		8		7	6
	THIS DRAWING IS UNPUBLI		RELEASED FOR PUBLICATION	20	
	P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE	E ATLANTIC VERSION TERMINATC
	2150740-2	D	FINE CRIMP HEIGHT AD.	JUST PNEUMATIC	C
	7 - 2150740 - 2	D	PNEUMATIC AND CRIMI TOOLING KIT	PNEUMATIC	
D	7-2150740-7	A	<u>CRIMP TOOLING KIT</u>		
	CRIMP		TA TYPE F -		
С	TERMINAL DAT. TERMINAL NAM WIRE STRIP 5.18-5.94 m TERMINAL APPLICATION TERMINAL SPECIFICATION TERMINALS TE TERMINAL 42868-1 42891-2	E : SHUR LENGTH m [.204234 114 APPLIED TE TE	PLUG . 180 DIA INSULATION V - 2017 -	MP SPECIFICATION DIAMETER RANGE	
	10 AWG 12 AWG	2.77+/		TIMP HEIGHT FERENCE SETTING 3.1 7.7	
	14 AWG	1.98+/	-0.05 [.078+/002]	11.1	
	\wedge	NDED SPARI			
В	STORAGE	OF APPLIC			
	 ▲ CRIMP H APPLICA NECESSA ▲ TERMINA 6. UNLESS DOCUMEN 	EIGHT REFI TOR WAS QU RY WHEN RU L LUBRICAN SPECIFIED T, 101-350	R 1-23419-5 LOCTITE TO ERENCE SETTING WAS THE S JALIFIED AT THE FACTORY. JNNING APPLICATOR IN THE NT IS RECOMMENDED. OTHERWISE TORQUE VALUES 000.	SETTING USED WHEN T ADJUSTMENT MAY BE FIELD. S SHALL BE USED PER	THE E
A					

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.

4

3

5

ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) THIS DRAWING IS A CONTROLLED DOC IT IS SUBJECT TO CHANGE AND THE SHOULD BE CONTACTED

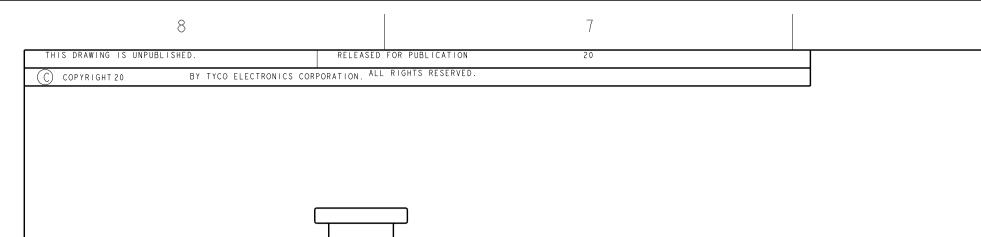
DIMENSIONS: mm MATERIAL

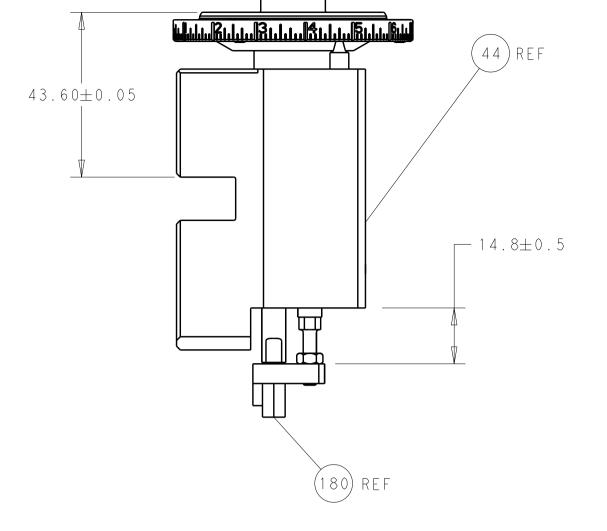
	2										
LOC	DIST			REVISIONS	REVISIONS						
А	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD				
			В	ECR-17-003863	16MAR2017	MR	GВ				
			С	ECR-18-015932	09OCT2018	ТB	ΤE				
			D	ECR-19-009276	13JUN2019	LG	ΤE				

	_	1	1	2119641-1	FEED CAM, AIR FEED	248	
	_	1	1	2844940-3	AIR FEED MODULE	238	
$\sqrt{3}$	_	1	1	2 - 1 7 5 2 3 5 4 - 0	STANDOFF, HOLD-DOWN	180	
<u>/ 3 `</u>	<u>_</u>	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	_	1	1	8-22280-7	SPRING, COMPRESSION	176	
	_	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
	_	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
	_	REF	RFF	994970-2	COUNTER, MAGNETIC	164	
	_	1		2119955-2	ASSY, LUBRICATOR, END FEED	84	
<u> </u>		1	1	455888-7	SPACER, CRIMPER	82	
	_	1	1	2119791-9	DEPRESSOR, WIRE	73	
	_	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
	_	2	2	2 - 18032 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	С
	_	1	1	2119943-1	WASHER, SPACER	69	
	_	1	1	2119740-1	TAG, IDENTIFICATION	67	
	_	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	_	<u> </u>	<u> </u>	1901681-1	HOLDDOWN, TERMINAL	65	
	_	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
	_	<u> </u>	<u> </u>	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
	_	1	1	5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59	
	_	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	_	2	2	2168083-8		56	
	_	2	2	5018030-1	SCR, SKT HD CAP, Rohs, M4 X 16		
					NUT, HEX, REG, Rohs, M3	54	
	_	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	_	1		1-5018030-0	NUT, HEX, REG, Rohs, M3.5	52	
	_	1		2063961-1	FEED FINGER	51	
	_	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	_	1		2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
	_	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
	-			1803602-1	SCR, BHSC, Rohs (M8 X 25)	41	
	_	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
	-	2	2	2168083-9	SCR, SKT HD CAP, Rohs, M4 X 20	31	
	_	2	2	2168083-2	SCR, SKT HD CAP, Rohs, M4 X 8.0	29	
	-			690455-1	STRIPPER, FRONT CASTING	27	В
	_	2	2	1-2168083-5	SCR, SKT HD CAP, Rohs, M4 X 30	25	
	-	1		1752371-1	PLATE, STRIP GUIDE	24	
	_			240825-2	PLATE, STRIP HOLD DOWN	23	
	-	2	2	2-22281-3	SPRING, COMPRESSION	22	
	_			1803292-4	DRAG	20	
	-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
	_	4	4	1-2079383-1	SCR, BHSC, Rohs (M6 X 12)	17	
	-	1	1	240641-5	SPACER	16	
	_	1	1	1-2119757-6	DEPRESSOR, SHEAR	15	
\wedge	-	1		1752360-1	SPACER, HOLD-DOWN	13	
<u> </u>		2	2	240644-9	PLATE, REAR SHEAR		
\wedge	_	<u> </u>			SPACER, SHEAR PLATE	10	
Δ	1			2-240642-2	PLATE, FRONT SHEAR	9	
$\angle 1$		2			ANVIL, COMBINATION, END FEED		
1	∠			1803366-4	BLADE, SLUG -		
	_	1	1	-		6	
	_			7 - 2 4 0 6 4 1 - 1	SPACER	5	
	_	-	_	-	-	4	
	_	1	1	-		3	
\wedge	-			455888-5	SPACER, CRIMPER		
<u> </u>		<u> </u>		2 - 1 8 0 3 2 2 4 - 3	CRIMPER, WIRE		
	- 77	" -72	- 2	PART NO	DESCRIPTION	I T E M N O	А
LLED DOCUM AND THE CO ONTACTED FO	ENT FOR TYCO ONTROLLING E OR THE LATES	ELECTRONICS NGINEERING C T REVISION.	CORPORATION	DWN 22SEP2 J.HOU	016 TE Connectivity		
				<u></u>			
	TOL E OTHE R	WISE SPE	INLESS CIFIED:	APVD 22SEP2 L.ZHANG	Ocean End Feed		
	0 PLC	±- +-		PRODUCT SPEC	Applicator		
	I PLC 2 PLC 3 PLC	±- ±- ±-		- APPLICATION SPEC			
	4 PLC ANGLES	±- ±-	<u>+</u> -	-	SIZE CAGE CODE DRAWING NO RE	STRICTED TO	
	FINISH	-		WEIGHT _	$A \mid 00779 \ C = 2150740$	-	
		-			SCALE SHEET OF	REV	

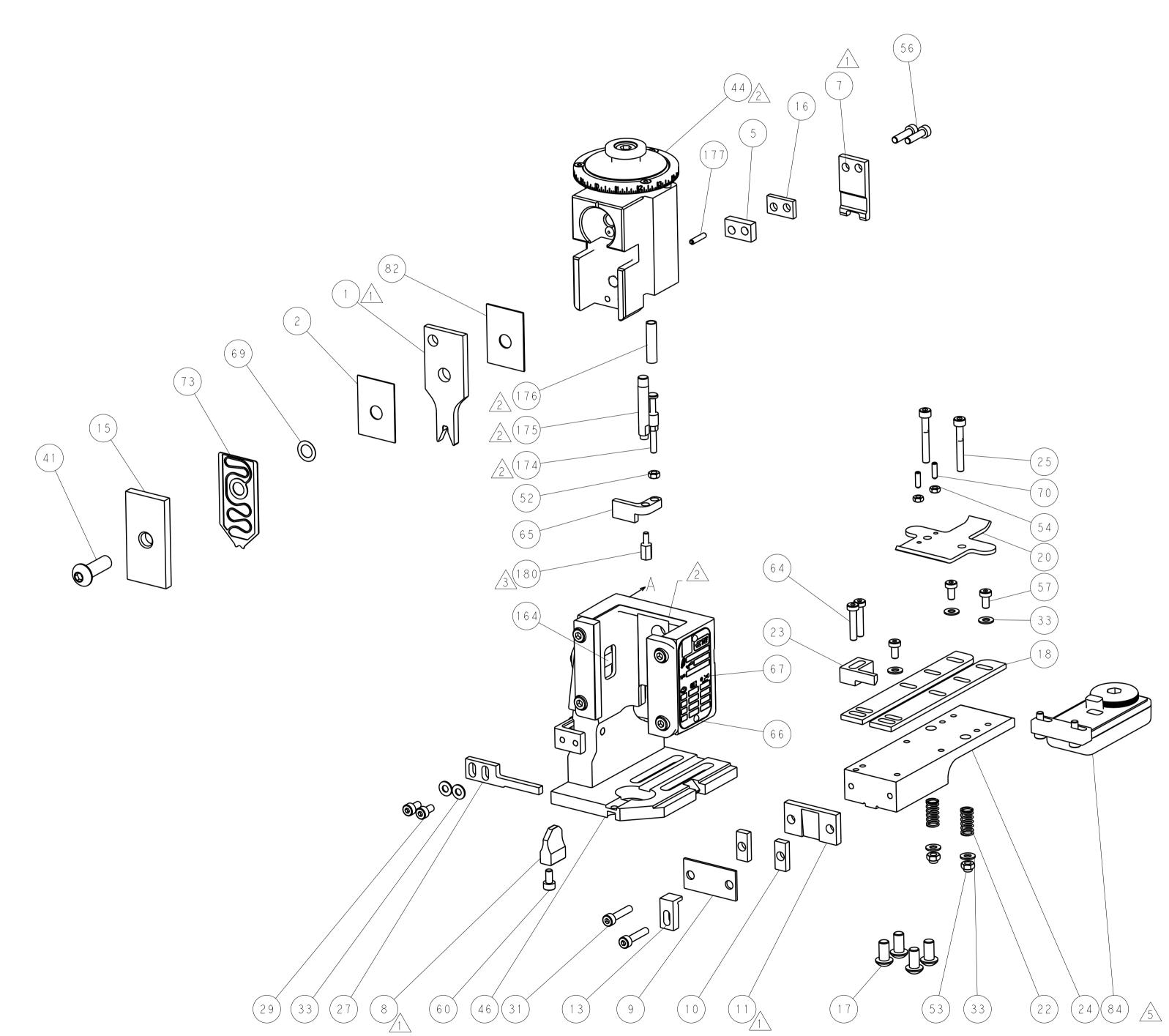
SCALE 1:1 SHEET 1 OF 4 REV D SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

ustomer Accessible Production Drawing





RAM AND HOLDDOWN SET-UP

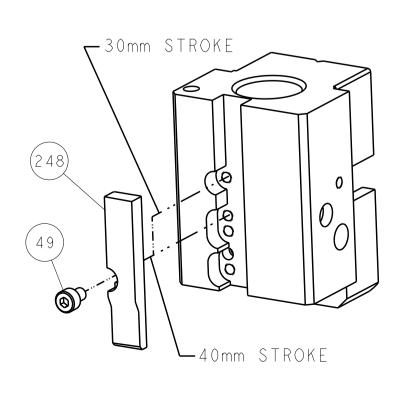


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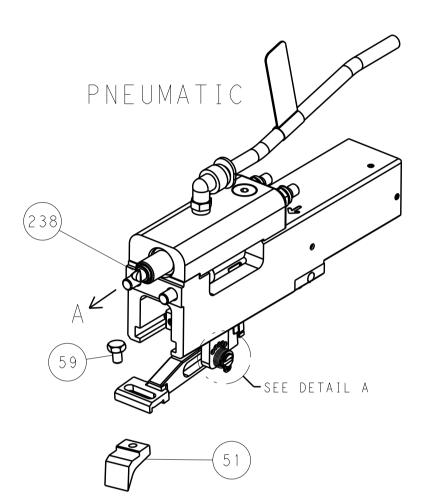
AMP 4805 REV 31MAR2000

AIR FEED

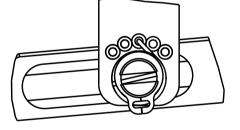
DIMENSIONS: ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) mm

		2			I			
	LOC	DIST						
	А	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD
•				-	SEE SHEET 1	-	-	-
				-				

FEED TYPE



FEED SPRING SETTING POSITION



DETAIL A



THIS DRAWING IS A CONTROLLED DO IT IS SUBJECT TO CHANGE AND TH SHOULD BE CONTACTE

3

CUMENT FOR TYCO ELECTRONICS CORPORATION HE CONTROLLING ENGINEERING ORGANIZATION D FOR THE LATEST REVISION.		dwn J.HOU	22SEP2016			775	TE Connectivity	
		снк L.ZHANG	22SEP2016				Harrisburg, PA 17105-360	8
	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD L.ZHANG	22SEP2016	NAME		Ocea	n End Feed	
	0 PLC ±- 1 PLC ±-	PRODUCT SPEC						
╁	2 PLC ±- 3 PLC ±- 4 PLC ±-	APPLICATION	-					
	4 PLC ±- ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO		RESTRICTED TO
	FINISH -	WEIGHT	-	ΑI	00779	C-21	50740	-
	-	Customer	Accessible Pr	oduci	ion Draw	ing	scale 1:1 sheet of	4 REV D
	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION							

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C COPYRIGHT 20	BY TYCO ELECTRON	NICS CORPORATION. ALL	. RIGHTS RESERVED.			
P A R T N U M B E R	REVISION	DE	SCRIPTION		FEED TYPE	
2 - 2 1 5 0 7 4 0 - 2	D	FINE CRIM	AP HEIGHT	ADJUST	PNEUMATIC	
7 - 2150740 - 7	А	CRIMP	TOOLING H	ΚΙΤ	-	
CRIMP WIRE 3.30 mr INSUL APPL INSTR 408-35	043 A: TE TER E: SHUR LENGTH	MINAL PLUG.18	BO DIA		PECIFICATION ETER RANGE	
5.18-5.94 mr		4 IN]	Ø			

	114-2017	-	-	
APPLICATION SPECIFICATION	-	-	-	
TERMINALS AF	PLIED 5 7			
TE TERMINAL ·	TE TERMINAL	TE TERMINAL	TE TERMINAL	
42868-1	42868-2	42868-3	42891-1	
42891-2				

WIRE SIZE 🎯 🖡 🖬		CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.77+/-0.05 [.109+/002]	3.1
12 AWG	2.29+/-0.05 [.090+/002]	7.7
14 AWG	1.98+/-0.05 [.078+/002]	11.1

AMP 4805 REV 31MAR2000

1 RECOMMENDED SPARE PARTS

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

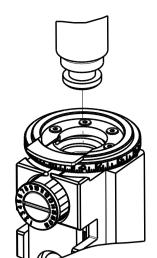
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.

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 TERMINAL LUBRICANT IS RECOMMENDED.

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

 $\overline{2}$ terminal pitch not compatible with mechanical feed.



6

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

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 DOCUME IT IS SUBJECT TO CHANGE AND THE CO SHOULD BE CONTACTED FO DIMENSIONS: mm \bigcirc MATERIAL

*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.

$\sqrt{3}$	-		2-1752354-0	STANDOFF, HOLD-DOWN	180	
	-	1	6 - 9 9 3 1 1 1 - 6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	_	1	8-22280-7	SPRING, COMPRESSION	176	
	_	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
		1				
	-		1901680-2	GUIDE PIN,HOLDDOWN	174	
	-	REF	994970-2	COUNTER, MAGNETIC	164	
	_	1	2119641-2	FEED CAM, AIR FEED	152	
	_	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
		1				
	-		2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	C
\wedge	_	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	С
<u> </u>		1			82	
			455888-7	SPACER, CRIMPER		
	-	1	2119791-9	DEPRESSOR, WIRE	73	
	_	1	1803607-4	DOCUMENTATION PACKAGE	71	
	_	2	2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	
		1				
	-		2119943-1	WASHER, SPACER	69	
	-	1	2119740-1	TAG, IDENTIFICATION	67	
	_	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	_	1	1901681-1	HOLDDOWN, TERMINAL	65	
	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	_	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	_	1	1 - 5018030 - 0	NUT, HEX, REG, RoHS, M3.5	52	
		1				
	-		2063961-1	FEED FINGER	51	
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	_	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
	_	7	1 - 18028 - 2	WASHER, FLAT, REG M4	33	
		$\frac{1}{2}$				
	-	2	2168083-9	SCR, SKT HD CAP, Rohs, M4 X 20	31	
	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	В
	_	1	690455-1	STRIPPER, FRONT CASTING	27	
		2	1 - 2168083 - 5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
	-		1752371-1	PLATE, STRIP GUIDE	24	
	-	1	240825-2	PLATE, STRIP HOLD DOWN	23	
	_	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
		1	1803292-4	DRAG	20	
	-	2	1901259-6	GUIDE, LOWER STRIP	18	
	-	1	240641-5	SPACER	16	
	_	1	1-2119757-6	DEPRESSOR, SHEAR	15	
		1	1752360-1	SPACER, HOLD-DOWN	13	
		1				
1	-		240644-9	PLATE, REAR SHEAR		
	-	2	2 - 2 4 0 6 4 5 - 2	SPACER, SHEAR PLATE	10	
\wedge	_	1	2 - 2 4 0 6 4 2 - 2	PLATE, FRONT SHEAR	9	
	1	1			8	
$\angle 1 $			2-1803002-8	ANVIL, COMBINATION, END FEED		
1	-		1803366-4	BLADE, SLUG -	/	
	-	-	-	-	6	
	_	1	7 - 2 4 0 6 4 1 - 1	SPACER	5	
	_				4	
ŀ	_	-	-			
			-	-	3	
	-	1	455888-5	SPACER, CRIMPER	2	
\wedge	1	1	2 - 1 8 0 3 2 2 4 - 3	CRIMPER, WIRE	1	
	1	1		CNIMPER, WINE		
	-77	- 22	PART NO	DESCRIPTION	ITEM	А
JMENT FOR TYCO	ELECTRONI				NO	
JMENT FOR TYCO CONTROLLING E FOR THE LATES	NGINEERING T REVISION	ORGANIZATI	J.HOU			
T ~ · ·			снк 22SEP2 L.ZHANG			
	ERANCES WISE SP	UNLESS ECIFIED:	APVD 22SEP2	016 NAME		
0 PLC	±-		L.ZHANG product spec	Ocean End Feed		
I PLC 2 PLC	±- ±-		-	Applicator		
3 PLC	±-		APPLICATION SPEC			
4 PLC ANGLES	±-	±-	-		STRICTED TO	
FINISH	-		WEIGHT _	A 00779 C-2150740	-	
	-		Customer Accessibl	e Production Drawing SCALE 1:1 SHEET 3 4	REV	
1				5 1.1 5 7		I
			SHEETS 1	& 2 ARE NOT REQUIRED FOR PACIFIC VE	RSION	

REVISIONS A 66 DESCRIPTION DATE DWN APVD - SEE SHEET 1 - -

AIR FEED MODULE

2-1752354-0 STANDOFF, HOLD-DOWN

SCR, BHSC, R₀HS (M6 X 20)

2844940-3

2079383-9

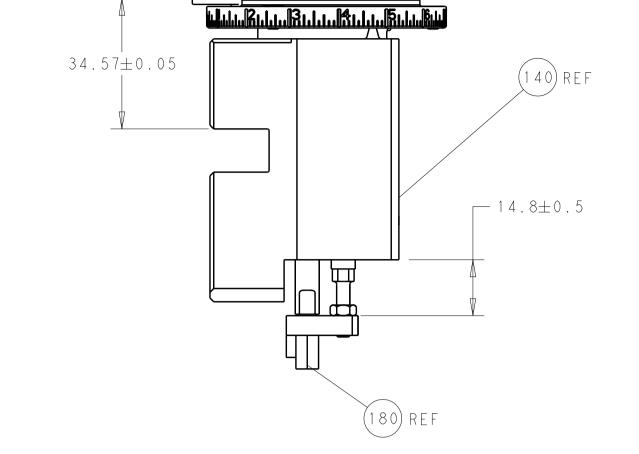
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186

180



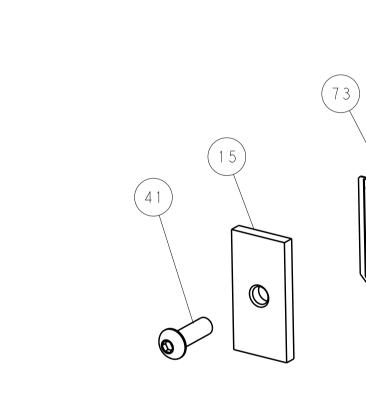
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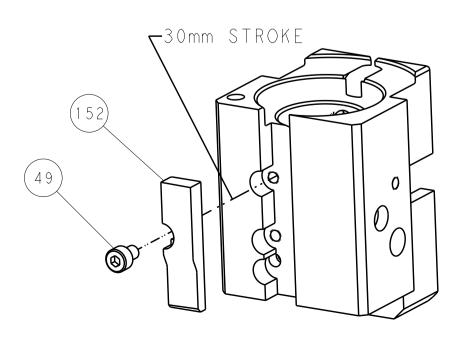
RAM AND HOLDDOWN SET-UP



6

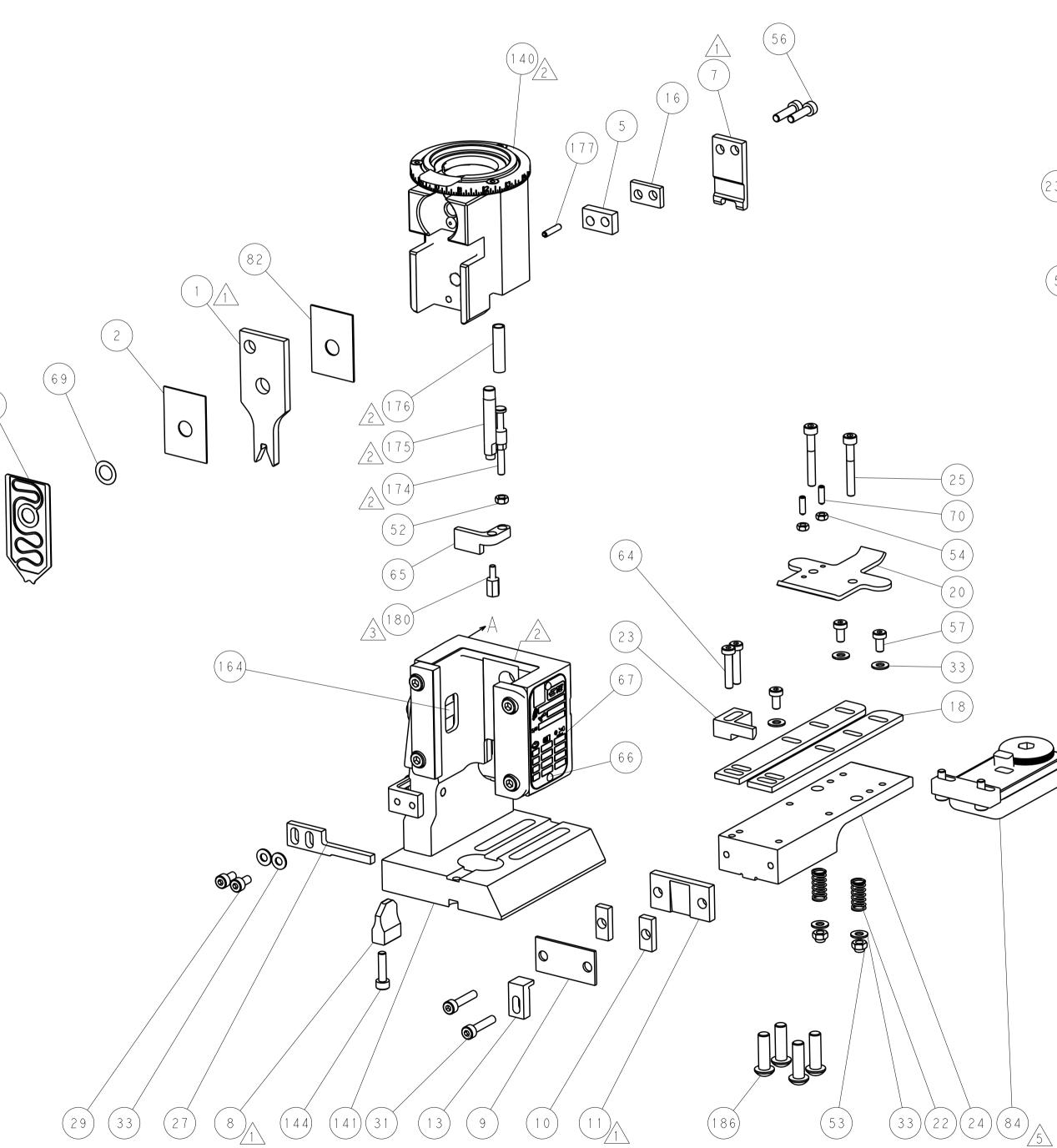
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AMP 4805 REV 31MAR2000

AIR FEED

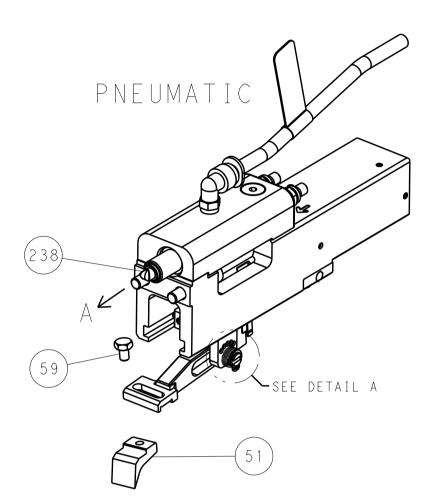


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	2								
LOC	DIST				REVISIONS				
A	66	Р	LTR		DESCRIPTION		DATE	DWN	APVD
			-	SEE SHEET 1			-	-	-



3



FEED SPRING SETTING POSITION

DETAIL A

OCUMENT FOR TYCO ELECTRONICS CORPORATION HE CONTROLLING ENGINEERING ORGANIZATION ED FOR THE LATEST REVISION.		dwn J.HOU	22SEP2016			775	7 TE Connect	,		
		снк L.ZHANG	22SEP2016				Harrisburg	, PA 17	105-360	8
	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD L.ZHANG	22SEP2016	NAME		Ocea	n End Fe	ed		
-	0 PLC ±- 1 PLC ±-	- PRODUCT SPEC Applicator								
+	2 PLC ±- 3 PLC ±-	APPLICATION SPE	EC							
_	4 PLC ±- ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO				RESTRICTED TO
	FINISH -	WEIGHT _		AI	00779	C=21	50740			-
	-	Customer Ac	cessible Pr	oduct	ion Draw	ing	scale 1:1	SHEET	4 ^{OF}	4 REV D
		SHE	ets 1 &	2 AF	RE NOT	REQUI	RED FOR	PAC I	FIC	VERSION

В

Mouser Electronics

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