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P A R T N U M B E R	REVISION		DE	SCRIPTION							

TOOLING KIT CRIMP TOOLING KIT

		FOR PUBLICATION		20	
01	NICS CORPORATION. ALL	RIGHTS RESERVED.			
	DES	SCRIPTION		FEED T	Y P E
	FINE CRIM	P HEIGHT	ADJUST	MECHANI	CAL
	FINE CRIM	P HEIGHT	ADJUST	PNEUMA	TIC
		CAL AND C DLING KIT		MECHANI	CAL
		IC AND CI	RIMP	PNEUMA	TIC

-

INTERFACE ADAPTER	

ATLANTIC VERSION TERMINATOR

2266419-1

2266419-2

7 - 2 2 6 6 4 1 9 - 1

7 - 2 2 6 6 4 1 9 - 2

7 - 2 2 6 6 4 1 9 - 7

D

D

D

	A	P P L I C A ⁻	TOR DATA	4							
	CRIMP	S	ΙΖΕ	TYPE	-						
	WIRE	1.40 mm	[.055]	F							
	INSUL	1.67 mm	[.066]	0							
	APPLICA	TOR INS 408-350	TRUCTIONS 42								
	TERMINA	L DATA:	KOSTAL T	ERMINAL	KOSTAL (CRIMP SP	ECIFICAT	ION			
	TERMINA	L NAME:	KOSTAL	MLK 1	.2m RECE	PTACLE					
	WIRE	STRIP LE	ENGTH ,		INSULATION DIAMETER RANGE						
	2.60-3.60) mm [.102	142 IN]		Ø1.20-1.4	0 mm [.047	055 [N]				
	TERMINAL		DOC0006154	IO ATTACH	HMENT 3 PG. 5	0 OF 57	-				
<u>,</u>	APPLICA SPECIFIC		-		-		-				
	TERMIN	NALS AF	PLIED								
	TE TEF	RMINAL ·	KOSTAL TE	RMINAL ·	TE TERMINA	AL KOS	KOSTAL TERMINAL				
	19499		3 21 24 73	401 0/3	1949957-2	2 3 2					
		957-3		401 0/3	1572680-1						
		680-2		176 0/3	1572680-3						
	19493			406 0/3	1949380-2	2 3 2	3 21 25 73406 0/3				
	19493	380-3	3 21 40 73	406 0/3							
							~				
	W I R E S I Z E		CRIMP mm [IN	HEIGH NCH]		CRIMP H REFEREN	HEIGHT /	<u>4</u> I NG			
	0.3	35mm2	0.76+/-0	.03 [.03	0+/001]		6.9				

