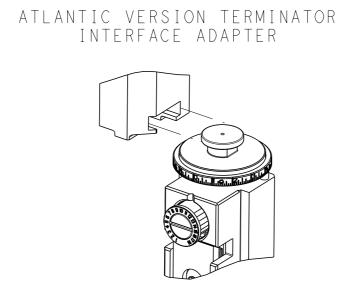
C COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE				
2151612-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151612-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7 - 2 1 5 1 6 1 2 - 1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7 - 2 1 5 1 6 1 2 - 2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7 - 2 1 5 1 6 1 2 - 7	D	CRIMP TOOLING KIT	-				

RELEASED FOR PUBLICATION



AMP 4805 REV 31MAR2000

THIS DRAWING IS UNPUBLISHED.

	APPLICATOR DATA
	CRIMP SIZE TYPE
	WIRE 1.96 mm [.077] F
	APPLICATOR INSTRUCTIONS
	408-35042
	TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION
	TERMINAL NAME: TERMINAL
	WIRE STRIP LENGTH INSULATION DIAMETER RANGE
	5.01-5.02 mm [.197198 IN] Ø1.96-2.64 mm [.077104 IN]
	TERMINAL DELPHI SPECIFICATION
	SPECIFICATION
	TERMINALS APPLIED
	TE TERMINAL   DELPHI TERMINAL   TE TERMINAL   DELPHI TERMINAL
	1642331-1 12110844
	WIRE CRIMP HEIGHT CRIMP HEIGHT 4
	SIZE mm [INCH] REFERENCE SETTING 1.00mm2 1.50+/-0.05 [.059+/002] 8.7
	0.80mm2 1.40+/-0.05 [.055+/002] 9.6
	1 RECOMMENDED SPARE PARTS
	2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND
I	STORAGE OF APPLICATOR.
	APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
	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.
	5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER
	DOCUMENT, 101-35000.

