

8

7

6

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4

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2

1

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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2151886-1

1

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151886-5

8-2151886-4

2119641-1

1901094-3

-

2119799-1

2-1752354-4

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151886-2

1

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151886-5

8-2151886-4

2119653-1

1901094-3

-

-

2-1752354-4

-

-

2168400-6 (QUANTITY 2)

-

2151886-5

1

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

1338685-1

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

-

-

2119799-1

2063440-1

2151886-6

1

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

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2151886-7

1

FINE CRIMP HEIGHT ADJUST

NONE

-

-

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7-2151886-7

1

CRIMP TOOLING KIT

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.78 mm [.070]

F

INSUL

2.28 mm [.090]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: MOLEX TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: STRAIGHT FORK TERMINAL 0.8mm

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.55-3.56 mm [.140-.140 IN]

Ø1.20-1.70 mm [.047-.067 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

TE TERMINAL

MOLEX TERMINAL

TE TERMINAL

MOLEX TERMINAL

0

94509-0103

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.50mm2

0.91+/-0.05 [.036+/- .002]

1

0.35mm2

0.85+/-0.05 [.033+/- .002]

2

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: 8-2151886-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151886-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151886-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151886-6

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 62, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.89.

*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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1

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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

-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

1

ORIGINAL

25FEB2013

S. A.

C. L.

-

-

-

-

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

-

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

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2063440-1

AIR FEED MODULE

238

-

-

1

1

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-

2119740-2

TAG, IDENTIFICATION

213

-

-

1

1

-

-

1901094-3

SPACER, FEEDER

198

-

1

1

1

1

1

2-1752354-4

STANDOFF, HOLD-DOWN

180

-

1

1

1

1

1

6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

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

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

1901681-1

HOLDDOWN, TERMINAL

51

-

-

-

-

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

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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

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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

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1

1

2119644-1

RAM WASHER, PRECISION

38

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1

1

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1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

1

1

2119092-1

BOLT, ADJUSTMENT

35

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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

1320908-3

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-2

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

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

1

2119805-1

SHEAR HOLDER, FRONT

10

1

1

1

1

1

1

454276-5

FLOATING SHEAR, FRONT

9

1

1

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1

1

1

1803057-7

ANVIL, COMBINATION

8

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7

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6

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1

1

1

1

1

2119757-4

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

238011-4

BLOCK, CRIMPER SPACER

4

1

1

1

1

1

1

1633965-4

CRIMPER, INSULATION O PREMIUM

3

-

1

1

1

1

1

455888-4

SPACER, CRIMPER

2

1

1

1

1

1

1

3-456404-6

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

TE Connectivity

Harrisburg, PA 17105-3608

PRELIMINARY

Ocean Side Feed Applicator

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

FINISH

MATERIAL

-

CS ALVES

25FEB2013

CHK P. BARLETTA

25FEB2013

APVD C. TMA

25FEB2013

NAME

PRODUCT SPEC

APPLICATION SPEC

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

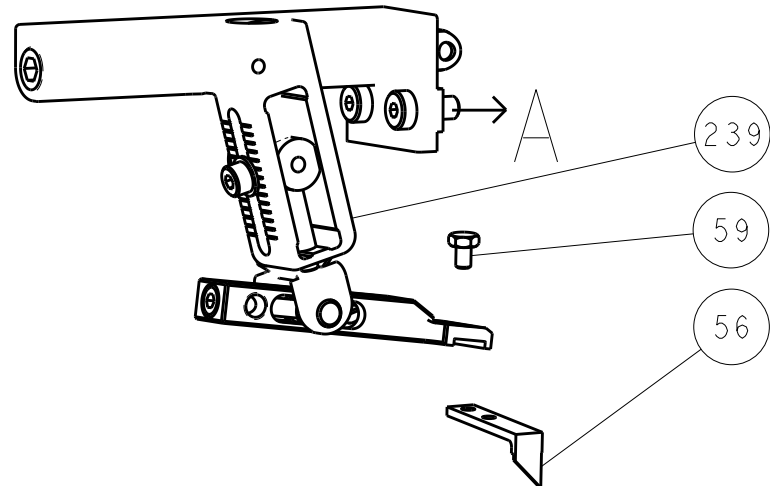
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AMP 4805 REV 31MAR2000

