	8 THIS DRAWING IS UNPUBLISHED. (C) COPYRIGHT 20 BY TYCO ELECTRO	RELEASED FOR PUBLICATION DNICS CORPORATION. ALL RIGHTS RESERVED.	7	6
	PART REVISION 2150222-1 C 2150222-2 C 7-2150222-2 C 7-2150222-7 A		FEED TYPE MECHANICAL PNEUMATIC MECHANICAL PNEUMATIC -	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER
D	APPLICATOR DA CRIMP SIZE WIRE 1.40 mm [.055] INSUL 2.29 mm [.090]	TA TYPE F F		
С	TERMINAL NAME: RECER WIRE STRIP LENGTH 5.41-5.66 mm [.21322 TERMINAL APPLICATION SPECIFICATION TERMINALS APPLIED TE TERMINAL G.H./LEA	TERMINAL INSULATION 3 INJ Ø 2.03-2.54 mm [. 4-2025 - 	N DIAMETER RANGE	
В	SIZE mm [0.60mm2 1.14+ 0.50mm2 1.09+ 0.35mm2 1.02+ 0.30mm2 0.99+	1P HEIGHT CRIMP INCH] CRIMP REFERE /-0.05 [.045+/002]	NCE SETTÍNG 5.7 6.3 7.1 7.4	
	LUBRICATION & ST APPLY PART NUMBER APPLY PART NUMBE CRIMP HEIGHT REFE APPLICATOR WAS Q NECESSARY WHEN R	ORAGE OF APPLICATOR. I-23419-5 LOCTITE TO THREAD R 2-23419-6 LOCTITE TO THREA RENCE SETTING WAS THE SETTIN UALIFIED AT THE FACTORY. ADJ UNNING APPLICATOR IN THE FIE OTHERWISE TORQUE VALUES SHAL	S OF ITEM 180. DS OF ITEM 242. G USED WHEN THE USTMENT MAY BE LD.	*WARNING ON INSTAL FOR LARGE THAN THE REFER TO
A				

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)

LLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING EST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.



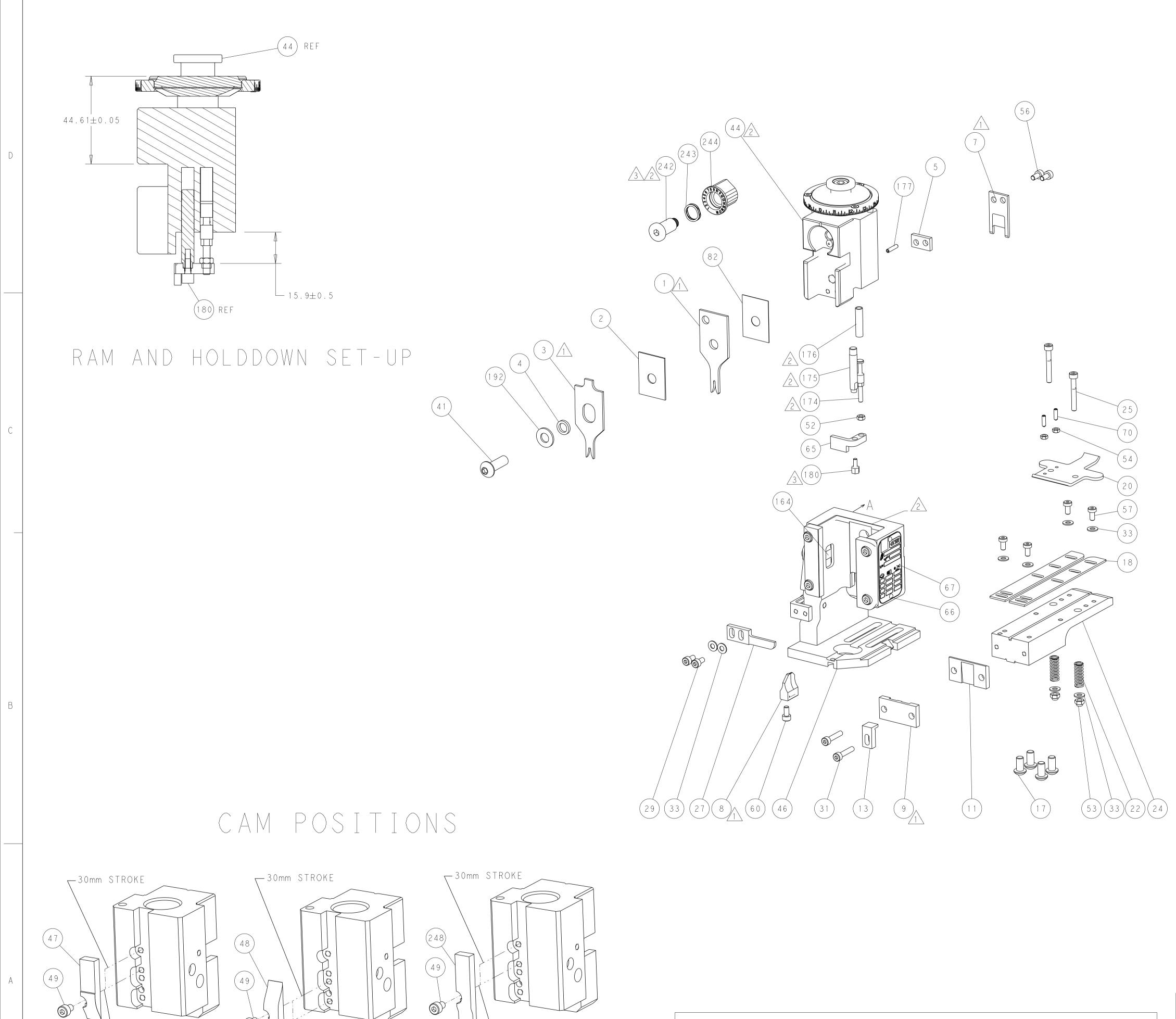
THIS DRAWING IS A CONTROLLED IT IS SUBJECT TO CHANGE AND SHOULD BE CONTAC DIMENSIONS: mm MATERIAL

