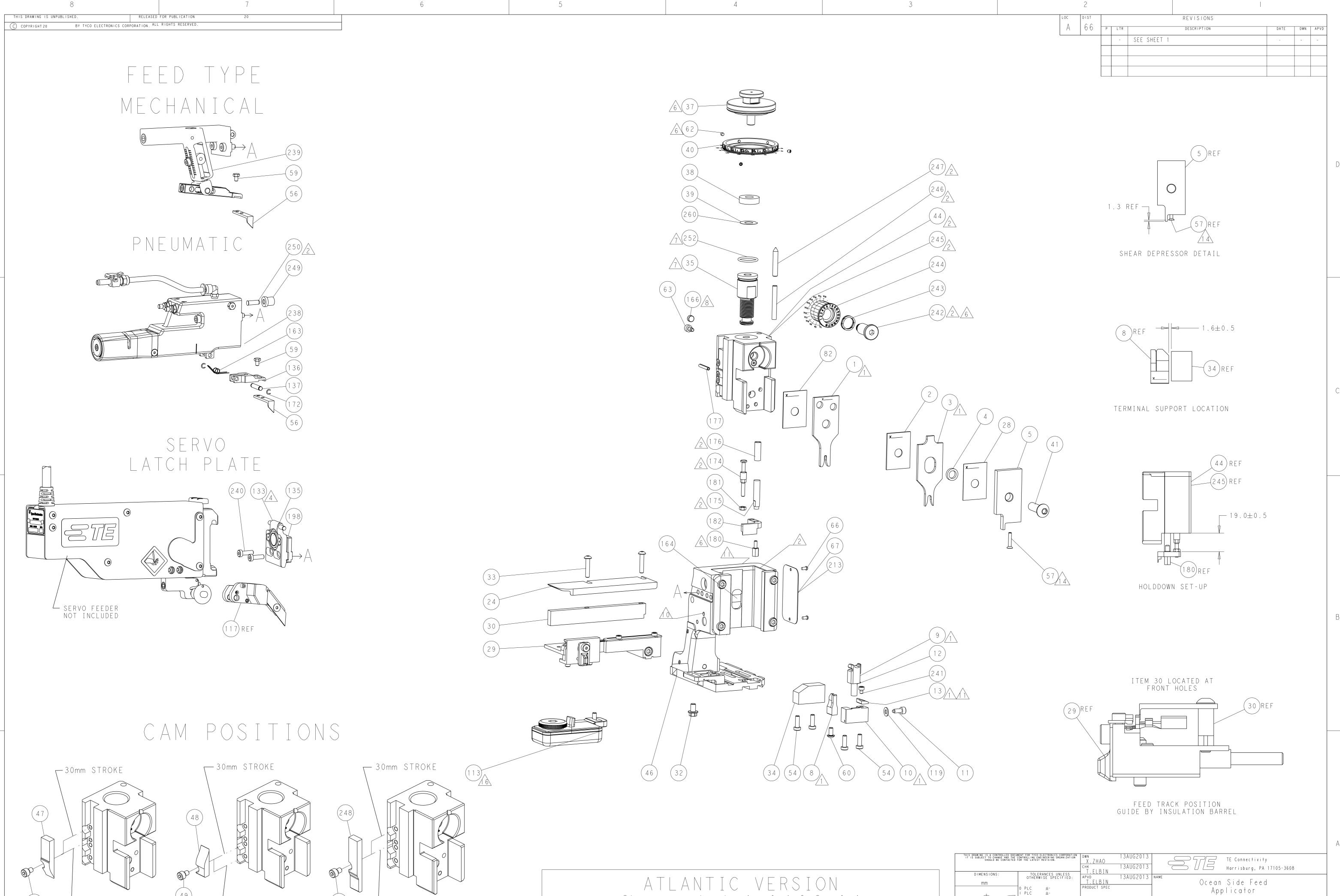
THIS DRAWING IS UNPUBLISHED.		ED FOR PUBLICATION	7 20		6	5		4		3	
C COPYRIGHT 20 BY TY ATLANTIC VERSIO TERMINATOR INTERFACE ADAPTE		REVISION	DESCRIPTION	FEED TYPE							SET 21
	2266017-1	D	FINE CRIMP HEIGHT ADJUS	T MECHANICAL	SUPERSEDED BY 5-21	51227-1					
	2266017-2	D	FINE CRIMP HEIGHT ADJUS	T PNEUMATIC	SUPERSEDED BY 5-21	51227-2					- <u>1</u> - - <u>1</u> - - <u>1</u> -
	2266017-5	D	FINE CRIMP HEIGHT ADJUS	T SERVO LATCH PLATE 4	- 						- 1 1 - 1 1 6 - 1 1
	2266017-6		NON-CRIMP HEIGHT ADJUS	ZALAICH PLAIEZIZ	OBSOLETE OBSOLETE						- 1 1 2
	7-2266017-		CRIMP TOOLING KIT	_							 1 1
APPLICATO CRIMP SIZ	e type										- 1 1 - 1 1 6 - 1 1 - 1 1
WIRE 2.03 mm [INSUL 4.06 mm [APPLICATOR INSTR 408-10389	.160] O UCTIONS	_									$\begin{array}{c ccccccccccccccccccccccccccccccccccc$
											 <u>8</u> - 1 1 - REF REF
TERMINAL DATA: T TERMINAL NAME: 2 WIRE STRIP LEN	.8MM SENSOF	r - Flat	CRIMP SPECIFICATION TYPE RECEPTACLE ION DIAMETER RANGE	TERMINAL DATA TERMINAL NAME WIRE STRIP	: 2.8MM SENSOR -	TE CRIMP SPECIFICAT - FLAT TYPE RECEPTAC INSULATION DIAMETER RANGE	LE				
4.20-4.80 mm [.165 TERMINAL APPLICATION SPECIFICATION		Ø1.40-2. -	10 mm [.055083 IN] -	4.20-4.80 mm TERMINAL APPLICATION SPECIFICATION	I	Ø1.30-2.10 mm [.051083 IN] 					REF 1 - 1 1
