

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

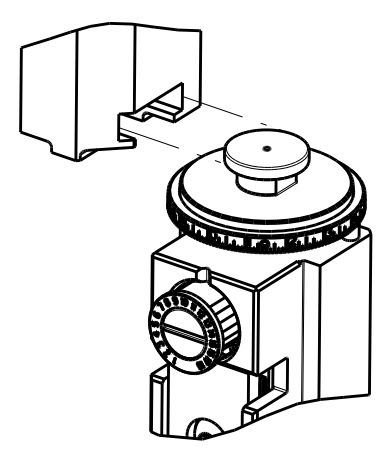
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151638-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

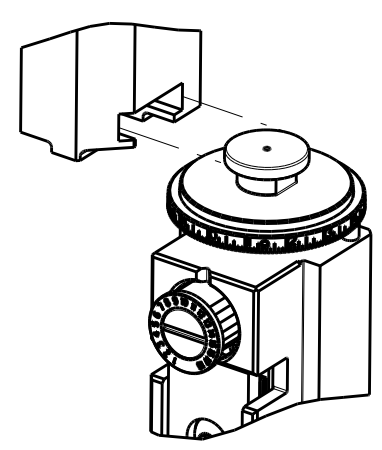
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2151638-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

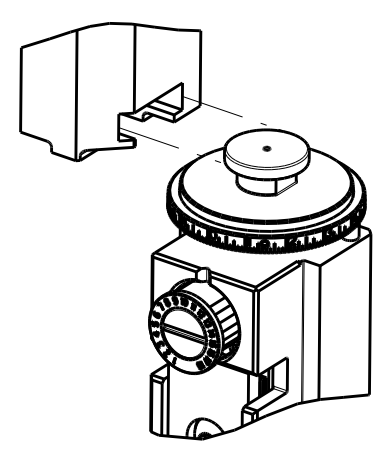
-

8-2151638-5

1901094-3

-

2168400-6 (QUANTITY 2)



2151638-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

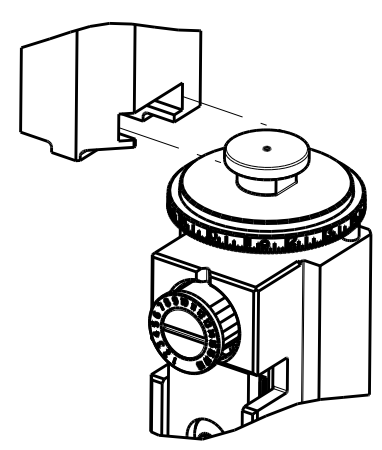
1338685-1

5-18022-5

2119653-1

-

-



2151638-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

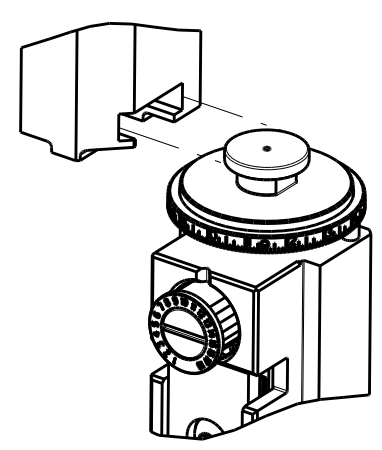
2161326-1

-

8-2151638-4

-

-



2151638-7

A

FINE CRIMP HEIGHT ADJUST

NONE

2119950-1

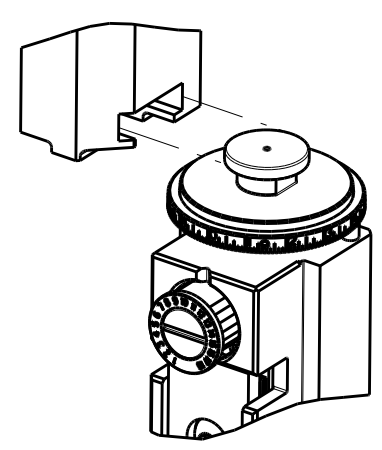
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



7-2151638-7

A

CRIMP TOOLING KIT

-

-

-

-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [1.00]

F

INSUL

3.05 mm [1.20]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: STOCKO TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.35-5.15 mm [1.71-.203 IN]

Ø0.00-2.44 mm [0.00-.096 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

TE TERMINAL

STOCKO TERMINAL

TE TERMINAL

STOCKO TERMINAL

2113264-1

RSB 8056 F 6.3-1.5

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

14 AWG

1.67+/-0.05 [1.066+/-0.002]

7.4

16 AWG

1.46+/-0.05 [1.057+/-0.002]

9.5

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151638-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151638-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151638-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151638-6

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

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.

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

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

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.

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

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.

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

CUT TO LENGTH AT ASSEMBLY.

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

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

29JUN2012

RK

GB

-

-

-

-

1

-

2119641-1

FEED CAM, AIR FEED

248

-

1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

-

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

-

2

2

2

2

2

18023-1

SCR, SKT HD CAP M3 X 5.0

241

-

-

2

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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-

-

-

1

2063440-1

AIR FEED MODULE

238

-

1

1

1

1

1

356885-4

STOP, SHEAR

237

-

-

1

1

-

-

2119740-2

TAG, IDENTIFICATION

213

-

-

1

1

-

-

1901094-3

SPACER, FEEDER

198

-

-

-

-

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

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-

-

-

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

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1

1

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1633743-1

SERVO FEED LATCH ASM

133

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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

455888-6

SPACER, CRIMPER

82

-

1

1

1

1

1

2-240641-6

SPACER

81

-

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

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

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3

3

3

992763-5

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

62

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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

-

2

2

2

2

2

1-2168083-2

SCR, SKT HD CAP, RoHS, M4 X 25

53

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-

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-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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-

-

1

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2119652-1

FEED CAM, PRE FEED

48

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-

-

-

1

2119653-1

FEED CAM, POST FEED

47

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1

1

1

1

1

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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1

