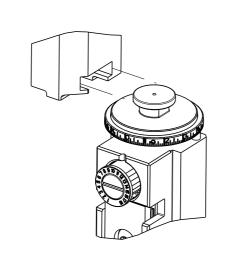
C COPYRIGHT 20	BY TYCO ELECTRO	NICS CORPORATION. ALL RIGHTS RESERVED.	_
P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE
2150653-1	В	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150653-2	В	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7 - 2150653 - 1	В	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7 - 2150653 - 2	В	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150653-7	A	CRIMP TOOLING KIT	-

RELEASED FOR PUBLICATION



ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

THIS DRAWING IS UNPUBLISHED

APPLICAT	OR DATA			
CRIMP SIZ	ZE TYPE			
WIRE 3.56 mm [.140] F			
INSUL 5.59 mm [. 220]			
APPL INSTRUC				
408-3504	3			
TERMINAL DATA:	TE TERMINAL	TE CR	IMP SPECIFICAT	ION
TERMINAL NAME:	RING TERMINA	4		
WIRE STRIP LE		1	DIAMETER RANG	F
5.56-6.32 mm [,	im [.130170 IN]	-
TERMINAL	114-2084	-	-	
APPLICATION				
SPECIFICATION	-	-	-	
TERMINALS AF	PLIED			
				1
TE TERMINAL - 63698-1	TE TERMINAL 61624-1	TE TERMINAL 61624-3	TE TERMINA	
		01024 0	12110001	
_				
WIRE SIZE ⊗ k] CRIMP HEIGH mm [INCH]		RIMP HEIGHT Eference sett	$\frac{4}{1}$
12 AWG				1110
2X 16 AWG	2.49+/-0.05 [.09		5.6	
1 4 AWG	2.24+/-0.05 [.08		8.8	
16 AWG	2.06+/-0.05 [.08		10.8	
			· · · · ·	

1 recommended spare parts

AMP 4805 REV 31MAR2000

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

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

A 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 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.

6 TERMINAL LUBRICANT IS RECOMMENDED.

UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*WARNING

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

ATLANTIC VERSION

THIS DRAWING IS A CONTROLLED IT IS SUBJECT TO CHANGE AND SHOULD BE CONTAC

DIMENSIONS:

