

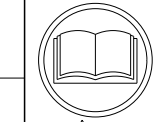
8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151032-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151032-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151032-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	O
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

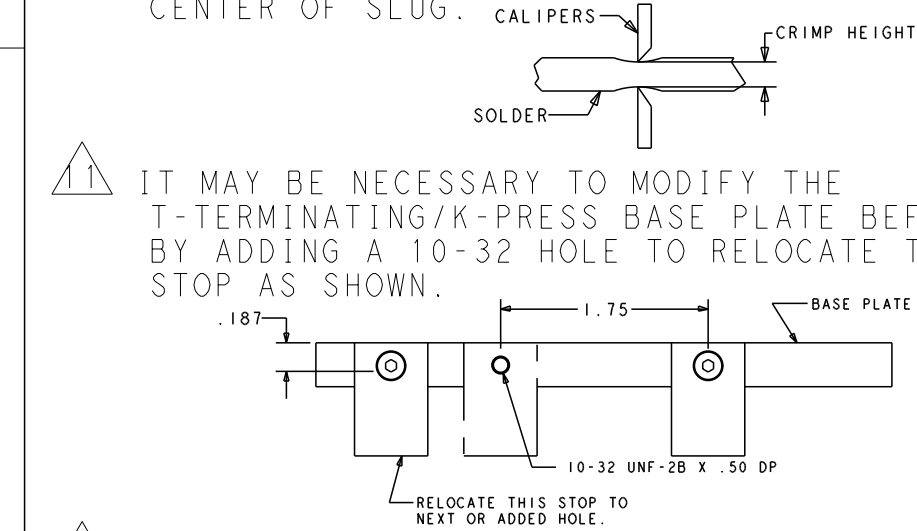
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH .265-.297 IN [6.73-7.54 mm]		INSULATION DIAMETER RANGE 	
TERMINAL APPLICATION SPECIFICATION 	114-2123 Rev G	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-350815-2	3-520116-2	3-520140-2	5-520150-2
5-350815-2	3-520124-2	3-520140-4	6-520150-2
3-350819-2	9-520124-2	5-520140-2	3-520276-2
5-350819-2		9-520140-2	9-520276-2
3-520106-2		3-520150-2	3-521142-2
		3-521150-2	3-1969626-1
GROUP 1		GROUP 2	

WIRE SIZE		CRIMP HEIGHT INCH [mm]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14 AWG		0.075+/-0.002 [1.91+/-0.05]		6.4	.187 IN [4.750mm]
16, (2)18, OR (3)20		0.070+/-0.002 [1.78+/-0.05]		7.7	.187 IN [4.750mm]

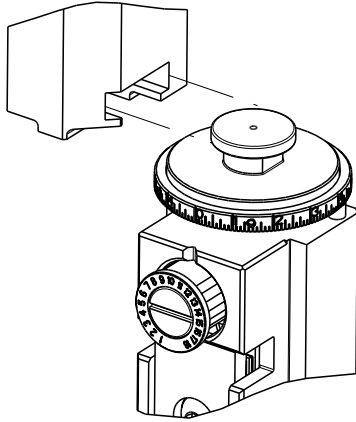


- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER.
ITEM 42 OR ITEM 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- GROUP 1 TERMINALS: Ø.160 IN [4.06mm] MAX INSULATION
GROUP 2 TERMINALS: Ø.260 IN [6.60mm] MAX INSULATION
- USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
15. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC 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.

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

LOC	DIST	REVISIONS				
A	66	#	LYR	DESCRIPTION	DATE	DWN APVD
			C2	ECR-15-016183	05NOV2015	JH JDG
			D	ECR-16-015863	16NOV2016	TB CT
			E	ECR-18-017780	13NOV2018	JAH CT
			F	ECR-19-005049	29MAR2019	LG TE

