	THIS DRAWING IS UNPUBLIS		RELEASED FOR PUBLICATION	7 2017		6	
	© COPYRIGHT 2017 PART NUMBER	by tyco electro REVISION	DNICS CORPORATION. ALL RIGHTS RESERVED.	FEED TYP	· E	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	
	2150780-1 2150780-2 7-2150780-1 7-2150780-2 7-2150780-2	B B B B A	FINE CRIMP HEIGHT FINE CRIMP HEIGHT MECHANICAL AND CR TOOLING KIT PNEUMATIC AND CR TOOLING KIT CRIMP TOOLING K	ADJUST PNEUMATI RIMP MECHANICA IMP PNEUMATI	A L		
D							
	CRIMP S WIRE 3.30 mr		TA TYPE F -				
С	TERMINAL DATA TERMINAL NAME WIRE STRIP 3.30-4.83 mm TERMINAL APPLICATION TERMINAL SPECIFICATION TERMINAL S TE TERMINAL 2303727-1	E: CLIP LENGTH n [.13019 D APPLIED INSINKERA	INSULATIONSULA	ON DIAMETER RANGE - -			
Β	18 AWG 18 AWG 18 AWG 18 AWG 18 AWG 18 AWG 18 AWG 20 REFER T STORAGE 3 CRIMP H APPLICAT NECESSAF 4 TERMINA 5. UNLESS S	NDED SPAR O SUPPLIE OF APPLIC EIGHT REF TOR WAS QU RY WHEN RU L LUBRICA	/-0.05 [.070+/002] E PARTS D INSTRUCTION SHEET FO CATOR. ERENCE SETTING WAS TH JALIFIED AT THE FACTOF JNNING APPLICATOR IN T NT IS RECOMMENDED. OTHERWISE TORQUE VALU	9.1 9.1 E SETTING USED WHEN RY. ADJUSTMENT MAY BE THE FIELD.	TION AND THE	ON SET SET THE	RNING INSTALI TING FO CRIMP PER SE
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)

MATERIAL

INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE TTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE TTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR ROPER SETUP AND ADJUSTMENTS.