USTOMER DRAWING

MATERIAL

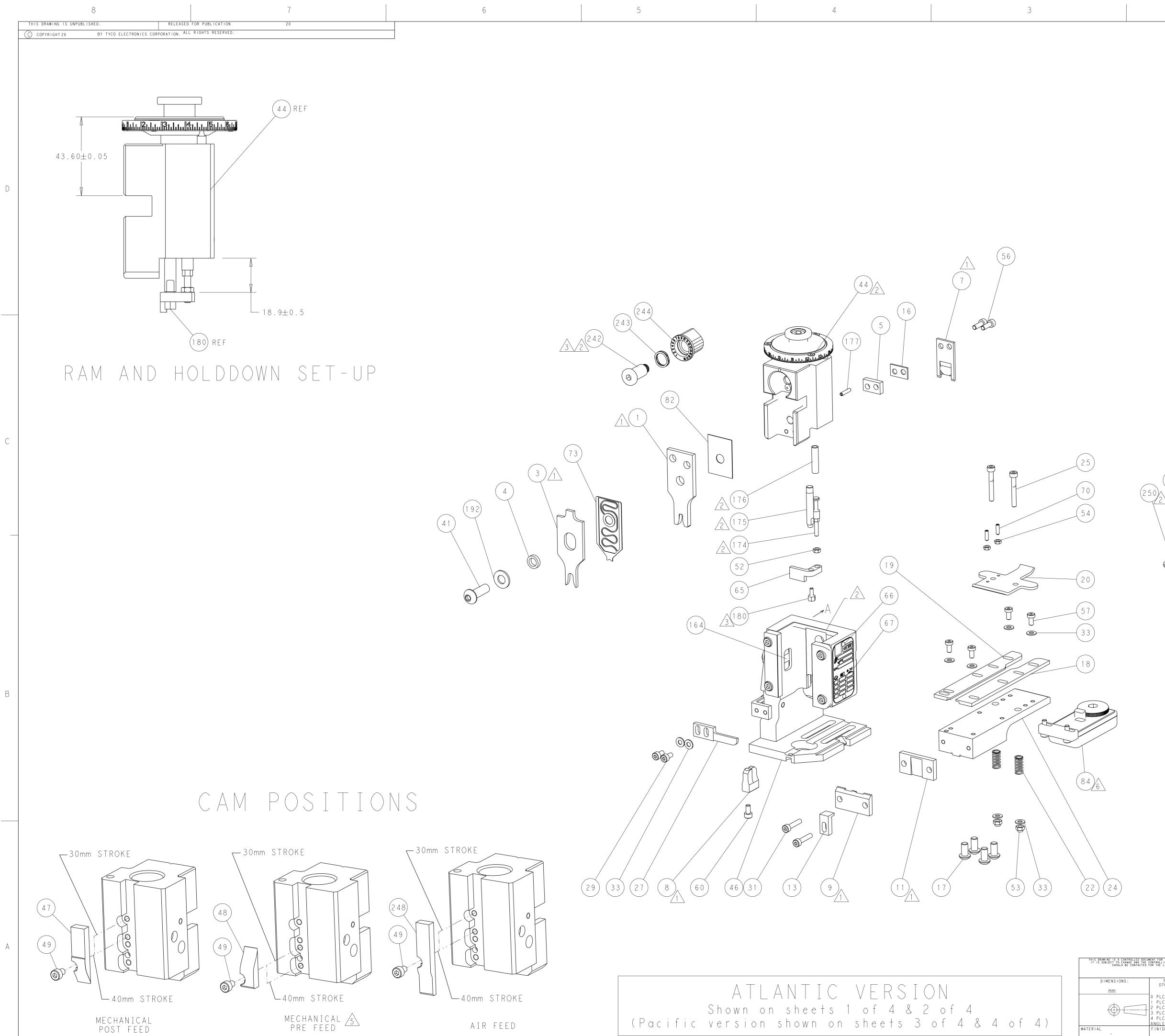
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

	L											
С	DIST		REVISIONS									
A	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD					
			1	DEVELOPMENT	14MAR2016	JH	UG					
			A	RELEASED	20APR2016	MEH	ΤE					
			В	ECR-18-016008	090CT2018	JAH	ΤE					