\*WARNING ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

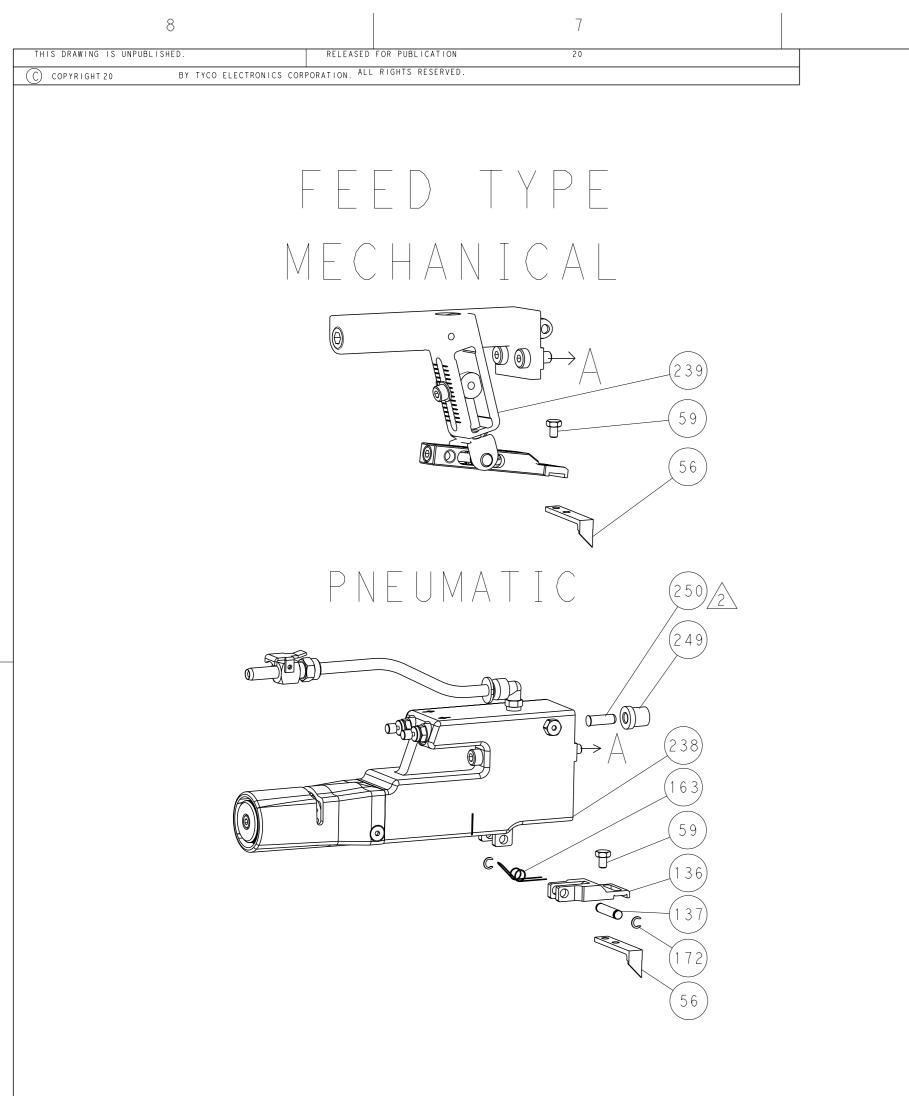
MATERIAL

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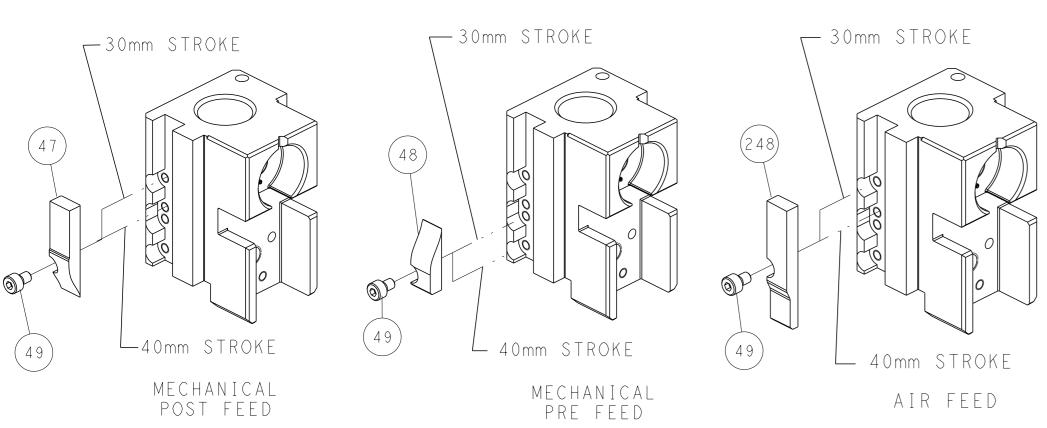
	2								
С	DIST		REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD		
			А	RELEASED	24APR2012	LG	GB		
			В	ECR-19-004659	24MAR2019	ТΒ	СТ		
			С	ECR-19-006699	26APR2019	ΜZ	ΤE		
			D	ECR-19-006948	30APR2019	LG	ΤE		

