		8			7	6
	THIS DRAWING IS UNPUBLI		RELEASED FOR PUBLICATION NICS CORPORATION. ALL RIGHTS RESERVED		20	ATLANTIC VERSION TERMINATOR
	P A R T N U M B E R	REVISION	DESCRIPTIC	ON	FEED TYPE	INTERFACE ADAPTER
	2150677-2	В	FINE CRIMP HEIGH	IT ADJUST	PNEUMATIC	
	7 - 2150677 - 2	В	PNEUMATIC AND TOOLING K		PNEUMATIC	
	7-2150677-7	A	CRIMP TOOLING	g kit	-	
D						
	APPLIC	ATOR DA	ТА			
	CRIMP WIRE 2.54 mr	SIZE n [.100]	T Y P E F			
	INSUL - APPL INSTR		-			
	408-35					
	TERMINAL DAT. TERMINAL NAM			E CRIMP S	PECIFICATION	
	WIRE STRIP	LENGTH		ATION DIAM	ETER RANGE	
	5.80-6.60 mr TERMINAL APPLICATION	114	- 3118 -		-	
С	SPECIFICATION				-	
	TERMINALS TE TERMINAL		ERMINAL TE TERM	1 T N A I	TE TERMINAL :	
	61013-2					
	WIRE SIZE		PHEIGHT	CRIMP REFERE	HEIGHT 4 NCE SETTING	
	14 AWG 16 AWG	1.96+/	/-0.05 [.077+/002] /-0.05 [.067+/002]		<u>3.8</u> 6.8	*WARNING
	18 AWG		/-0.05 [.060+/002]		9.0	ON INSTAL Setting e
						SETTINGS
	1 RECOMME	NDED SPARE	E PARTS			THE CRIMP Proper se
В		O SUPPLIEI OF APPLIC	D INSTRUCTION SHEET CATOR.	T FOR CLEA	NING, LUBRICATION	AND
D	APPLY P	ART NUMBER	R 1-23419-5 LOCTITE	e to threa	DS OF ITEM 180.	
	APPLICA	TOR WAS QL	ERENCE SETTING WAS JALIFIED AT THE FAC JNNING APPLICATOR I	CTORY. ADJU	USTMENT MAY BE	
	\land		NT IS RECOMMENDED.		L <i>U</i> .	
	6. UNLESS DOCUMEN	SPECIFIED T, 101-350	OTHERWISE TORQUE V)00.	ALUES SHAI	LL BE USED PER	
	TERMINA	L PITCH NO	OT COMPATIBLE WITH	МЕСНАМІСА	L FEED.	
А						
r X						

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

NSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE ING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE INGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR ER SETUP AND ADJUSTMENTS.

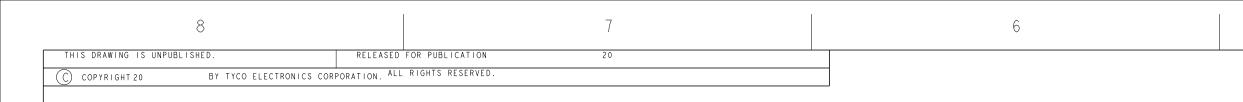
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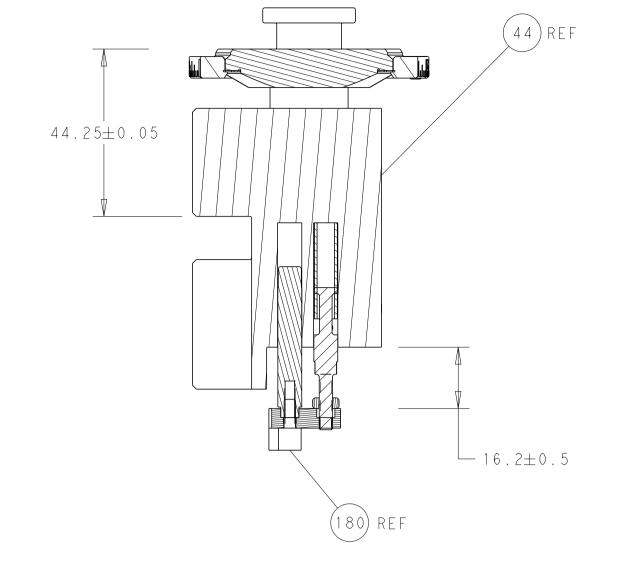
3

