

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL, TYPE.

TERMINAL DATA: MTA TERMINAL MTA CRIMP SPECIFICATION. Table with columns: TE TERMINAL, MTA TERMINAL, TE TERMINAL, MTA TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT, REFERENCE SETTING.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
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: 8-2266076-5
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266076-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266076-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266076-6
ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242, FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
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.
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
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.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.30.

\*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with columns: PART NO, DESCRIPTION, ITEM NO. List of parts and their descriptions.

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

REVISIONS table with columns: REV, LTR, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: PART NO, DESCRIPTION, ITEM NO. Includes items like WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, etc.

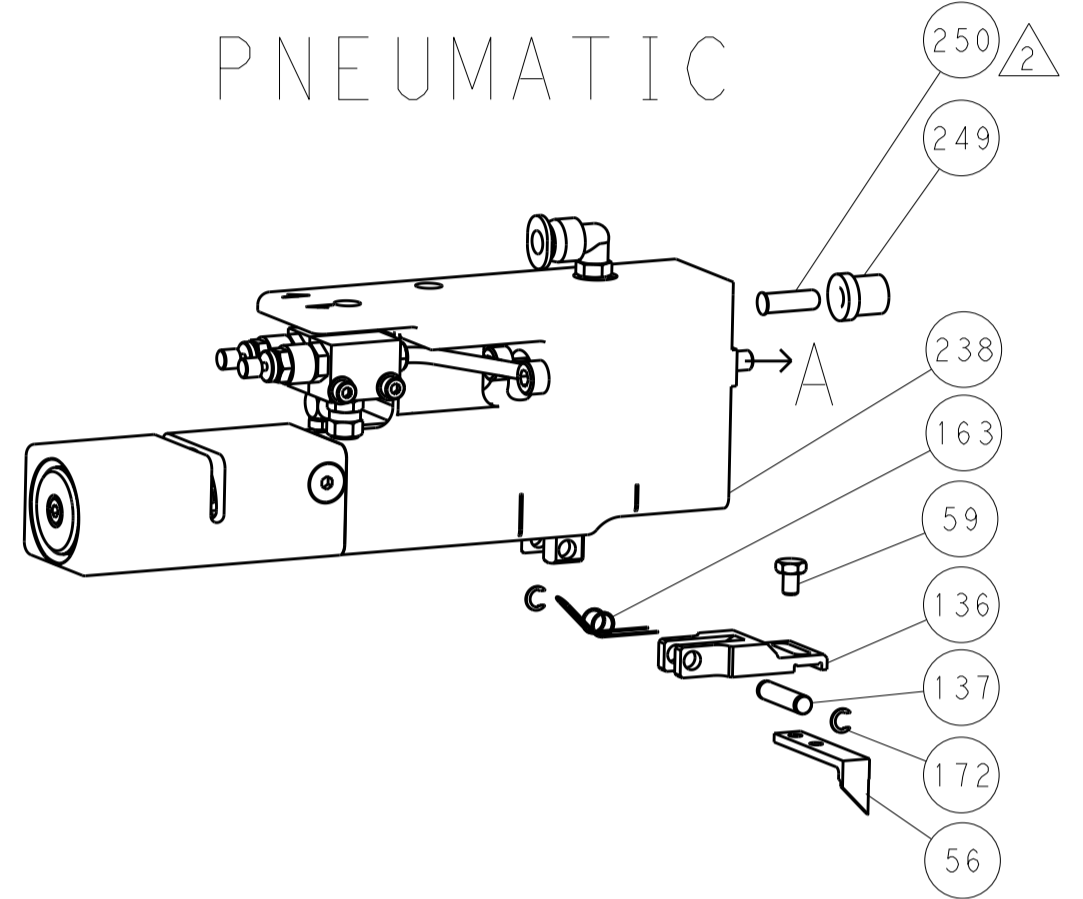
Technical drawing header including dimensions, tolerances, materials, and customer information (Ocean Side Feed Applicator).