AMP 4805 REV 31MAR2000

1 recommended spare parts

2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

4 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

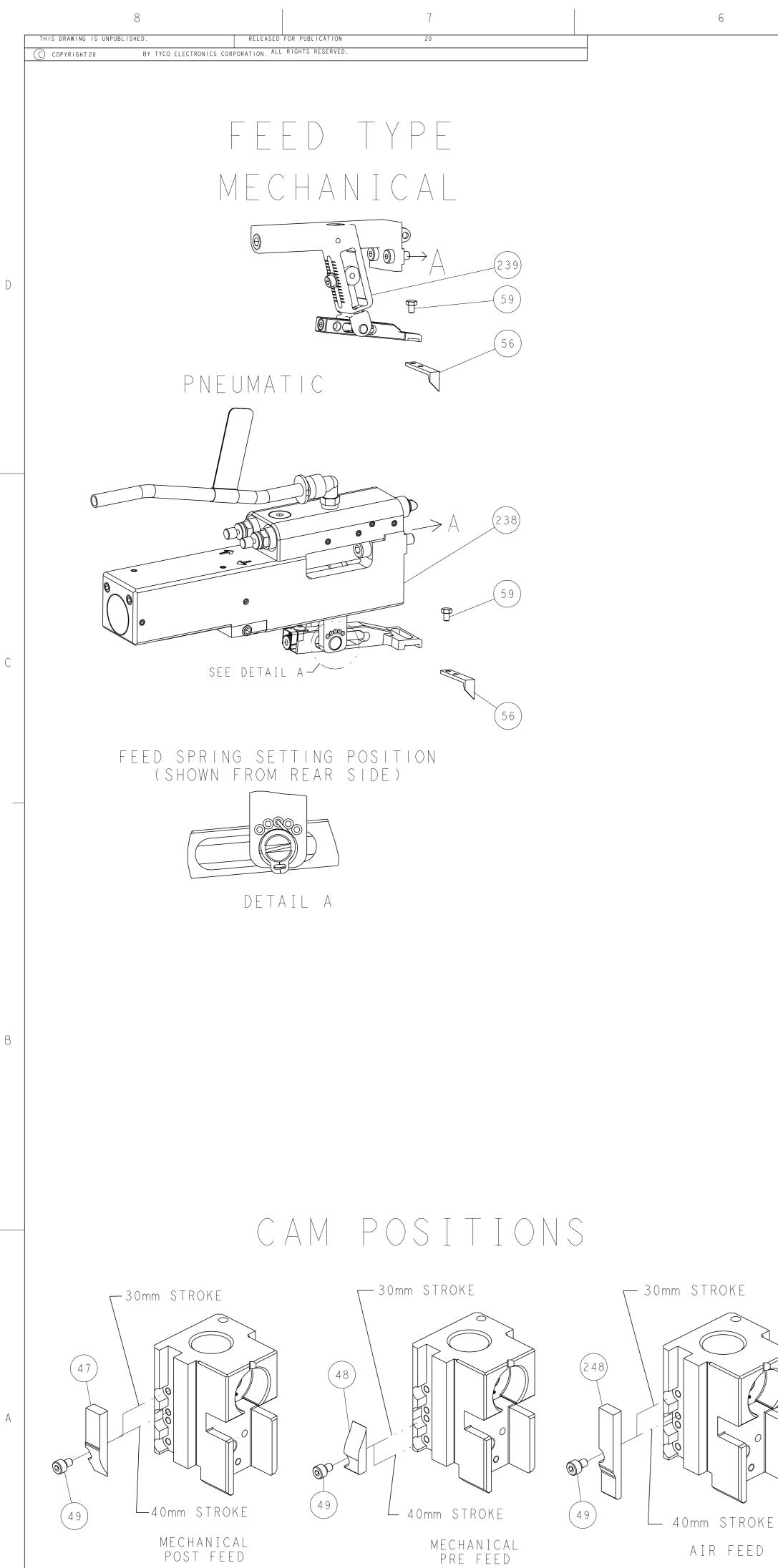
DIMENSIONS: mm \bigcirc

	2										
LOC	DIST			REVISIONS	REVISIONS						
A	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD				
<u>.</u>	•		В	ECR-17-017161	21NOV2017	JAH	ΤE				
			B 1	ECR-18-014882	19SEP2018	КН	СТ				
			С	ECR - 19 - 014046	09SEP2019	FΖ	TE				
			D	ECR-20-015755	04NOV2020	JWC	GB				