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

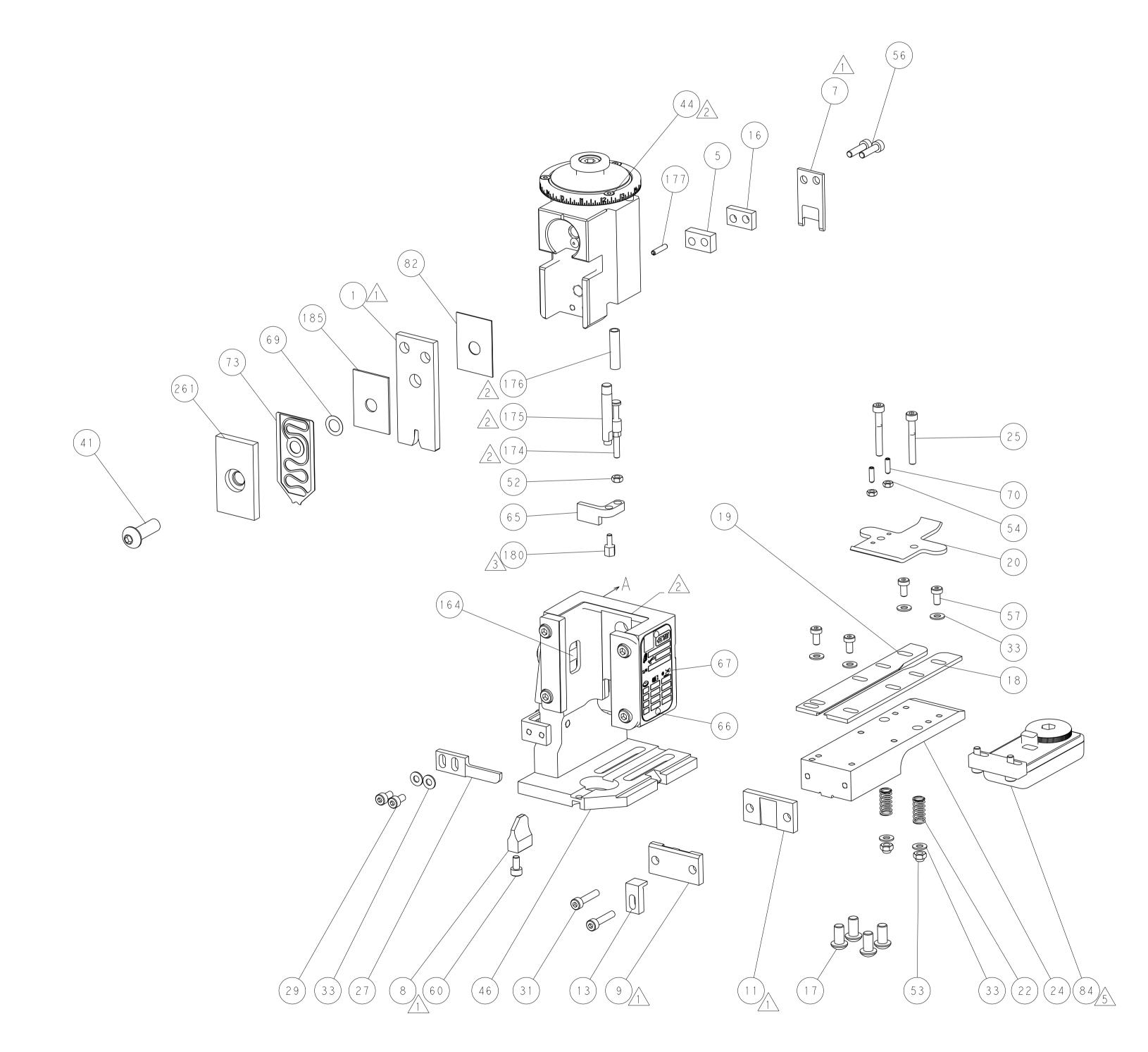
	_	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261	
	_	1	1	2119641-1	FEED CAM, AIR FEED	248	
	_	1	1	2844940-4	AIR FEED MODULE	238	
	_	1	1	1 - 455888 - 0	SPACER, CRIMPER	185	
$\sqrt{3}$	_	1	1	1752354-8	STANDOFF, HOLD-DOWN	180	
	-	1	1	6 - 9 9 3 1 1 1 - 6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	_	1	1	8-22280-7	SPRING, COMPRESSION	176	
	_	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
	_	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
	_	REF	REF	994970-2	COUNTER, MAGNETIC	164	
5	_	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
<u>/ </u>	_	1	1	455888-5	SPACER, CRIMPER	82	0
	_	1	1	1 - 2119791 - 0	DEPRESSOR, WIRE	73	С
	_	1	1	1803607-4	DOCUMENTATION PACKAGE	7 1	
	_	2	2	2 - 18032 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	
	_	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	
	_	1		1901681-1	HOLDDOWN, TERMINAL	65	
		1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
		1	1			59	
	_			5-18022-5	SCR, HEX HD CAP, M4 X 6.0		
	_	4	4	2168400-4	SHCS, LOW HEAD, ROHS, M4 X 8	57	
	_	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
	_	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	-			1 - 5018030 - 0	NUT, HEX, REG, RoHS, M3.5	52	
	-	1	1	2063961-1	FEED FINGER	51	
	_	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	_	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
	-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1	
	_	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	В