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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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

-

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

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1

1-1320908-0

SPACER, STRIP GUIDE

30

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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455888-4

SPACER, CRIMPER

28

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1

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1320928-2

STRIP GUIDE

24

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1

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1

1

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1

1-18028-2

WASHER, FLAT, REG M4

20

-

1

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1

1

1

2119533-1

STRIPPER, SIDE FEED

19

-

1

1

1

1

1

690463-1

FLOATING SHEAR, REAR

17

-

2

2

2

2

2

1-2168083-1

SCR, SKT HD CAP, RoHS, M3 X 6

16

-

1

1

1

1

1

690464-1

SHEAR PLATE, REAR

15

-

1

1

1

1

1

2119862-1

SHEAR HOLDER, REAR

14

-

2

2

2

2

2

2119806-1

INSERT, SHEAR

13

-

2

2

2

2

2

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

454276-5

FLOATING SHEAR, FRONT

9

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1

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1633922-6

ANVIL, COMBINATION

8

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7

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690468-6

DEPRESSOR SHEAR, REAR

6

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1

1

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

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1

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1

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2-238011-1

BLOCK, CRIMPER SPACER

4

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1-1633961-9

CRIMPER, INSULATION F PREMIUM

3

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1

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1

455888-5

SPACER, CRIMPER

2

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1

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1

456407-4

CRIMPER, WIRE PREMIUM

1

AMP 4805 REV 31MAR2000

8

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1

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISION ONLY. IF A REVISION IS REQUIRED, THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.

DWN

R. KNEPPER

20APR2012

CHK

T. ELBIN

20APR2012

APVD

M. CLIFFORD

20APR2012

DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC

±.0

1 PLC

±0.1

2 PLC

±0.02

3 PLC

±0.005

4 PLC

±0.0005

ANGLES

±.0

FINISH

-.0

MATERIAL

-.0

PRODUCT SPEC

-.0

APPLICATION SPEC

-.0

WEIGHT

-.0

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2151638

RESTRICTED TO

-.0

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

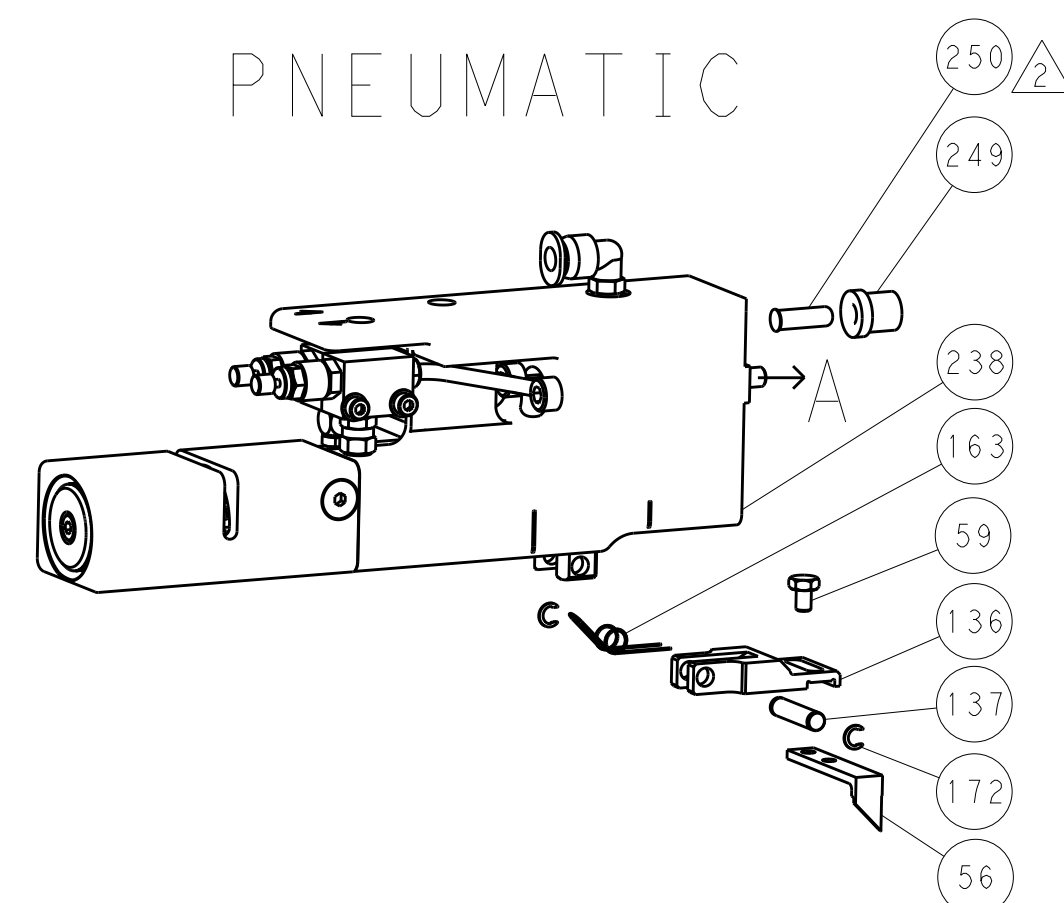
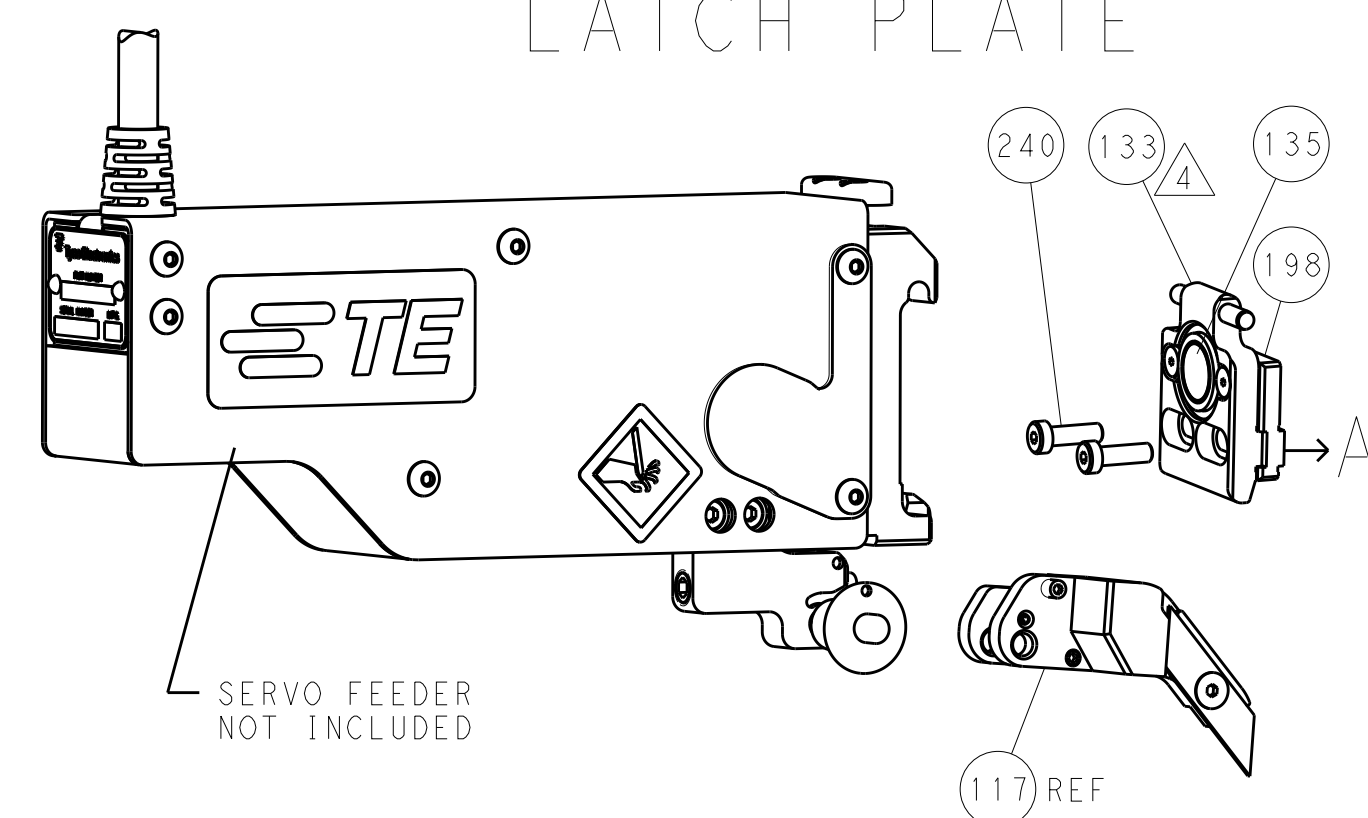
4

