

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THIS DRAWING IS UNPUBLISHED.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

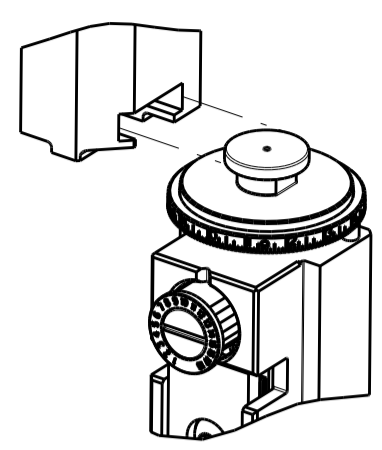
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151644-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151644-5

8-2151644-4

2119641-1

1901094-3

-

2119799-1

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151644-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151644-5

8-2151644-4

2119653-1

1901094-3

-

-

-

-

-

-

-

-

2168400-6 (QUANTITY 2)

-

2151644-5

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

-

2119799-1

-

2063440-1

2151644-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

-

-

-

-

-

-

-

-

-

-

-

-

2151644-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

-

-

-

-

-

7-2151644-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP WIRE INSUL

SIZE 2.29mm [.090] 0.00mm [.000]

TYPE F -

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: MAXI-SEAL TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH .171-.186 IN [4.34-4.72 mm]

INSULATION DIAMETER RANGE Ø.120-.125 IN [3.05-3.18 mm]

TERMINAL APPLICATION SPECIFICATION

NONE - -

TERMINALS APPLIED

TE TERMINAL 2113267-1

MAXI-SEAL TERMINAL T188

TE TERMINAL

MAXI-SEAL TERMINAL

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

14 AWG

1.75+/-0.05 [.069+/- .002]

8.1

16 AWG

1.50+/-0.05 [.059+/- .002]

10.7

18 AWG

1.35+/-0.05 [.053+/- .002]

12.5

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: 8-2151644-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151644-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151644-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151644-6

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 ITEM 50.

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, .1070 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

-

1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-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