	_	1	_	1	-	2119640-1	PUSH ROD, AIR FEED	250	D
-	-	1	-	1		1803259-1	BUSHING, FLANGED	249	
-	_	1	-	1	-	2119641-1 2119082-9	FEED CAM, AIR FEED CAM, SNAIL, INSULATION ADJUSTMENT	248	-
-	_	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	-
-	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	-
-		1	-	1	-	2063440-1	AIR FEED MODULE	238	-
\wedge	_	1	1	1	1	<u>1 - 18028 - 0</u> 1752354 - 1	WASHER, FLAT, REG M8 STANDOFF,HOLD-DOWN	192	
23	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	-
-	-	1	1	1	1	1901680-2 21045-3	GUIDE PIN,HOLDDOWN RING, RETAIN, EXTERN, 3/16 CRESCENT	174	-
-	_	REF	RFF		REF	994970-2	COUNTER, MAGNETIC	164	-
-	-	1	-	1	_	240638-1	SPRING, FEED FINGER	163	
	-	1	-	1		3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	_
6	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	-
-	_	1	1	1	1	455888-4 2119791-5	SPACER, CRIMPER DEPRESSOR, WIRE	82	-
-	_	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
	-	2	2	2	2	2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	-	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	1	<u>1901681-1</u> 2168083-2	HOLDDOWN, TERMINAL SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	-	-	1	-	1	5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-	1	-	1	2063961-1	FEED FINGER	58	_
-	-	4	4	4	4	2168400-4	SHCS, LOW HEAD, ROHS, M4 X 8	57	
-	_	2	2	2	2	2168083-3 5018030-1	SCR, SKT HD CAP, RoHS, M4 X 12.0 NUT, HEX, REG, RoHS, M3	<u>56</u> 54	-
-	_	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	_	1	1	1	1	1 - 5018030 - 0	NUT, HEX, REG, RoHS, M3.5	52	
-	-	1	-	1	_	2119792-2	PAWL, EF, AIR	51	-
-	-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0 FEED CAM, PRE FEED	49	-
-	_	-	1	_	1	<u>2119652-1</u> 2119653-1	FEED CAM, FRE FEED	4 7	
-	-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	-
	-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	-
-	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	-
-	_	8	8	8	8	<u>1 - 18028 - 2</u> 2168083 - 9	WASHER, FLAT, REG M4 SCR, SKT HD CAP, Rohs, M4 X 20	33	-
-	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	B
	-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
_	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	-
-	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	-
-	-	2	2	1	<u> </u>	<u>2 - 22281 - 3</u> 1803292 - 4	SPRING, COMPRESSION DRAG	22	
-	-	1	1	1	1	1 - 1 9 0 1 6 9 6 - 5	STRIP GUIDE, REAR	19	
	-	1	1	1	1	1 - 1 9 0 1 6 9 5 - 5	STRIP GUIDE, FRONT	18	
-	-	4	4	4	4	1-2079383-1	SCR, BHSC, Rohs (M6 X 12)	17	-
-	-	1	1	1		<u>5-240641-4</u> 1752360-1	SPACER SPACER, HOLD-DOWN	16	
\bigwedge	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11	
	-	-	-	-	-	_	-	1 0	
4	-	1	1	1	1	6-690482-8	PLATE, FRONT SHEAR	9	-
4	1	2	2	1	1	<u>4-1803059-3</u> 2217206-6	ANVIL, COMBINATION, END FEED BLADE, SLUG	8	-
	_	-	-	-	-	-		6	-
-	_	1	1	1	1	240641-3	SPACER	5	
	_	1	1	1	1	6 - 2 3 8 0 1 1 - 9	BLOCK, CRIMPER SPACER	4	-
1	1	2	2	1	1	4 - 1803018 - 8	CRIMPER, INSULATION O	3	-
\bigwedge	-	- 2	- 2	- 1	-	- 456411-1	- CRIMPER, WIRE PREMIUM	2	
$\langle \rangle$	ו 		> - 7 1		1			ITEM	A
RAWING IS A	, ,		- ' '	ELECTRONIC		PART NO	DESCRIPTION	NO	
SUBJECT TÖ Shou	CHANGE ILD BE COM	ND THE CON TACTED FOR	THE LATEST	GINEERING REVISION.	S CORPORATIO DRGANIZATION	снк 14MAR2			
DIMENSI	ONS:		TOLE OTHERV	RANCES I VISE SPE	UNLESS CIFIED:	L.ZHANG APVD 14MAR2	016 NAME		
		0	PLC PLC	±- ±-		PRODUCT SPEC	Ocean End Feed Applicator		
\bigcirc)-[PLC PLC	±- ±- ±-		- APPLICATION SPEC		CTD 10750	-
L		A	PLC <u>NGLES</u> INISH	±-	±-		$A \mid 00779 \bigcirc 2150653$	STRICTED TO	
-				-		- CUSTOMER DRAWING	SCALE SHEET OF	REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

SCALE 1:1 SHEET OF A REV B



AMP 4805 REV 31MAR2000

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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A 66	p ltr - SEE SH	HEET 1	REVISIONS		DATE -	DWN -	APVD -	
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		0	9	(137)				
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								В
LED DOCUMENT FOR TYCO ELECTRONICS CORPORATION AND THE CONTROLLING ENGINEERING ORGANIZATION TACTED FOR THE LATEST REVISION.	14MAR2016			TE Connectivity				A
TOLERANCES UNLESS OTHERWISE SPECIFIED: APVD U.GUO	14MAR2016	NAME		Harrisburg, PA n End Feed				
I PLC ±- - 2 PLC ±- - - 3 PLC ±- - APPLICATIO 4 PLC ±- - - ANGLES ±- - - -			E CODE DRAWING NO			RESTRIC	CTED TO	
FINISH WEIGHT	- R DRAWING	A 00	779 C-21	50653 scale 1 · 1 shee	T 0F /		v B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

