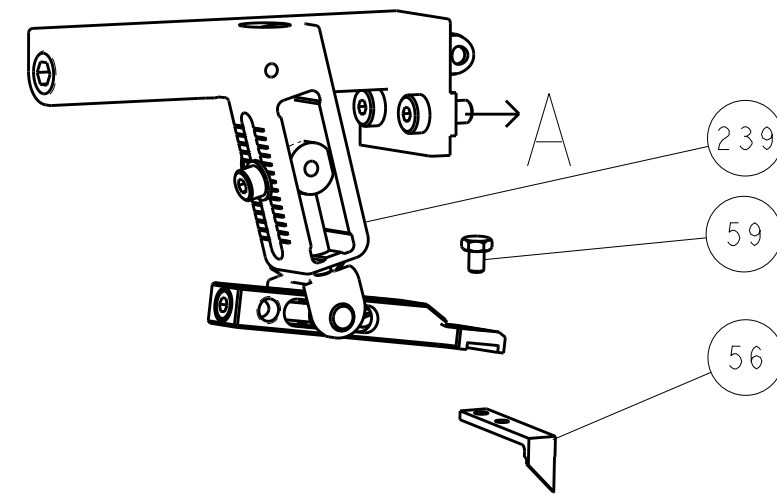
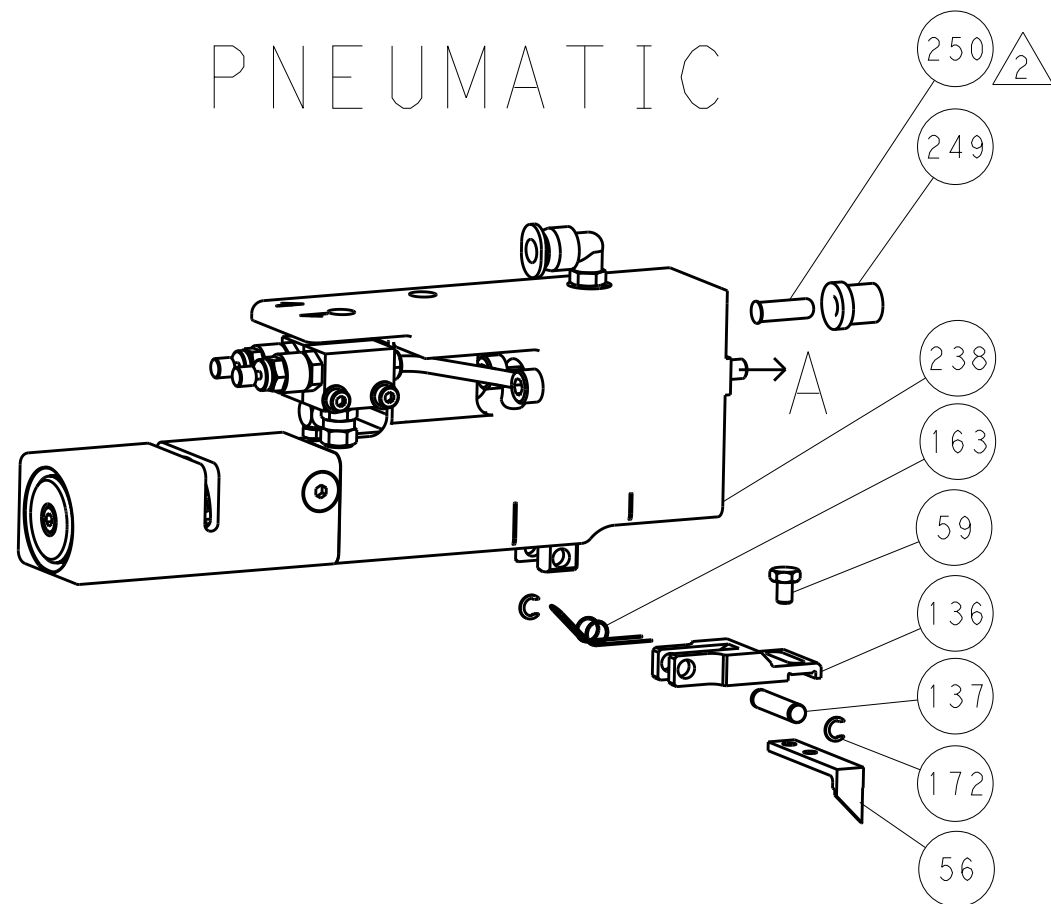