A

RELEASED

26APR2010

KS

TE

-

-

1

-

-

-

2119758-1

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

245

-

1

1

1

1

1

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

-

-

-

-

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

455888-4

SPACER, CRIMPER

82

-

1

1

1

1

1

22281-8

SPRING, COMPRESSION

77

-

1

1

1

1

1

854769-4

HOLDER, INS

74

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

1

1

1

1

2119943-1

WASHER, SPACER

69

-

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

-

2

-

2

2

2

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

1

1

1

21028-2

PIN, SLOTTED SPRING .062 X .250

58

-

-

-

-

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

1

1

1

1

1-1752354-4

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

2-1752356-2

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

1-1320908-0

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

1633933-4

ANVIL, COMBINATION

8

-

-

-

-

-

-

-

-

7

-

-

-

-

-

-

-

-

6

-

1

1

1

1

1

2119780-9

DEPRESSOR, SHEAR

5

-

-

-

-

-

-

-

-

4

-

-

-

-

-

-

-

-

3

-

-

-

-

-

-

-

-

2

-

1

1

1

1

1

4-456406-1

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES FINISH

MATERIAL

FINISH

DWN L. STAKEN 04APRIL2012

CHK G. BAILEY 04APRIL2012

APVD T. ELBIN 04APRIL2012

NAME

PRODUCT SPEC

APPLICATION SPEC

SIZE CASE CODE DRAWING NO RESTRICTED TO

00779 ©=2151644

Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV A

TE Connectivity

Harrisburg, PA 17105-3608

OCEAN SIDE FEED APPLICATOR

OCEAN SIDE FEED APPLICATOR

AMF 4805 REV 31MAR2000

Prs/ENGINEER DRAWING

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC

250
249
238
163
59
136
137
172
56

SERVO FEEDER
NOT INCLUDED

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

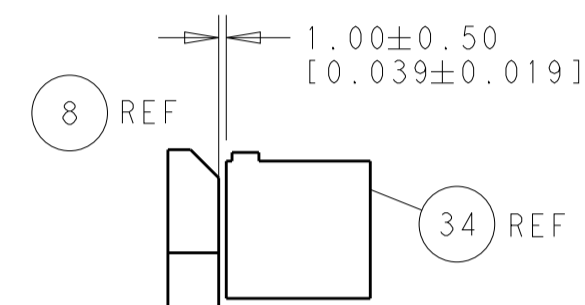
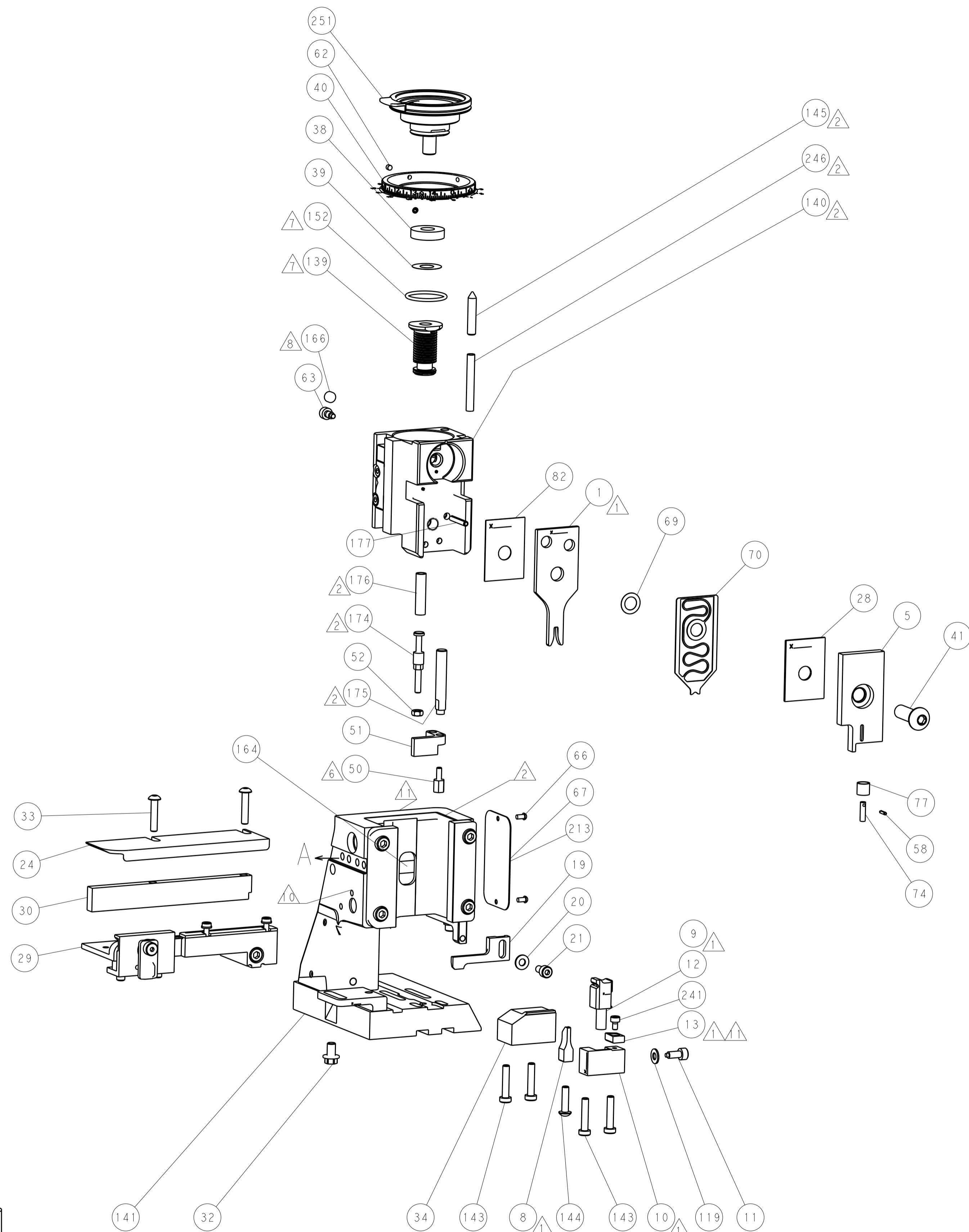
MECHANICAL PRE FEED