FEED CAM, AIR FEED 2119641-1 248 1 - 1 1 1 1 1 2119082-5 244 CAM, SNAIL, INSULATION ADJUSTMENT 2079764-1 |WASHER, WAVE SPRING, CREST-TO-CREST 2119083-1 RETAINER, INSULATION DIAL SCR, SKT HD CAP M3 X 4.0 7 - 1 8 0 2 3 - 1 241 MECHANICAL FEED ASSEMBLY 2119580-1 1 -AIR FEED MODULE 2844940-1 – 1 REF REF REF REF 994970-2 COUNTER, MAGNETIC 2844908-SCREW, LOCKING POST, LOCKING 2844907-1 455888-6 SPACER, CRIMPER 1803607-3 DOCUMENTATION PACKAGE 2119740-TAG, IDENTIFICATION 6 / 2 2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 66 - | 1 | 1 | 1 | 1 SCR, SKT HD CAP, Rohs, M4 X 8.0 2168083-60 - | 1 | 1 | 1 | 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59 - | 1 | 1 | 1 | 1 | 1338685-1 |PAWL, FEED 56 SCR, SKT HD CAP, RoHS, M4 X 12.0 - 4 4 4 4 2168083-3 54 - 2 2 2 2 2-2168083-5 SCR, SKT HD CAP, RoHS, M4 X 14 53 HOLD DOWN, SPRING LOADED 50 - | 1 | 1 | 1 | 1 1803382-1 - 1 2 1 2 SCR, SKT HD CAP M4 X 6.0 49 18023-9 FEED CAM, PRE FEED 48 2119652-1 47 1 – 2119653-1 FEED CAM, POST FEED 46 APPLICATOR BASIC ASSEMBLY, SF 1803583-9 44 1803515-1 RAM ASSEMBLY, SF ATLANTIC 41 1803602-1 SCR, BHSC, RoHS (M8 X 25) 34 2-1752356-0 SUPPORT, TERMINAL SCR, BHSC, RoHS (M4 X 20) 2079383-5 2 2 2 2-2844962-4 SPACER, CYLINDRICAL, STRIP GUIDE 30 2 2 2 2 ASSEMBLY, STRIP GUIDE 2844992-2 SPACER, CRIMPER 455888-3 28 1320928-6 STRIP GUIDE SCR, SKT HD CAP, RoHS, M4 X 8.0 2168083-2 21 2 2 2 2 2 WASHER, FLAT, REG M4 20 1 - 1 8 0 2 8 - 2 2119533-1 STRIPPER, SIDE FEED 19 2119806-1 INSERT, SHEAR 3-22280-3 SPRING, COMPRESSION 1-356885-4 STOP, SHEAR 1 1 2119805-1 SHEAR HOLDER, FRONT 1 (1803095-6 FLOATING SHEAR, FRONT 1 2 2 1 1 ANVIL, COMBINATION 1 - 1 8 0 3 5 5 4 - 5 SPACER 240641-1 2119757-1 DEPRESSOR, SHEAR 1 | 1 | 1 | 1 BLOCK, CRIMPER SPACER 3-238011-3 CRIMPER, INSULATION O PREMIUM 7-1633965-6 1 2 2 1 1 SPACER, CRIMPER 455888-5 1 2 2 1 1 2-1633664-7 CRIMPER, WIRE ITEM - 7 7 | - 7 2 | - 7 1 | - 2 | - 1 | DESCRIPTION PART NO NO THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOLLD BE CONTACTED FOR THE LATEST REVISION. TE Connectivity Harrisburg, PA 17105-3608 23JULY2014 J.HOU 23JULY2014 Y.YIN TOLERANCES UNLESS OTHERWISE SPECIFIED: 23JULY2014 NAME U.GUO PRODUCT SPEC Ocean Side Feed PLC Applicator PLC ±-±-APPLICATION SPEC 3 PLC SIZE CAGE CODE DRAWING NO PLC RESTRICTED TO ±-|| 00779 || C = 2266419FINISH