	8		7	6
	PART	RELEASED FOR PUBLICATION ONICS CORPORATION. ALL RIGHTS RESERVED.	20	PACIFIC VERSION TERMINATOR
	NUMBER REVISION 2-2150653-1 B 2-2150653-2 B 7-2150653-7 A	DESCRIPTION FINE CRIMP HEIGHT AD FINE CRIMP HEIGHT AD CRIMP TOOLING KI	DJUST PNEUMATIC	
D				
	APPLICATOR DA CRIMP SIZE WIRE 3.56 mm [.140] INSUL 5.59 mm [.220] APPL INSTRUCTIONS 408-35043	T A T Y P E F O		
C	APPLICATION SPECIFICATION TERMINALS APPLIEE TE TERMINAL TE T	TERMINAL INSULATION 9 INJ 4-2084 - -	IMP SPECIFICATION I DIAMETER RANGE mm [.130170 IN] 1217996-1	
В	SIZE mm [12 AWG 2.49+ 2X 16 AWG 2.36+ 14 AWG 2.24+ 16 AWG 2.06+	INCH]R/-0.05 [.098+/002]//-0.05 [.093+/002]/-0.05 [.088+/002]/-0.05 [.081+/002]/-1.05 [.081+/002]/-2.23419-5 [.0011110]/-2.23419-6 [.00111110]//-2.23419-6 [.00111110]//-2.23419-6 [.001111110]//-2.23419-6 [.001111110]//-2.23419-6 [.001111110]//-2.23419-6 [.001111110]//-2.23419-6 [.001111110]//-2.23419-6 [.001111110]//-2.23419	HREADS OF ITEMS 180. HREADS OF ITEM 242. SETTING USED WHEN THE ADJUSTMENT MAY BE FIELD. .ICATORS IS POST-FEED NFIGURED FOR PRE-FEED S WITH SOME APPLICATIO	WITH WITH DNS.
		OTHERWISE TORQUE VALUES	SHALL BE USED PER	

*WARNING

5

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

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.