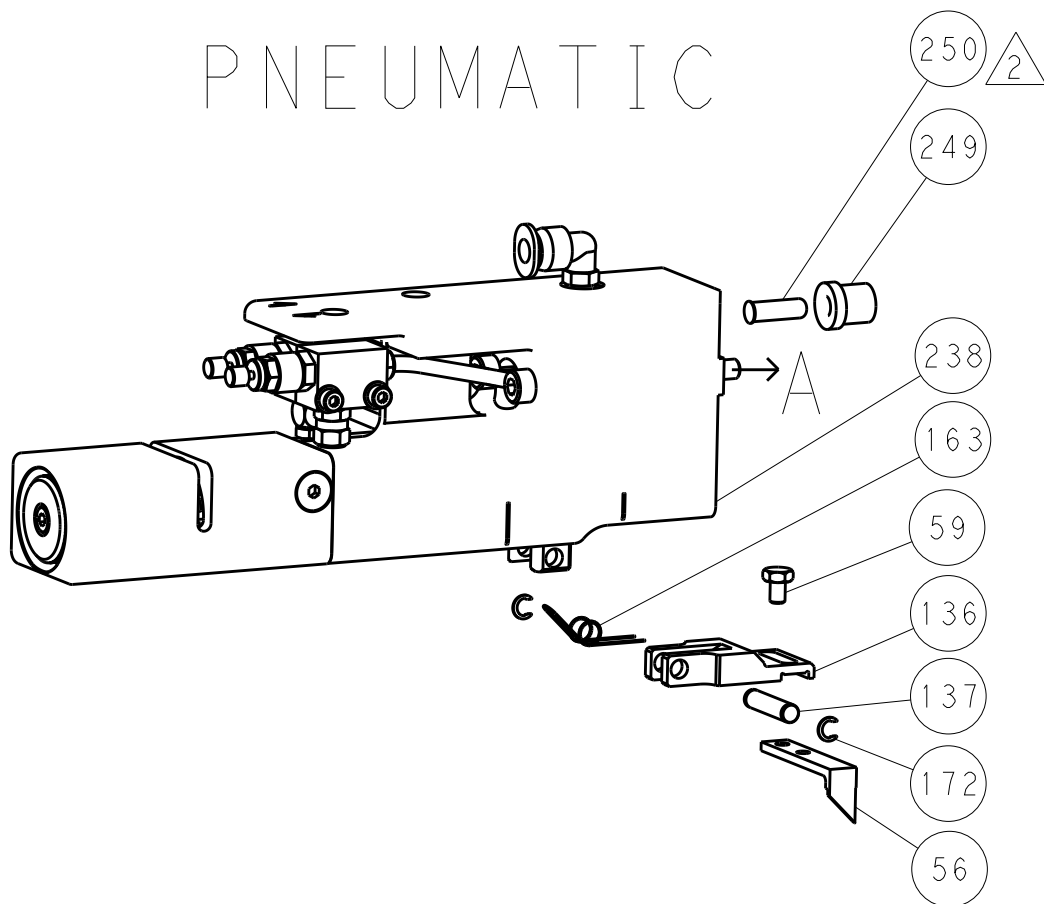
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