REVISIONS A 66 DESCRIPTION DATE DWN APVD 22NOV2011 | TB | RK C ECR-22-129302

_	1	-		2119641-1	FEED CAM, AIR FEED	248	I
1	1	1		2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	I
1	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
1	1	1		2119083-1	RETAINER, INSULATION DIAL	242	I
1	_	1	, ,	2119580-1	MECHANICAL FEED ASSEMBLY	239	I
-	1	-		2844940-3	AIR FEED MODULE	238	I
1	1	1		1 - 1 8 0 2 8 - 0	WASHER, FLAT, REG M8	192	I
1	1	1		1752354-4	STANDOFF, HOLD-DOWN	180	I
1	1	1		-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	I
1	1	1		8 - 2 2 2 8 0 - 7	SPRING, COMPRESSION	176	I
1	1	1		1752353-2	GUIDE PIN, HOLDDOWN	175	I
1				1901680-2	GUIDE PIN, HOLDDOWN	174	I
<u>RE</u>	FREF	RFF		994970-2	COUNTER, MAGNETIC	164	С
1				455888-3	SPACER, CRIMPER	82	I
	1			1803607-4	DOCUMENTATION PACKAGE	71	I
2	2	2		2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	I
	1			2119740-1	TAG, IDENTIFICATION	67	I
2	2	2		2168078-1	SCREW, DRIVE, RH, Rohs, 2 x .188	66	I
1	1			1901681-5	HOLDDOWN, TERMINAL	65	I
1	1			2168083-2	SCR, SKT HD CAP, Rohs, M4 X 8.0	60	I
1	1			5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
1		4		2063961-1	FEED FINGER	<u>58</u> 57	I
4	4	4		2168400-4 2168083-2	SHCS, LOW HEAD, ROHS, M4 X 8	56	I
2	2	2		5018030-1	SCR, SKT HD CAP, Rohs, M4 X 8.0	54	I
2	2	2		986965-8	NUT, HEX, REG, R⊙HS, M3 NUT, LOCK, HEX, TORQUE (M4)	53	I
<u> </u>	<u> </u>	<u> </u>		- 5018030-0	NUT, HEX, REG, RoHS, M3.5	52	I
	1	 _		2063961-1	FEED FINGER	51	I
2	1	2		18023-9	SCR, SKT HD CAP M4 X 6.0	49	I
1		1		2119652-1	FEED CAM, PRE FEED	4 9	I
1	_	1		2119653-1	FEED CAM, POST FEED	47	I
1	1	1		2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	I
1	1	1		1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	I
1	1	1		1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1	I
8	8	8		1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	33	В
2	2	2		2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	D
2	2	2		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	I
1	1	1		240639-1	STRIPPER (MACHINING)	27	I
2	2	2	1 -	-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	I
1	1	1		1752371-9	PLATE, STRIP GUIDE	24	I
2	2	2		4 - 2 2 2 8 1 - 1	SPRING, COMPRESSION	22	I
1	1	1	-	1803292-1	DRAG	20	I
2	2	2		1901259-3	GUIDE, LOWER STRIP	18	I
4	4	4	1 -	-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	I
1	1	1		1752360-1	SPACER, HOLD-DOWN	13	I
1	1	1		240833-2	PLATE, REAR SHEAR	1 1	
-	-	-		-		10	I
1		1		690482-4	PLATE, FRONT SHEAR	9	I
2			8		ANVIL, COMBINATION	8	I
				690474-4	BLADE, SLUG		I
-	-	-		-		6	I
1	1			240641-8	SPACER	5	I
<u> </u> つ	1			2 - 238011 - 2	BLOCK, CRIMPER SPACER	4	I
2	1	1		<u>-2119582-1</u> 455888-9	CRIMPER, INSULATION F PREMIUM		I
2	1	1		456402-1	SPACER, CRIMPER CRIMPER, WIRE PREMIUM		I
						ITEM	
- 7	- 2	- 1	F	PART NO	DESCRIPTION	NO	A
DOCUMENT THE CONT TED FOR	FOR TYCO ELI ROLLING ENGII THE LATEST RI	ECTRONICS CON NEERING ORG/ EVISION.	DRPORATION ANIZATION	DWN 22NOV B.WEAVER	2011 TE Connectivity		1
	TALES	NCES III	Ecc	снк 22NOV К.STAKEM			
	TOLERA OTHERWI	SE SPECI	FIED:	APVD 22NOV G.BAILEY	OCEAN 2.0 End Feed		
	PLC PLC	±- ±-		PRODUCT SPEC	Applicator		
23	PLC PLC	±- ±-		- APPLICATION SPEC	-		
AN	PLC GLES	±- :	±	-		RESTRICTED TO	
	NISH	-		WEIGHT _	A 00779 C=2150222	-	