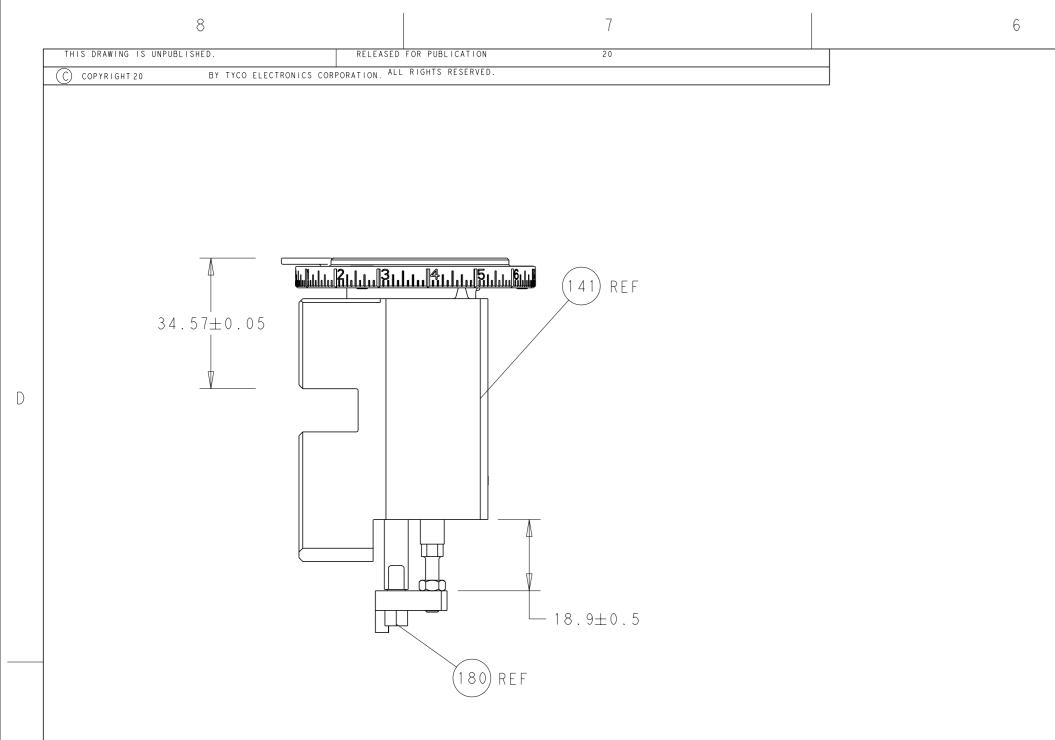
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			1	1	0110010			D
		-	1	1	2119640-1	PUSH ROD, AIR FEED	250	C
		_	1	1	<u>1803259-1</u> 2119082-9	BUSHING, FLANGED CAM, SNAIL, INSULATION ADJUSTMENT	249	
			1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	\bigwedge	_	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
	<u> </u>	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
		_	1	-	2063440-1	AIR FEED MODULE	238	
		_	1	1	1 - 1 8 0 2 8 - 0	WASHER, FLAT, REG M8	192	
	~	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
	3	-	1	1	1752354-1	STANDOFF, HOLD-DOWN	180	
		-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		
		_	1	1	<u>8-22280-7</u> 1752353-2	SPRING, COMPRESSION GUIDE PIN,HOLDDOWN	176	
		_	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
		_	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
		_	REF	REF	994970-2	COUNTER, MAGNETIC	164	
		_	1	1	240638-1	SPRING, FEED FINGER	163	
		_	1	_	2119641-2	FEED CAM, AIR FEED	152	
		-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
		_	- 1	1	2119653-2	FEED CAM, POST FEED	1 4 2	
		_	1	1	<u>2119655-6</u> 1803518-1	APPLICATOR BASIC ASSEMBLY, EF RAM ASSEMBLY, EF PACIFIC	141	