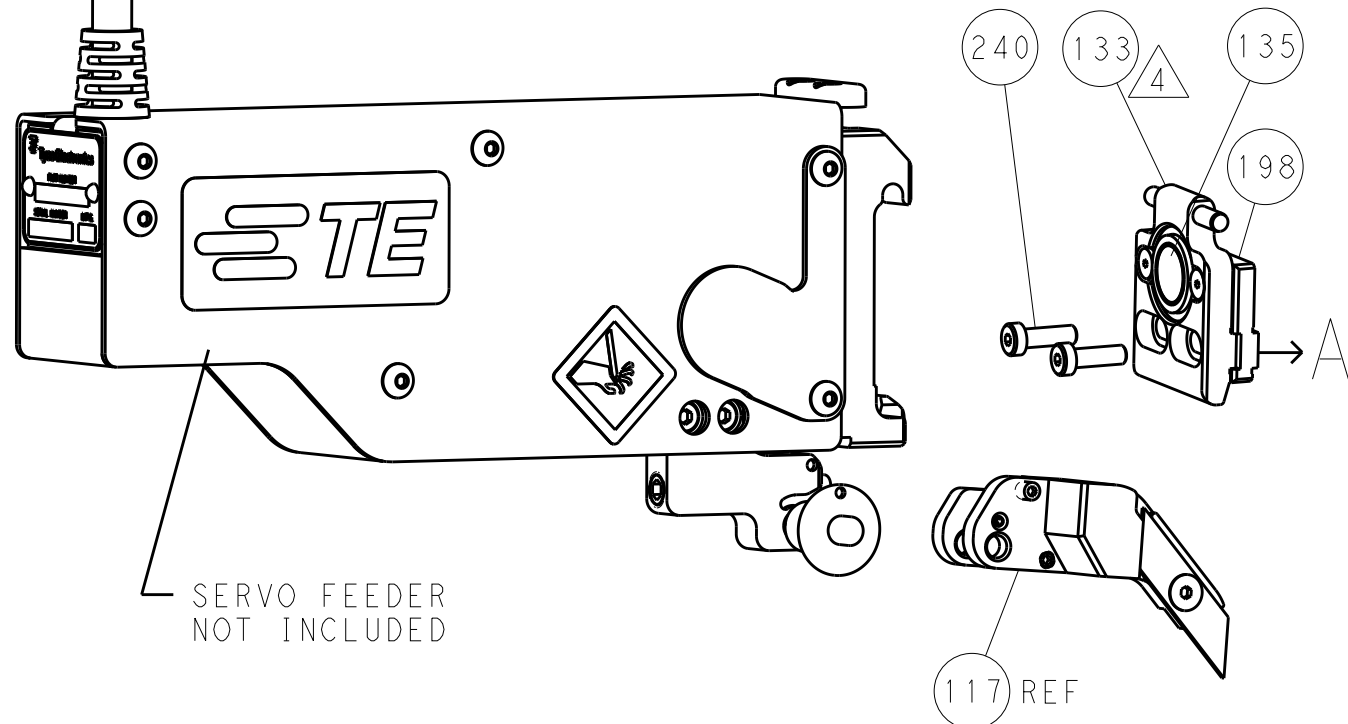
FEED TYPE MECHANICAL



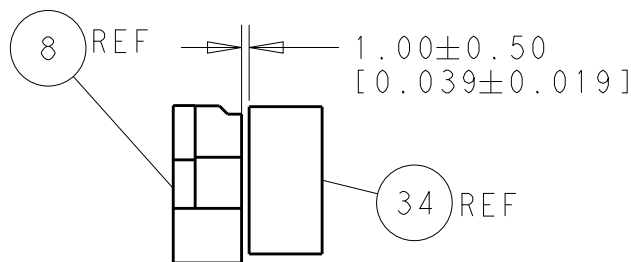