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

Customer Accessible Production Drawing



5

AMP 4805 REV 31MAR2000

└-40mm STROKE

MECHANICAL POST FEED ↓40mm STROKE

MECHANICAL PRE FEED

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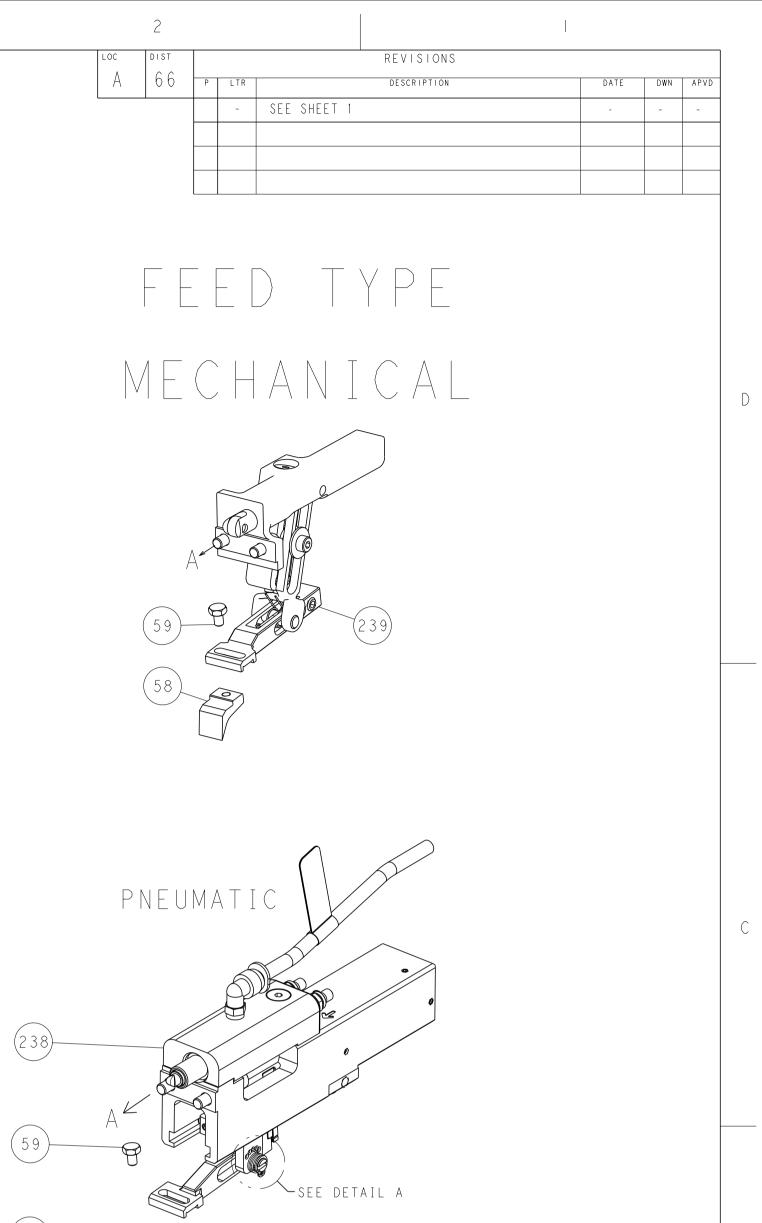
AIR FEED

└─40mm STROKE

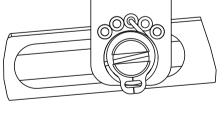
ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) THIS DRAWING IS A CONTROLLED DOC IT IS SUBJECT TO CHANGE AND THE SHOULD BE CONTACTED DIMENSIONS: MM MATERIAL --

3

4



FEED SPRING SETTING POSITION



DETAIL A

В

DOCUMENT FOR TYCO ELECTRONICS CORPORATION THE CONTROLLING ENGINEERING ORGANIZATION TED FOR THE LATEST REVISION.		dwn B.WEAVER				TE	TE Connecti	,				
TOLERANCES UNLESS OTHERWISE SPECIFIED:			LESS IFIED:	CHK K.STAKEN APVD	22NOV20							
	0 PLC I PLC 2 PLC	±- ±- ±-		G.BAILE PRODUCT SPEC -	0		(2.0 End plicator			
	3 PLC 4 PLC ANGLES	±- ±-	±	APPLICATION -	SPEC	S I Z E	CAGE CODE	DRAWING NC			RES	STRICTED TO
	FINISH	-		WEIGHT	-	AI	00779	C-21	-			-
				Customer	Accessible	e Produ	tion Draw	ring	scale 1:1	SHEET 2	^{of} 4	REV C
				SHE	EETS 38	4 AR	E NOT F	REQUIR	ED FOR A	TLANTI) ve	RSION

		8		7	6
	THIS DRAWING IS UNPUBLIS	HED. RELEASED	FOR PUBLICATION	20	
	C COPYRIGHT 20	BY TYCO ELECTRONICS CORPORATION. ALL	RIGHTS RESERVED.		
	P A R T N U M B E R	REVISION DE	SCRIPTION	FEED TYPE	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER
	2-2150222-1	C FINE CRIM	1P HEIGHT ADJUST	MECHANICAL	
	2-2 50222-2		IP HEIGHT ADJUST	PNEUMATIC	
	7-2 50222-7	A CRIMP	TOOLING KIT	_	
D					
	CRIMP S WIRE 1.40 mm	UCTIONS			
C	TERMINAL NAME WIRE STRIP 5.41-5.66 mm TERMINAL APPLICATION TERMINALS TERMINAL 2113211-1	n [.213223 IN] 114-2025 -	1 FASTON ERMINAL INSULATIO Ø 2.03-2.54 mm [. - TE TERMINAL (1	N DIAMETER RANGE	

WIRE SIZE (SIZE)	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT A REFERENCE SETTING
0.60mm2	1.14+/-0.05 [.045+/002]	5.7
0.50mm2	1.09+/-0.05 [.043+/002]	6.3
0.35mm2	1.02+/-0.05 [.040+/002]	7.1
0.30mm2	0.99+/-0.05 [.039+/002]	7.4

AMP 4805 REV 31MAR2000

/1 RECOMMENDED SPARE PARTS.

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

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT IOI-35000.

*WARNING

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.

5 4 3

	2			1			
LOC	DIST			REVISIONS			
А	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

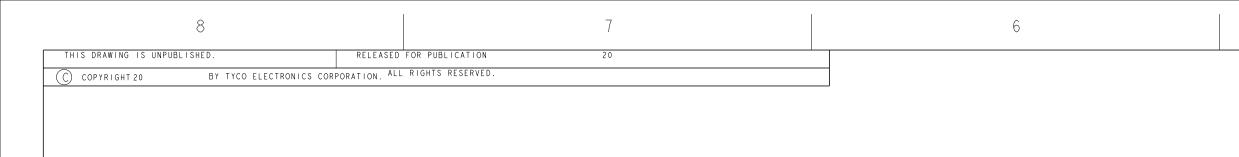
	_	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	_	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
$\sqrt{3}$	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
201	_	_	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	_	1	_	2844940-3	AIR FEED MODULE	238
-	_	1	1	1 - 1 8 0 2 8 - 0	WASHER, FLAT, REG M8	192
-	_	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	_	1	1	1752354-4	STANDOFF, HOLD-DOWN	180
/3		1	1	6 - 993111 - 6		177
-	_	1	1		PIN, SLOTTED SPRING 3.0 X 14.0	
-	-	1		8-22280-7	SPRING, COMPRESSION	176
-	_			1752353-2	GUIDE PIN, HOLDDOWN	175
_	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
_	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	_	2119641-2	FEED CAM, AIR FEED	152
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	_	-	1	2119653-2	FEED CAM, POST FEED	142
-	_	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
_	_	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	_	1	1	455888-3	SPACER, CRIMPER	82
-	_	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-						
-	-		2	2 - 18032 - 2	SCR, SET, FLT PNT, M3 X 10.0	70
-	-			2119740-1	TAG, IDENTIFICATION	67
_	-	2	2	2168078-1	SCREW, DRIVE, RH, Rohs, 2 x .188	66
	-	1	1	1901681-5	HOLDDOWN, TERMINAL	65
	-	1	1	5 - 1 8 0 2 2 - 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
-	_	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	_	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	_	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-			<u> </u>			
-	-			1-5018030-0	NUT, HEX, REG, ROHS, M3.5	52
-	_		-	2063961-1	FEED FINGER	51
_	-	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
	-	8	8	1 - 1 8 0 2 8 - 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
-	_	1	1	240639-1	STRIPPER (MACHINING)	27
-	_	2	2	1 - 2168083 - 5	SCR, SKT HD CAP, RoHS, M4 X 30	25
_		1	1	1752371-9	PLATE, STRIP GUIDE	24
-						
-	_	2	2	4 - 22281 - 1	SPRING, COMPRESSION	22
-	_			1803292-1	DRAG	20
-	_	2	2	1901259-3	GUIDE, LOWER STRIP	18
	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	240833-2	PLATE, REAR SHEAR	1 1
_	-	-	_	-	-	10
1	_	1	1	690482-4	PLATE, FRONT SHEAR	9
$\overline{1}$	1	1	1	8 - 1 6 3 3 3 8 4 - 2	ANVIL, COMBINATION	8
$\overline{\Lambda}$	_	1	1	690474-4	BLADE, SLUG	7
	_	-	_		-	6
-	_	1		240641-8	SPACER	5
-	_	1		2 - 2 3 8 0 1 1 - 2	BLOCK, CRIMPER SPACER	4
	1	1				
$\angle 1 $		1		1-2119582-1	CRIMPER, INSULATION F PREMIUM	3
\wedge	-	4		455888-9	SPACER, CRIMPER	2
$\langle 1 \rangle$				456402-1	CRIMPER, WIRE PREMIUM	
	-77	/-22	- 2 1	PART NO	DESCRIPTION	ITEM
AWING IS A CONTROLLED D						NO
AWING IS A CONTROLLED D SUBJECT TO CHANGE AND T SHOULD BE CONTACT	HE CONTRO ED FOR TH	DLLING ÉNĞĪN IE LATEST RE	EERING ORGA	I D.WLAVLN		
HENSIONS:		TOLFRA	NCES UNI	K STAKEM		
mm		OTHERWIS	NCES UNL SE SPECI	<u>G.BAILEY</u>	V2011 OCEAN 2.0 End Feed	
1	0 P		±- ±-	PRODUCT SPEC	Applicator	
\bigcirc	- 2 P 3 P	LC	±- ±-	- APPLICATION SPEC		
+	4 P		±- =	<u>-</u>	SIZE CAGE CODE DRAWING NO	RESTRICTED TO
-		ISH	-	WEIGHT _	A 00779 C-2150222	-
-			-		ble Production Drawing SCALE 1.1 SHEET 2 OF A	REV

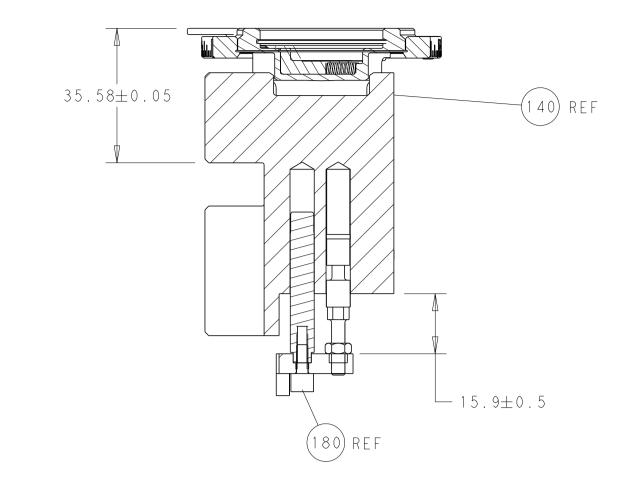
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Customer Accessible Production Drawing

SCALE 1.1 SHEET 3 OF REV C

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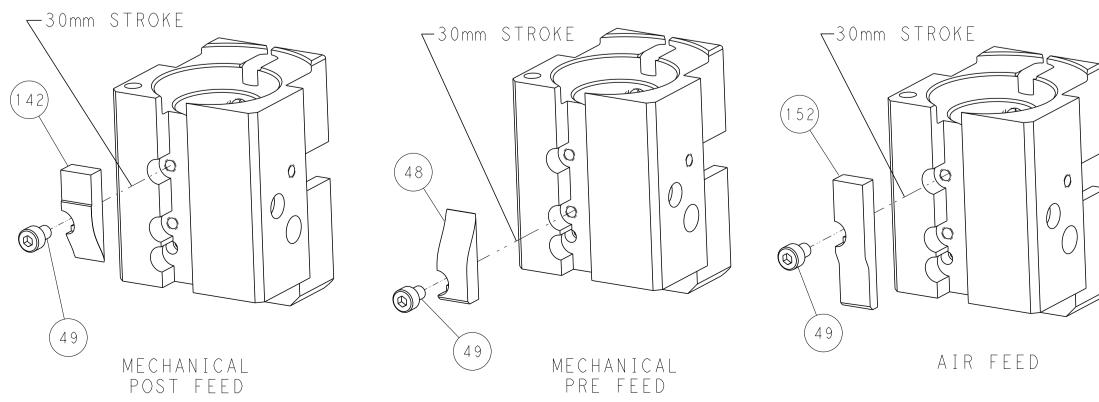




RAM AND HOLDDOWN SET-UP



CAM POSITIONS



AMP 4805 REV 31MAR2000

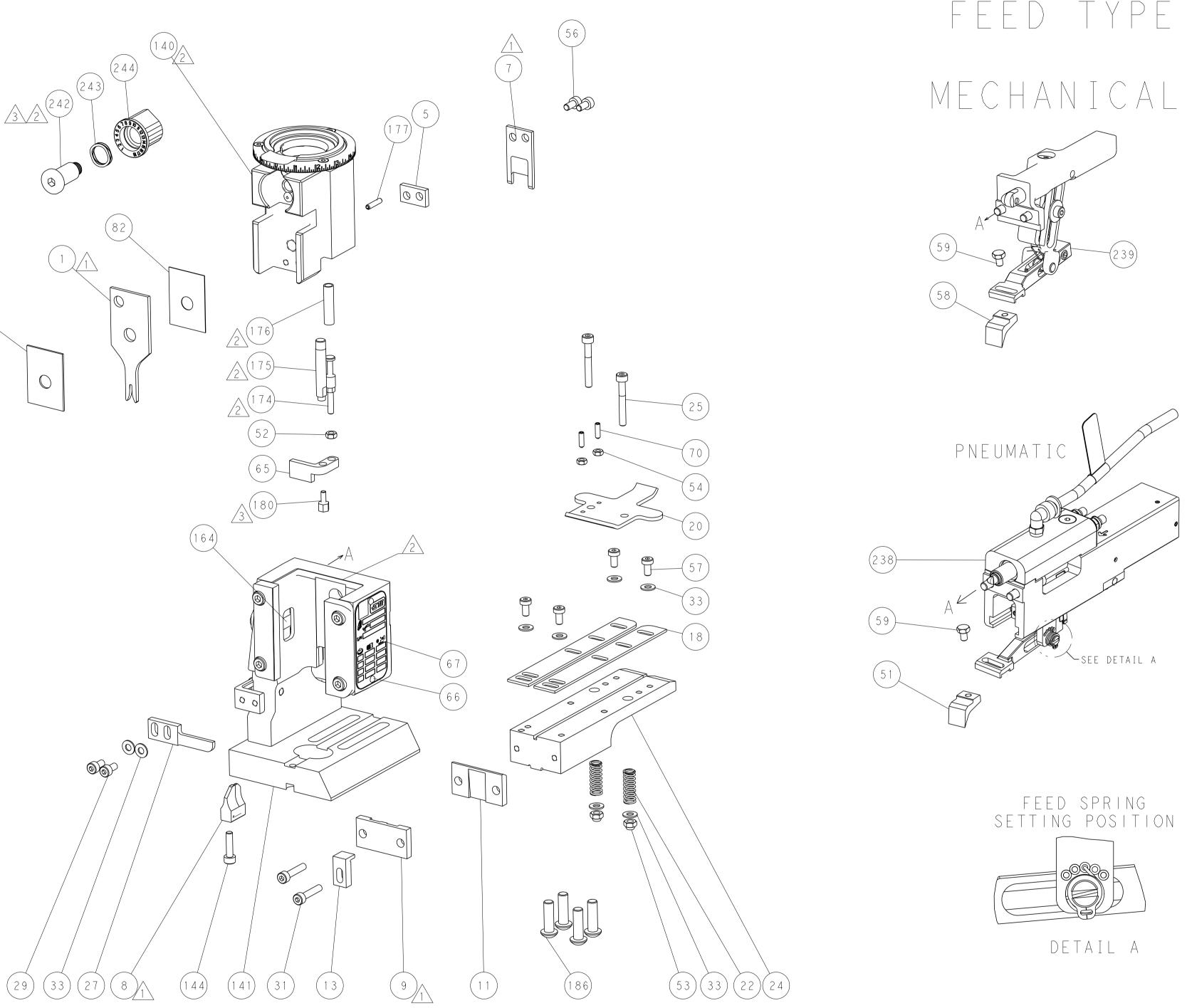
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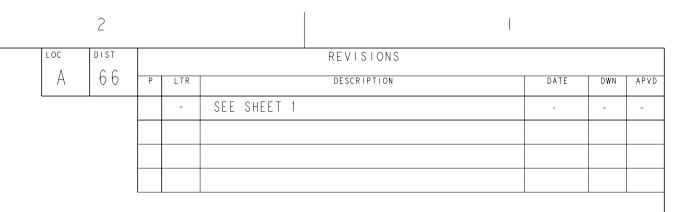
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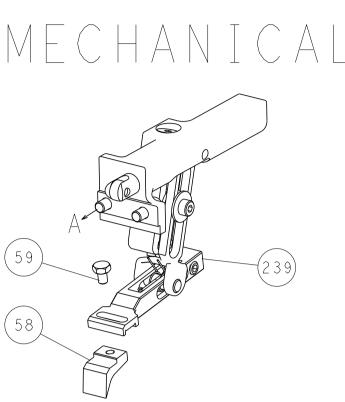
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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MATERIAL	
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FEED TYPE



DOCU THE TED	MENT FOR TYCO ELECTRONICS CORPORATION CONTROLLING ENGINEERING ORGANIZATION FOR THE LATEST REVISION.	dwn B.WEAVER	22NOV2011				TE Connect	i v i t y	
	r	CHK K.STAKEM	22NOV2011	-			Harrisburg		608
	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD G.BAILEY	22NOV2011	NAME	() (F A N	2.0 End	Feed	
_	0 PLC ±- 1 PLC ±-	PRODUCT SPEC					plicator		
	2 PLC ±- 3 PLC ±-	APPLICATION SPI	EC	-			-		
	4 PLC ±- ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO			RESTRICTED TO
	FINISH -	WEIGHT -		1 A	00779	C-21	50222		-
	-	Customer Ad	ccessible P	roduc [.]	tion Draw	ing	scale 1:1	SHEET 4	of 4 Rev C
		SHE	ETS 1 &	2 AF	RE NOT	REQUI	RED FOR	PACIFIC	C VERSION

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