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

### FEED TYPE MECHANICAL



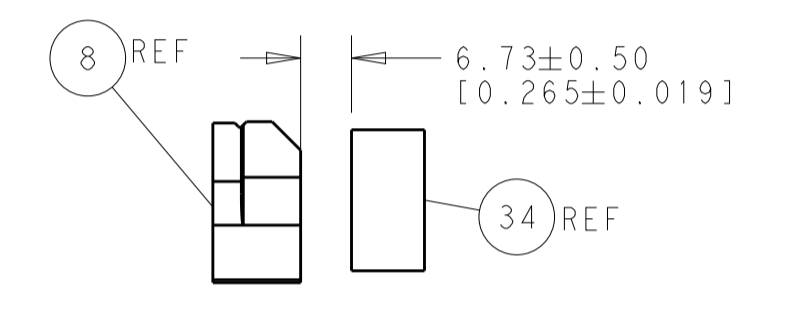
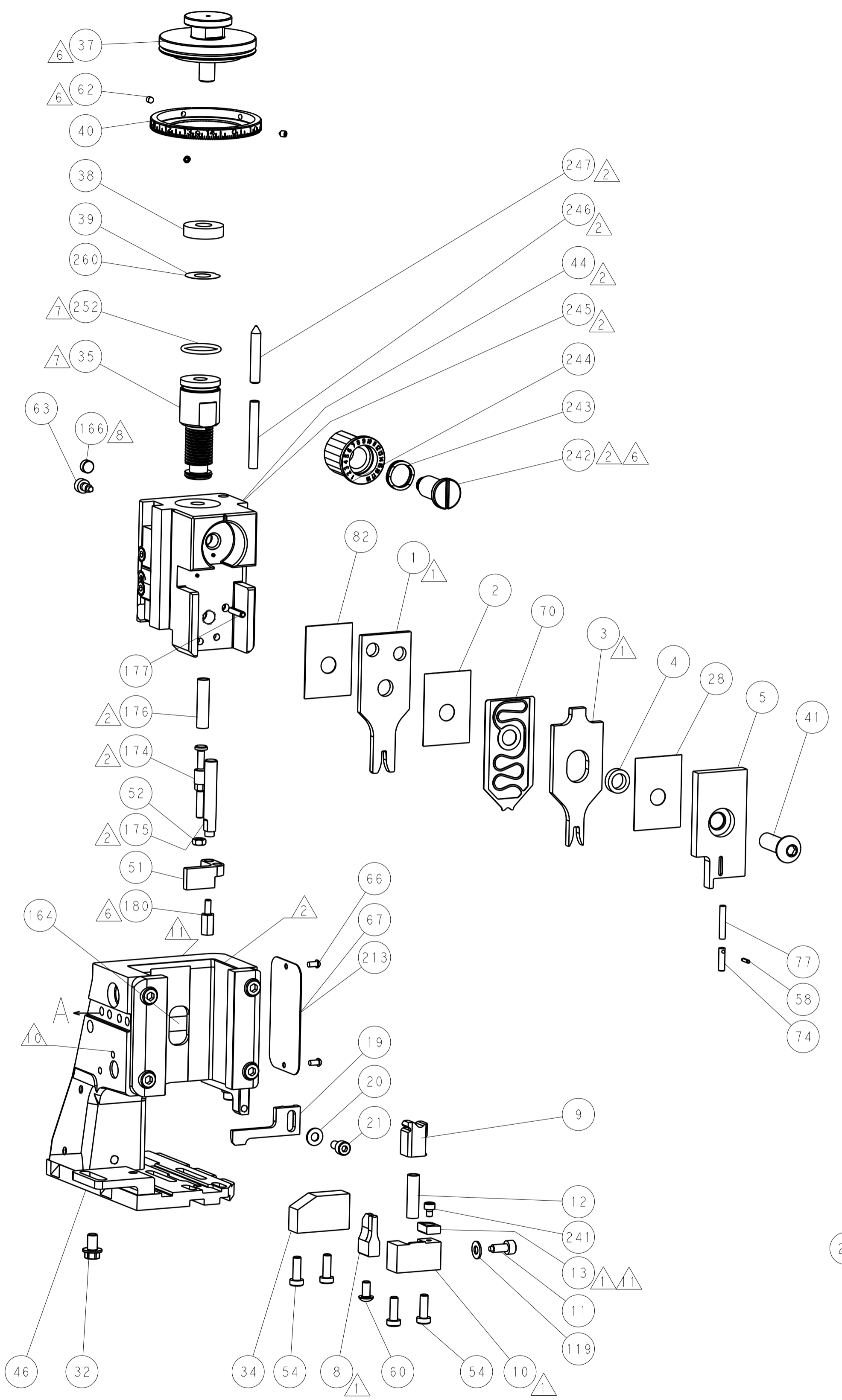
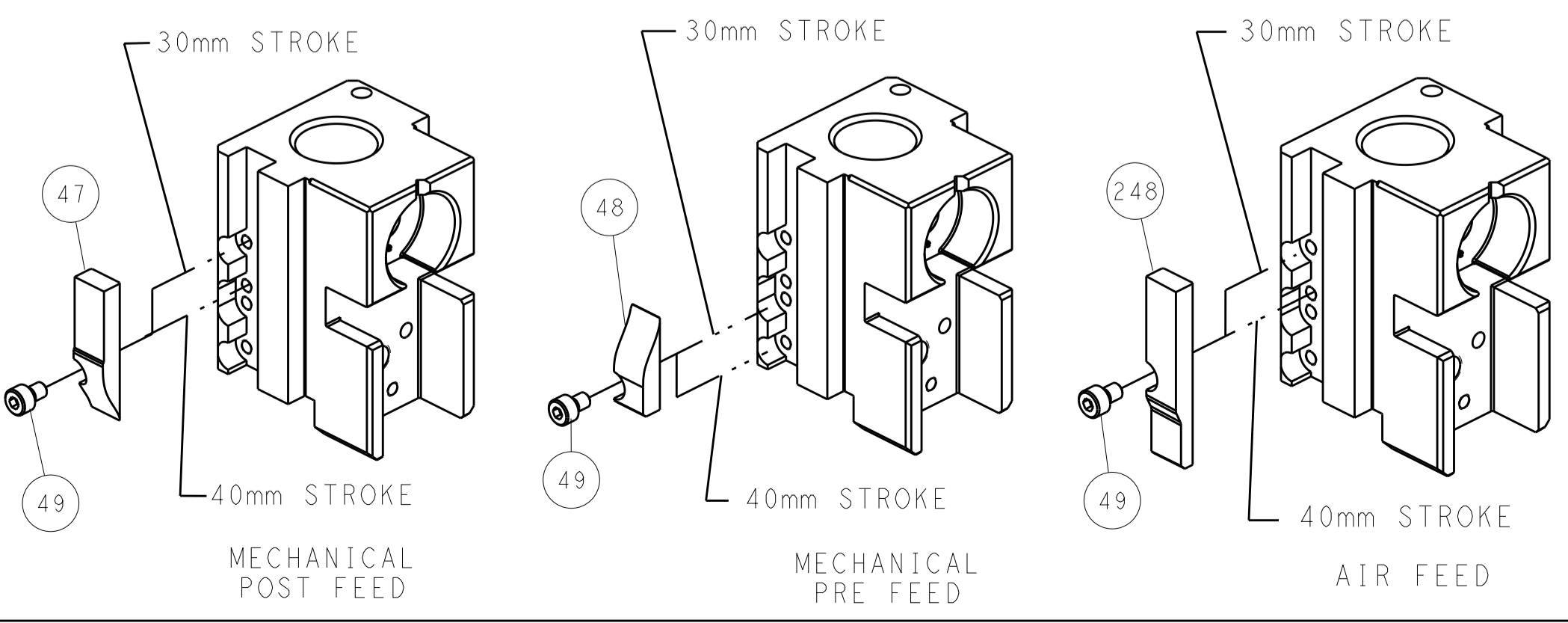
### PNEUMATIC



