

8

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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

2150305-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

2119792-2

1901697-1

-

-

-

8-2150305-5

2119641-1

-

-

2063440-1

2168400-7 (QUANTITY 2)

-

2150305-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

2063961-1

1901697-1

-

5-18022-5

8-2150305-5

8-2150305-4

2119653-1

-

-

-

-

2168400-7 (QUANTITY 2)

2150305-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

2063961-1

2119792-2

-

5-18022-5

-

-

2119653-1

-

-

-

-

2063440-1

2150305-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

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-

2150305-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2150305-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

F

INSUL

-

-

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, SPADE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

.186-.201 IN [4.72-5.11 mm]

Ø

-

TERMINAL APPLICATION SPECIFICATION

114-2084

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

40608

160036-2

160167-2

160332-2

41879

160061-2

160167-3

160036-1

160167-1

160332-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING⁹

16 AWG

1.70+/-0.05 [1.067+/-0.002]

6.3

18 AWG

1.55+/-0.05 [1.061+/-0.002]

8.0

20 AWG

1.47+/-0.05 [1.058+/-0.002]

8.8

22 AWG

1.40+/-0.05 [1.055+/-0.002]

9.6

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: 8-2150305-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150305-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150305-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150305-6

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 .
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 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

THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

12

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF (ENTER SHIM HEIGHT VALUE).

*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

-

1

-

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

-

-

-

-

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)

LOC

DIST

REV

SET UP GAUGE

2119599-2

A

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

26FEB2013

KH

GB

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1

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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

-

-

-

2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

-

2

2

-

-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

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

-

REF

REF

-

-

-

1901697-1

FEED FINGER ASSEMBLY,EF

183

-

1

1

1

1

1

6-9931111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

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1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

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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

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-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

-

-

-

-

1

-

3-23627-7

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

137

-

-

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

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

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1

1

1

1

1

1901681-5

HOLDDOWN, TERMINAL

65

-

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

-

-

-

-

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1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

-

1

2063961-1

FEED FINGER

58

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4

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

56

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2

2

2

2

2

5018030-2

NUT, HEX, REG, RoHS, M4

55

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2

2

2

2

2

5018030-1

NUT, HEX, REG, RoHS, M3

54

-

2

2

2

2

2

986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

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1

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

-

-

-

1

-

2119792-2

PAWL, EF, AIR

51

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1

1

1

1

1

4-1752354-1

STANDOFF,HOLD-DOWN

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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-

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1

2119653-1

FEED CAM, POST FEED

47

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1

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2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

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1

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1

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1

2119369-1

RAM,AMP STYLE, END FEED

44

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1

1

1

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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

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1

1

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1

1

2119644-2

RAM WASHER, PRECISION

38

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1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

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1

1

1

2119092-1

BOLT, ADJUSTMENT

35

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8

8

8

8

8

1-18028-2

WASHER, FLAT, REG M4

33

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2

2

2

2

2

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

31

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2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

29

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1

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240639-1

STRIPPER (MACHINING)

27

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2

2

2

2

2

1320906-1

STUD, THREADED

25

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1

1

1

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1752371-1

PLATE, STRIP GUIDE

24

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2

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

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1

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1752373-4

DRAG

20

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1901696-7

STRIP GUIDE, REAR

19

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1901695-7

STRIP GUIDE, FRONT

18

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4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1

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1752360-1

SPACER,HOLD-DOWN

13

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1

240644-1

PLATE, REAR SHEAR

11

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2

2

2

2

2

1-240645-1

SPACER, SHEAR PLATE

10

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1

1

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240642-1

PLATE, FRONT SHEAR

9

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1803002-2

ANVIL, COMBINATION, END FEED

8

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8-240651-7

BLADE, SLUG

7

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4-240641-1

SPACER

5

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456407-7

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE CONTACTED FOR THE LATEST NOTIFICATION.

DIMENSIONS:
mm

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC
ANGLES

±
±0.5
±0.13
±0.013
±0.0001
±

TOLERANCES UNLESS
OTHERWISE SPECIFIED:

FINISH

MATERIAL

DWN

CHK

S.XI

APVD

06DEC2012

06DEC2012

06DEC2012

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

TE Connectivity

Harrisburg, PA 17105-3608

Ocean End Feed

Applicator

-

00779

©=2150305

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

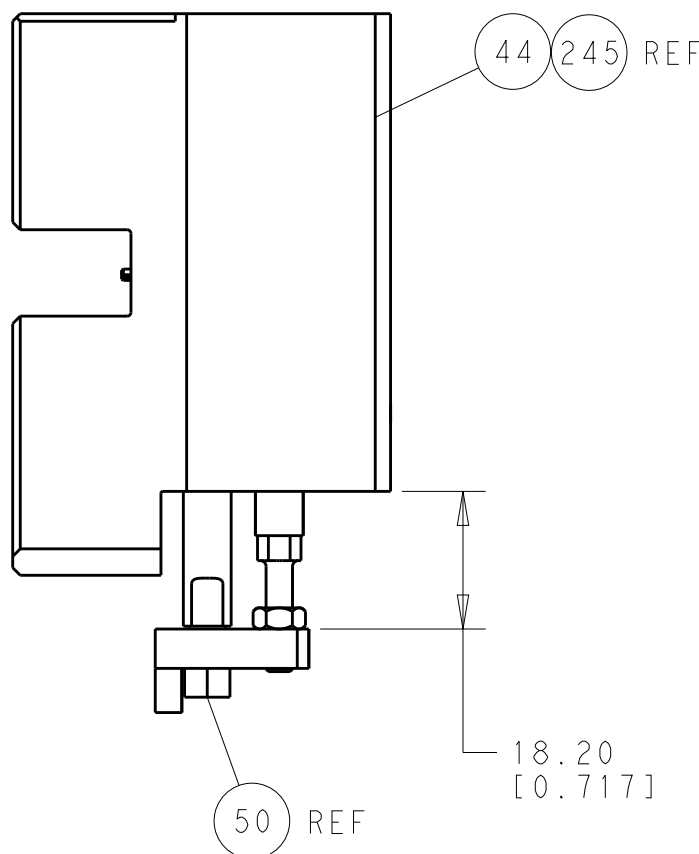
A

AMP 4805 REV 31MAR2000

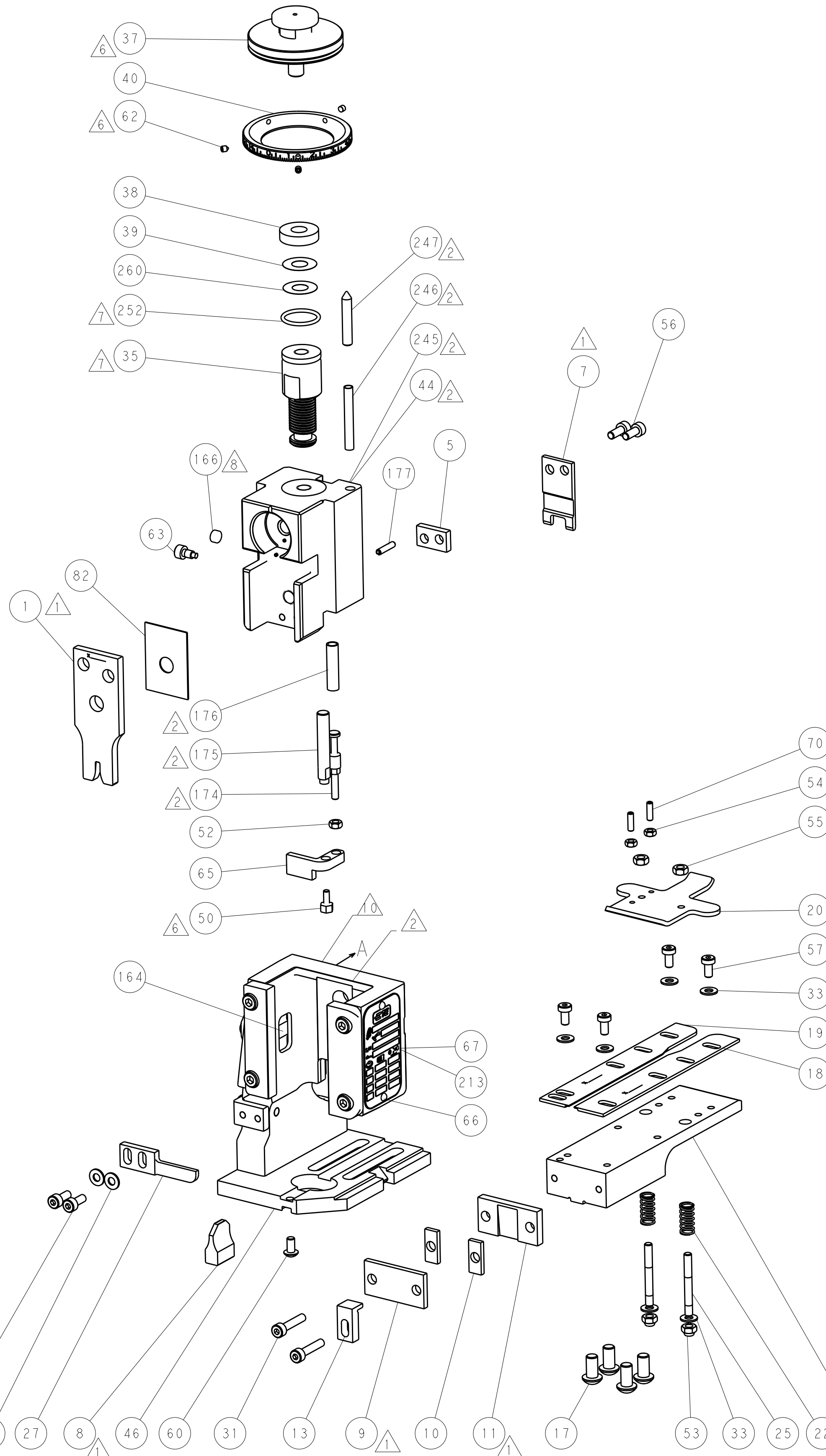
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

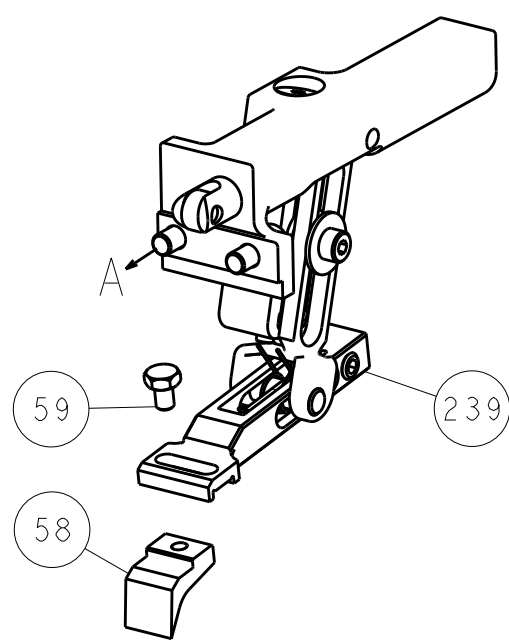
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003



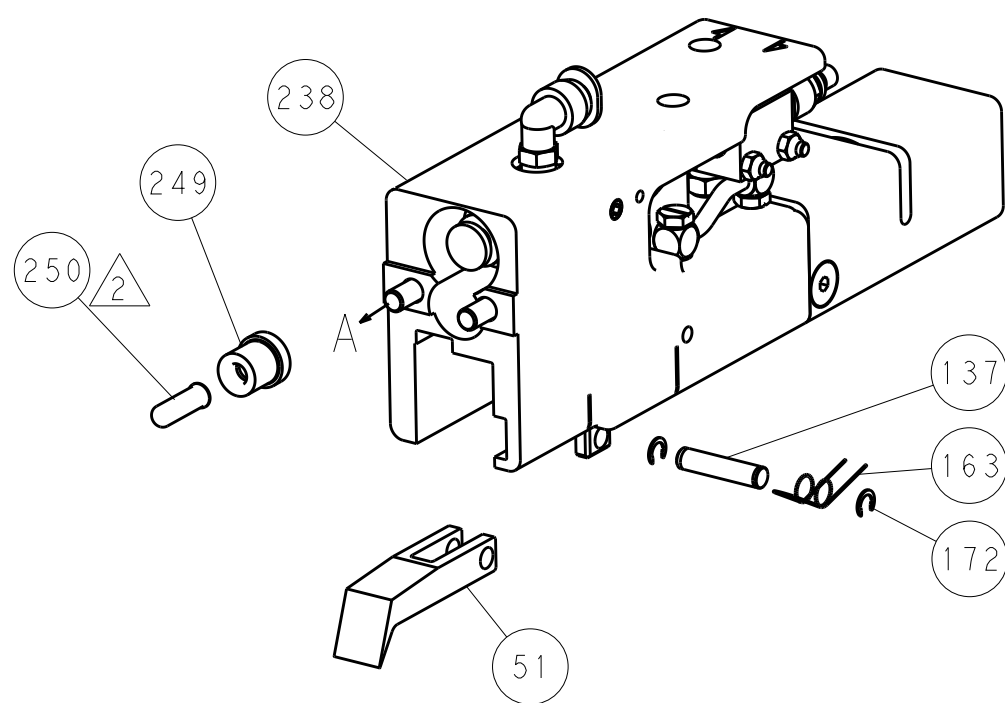
HOLDDOWN SET-UP



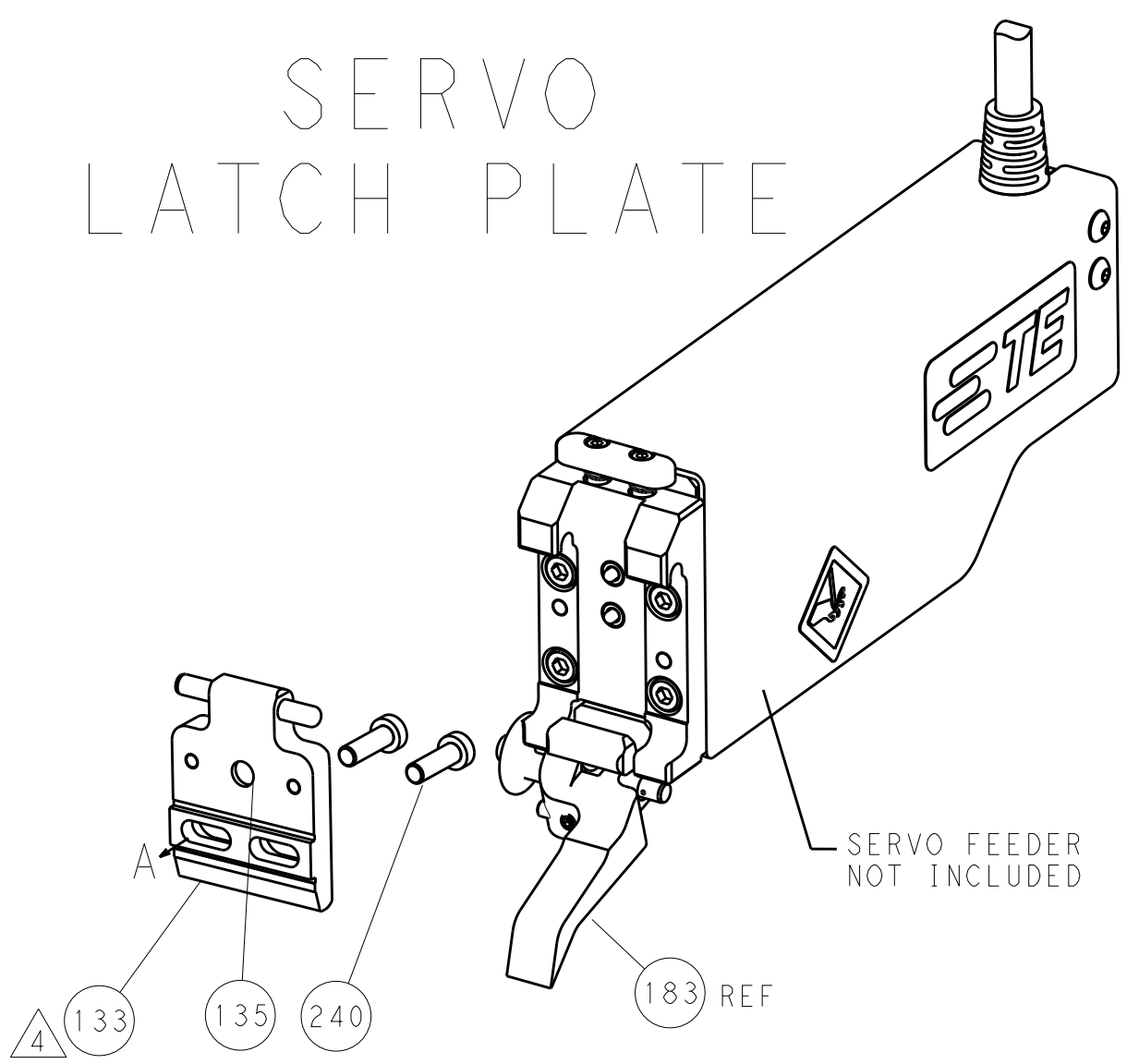
FEED TYPE
MECHANICAL



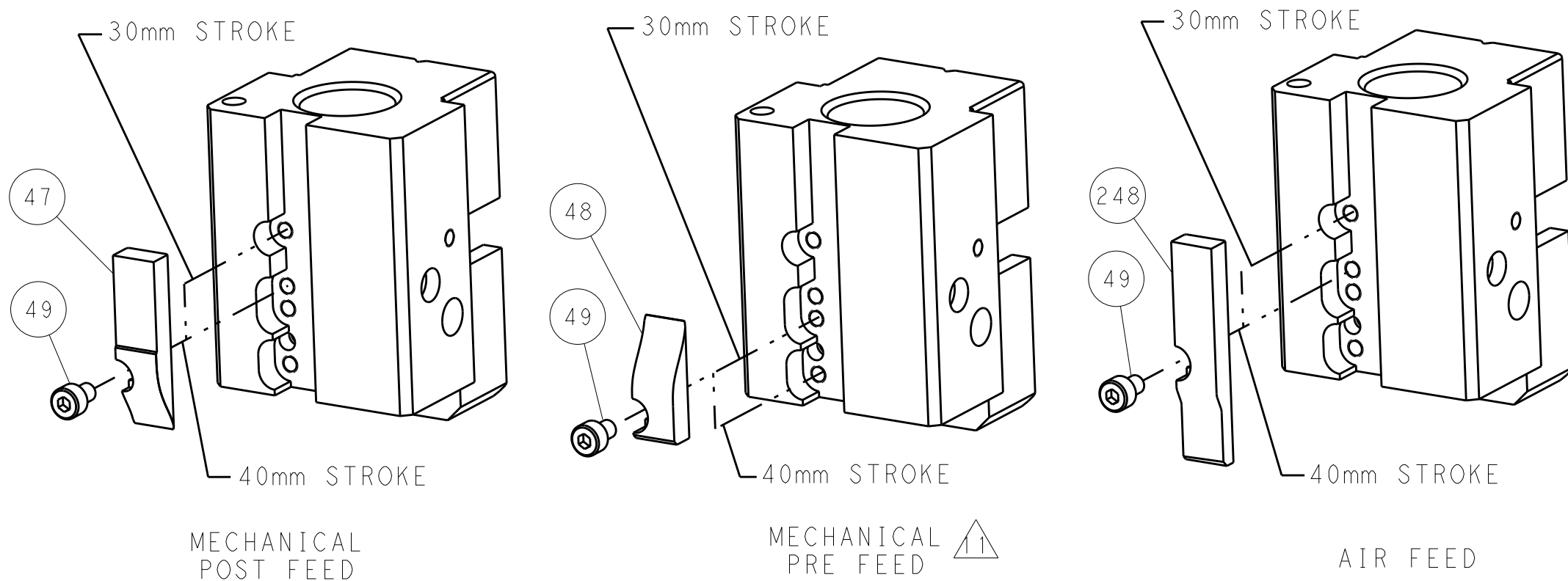
PNEUMATIC



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)

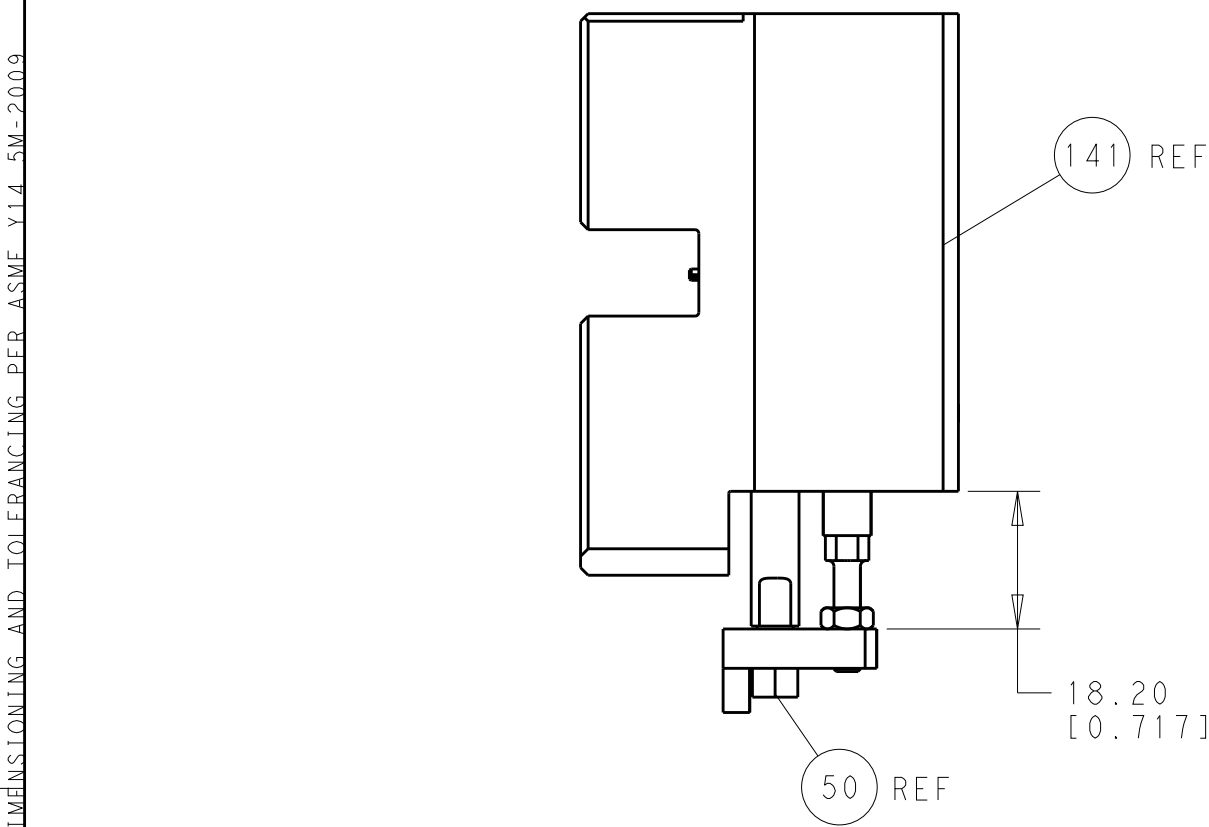
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 06DEC2012		TE Connectivity	
mm		0 PLC ±.5		CHK S.XI 06DEC2012		Harrisburg, PA 17105-3608	
1 PLC ±0.13		APVD S.XI 06DEC2012		NAME		Ocean End Feed Applicator	
2 PLC ±0.13		PRODUCT SPEC		SIZE		CAGE CODE DRAWING NO	
3 PLC ±0.013		APPLICATION SPEC		A1 00779		C=2150305	
4 PLC ±0.0001		FINISH		WEIGHT		Customer Accessible Production Drawing	
MATERIAL		SCALE		1:1		SHEET 2 OF 4	
		REV		A			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

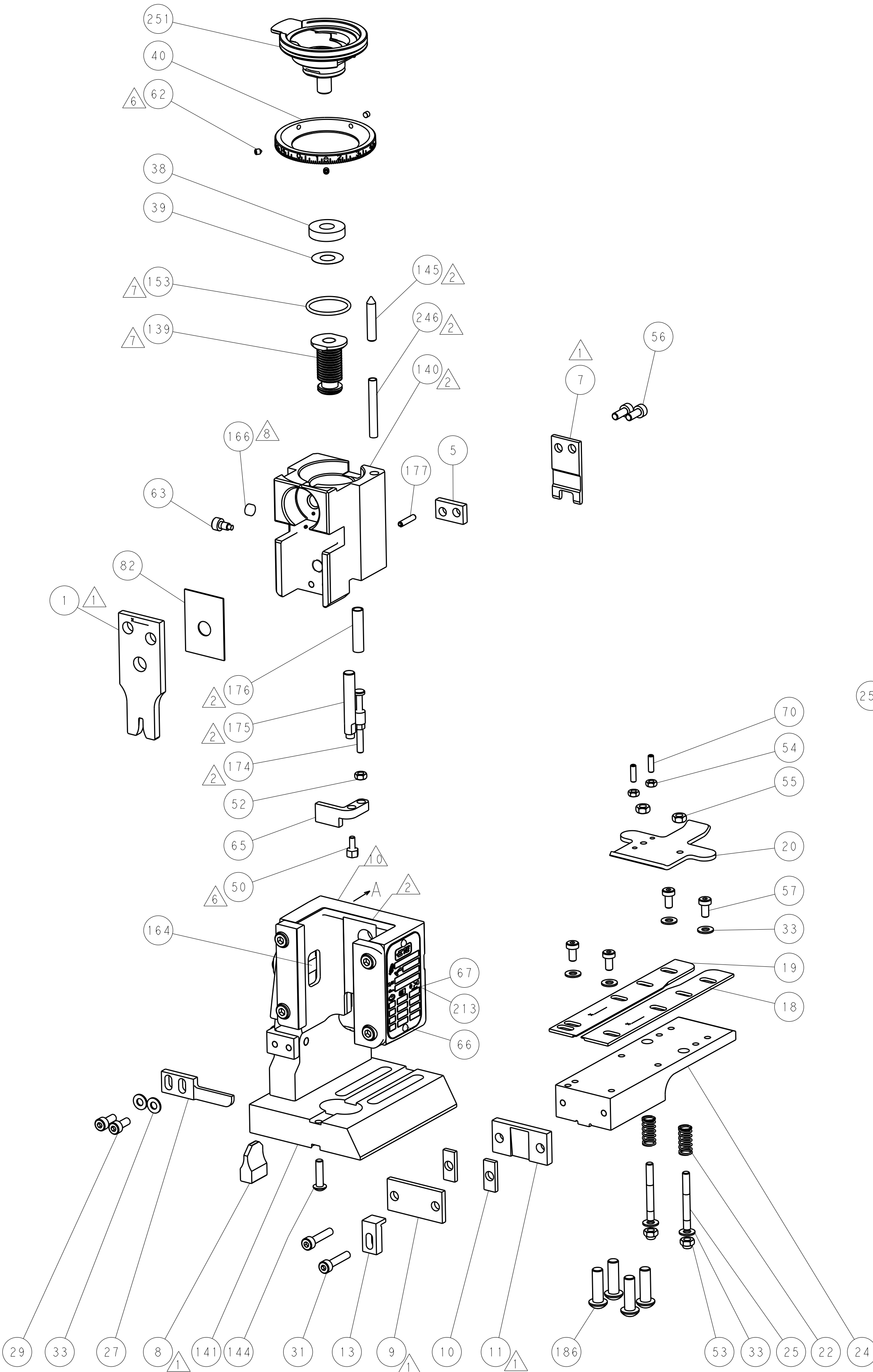
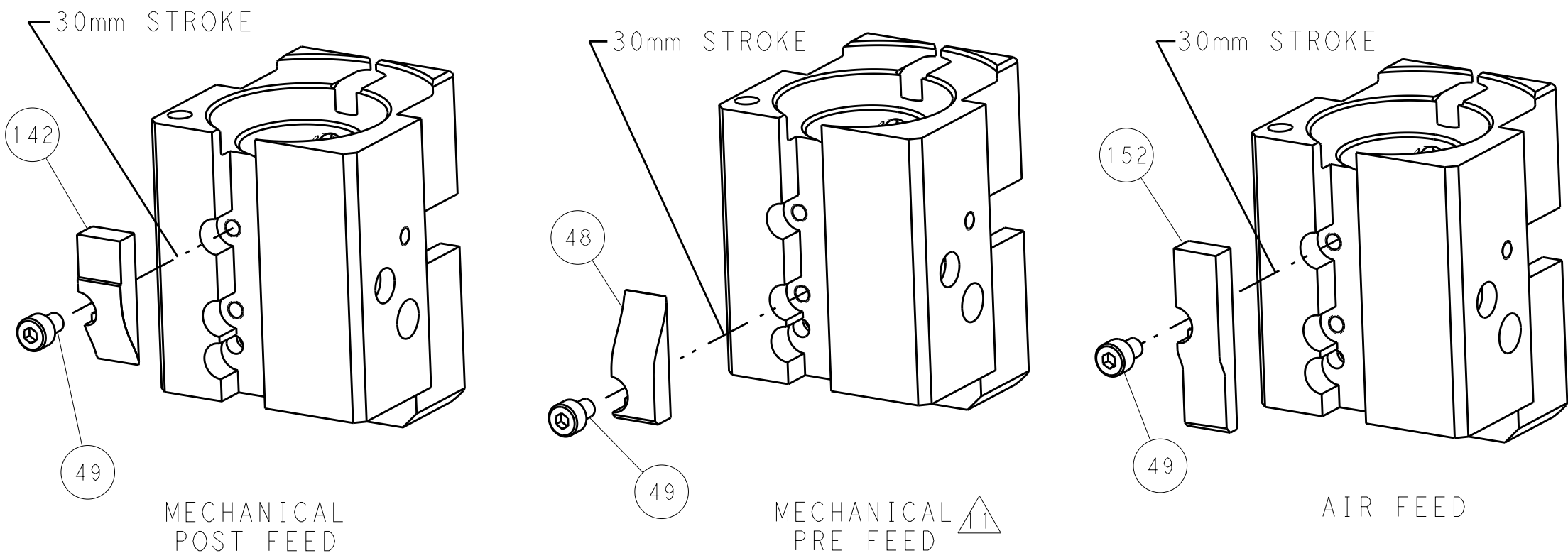
B

A



HOLDDOWN SET-UP

CAM POSITIONS



PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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