	-	REF	REF	462992-5	GUARD ASSY	257
	-	REF	REF	679532-1	INSERT, GUARD	256
	-	1	1	189728-1	BRACKET, SPACER	255
	-	1	1	568681-1	SPACER, BASE PLATE	253
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
	-	1	1	2844940-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	240641-6	SPACER	81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2161332-1	DEPRESSOR, WIRE FUNNEL	70
	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	462427-2	FINGER, FEED	56
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	462433-7	SUPPORT, INSULATION	43
	-	1	1	462433-6	SUPPORT, INSULATION	42
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	2	22281-9	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	684042-4	GUIDE, STRIP, FRONT	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	462431-5	WIRE FUNNEL	22
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	463460-3	HOLD DOWN, TERMINAL	18
	-	1	1	469542-3	REAR FLOATING SHEAR	17
	-	4	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	1	2280441-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	356885-4	STOP, SHEAR	11
	-	1	1	462843-6	TERMINAL SUPPORT	10
	-	1	1	462843-5	TERMINAL SUPPORT	9
	1	2	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
	-	1	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
	-	1	1	462431-4	WIRE FUNNEL	5
	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	1	2	1	464281-1	CRIMPER, SEMI FLAT 16-14	1

-77-72 -2		PART NO	DESCRIPTION		ITEM NO
DWN B. WEAVER CHK G. HOFENER APVD T. ELBIN		17OCT2011 17OCT2011 17OCT2011	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		0 PLC 1 PLC 2 PLC 3 PLC 4 PLC	NAME OCEAN SIDE FEED APPLICATOR		
		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	SIZE 00779		RESTRICTED TO
MATERIAL -		FINISH -	WEIGHT -		Customer Accessible Production Drawing
			SCALE 1:1		SHEET 1
			DRAWING NO ©=2151032		REV F

8

7

6

5

4

3

2

1

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2011

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PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

2-2151032-2

F

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

7-2151032-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

.205 [5.21 mm]

Ø

INSUL

-

-

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: FULLY INSULATED FASTON

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

265-.297 IN [6.73-7.54 mm]

Ø

8

TERMINAL APPLICATION SPECIFICATION

114-2123 Rev G

-

-

TERMINALS APPLIED

4

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

3-350815-2

3-520116-2

3-520140-2

5-520150-2

5-350815-2

3-520124-2

3-520140-4

6-520150-2

3-350819-2

9-520124-2

5-520140-2

3-520276-2

5-350819-2

9-520140-2

9-520276-2

3-520106-2

3-520150-2

3-521142-2

3-521150-2

3-1969626-1

GROUP 1

8

9

GROUP 2

8

9

WIRE SIZE

CRIMP HEIGHT INCH [mm]

CRIMP HEIGHT REFERENCE SETTING

3

Ø SOLDER

10

14 AWG

0.075+/-0.002 [1.91+/-0.05]

6.4

.187 IN [4.750mm]

16, (2)18, OR (3)20

0.070+/-0.002 [1.78+/-0.05]

7.7

.187 IN [4.750mm]

1 RECOMMENDED SPARE PARTS

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

3 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.

4 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

5 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.

6 ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR ITEM 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

7 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.

8 GROUP 1 TERMINALS: Ø.160 IN [4.06mm] MAX INSULATION
GROUP 2 TERMINALS: Ø.260 IN [6.60mm] MAX INSULATION

9 USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS

10 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

CALIPERS

CRIMP HEIGHT

SOLDER

11 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.

1.75

BASE PLATE ASSEMBLY

10-32 UNF-28 X .50 DP

RELOCATE THIS STOP TO NEXT OR ADDED HOLE.

12 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

13 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

14 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

OWN

CHK

APVD

T

ELBIN

17OCT2011

17OCT2011

17OCT2011

DIMENSIONS:

mm

0 PLC ±

1 PLC ±

2 PLC ±

3 PLC ±

4 PLC ±

ANGLES FINISH

-

MATERIAL

-

OWN

B. WEAVER

17OCT2011

CHK

G. HOFENER

17OCT2011

APVD

T. ELBIN

17OCT2011

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

F

NAME

OCEAN SIDE FEED APPLICATOR

SIZE

CAGE CODE

DRAWING NO

00779

©=2151032

RESTRICTED TO

-

TE Connectivity

Harrisburg, PA 17105-3608

LOC

DIST

A

66

P

LYR

-

SEE SHEET 1

DESCRIPTION

DATE

OWN

APVD

- REF

462992-5

GUARD ASSY

257

- REF

679532-1

INSERT, GUARD

256

- 1

189728-1

BRACKET, SPACER

255

- 1

568681-1

SPACER, BASE PLATE

253

- 1

18023-1

SCR, SKT HD CAP M3 X 5.0

241

- 1

2844940-2

AIR FEED MODULE

238

- 1

1-18028-0

WASHER, FLAT, REG M8

192

- REF

994970-2

COUNTER, MAGNETIC

164

- 1

2119641-2

FEED CAM, AIR FEED

151

- 1

2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

- 4

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

143

- 1

2-1803583-0

APPLICATOR BASIC ASSEMBLY, SF

141

- 1

1803516-1

RAM ASSEMBLY, SF PACIFIC

140

- 1

1-22281-8

SPRING, COMPRESSION

121

- 1

2844908-1

SCREW, LOCKING

99

- 1

2844907-1

POST, LOCKING

98

- 1

1-690438-0

FRONT STRIP GUIDE

96

- 4

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

- 1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

- 1

455888-4

SPACER, CRIMPER

82

- 1

240641-6

SPACER

81

- 1

1803607-3

DOCUMENTATION PACKAGE

71

- 1

2161332-1

DEPRESSOR, WIRE FUNNEL

70

- 1

2161331-1

SPACER, WIRE FUNNEL DEPRESSOR

69

- 2

1-18028-4

WASHER, FLAT, REG M3

68

- 1

2119740-1

TAG, IDENTIFICATION

67

- 2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

- 2

2-18032-5

SCR, SET, FLT PNT, M5 X 20.0

61

- 1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

- 1

462427-2

FINGER, FEED

56

- 2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

- 1

18023-9

SCR, SKT HD CAP M4 X 6.0

49

9

- 1

462433-7

SUPPORT, INSULATION

43

9

- 1

462433-6

SUPPORT, INSULATION

42

- 1

1803602-1

SCR, BHSC, RoHS (M8 X 25)