		_	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	С
	6	_	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
	~~~	_	1	1	455888-4	SPACER, CRIMPER	82	
		_	1	1	2119791-5	DEPRESSOR, WIRE	73	
		-	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
		-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
		_			2119740-1	TAG, IDENTIFICATION	67	
		_	2	2	<u>2168078-1</u> 1901681-1	SCREW, DRIVE, RH, R∘HS, 2 x .188 HOLDDOWN, TERMINAL	66	
		_	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
		_	-	1	2063961-1	FEED FINGER	58	
		-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
NG		_	2	2	2168083-3	SCR, SKT HD CAP, Rohs, M4 X 12.0	56	
		_	2	2	<u>5018030-1</u> 986965-8	NUT, HEX, REG, RoHS, M3 NUT, LOCK, HEX, TORQUE (M4)	<u>54</u> 53	
		_	1	1	1 - 5018030 - 0	NUT, HEX, REG, RoHS, M3.5	52	
S.		-	1	_	2119792-2	PAWL, EF, AIR	51	
$\smile$ .		_	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
		-	-	1	2119652-1	FEED CAM, PRE FEED	48	
		_	8	8	1803602-1 1-18028-2	SCR, BHSC, Rohs (M8 X 25)	41	
		_	2	2	2168083-9	WASHER, FLAT, REG M4 SCR, SKT HD CAP, RoHS, M4 X 20	31	
		_	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	В
		-	1	1	240639-1	STRIPPER (MACHINING)	27	