1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
1	-	1	-	1803259-1	BUSHING, FLANGED	249	
1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	1			2119083-1	RETAINER, INSULATION DIAL	242	
	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241	
-	1	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
2	-	2	-	2063440-1 21045-3	AIR FEED MODULE	238	
RE		REF	REF		RING, RETAIN, EXTERN, 3/16 CRESCENT COUNTER, MAGNETIC	164	
				240638-1	SPRING, FEED FINGER	163	
1		1	_	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
1		1	_	2119799-1	HOLDER, FEED FINGER, AF	136	
1	1	1	1	455888-9	SPACER, CRIMPER	120	С
1	1	1	1	2844908-1	SCREW, LOCKING	99	
1	1	1	1	2844907-1	POST, LOCKING	98	
1	1	1	1	455888-6	SPACER, CRIMPER	82	
1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
1	1	1	1	2119943-1	WASHER, SPACER	69	
1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
1		1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
1	1	1	1	5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59	
1	1	1	1	1 3 3 8 6 8 5 - 1	PAWL, FEED	56	
4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
1	1	1	1	1752356-1	SUPPORT, TERMINAL	34	F
2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
2	2	2	2	2 - 2 8 4 4 9 6 2 - 6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
1	1	1	1	1 - 455888 - 0	SPACER, CRIMPER	28	
1	1	1	1	1320928-2	STRIP GUIDE	24	
1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
2	2	2	2	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	20	
1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	1	1	1	2119806-1	INSERT, SHEAR	13	
1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
1	1	1	1	1 - 356885 - 4	STOP, SHEAR		
1		1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1		1	1	434210 3	FLOATING SHEAR, FRONT	9	
2	2	1	1	1633928-5	ANVIL, COMBINATION	8	
1	1	1	1	240641-1	SPACER		
-	-	-	-			6	
1				2119757-8	DEPRESSOR, SHEAR	5	
				2-238011-1	BLOCK, CRIMPER SPACER	4	
2	2			3-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
		1	1	455888-3	SPACER, CRIMPER	2	
2	2			1633305-1	CRIMPER, WIRE PREMIUM	   T T F 1/	
- 7	2 - 71	- 2	- 1	PART NO	DESCRIPTION	ITEM NO	A
CUMENT E CONTI D FOR	FOR TYCO ELEC ROLLING ENGINE THE LATEST REV	TRONICS COR ERING ORGAN	PORATION IZATION	DWN 15FEB2012	TE Connectivity		
				<u>Ү.ҮIN</u> снк 15FEB2012 G.BAILEY	Harrisburg, PA 17105-3608		
	TOLERAN OTHERWIS	CES UNLE E SPECIF	ISS IED:	APVD 15FEB2012 S.XI	NAME		
		±-		S.XI PRODUCT SPEC	_ Ocean Side Feed Applicator		
12	PLC :	±- ±- ±-		- APPLICATION SPEC			
4		±- ±- ±		-	SIZE CAGE CODE DRAWING NO REST	RICTED TO	
	NISH	-		WEIGHT _	A   00779 C=2151612		
		-			DODUCTION DRAWING SCALE , SHEET , OF ,	REV	

JSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 1 OF 4 REV D SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