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



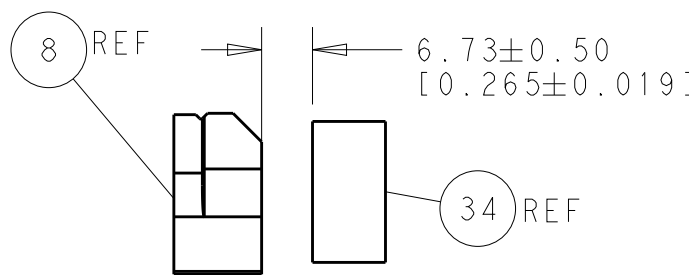
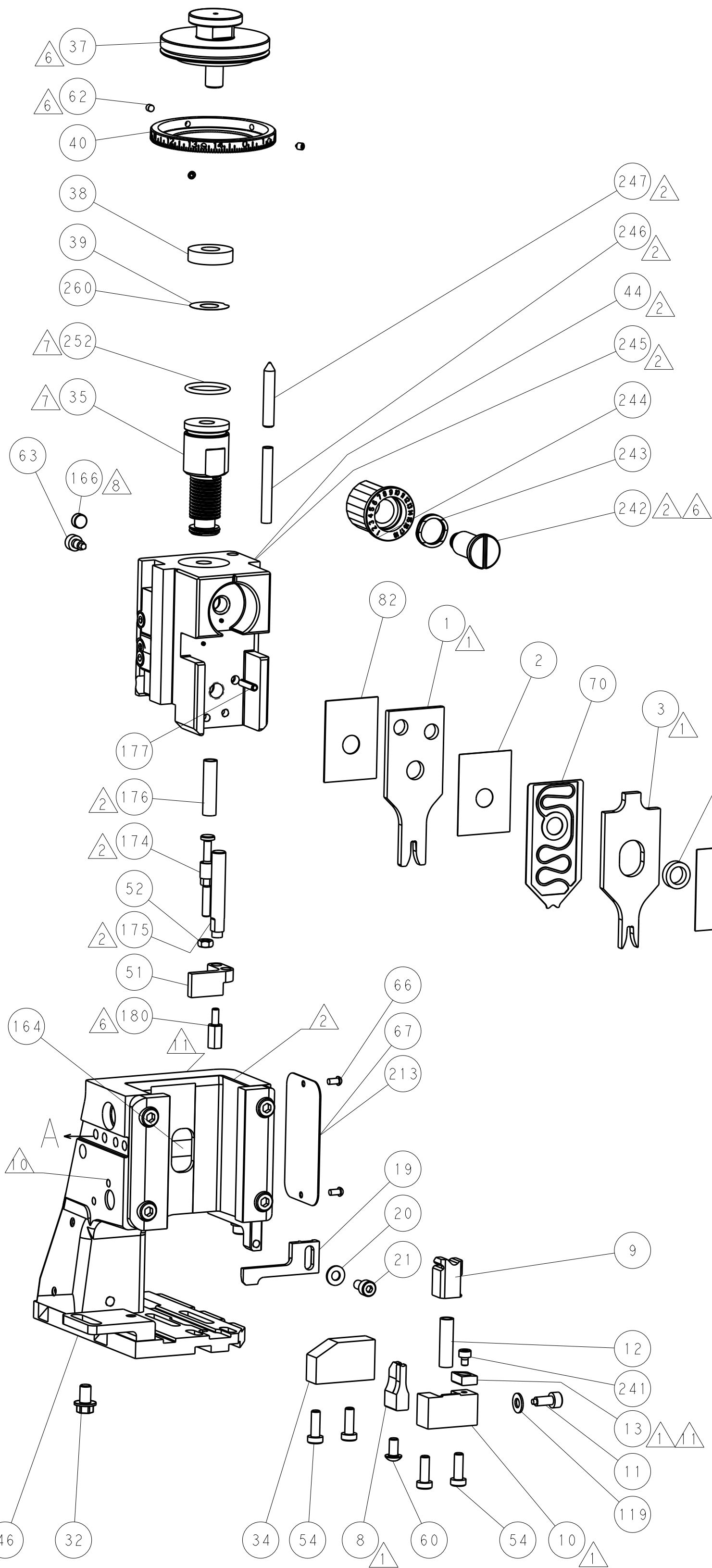
PNEUMATIC