		_	2	2	1 - 2 1 6 8 0 8 3 - 5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
		-	1	1	1752371-5	PLATE, STRIP GUIDE	24	
		_	2	2	2-22281-3	SPRING, COMPRESSION	22	
		_	1	1	1803292-4	DRAG Strip guide, rear	20	
			1	1	1 - 1 9 0 1 6 9 5 - 5	STRIP GUIDE, FRONT	18	
		_	1	1	5 - 2 4 0 6 4 1 - 4	SPACER	16	
		-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	-	1	1	240644-9	PLATE, REAR SHEAR	1 1	
	$\wedge$	_	-	-	-		10	
	$\begin{pmatrix} 1 \\ \end{pmatrix}$	-	1	1	<u>6-690482-8</u> 4-1803059-3	PLATE, FRONT SHEAR ANVIL, COMBINATION, END FEED	9	
		-	1	1	2217206-6	BLADE, SLUG	7	
	<u> </u>	_	-	-	-	-	6	
		_	1	1	240641-3	SPACER	5	
	~	-	1	1	6 - 2 3 8 0 1 1 - 9	BLOCK, CRIMPER SPACER	4	
	1	1	1	1	4 - 1 8 0 3 0 1 8 - 8	CRIMPER, INSULATION O	3	
	$\wedge$	-	- 1	- 1	- 456411-1	- CDIMDED WIDE DDEMIIIM	2	
	$\sum 1$					CRIMPER, WIRE PREMIUM	ITEM	٨
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DIMENSIC	DNS:		TOLERAI OTHERWIS	NCES UNL Se speci	ESS L.ZHANG FIED: APVD 14MAR	2016 NAME		
mm		0 P		±- ±-	U.GUO PRODUCT SPEC	Ocean End Feed Applicator		
		2 P 3 P	PLC PLC	±- ±-	- APPLICATION SPEC			
MATERIAL		ANG	PLC GLES NISH	±- :	<u>-</u>	A 00779 C-2150653	STRICTED TO	
-				-	CUSTOMER DRAWING	A   00779 G=2150655 SCALE 1:1 SHEET 3 of 4	- Rev B	