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

ustomer Accessible Production Drawing SCALE 1.2 SHEET 1 OF A REV

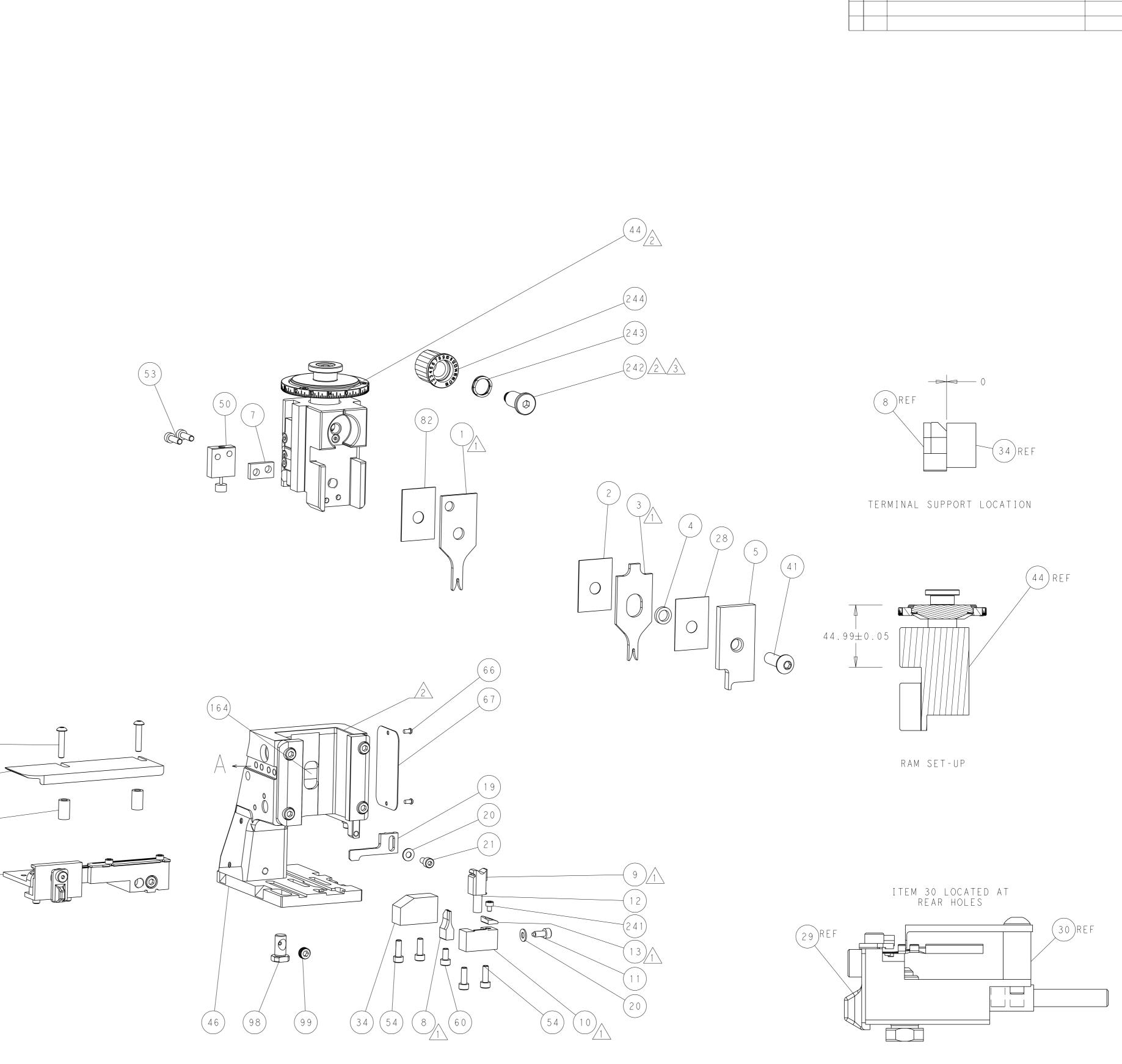


AIR FEED

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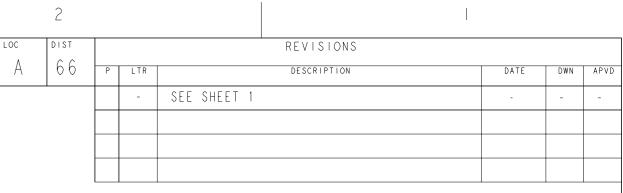
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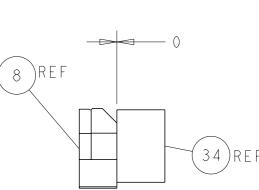


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4

DIMENSIONS: ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) mm \odot MATERIAL