41

- 2

5-22278-1

SPRING, COMPRESSION

33

- 2

1-2168083-4

SCR, SKT HD CAP, RoHS, M4 X 5

30

- 1

2161336-2

PLATE, REAR STRIP GUIDE

29

- 2

22281-9

SPRING, COMPRESSION

27

- 1

356835-1

LEVER, DRAG RELEASE

26

- 1

240792-1

DRAG, TERMINAL

25

- 1

684042-4

GUIDE, STRIP, FRONT

24

- 1

980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

9

- 1

462431-5

WIRE FUNNEL

22

- 1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

- 1

1-18028-2

WASHER, FLAT, REG M4

20

- 1

2119533-1

STRIPPER, SIDE FEED

19

- 1

463460-3

HOLD DOWN, TERMINAL

18

1

- 1

469542-3

REAR FLOATING SHEAR

17

- 4

1-2168083-1

SCR, SKT HD CAP, RoHS, M3 X 6

16

1

- 1

2161335-2

SHEAR PLATE, REAR

15

- 1

2119862-2

SHEAR HOLDER, REAR

14

1

- 1

2280441-1

INSERT, SHEAR

13

- 1

3-22280-3

SPRING, COMPRESSION

12

- 1

356885-4

STOP, SHEAR

11

9

- 1

462843-6

TERMINAL SUPPORT

10

9

- 1

462843-5

TERMINAL SUPPORT

9

1

1

464282-2

ANVIL, SAND-BLASTED 16-14

8

5

- 1

803925-2

GUIDE, CARRIER SCRAP

7

- 1

2-690468-5

DEPRESSOR SHEAR, REAR

6

9

6

- 1

462431-4

WIRE FUNNEL

5

- 1

238011-1

BLOCK, CRIMPER SPACER

4

1

1

464281-1

CRIMPER, SEMI FLAT 16-14

1

-77-22

PART NO

DESCRIPTION

ITEM NO

AMP 4805 REV 31MAR2000

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

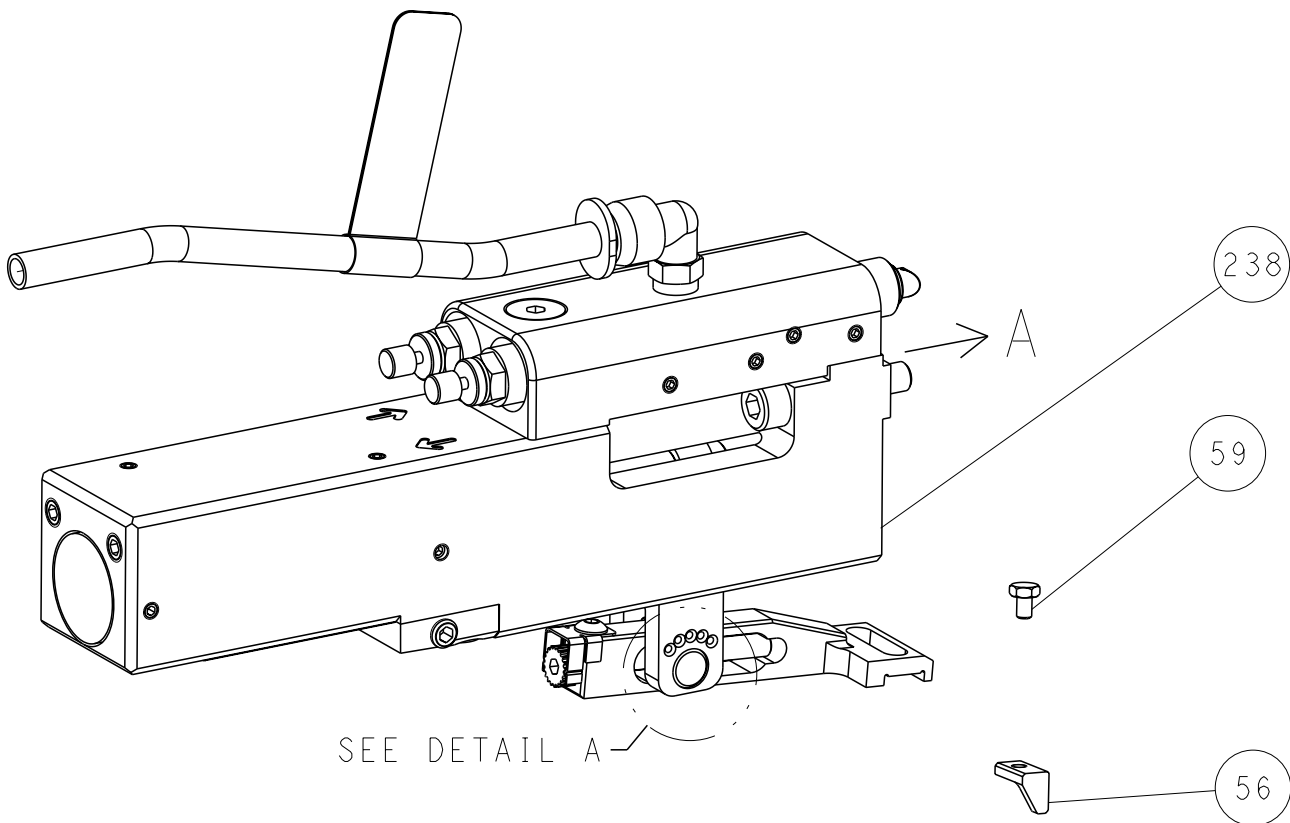
REV

F

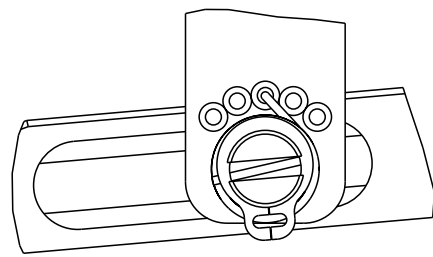
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
PNEUMATIC