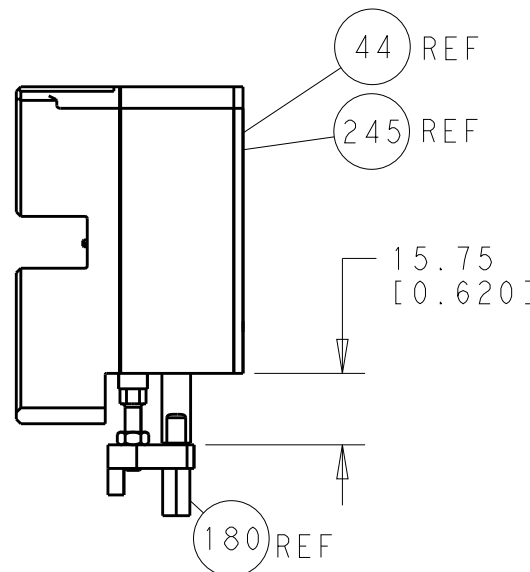
SERVO
LATCH PLATE



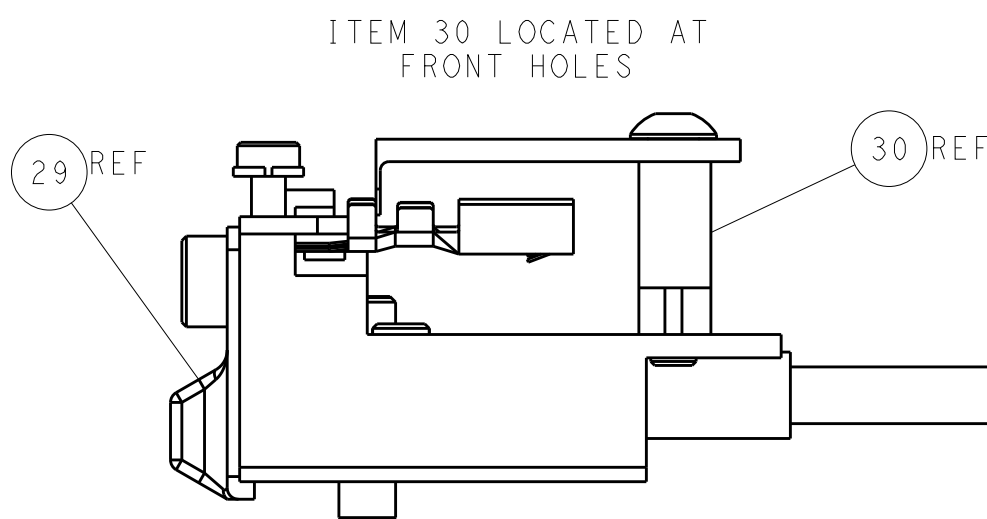
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
mm		0 PLC ±0.5		K. HUANG		L. ZHANG		J. GUO		Ocean Side Feed		A1		00779		C=2266076		-	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		1:2		SHEET		2		OF 4		REV	

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

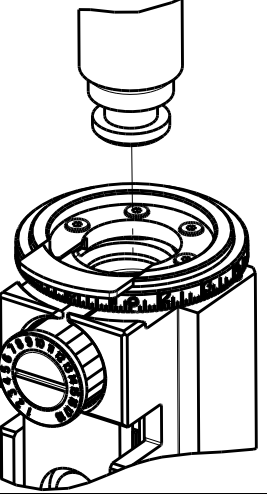
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266076-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

8-2266076-5

1901094-3

2-1752354-6

2168400-6 (QUANTITY 2)

2161326-1

8-2266076-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

8-2266076-5

1901094-3

2-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

8-2266076-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

2-2266076-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2266076-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

2-2266076-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2266076-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.40 mm [.094]