В

FEED TRACK POSITION GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUM IT IS SUBJECT TO CHANGE AND THE C SHOULD BE CONTACTED F	MENT FOR TYCO CONTROLLING EN FOR THE LATEST	ELECTRONICS CORPORATION IGINEERING ORGANIZATION REVISION.	dwn J.HOU	23JULY2014			775	TE Connecti	vity		
			снк Ү.ҮІМ	23JULY2014	——————————————————————————————————————					3	
DIMENSIONS:	OTHERV	RANCES UNLESS NISE SPECIFIED:	APVD	23JULY2014	NAME Ocean Side Feed						
mm			U.GUO								
	0 PLC	±-	PRODUCT SPEC		Applicator						
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- Customer Accessib						ion Draw	ing	scale 1:2	sheet 2	OF 2	4 REV D
			SHE E	ETS 3 & 4	A R E	NOT F	REQUIRI	ed for a	TLANT	IC	VERSION

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	THIS DRAWING IS UNPUBLI	BY TYCO ELECTRO	DNICS CORPORATION. AL	L RIGHTS RESERVED.			PACIFIC VERSION TERMINATOR INTERFACE ADAPTER
	NUMBER 2 - 2 2 6 6 4 1 9 - 1 2 - 2 2 6 6 4 1 9 - 2 7 - 2 2 6 6 4 1 9 - 7	REVISION D D B	FINE CRIM	MP HEIGHT ADJU MP HEIGHT ADJU	JST MECHAN	ICAL	
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	CRIMP WIRE 1.40 INSUL 1.67 APPLICATOR I	Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Image: Interformer Lange Interformer Lange: Interforer Lange Image: Interforer					
С	TERMINAL NAM	E: KOSTA LENGTH 102142 IN DOC0006 APPLIEC KOSTAL 3 21 24 3 21 24 3 21 24	ALMLK 1 - - - - - - - - - - - - -	.2m RECEPTA INSULATION D Ø1.20-1.40 mm MENT 3 PG. 50 OF - TE TERMINAL 1949957-2 1572680-1 1572680-3	CLE IAMETER RANGE [.047055 IN] 57 - - - - KOSTAL TERMINA 3 21 25 73401 0 3 21 40 65176 0 3 21 25 65176 0	L / 3 / 3 / 3	
В	WIRE SIZE 0.35mm2	ENDED SPAR OF APPLI PART NUMBE	AP HEIGHT INCH] /-0.03 [.030 /-0.03 [.030 /-0.03 [.030 /-0.03 INSTRUCT CATOR. R 2-23419-	ION SHEET FOR C	ERENCE SETTI 6.9 :Leaning, lubri ireads of item	CATION AND 242.	
	APPLICA NECESSA 5. UNLESS	TOR WAS Q RY WHEN R SPECIFIED	UALIFIED A UNNING APPI OTHERWISE	T THE FACTORY. _ICATOR IN THE	ADJUSTMENT MAY FIELD.	BE	ON INSTALL For larges than the v
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TALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING RGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER HE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