REV

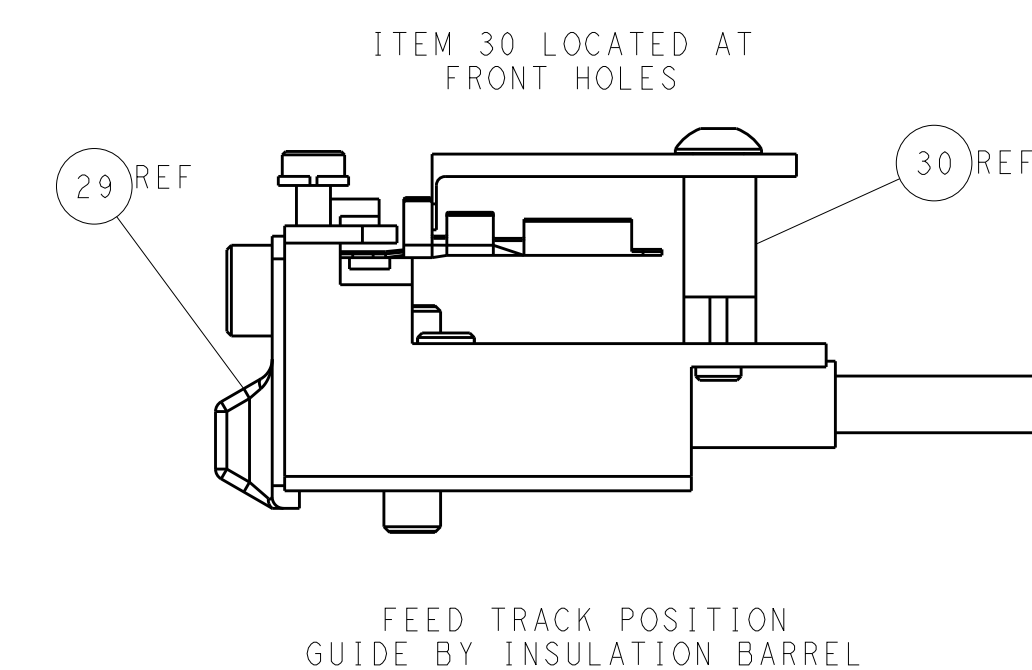
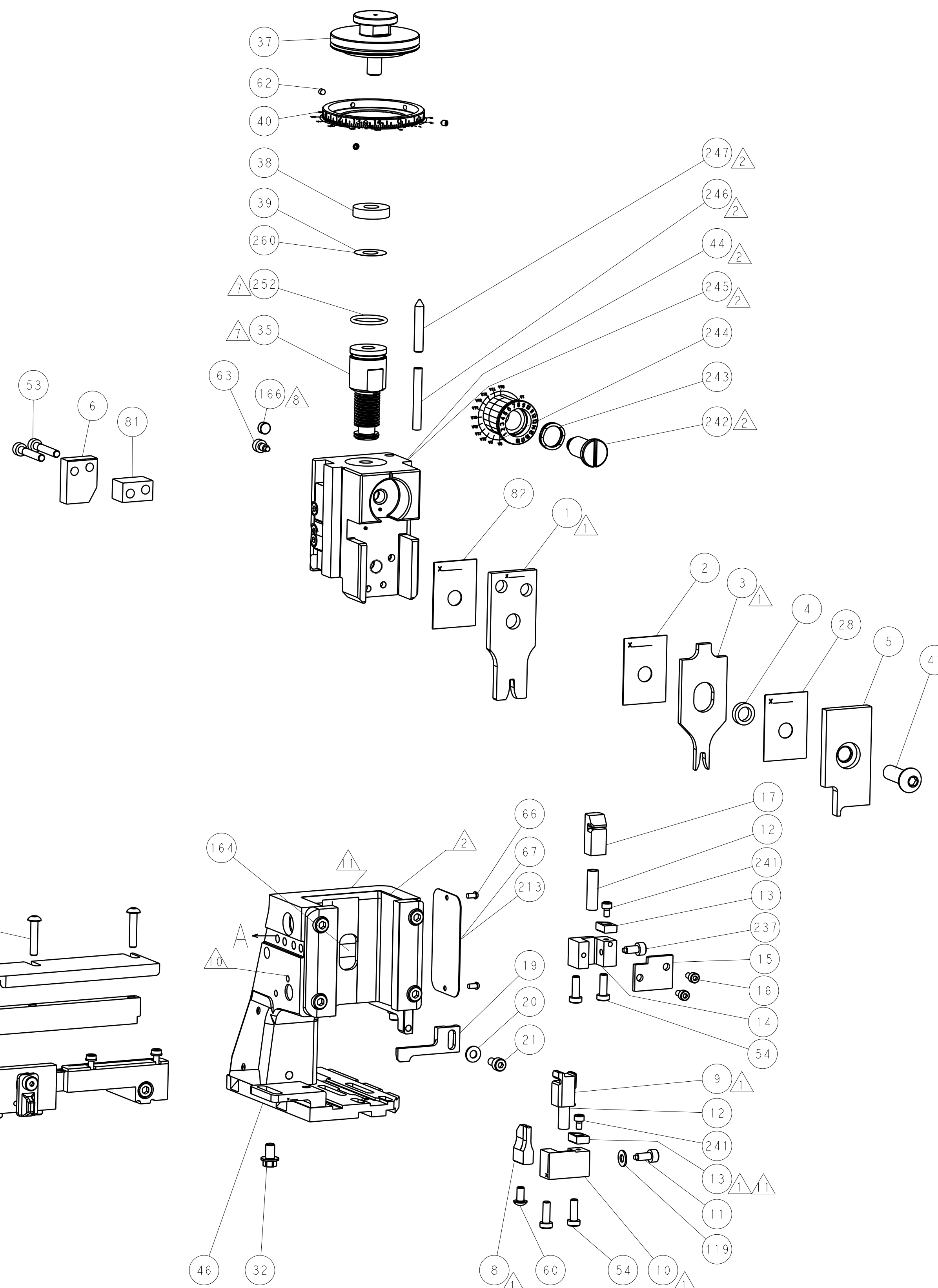
