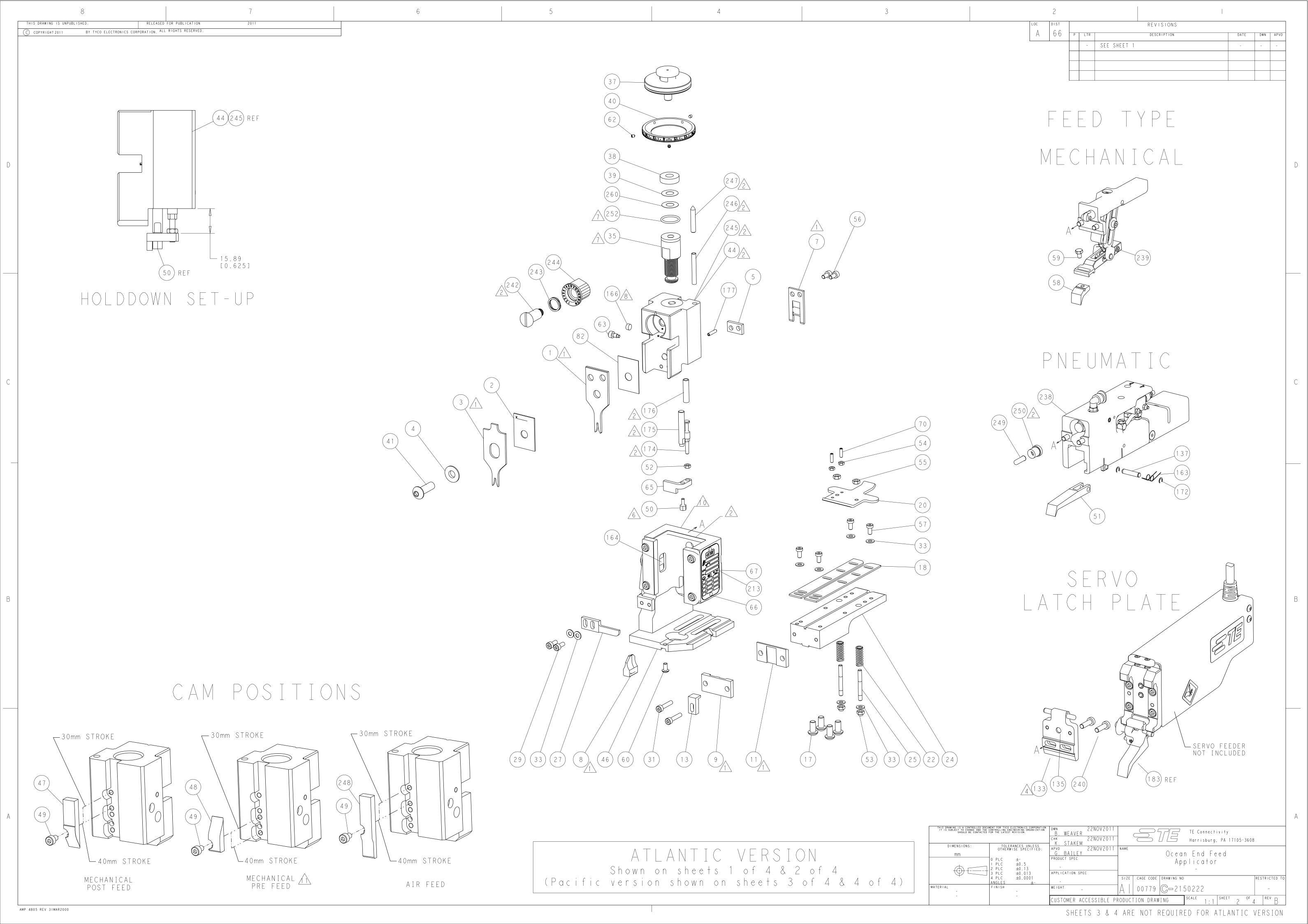
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION REVISIONS SET UP GAUGE 2119599-2 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED A | 66 DESCRIPTION DATE DWN APVD APPLICATOR STYLE CONVERSION CHART ATLANTIC VERSION B ECR-11-023770 22NOV2011 BW GB TERMINATOR REVISION DESCRIPTION FEED TYPE NUMBER CONVERT TO PART NUMBERS REQUIRED INTERFACE ADAPTER PNEUMATIC FEED 2119950-1 2119792-1 2063440-1 2119641-1 2150222-1 8-2150222-5 FINE CRIMP HEIGHT ADJUST MECHANICAL SERVO LATCH PLATE| 2119951-1 1901697-1 2168400-7 (QUANTITY 2) _ 2119641-1 FEED CAM, AIR FEED SMART APPLICATOR | 2161326-1 8-2150222-4 --2119798-DETENT PIN MECHANICAL FEED | 2119949-1 2063961-5-18022-5 2119653-1 -1 - 22279 - 3 SPRING, COMPRESSION 246 2150222-2 FINE CRIMP HEIGHT ADJUST PNEUMATIC SERVO LATCH PLATE| 2119951-1 1901697-8-2150222-5 2168400-7 (QUANTITY 2) -2119759-RAM, AMP STYLE, END FEED, NON-ADJUST SMART APPLICATOR | 2161326-1 8-2150222-4 244 --CAM, SNAIL, INSULATION ADJUSTMENT 2119082-9 2079764-| WASHER, WAVE SPRING, CREST-TO-CREST | 243 MECHANICAL FEED | 2119949-1 2063961-1 5-18022-5 2119653-1 _ SERVO 2150222-5 FINE CRIMP HEIGHT ADJUST LATCH PLATE/4 242 RETAINER, INSULATION DIAL 2119083-2063440-1 PNEUMATIC FEED 2119950-1 2119792-1 2119641-1 -SHCS, LOW HEAD, RoHS, M5 X 10 240 2168400-_ _ _ _ 2150222-6 NON-CRIMP HEIGHT ADJUST 239 /4 LATCH PLATE/12 2119580-MECHANICAL FEED ASSEMBLY -_ ---2063440-AIR FEED MODULE 2150222-7 FINE CRIMP HEIGHT ADJUST NONE ------2119740-TAG, IDENTIFICATION 7-2150222-7 CRIMP TOOLING KIT -----1901697-FEED FINGER ASSEMBLY, EF PIN, SLOTTED SPRING 3.0 X 14.0 6-993111-6 8-22280-SPRING, COMPRESSION 1752353-2 GUIDE PIN, HOLDDOWN APPLICATOR DATA GUIDE PIN, HOLDDOWN 1 | 1 | 1 | 1 1901680-TYPE RING, RETAIN, EXTERN, 3/16 CRESCENT 21045-3 WIRE | 1.40 mm [.055] MAGNET, RARE EARTH HIGH ENERGY 994969-| 166 [NSUL 2.29 mm [.090] FREFREFREFR COUNTER, MAGNETIC 994970-2 | 164 APPL INSTRUCTIONS SPRING, FEED FINGER 240638-1 408-10390 