THIS DRAWING IS A CONTROLLED DOC IT IS SUBJECT TO CHANGE AND THE SHOULD BE CONTACTED DIMENSIONS: mm MATERIAL

3

			K E F	994970-2	COUNTER, MAGNETIC		
	-	1	-	2119641-2	FEED CAM, AIR FEED	151	
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
	-	_	1	2119653-2	FEED CAM, POST FEED	142	
	-	1	1	1 - 1803583 - 0	APPLICATOR BASIC ASSEMBLY, SF	141	
	_	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
	_	1	1	2844908-1	SCREW, LOCKING	99	
	_	1	1	2844907-1	POST, LOCKING	98	
		1	1	455888-6	SPACER, CRIMPER	82	
		1	1	1803607-3	DOCUMENTATION PACKAGE	71	
		1	1			67	
		2		2119740-1	TAG, IDENTIFICATION		
	-		2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	-			5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1		1338685-1	PAWL, FEED	56	
	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
	-	1	1	1803382-1	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	
	-	1	1	2-1752356-0	SUPPORT, TERMINAL	34	В
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
	-	2	2	2 - 2 8 4 4 9 6 2 - 4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	455888-3	SPACER, CRIMPER	28	
	-	1	1	1320928-6	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	
\bigwedge	-	1	1	2119806-1	INSERT, SHEAR	13	
	-	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	1	1	1 - 356885 - 4	STOP, SHEAR	1 1	
\bigwedge	_	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
$\frac{1}{1}$] _	1	1	1803095-6	FLOATING SHEAR, FRONT -	9	
$\frac{1}{1}$	1	1	1	1 - 1 8 0 3 5 5 4 - 5	ANVIL, COMBINATION	8	
<u> </u>	-	1	1	240641-1	SPACER	7	
	-	_	_	_	-	6	
	_	1	1	2119757-1	DEPRESSOR, SHEAR	5	
	_	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4	
\bigwedge	1	1	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3	
<u> </u>		1	1	455888-5	SPACER, CRIMPER	2	
\wedge	1	1	1	2-1633664-7		<u> </u>	
<u> </u>				2-1033004-1	CRIMPER, WIRE		
	-77	- 2 2	- 21	PART NO	DESCRIPTION	ITEM NO	А
DOCUMENT F THE CONTRO	OR TYCO ELEC LLING ENGINE E LATEST REV	TRONICS CORF ERING ORGANI	PORATION [DWN 23JULY2014	TE Connectivity		
		10104.		<u>J.HOU</u> 23JULY2014			
	TOLERAN OTHERWISE	CES UNLE E SPECIF	SS IED: /	Y.YIN APVD 23JULY2014	NAME		
0 P	LC :	±-		U.GUO PRODUCT SPEC	Ocean Side Feed		
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3 P 4 P	LC :		1	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO REST	RICTED TO	
A N G F I N	LES ISH	±	- V	- VEIGHT _	A 00779 C-2266419	_	
		-			SCALE SHEET OF	REV	
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2079764-1

2119083-1

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2844940-1

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LOC	DIST			REVISIONS								
А	66	Р	LTR	DESCRIPTION	DESCRIPTION DATE DWN							
	1		-	SEE SHEET 1	-	-	-					