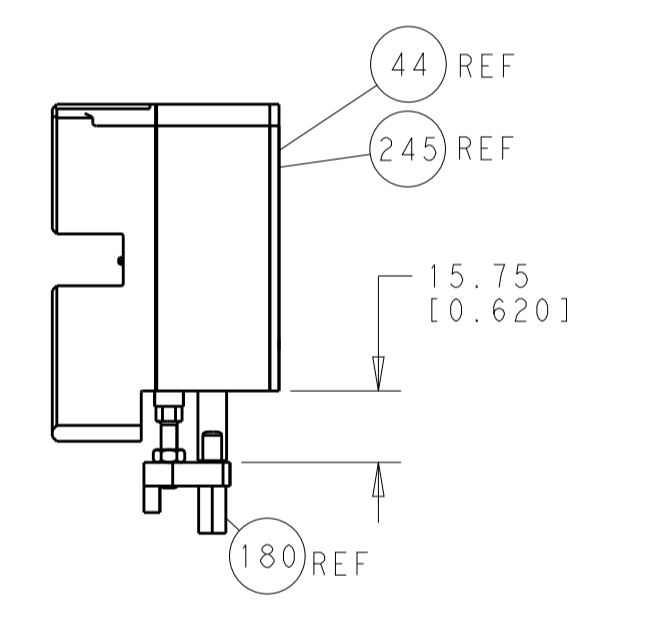
### SERVO LATCH PLATE



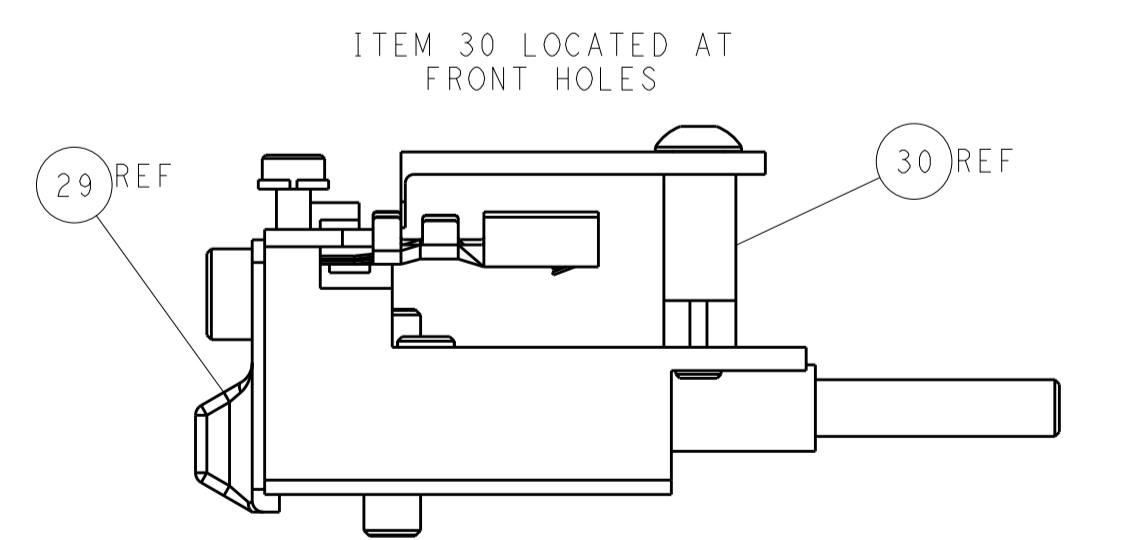
### CAM POSITIONS



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 16OCT2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD 16OCT2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 of 4		REV A	

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
					CONVERT TO	PART NUMBERS REQUIRED							
	2-2266076-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		
	2-2266076-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	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	-	-		
	2-2266076-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	-	8-2266076-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2266076-4	-	-	-		
2-2266076-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-		
7-2266076-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-		

CRIMP	SIZE	TYPE
WIRE	2.40 mm [ .094 ]	F
INSUL	3.20 mm [ 1.26 ]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.40 mm [ .157-.173 IN ]		Ø1.96-2.67 mm [ .077-.105 IN ]	
TERMINAL APPLICATION SPECIFICATION	BO-018.009B Rev 7	-	-
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2113384-1	1708331		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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.
- 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.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

	ITEM NO	DESCRIPTION	ITEM NO
- 1 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	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
-77 -27 -25 -22 -21	PART NO	DESCRIPTION	ITEM NO

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	REV	DATE	BY	APPV
-	-	-	-	SEE SHEET 1	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
- 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 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
- 1 1 1 1 1	2-1752354-6			STANDOFF, HOLD-DOWN	180
- 1 1 1 1 1	6-993111-6			PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1 1 1	8-22280-7			SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2			GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2			GUIDE PIN, HOLDDOWN	174
- - - 2 - -	21045-3			RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1 1 1	994969-1			MAGNET, RARE EARTH HIGH ENERGY	166
- REF REF REF REF	994970-2			COUNTER, MAGNETIC	164
- - - 1 - -	240638-1			SPRING, FEED FINGER	163
- 1 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 1	2119798-2			DETENT PIN	145
- 1 1 1 1 1	2079383-8			SCR, BHSC, RoHS (M4 X 16)	144
- 4 4 4 4 4	2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20	143
- - - - 1 1	2119653-2			FEED CAM, POST FEED	142
- 1 1 1 1 1	1-2119656-0			APPLICATOR BASIC ASSEMBLY, SF	141
- 1 1 1 1 1	2119650-1			RAM, ASIAN STYLE, SIDE FEED	140
- 1 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	1-18028-2			WASHER, FLAT, REG M4	119
- - REF - -	2119944-1			FEED FINGER ASSEMBLY, SF	117
- 1 1 1 1 1	455888-5			SPACER, CRIMPER	82
- 1 1 1 1 1	22278-8			SPRING, COMPRESSION	77
- 1 1 1 1 1	854769-4			HOLDER, INS	74
- 1 1 1 1 1	2119956-1			DOCUMENTATION PACKAGE	71
- 1 1 1 1 1	2119791-9			DEPRESSOR, WIRE	70
- 1 - 1 1 1	2119740-1			TAG, IDENTIFICATION	67
- 2 2 2 2 2	2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1 1 1	2119793-1			LIMITER, ADJUSTMENT BOLT	63
- 3 3 3 3 3	992763-5			SCR, SET, SOC, CONE POINT, M3 X 4.0	62
- - - 1 1 1	5-18022-5			SCR, HEX HD CAP, M4 X 6.0	59
- 1 1 1 1 1	21028-2			PIN, SLOTTED SPRING .062 X .250	58
- - - 1 1 1	1338685-1			PAWL, FEED	56
- 1 1 1 1 1	1-5018030-0			NUT, HEX, REG, RoHS, M3.5	52
- 1 1 1 1 1	1901681-1			HOLDDOWN, TERMINAL	51
- - - 1 2	18023-9			SCR, SKT HD CAP M4 X 6.0	49
- - - - 1	2119652-1			FEED CAM, PRE FEED	48
- 1 1 1 1 1	2079383-7			SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1 1	2119645-1			DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1 1	2119957-1			APPLICATOR SHIM PACK	39
- 1 1 1 1 1	1-2119644-2			RAM WASHER, PRECISION	38
- 1 1 1 1 1	1-1752356-3			SUPPORT, TERMINAL	34
- 2 2 2 2 2	2079383-5			SCR, BHSC, RoHS (M4 X 20)	33
- 1 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 1	2119959-1			ASSEMBLY, STRIP GUIDE	29
- 1 1 1 1 1	455888-3			SPACER, CRIMPER	28
- 1 1 1 1 1	1320928-2			STRIP GUIDE	24
- 1 1 1 1 1	2168083-2			SCR, SKT HD CAP, RoHS, M4 X 8.0	21
- 1 1 1 1 1	1-18028-2			WASHER, FLAT, REG M4	20
- 1 1 1 1 1	2119533-1			STRIPPER, SIDE FEED	19
- 1 1 1 1 1	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 1 1 1 1	1803056-6			ANVIL, COMBINATION	8
- - - - -	-			-	7
- - - - -	-			-	6
- 1 1 1 1 1	2119780-9			DEPRESSOR, SHEAR	5
- 1 1 1 1 1	3-238011-1			BLOCK, CRIMPER SPACER	4
- 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	3-1490019-3			CRIMPER, WIRE PREMIUM	1
-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)

<p>THE DIMENSIONS TO BE SHOWN TO CONFORM TO THE DIMENSIONS SPECIFIED IN THIS DRAWING UNLESS OTHERWISE SPECIFIED.</p>	<p>CHK L. HUANG 16OCT2013 L. ZHANG 16OCT2013 APVD H. GUO 16OCT2013</p>	<p>NAME Ocean Side Feed Applicator</p>
<p>DIMENSIONS: mm</p> <p>TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.05 1 PLC ±.05 3 PLC ±.13 5 PLC ±.13 4 PLC ±.0001 ANGLES</p>	<p>PRODUCT SPEC APPLICATION SPEC</p>	<p>SIZE CASE CODE DRAWING NO A1 00779 C-2266076</p>
<p>MATERIAL FINISH</p>	<p>RESTRICTED TO Customer Accessible Production Drawing</p>	<p>SCALE 1:2 SHEET 3 OF 4 REV A</p>

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE MECHANICAL



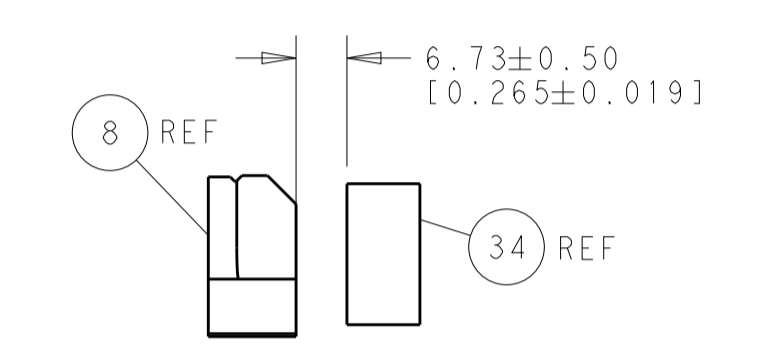
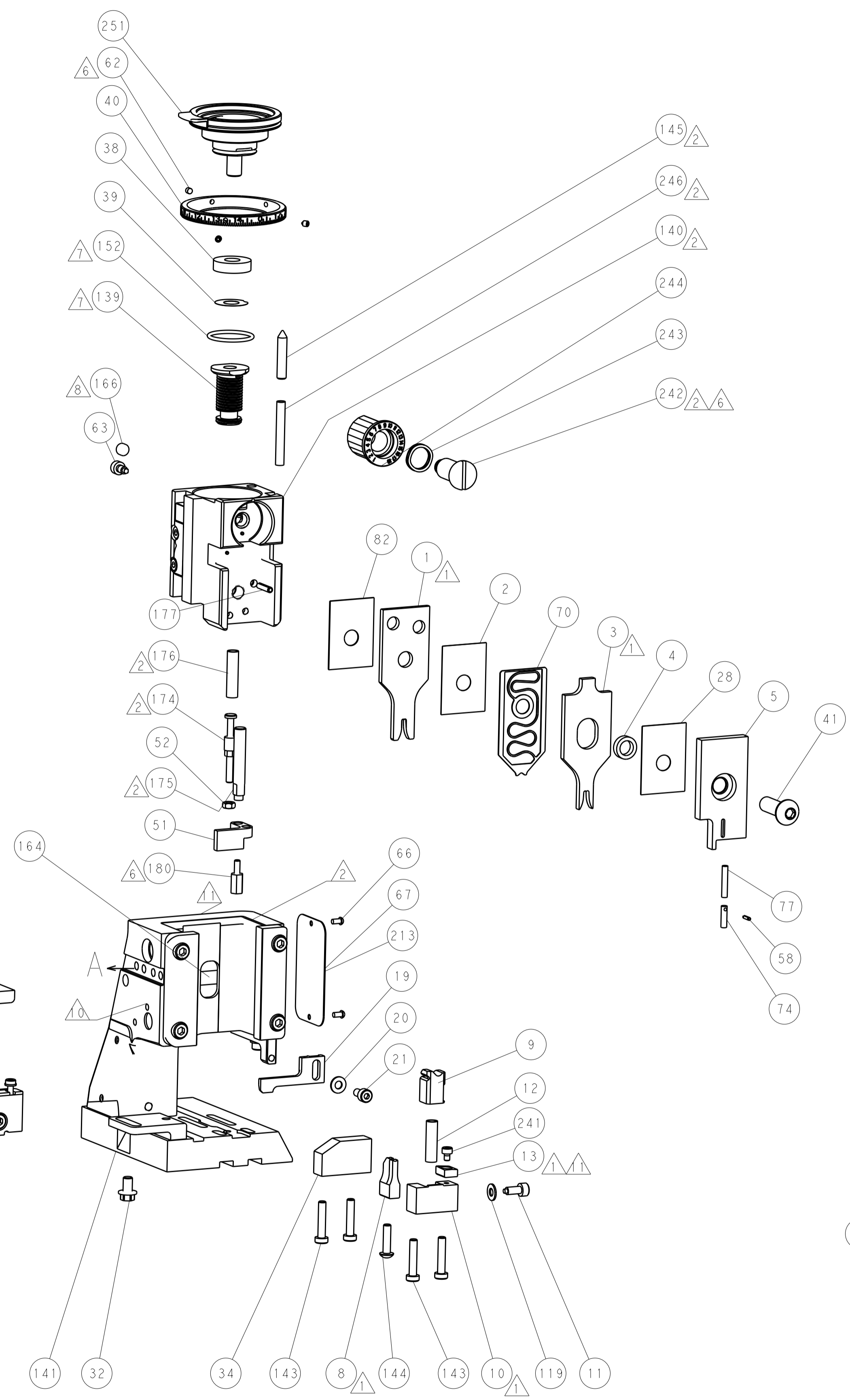
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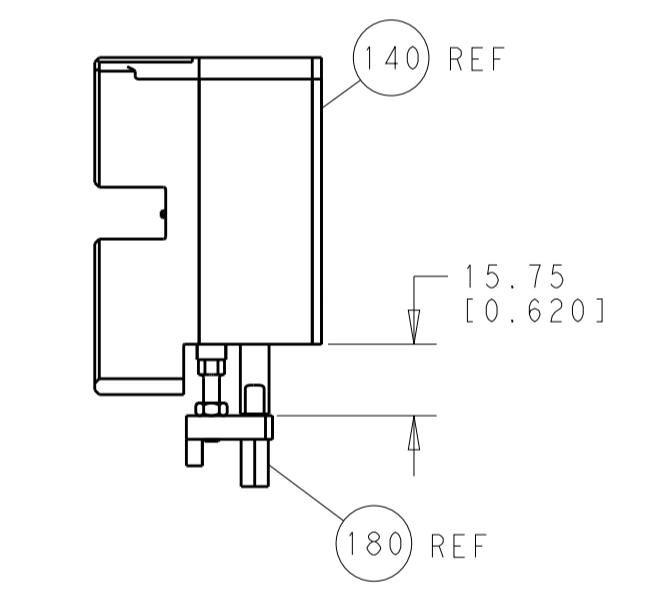
# SERVO LATCH PLATE