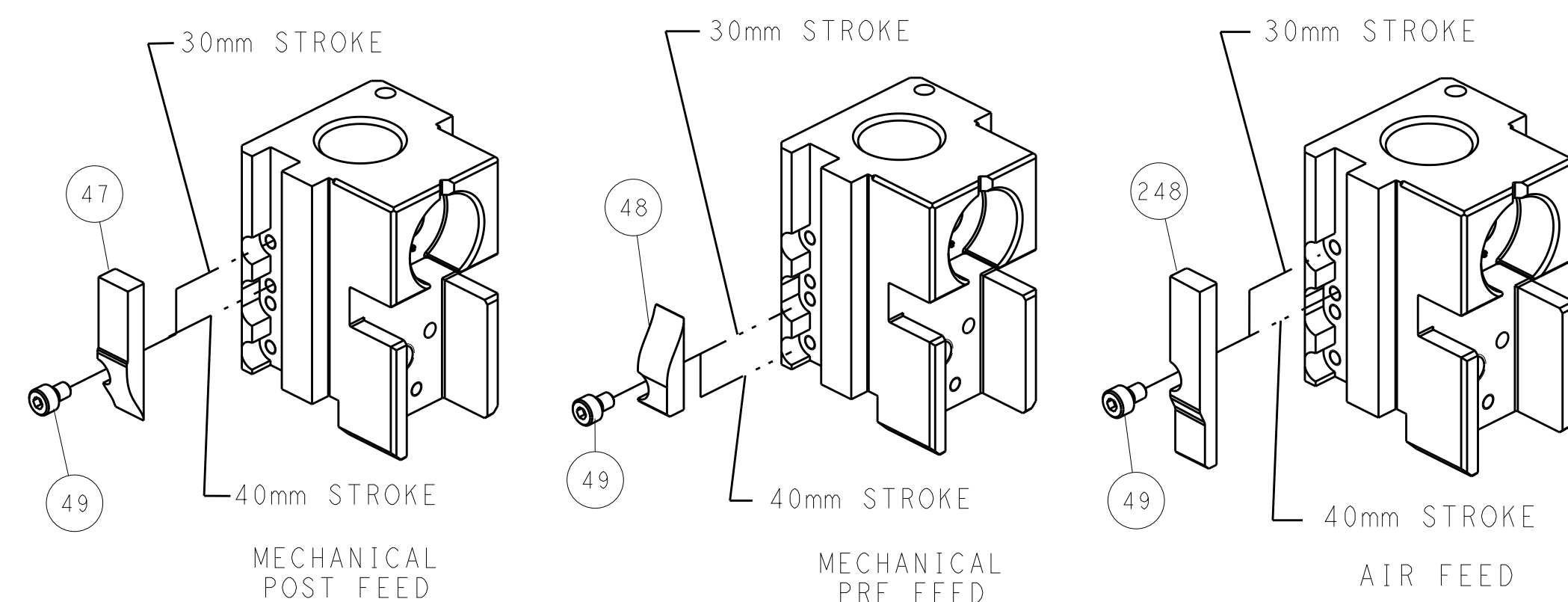
A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