CAM, SNAIL, INSULATION ADJUSTMENT

RETAINER, INSULATION DIAL

SCR, SKT HD CAP M3 X 4.0

MECHANICAL FEED ASSEMBLY

AIR FEED MODULE

COUNTER, MAGNETIC

WASHER, WAVE SPRING, CREST-TO-CREST 243

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244

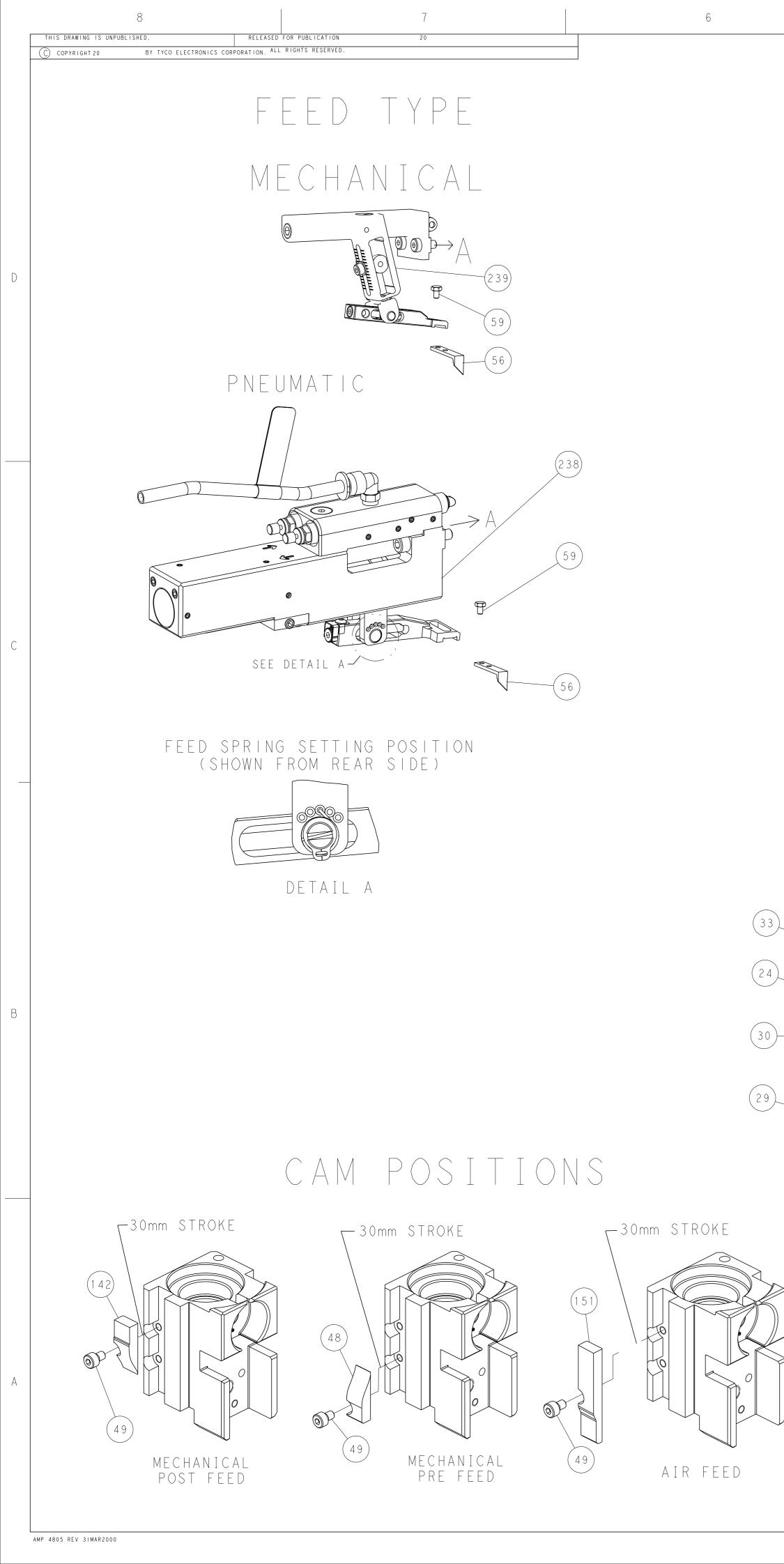
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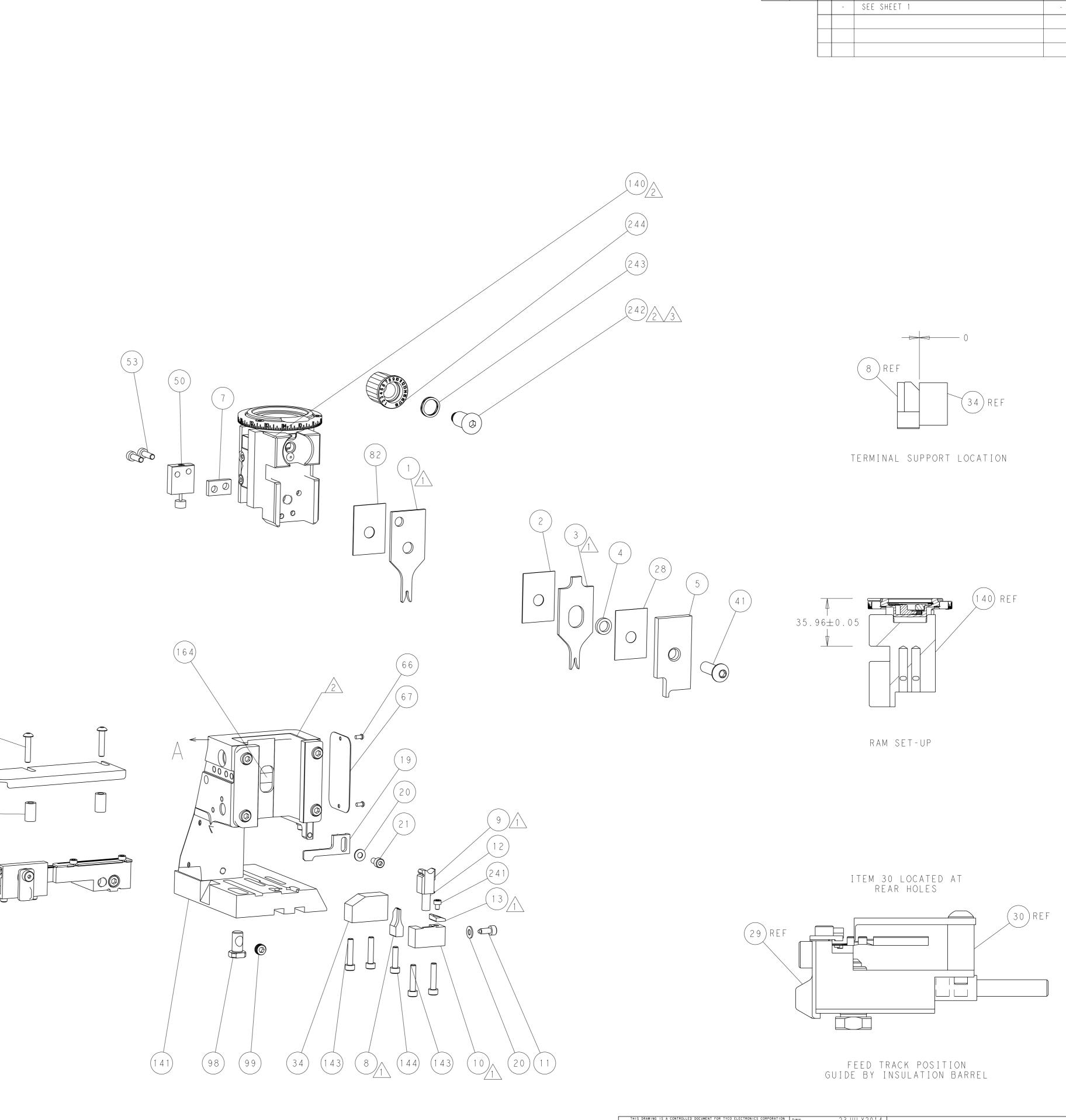
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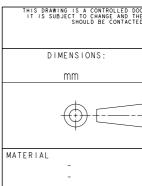
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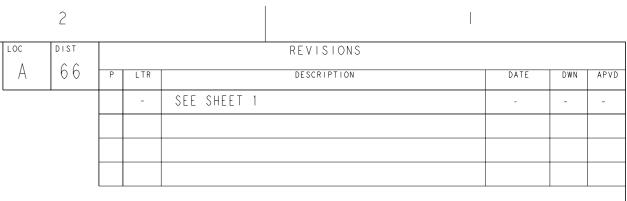
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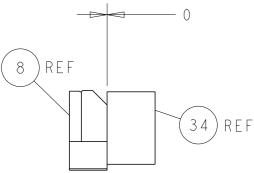


PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)











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TOLERANCES UNLESS OTHERWISE SPECIFIED:			ILESS IFIED:	APVD U.GUO	23JULY	Y2014	NAME Ocean Side Feed									
	0 PLC I PLC 2 PLC	±- ±- ±-		PRODUCT SPEC			Applicator									
	3 PLC 4 PLC	±- ±-		APPLICATION S	PEC		SIZE	CAGE CODE	DRAWING NO	,				R	ESTRICTE	D TO
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				SH	EETS	1 &	2 AF	RE NOT	REQUI	RED	FOR	PAC	IFIC	; V	ERSI	ON

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