	-	1	1	240639-1	STRIPPER (MACHINING)	27	
	_	2	2	1 - 2168083 - 5	SCR, SKT HD CAP, R₀HS, M4 X 30	25	
	-	1	1	1 - 1 7 5 2 3 7 1 - 6	PLATE, STRIP GUIDE	24	
	_	2	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
	_	1	1	1803292-4	DRAG	20	
	_	1	1	1 - 1 9 0 1 6 9 6 - 8	STRIP GUIDE, REAR	19	
	_	1	1	1 - 1 9 0 1 6 9 5 - 8	STRIP GUIDE, FRONT	18	
	_	4	4	1 - 2079383 - 1	SCR, BHSC, RoHS (M6 X 12)	17	
	_	1	1	240641-3	SPACER	16	
	_	1	1	1752360-1	SPACER, HOLD-DOWN	13	
\bigwedge	_	1	1	1 - 2 4 0 6 4 4 - 7	PLATE, REAR SHEAR		
<u></u>	_	_	_	_	-	10	
\bigwedge	_	1	1	3-690482-2	PLATE, FRONT SHEAR	9	
	1	2		2 - 1803002 - 3	ANVIL, COMBINATION, END FEED	8	
		1		1 - 2217206 - 0	BLADE, SLUG	7	
		_		-		6	
		1	1	8 - 2 4 0 6 4 1 - 8	SPACER	5	
				-		4	
		_	_	_	-		
		_				3	
\wedge	1	-	-	-		2	
$\angle 1 \setminus$,	<u> </u>		456421-2	CRIMPER, WIRE		
	- 77	/ - 72	- 2	PART NO	DESCRIPTION	I T E M NO	А
IS DRAWING IS A CONTROLLEC T IS SUBJECT TO CHANGE AND SHOULD BE CONTA	DOCUMENT THE CONTR CTED FOR T	FOR TYCO ELE OLLING ENGIN HE LATEST RE	ECTRONICS CO NEERING ORGA	I N. HUANO			
DIMENSIONS:		TOLERA	NCES UNL SE SPECI	CHK 24MAY K.HUANG			
mm				L.ZHANG	Ocean End Feed		
		PLC PLC	±- ±-	PRODUCT SPEC	Applicator		
\oplus	3	PLC PLC	±- ±-	APPLICATION SPEC	-		
	ANG	PLC GLES	±- 	±	SIZE CAGE CODE DRAWING NO	RESTRICTED TO	
RIAL -	F	NISH	-	WEIGHT _	A 00779 C-2150677	-	
<u> </u>				Customer Accessi	ble Production Drawing Scale 1:1 SHEET 1 OF 4	REV B	
				C L L L L L L L L L L L L L L L L L L L	3 & 4 ARF NOT REQUIRED FOR ATLANTIC		

DIST			REVISIONS			
66	Р	LTR	DESCRIPTION	DATE	DWN	APVD
		А	RELEASED	04JULY2016	КН	GB
		В	ECR-23-166634	16FEB2023	ТB	RK





RAM AND HOLDDOWN SET-UP



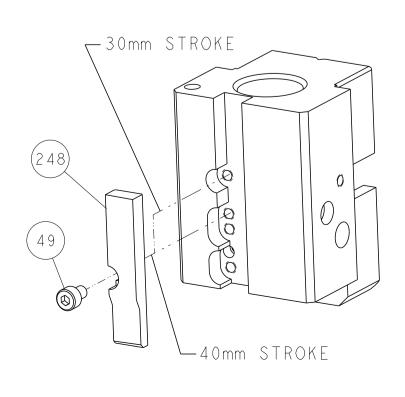
4

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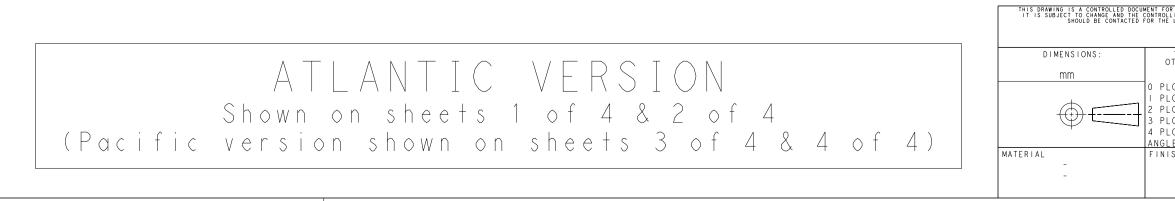


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AMP 4805 REV 31MAR2000



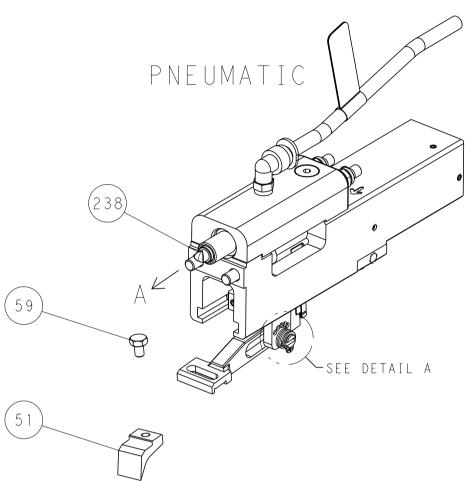
AIR FEED



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



3





DETAIL A

IT FOR TYCO ELECTRONICS CORPORATION ITROLLING ENGINEERING ORGANIZATION R THE LATEST REVISION.	dwn K.HUANG	24MAY2016				TE Connect	ivity		
	снк К.HUANG	24MAY2016				Harrisburg	, PA 171	05-3608	5
TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD L.ZHANG	24MAY2016	NAME		Ocea	n End Fe	ed		
PLC ±- PLC ±- PLC ±-	PRODUCT SPEC					plicator			
PLC ±-	APPLICATION SPI	EC	0.175			-			
PLC ±- NGLES ±-	-		SIZE	CAGE CODE	DRAWING NO				RESTRICTED TO
-	WEIGHT _		AI	00779	C-21 !	50677			-
-	Customer Ad	ccessible Pr	oduct	ion Draw	ing	scale 1:1	SHEET	2 OF 2	1 ^{rev} B

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

	8				7
THIS DRAWING IS UNPUBLIS		RELEASED	FOR PUBLICATION RIGHTS RESERVED.		20
P A R T N U M B E R	REVISION	DES	SCRIPTION		FEED TYP
2 - 2 1 5 0 6 7 7 - 2	В	FINE CRIM	P HEIGHT	ADJUST	P N E U M A T I
7 - 2150677 - 7	A	CRIMP	TOOLING	KIT	
CRIMP	A: TE TERI E: .109 LENGTH n [.228260 114 APPLIED	TYPE F - O MINAL DIA PIN - 3118 -		ION DIAME	ECIFICATION TER RANGE - - TE TERMINAL
WIRE SIZE → ★ 14 AWG 16 AWG 18 AWG	1.70+/	P HE IGHT INCH] -0.05 [.077 -0.05 [.067 -0.05 [.060	+/002]	CRIMP H REFEREN	HEIGHT 4 NCE SETTING 3.8 6.8

AMP 4805 REV 31MAR2000

1 RECOMMENDED SPARE PARTS

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

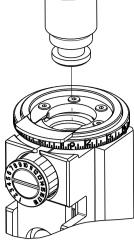
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.

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.

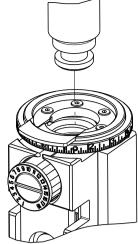
 $\cancel{5}$ terminal lubricant is recommended.

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

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



PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



*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.

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

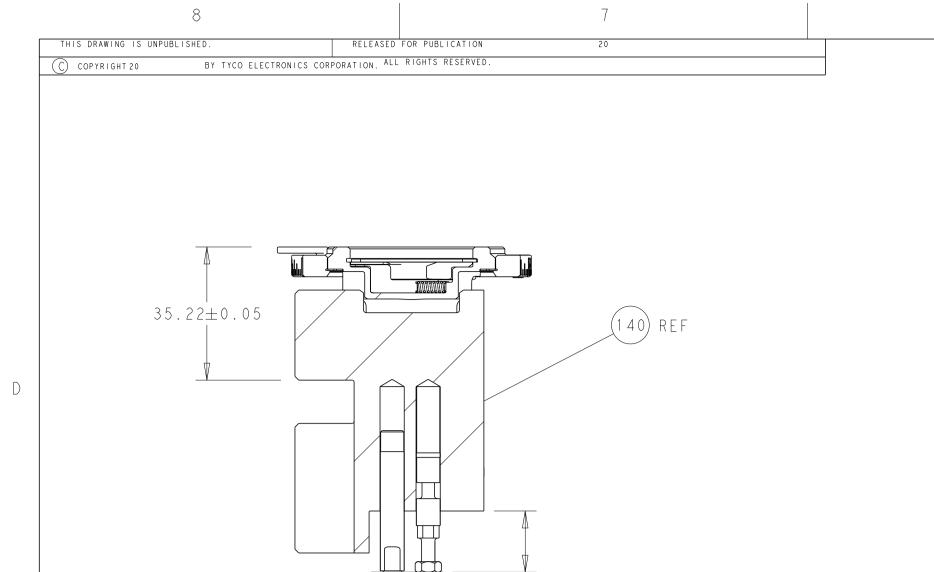
THIS DRAWING IS A CONTROLLED DO IT IS SUBJECT TO CHANGE AND TI SHOULD BE CONTACTS DIMENSIONS: mm MATERIAL

FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE GS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO IMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR SETUP AND ADJUSTMENTS.

5 4 3

	-	1 4 1 1	1803203-1 2844940-4 2079383-9 1-455888-0	BLOCK, FRONT DEPRESSOR AIR FEED MODULE SCR, BHSC, R⊙HS (M6 X 20)	261 238 186
	-	4	2079383-9		
	-	1		JOCK, BHOC, KOHO (MO X 20)	
	-	1	1 400000 0	SPACER, CRIMPER	185
	-		1752354-8		180
-	_	1		STANDOFF, HOLD-DOWN	177
-	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	
-		1	8-22280-7	SPRING, COMPRESSION	176
_	-		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	1 4 1
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
/5	_	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	_	1	455888-5	SPACER, CRIMPER	82
-		1	1 - 2 1 1 9 7 9 1 - 0	DEPRESSOR, WIRE	73
-		1			
-	-		1803607-4	DOCUMENTATION PACKAGE	71
-	-	2	2 - 18032 - 2	SCR, SET, FLT PNT, M3 X 10.0	70
	-		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
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
F	-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
F	-	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
-	_	<u> </u>	1 - 5018030 - 0	NUT, HEX, REG, RoHS, M3.5	52
-	_	1	2063961-1		
-		1		FEED FINGER	51
_	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-		1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	8	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	33
	-	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
	-	1	240639-1	STRIPPER (MACHINING)	27
	-	2	1 - 2168083 - 5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1 - 1 7 5 2 3 7 1 - 6	PLATE, STRIP GUIDE	24
	_	2	2 - 22281 - 3	SPRING, COMPRESSION	22
-	_	1	1803292-4	DRAG	20
-	_	1	1-1901696-8	STRIP GUIDE, REAR	19
-	_	1			
-		1	1-1901695-8	STRIP GUIDE, FRONT	18
F	-		240641-3	SPACER	16
	-		1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1 - 2 4 0 6 4 4 - 7	PLATE, REAR SHEAR	
	-	_	-	-	10
	-	1	3-690482-2	PLATE, FRONT SHEAR	9
1	1	1	2 - 1 8 0 3 0 0 2 - 3	ANVIL, COMBINATION, END FEED	8
$\sqrt{1}$	-	1	1 - 2 2 1 7 2 0 6 - 0	BLADE, SLUG	7
	-	-	-	-	6
-	_	1	8 - 2 4 0 6 4 1 - 8	SPACER	5
-	_	_		-	4
-	_		_	-	3
-					2
	1	1			1
			456421-2	CRIMPER, WIRE	
-	-77	- 22	PART NO	DESCRIPTION	I T E M NO
OCUMENT FOR HE CONTROLL	TYCO ELE	CTRONICS COP EERING ORGAN VISION.	RPORATION DWN 24MA	Y2016 TE Correctionity	
ED FOR THE L	LAIEST RE	VISTON.	снк 24МА	Y2016 TE Connectivity Harrisburg, PA 17105-3608	
10	TOLERA	NCES UNLI SE SPECIF	ESS K.HUANG IED: APVD 24MA	Y2016 NAME	
		±-	L.ZHANG PRODUCT SPEC	Ocean End Feed	
$1 \frac{1}{2} $	С	±- ±-	-	Applicator	
- 2 PLC 3 PLC 4 PLC	С	±- ±-	APPLICATION SPEC		STRICTED TO
ANGLE FINIS	ES	±-			STRICTED TO
		-	-	A 00779 C-2150677	-
			Customer Accessi	ble Production Drawing SCALE 1:1 SHEET 3 4	^{rev} B
			SHEETS	1 & 2 ARE NOT REQUIRED FOR PACIFIC V	ERSION

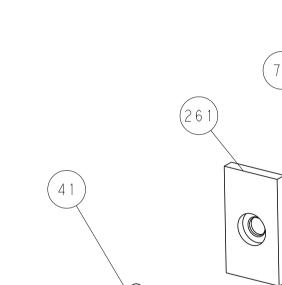
REVISIONS A 66 DESCRIPTION SEE SHEET 1



(180) REF

RAM AND HOLDDOWN SET-UP

└── 16.2±0.5

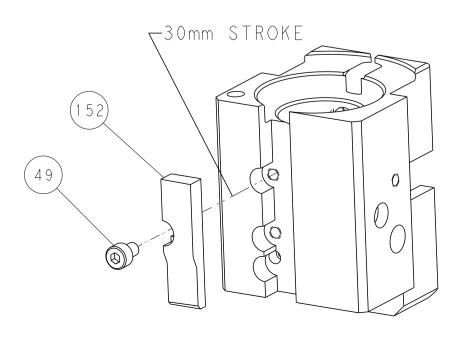


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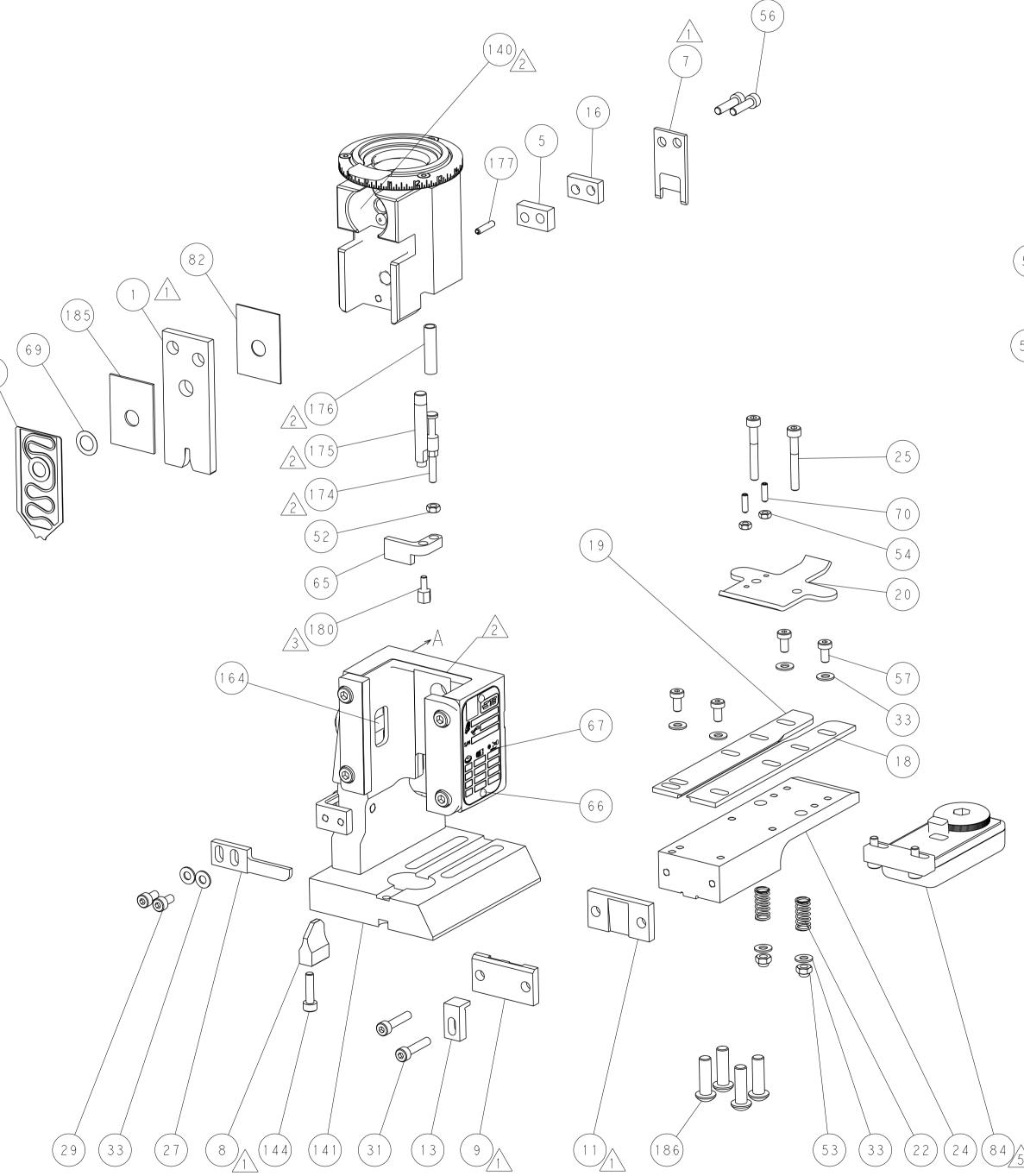


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AMP 4805 REV 31MAR2000



AIR FEED



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	Д	66	P LTR	SEE SHEET	REVISIONS DESCRIPTION	DATE -	DWN -	APVD -
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				S M	•			
238				No.	•			
	$A \swarrow$		- The					
(59)	P			R K see deta				
51				∼see deta	IL A			
		SET	f e e l T i N Г) SPRIN G POSI	TION			_
			D	ETAIL .	A			
)								
<u>/5</u>								
DOCIMENT FOR THE CONTRACT		N						
DOCUMENT FOR TWCO ELECTRONI THE CONTROLLING ENGINEERING CTED FOR THE LATEST REVISION TOLERANCES OTHERWISE SP		N DWN K.HU, CHK K.HU, APVD	ang 2- ang	4MAY2016 4MAY2016 4MAY2016 NAME	Harri	nnectivity sburg, PA 17105-3608		

TYCO ELECTRONICS CORPORATION ING ENGINEERING ORGANIZATION LATEST REVISION.	DWN 24MAY2016 К.HUANG снк 24MAY2016 К.HUANG	_		7/2		onnect isburg,	ivity , PA 17	105-36	08		
TOLERANCES UNLESS THERWISE SPECIFIED: C ±- C ±- C ±- C ±- C ±-	APVD 24MAY2016 L.ZHANG PRODUCT SPEC - APPLICATION SPEC	NAME		Ocear App		d Fe ator					
C ±- F S +-	-	SIZE	CAGE CODE	DRAWING NO					RI	ESTRICTED	ТО
E <u>S ±-</u> SH -	WEIGHT _	1 A	00779	C -215	5067	7				-	
-	Customer Accessible Pi	roduci	tion Draw	ing	SCALE	1:1	SHEET	4 °	F 4	rev B	
	SHEETS 1 &	2 AF	RE NOT	REQUIE	RED	FOR	PAC	[F I C	V	ERSIO	N

D