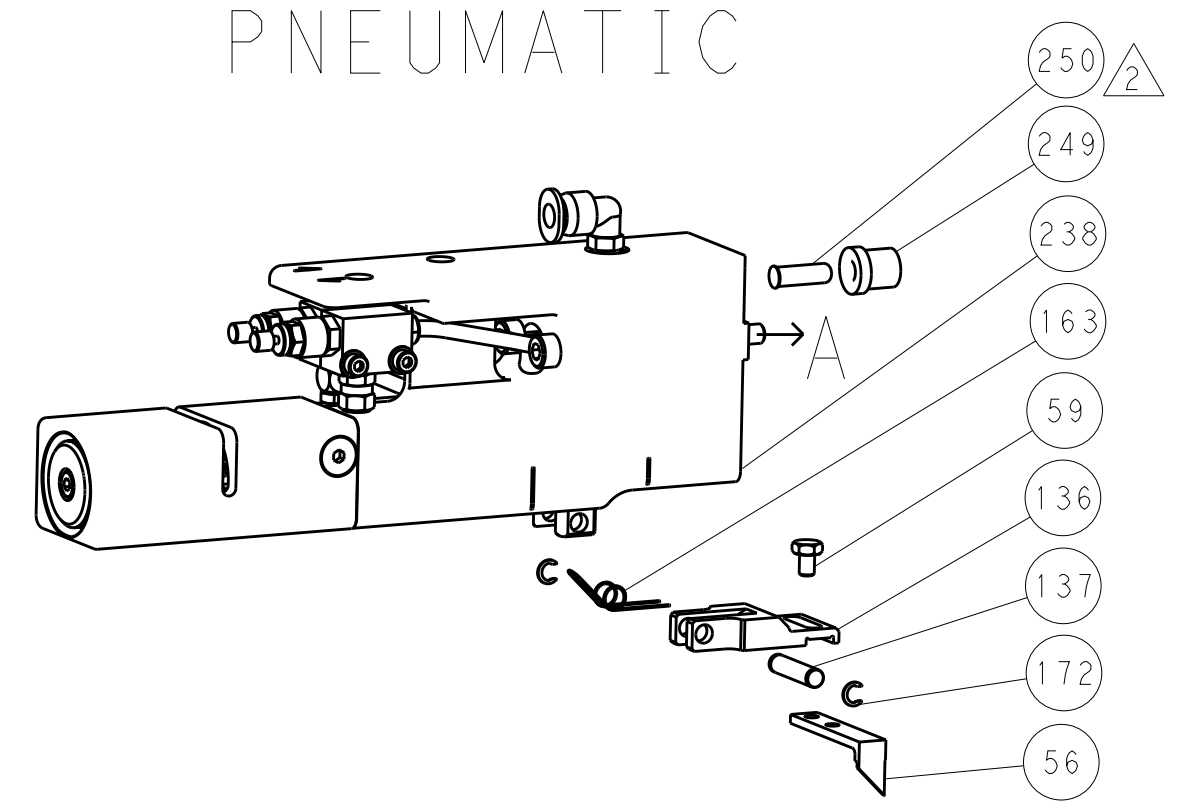
C

D

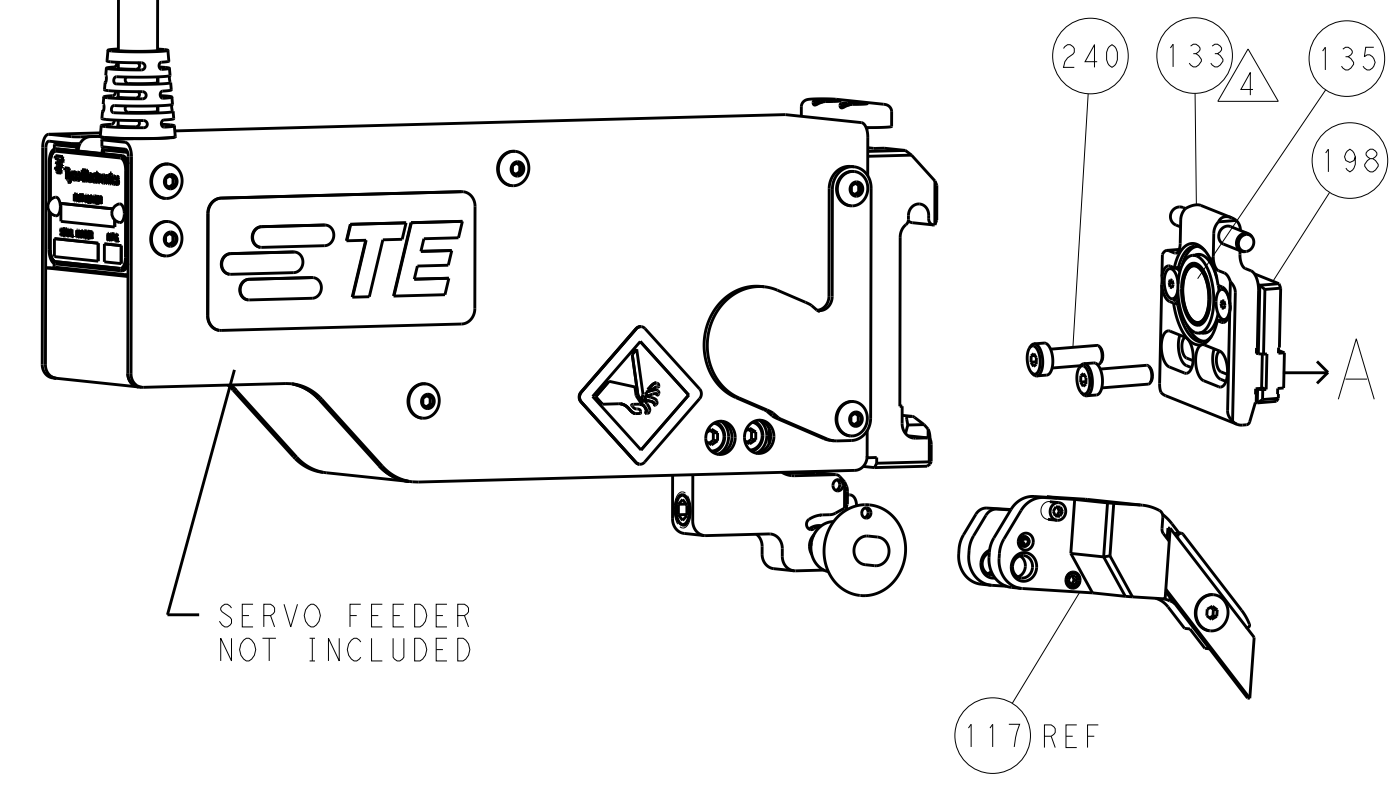
FEED TYPE MECHANICAL



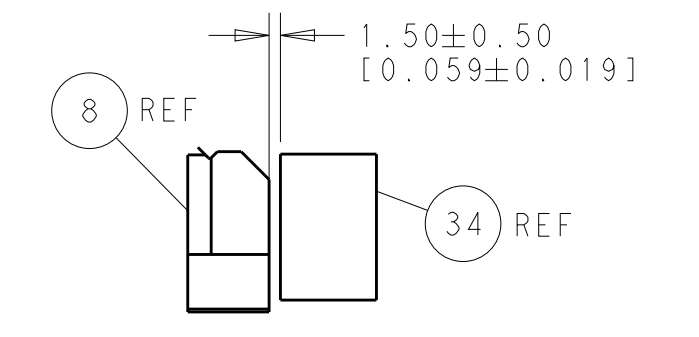
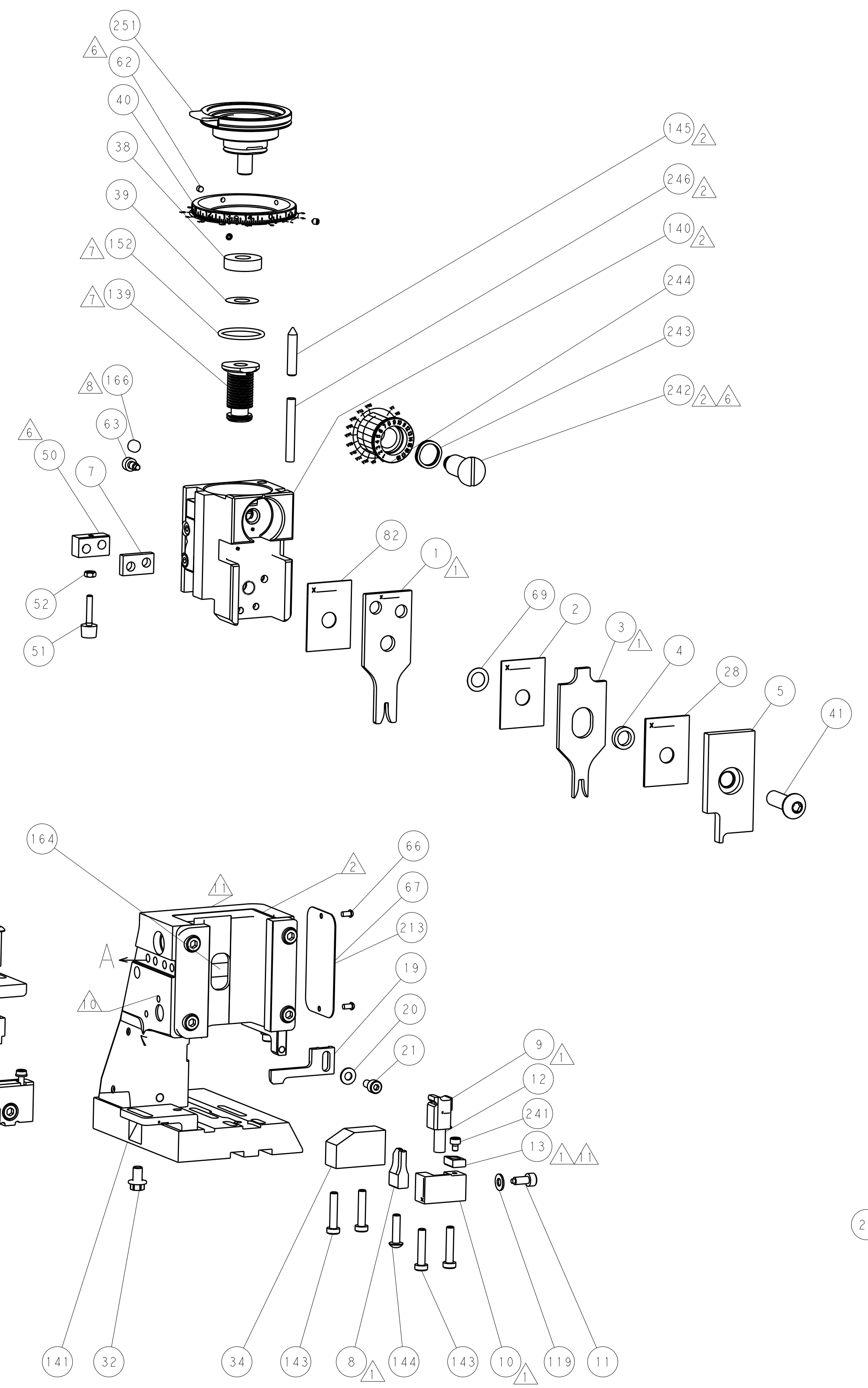