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 REFREF MEMORY CHIP, PROGRAMMED SEE NOTE 4 1633743-1 SERVO FEED LATCH ASM SPACER, CRIMPER 455888-3 82 TERMINAL DATA: G.H./LEAR TERMINAL TE CRIMP SPEC 7 1 2119956-2 DOCUMENTATION PACKAGE TERMINAL NAME: RECEPTACLE 3.1 FASTON 2-18032-2 SCR, SET, FLT POINT M3 X 10.0 70 WIRE STRIP LENGTH INSULATION DIAMETER RANGE 67 2119740-1 TAG, IDENTIFICATION \emptyset .080-.100 IN [2.03-2.54 mm] .213-.223 [N [5.41-5.66 mm] 66 2168078-SCREW, DRIVE, RH, ROHS ERMINAL 114-2025 1901681-5 HOLDDOWN, TERMINAL APPLICATION 🐸 LIMITER, ADJUSTMENT BOLT 2119793-SPECIFICATION SCR, SET, SOC, CONE POINT, M3 x 4.0 992763-5 62 TERMINALS APPLIED 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60 59 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 TE TERMINAL G.H./LEAR TERMINAL TE TERMINAL G.H./LEAR TERMINAL 58 2063961-1 FEED FINGER 2113211-1 22246.124.186 57 | 4 | 4 | 4 | 4 | 4 2168400-4 SHCS, LOW HEAD, ROHS, M4 X 8 56 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 5018030-2 NUT, HEX, REG, RoHS, M4 NUT, HEX, REG, RoHS, M3 5018030-CRIMP HEIGHT T CRIMP HEIGHT /9\ 986965-8 NUT, LOCK, HEX, TORQUE (M4) REFERENCE SETTING 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 0.60mm2 1.14+/-0.05 [.045+/-.002] PAWL, EF, AIR 2119792-1 1 09+/-0 05 [043+/- 002] 1752354-4 STANDOFF, HOLD-DOWN 0.35mm2 1.02+/-0.05 [.040+/-.002] 7.1 SCR. SKT HD CAP M4 X 6.0 18023-9 49 0.30mm2 0.99+/-0.05 [.039+/-.002] 7.4 48 2119652-FEED CAM, PRE FEED FEED CAM, POST FEED 47 2119653-1 APPLICATOR BASIC ASSEMBLY, EF 46 2119655-5 44 2119369-1 RAM, AMP STYLE, END FEED 2079383-SCR, BHSC, RoHS (M8 X 25) 40 2119645-DISC, NUMBERED FA WIRE ADJUSTMENT 1 RECOMMENDED SPARE PARTS *WARNING 39 APPLICATOR SHIM PACK 2119957-ON INSTALLATION, SET WIRE DISC, ITEM 40 TO 2 GREASE BEARING SURFACES LIGHTLY 38 RAM WASHER, PRECISION 2119644-LARGEST WIRE SIZE SETTING. USE OF SETTINGS FA HEAD, ATLANTIC STYLE 37 2119085-3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING SHEET SUPPLIED WITH THE APPLICATOR. 35 2119092-BOLT, ADJUSTMENT WILL CAUSE DAMAGE TO CRIMP TOOLING. 1 - 18028 - 2 | WASHER, FLAT, REG M4 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT 2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20 ASSEMBLY. SEE BELOW FOR PART NUMBER MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150222-4 SCR, SKT HD CAP, RoHS, M4 X 10 1-2168083-0 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150222-4 STRIPPER (MACHINING) 240639-1 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": STUD, THREADED SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150222-6 1320906-1 1752371-9 | PLATE, STRIP GUIDE 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE 4 - 22281 - 1 SPRING, COMPRESSION APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS. DRAG 1752373-1 4 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 18 1901259-3 GUIDE, LOWER STRIP 1 - 2079383 - 1 SCR, BHSC, RoHS (M6 X 12) $\overline{2}$ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252. | 4 | 4 | 4 | 4 | 4 1752360-1 SPACER, HOLD-DOWN MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY 240833-2 PLATE, REAR SHEAR ACTUATE THE COUNTER. 690482-4 PLATE, FRONT SHEAR 29 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE 8-1633384-2 ANVIL, COMBINATION BLADE, SLUG 690474-4 NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD. 240641-8 SPACER $\overline{/10
angle}$ spare feed cam storage location refer to instruction sheet 1 - 238009 - 4 2119957-2 APPLICATOR SHIM PACK BLOCK, FL CRIMPER SPACER 260 FOR ADDITIONAL INFORMATION. 252 8 - 21084 - 0 O-RING, .676 ID, .070 DIA. MAT. 1-2119582-CRIMPER, INSULATION F PREMIUM - | 1 | - | 1 | 1 | 1 11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH 250 2119640-1 PUSH ROD, AIR FEED 455888-9 SPACER, CRIMPER | - | 1 | ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH 249 BUSHING, LCH5-12, MISUMI \setminus 1 | 1 | 1 | 1 | 1 | 1 | 1 456402-1 CRIMPER, WIRE PREMIUM 2079988-1 ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. ITEM NO ITEM NO FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION. 77 - 7 | - 6 | - 5 | - 2 | - 1 PART NO DESCRIPTION PART NO DESCRIPTION HIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION. <u>/12\</u> when assembling -6 non-crimp height adjust applicator TE Connectivity B. WEAVER Harrisburg, PA 17105-3608 USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM . STAKEM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT 22NOV2011 NAME ATLANTIC VERSION <u>. Bailey</u> Ocean End Feed Applicator Shown on sheets 1 of 4 & 2 of 4 APPLICATION SPEC SIZE CAGE CODE DRAWING NO ±0.0001 (Pacific version shown on sheets 3 of 4 & 4 of 4) | 00779 | C-2150222 SCALE 1:1 SHEET 1 OF 4 REV B STOMER ACCESSIBLE PRODUCTION DRAWING SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED C) COPYRIGHT 2011 APPLICATOR STYLE CONVERSION CHART PACIFIC VERSION REVISION TERMINATOR DESCRIPTION FEED TYPE NUMBER CONVERT TO PART NUMBERS REQUIRED INTERFACE ADAPTER PNEUMATIC FEED 2119950-1 2119792-1 2-2150222-1 8-2150222-5 SERVO LATCH PLATE | 2119951-1 FINE CRIMP HEIGHT ADJUST MECHANICAL 1901697-1 SMART APPLICATOR | 2161326-1 8-2150222-4 MECHANICAL FEED | 2119949-1 2063961-5-18022-5 2-2150222-2 8-2150222-5 FINE CRIMP HEIGHT ADJUST PNEUMATIC SERVO LATCH PLATE | 2119951-1 1901697-1 SMART APPLICATOR | 2161326-1 8-2150222-4 MECHANICAL FEED | 2119949-1 2063961-1 5-18022-5 SERVO 2-2150222-5 FINE CRIMP HEIGHT ADJUST LATCH PLATE/4 PNEUMATIC FEED 2119950-1 2119792-1 2-2150222-7 FINE CRIMP HEIGHT ADJUST NONE _ _ 7-2150222-7 CRIMP TOOLING KIT APPLICATOR DATA SIZE CRIMP TYPE WIRE | 1.40 mm [.055] [NSUL | 2.29 mm [.090] APPL INSTRUCTIONS 408-10390 TERMINAL DATA: G.H./LEAR TERMINAL TE CRIMP SPEC TERMINAL NAME: RECEPTACLE 3.1 FASTON WIRE STRIP LENGTH INSULATION DIAMETER RANGE .213-.223 IN [5.41-5.66 mm] Ø.080-.100 IN [2.03-2.54 mm] TERMINAL APPLICATION 114-2025 SPECIFICATION TERMINALS APPLIED TE TERMINAL G.H./LEAR TERMINAL TE TERMINAL G.H./LEAR TERMINAL 2113211-1 22246.124.186

*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.

2119641-2

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2119653-2

2119641-2

2119653-2

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FINE ADJUST HEAD ASM, PACIFIC STYLE 2119782-1 250 2119640-1 PUSH ROD, AIR FEED I T E M N O DESCRIPTION PART NO

PACIFIC VFRSION

			V L I \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	\bigcirc \bigcirc \bigcirc		
	Shown on	sheets 3	s of 4 &	4 of	4	
(Atlantic	version	shown on	sheets	1 of	4 & 2 of	

				1				
	_	1	1	1	1	2079988-1 1-22279-3	BUSHING, LCH5-12, MISUMI SPRING, COMPRESSION	249
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	_	1	1 1	1 1	1	2079764-1 2119083-1	WASHER, WAVE SPRING, CREST-TO-CREST RETAINER, INSULATION DIAL	243
	_	_	2		_	2168400-7	SHCS, LOW HEAD, ROHS, M5 X 10	240
	_	_	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
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	-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	_ _	- 1	REF	_ 1	- 1	1901697-1 6-993111-6	FEED FINGER ASSEMBLY, EF	183
	_	1	1	1	1	8-22280-7	PIN, SLOTTED SPRING 3.0 X 14.0 SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	_	1 –	<u> </u>	<u>1</u> 2	1 –	1901680-2 21045-3	GUIDE PIN, HOLDDOWN RING, RETAIN, EXTERN, 3/16 CRESCENT	174
	_	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	_	REF	REF	$\frac{REF}{^{1}}$	REF	994970-2	COUNTER, MAGNETIC	164
	_	1	1	1	1	240638-1 8-21084-1	SPRING, FEED FINGER O-RING, .801 ID, .070 DIA. MAT.	163
	-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	152
	_	1	1	1 1	1	2119798-2 2079383-8	DETENT PIN SCR, BHSC, RoHS (M4 X 16)	1 4 5
	_	_	-	<u> </u>	1	2119653-2	FEED CAM, POST FEED	144
	_	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	1 4 1
	_	1	1	1	1	2119651-1 2119092-2	RAM, ASIAN STYLE, END FEED BOLT, ADJUSTMENT	1 4 0
٨	_	-	-	1	_	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
4	-		REF	_	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
		1	1	 1	1	1633743-1 455888-3	SERVO FEED LATCH ASM SPACER, CRIMPER	133
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	_	2	2	2	2	2 - 1 8 0 3 2 - 2 2 1 1 9 7 4 0 - 1	SCR, SET, FLT POINT M3 X 10.0 TAG, IDENTIFICATION	70
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, ROHS	66
	-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	6.5
	_	3	3	3	3	2119793-1 992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	63
	-	-	-		1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	_	4	4	<u>-</u> 4	1 4	2063961-1 2168400-4	FEED FINGER SHCS, LOW HEAD, ROHS, M4 X 8	58
	_	2	2	2	2	2168083-2	SCR, SKT HD CAP, ROHS, M4 X 8.0	56
	-	2	2	2	2	5018030-2	NUT, HEX, REG, ROHS, M4	55
	-	2	2 2	2	2	5018030-1 986965-8	NUT, HEX, REG, ROHS, M3 NUT, LOCK, HEX, TORQUE (M4)	5 4 5 3
	_	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	_	- 1	1	1	_ 1	2119792-1	PAWL, EF, AIR	51
		_	_	1	2	1752354-4 18023-9	STANDOFF, HOLD-DOWN SCR, SKT HD CAP M4 X 6.0	50
	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	_	1	1 1	<u>1</u> 1	1	2079383-7 2119645-1	SCR, BHSC, ROHS (M8 X 25) DISC, NUMBERED FA WIRE ADJUSTMENT	41
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	_	8	8 2	8	8	1 - 18028 - 2 2168083 - 9	WASHER, FLAT, REG M4 SCR, SKT HD CAP, ROHS, M4 X 20	33
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	_	2	1 2	1 2	2	2 4 0 6 3 9 - 1 1 3 2 0 9 0 6 - 1	STRIPPER (MACHINING) STUD, THREADED	27
	_	1	1	1	1	1752371-9	PLATE, STRIP GUIDE	24
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1	_	1	1	1	1	240833-2	PLATE, REAR SHEAR	1 1
/1	1	1	1	1	1	690482-4 8-1633384-2	PLATE, FRONT SHEAR ANVIL, COMBINATION	9 8
	_	1	1	1	1	690474-4	BLADE, SLUG	7
	_	1	1 1	1	1	240641-8 1-238009-4	SPACER BLOCK, FL CRIMPER SPACER	5 4
1	1	1	1	1	1	1-2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
<u>/1</u>	7 7					456402-1	CRIMPER, WIRE PREMIUM	I TEM
THIS DRA			- 25			PART NO	DESCRIPTION	NO

TE Connectivity

Harrisburg, PA 17105-3608

Ocean End Feed Applicator

SIZE CAGE CODE DRAWING NO

STOMER ACCESSIBLE PRODUCTION DRAWING

| 00779 | C-2150222

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

REVISIONS

DESCRIPTION

- SEE SHEET 1

DATE DWN APVD

SET UP GAUGE

2119599-2

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

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B. WEAVER

. STAKEM APVD G. BAILEY

APPLICATION SPEC

2063440-1

2168400-7 (QUANTITY 2)

2168400-7 (QUANTITY 2)

2063440-1

A 66

AMP 4805 REV 31MAR2000

0.60mm2

0.50mm2

0.35mm2

0.30mm2

1 RECOMMENDED SPARE PARTS

ACTUATE THE COUNTER.

2 GREASE BEARING SURFACES LIGHTLY

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT SIZE REFERENCE SETTING

1.14+/-0.05 [.045+/-.002]

1.09+/-0.05 [.043+/-.002]

1.02+/-0.05 [.040+/-.002]

0.99+/-0.05 [.039+/-.002]

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

SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.

NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

5. 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.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:

/8\ MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY

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.

ORIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE

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

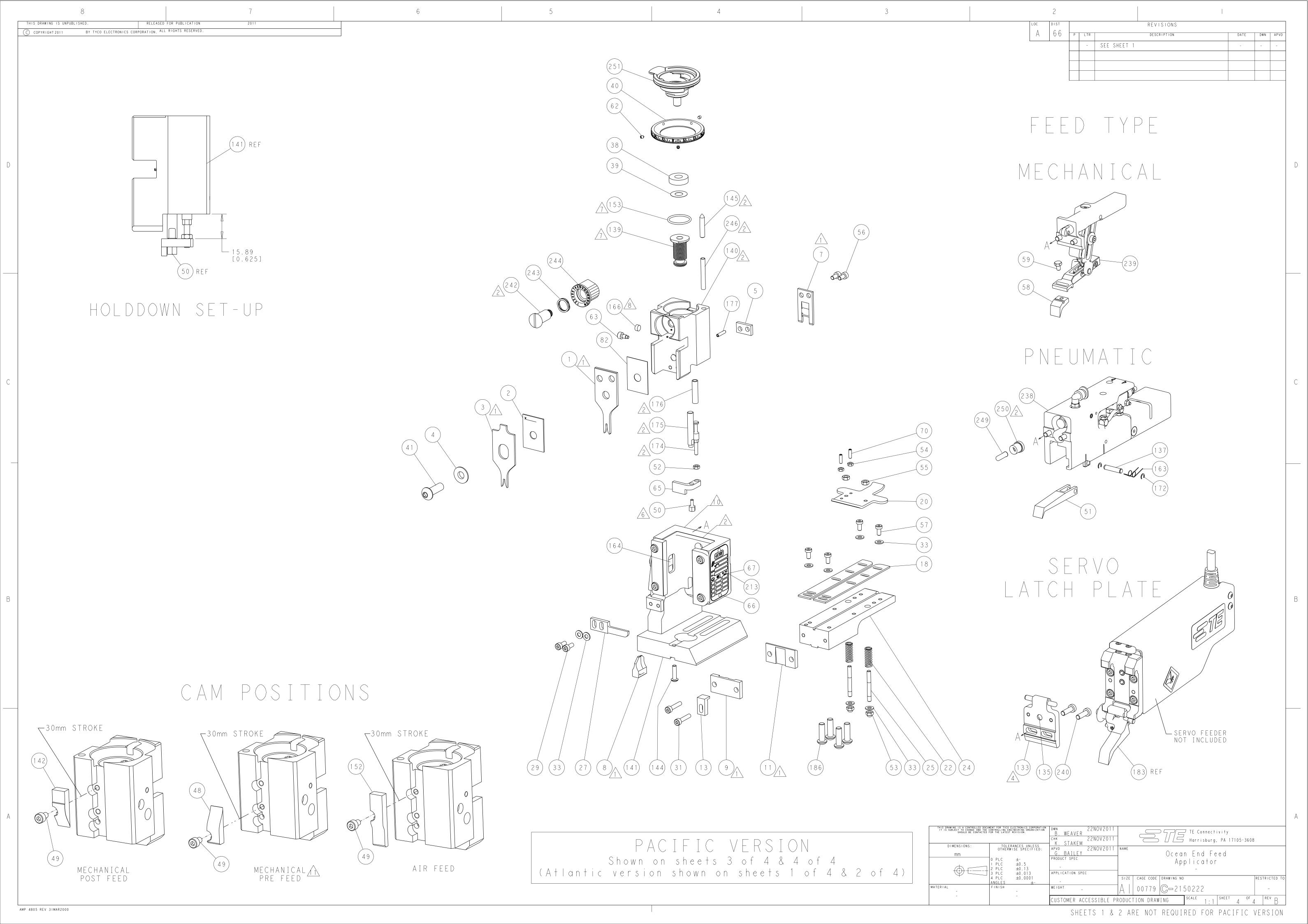
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150222-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150222-4

5.7

6.3

7.1

7 4



Mouser Electronics

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TE Connectivity: 2150222-2