F

INSUL

3.20 mm [.126]

F

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: MTA TERMINAL

MTA CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL MINI F280

WIRE STRIP LENGTH

4.00-4.40 mm [.157-.173 IN]



INSULATION DIAMETER RANGE

Ø1.96-2.67 mm [.077-.105 IN]

TERMINAL APPLICATION SPECIFICATION

BO-018.009B Rev 7

-

-

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

2113384-1

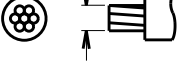
MTA TERMINAL

1708331

TE TERMINAL

MTA TERMINAL

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

1+1 mm2

1.50+/-0.05 [.059+/- .002]

5.6

2.00mm2

1.50+/-0.05 [.059+/- .002]

5.9

1.50mm2

1.40+/-0.05 [.055+/- .002]

6.6

0.75+0.75 mm2

1.40+/-0.05 [.055+/- .002]

6.6

1.00mm2

1.30+/-0.05 [.051+/- .002]

7.6

0.5+0.5 mm2

1.30+/-0.05 [.051+/- .002]

7.6



RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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

4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266076-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266076-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266076-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6

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

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

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

9

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.

10

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

11

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

-

1

1

1

1

2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

1

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-8

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-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)

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISONS

P

LYR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

-

-

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

2063440-1

AIR FEED MODULE

238

-

-

1

-

-

2119740-2

TAG, IDENTIFICATION

213

-

-

1

-

-

1901094-3

SPACER, FEEDER

198

6

-

1

1

1

1

2-1752354-6

STANDOFF, HOLD-DOWN

180

-

1

1

1

1

6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

-

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1

1752353-2

GUIDE PIN, HOLDDOWN

175

-

1

1

1

1

1901680-2

GUIDE PIN, HOLDDOWN

174

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

-

-

REF

1

-

240638-1

SPRING, FEED FINGER

163

-

1

1

1

1

8-21084-1

O-RING, .801 ID, .070 DIA. MAT.

152

-

-

-

-

1

-

2119641-2

FEED CAM, AIR FEED

151

-

1

1

1

1

2119798-2

DETENT PIN

145

-

1

1

1

1

2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

-

4

4

4

4

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

143

-

-

-

-

1

-

2119653-2

FEED CAM, POST FEED

142

-

1

1

1

1

1-2119656-0

APPLICATOR BASIC ASSEMBLY, SF

141

-

1

1

1

1

2119650-1

RAM, ASIAN STYLE, SIDE FEED

140

-

1

1

1

1

2119092-2

BOLT, ADJUSTMENT

139

-

-

-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

-

-

-

1

-

2119799-1

HOLDER, FEED FINGER, AF

136

-

-

REF

-

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

-

-

1

-

-

-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

-

-

-

2119944-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

22278-8

SPRING, COMPRESSION

77

-

1

1

1

1

854769-4

HOLDER, INS

74

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-9

DEPRESSOR, WIRE

70

-

1

-

1

1

1

2119740-1

TAG, IDENTIFICATION

67

6

-

2

2

2

2

2168078-1

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

66

-

1

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

1

1

1

1

21028-2

PIN, SLOTTED SPRING .062 X .250

58

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

1

1

1

1

1901681-1

HOLDDOWN, TERMINAL

51

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

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-

-

1

2119652-1

FEED CAM, PRE FEED

48

-

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

-

1

1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

1

1

1-2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

1-1752356-3

SUPPORT, TERMINAL

34

-

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

-

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1

1-1320908-2

SPACER, STRIP GUIDE

30

-

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

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1

455888-3

SPACER, CRIMPER

28

-

1

1

1

1

1

1320928-2

STRIP GUIDE

24

-

1

1

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1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1

1

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1-18028-2

WASHER, FLAT, REG M4

20

-

1

1

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2119533-1

STRIPPER, SIDE FEED

19

1

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1

1

1

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2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