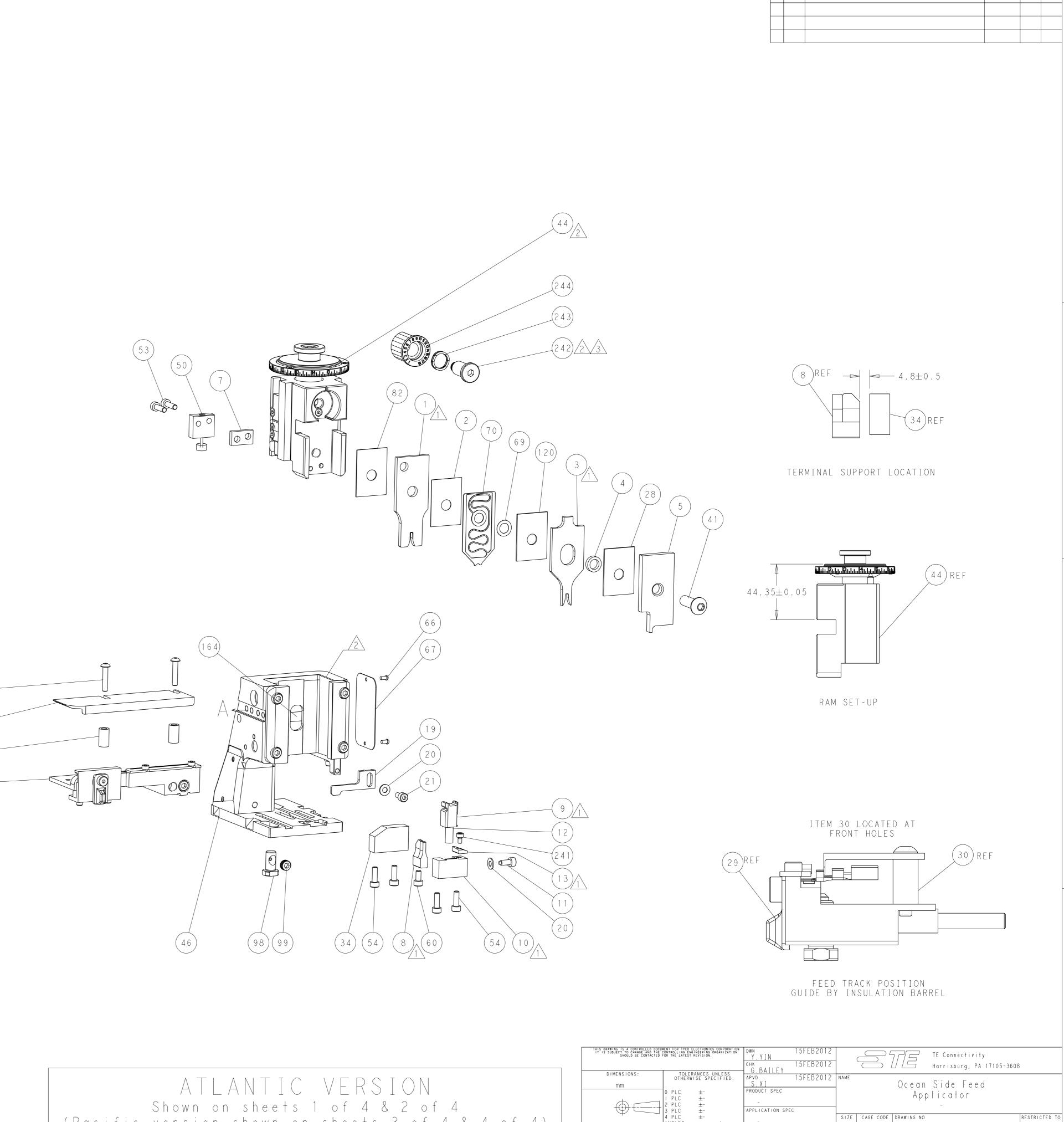






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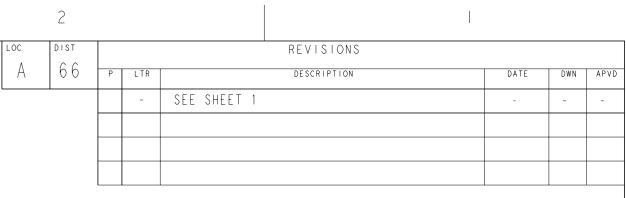


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(33)

ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) MATERIAL FINISH











00779 C-2151612

	8		7		6				
	THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION ONICS CORPORATION. ALL RIGHTS RESERVED.	20		PACIFIC VERSION TERMINATOR				
	PART NUMBER REVISION	DESCRIPTION	FEED TYPE		INTERFACE ADAPTER				
	2 - 2151612 - 1 D 2 - 2151612 - 2 D 7 - 2151612 - 7 D	FINE CRIMP HEIGHT ADJUST FINE CRIMP HEIGHT ADJUST CRIMP TOOLING KIT	MECHANICAL PNEUMATIC -	-					
D									
	APPLICATOR DA CRIMP SIZE WIRE 1.96 mm [.077] INSUL 2.67 mm [.105] APPLICATOR INSTRUCTIO 408-35042	TYPE F F							
С	APPLICATION SPECIFICATION TERMINALS APPLIED TE TERMINAL DELPHI	INAL INSULATION DIAN 01.96-2.64 mm [.0 SPECIFICATION - 	1ETER RANGE						
	WIRE CRIMP HEIGHT CRIMP HEIGHT   SIZE Incomm2 Incomm2 Incomm2   1.40+/-0.05 Incomp2 Incomm2   Incomm2 Incomm2 Incomp2   Incomm2 Incomp2 Incomp2   Incomm2 Incomp2 Incomp2   Incomm2 Incomp2 Incomp2   Incomm2 Incomp2 Incomp2   Incomp2 Incomp2 Incomp2								
В	STORAGE OF APPL APPLY PART NUMB CRIMP HEIGHT RE APPLICATOR WAS O NECESSARY WHEN F	ED INSTRUCTION SHEET FOR CLE ICATOR. ER 2-23419-6 LOCTITE TO THRE FERENCE SETTING WAS THE SETT QUALIFIED AT THE FACTORY. AD RUNNING APPLICATOR IN THE FI D OTHERWISE TORQUE VALUES SH	ADS OF ITEM 242. ING USED WHEN THE JUSTMENT MAY BE ELD.	AND					
А									

AMP 4805 REV 31MAR2000

\*WARNING ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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PACIFIC VERSION