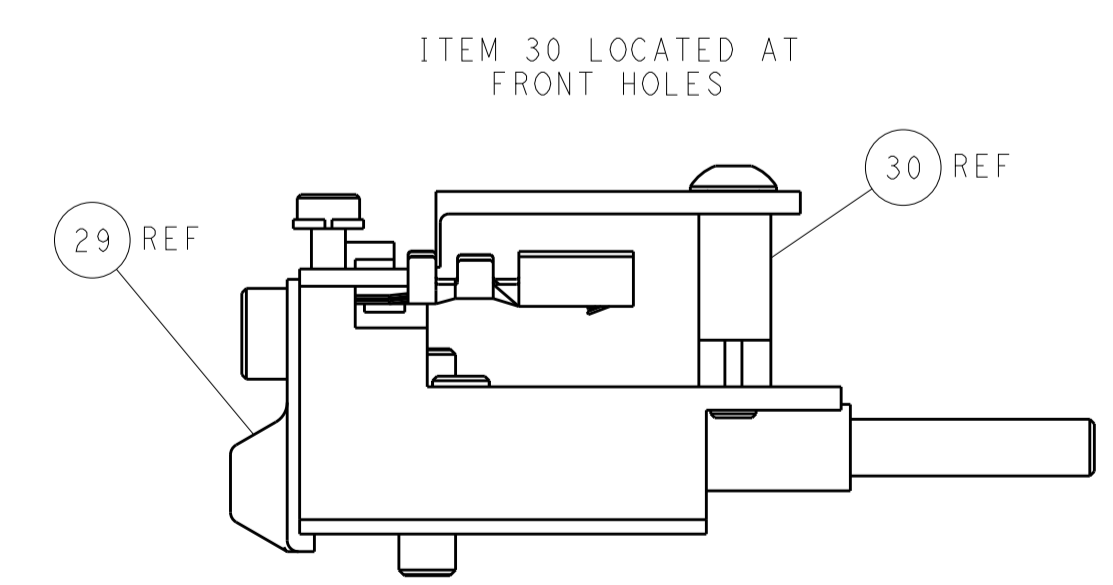
# CAM POSITIONS



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)

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:
MATERIAL:	FINISH:	A1 00779 ©=2266076 Customer Accessible Production Drawing	SCALE: 1:2 SHEET 4 OF 4 REV A