TERMINALS APP		1			(C)114-18148-1 APPLIED <u>A</u> <u>A</u> <u>A</u> TE TERMINAL						REF - 1 1 - 1 1
TE TERMINAL (B) 968087-1 (B) 968087-2 - -	TE TERMINAL (B) 1703034-1 (B) 1703034-2	TE SEAL	TE SEAL 828904-1	(A) 967542-1 (A) 967542-2 (C) 1-968855-1	(C) 1-968855-2 (C) 1-968855-3 (C) 1-968855-4	TE SEAL TE SEAL 828904-1					- 1 1 - 2 2 - 1 $-$
	CRIMP HEIGH		CRIMP HEIGHT	WIRF	- CRIMP HEIGHT	CRIMP HEIGHT					
WIRE SIZE	CRIMP HEIGH mm [INCH] <u>1.36+/-0.05 [.05</u> 1.27+/-0.05 [.05	54+/002]	CRIMP HEIGHT 9 REFERENCE SETTING 4.5 5.6	₩ I R E S I Z E 1.00mm2 0.75mm2	CRIMP HEIGHT mm [INCH] 1.20+/-0.05 [.047+/ 1.18+/-0.05 [.046+/		ING				$\begin{array}{c ccccccccccccccccccccccccccccccccccc$
0.50mm2	1.18+/-0.05 [.04	46+/002]	6.6	0.50mm2	1.15+/-0.05 [.045+/						
A RECOMMENDED S 2 GREASE BEARIN		ЗНТLY									- 1 1 - 1 - - 1 1
	D WITH THE APP	LICATOR.		-							- 1 - 1
ASSEMBLY. SEE MECHANICAL PNEUMATIC	BELOW FOR PAR FEED WITH "SM	T NUMBER: ART APPLICA RT APPLICAT) INTO BLANK MEMORY CHIP A TOR" CONVERSION: 8-2266017 OR" CONVERSION: 8-2266017 ADJUST": 8-2266017	- 4 - 4	TERMINAL L	UBRICANT IS RECOMMENDED.					7 - 1 - 1 - 1 1 - 2 2
SERVO FEED 5. ADJUSTMENT OF	WIIH "NON-CRI	MP HEIGHI A MAY BE REQU	DJUSI": 8-2266017 IRED WHEN MOVING THE								- 1 1 - 1 1 - 1 1
APPLY PART NU	MBER 2-23419-6	LOCTITE TO) THREADS OF ITEM 62 & 180 THREADS OF ITEM 242. 5 LOCTITE TO THREADS OF IT						, ITEM 40 TO OF SETTINGS		$ \begin{array}{c ccccccccccccccccccccccccccccccccccc$
	166 MUST BE OR		TEMS 35 & 252. Rectly in order to properly	(BELOW MINI		ED CRIMP HI	EIGHT SETTING		- 1 1 - 1 1 - 1 1 - 1 1
CRIMP HEIGHT APPLICATOR WA	REFERENCE SETT	THE FACTOR	SETTING USED WHEN THE Y. ADJUSTMENT MAY BE HE FIELD.								$\begin{array}{c ccccccccccccccccccccccccccccccccccc$
FOR ADDITIONA	L INFORMATION.		TO INSTRUCTION SHEET			$\begin{array}{ c c c c c c c c c c c c c c c c c c c$	- 2119957-2 1 8-21084-0	APPLICATOR SHIM	PACK 26 , .070 DIA. MAT. 25	0	- 1 1 - 1 1 1 1 1 1
A	IL APPLICATOR T 3 AND ATTACH T G. REFER TO IN	U A NON-CAF O THE LOCAT STRUCTION S	RIER CUTTING STYLE, ION ON THE BACK SIDE HEET FOR ADDITIONAL				- 2119640-1 - 1803259-1	PUSH ROD, AIR F BUSHING, FLANGE	EED 25 D 24	09	$\begin{array}{c ccccccccccccccccccccccccccccccccccc$
USE SHIM PACK	NG -6 NON-CRIM 2119957-2 TO IGHT AT NORMAL	ALIGN APPLI	CATOR'S MAXIMUM						NO NO		THIS DRAWING IS A CONTROLLED DOCUMENT IT IS SUBJECT TO CHANGE AND THE CONT SHOULD BE CONTACTED FOR DIMENSIONS:
HAS BEEN ADJU	AL IN ALLEN SC STED TO CORREC)CKET TO FIL T HEIGHT AT	L HOLE AFTER FLAT HD QUALIFICATION.				Shown on she		4 & 2 of 4		mm 0 1 2 3 4
APPLY #1-2341	9-5 LOC-TITE	TO THREADS.	N A STRIPPER SEAL TERMINAIN	NG UNIT.		(Pacific v	ersion show	vn on shee	ts 3 of 4 & 4	ot 4)	AN MATERIAL

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				С		7-000365		TB GB	-
				C 1) ECR-1	7-009056 7-010326	17JUL2017 }	MZ KZ KH JDG	
				D1	ECR-1	8 - 0 0 6 9 9 4	07MAY2018 J	JAH JDG	
-	- 1		- 1	211964		FEED CAM, AIR FEED DETENT PIN		248	-
-	1	1	1	1 - 2 2 2 7	79-3	SPRING, COMPRESSION		246	
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1			1	211908		RETAINER, INSULATION DIAL SCR, SKT HD CAP M3 X 4.0		· 242 · 241	
2	2	-	-	216840	00-6	SHCS, LOW HEAD, RoHS, M5 X	16	240	
-	-	- 1	1	211958 206344		MECHANICAL FEED ASSEMBLY AIR FEED MODULE		· 239 · 238	-
1	1	-	-	211974		TAG, IDENTIFICATION		213]
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1	1	1	1	207938	83-4	SCR, BHSC, RoHS (M4 X 8)	<u> </u>	· 60	
-	- 1	$\left \begin{array}{c} 1 \\ 1 \end{array} \right $	1	5 - 1802 98557		SCR, HEX HD CAP, M4 X 6.0 SCR, FLT SKT HD CAP M3 X 16	<u>^</u>	· 59 · 57	-
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-	1	1	1	211909	92-1	BOLT, ADJUSTMENT		35	
1 2	1 2	1	1	175235 207938		SUPPORT, TERMINAL SCR, BHSC, RoHS (M4 X 20)		· 34 · 33	
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1	1	1	1	211980	06-1	INSERT, SHEAR		13	
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1	1	1	1	211980	05-1	SHEAR HOLDER, FRONT		10	
1	1		1	31870 133320) 7 - 1	FLOATING SHEAR, FRONT ANVIL, COMBINATION		9	4
-	-	- 	-	-) 4 ~ 1	ANVIL, COMDINATION		. 7	
-	- 1	- 1	- 1	- 211978	<u>• 1 - 1</u>	- DEPRESSOR, SHEAR		6	
1	1	1	1	23801	1 - 9	BLOCK, CRIMPER SPACER		. 4	
1	$\begin{bmatrix} 1 \\ 1 \end{bmatrix}$		$\begin{bmatrix} 1\\ 1 \end{bmatrix}$	3-21197 1-4558		CRIMPER, INSULATION O PR SPACER, CRIMPER	REMIUM	· 3 · 2	-
1	1	1	1	1 - 4564		CRIMPER, WIRE PREMIUM		· 1	
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3 PL 4 PL ANGL	LC H LC H LES	±- ±- ±- <u>±-</u>	′	APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	RE	ESTRICTED TO	-
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SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



MECHANICAL Post feed

(49)

AMP 4805 REV 31MAR2000

40mm STROKE

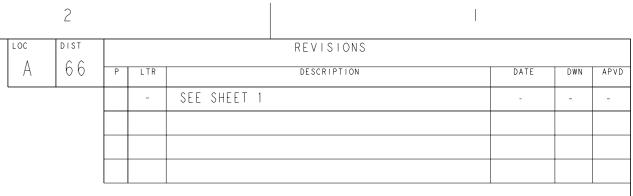
L 40mm STROKE MECHANICAL PRE FEED

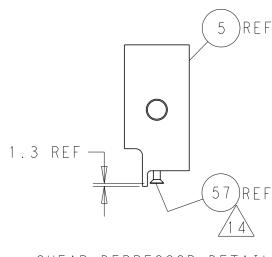
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40mm STROKE AIR FEED

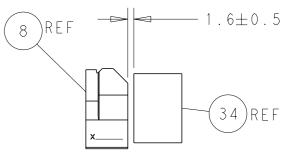
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ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) MATERIAL









00779 C-2266017

ustomer Accessible Production Drawing Scale 1:2 SHEET 2 of 4 REV D 1

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FINISH

APPLICATION SPEC

	8 7 THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20	6	5		4
	© COPYRIGHT 20BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.PACIFIC VERSION TERMINATOR INTERFACE ADAPTERPART NUMBERREVISION DESCRIPTION	FEED TYPE			
	2 2266017 1 D FINE CRIMP HEIGHT ADJUST	MECHANICAL OBSOLETE	-		
	2 2266017 2 D FINE CRIMP HEIGHT ADJUST	PNEUMATIC OBSOLETE	Ξ.		
D	22266017-5DFINE CRIMP HEIGHT ADJUST22266017-7DFINE CRIMP HEIGHT ADJUST7-2266017-7ACRIMP TOOLING KIT	SERVO LATCH PLATE OBSOLETE NONE OBSOLETE			
	APPLICATOR DATACRIMPSIZETYPEWIRE2.03 mm [.080]FINSUL4.06 mm [.160]OAPPLICATOR INSTRUCTIONS 408-10389Image: Colspan="2">Image: Colspan="2" Image: Colsp				
С	TERMINAL DATA: TE TERMINALTE CRIMP SPECIFICATIONTERMINAL NAME: 2.8MM SENSOR - FLAT TYPE RECEPTACLEWIRE STRIP LENGTHINSULATION DIAMETER RANGE4.20-4.80 mm [.165189 IN]01.40-2.10 mm [.055083 IN]TERMINAL(B) 114-18144-1TERMINALTE TERMINALTE SEALTE SEAL <th< th=""><th>WIRE STRIP LENGTH 4.20-4.80 mm [.165 TERMINAL (A) APPLICATION (C) TERMINALS APPLI TERMINAL TE (A) 967542-1 (C) (A) 967542-2 (C)</th><th>MM SENSOR - FLAT TY INSULATION (189 IN] 114-18144-0 114-18148-1 -</th><th>IMP SPECIFICATION PE RECEPTACLE DIAMETER RANGE mm [.051083 IN]</th><th></th></th<>	WIRE STRIP LENGTH 4.20-4.80 mm [.165 TERMINAL (A) APPLICATION (C) TERMINALS APPLI TERMINAL TE (A) 967542-1 (C) (A) 967542-2 (C)	MM SENSOR - FLAT TY INSULATION (189 IN] 114-18144-0 114-18148-1 -	IMP SPECIFICATION PE RECEPTACLE DIAMETER RANGE mm [.051083 IN]	
	WIRE CRIMPHEIGHT CRIMPHEIGHT CRIMPHEIGHT Percention 1.00mm2 1.36+/-0.05 [.054+/002] 4.5 0.75mm2 1.27+/-0.05 [.050+/002] 5.6 0.50mm2 1.18+/-0.05 [.046+/002] 6.6	1.00mm2 1.2 0.75mm2 1.1	IMP HEIGHT [INCH] 20+/-0.05 [.047+/002] 8+/-0.05 [.046+/002] 5+/-0.05 [.045+/002]	RIMP HEIGHT 9 EFERENCE SETTING 6.3 6.5 6.8	
В	 ▲ RECOMMENDED SPARE PARTS ▲ GREASE BEARING SURFACES LIGHTLY 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR. ▲ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266017- PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266017- SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266017- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE 	4			
	APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152. MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE			LARGEST W BELOW MIN	LATION, SET WI IRE SIZE SETTI IMUM REQUIRED E DAMAGE TO CR
А	APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.			- 1 1 1 1 - 77 - 27 - 25 - 2	
	APPLY #1-23419-5 LOC-TITE TO THREADS. APPLY #1-23419-5 LOC-TITE TO THREADS. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINAING TERMINAL LUBRICANT IS RECOMMENDED. AMP 4805 REV 3IMAR2000	5 UNIT.	(A +	Shown	ACIFIC VE on sheets 3 o ion shown on s

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

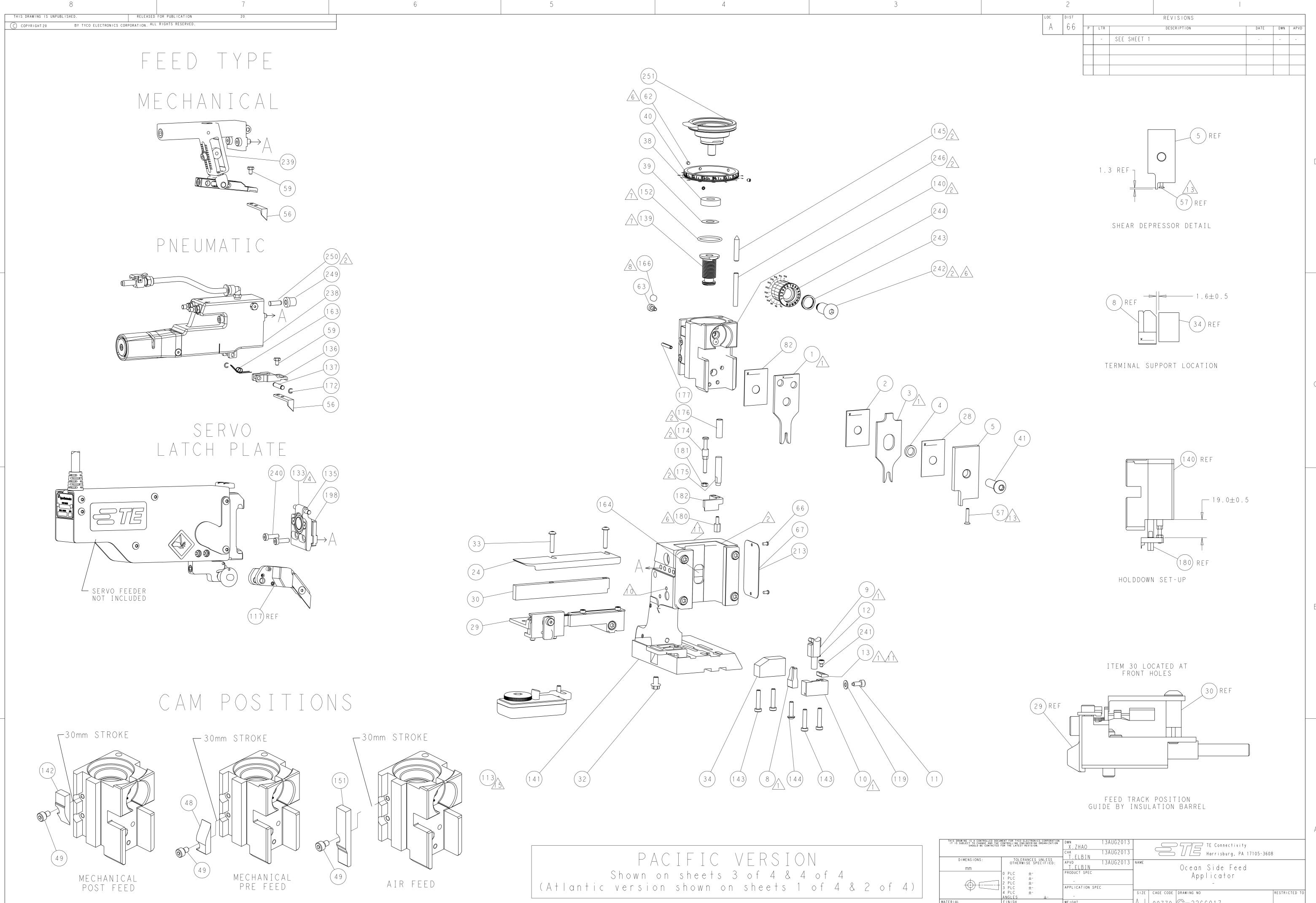
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
- 7 7	- 27	- 25	- 2 2	- 21	PART NO	DESCRIPTION	I T E M N O

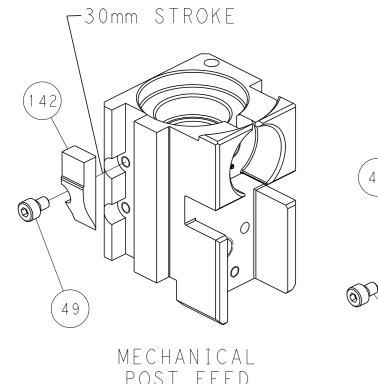
TWARNINU
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.

	CRIMP HEIGHT
+/002]	6.3
+/002]	6.5
+/002]	6.8

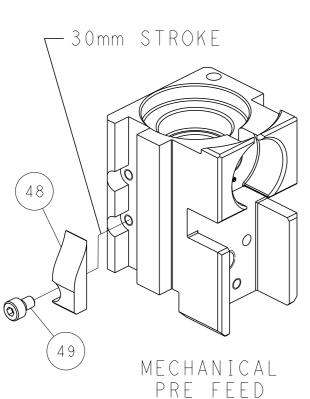
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		SET UP GAUGE 2119599-1 A 66 P LTR				R	REVISIONS DESCRIPTION DATE					DWN APVD		
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Γ	_	-	_	1	_	180325	59-1	BUSHI	NG, FLANGEI	D		· ·	249	
-	-	1	1	1	1	1 - 2 2 2 ⁻ 2 1 1 9 0 8	79-3	SPRIN	IG, COMPRES		ISTMENT	- / L	246 244	
_	-	1	1	1	1	207976	ô 4 - 1	WASHE	R, WAVE SPI	RING, CREST		ST :	243	
<u>_6</u>	-	1	1	1	1	211908 7-1802			NER, INSUL, SKT HD CAP				2 4 2 2 4 1	
_	-		2		-	216840			LOW HEAD, NICAL FEED	Rohs, M5 X Assembly	16		240 239	D
-	-	-	-	1	-	206344			EED MODULE DENTIFICAT	ION		. / [238	
-	-	-	1	-	-	190109	94-3	SPACE	R, FEEDER			-	198	
_	-	1	1	1	1	4 - 17223 1 - 50180		NUT,	PER, SIDE HEX, REG,	RoHS, M3.5		-	182 181	
6	-	1	1	1	1	<u>1-17523</u> 99311			OFF,HOLD-DO SLOTTED SPI	OWN RING 3.0 X 1	20.0	-	<u>180</u> 177	
-	-	1	1	1	1	5-2228 175235			IG, COMPRES			-	176	
-	-	1	1	1	1	190168	80-2	GUIDE	PIN, HOLDDO	NWC		·	174 174	
	-	- 1	1	2	-	21045 99496	9 - 1	MAGNE	T, RARE EA	XTERN, 3/16 RTH HIGH ENI			166	
-	-	REF -	REF	REF 1	REF -	99497 24063			ER, MAGNET IG, FEED FII			-	164 163	
<u>_7</u>	-	1	1	1	1	8 - 2 1 0 8 2 1 1 9 6 4			IG, .801 ID CAM, AIR FI	, .070 DIA. EED	MAT.		152 151	
-	-	1	1	1	1	211979	98-2	DETEN	IT PIN BHSC, RoHS				145	
-	_	4	4	4	4	216840)0-5	SHCS,	LOW HEAD,	Rohs, M4 X	20		143	
-	-	- 1	- 1	- 1	1	211965 2-21196			CAM, POST CATOR BASIC	FEED C ASSEMBLY,	SF	-	142 141	
\wedge	-	1	1	1	1	211965			ASIAN STYL	E, SIDE FEEI T)	-	140 139	С
-	-	-	-	1	-	3-2362	27-7	PIN,		VD, 3/16 X	.854	•	137 136	
-	-	-	REF	-	-	SEE NO	TE 4	MEMOR	Y CHIP, PRO	OG R A MME D		-	135	
-	-	- 1	1	- 1	- 1	163374 1-1802		WASHE) FEED LATCI IR, FLAT, RI	EG M4			133 119	
13	-	- 1	REF 1	- 1	- 1	211994 211995			FINGER ASSI	EMBLY,SF R, SIDE FEEI)		117 113	
	-	1	1	1	1	45588 211995			R, CRIMPER MENTATION P				82	
-	-	1	- 2	1	1	211974	40-1	TAG,I	DENTIFICAT	ION	100		67	
_	-	1	1	1	1	211979	93-1	LIMIT	ER, ADJUSTI			-	66 63	
<u>_6</u>	-	3	3	3	3	99276 5-1802			SEI, SOC, (HEX HD CAP	<u>CONE PNT, M.</u> , M4 X 6.0	<u>3 x 4.0</u>		62 59	
13	-	1 -	1 -	1	1	98557 133868			FLT SKT HD FEED	CAP M3 X 1	6.0		57 56	
-	-	-	-	1	2	18023	3 - 9	SCR,	SKT HD CAP CAM, PRE FI			•	49 48	
-	-	1	1	1	1	207938	33-7	SCR,	BHSC, RoHS	(M8 X 25)			41	
-	-	1	1	1	1	211964 211995	57-1	APPLI	CATOR SHIM		JSIMENI		40 39	B
-	-	1	1	1	1	211964 175235			ASHER, PREG DRT, TERMIN				38 34	
-	-	2	2	2	2	207938			BHSC, Rohs IEAD, FLANG	(M4 X 20) ED, M5 x 8mr	n LONG		33 32	
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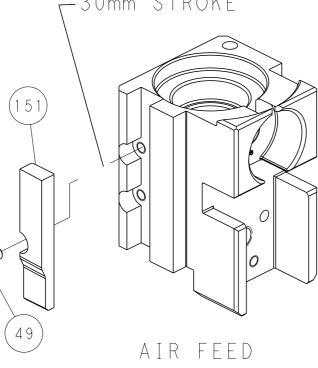
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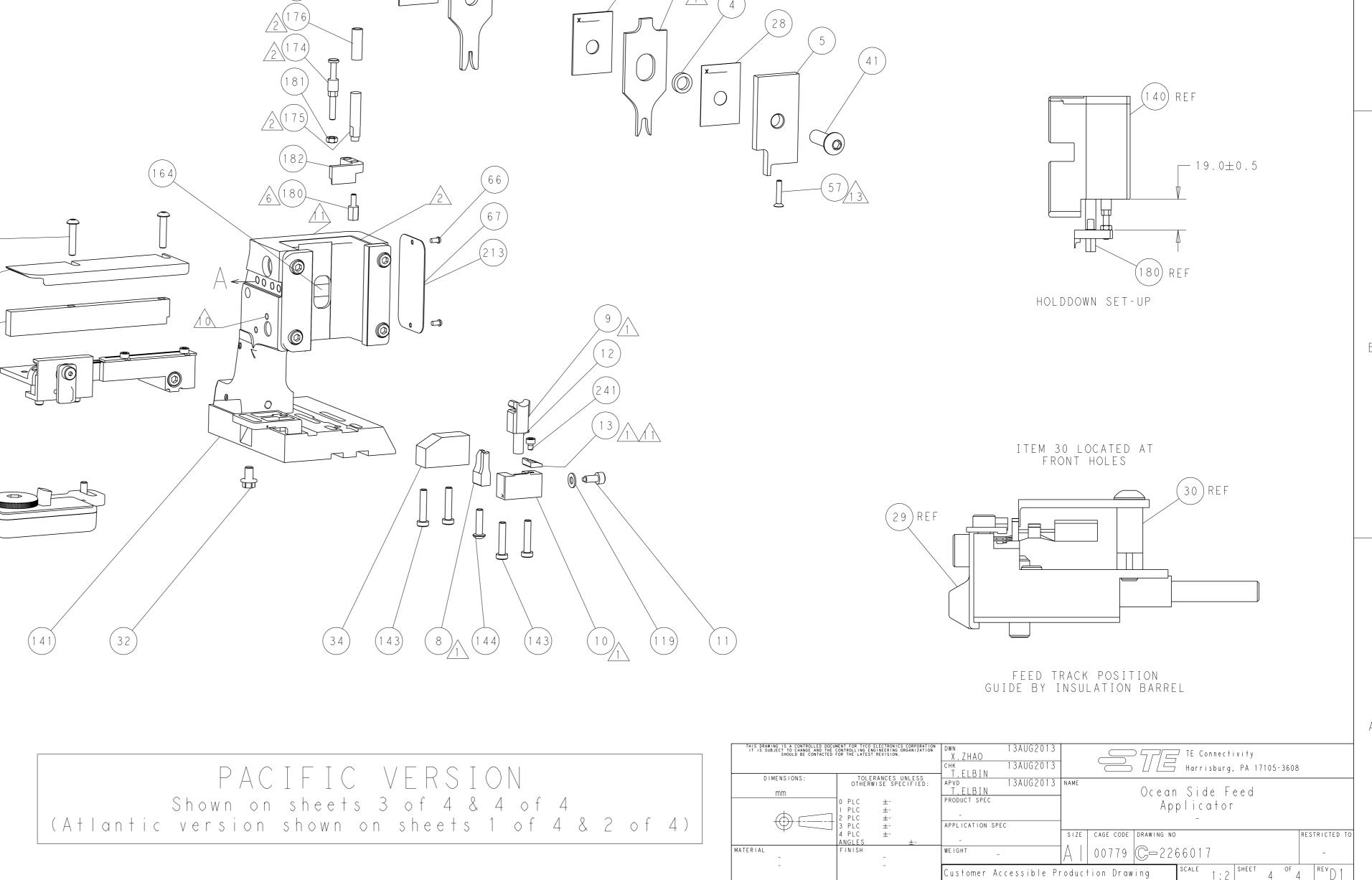


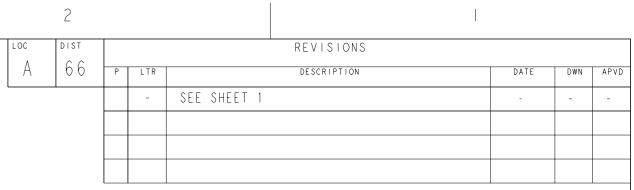


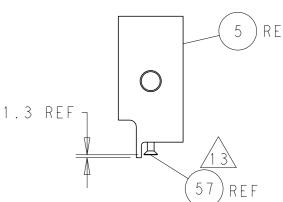
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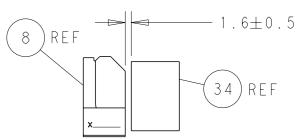












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