-

1

1

1

1

1

1-356885-4

STOP, SHEAR

11

1

-

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

1

1

1803095-1

FLOATING SHEAR, FRONT

9

1

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1

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1803056-6

ANVIL, COMBINATION

8

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7

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6

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1

2119780-9

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

3-238011-1

BLOCK, CRIMPER SPACER

4

1

1

1

1

1

1

7-1633961-0

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-1

SPACER, CRIMPER

2

1

1

1

1

1

1

3-1490019-3

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

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OWN

CHK

APVD

DATE

16OCT2013

16OCT2013

16OCT2013

16OCT2013

CHN

L. ZHANG

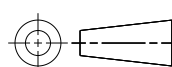
U. GUO

16OCT2013

16OCT2013

DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.13

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

A

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

A1

00779

©=2266076

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

D

C

B

A

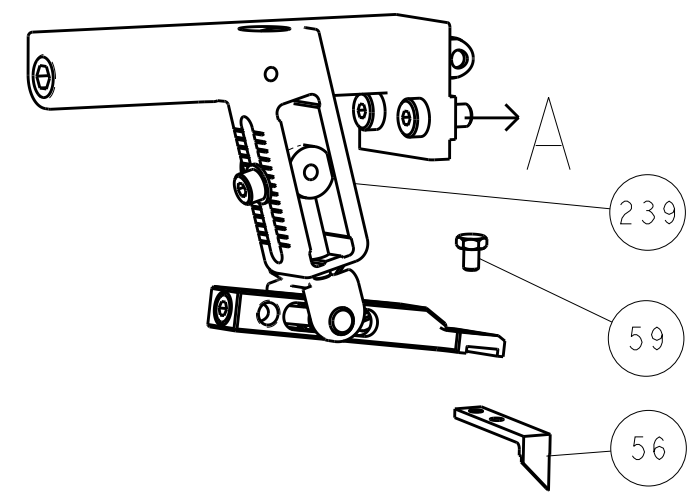
D

C

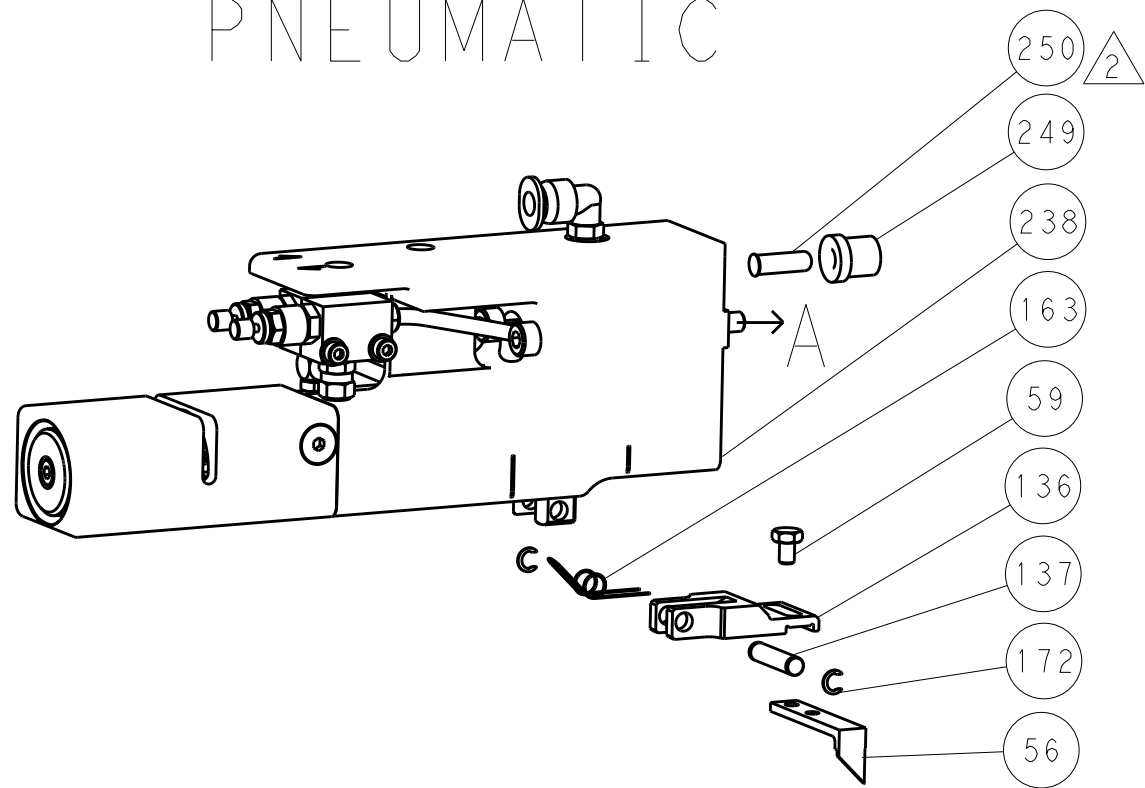
B

A

FEED TYPE MECHANICAL



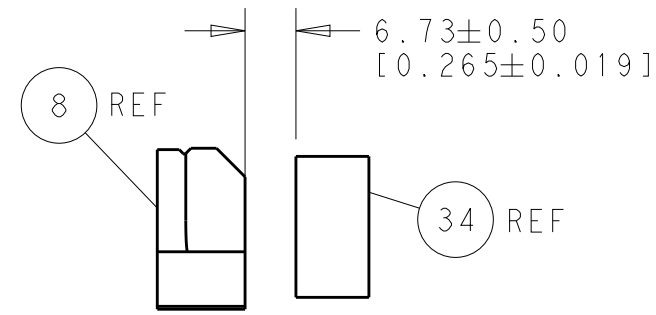
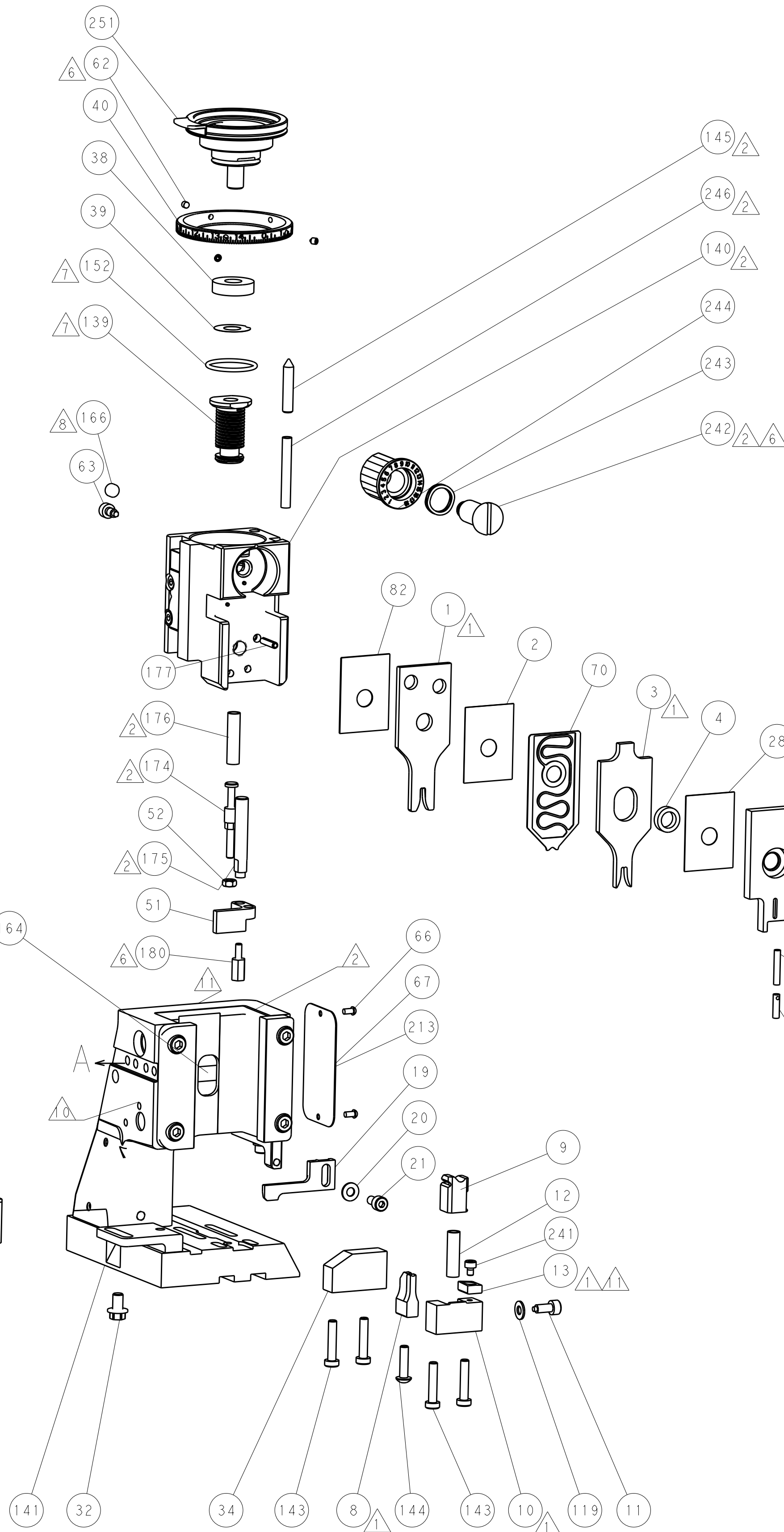
PNEUMATIC