30mm STROKE

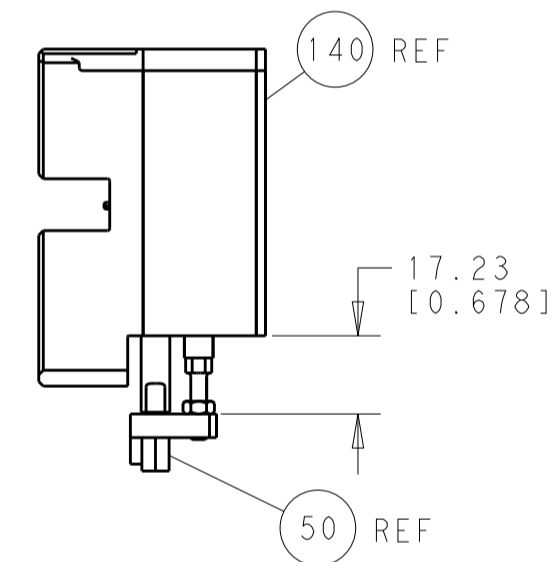
151

49

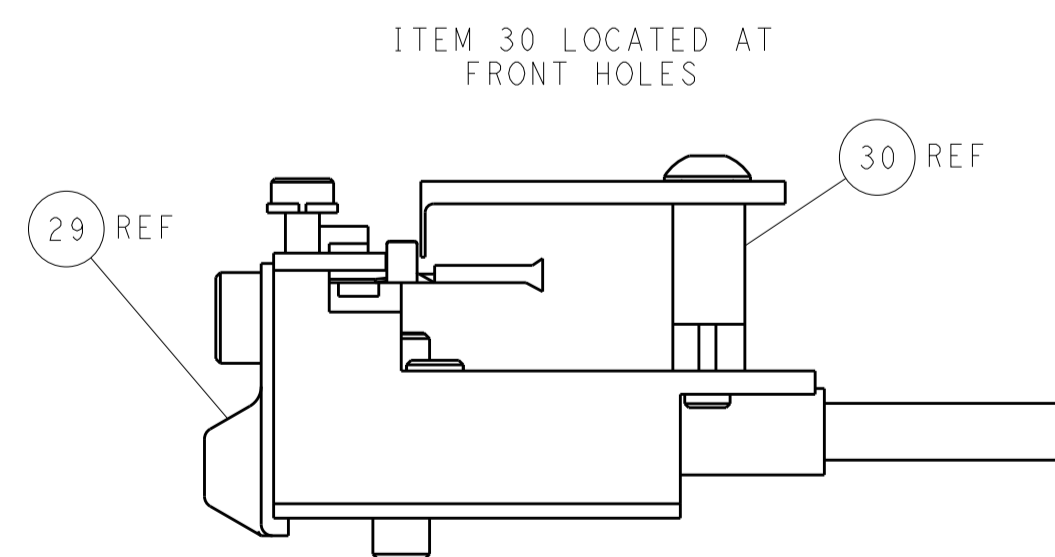
AIR FEED



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR ENVOI-ELECTRONIC CORPORATION IT IS SUBJECT TO THE PROPERTIES, STANDARDS AND SPECIFICATIONS OF THE ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST VERSION</small>		DWN K. STAKW 04PRIL2012 CHK G. BAILEY 04PRIL2012 APVD T. ELBIN 04PRIL2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME OCEAN SIDE FEED APPLICATOR OCEAN SIDE FEED APPLICATOR	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CASE CODE 00779	
		WEIGHT -		DRAWING NO C=2151644	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV A	