ATLANTIC VERSION

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

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISIONS.		DWN KNEPPER 20APR2012 CHK ELBIN 20APR2012		 TE Connectivity Harrisburg, PA 17105-3608	
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		NAME APVD M. CLIFFORD 20APR2012 PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL -		FINISH -		SIZE A1	
		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C=2151638	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

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

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

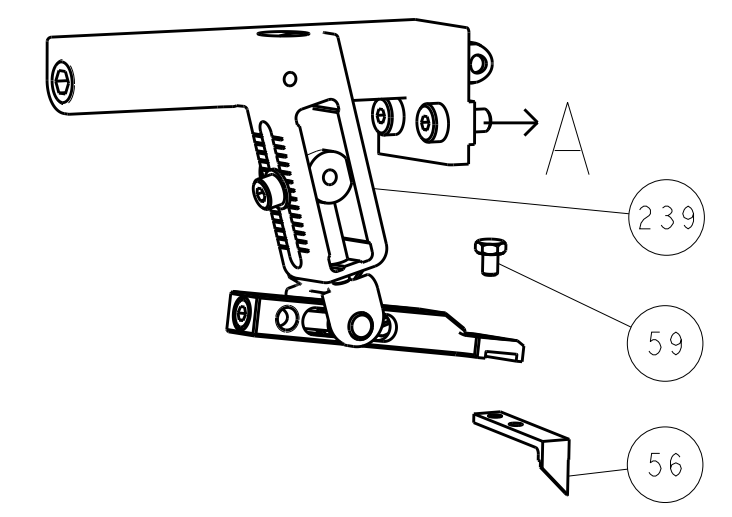
D

C

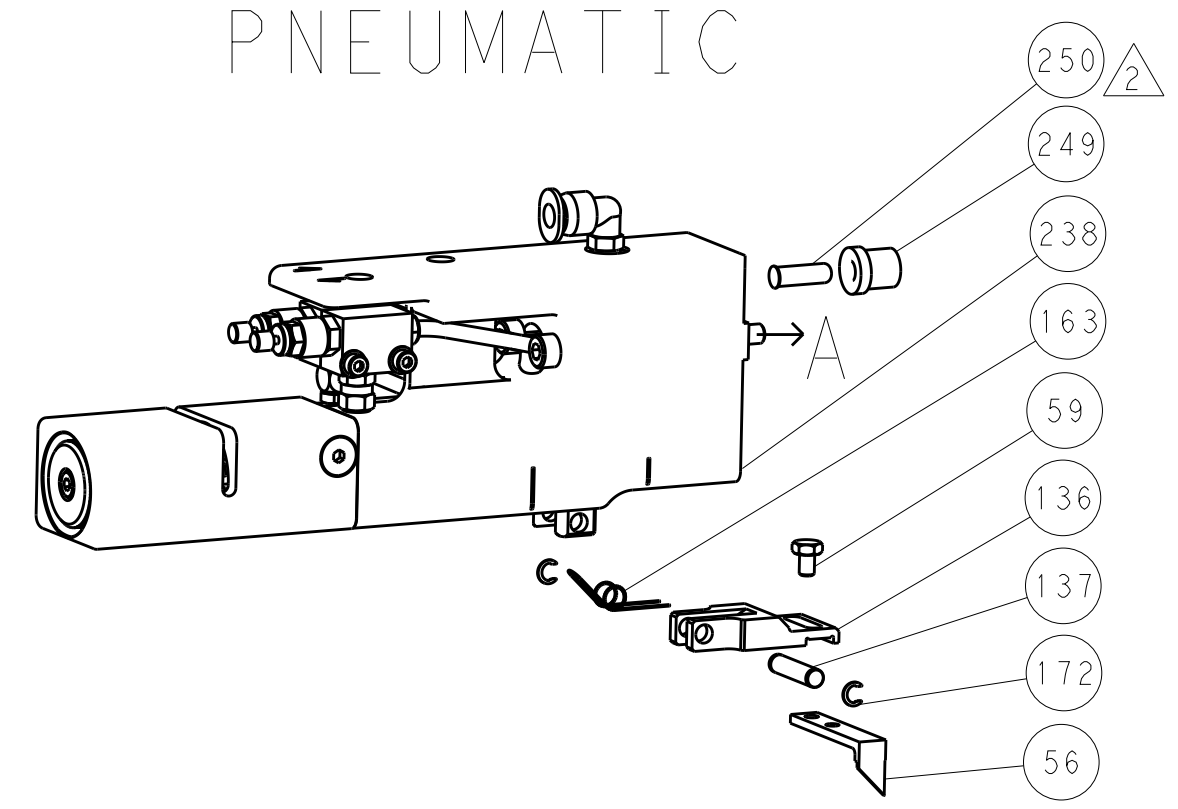
B

A

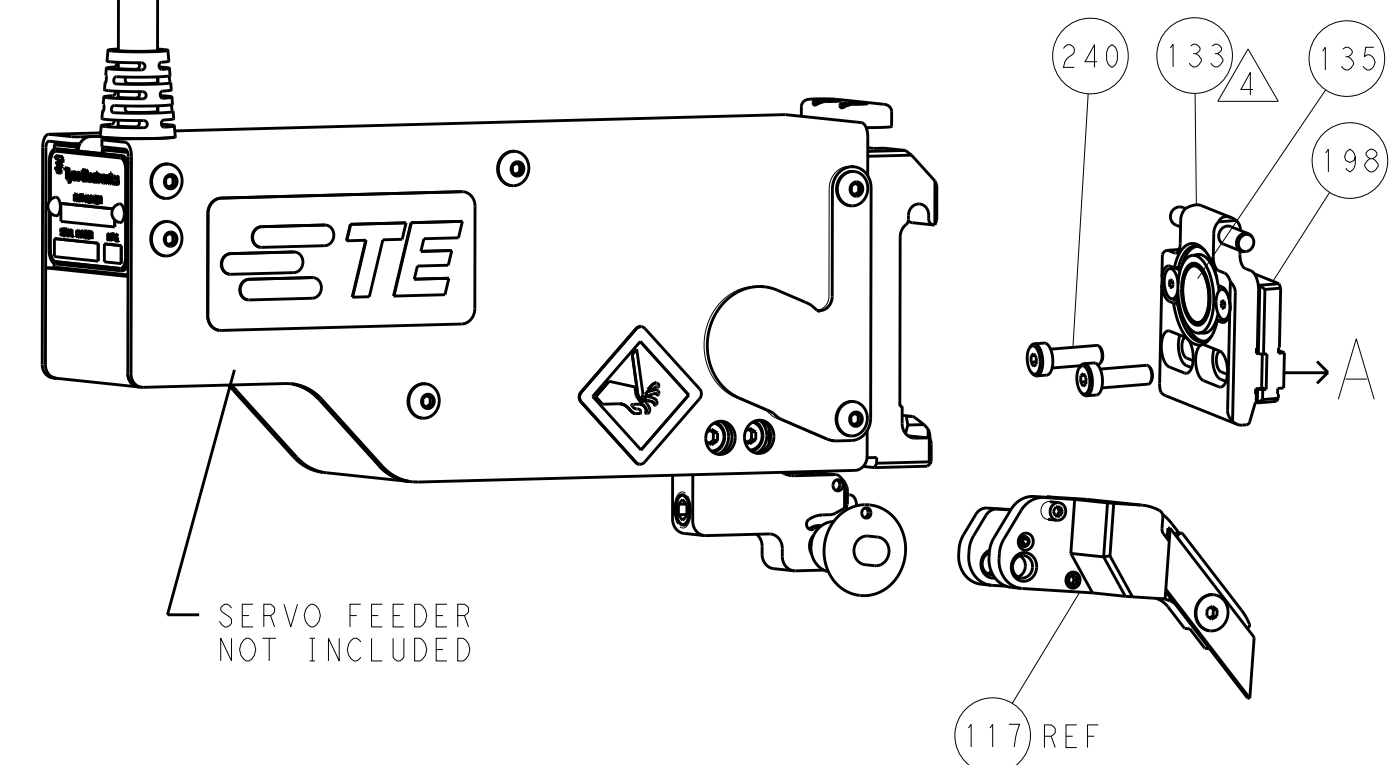
FEED TYPE MECHANICAL



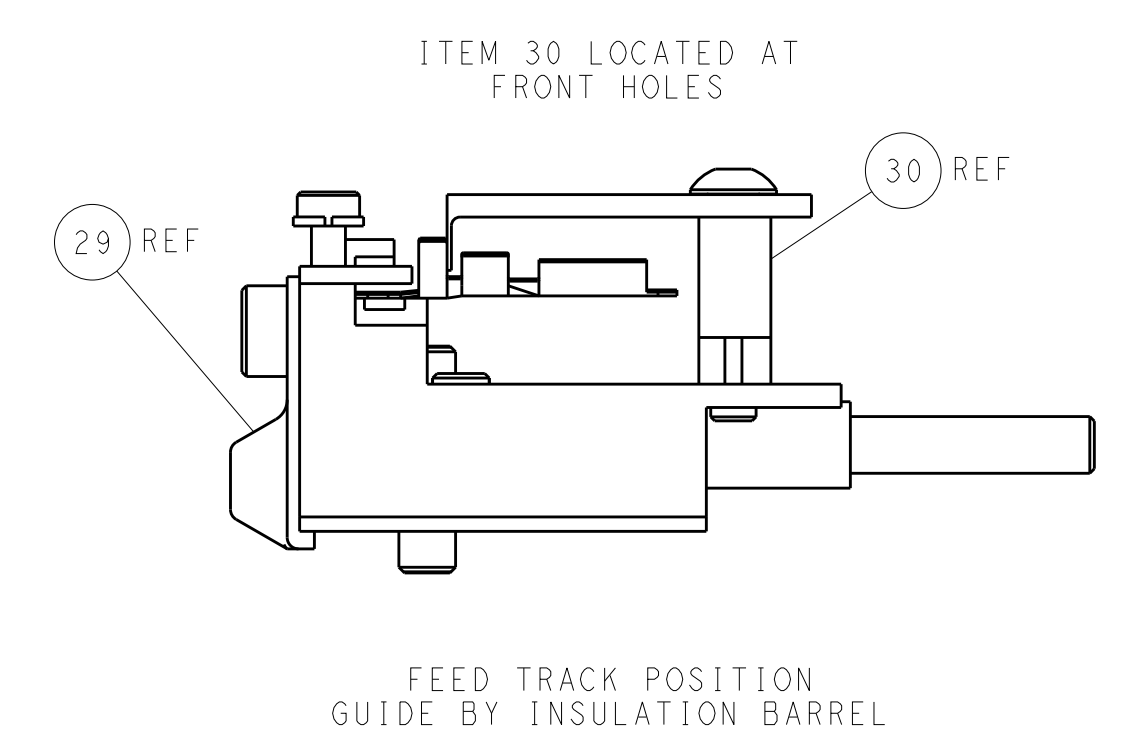
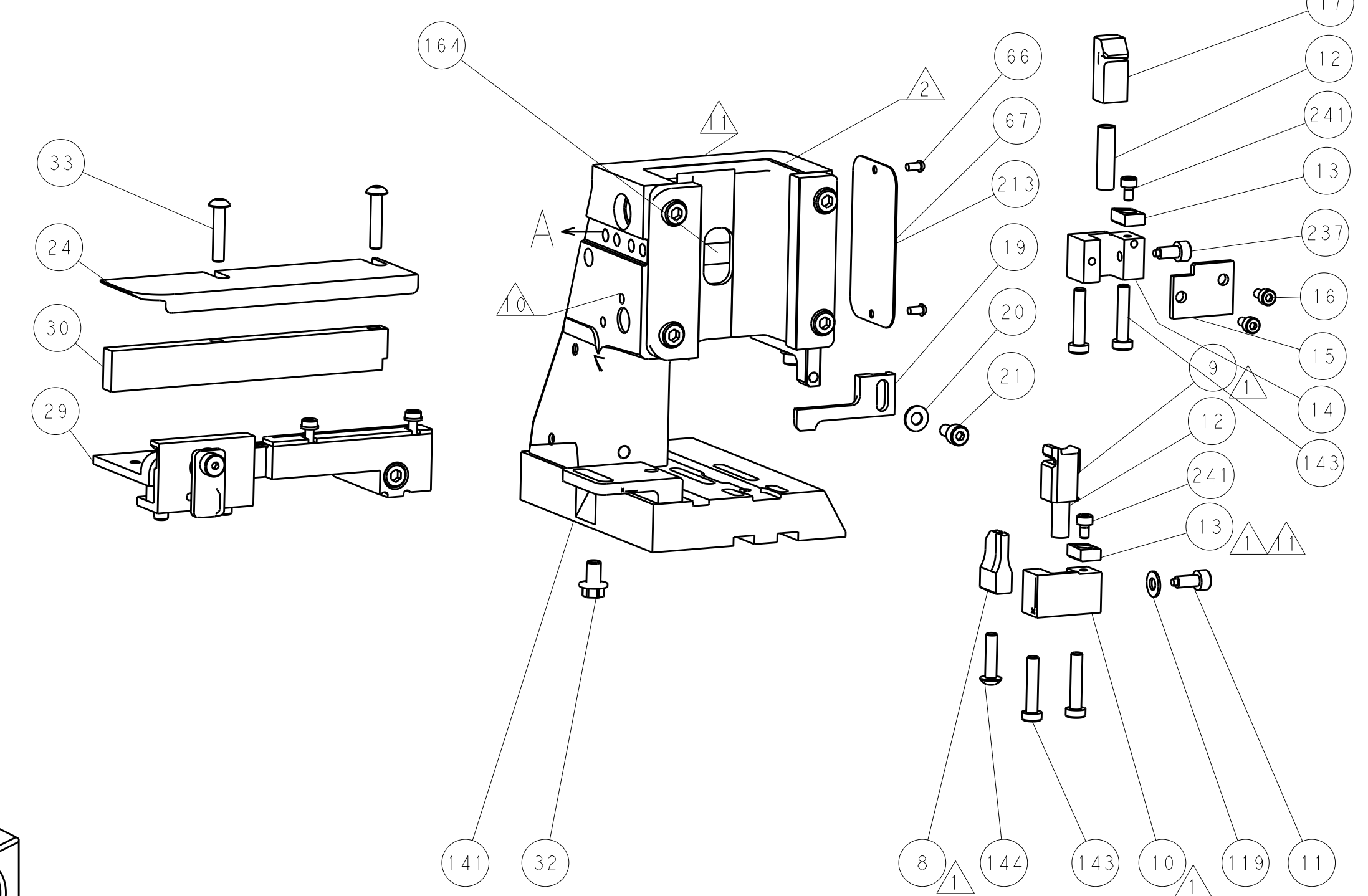
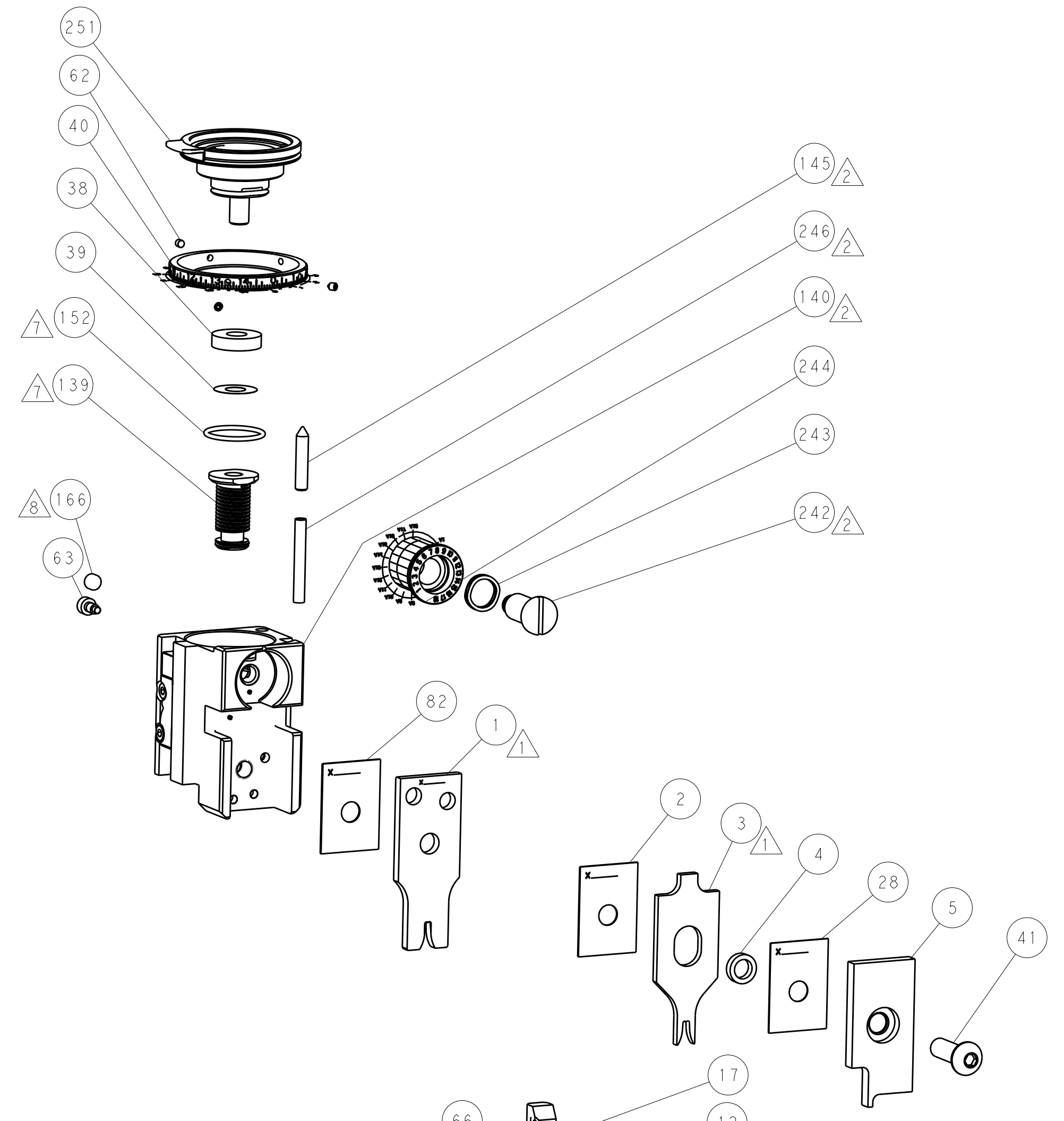
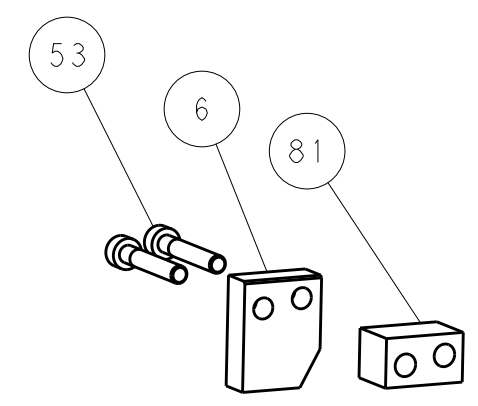
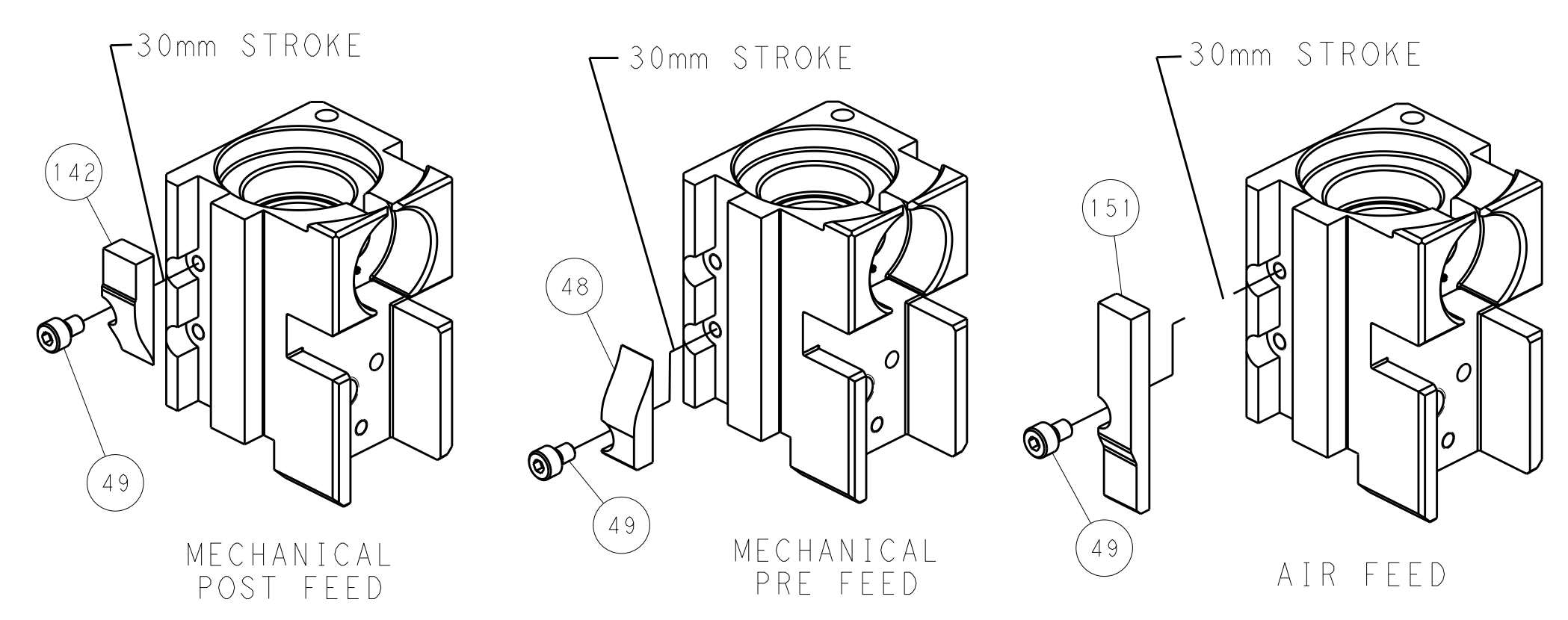
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST REVISION.		OWN R. KNEPPER 20APR2012	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK T. ELBIN 20APR2012	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.02 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES ±.1		APVD W. CLIFFORD 20APR2012	CAGE CODE 00779
MATERIAL -		PRODUCT SPEC -	DRAWING NO C=2151638
WEIGHT -		APPLICATION SPEC -	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:1	SHEET 4 OF 4
		REV A	