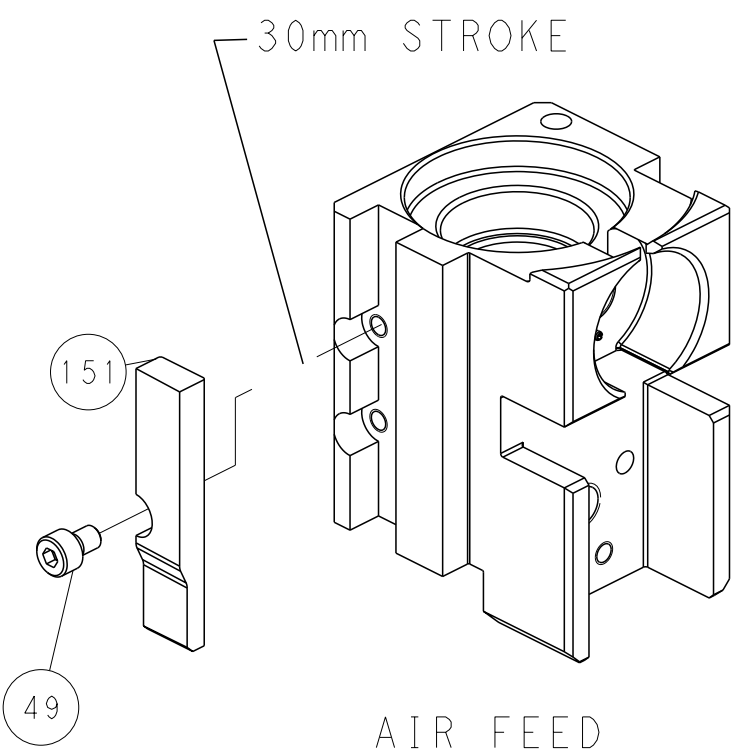


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

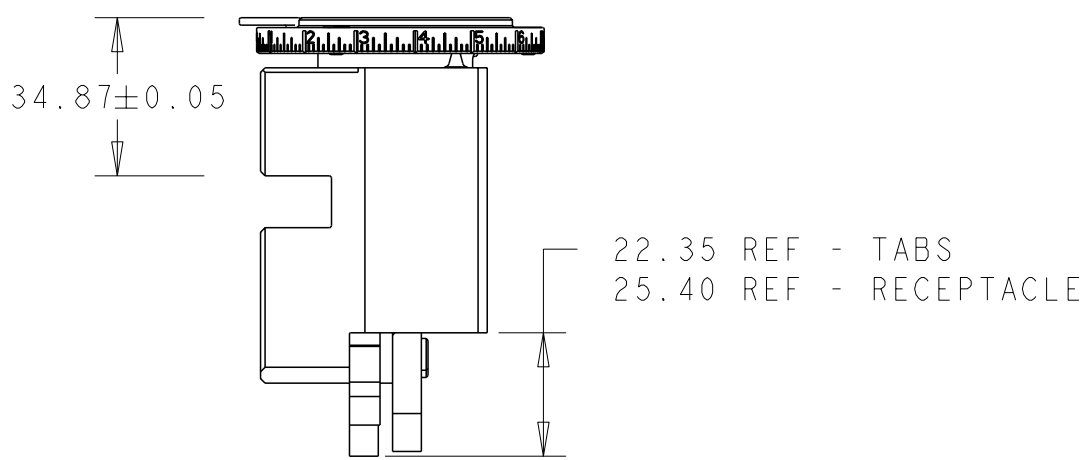
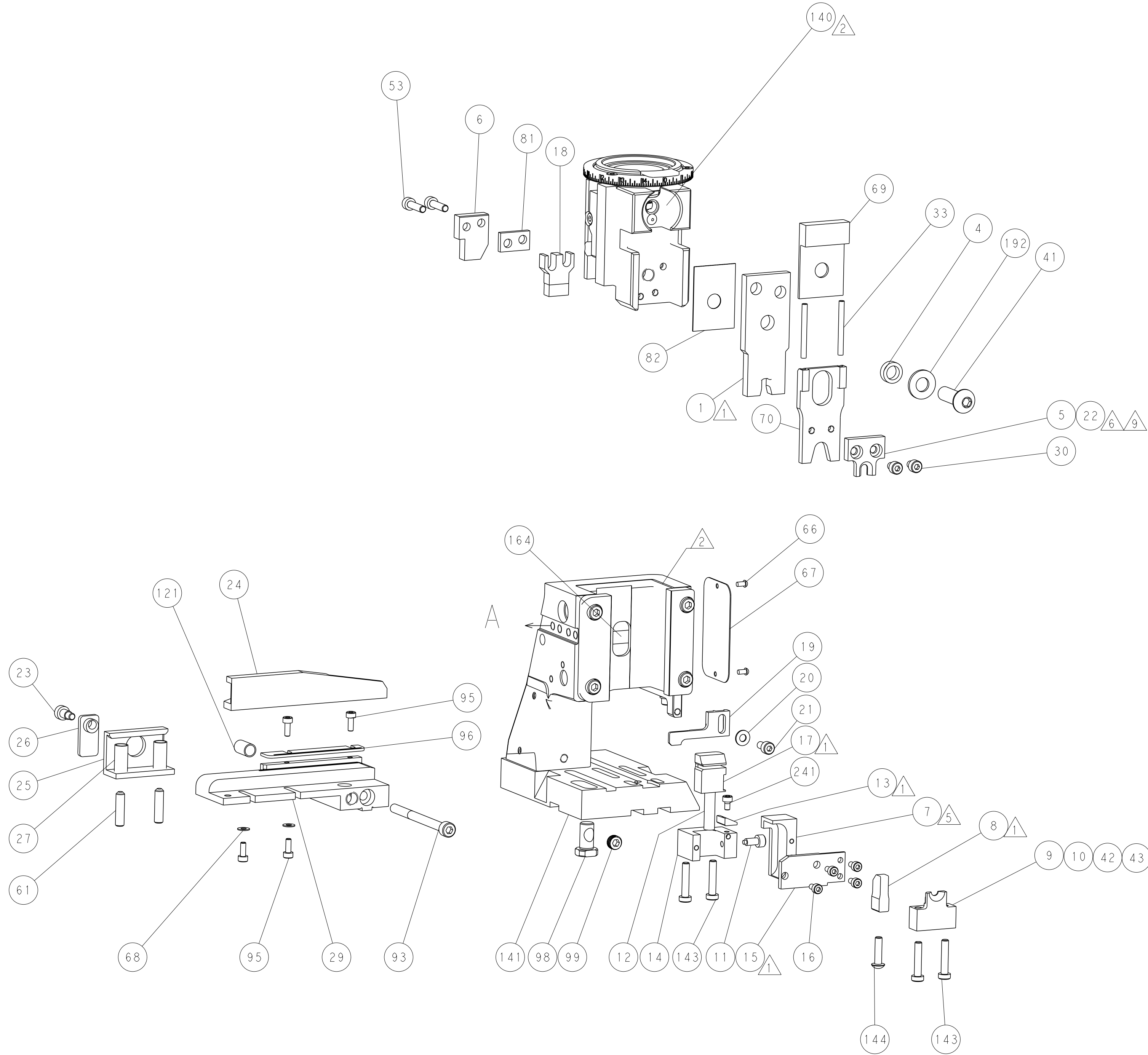


DETAIL A

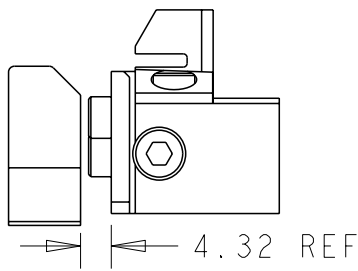
CAM POSITION



AIR FEED



RAM & HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

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

1111 BEARING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISPOSITION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN B. WEAVER 17OCT2011	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFENER 17OCT2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *		APVD T. ELBIN 17OCT2011	NAME OCEAN SIDE FEED APPLICATOR	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2151032	
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4
			OF 4	REV F

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2151032-2](#)