		8		7	6	
	THIS DRAWING IS UNPUBLIS		RELEASED FOR PUBLICATION NICS CORPORATION. ALL RIGHTS RESERVED.	2016	ATLANTIC VERSION TERMIN	NATOR
	P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE	INTERFACE ADAPTER	NATON .
	2150727-1	B	FINE CRIMP HEIGHT ADJUS			
	2150727-2 7-2150727-1	B	FINE CRIMP HEIGHT ADJUS MECHANICAL AND CRIMP TOOLING KIT	T PNEUMATIC MECHANICAL		
	7 - 2150727 - 2	В	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC		
	7-2150727-7	A	CRIMP TOOLING KIT	_		
					and the second sec	
$\supset$						
	APPLIC	ATOR DA	ТА			
		SIZE n [.062]	TYPE			
	INSUL 2.03 mm	n [.080]	F F			
	APPL INSTR 408-35					
	TERMINAL DATA			SPECIFICATION		
	WIRE STRIP		TONGUE WIRE TERMINAL			
	2.77-3.53 mm TERMINAL			039060 IN] -		
$\hat{\boldsymbol{\omega}}$	APPLICATION SPECIFICATION			-		
	TERMINALS	APPLIED	$5\sqrt{7}$			
	TE TERMINAL 170022-1		ERMINAL     TE TERMINAL       022-2     170022-3	TE TERMINAL ·		
		CDIM	PHEIGHT READ CRIMP	PHEIGHT A		
	SIZE 👾 👎	= [	INCH] REFER	RENCE SETTÍNG		
	22 AWG OR 0.38m 24 AWG OR 0.20m 26 AWG OR 0.12m	1m2 0.97+/	<u> (-0.05 [.041+/002] (-0.05 [.038+/002] (-0.05 [.038+/002] (-0.05 [.036+/-</u>	<u>6.5</u> <u>7.2</u>		
		<u>    2   0.9 +</u> /	<u>/-0.05 [.036+/002]</u>	7.9		
					* W	ARNING INSTALI
					SET SET	TTING FO TTINGS (
3	$\land$	NDED SPAR				ECRIMP
		O SUPPLIE OF APPLI	D INSTRUCTION SHEET FOR CL CATOR.	EANING, LUBRICATION A	ND PR(	OPER SE
			R 2-23419-6 LOCTITE TO THR			
	APPLICA	TOR WAS Q	ERENCE SETTING WAS THE SET UALIFIED AT THE FACTORY. AD UNNING APPLICATOR IN THE FI	)JUSTMENT MAY BE		
	5 TERMINA	L LUBRICA	NT IS RECOMMENDED.			
		SPECIFIED T, 101-35	OTHERWISE TORQUE VALUES SH 000.	HALL BE USED PER		
	TERMINA	L MUST BE	FED OFF INSULATION LEGS.			
Д						
·						
	I					

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)

1 8 2 1 THIS DRAWING IS A CONTROLLED IT IS SUBJECT TO CHANGE AND T SHOULD BE CONTACT DIMENSIONS: mm 

MATERIAL

STALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE NG FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE NGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO RIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR R SETUP AND ADJUSTMENTS.