3

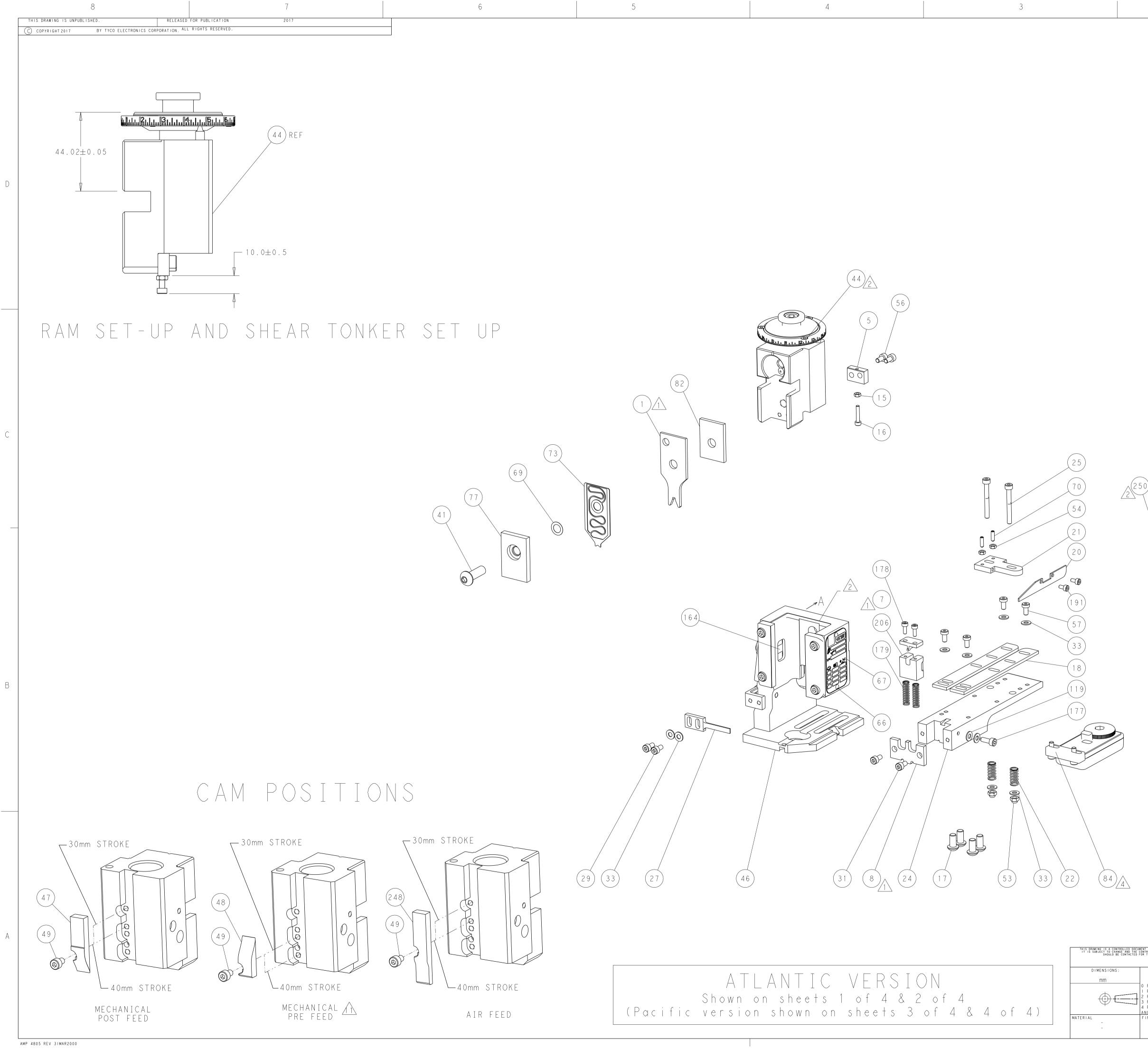
THIS DRAWING IS A CONTROLLED IT IS SUBJECT TO CHANGE AND SHOULD BE CONTAC

DIMENSIONS:

	2								
LOC	DIST		REVISIONS						
A	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD		
	-		1	PRELIMINARY	03MAR2017	MEH	ΤE		
			А	RELEASED	13APR2017	ТB	TE		
			В	ECR-19-010225	29JUN2019	ТВ	GB		

				1			
_	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
_	1	-		-	1803259-1 2119641-1	BUSHING, FLANGED FEED CAM, AIR FEED	249 248
_	_	1	   _	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
_	1	-	1	-	2063440-1	AIR FEED MODULE	238
_	1	1	1	1	1803163-3	FLOATING SHEAR HOLDER	206
_	2	2	2	2	1 - 2168083 - 1	SCR, SKT HD CAP, Rohs, M3 X 6	191
_	2	2	2	2	2-22280-0	SPRING, COMPRESSION	179
-	2	2	2	2	2168083-1 356885-1	SCR, SKT HD CAP, R∘HS, M3 X 8.0 STOP, SHEAR	178
_	2	-	2		21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
_		REF				COUNTER, MAGNETIC	164
_	1	-	1	-	240638-1	SPRING, FEED FINGER	163
_	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	2	2	2	2	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	1 1 9
-	1	1		1	2119955-2 3-455888-7	ASSY, LUBRICATOR, END FEED SPACER, CRIMPER	84
_	1	1	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77
_	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
_	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
_	2	2	2	2	2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70
_	1	1	1	1	2119943-1	WASHER, SPACER	69
_				1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1 5-18022-5	SCREW, DRIVE, RH, Rohs, 2 x .188 SCR, HEX HD CAP, M4 X 6.0	66
_	_	1	_	1	2063961-1	FEED FINGER	58
_	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
_	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
_	1	-	1	-	2119792-1	PAWL, EF, AIR	51
-	_	2	1	2	18023-9 2119652-1	SCR, SKT HD CAP M4 X 6.0 Feed cam, pre feed	49
_	_	1	_	1	2119653-1	FEED CAM, POST FEED	47
_	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
_	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
_	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4 1
_	8	8	8	8	1 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-2 2168083-2	SCR, SKT HD CAP, Rohs, M4 X 8.0 SCR, SKT HD CAP, Rohs, M4 X 8.0	31
_	1	1	1	1	468281-6	STRIPPER	27
_	2	2	2	2	1 - 2168083 - 6	SCR, SKT HD CAP, RoHS, M4 X 35	25
_	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24
_	2	2	2	2	2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22
_	1	1	1	1	1633168-1	ARM, STOCK DRAG	21
-		1		1	464452-2	DRAG, STOCK	20
_	2	2	2	2	<u>1 - 1 9 0 1 2 5 9 - 8</u> 1 - 2 0 7 9 3 8 3 - 1	GUIDE, LOWER STRIP SCR, BHSC, RoHS (M6 X 12)	18
_	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16
_	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
-	-	-	-	_	-	-	1 1
-	-	-	-	-	_	-	10
- 1	-	-	-	- 1			9
	<u> </u>	2	1	1	<u>1213862-5</u> 1633722-3	ANVIL, SPLICE TYPE Shear blade	8
	-			   _	-	-	6
-	1	1	1	1	690753-6	SPACER, TONKER	5
	-			-	_	-	4
-	_	-	-	_	_	-	3
-	-	-	-	-			2
		2			1803504-1	CRIMPER, WIRE	ITEM
-77	[-72	- 7 1	- 2	- 1	PART NO	DESCRIPTION	NO
RAWING IS SUBJECT TO SHO	A CONTROLLE O CHANGE AN ULD BE CONT.	D DOCUMENT F D THE CONTRC ACTED FOR TH	OR TYCO EL DLLING ENGI HE LATEST R	ECTRONICS C NEERING ORG EVISION.			<u> </u>
DIMENSI	ONS:		TOLERA	NCES UN SE SPECI	CHK 03MAI T. ELBIN FLED: APVD 0.3MAI	22017 NAME	
mm		0 P		±-	T. ELBIN PRODUCT SPEC	Ocean End Feed	
(f)	)	1 P 2 P	'LC 'LC	±- ±-	- APPLICATION SPEC	Applicator	
Ψ		4 P	PLC PLC GLES	±- ±-	±		ESTRICTED TO
L _			IISH	-	WE I G H T _	A   00779 C=2150780	-
-					Customer Accessi	ble Production Drawing SCALE 1:1 SHEET 1 4	REVB

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



	2							
A	66	P LTR		REVISIONS		DATE	DWN	APV
	-	-	SEE SHEET 1			-	-	-
		(	$ \top $	YPE				
$\setminus$								
			6	$\supset$				
		Ro						
	Д							
	$\frown$	R J		$\frown$				
	(59)-			239				
	(58)							
		-     N	∧ ∧ <del>–</del>	T ( )	~			
$\vdash$			$\wedge \land \top$		V			
			/					
				/				
(23	88)	Ŕ						
249)				2 St				
			0	60				
	A		Q Q	0				
			a g		(1 3 7)			
	$\bigcup$		Droc	0.00/0	(1 6 3)			
					(172)			
	L	S	(51)					
		7						
YCO ELECTRONICS CORPORATION	DWN	<u> </u>	MAR 2017 I					
	снк — <u>Т. EL</u>	<u>RR</u> 03 BIN	MAR2017 MAR2017 MAR2017 NAME		E Connectivity arrisburg, PA		3	
DLERANCES UNLESS ERWISE SPECIFIED: ±- ±-	CHK T.EL	RR 03 BIN 03 BIN	0	Ocean			3	
	CHK T.EL APVD T.EL PRODUCT S	RR 03 BIN 03 BIN spec	MAR2017 C	Ocean	arrisburg, PA End Feed icator -		}	CTED .