1						1 & 2 ARE NOT REQUIRED FOR PACIFIC V		
					JILLIJ	I G Z ANT NOT NEWDINED FON FACIFIC V		

## REVISIONS A 66 DESCRIPTION DATE DWN APV SEE SHEET 1

MATERIAL

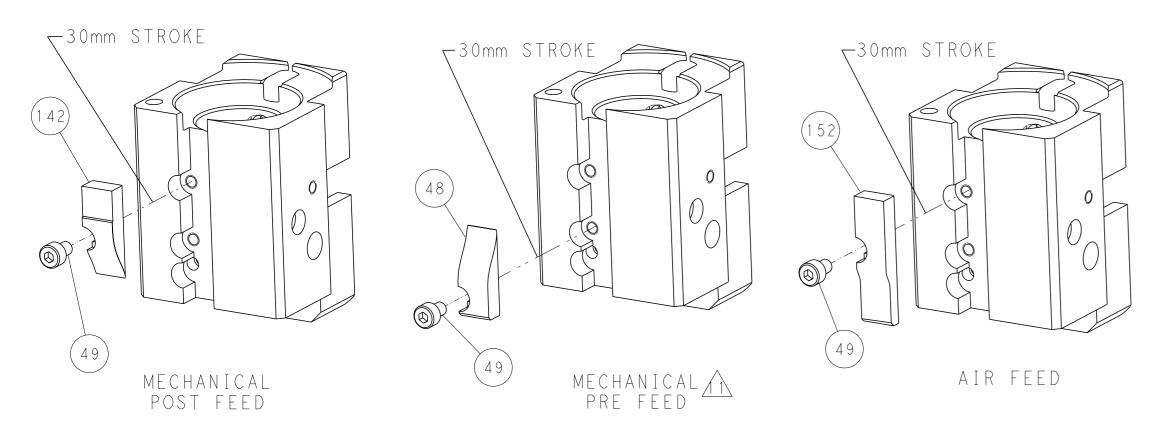


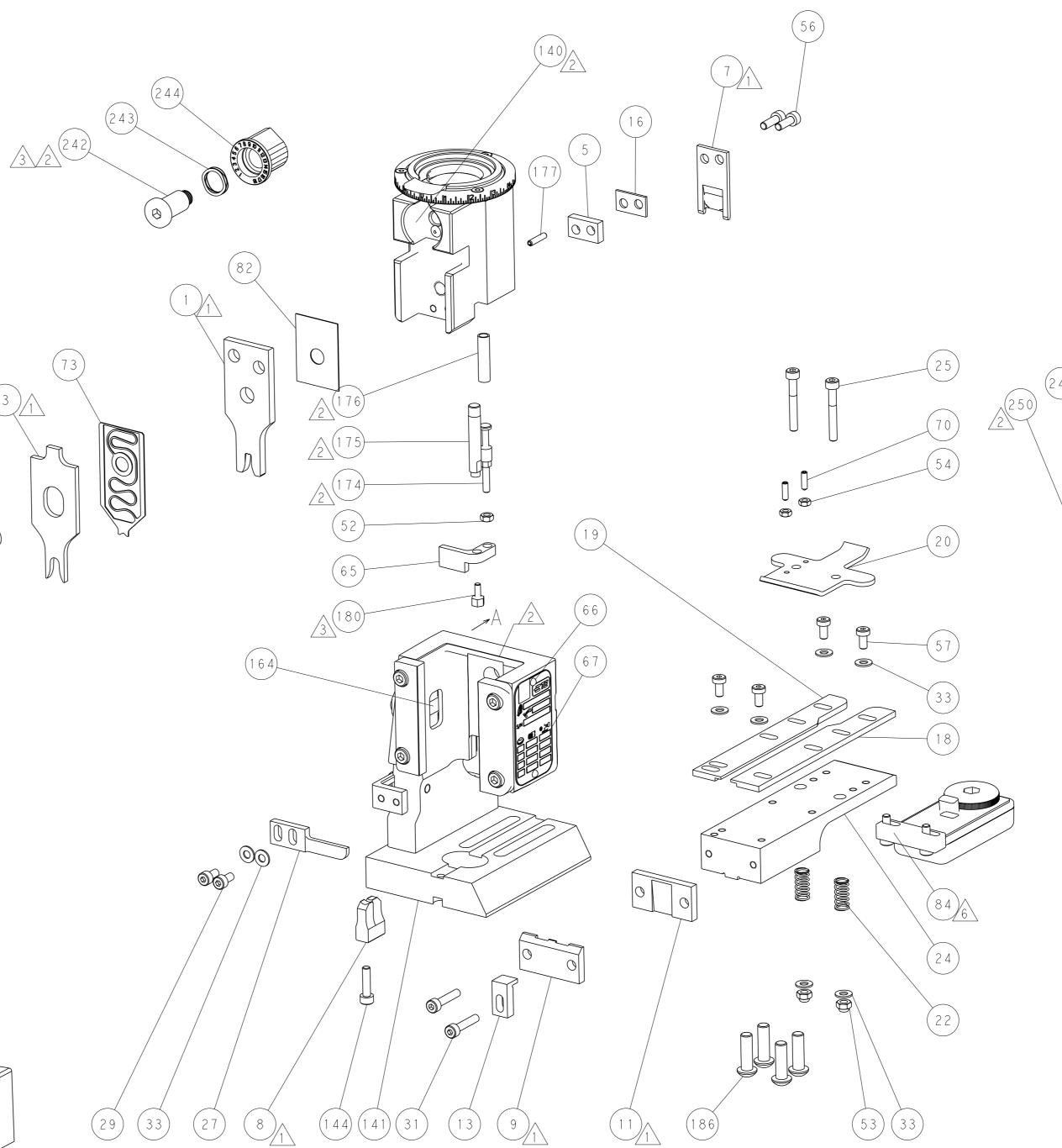
## RAM AND HOLDDOWN SET-UP

В

AMP 4805 REV 31MAR2000

CAM POSITIONS





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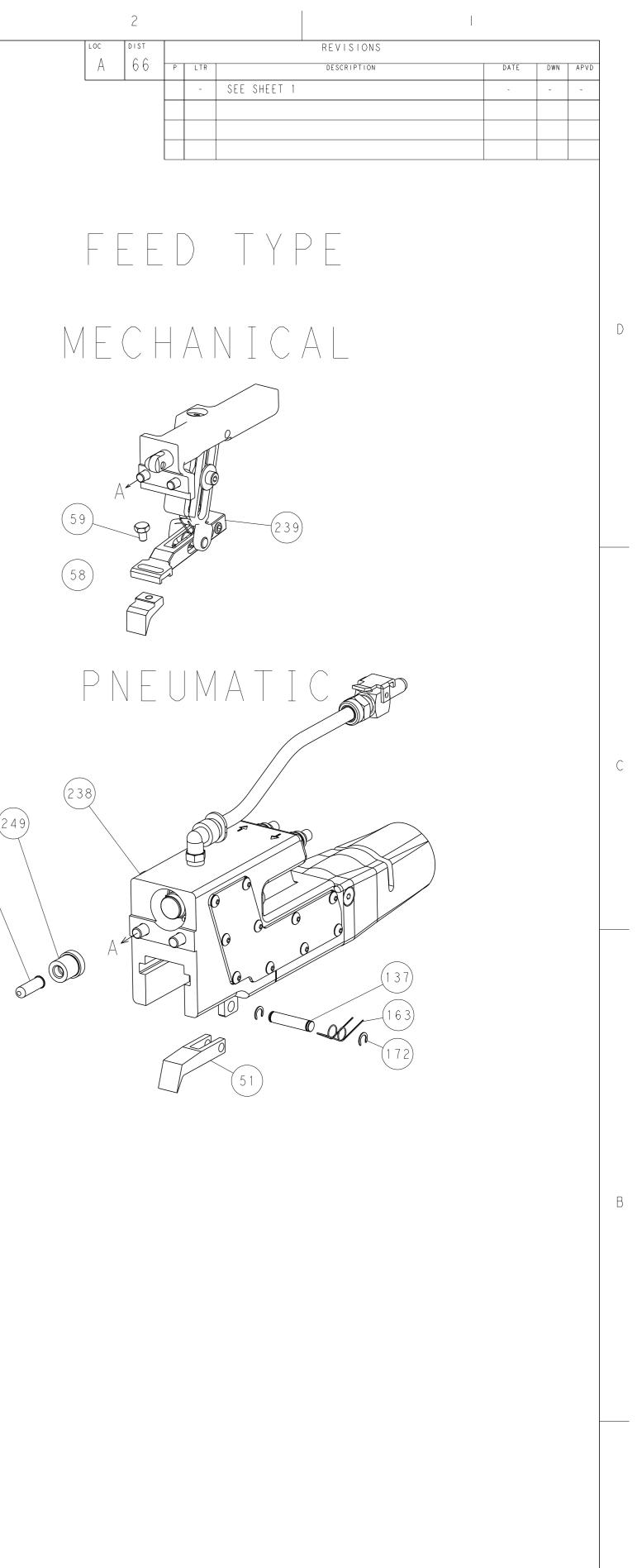
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		OCUMENT FOR TYCO ELECTRONICS CORPORATIO HE CONTROLLING ENGINEERING ORGANIZATION ED FOR THE LATEST REVISION.	* DWN 14MAR2016 J.HOU CHK 14MAR2016 L.ZHANG		8
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4	DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±- 1 2 PLC ±-	APVD 14MAR2016 U.GUO PRODUCT SPEC	Ocean End Feed Applicator	
(Atlantic version shown on sheets 1 of 4 & 2 of 4)			APPLICATION SPEC 	SIZE CAGE CODE DRAWING NO A   00779 C-2150653	RESTRICTED TO
	-		CUSTOMER DRAWING	SCALE 1:1 SHEET OF	4 Rev B
			SHEETS 1 &	2 ARE NOT REQUIRED FOR PACIFIC	VERSION

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## **Mouser Electronics**

Authorized Distributor

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TE Connectivity: 7-2150653-7