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

3

		-	1	1	18023-1	SCR, SKI HD CAP M3 X 5.0	241	
		-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
	Γ	-	1	-	2063440-1	AIR FEED MODULE	238	
	F	_	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
	ŀ	_	REF	REF		COUNTER, MAGNETIC	164	
	ŀ	_	1	-		SPRING, FEED FINGER	163	
	+		1					
	+	-		-		FEED CAM, AIR FEED	151	
	ļ	-	1	1		SCR, SKT HD CAP, RoHS, M4 X 16	144	
		-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	1 4 3	С
		-	-	1	2119653-2	FEED CAM, POST FEED	142	
	Γ	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
	F	_	1	1		RAM ASSEMBLY, SF PACIFIC	140	
	F	_	1	-		PIN, RETAIN, GRVD, 3/16 X .854	137	
	ŀ	_	1	_		HOLDER, FEED FINGER, AF	136	
	+		1	1				
	+	-				SPACER, CRIMPER	120	
	-	-				SCREW, LOCKING	99	
		-	1	1	2844907-1	POST, LOCKING	98	
		-	1	1	455888-6	SPACER, CRIMPER	82	
		-	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
		-	1	1	2119791-9	DEPRESSOR, WIRE	70	
	F	-	1	1		WASHER, SPACER	69	
	F	_	1	1		TAG, IDENTIFICATION	67	
	F	_	2	2		SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	ŀ		1	1				
	+	-			5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-				PAWL, FEED	56	
	-	-	2	2		SCR, SKT HD CAP, Rohs, M4 X 14	53	
		-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
		-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
		-	-	1	2119652-1	FEED CAM, PRE FEED	48	
		-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
	F	-	1	1	1752356-1	SUPPORT, TERMINAL	34	В
	F	_	2	2		SCR, BHSC, RoHS (M4 X 20)	33	D
	ŀ	_	2	2		SPACER, CYLINDRICAL, STRIP GUIDE	30	
	ŀ		1	1			-	
	ŀ	_	1	1		ASSEMBLY, STRIP GUIDE	29	
	-	-				SPACER, CRIMPER	28	
		-	1	1		STRIP GUIDE	24	
		-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
		-	2	2	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	20	
	.	-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
E	1	-	1	1	2119806-1	INSERT, SHEAR	13	
		_	1	1		SPRING, COMPRESSION	12	
	F	_	1	1		STOP, SHEAR		
ΤO	$\Lambda$	_	1	1		SHEAR HOLDER, FRONT	10	
		_	1	1		FLOATING SHEAR, FRONT	9	
		1	1	1				
	$\angle 1 \downarrow$	I	1	1		ANVIL, COMBINATION	8	
	ŀ	-			240641-1	SPACER		
	ļ	-	-	-	-	-	6	
	ļ	-	1	1		DEPRESSOR, SHEAR	5	
		-	1	1	2 - 2 3 8 0 1 1 - 1	BLOCK, CRIMPER SPACER	4	
	<u>_1</u> \[	1	1	1	3-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
		-	1	1	455888-3	SPACER, CRIMPER	2	
	1	1	1	1	1633305-1	CRIMPER, WIRE PREMIUM	1	
			~ ~	~ ^			ITEM	٨
		- / /	- 2 2	- 21	PART NO	DESCRIPTION	NO	А
THIS DRAWING IS A CONTROLLED D IT IS SUBJECT TO CHANGE AND T SHOULD BE CONTACT	OCUMENT FOR THE CONTROLL TED FOR THE	R TYCO ELEC ING ENGINE LATEST REV	TRONICS CORF ERING ORGANI ISION.	ZATION C	Y.YIN 15FEB2012	TE Connectivity		
					:нк 15FEB2012	Harrisburg, PA 17105-3608		
DIMENSIONS:	0.	TOLERAN THERWISE	CES UNLE SPECIF	SS IED: A	G.BAILEY 15FEB2012	NAME		
mm	0 PL		±-	L	<u>S.XI</u> product spec	Ocean Side Feed		
<b></b>		С =	±- ±-		-	Applicator		
	3 PL	C =	±- ±-	A	APPLICATION SPEC		RICTED TO	
MATERIAL	ANGL FINIS	ES	- ±·		- /F I G H T		ICIED IO	
		-		Ľ	/EIGHT _	A   00779  C=2151612		
				(	CUSTOMER ACCESSIBLE PI	RODUCTION DRAWING SCALE 1:2 SHEET 3 4	rev D	
					SHFFTS 1 &	2 ARE NOT REQUIRED FOR PACIFIC VER	SION	