	THIS DRAWING IS UNPUBL		RELEASED FOR PUBLICATION	7 2017		6	
	P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE		FIC VERSION TERMINA	4 T O R
	2 - 2150780 - 1 2 - 2150780 - 2 7 - 2150780 - 7	В	FINE CRIMP HEIGHT AD FINE CRIMP HEIGHT AD CRIMP TOOLING KIT	JUST PNEUMATIC			
D							
	CRIMP		TA TYPE F -				
С	TERMINAL NAM WIRE STRI	ME: CLIP PLENGTH mm[.13019 N APPLIED INSINKERA	INSULATION OINJ Ø NONE - 	IMP SPECIFICATION DIAMETER RANGE INSINKERATOR TERMINAL			
	WIRE SIZE SIZE	mm [	1P HEIGHT INCH] CF 7-0.05 [.070+/002]	RIMP HEIGHT 3 EFERENCE SETTING 9.1			
В	CRIMP APPLI NECES 5. UNLES	GE OF APPL HEIGHT RE CATOR WAS SARY WHEN NAL LUBRIC	ED INSTRUCTION SHEET FO ICATOR. FERENCE SETTING WAS THE QUALIFIED AT THE FACTOR RUNNING APPLICATOR IN TH ANT IS RECOMMENDED. D OTHERWISE TORQUE VALUE	SETTING USED WHEN Y. ADJUSTMENT MAY BI HE FIELD.	THE E		*WA ON SET SET THE PRC
A							

AMP 4805 REV 31MAR2000

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

\*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.

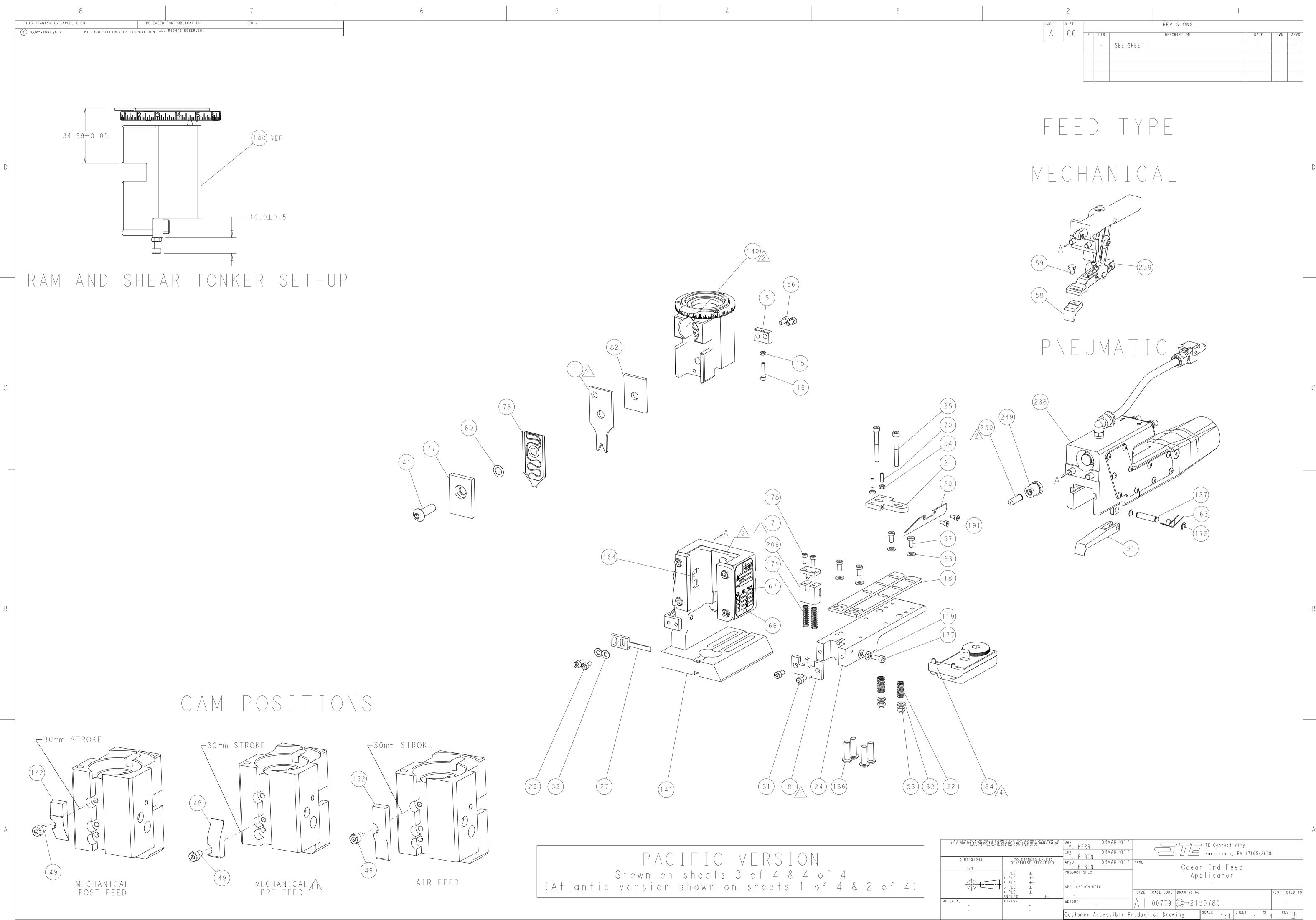
LOC	DIST				REVISIONS				
Λ	66								1.511.5
		P	LTR		DESCRIPTION		DATE	DWN	APVD
			-	SEE SHEET 1			-	-	-
			•						