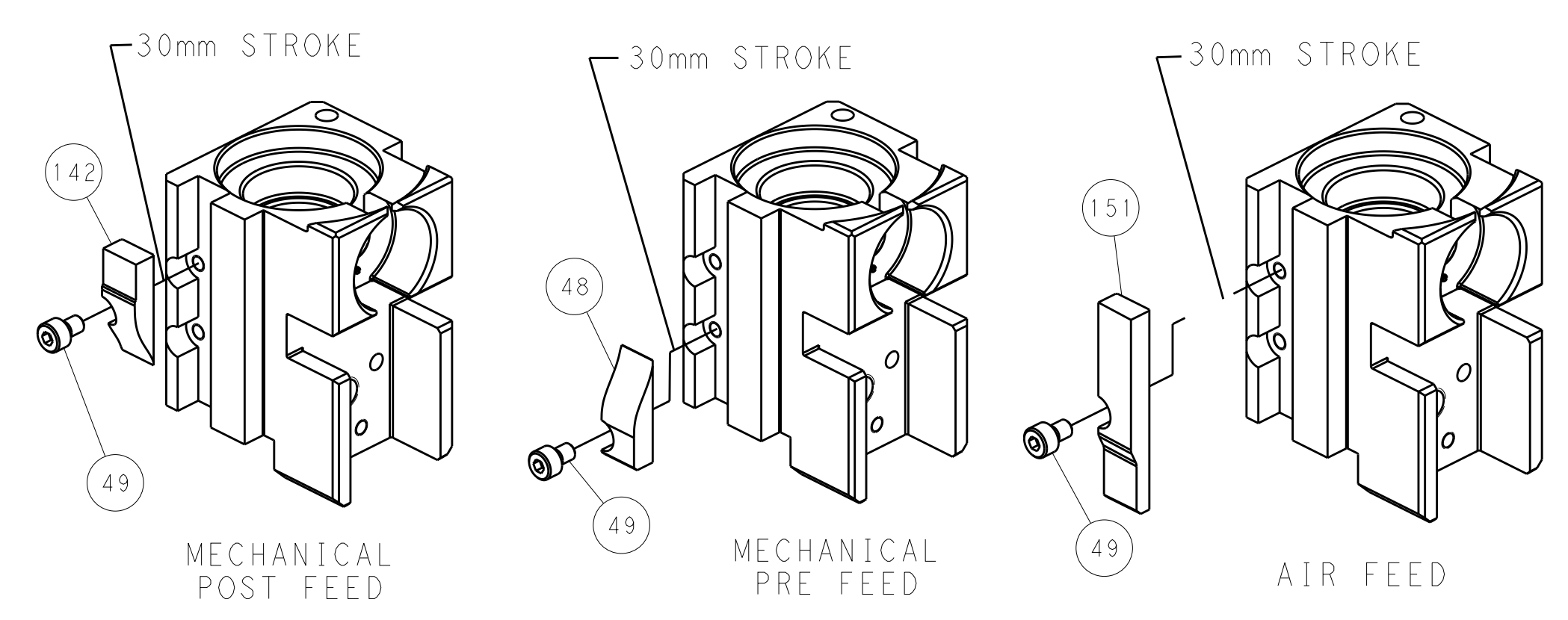
PNEUMATIC



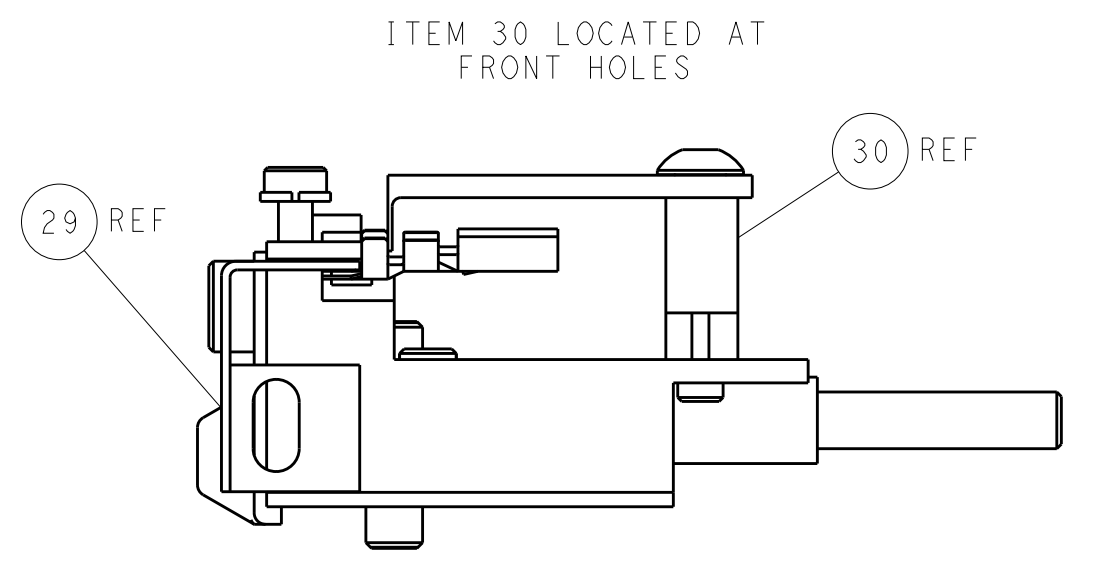
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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 UNPUBLISHED. BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		LOC A		DIST 66		REV S. XI		DATE 19SEP2012		NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		0 PLC ±0.1		1 PLC ±0.02		2 PLC ±0.02		3 PLC ±0.005	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
Customer Accessible Production Drawing		1:1		4		4		A		-	