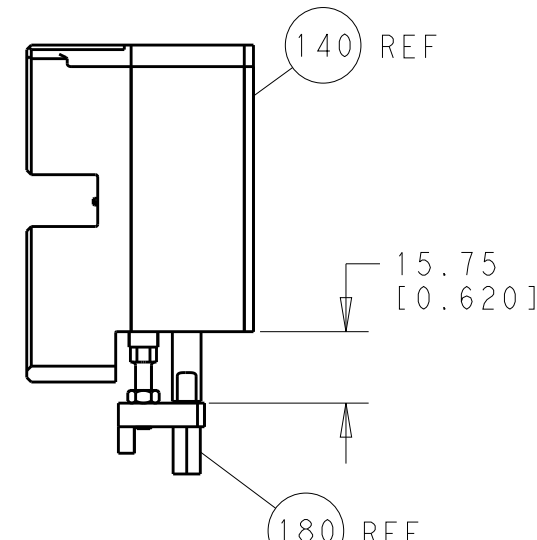
SERVO LATCH PLATE



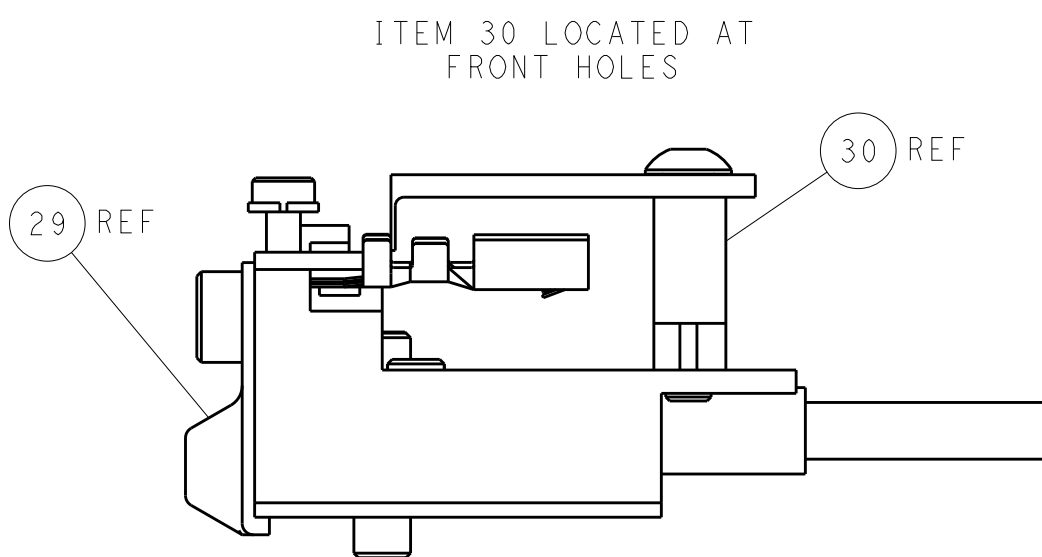
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	16OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	16OCT2013		
				APVD	16OCT2013	NAME	
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		-	
				WEIGHT		-	
				Customer Accessible Production Drawing		SCALE	
				1:2		SHEET 4 OF 4	
				REV		A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION