8 7	6	5	4	3
THIS DRAWING IS UNPUBLISHED.RELEASED FOR PUBLICATION20© COPYRIGHT 20BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.PART NUMBERREVISIONDESCRIPTIONFEED T	ATLANTIC VERSION INTERFACE		I	I
2150378-1CFINE CRIMP HEIGHT ADJUSTMECHANI2150378-2DFINE CRIMP HEIGHT ADJUSTPNEUMAT7-2150378-1CMECHANICAL AND CRIMP TOOLING KITMECHANI7-2150378-2DPNEUMATIC AND CRIMP TOOLING KITPNEUMAT7-2150378-7BCRIMP TOOLING KIT-DDCRIMP TOOLING KIT-	TIC CAL			
APPLICATOR DATA CRIMP SIZE TYPE WIRE 2.79 mm [.110] F INSUL 4.32 mm [.170] F APPL INSTRUCTIONS 408-35043				
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION TERMINAL NAME: . 250 SERIES AUTOMOTIVE POS LOCK RECE WIRE STRIP LENGTH INSULATION DIAMETER RANGE 4.20-5.20 mm [.165205 IN] Ø2.20-3.40 mm [.087134 IN] TERMINAL 114-5060 APPLICATION - SPECIFICATION - TERMINAL 114-5060 TERMINAL - TERMINAL - TERMINALS APPLIED TE TERMINAL TE TERMINAL 170454-1 170454-2		.250 SERIES AUTOMOTIVE POS LOCK RI NGTH INSULATION DIAMETER RANG .165205 INJ Ø2.20-3.40 mm [.087134 IN 6		
WIRE SIZE CRIMP HEIGHT Mm [INCH] CRIMP HEIGHT AREFERENCE SETTIN 14 AWG OR 2.00mm2 1.86+/-0.05 [.073+/002] 4.5 16 AWG OR 1.25mm2 1.62+/-0.05 [.064+/002] 6.9 18 AWG OR 0.85mm2 1.50+/-0.05 [.059+/002] 8.2	LUBRICATION AND	CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SET 1.54+/-0.05 [.061+/002] 7.7 *WARNING ON INSTALLATION, SET WI FOD HADOFOT WIDE OUTF	RE DISC TO CRIMP HEIGH	
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMEN NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED F ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOM FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE P THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIF CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN AP CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GRO 	D WHEN THE T MAY BE OR PRE-FEED WITH E APPLICATIONS. RE-FEED CONFIGURATION. AND UNIQUE CUSTOMER REQUIREMN IED BY TE CONNECTIVITY. THIS	THAN THE VALUE SHOWN MA REFER TO THE INSTRUCTIO	CRIMP HEIGHT REFERENCE Y CAUSE DAMAGE TO THE N SHEET FOR PROPER SET	CRIMP TOOLING,
EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT T VALIDATED AND APPROVED APPLICATIONS, AS STATED WI SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPL	IED WARRANTIES OF MERCHANTABI IGHLY RECOMMENDED THAT THE CU DUCT PERFORMANCE IN THE SPECI			
			ATLANTIC VFR	$\sim SION$

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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)

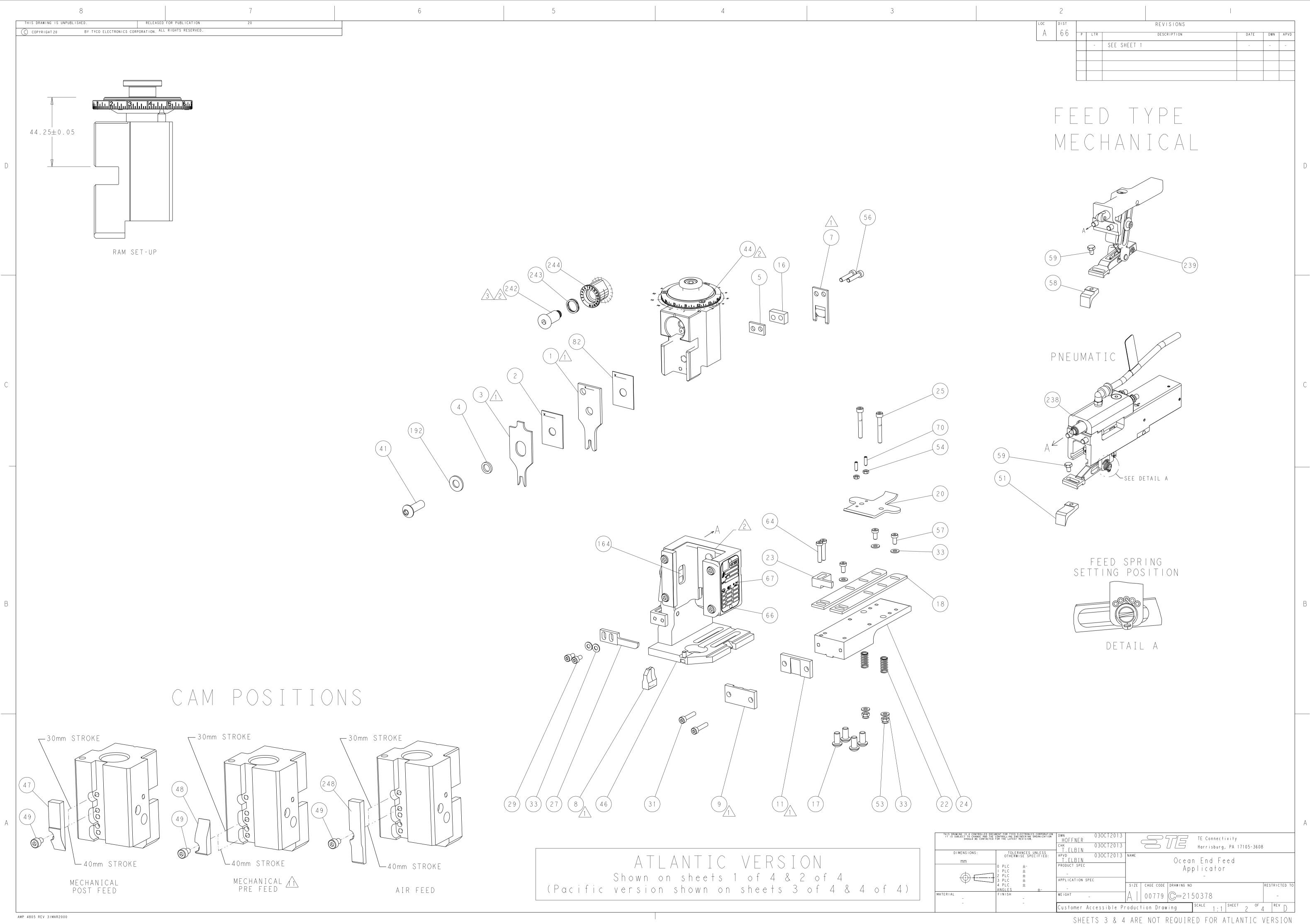
TING ER NTS.



SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

		1				
_	1	-	2119641-1	FEED CAM, AIR FEED	248	
1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
1	_	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-4	AIR FEED MODULE	238	
1	1	1	1 - 1 8 0 2 8 - 0	WASHER, FLAT, REG M8	192	
REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	~
1	1	1	455888-4	SPACER, CRIMPER	82	C
1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
2	2	2	2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	
1	1	1	2119740-1	TAG, IDENTIFICATION	67	
2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
1	_	1	2063961-1	FEED FINGER	58	
3	3	3	2168400-4		57	
2	2	2	2168083-9	SHCS, LOW HEAD, ROHS, M4 X 8	56	
		2		SCR, SKT HD CAP, Rohs, M4 X 20		
2	2		5018030-1	NUT, HEX, REG, RoHS, M3	54	
2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-9	FEED FINGER	51	
2		2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
1	_	1	2119652-1	FEED CAM, PRE FEED	48	
1	-	1	2119653-1		47	
			2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
			1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
1	1		1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1	
/	/	/	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	33	
2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	В
2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
1	1	1	240639-1	STRIPPER (MACHINING)	27	
2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
2	2	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
1	1	1	1803292-4	DRAG	20	
2	2	2	1901259-5	GUIDE, LOWER STRIP	18	
4	4	4	1 - 2079383 - 1	SCR, BHSC, RoHS (M6 X 12)	17	
1	1	1	4 - 2 4 0 6 4 1 - 5	SPACER	16	
1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	_	-	_	-	10	
1	1	1	690482-5	PLATE, FRONT SHEAR	9	
2	1	1	1 - 1 3 3 3 2 1 9 - 4	ANVIL, COMBINATION	8	
1	1	1	2217206-7	BLADE, SLUG	7	
_	_	-	_	-	6	
1	1	1	240641-6	SPACER	5	
1	1	1	2 - 2 3 8 0 1 1 - 2	BLOCK, CRIMPER SPACER	4	
2	1	1	4 - 2119582 - 9	CRIMPER, INSULATION F PREMIUM	3	
1	1	1	455888-9	SPACER, CRIMPER	2	
2	1	1	456408-2	CRIMPER, WIRE PREMIUM	1	
7 1		1			ITEM	А
- /	- 2	-	PART NO	DESCRIPTION	NO	А
DOCUMENT FO THE CONTRO TED FOR TH	OR T <u>YCO EL</u> LLING ENGI E LATEST RI	CTRONICS CON NEERING ORGA				
	TOLERA	NCES UNI	снк 030С1 T.ELBIN			
	OTHERWI	NCES UNL SE SPECI	<u> </u>	Ocean End Feed		
0 P	LC	±- ±	PRODUCT SPEC	Applicator		
2 P 3 P	LC	± ±	- APPLICATION SPEC			
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FIN	1 3 H	-	WEIGHT _	A 00779 C-2150378	-	
			Customer Accessi	ble Production Drawing Scale 1:1 SHEET 1 of 4	rev D	

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OC	DIST			REVISIONS			
А	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD
	•		В	ECR-16-017080	02DEC2016	ΥY	СТ
			B 1	ECR-17-001723	23FEB2017	ΜZ	КZ
			С	ECR-18-014745	17SEP2018	JAH	ΤE
			D	ECR - 19 - 011044	13JUL2019	ТВ	ΤE



	MENT FOR TYCO ELECTRONICS CORPORATION CONTROLING ENGINEERING ORGANIZATION FOR THE LATEST REVISION.	dwn HOFFNER снк Т.ELBIN	030CT2013 030CT2013				TE Connect Harrisburg	,	105-3608		
	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ± 2 PLC ± 3 PLC ±	APVD T.ELBIN PRODUCT SPEC - APPLICATION SP	030CT2013	NAME			n End Fe plicator -				-
J	4 PLC ± ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO				RESTRICTED TO	
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SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8 THIS DRAWING IS UNPUBLISHED. RELEASED	D FOR PUBLICATION	7	6	5	4	3
C COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. AL		FEED TYPE	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER			
2-2150378-2 D FINE CRI	MP HEIGHT ADJUST MP HEIGHT ADJUST P TOOLING KIT	MECHANICAL PNEUMATIC -				
D						
APPLICATOR DATACRIMPSIZEWIRE2.79 mm [.110]FINSUL4.32 mm [.170]						
APPL INSTRUCTIONS 408-35043						
TERMINAL DATA: TE TERMINAL TERMINAL NAME: .250 SERIES A		PECIFICATION	TERMINAL DATA: TE TERMINAL TERMINAL NAME: 250 SERIE	TE CRIMP SPECIFICA S AUTOMOTIVE POS LOCK RE		
WIRE STRIP LENGTH 4.20-5.20 mm [.165205 IN] TERMINAL APPLICATION	INSULATION DIAM Ø2.20-3.40 mm [.08 -	ETER RANGE	WIRE STRIP LENGTH 4.20-5.20 mm [.165205 IN] TERMINAL APPLICATION		G E	
C SPECIFICATION - TERMINALS APPLIED TE TERMINAL TE TERMINAL	- Te terminal	- Te terminal	SPECIFICATION - TERMINALS APPLIED			
170454-1 170454-2	85069-2		TE TERMINAL TE TERMINAL 170454-1 -	TE TERMINAL TE TERMIN		
WIRE SIZE SIZE CRIMP HEIGHT	CRIMP	HEIGHT 4 NCE SETTING	WIRE CRIMPHEI	GHT CRIMP HEIGHT		
14 AWG OR 2.00mm2 1.86+/-0.05 [.073] 16 AWG OR 1.25mm2 1.62+/-0.05 [.064] 18 AWG OR 0.85mm2 1.50+/-0.05 [.055]	3+/002] 4+/002]	<u>4.5</u> <u>6.9</u> 8.2	WIRE SIZE SIZE CRIMPHEI mm [INCH] 1.00mm2 1.54+/-0.05	.061+/002] REFERENCE SET	TÍNG	
REFER TO SUPPLIED INS	TRUCTION SHEET FOR	CLEANING, LUBRICATIO				
B CRIMP HEIGHT REFERENC APPLICATOR WAS QUALIF	23419-6 LOCTITE TO		FOR LARGE Than the	ST WIRE SIZE. CRIM VALUE SHOWN MAY CA	DISC TO CRIMP HEIGHT RE AP HEIGHT REFERENCE SET AUSE DAMAGE TO THE CRIM HEET FOR PROPER SETUP A	TINGS GREATER 1P TOOLING,
NECESSARY WHEN RUNNING	G APPLICATOR IN THE IP FOR END FEED APP PPLICATOR CAN BE CO	E FIELD. LICATORS IS POST-FEED DNFIGURED FOR PRE-FEEI	WITH D WITH	INC INSTRUCTION SF	illi für fruflr Sliuf A	ND ADJUSIMENIS.
	AL JAMMING MAY OCCU IS PROVIDED TO MEE D AND IS CONDITIONA	JR IN THE PRE-FEED CON T A CUSTOM AND UNIQUE ALLY SPECIFIED BY TE (NFIGURATION. CUSTOMER REQUIREMENT. CONNECTIVITY. THIS			
CONNECTIVITY APPLICA TE CONNECTIVITY SPEC EXPRESSLY DISCLAIMS VALIDATED AND APPROVI	TION SPECIFICATION; IFICATIONS 109-180 ANY AND ALL WARRAN ED APPLICATIONS, AS	ED AS AN APPROVED APPL HOWEVER, IT HAS BEEN 79(TEST GROUP 1) AND FIES THAT THE PRODUCT S STATED WITHIN TE CON FED TO IMPLIED WARRAN	N VALIDATED ACCORDING TO 114-18022. TE CONNECTIVITY WILL PERFORM SIMILARLY TO NNECTIVITY APPLICATION			
PERFORM FURTHER DETA APPLICATION. 7. UNLESS SPECIFIED OTHER	ILED EVALUATION TO	AŜSESS PRODUCT PERFOI	MMENDED THAT THE CUSTOMER RMANCE IN THE SPECIFIC			
DOCUMENT, 101-35000.						
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				Sha	PACIFIC VERSION own on sheets 3 of 4 &	

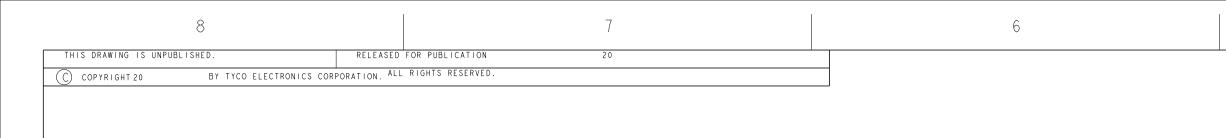
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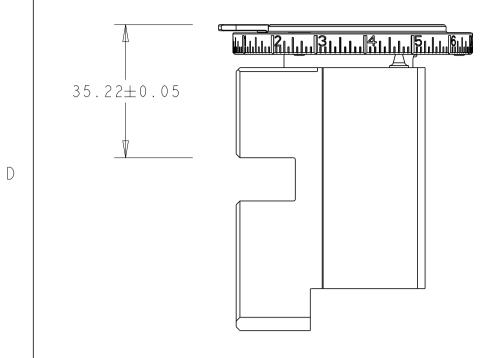
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

	_	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	_	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	_	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
<u> </u>	_	_	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
_	_	1	_	2844940-4	AIR FEED MODULE	238	
_	_	1	1	1 - 18028 - 0	WASHER, FLAT, REG M8	192	
-	_	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	_		REF	994970-2	COUNTER, MAGNETIC	164	
_	_		_	2119641-2	FEED CAM, AIR FEED	152	
_	_	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	С
_	_	_	1	2119653-2	FEED CAM, POST FEED	1 4 2	
_	_	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	_	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	_	1	1	455888-4	SPACER, CRIMPER	82	
-		1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-		2	2	2 - 18032 - 2		70	
_			<u> </u>		SCR, SET, FLT PNT, M3 X 10.0	67	
_	_			2119740-1	TAG, IDENTIFICATION		
-	_	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	_	2	2	2168400-5	SHCS, LOW HEAD, ROHS, M4 X 20	64	
_	_			5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59	
_	_	-		2063961-1	FEED FINGER	58	
-	-	3	3	2168400-4	SHCS, LOW HEAD, ROHS, M4 X 8	57	
-	-	2	2	2168083-9	SCR, SKT HD CAP, Rohs, M4 X 20	56	
_	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	-	1	-	2063961-9	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	2119653-1	FEED CAM, POST FEED	47	
_	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1	
-	-	7	7	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	33	В
-	-	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	1752371-5	PLATE, STRIP GUIDE	24	
	—	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
	_	2	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
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	_	2	2	1901259-5	GUIDE, LOWER STRIP	18	
	_	1	1	4 - 2 4 0 6 4 1 - 5	SPACER	16	
$\overline{1}$	_	1	1	240644-1	PLATE, REAR SHEAR	1 1	
	_	-	_	_	-	10	
\bigwedge	_	1	1	690482-5	PLATE, FRONT SHEAR	9	
$\overline{1}$	1	1	1	1 - 1 3 3 3 2 1 9 - 4	ANVIL, COMBINATION	8	
$\overline{1}$	-	1	1	2217206-7	BLADE, SLUG	7	
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-	_	1	1	240641-6	SPACER	5	
-	_	1	1	2 - 2 3 8 0 1 1 - 2	BLOCK, CRIMPER SPACER	4	
$\overline{1}$	1	1	1	4 - 2119582 - 9	CRIMPER, INSULATION F PREMIUM	3	
<u>~</u>	_	1	1	455888-9	SPACER, CRIMPER	2	
1	1	1	1	456408-2	CRIMPER, WIRE PREMIUM	1	
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DIMENSIONS:		TOLERA OTHERWI:	NCES UNL SE SPECIF	ESS T.ELBIN IED: APVD 030C	T2013 NAME		
mm	0 P	LC	±-	T.ELBIN product spec	Ocean End Feed		
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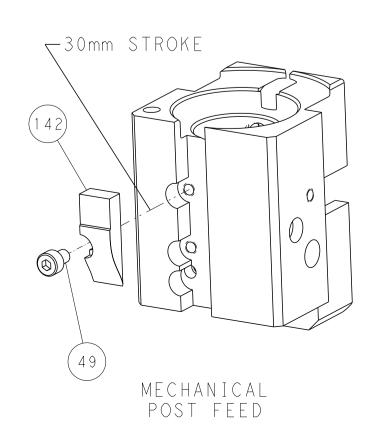




RAM SET-UP

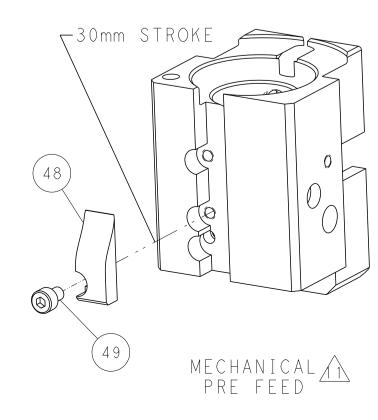
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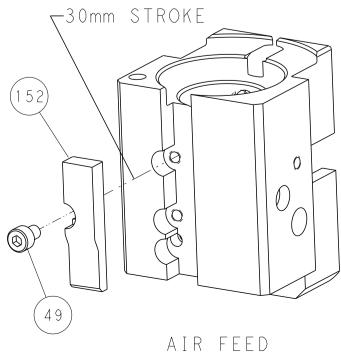
CAM POSITIONS

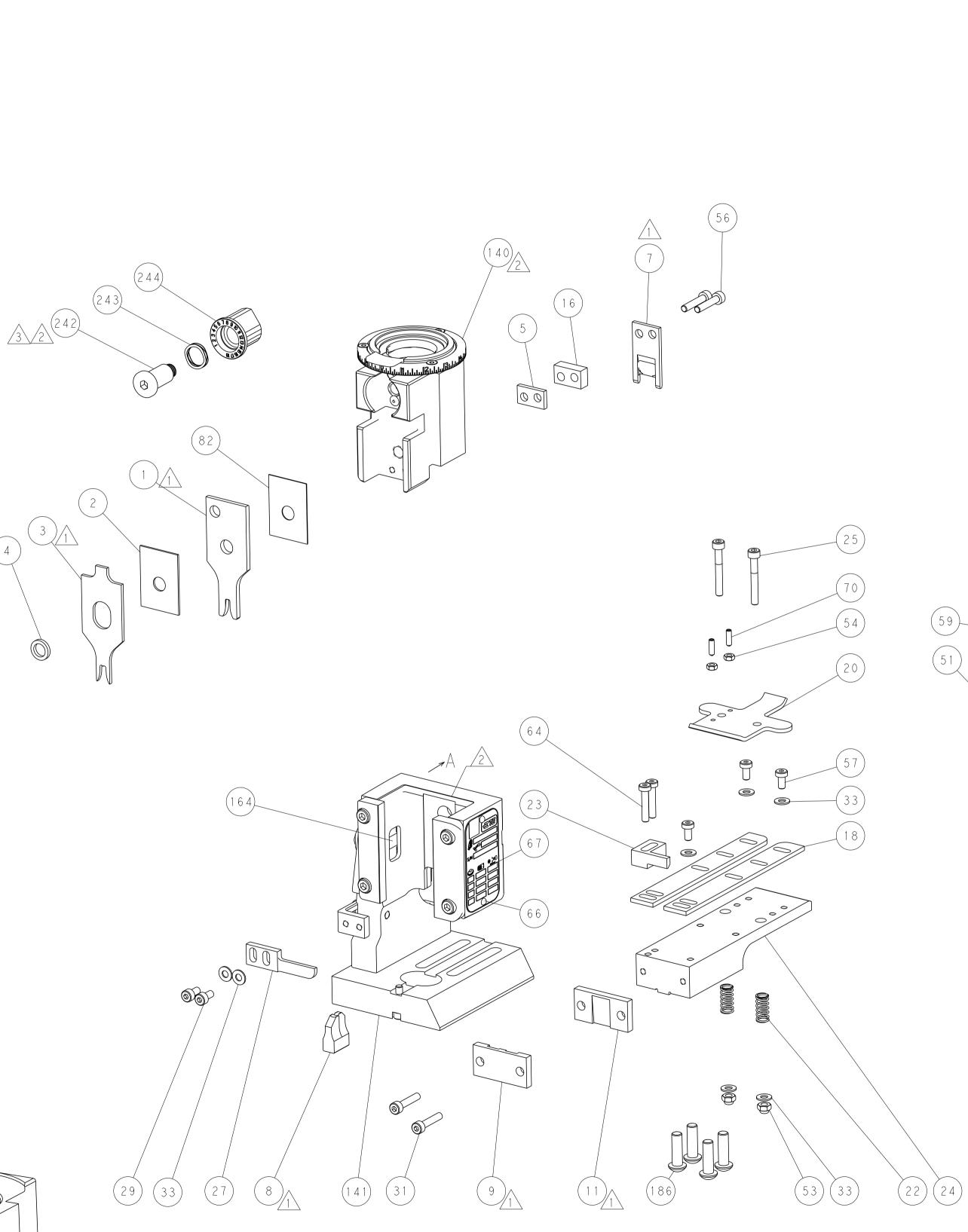


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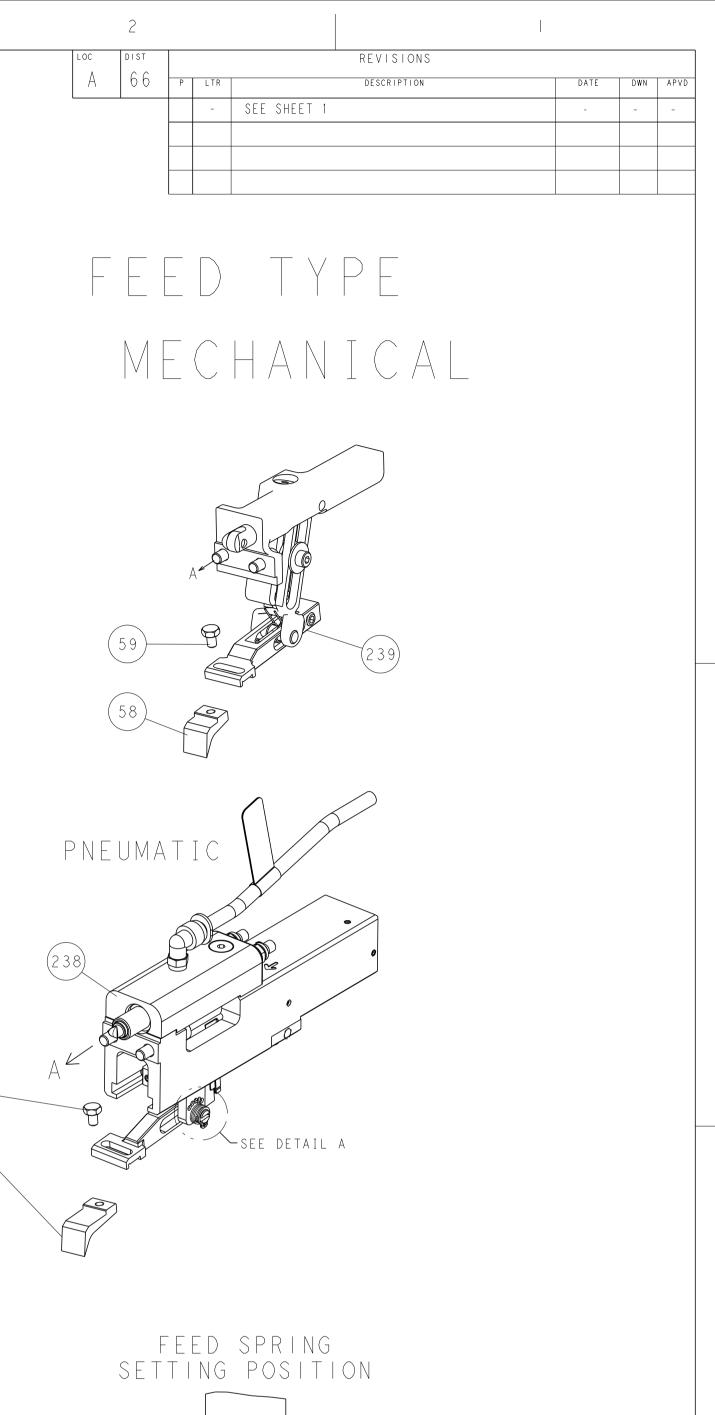


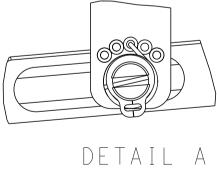
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PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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mm	0 PLC ±-	PRODUCT SPEC				Applicator	
	I PLC ± 2 PLC ±	-		-		_	
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SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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