4

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

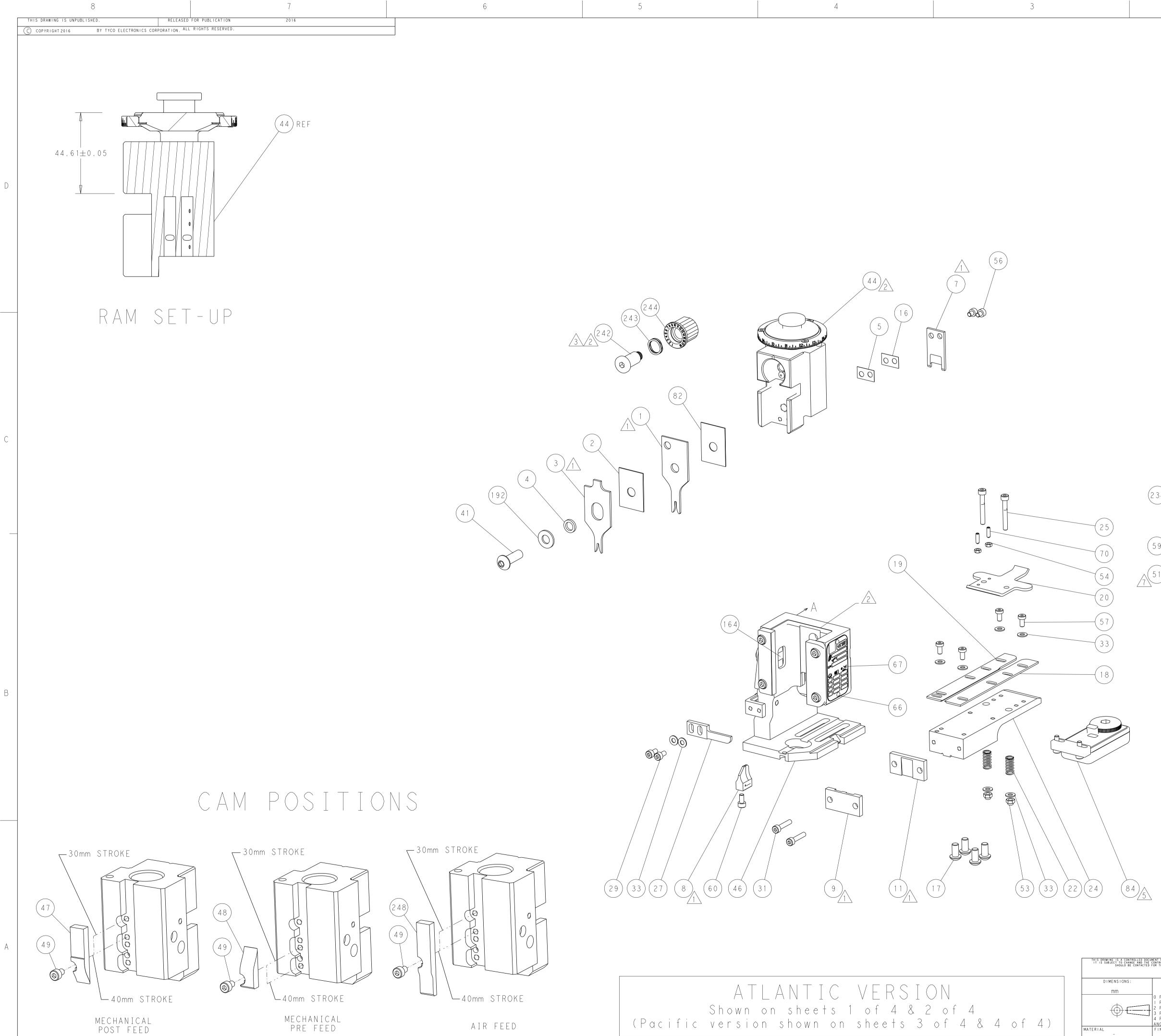
			21130411		240	
1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
1	_	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
_	1	_	2844940-3	AIR FEED MODULE	238	
1	1	1	1 - 18028 - 0	WASHER, FLAT, REG M8	192	
	FREF		994970-2	COUNTER, MAGNETIC	164	
						С
			2119955-2	ASSY, LUBRICATOR, END FEED	84	
1	1	1	455888-5	SPACER, CRIMPER	82	
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	
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	
4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
2	2	2	1 - 2 1 6 8 0 8 3 - 4	SCR, SKT HD CAP, R₀HS, M4 X 5	56	
2	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	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
<u> </u>		1				
1		1	2119652-1	FEED CAM, PRE FEED	48	
1	-	1	2119653-1	FEED CAM, POST FEED	47	
1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
8	8	8	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	
2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	В
1	1	1	240639-1	STRIPPER (MACHINING)	27	
2	2	2	1-2168083-5	SCR, SKT HD CAP, Rohs, M4 X 30	25	
<u> </u>			1752371-5	PLATE, STRIP GUIDE	24	
2	2	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	
1	1	1	1803292-1	DRAG	20	
1	1	1	1901696-2	STRIP GUIDE, REAR	19	
1	1	1	1901695-2	STRIP GUIDE, FRONT	18	
4	4	4	1 - 2079383 - 1	SCR, BHSC, RoHS (M6 X 12)	1 7	
1	1	1	4 - 2 4 0 6 4 1 - 9	SPACER	16	
1	1	1				
			240644-1	PLATE, REAR SHEAR		
-	-	-	-	-	10	
1	1	1	690482-5	PLATE, FRONT SHEAR	9	
2	1	1	4 - 1803060 - 2	ANVIL, COMBINATION, END FEED	8	
1	1	1	2217206-8	BLADE, SLUG	7	
_	_	-	-	-	6	
1	1	1	4 - 2 4 0 6 4 1 - 3	SPACER	5	
1	1	1	2 - 2 3 8 0 1 1 - 2	BLOCK, CRIMPER SPACER	4	
	1	1				
2		<u> </u>	5-2119582-9	CRIMPER, INSULATION F PREMIUM	3	
1	1	1	455888-7	SPACER, CRIMPER	2	
2	1	1	4 - 4 5 6 4 0 3 - 2	CRIMPER, WIRE PREMIUM	1	
_ 7	1 - 2	- 1			ITEM	A
1			PART NO	DESCRIPTION	NO	, r
DOCUMENT THE CONTI TED FOR	FOR TYCO ELE ROLLING ENGIN THE LATEST RE	CTRONICS CO EERING ORG/ VISION.	DRPORATION INIZATION DWN 17AU M. HERR	G2016 TE Connectivity		
			снк 17AU тервій	G2016 Harrisburg, PA 17105-3608		
	TOLERA OTHERWI:	NCES UNI SE SPECI	FIED: APVD 17AU	G2016 NAME Occarp End Food		
	PLC	±-	T. ELBIN product spec	Ocean End Feed Applicator		
	PLC PLC	±- ±-	-	Appricator		
3	PLC PLC	 ±-	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	ESTRICTED TO	
AN	<u>GLES</u> NISH		± WEIGHT			
		-	-	A   00779  C-2150727	-	
			Customer Accessi	ble Production Drawing SCALE 1:1 SHEET 1 4	rev B 2	J

FEED CAM, AIR FEED

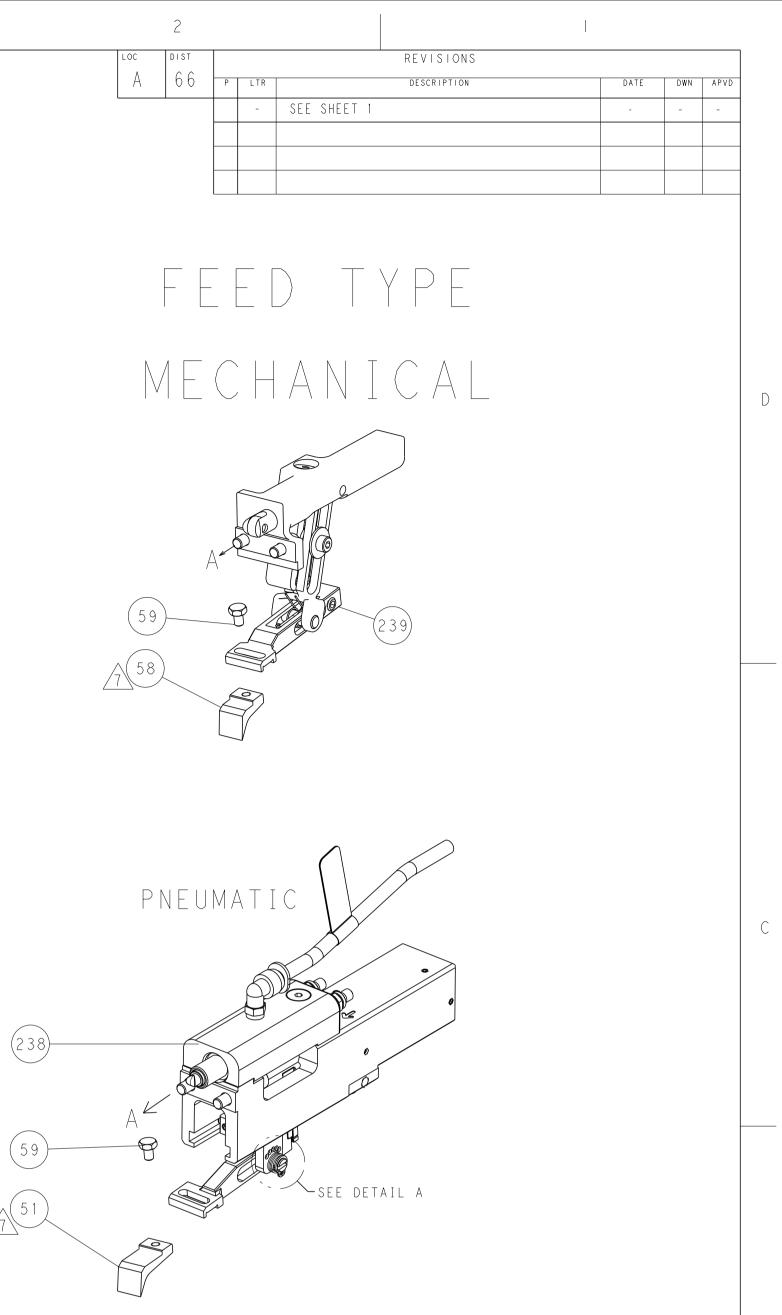
2119641-1

<u>_</u>									
DIST			REVISIONS						
66	P LTR DESCRIPTION DATE DWN								
•		А	RELEASED	30AUG2016	MEH	ΤE			
		В	ECR-21-005502	17MAY2021	ТB	RK			
		B 1	ECR-23-180581	07JUL2023	FΖ	JAH			
		B 2	ECR-23-181587	18JUL2023	FΖ	GB			

248

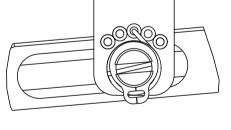


ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) MATERIAL



FEED SPRING SETTING POSITION

В



DETAIL A

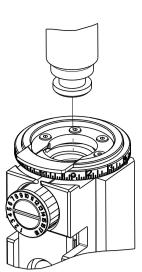
CUMENT FOR TYCO ELECTRONICS CORPORATION E CONTROLLING ENGINEERING ORGANIZATION D FOR THE LATEST REVISION.		DWN 17AUG2016 М. HERR снк 17AUG2016 Т. ELBIN	(			TE Connectivity Harrisburg, PA 17105-	3608	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±-		APVD 17AUG2016 T. ELBIN PRODUCT SPEC	NAME			n End Feed olicator		
<u>+</u>	2 PLC ±- 3 PLC ±- 4 PLC ±- ANGLES ±-	APPLICATION SPEC	S I Z E	CAGE CODE	DRAWING NO	-	R	RESTRICTED TO
	FINISH - -	WEIGHT _	AI		$\mathbb{C}$ -215			-
		Customer Accessible P			ing	SCALE 1:1 SHEET 2	OF 4	REV B2
		SHEETS 3 & 2	i are	. NOI F	k e QU I R f	ED FOR ATLANTI	C V	ERSION

		8			7		
	THIS DRAWING IS UNPUBLIE		RELEASED NICS CORPORATION. ALL	FOR PUBLICATION RIGHTS RESERVED.	2016	I	
	P A R T N U M B E R	REVISION	DES	SCRIPTION	FEED TYPE		PACIFIC INT
	2 - 2150727 - 1 2 - 2150727 - 2	B		IP HEIGHT ADJUST IP HEIGHT ADJUST			
	7 - 2150727 - 7	A		TOOLING KIT	-		
D							
	CRIMP WIRE 1.57 mr		T A T Y P E F F				
С	TERMINAL DATA TERMINAL NAM WIRE STRIP 2.77-3.53 mr TERMINAL APPLICATION SPECIFICATION TERMINALS TE TERMINAL 170022-1	E: RING LENGTH m [.10913 114- D 114- APPLIED	TONGUE W 	TE CRIMP /IRE TERMINAL INSULATION DIA Ø1.00-1.52 mm [.0 - - TE TERMINAL 170022-3			
	WIRE SIZE & 22 AWG OR 0.38r 24 AWG OR 0.20r 26 AWG OR 0.12r	mm [ nm2 1.04+, nm2 0.97+,	P HEIGHT INCH] (-0.05 [.041 (-0.05 [.038 (-0.05 [.036	+/002] +/002]	HEIGHT ENCE SETTING 6.5 7.2 7.9		
В	REFER STORAG APPLY CRIMP APPLIC NECESS STERMIN	E OF APPL PART NUMB HEIGHT RE ATOR WAS ( ARY WHEN F IAL LUBRIC	ED INSTRUCT ICATOR. ER 2-23419- FERENCE SET QUALIFIED A RUNNING APP ANT IS RECC	FION SHEET FOR CL -6 LOCTITE TO THR FTING WAS THE SET T THE FACTORY. AN LICATOR IN THE F OMMENDED. TORQUE VALUES SI	EADS OF ITEM 24 TING USED WHEN DJUSTMENT MAY B IELD.	2. THE E	
	6. UNLESS DOCUME A	SPECIFIEI NT, 101-35	) OTHERWISE 5000.	TORQUE VALUES SI	HALL BE USED PE	К	
	∠7∖ TERMIN	IAL MUST B	e fed off 1	INSULATION LEGS.			

AMP 4805 REV 31MAR2000

\*WARNING

## C VERSION TERMINATOR ITERFACE ADAPTER



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

mm MATERIAL

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.

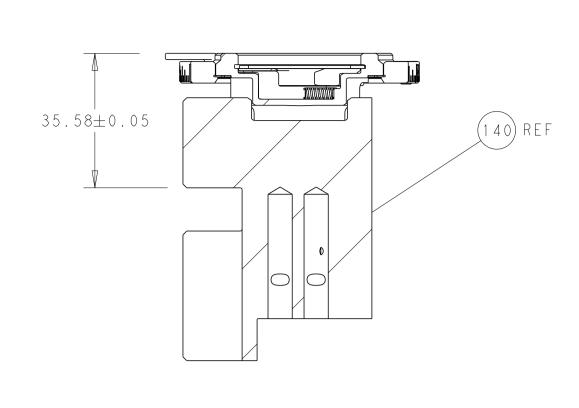
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

	_ 1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	- 1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	243
<u>_3</u>		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		2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
_	- RE	FREF	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
5	- 1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	- 1	1	455888-5	SPACER, CRIMPER	82
	- 1	1	1803607-4	DOCUMENTATION PACKAGE	7 1
	- 2	2	2 - 18032 - 2	SCR, SET, FLT PNT, M3 X 10.0	70
	- 1	1	2119740-1	TAG, IDENTIFICATION	67
_	- 2	2	2168078-1		66
_	- <u> </u>			SCREW, DRIVE, RH, Rohs, 2 x .188	
	-		5 - 18022 - 5	SCR, HEX HD CAP, M4 X 6.0	59
<u> </u>			2063961-1	FEED FINGER	58
_	- 4		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	- 2		1 - 2 1 6 8 0 8 3 - 4	SCR, SKT HD CAP, Rohs, M4 X 5	56
	- 2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
<u> </u>	- 2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
/7\[	- 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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1
	- 8	8	1 - 18028 - 2	WASHER, FLAT, REG M4	33
	- 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
	- 1	1	240639-1	STRIPPER (MACHINING)	27
-		2			
_	1		1-2168083-5	SCR, SKT HD CAP, Rohs, M4 X 30	25
_	-		1752371-5	PLATE, STRIP GUIDE	24
_	- 2	2	2 - 22281 - 3	SPRING, COMPRESSION	22
_	-		1803292-1	DRAG	20
	- 1	1	1901696-2	STRIP GUIDE, REAR	19
	- 1	1	1901695-2	STRIP GUIDE, FRONT	18
	- 1	1	4 - 2 4 0 6 4 1 - 9	SPACER	16
1	- 1	1	240644-1	PLATE, REAR SHEAR	1 1
		_	-	-	10
1	- 1	1	690482-5	PLATE, FRONT SHEAR	9
	1 1	1	4 - 1 8 0 3 0 6 0 - 2	ANVIL, COMBINATION, END FEED	8
/ 1 \ I	- 1	1	2217206-8	BLADE, SLUG	7
$\begin{pmatrix} 1 \\ 1 \\ 1 \\ \end{pmatrix}$					6
	1	1	4 - 2 4 0 6 4 1 - 3	SPACER	5
			2 - 2 3 8 0 1 1 - 2		
	-			BLOCK, CRIMPER SPACER	4
	-   - 1				$\prec$
	1	1	5-2119582-9	CRIMPER, INSULATION F PREMIUM	
	1	1	5 - 2119582 - 9 455888 - 7	SPACER, CRIMPER	2
	- 1 1 1	1 1 1 1	5-2119582-9		
	- 1 1 1 - 1 1 1	1 1 1 2 - 2 1	5 - 2119582 - 9 455888 - 7 4 - 456403 - 2	SPACER, CRIMPER CRIMPER, WIRE PREMIUM	2 1 I TEM
IG IS A CONTROLLED DOC IG IS A CONTROLLED DOC IECT TO CHANGE AND THE SHOULD BE CONTROLLED	- 1 1 1 - 1 1 1 7 7 - 2		5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO	SPACER, CRIMPER	2
G IS A CONTROLLED DOC ECT TO CHANGE AND THE SHOULD BE CONTACTED	- 1 1 1 - 1 1 1 7 7 - 2		5-2119582-9 455888-7 4-456403-2 РАПТ NO M. HERR Снк 17AU	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION	2 1 I TEM
	- 1 1 1 - 1 1 1 7 7 - 2 UMENT FOR TYCC CONTROL ING E FOR THE LATES		5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO PART NO M. HERR CHK CHK T. ELBIN FIED: APVD 17AUC	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 32016 G2016 Harrisburg, PA 17105-3608 G2016 NAME	2 1 I TEM
ENSIONS:	- 1 1 1 - 1 1 1 7 7 - 2 UMENT FOR TYCC CONTROL ING E FOR THE LATES	ELECTRONICS ( NGINEERING ORC T REVISION.	5-2119582-9 455888-7 4-456403-2 PART NO PART NO M. HERR CHK FLBIN 17AUC	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 52016 G2016 NAME Ocean End Feed	2 1 I TEM
ENSIONS:	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	ELECTRONICS C GINEERING ORC TREVISION. ERANCES UN WISE SPEC ±- ±- ±-	5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO PART NO M. HERR CHK 17AUC T. ELBIN T. ELBIN T. ELBIN	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 32016 G2016 Harrisburg, PA 17105-3608 G2016 NAME	2 1 I TEM
ENSIONS:	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	ELECTRONICS C GINEERING ORC TREVISION. ERANCES UN WISE SPEC ±-	5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO PART NO M. HERR CHK 17AUC T. ELBIN T. ELBIN T. ELBIN	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 52016 G2016 NAME Ocean End Feed Applicator	2 1 ITEM NO
ENSIONS:	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	ELECTRONICS CONTRECTING ORC INTERING ORC TREVISION. ERANCES UN WISE SPEC ±- ±- ±- ±- ±-	5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO CHK 17AUC CHK 17AUC T. ELBIN PRODUCT SPEC - APPLICATION SPEC +- WEIGHT	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 52016 G2016 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO R	2 1 I TEM
In the second se	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	ELECTRONICS CONTRECTING ORC INTERING ORC TREVISION. ERANCES UN WISE SPEC ±- ±- ±- ±- ±-	5 - 2119582 - 9 455888 - 7 4 - 456403 - 2 PART NO ARTIGATION DWN 17AUC M. HERR 17AUC CHK 17AUC T. ELBIN 17AUC T. ELBIN 17AUC T. ELBIN 17AUC APVD 17AUC T. ELBIN 17AUC	SPACER, CRIMPER CRIMPER, WIRE PREMIUM DESCRIPTION 52016 G2016 NAME Ocean End Feed Applicator	2 1 ITEM NO

	2			I.							
;	DIST		REVISIONS								
4	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD				
	•		-	SEE SHEET 1	-	-	-				

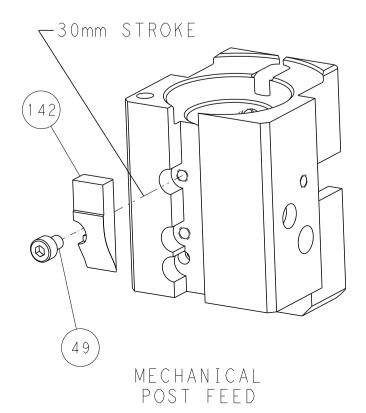
8		7	6
THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2016	
C COPYRIGHT 2016 BY TYCO ELECTRONICS CO	RPORATION. ALL RIGHTS RESERVED.		

В

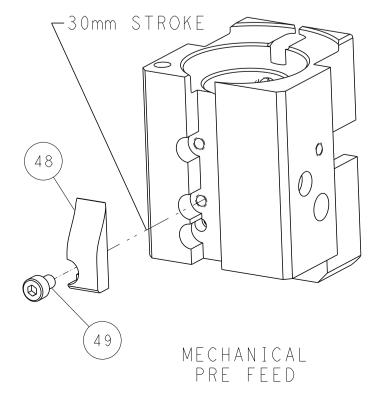


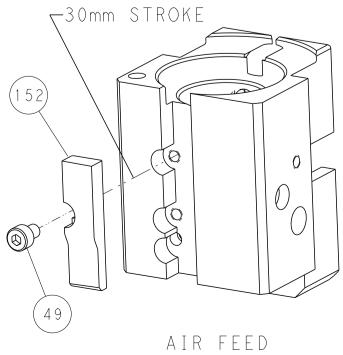
## RAM SET-UP

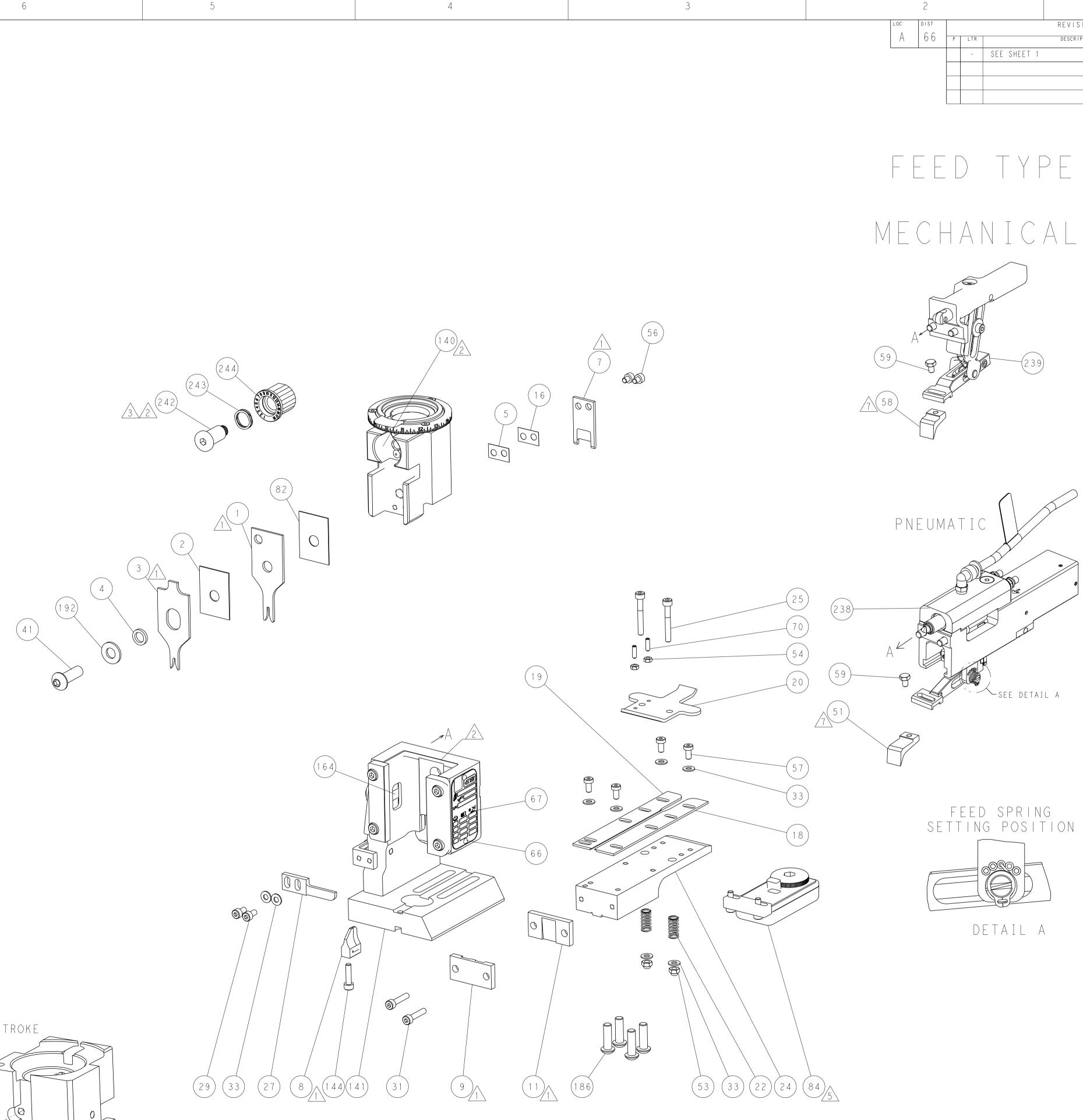




AMP 4805 REV 31MAR2000

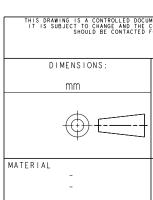


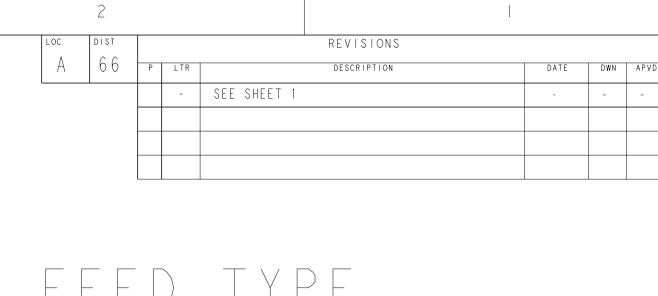


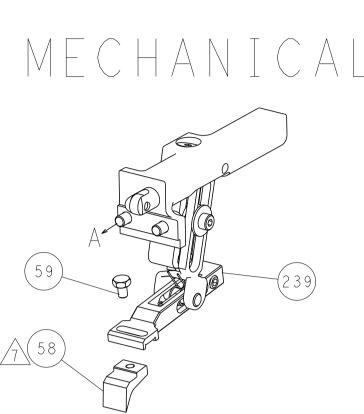


CAM POSITIONS

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







В

OCUMENT FOR TYCO ELECTRONICS CORPORATION HE CONTROLLING ENGINEERING ORGANIZATION ED FOR THE LATEST REVISION.		M. HERR	AUG2016	TE Connectivity						
		снк 17, T.ELBIN	AUG2016				Harrisburg,	PA 17105	5-3608	
	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD 17, T. ELBIN	AUG2016	NAME		Ocean	End Fe	ed		
	0 PLC ±- 1 PLC ±-	PRODUCT SPEC					licator			
+	2 PLC ±- 3 PLC ±-	APPLICATION SPEC					-			
	4 PLC ±- ANGLES ±-	-		SIZE A I	CAGE CODE	DRAWING NO				RESTRICTED TO
	FINISH -	WEIGHT _	,	A I I	00779	C - 215	0/2/			-
	-	Customer Acces	sible Pr	oduct	ion Draw	ing	scale 1:1	sheet 4	of 4	<sup>rev</sup> B2
		SHEETS	5182	2 AF	RE NOT	REQUIR	RED FOR	PACIF	IC V	'ERSION