PUSH ROD, AIR FEED

BUSHING, FLANGED

RETAINER, INSULATION DIAL

SCR, SKT HD CAP M3 X 5.0

CAM, SNAIL, INSULATION ADJUSTMENT

WASHER, WAVE SPRING, CREST-TO-CREST

2119640-1

1803259-1

2119082-8

2079764-1

2119083-1

18023-1

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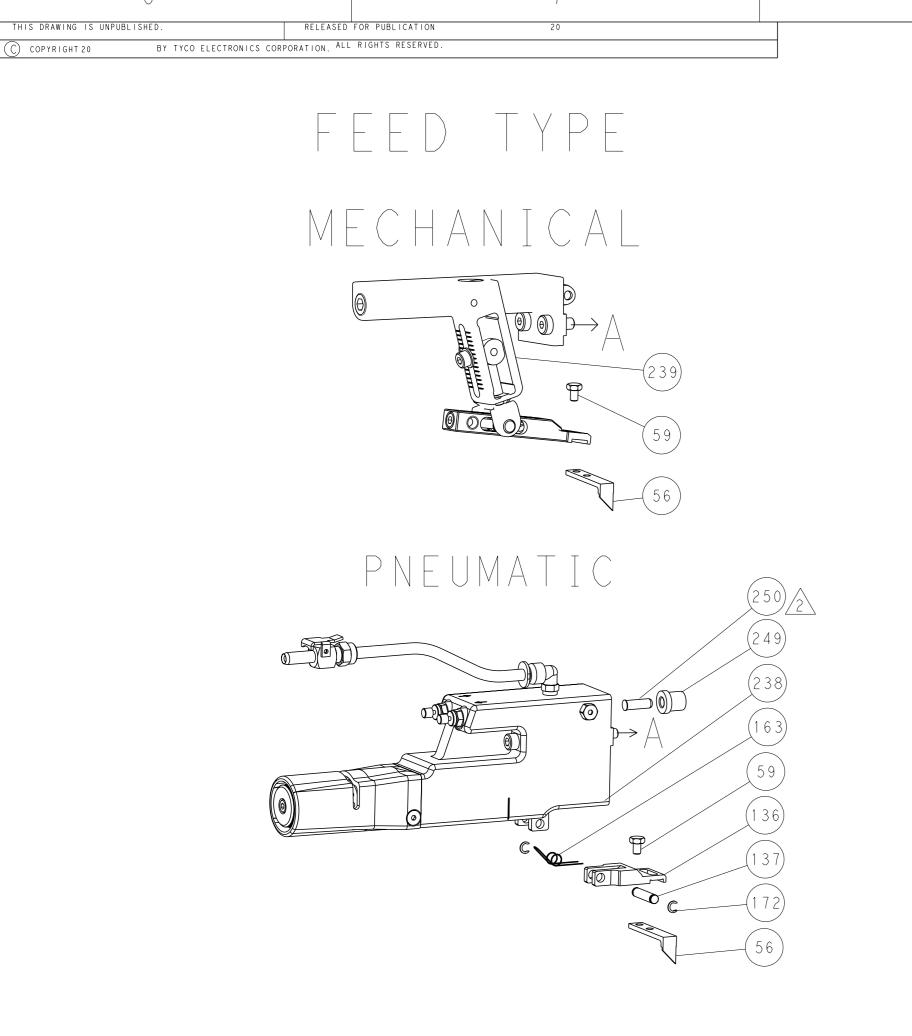
