





А	A	
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL	INSTRUCTIONS 408-10390	

TERMINAL DATA:	TE TERMINAL	TE CRIMI	P SPECIFICATION				
TERMINAL NAME:	205 SERIES F	FASTON RECEPT	ACLE				
WIRE STRIP LE	ENGTH -	INSULATION D	IAMETER RANGE				
3.87-4.63 mm [.152182 [N]	Ø2.16-3.17 mm [.085125 IN]					
TERMINAL APPLICATION	114-2036	-	-				
SPECIFICATION	-	-	-				
TERMINALS AF	PPLIED/2						
TE TERMINAL ·	TE TERMINAL	TE TERMINAL	TE TERMINAL				
170122-2	170122-4						

WIRE SIZE 🛞 🕇	CRIMP HEIGHT ME [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
18 AWG	1.19+/-0.05 [.047+/002]	5.5
20 AWG	1.09+/-0.05 [.043+/002]	6.5
22 AWG	1.04+/-0.05 [.041+/002]	7.0



1 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150713-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150713-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150713-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

ORIMP 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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS.
FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

12 TERMINAL LUBRICANT IS RECOMMENDED.

*WARNING ON INSTALLATION, SET WIRE DISC, ITEM 40 TO BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

_	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
_	_	_	1	_	2119640-1	PUSH ROD, AIR FEED	250
_	-	_	1	-	1803259-1	BUSHING, FLANGED	249
_	1	1	1	1	1 - 22279 - 3	SPRING, COMPRESSION	246
_	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 77	- 27	- 25	- 22	- 21	PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION

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

	S		JP GA		DIST REVISIONS				
		211	9599	- 2	66 P LTR DESCRIPTION - SEE SHEET 1	DATE (DWN -	APVD -	
_	1 1	1	1	1	2079764-1 WASHER, WAVE SPRING 2119083-1 RETAINER, INSULATION			4 3 4 2	
_		2	_	-	2168400-7 SHCS, LOW HEAD, Rot	HS, M5 X 10	2	40	
_		-	<u>-</u> 1	1	2119580-1 MECHANICAL FEED ASS 2063440-1 AIR FEED MODULE	SEMBLY		3 9 3 8	
_	-	1	- /	-	2119740-2 TAG, IDENTIFICATION		2	1 3	
_	4 - R	4 : E F	4	-	2079383-9 SCR, BHSC, RoHS (M6 1901697-1 FEED FINGER ASSEMBL			8 6 8 3	
_	1 1	1	1	1	1752354-7 STANDOFF, HOLD-DOWN 6-993111-6 PIN, SLOTTED SPRING	G 3 0 X 14 0		8 0 7 7	
_	1	1	1	1	8-22280-7 SPRING, COMPRESSION	N	1	76	
_	1 1	1	1	1 1	1752353-2 GUIDE PIN, HOLDDOWN 1901680-2 GUIDE PIN, HOLDDOWN			7 5 7 4	
_	-	_	2	_	21045-3 RING, RETAIN, EXTER	RN, 3/16 CRESCENT	1	7 2	
_	REFR	EFF	REF	REF	994969-1 MAGNET, RARE EARTH 994970-2 COUNTER, MAGNETIC	HIGH ENERGY	_	6 6 6 4	
_	_ 1	- 1	1	- 1	240638-1 SPRING, FEED FINGER			63	
_	<u> </u>	-	1	_	8-21084-1 O-RING, .801 ID, .0 2119641-2 FEED CAM, AIR FEED		_	53 52	
_	1 1	1	1	1	2119798-2 DETENT PIN 2079383-8 SCR, BHSC, RoHS (M4			4 5 4 4	
_	_	-	_	1	2119653-2 FEED CAM, POST FEEL	D	1	42	
-	1 1	1	1	1 1	2119655-6 APPLICATOR BASIC AS 2119651-1 RAM, ASIAN STYLE, E		_	4 1 4 0	
_	1	1	1	1	2119092-2 BOLT, ADJUSTMENT		1	39	
_	- R	- ! E F	1 -	-	3-23627-7 PIN, RETAIN, GRVD, SEE NOTE 4 MEMORY CHIP, PROGRA			3 7 3 5	
_		1	_ 1	- 1	1633743-1 SERVO FEED LATCH AS 2119955-2 ASSY, LUBRICATOR, E	SM	1	3 3	
_	1	1	1	1	455888-5 SPACER, CRIMPER			2	
-	1 2	1 2	1 2	1 2	2119956-2 DOCUMENTATION PACKA 2-18032-2 SCR, SET, FLT POINT		7	1	
-	1	-	1	1	2119740-1 TAG, IDENTIFICATION		6	7	
_	2	2	2	2	2168078-1 SCREW, DRIVE, RH, F 1-1901681-3 HOLDDOWN, TERMINAL			<u>6</u> 5	
_	1	1	1	1	2119793-1 LIMITER, ADJUSTMEN	T BOLT	6	3	
_	3 -	3	3	3 1	992763-5 SCR, SET, SOC, CONE 5-18022-5 SCR, HEX HD CAP, M4			2	
_	- 4	<u>-</u>	- 4	1 4	2063961-1 FEED FINGER 2168400-4 SHCS, LOW HEAD, Rob	HS MAY 8		8 7	
_	2	2	2	2	2168083-2 SCR, SKT HD CAP, R	oHS, M4 X 8.0	5	6	
_	2 2	2	2	2	5018030-2 NUT, HEX, REG, RoHS 5018030-1 NUT, HEX, REG, RoHS			5 4	
-	2	2	2	2	986965-8 NUT, LOCK, HEX, TOP	RQUE (M4)	5	3	
_	-	-	1	_	1-5018030-0 NUT, HEX, REG, RoHS 2119792-2 PAWL, EF, AIR	s, M3.5		1	
_	-	-	1	2	18023-9 SCR, SKT HD CAP M4		_	9 8	
_	1	1	1	1	2119652-1 FEED CAM, PRE FEED 2079383-7 SCR, BHSC, RoHS (M8		_	1	
_	1 1	1	1	1	2119645-1 DISC, NUMBERED FA V 2119957-1 APPLICATOR SHIM PAG			9	
_	1	1	1	1	2119644-1 RAM WASHER, PRECISI	ION	3	8	
_	8 2	8 2	8	8	1-18028-2 WASHER, FLAT, REG M 2168083-8 SCR, SKT HD CAP, Ro			3 1	
-	2	2	2	2	1-2168083-0 SCR, SKT HD CAP, R	oHS, M4 X 10	2	9	
_	2	2	2	2	240639-4 STRIPPER (MACHINING 1320906-1 STUD, THREADED	ا ر		7 5	
_	1 2	1 2	1 2	1 2	1752371-5 PLATE, STRIP GUIDE 2-22281-3 SPRING, COMPRESSION			2	
_	1	1	1	1	1752373-4 DRAG		2	0	
_	2 1	2	2	2 1	1901259-3 GUIDE, LOWER STRIP 1752360-1 SPACER, HOLD-DOWN		1 1	8	
_	1	1	1	1	240644-1 PLATE, REAR SHEAR		1	1	
	1	1	1	1	690482-5 PLATE, FRONT SHEAR			9	
1	1 1	1 1	1	1 1	5-1803059-8 ANVIL, COMBINATION, 2217206-7 BLADE, SLUG	, END FEED		8 7	
_	-	-	-	-				6	
_	1 1	1	1	1 1	2-240641-4 SPACER 238009-1 BLOCK, FL CRIMPER S	 S P A C E R		5 4	
1	1	1	1	1	2-1633961-3 CRIMPER, INSULATION			3	
1	1 1	1	1	1 1	455888-6 SPACER, CRIMPER 4-456406-7 CRIMPER, WIRE PREM:	IUM		<u>2</u> 1	
- 7	7-27-	25	- 22	- 21	, , , , , , , , , , , , , , , , , , ,	IPTION		EM IO	
NG IS A JECT TO SHOU	CONTROLLED DOG CHANGE AND THE ILD BE CONTACTED	CUMENT FOR CONTROLL FOR THE	R TYCO ELE ING ENGIN LATEST RE	CTRONICS CORPO EERING ORGANIZ VISION.	DWN 03AUG2016 03AUG2016 03AUG2016	TE Connectivity	1 1		
MENSI:	ONS:		TOLERAI THER W IS	NCES UNLES BE SPECIFI	K.ZHANG APVD 03AUG2016 NAME	⊐ Harrisburg, PA 17105-3608 an End Feed			
···	\	0 PL 1 PL 2 PL	C C	±- ±- ±-	PRODUCT SPEC A p	oplicator -			
Ψ	/	3 PL 4 PL ANGL	C C ES	±- ±- ±-	APPLICATION SPEC SIZE CAGE CODE DRAWING N		STRICT	ED TO	
-		FINI	υп	-	Customer Accessible Production Drawing	SCALE SHEET 3 OF 4	- REV		