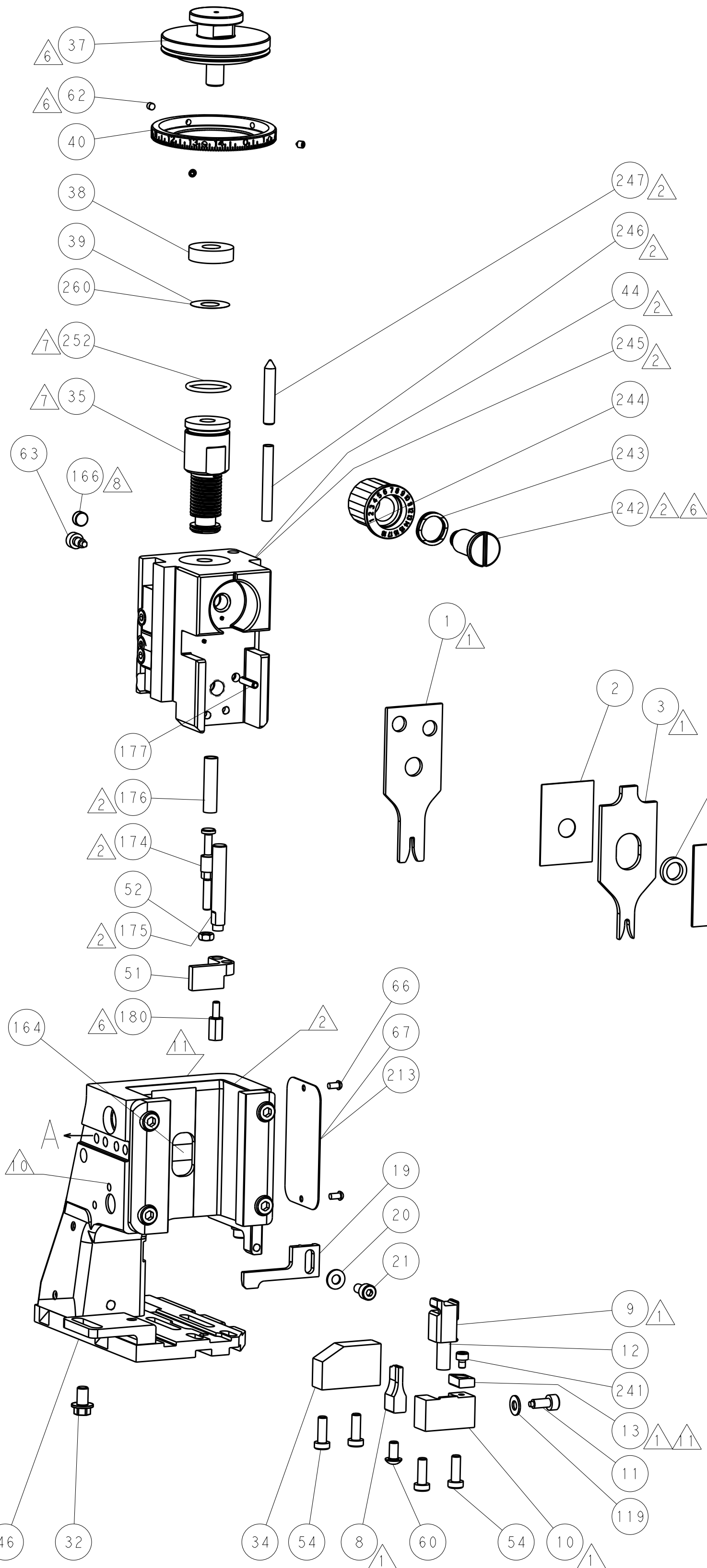
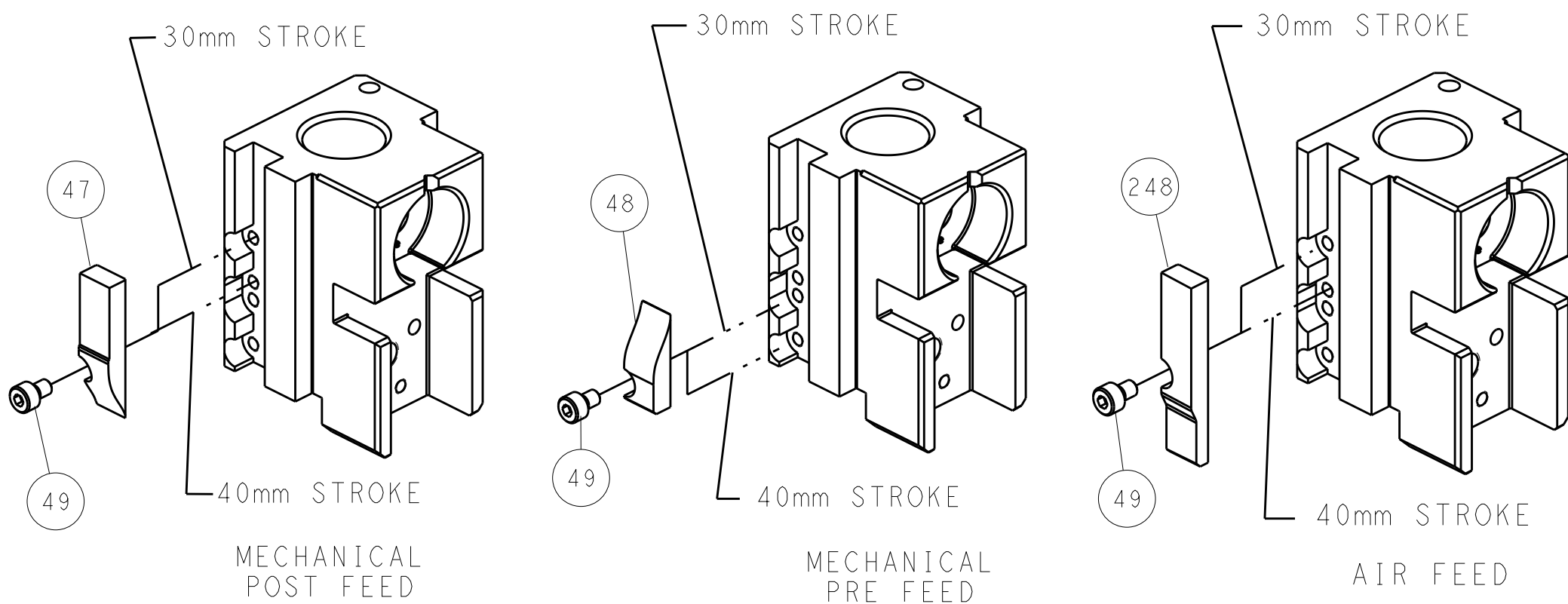
PNEUMATIC



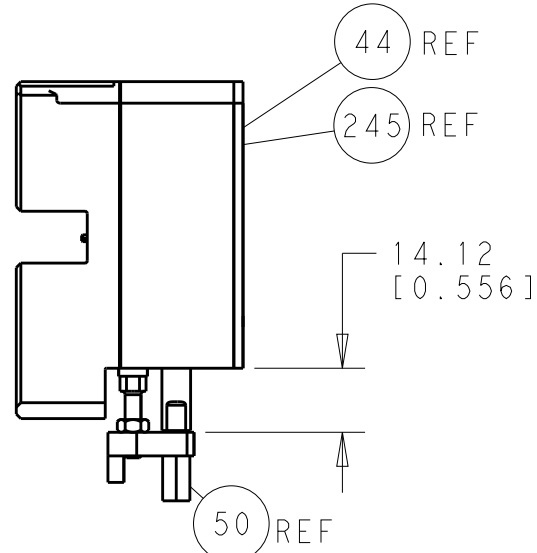
SERVO LATCH PLATE



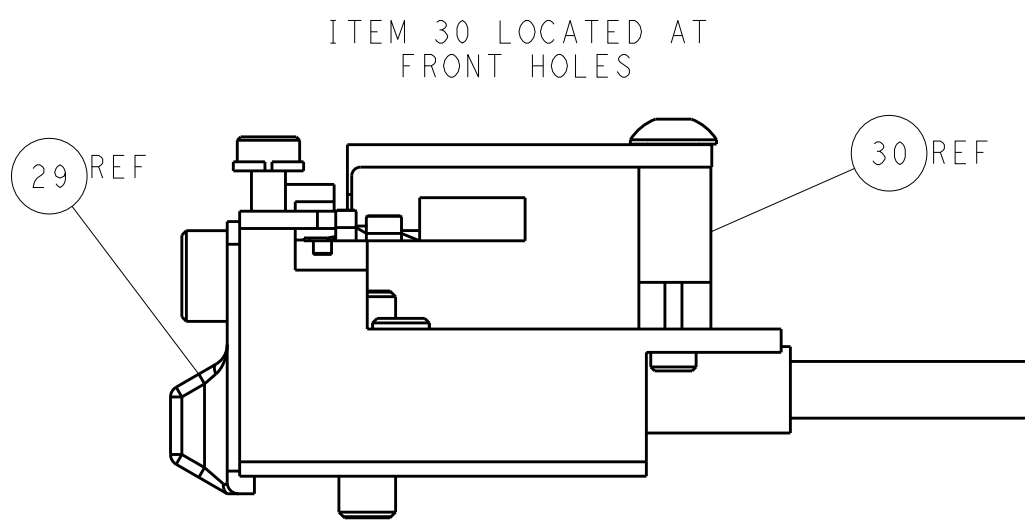
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm		0 PLC ±0.1		S. ALVES		Harrisburg, PA 17105-3608	
		1 PLC ±0.02		P. BARLETTA			
		2 PLC ±0.005		C. LIMA			
		3 PLC ±0.0005		25FEB2013			
		4 PLC ±0.0005		25FEB2013			
		FINISH		PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE			
				1:1			
				SHEET			
				2 of 4			
				REV			
				1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

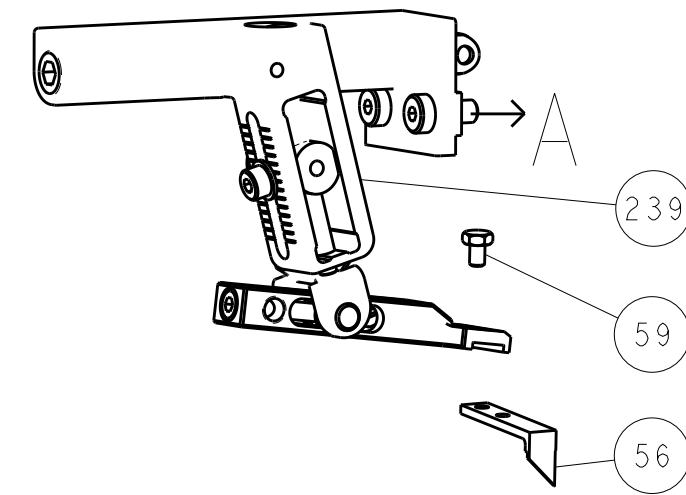
A

B

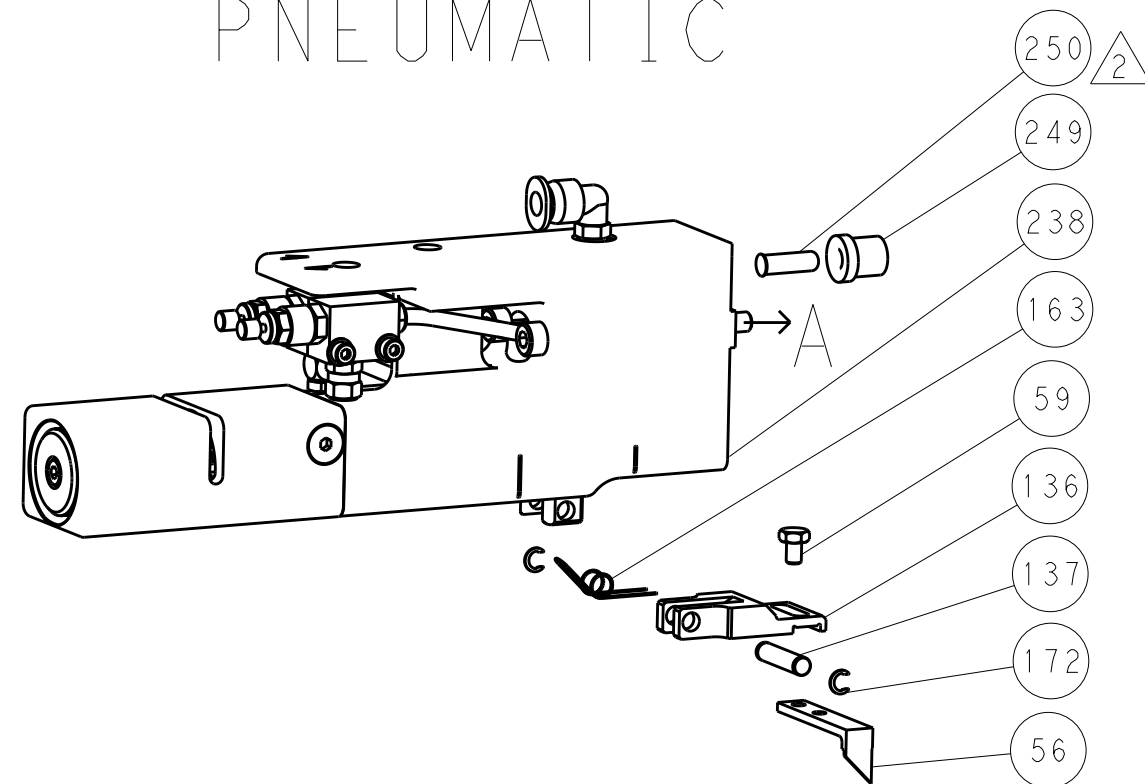
C

D

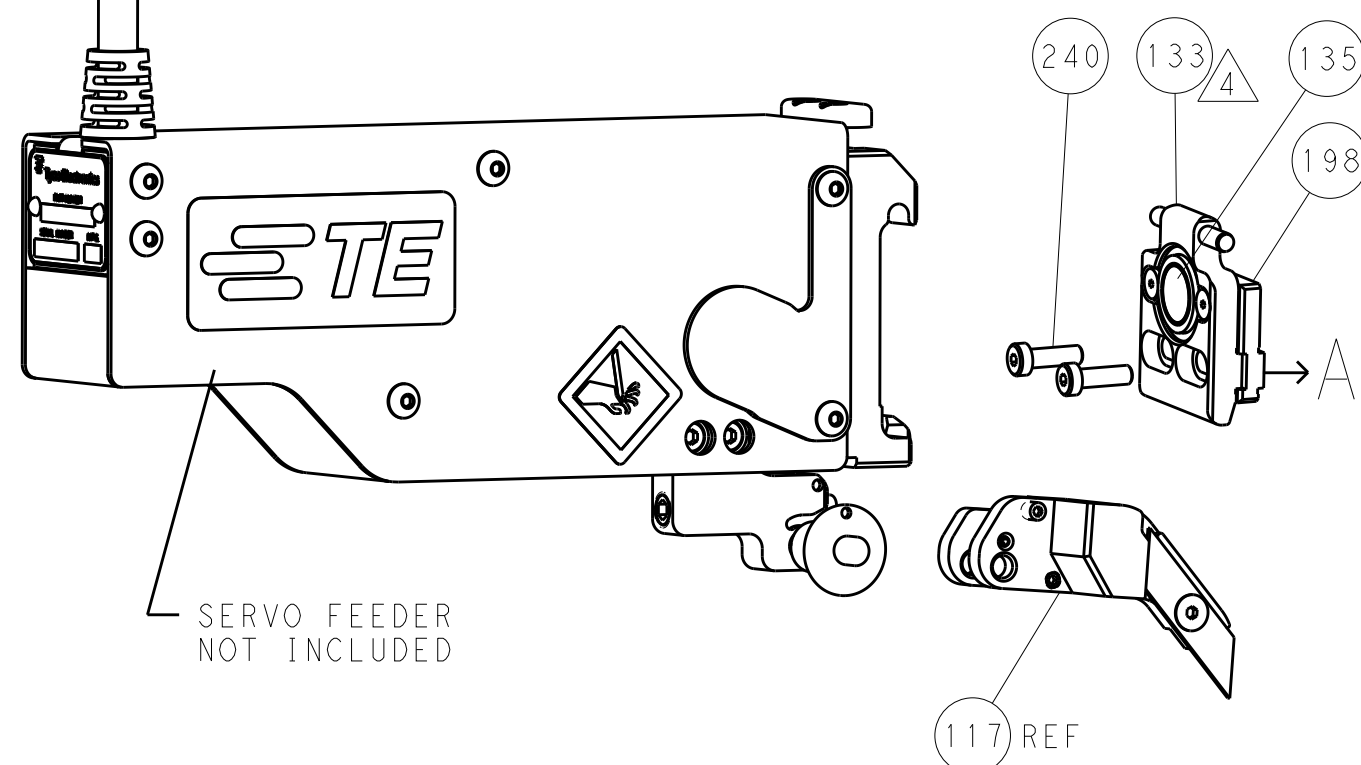
FEED TYPE MECHANICAL



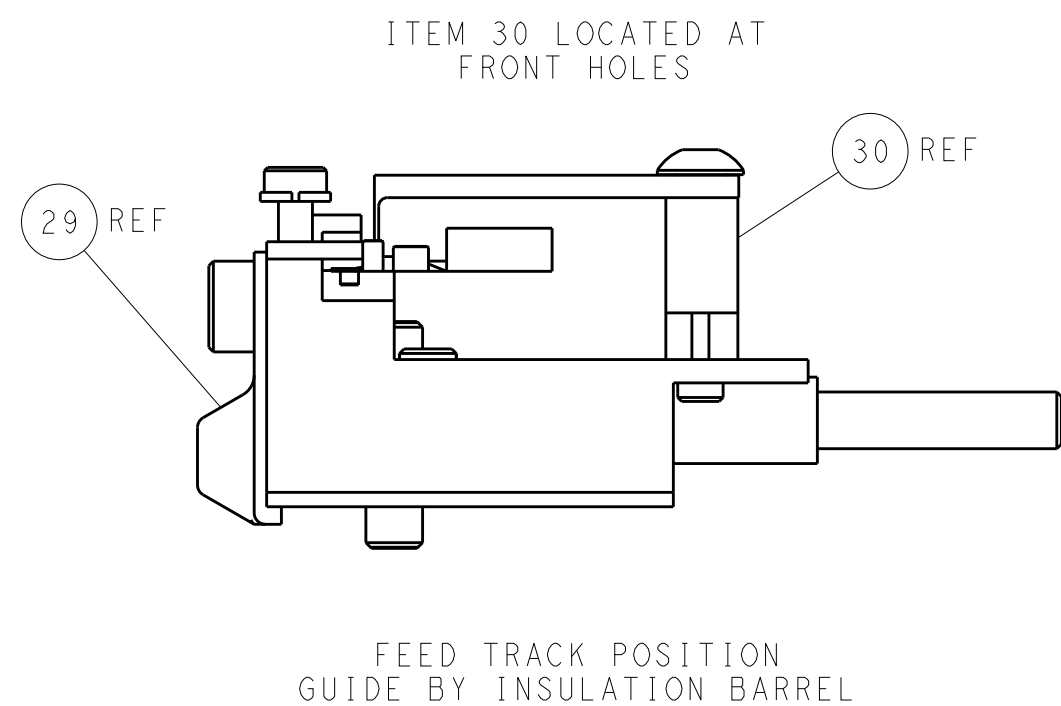
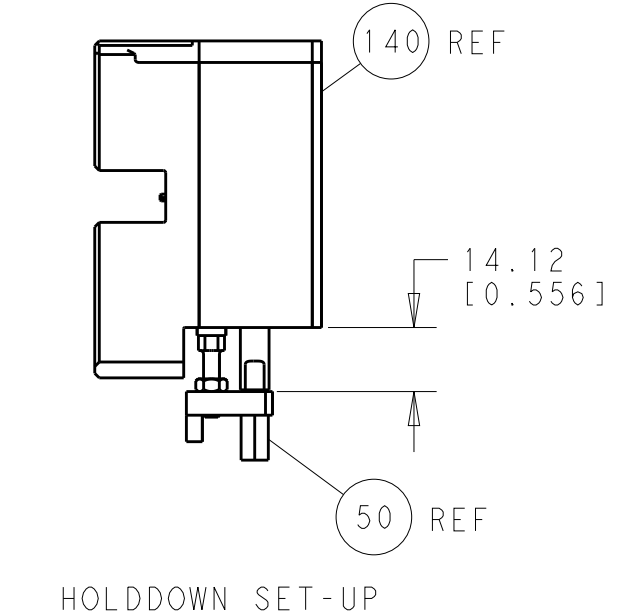
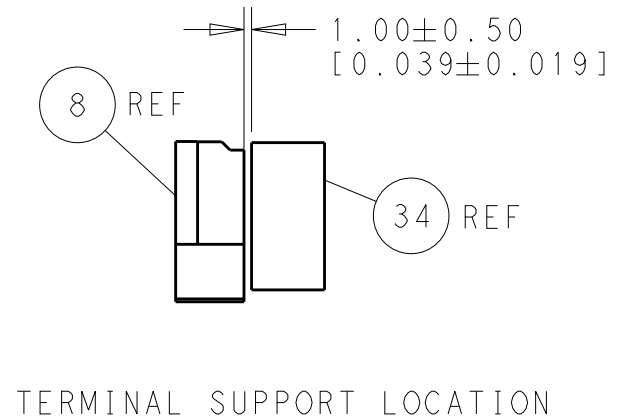