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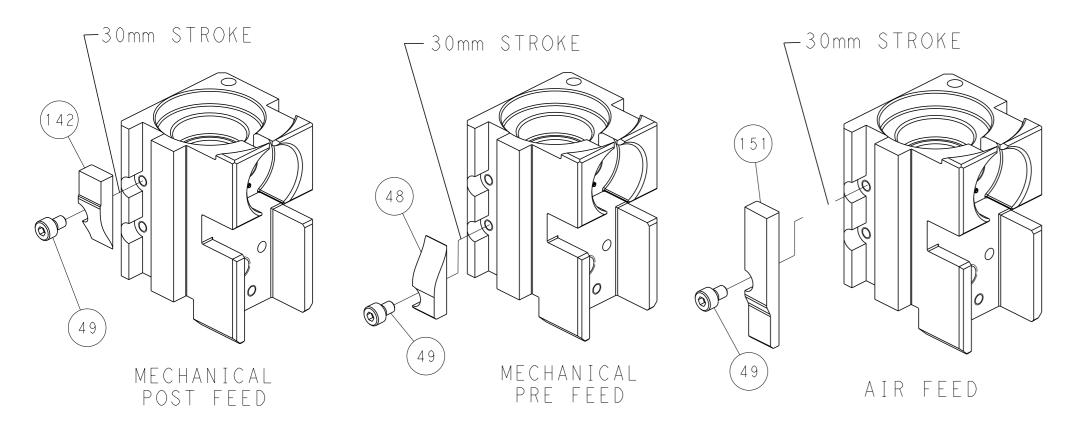
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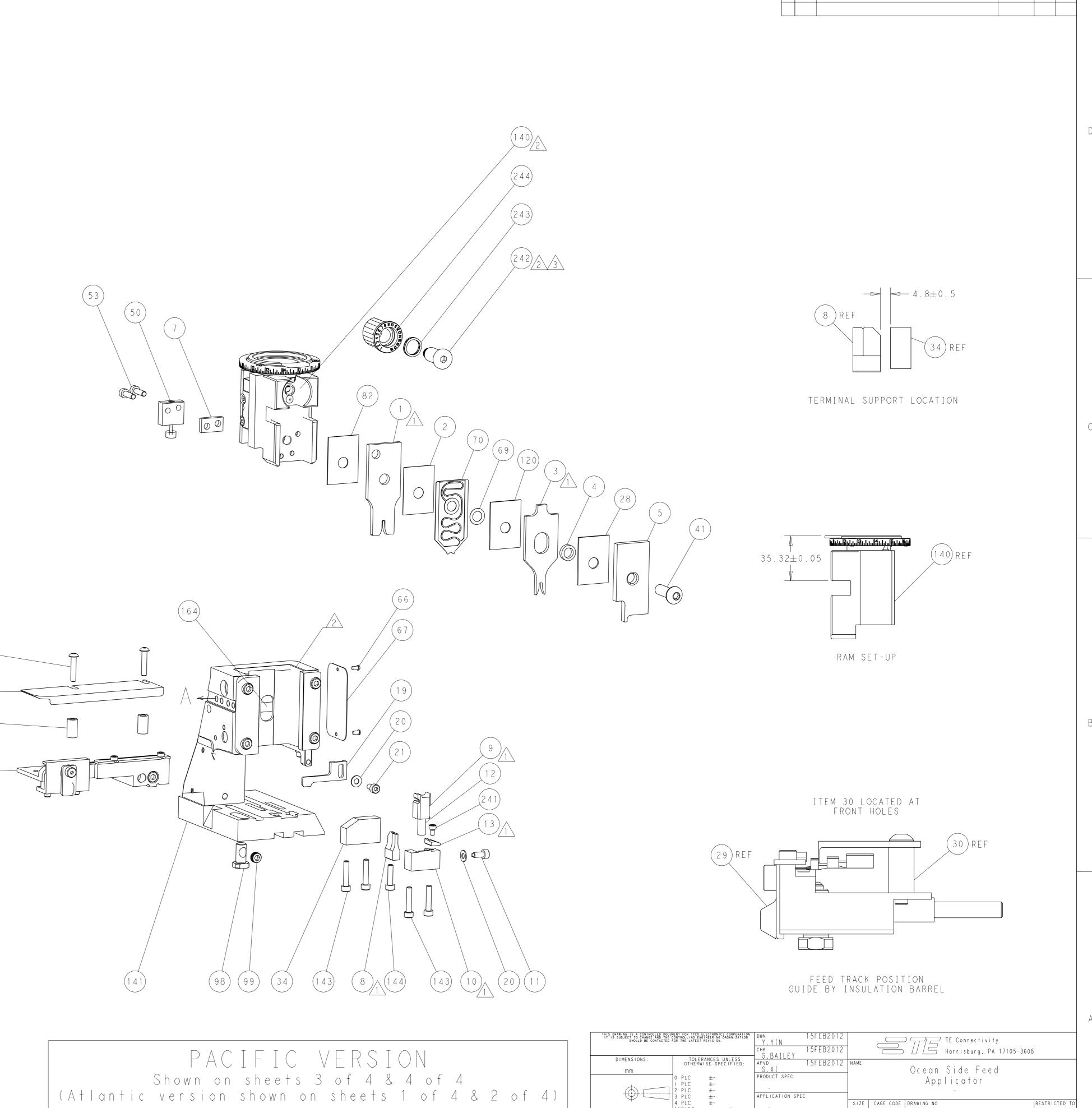
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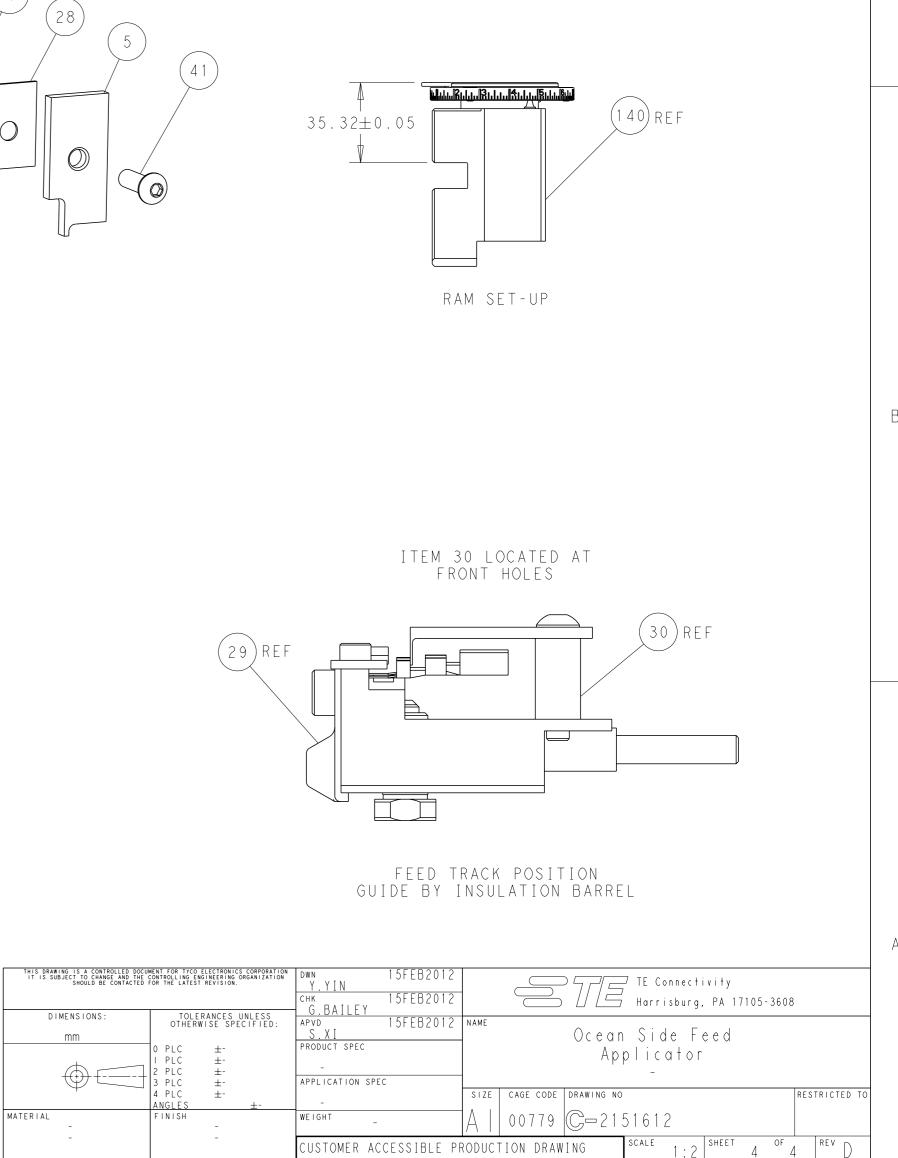
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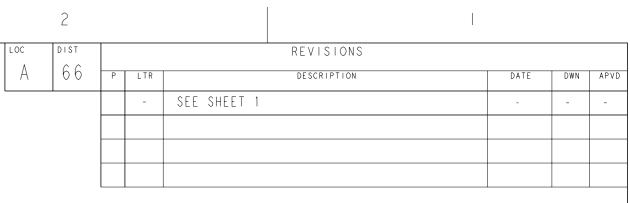


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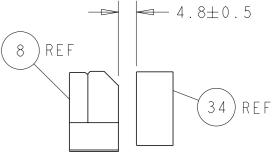
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