D

	-	1 –		2119640-1	PUSH ROD, AIR FEED	250	
	- '	1 –		1803259-1	BUSHING, FLANGED	249	
		- 1		2119580-1	MECHANICAL FEED ASSEMBLY	239	-
	-			2063440-1	AIR FEED MODULE	238	-
	-	222		1803163-3	FLOATING SHEAR HOLDER	206	-
		$\frac{2}{4}$ $\frac{2}{4}$		<u>-2168083-1</u> 2079383-9	SCR, SKT HD CAP, RoHS, M3 X 6 SCR, BHSC, RoHS (M6 X 20)	186	1
		2 2		2-22280-0	SPRING, COMPRESSION	179	
		2 2		2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
	- '	1 1		356885-1	STOP, SHEAR	177	-
	- 2	2 -		21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	1
	- RE	EFREF		994970-2	COUNTER, MAGNETIC	164	
	- "	1 –		240638-1	SPRING, FEED FINGER	163	
	- '	1 –		2119641-2	FEED CAM, AIR FEED	152	-
		- 1		2119653-2	FEED CAM, POST FEED	142	-
	-			2119655-6	APPLICATOR BASIC ASSEMBLY, EF	1 4 1	-
		 1 _		<u>1803518-1</u> 3-23627-7	RAM ASSEMBLY, EF PACIFIC PIN, RETAIN, GRVD, 3/16 X .854	140	
	- 2	2 2		1-18028-2	WASHER, FLAT, REG M4	119	C
		1 1		2119955-2	ASSY, LUBRICATOR, END FEED	84	-
<u>/ 4 \</u>	- '	1 1		3 - 4 5 5 8 8 8 - 7	SPACER, CRIMPER	82	-
	- '	1 1		1803203-2	BLOCK, FRONT DEPRESSOR	77	
	- "	1 1		2119791-5	DEPRESSOR, WIRE	73	
	- '	1 1		1803607-2	DOCUMENTATION PACKAGE	7 1	
	- 2	2 2		2 - 1 8 0 3 2 - 2	SCR, SET, FLT PNT, M3 X 10.0	70	-
	- '	1 1		2119943-1	WASHER, SPACER	69	
	-			2119740-1	TAG, IDENTIFICATION	67	-
	- 4	22		2168078-1 5-18022-5	SCREW, DRIVE, RH, RoHS, 2 x .188 SCR, HEX HD CAP, M4 X 6.0	66 59	
		- 1		2063961-1	FEED FINGER	58	
	- 2	4 4		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	- 2	2 2		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	-
	- 2	2 2		5018030-1	NUT, HEX, REG, RoHS, M3	54	
	- 2	2 2		986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	- "	1 -		2119792-1	PAWL, EF, AIR	51	
	- '	1 2		18023-9	SCR, SKT HD CAP M4 X 6.0	49	-
		-     1   1		2119652-1	FEED CAM, PRE FEED	48	-
	- 5	1     3   8		<u>1803602-1</u> 1-18028-2	SCR, BHSC, R⊙HS (M8 X 25) WASHER, FLAT, REG M4	41	
	`	2 2		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	31	
		2 2		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	B
	- '	1 1		468281-6	STRIPPER	27	-
	- 2	2 2	· 1	-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
	- '	1 1		1803162-1	PLATE, STRIP GUIDE	24	
	- 2	2 2		2 - 2 2 2 8 1 - 3	SPRING, COMPRESSION	22	-
				1633168-1	ARM, STOCK DRAG	21	-
	-	1   1 2   2		464452-2	DRAG, STOCK	20	
	- <u>(</u>	<u>2 2</u> 1 1		-1901259-8 -2168083-3	GUIDE, LOWER STRIP SCR, SKT HD CAP, RoHS, M3 X 16	18	
	- ,	1 1		5018030-1	NUT, HEX, REG, RoHS, M3	15	-
				-	-	1 1	
				_	-	1 0	1
				-	-	9	
1	1 '	1 1		1213862-5	ANVIL, SPLICE TYPE	8	-
<u>_1</u>	- '	1 1		1633722-3	SHEAR BLADE	7	-
		 1 1		-		6	-
		 _   _		690753-6	SPACER, TONKER	5	
				_	_	3	
				_	-	2	
$\wedge$	1 '	1 1		1803504-1	CRIMPER, WIRE	1	1
	77-2	22-21		PART NO	DESCRIPTION	ITEM	A
THIS DRAWING IS A CONTROLLED DOCU IT IS SUBJECT TO CHANGE AND THE SHOULD BE CONTACTED				dwn 0.3MAR	2017	NO	-
SHOULD BE CONTĂCTÉĎ	FOR THE LATE	EST REVISION.		M. HERR CHK 03MAR			
DIMENSIONS:	TOL OTHE	LERANCES UN RWISE SPECI	_ESS FIED:	- <u>T. ELBIN</u> apvd 03MAR T. ELBIN			1
mm	0 PLC I PLC	±- ±-		PRODUCT SPEC	Applicator		
	2 PLC 3 PLC	±- ±-		- APPLICATION SPEC			
MATERIAL	4 PLC ANGLES FINISH	±-	±-	 WEIGHT		ESTRICTED TO	
		-		-	$A \mid 00779 \mid C = 2150780$		-

SCALE 1:1 SHEET 3 OF 4 REV B SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Customer Accessible Production Drawing



AMP 4805 REV 31MAR2000

ENT FOR TYCO ELECTRONICS CORPORATION ONTROLLING ENGINEERING ORGANIZATION OR THE LATEST REVISION.	DWN 03MAR2017 M. HERR		TE Connectivity			
	снк 03MAR2017 Т. ELBIN	——————————————————————————————————————				
TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD 03MAR2017 T. ELBIN	Ocean End Feed				
0 PLC ±- I PLC ±-	PRODUCT SPEC		Applicator			
2 PLC ±- 3 PLC ±-	APPLICATION SPEC	_	-			
4 PLC ±- ANGLES ±- FINISH	-		ING NO	RESTRICTED TO		
	WEIGHT _	A   00779 C-	=2150780	-		
	Customer Accessible P	roduction Drawing	SCALE 1:1 SHEET 4 4	B REV		
	SHEETS 1 &	2 ARE NOT REG	QUIRED FOR PACIFIC \	/ERSION		