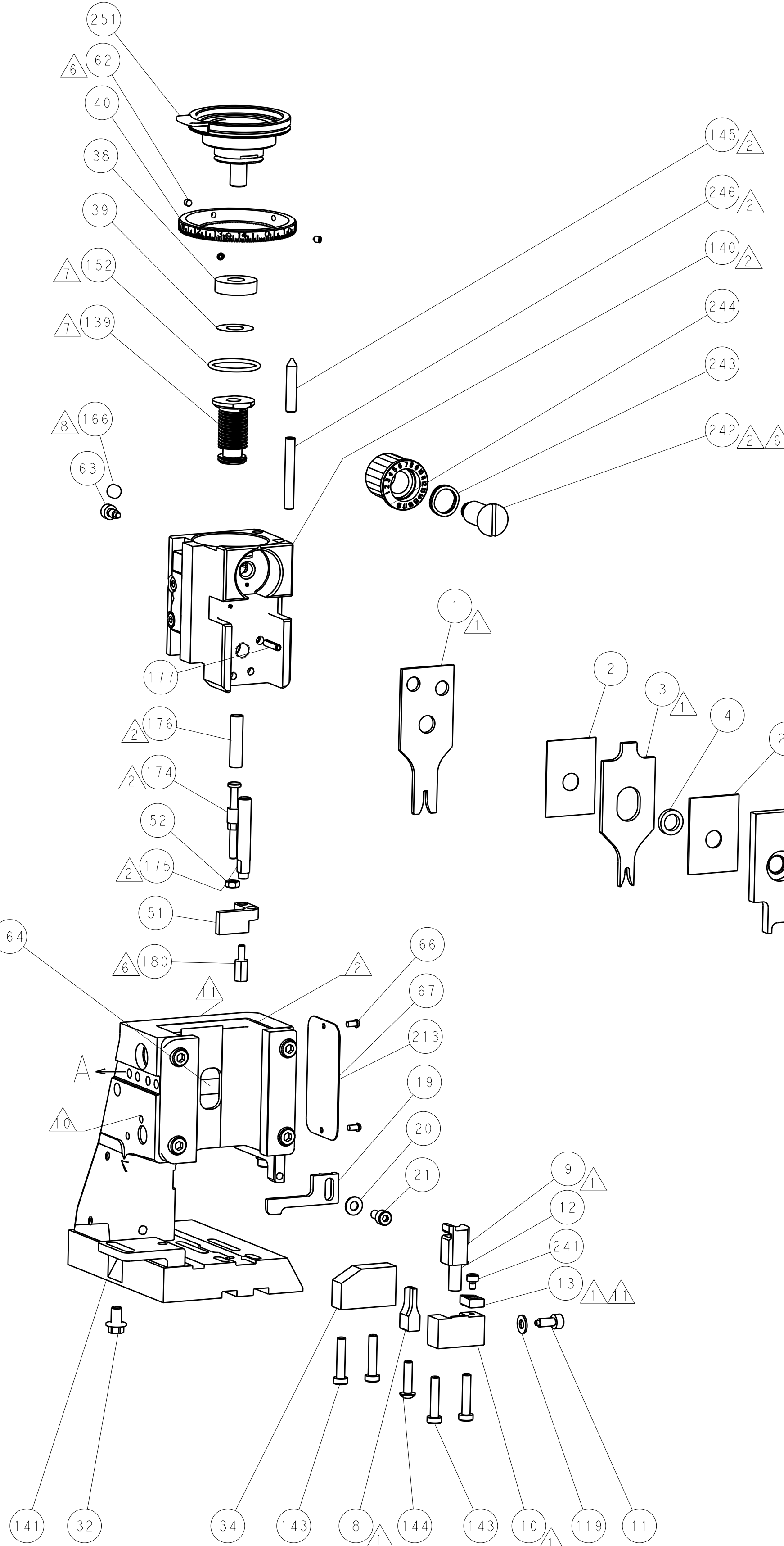
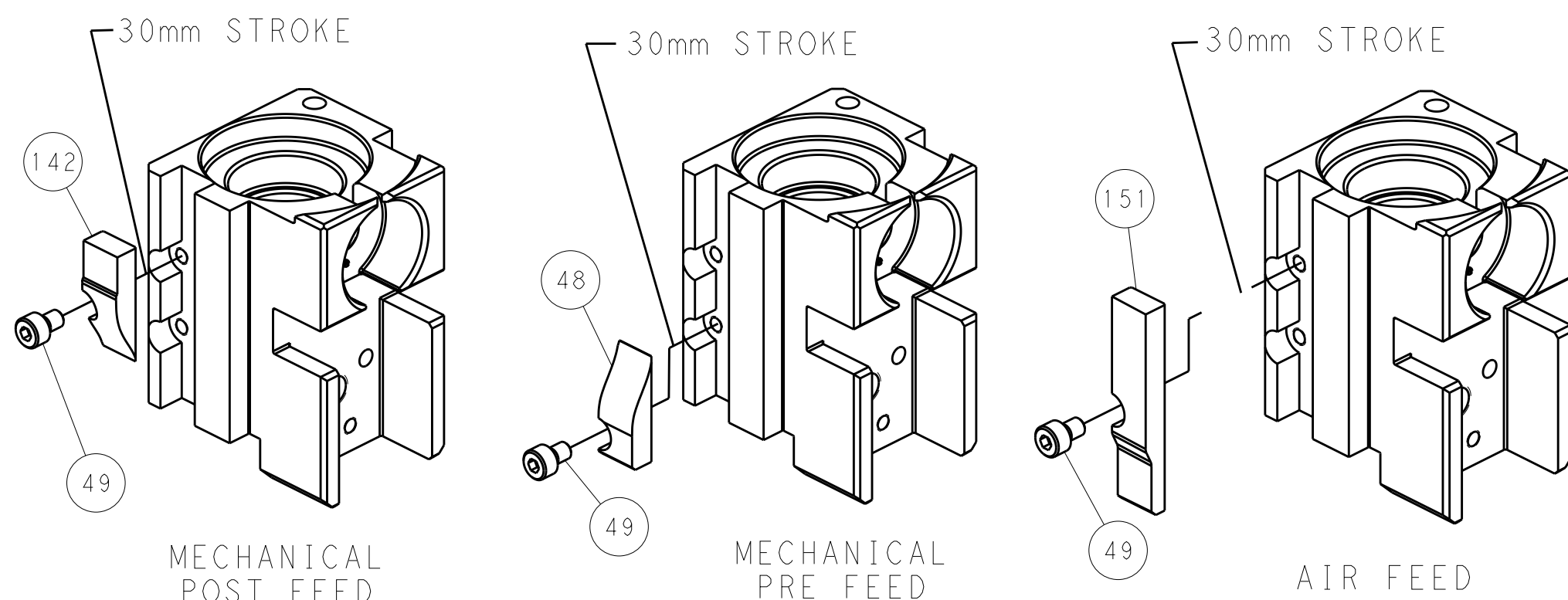
PNEUMATIC



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)

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DIMENSIONS: mm		CHK P. BARLETTA 25FEB2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD C. LIMA 25FEB2013	SIZE 00779	
		PRODUCT SPEC	CAGE CODE C=2151886	
0 PLC ±0.1		APPLICATION SPEC	RESTRICTED TO	
1 PLC ±0.1		WEIGHT	Customer Accessible Production Drawing	
2 PLC ±0.02		SCALE 1:1	SHEET 4	
3 PLC ±0.005		REV 1	OF 4	
4 PLC ±0.0005				
ANGLES				
FINISH				

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION