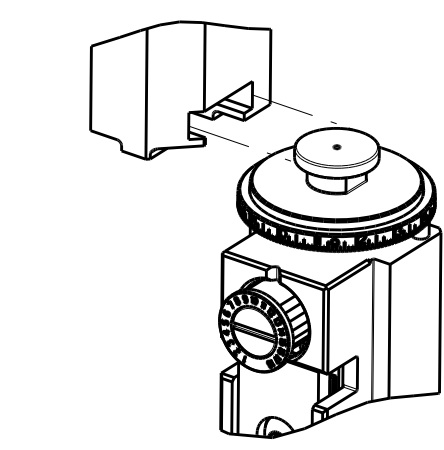


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266076-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266076-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266076-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266076-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266076-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.20 mm [.126]	F

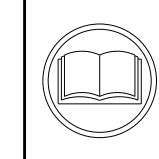
APPLICATOR INSTRUCTIONS
408-35042

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	B0-018.009B Rev 7		
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2113384-1	1708331		

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			
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

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2	1.35+/-0.05 [.053+/- .002]	6.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.

***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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	16OCT2013	KH	UG
		A		RELEASED	18NOV2013	BH	TE
		A1		ECR-18-013027	16AUG2018	MZ	GB
		B		ECR-19-008666	01JUN2019	TB	CT

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	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	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	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	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	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	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1803056-6	ANVIL, COMBINATION	8	
-	1	1	1	1	240641-1	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	7-1633961-0	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	3-1490019-3	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH				1:2	1	OF	4	B

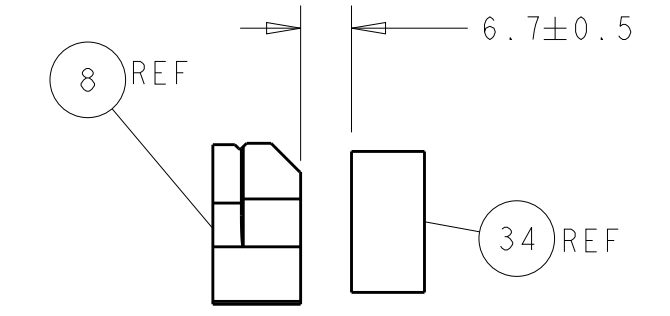
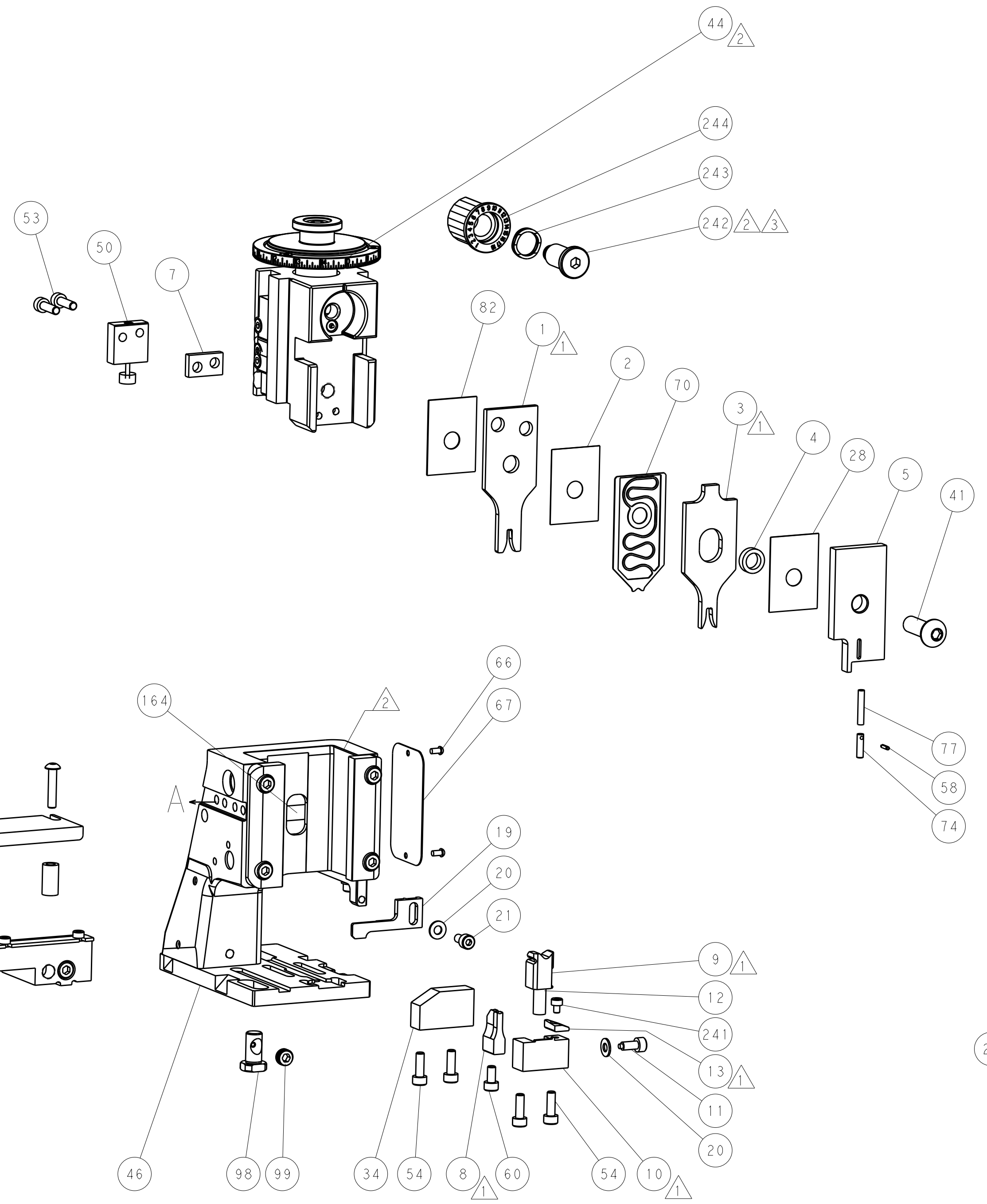
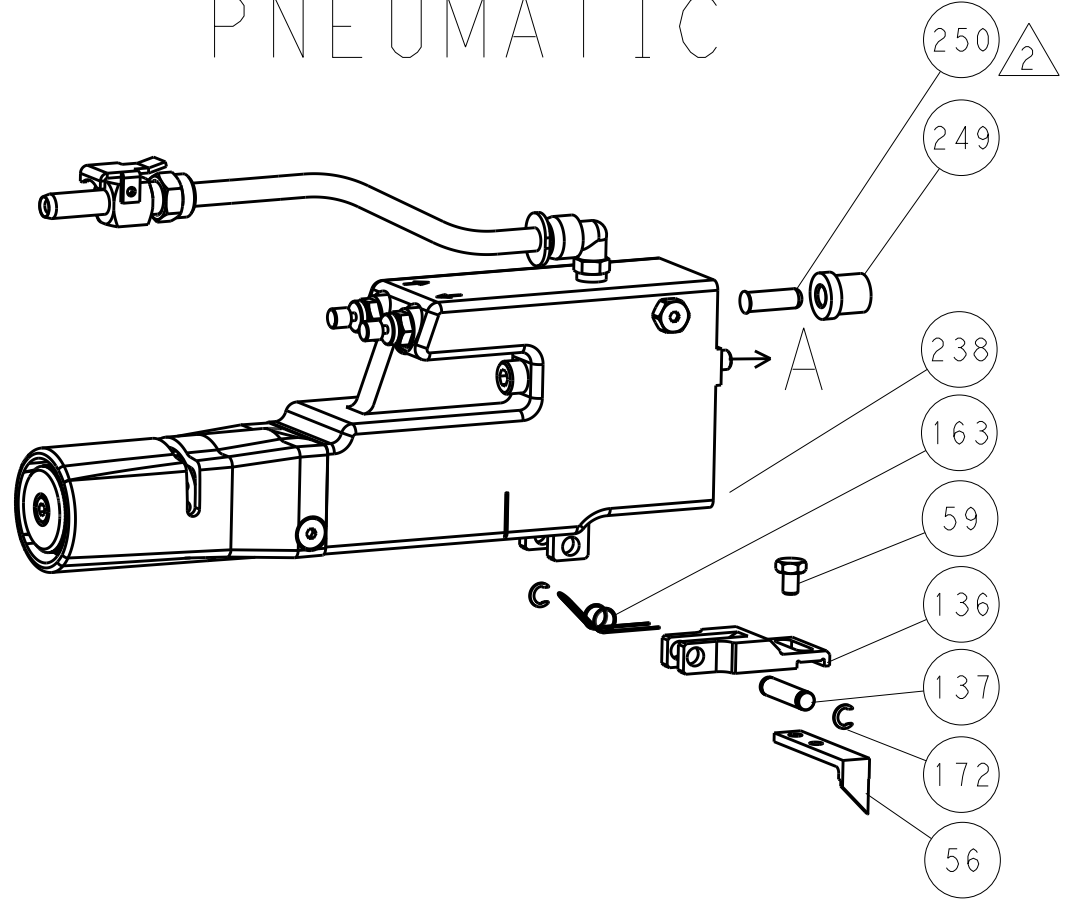
Customer Accessible Production Drawing

LOC		DIST		REVISIONS			
REV	DATE	BY	CHK	DESCRIPTION	DATE	DWN	APVD
A	66			SEE SHEET 1			

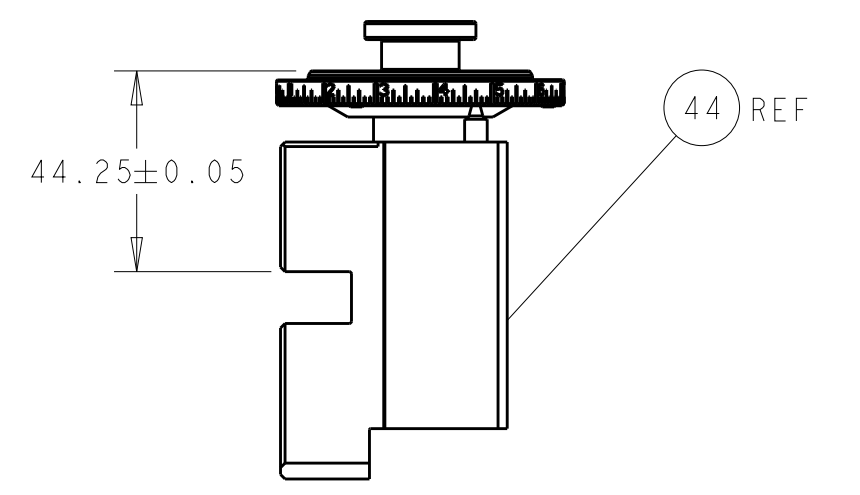
FEED TYPE MECHANICAL



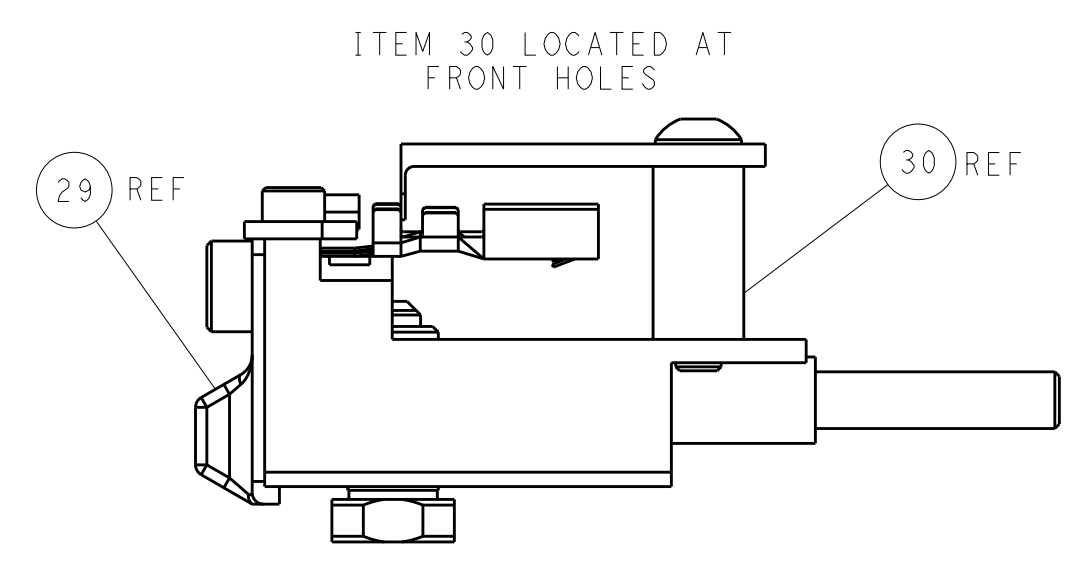
PNEUMATIC



TERMINAL SUPPORT LOCATION

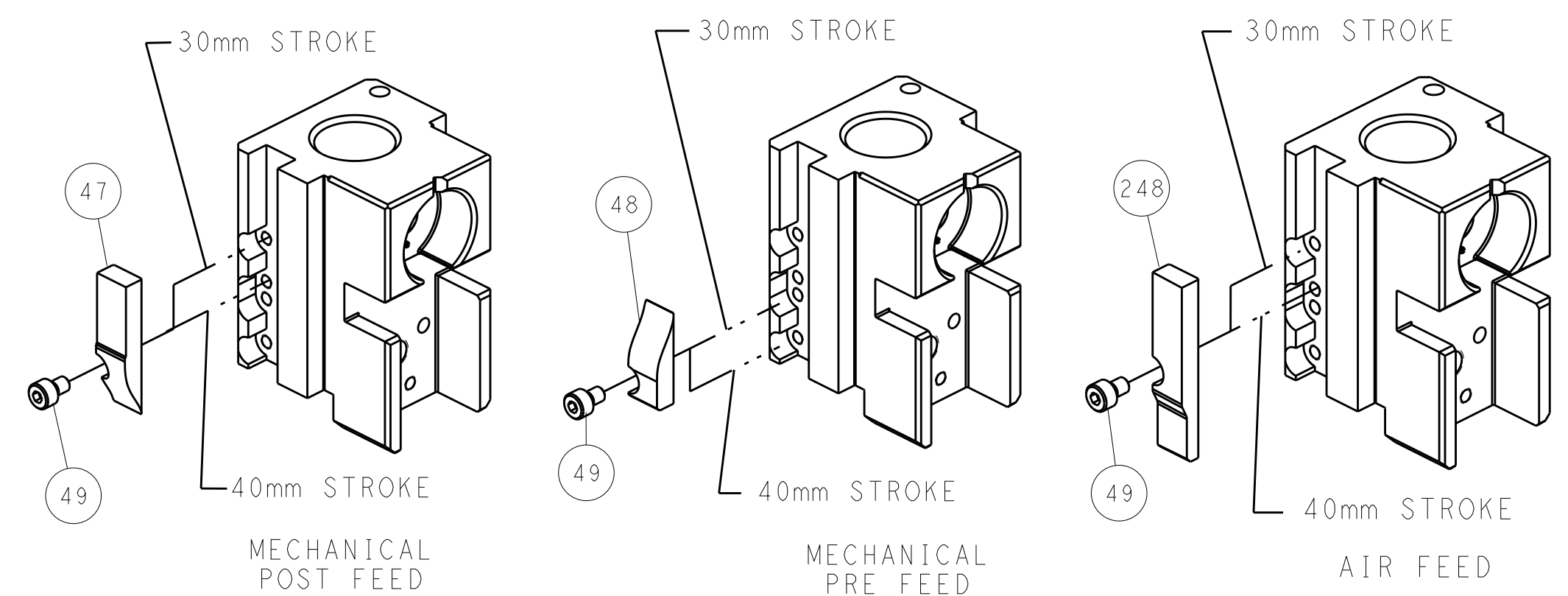


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

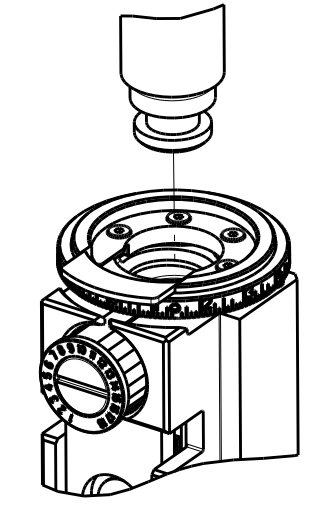


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. HUANG 16OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	CHK: L. ZHANG 16OCT2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: H. GUO 16OCT2013		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 2 of 4		REV: B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266076-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266076-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266076-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.20 mm [.126]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MTA TERMINAL MTA CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.40 mm [1.57-.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		

TERMINAL DATA: MTA TERMINAL MTA CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.40 mm [1.57-.173 IN]	Ø1.96-2.67 mm [.077-.105 IN]		
TERMINAL APPLICATION SPECIFICATION			
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 [1.059+/-0.002]	5.6
2.00mm2	1.50+/-0.05 [1.059+/-0.002]	5.9
1.50mm2	1.40+/-0.05 [1.055+/-0.002]	6.6
0.75+0.75 mm2	1.40+/-0.05 [1.055+/-0.002]	6.6
1.00mm2	1.30+/-0.05 [1.051+/-0.002]	7.6
0.5+0.5 mm2	1.30+/-0.05 [1.051+/-0.002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2	1.35+/-0.05 [1.053+/-0.002]	6.7

- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
△	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
△	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△	1	1	1803095-6	FLOATING SHEAR, FRONT	9
△	1	1	1803056-6	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
△	1	1	7-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
△	1	1	3-1490019-3	CRIMPER, WIRE PREMIUM	1

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

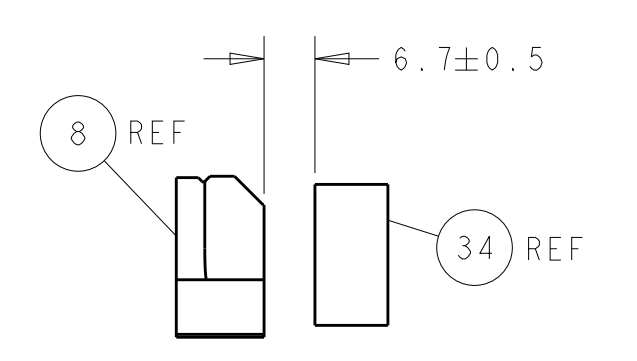
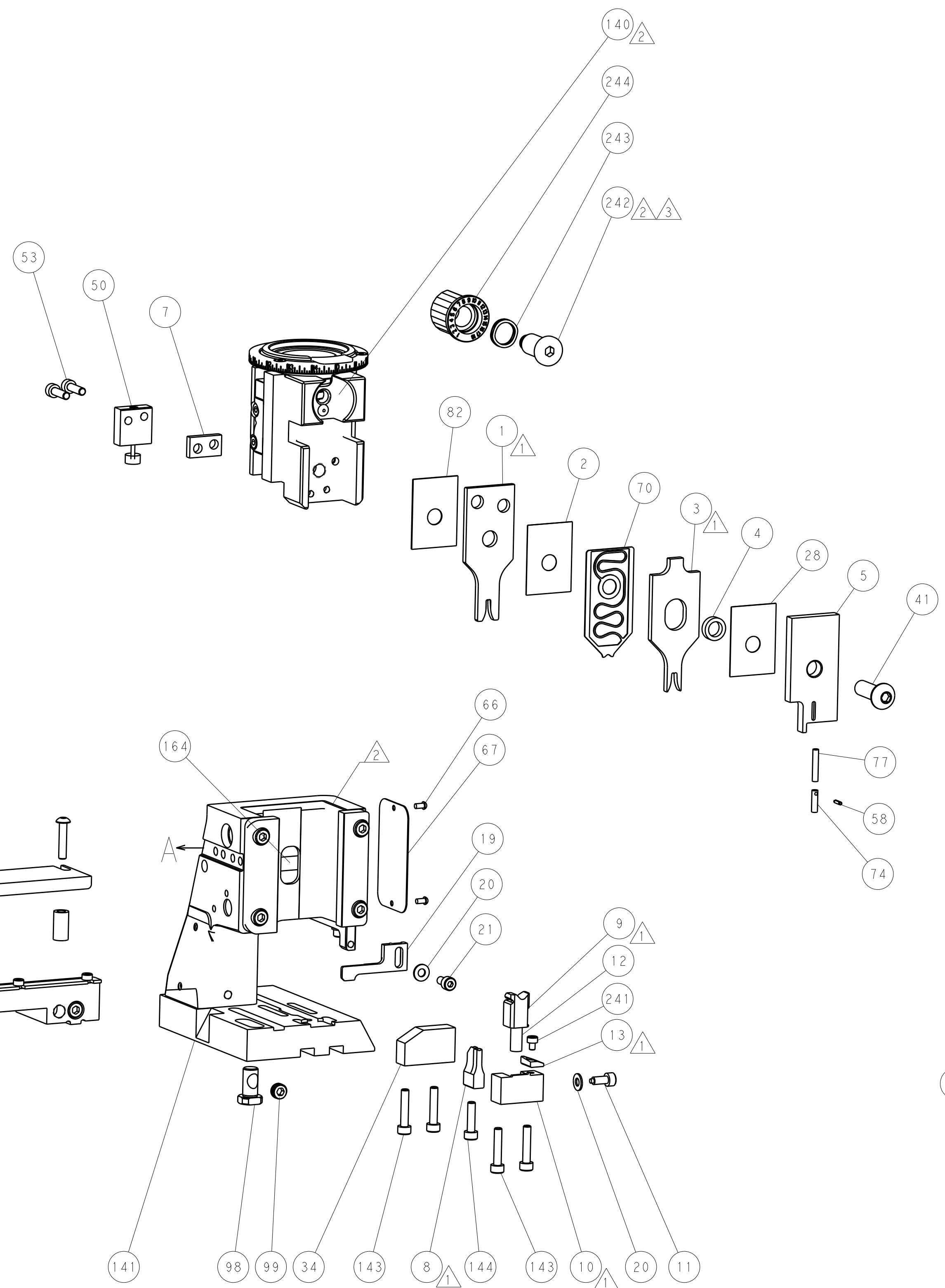
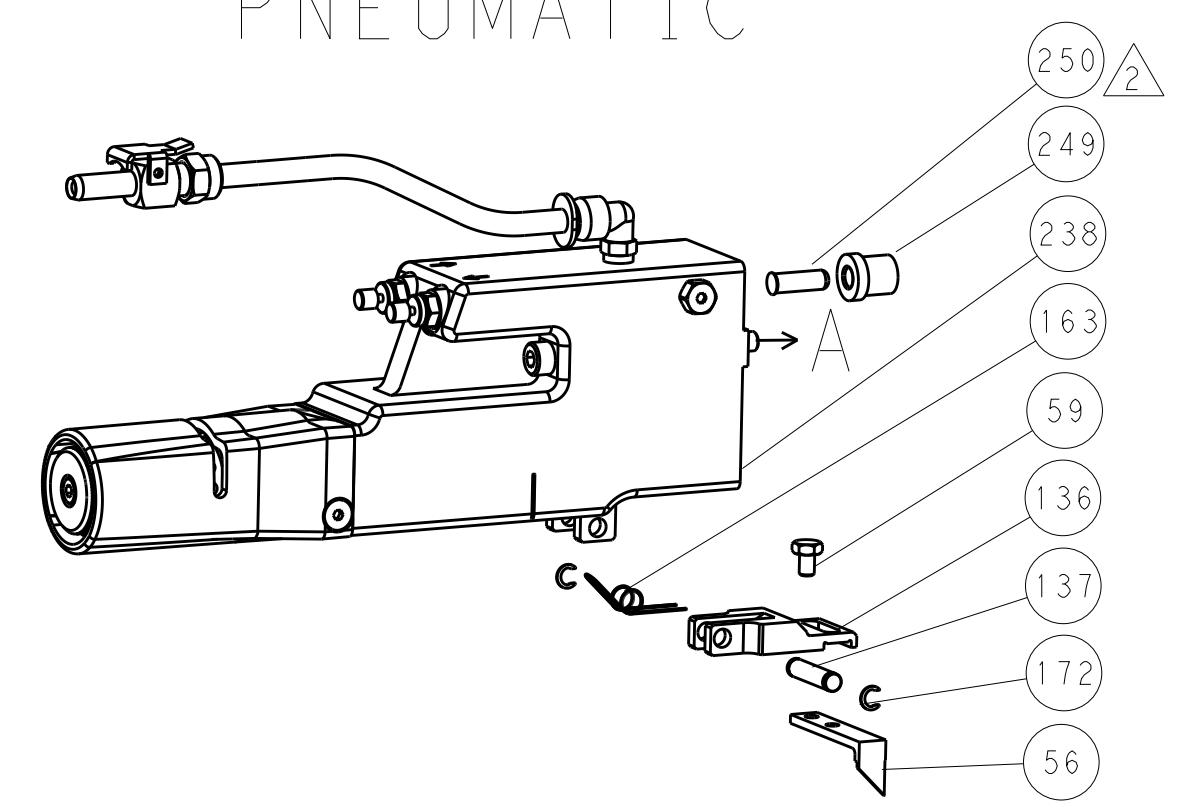
DRW	H. HUANG	16OCT2013	CHK	L. ZHANG	16OCT2013	APVD	J. GUO	16OCT2013
NAME	Ocean Side Feed Applicator							
SIZE	A1	CAGE CODE	00779	DRAWING NO	2266076	RESTRICTED TO		
SCALE	1:2	SHEET	3	OF	4	REV	B	

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

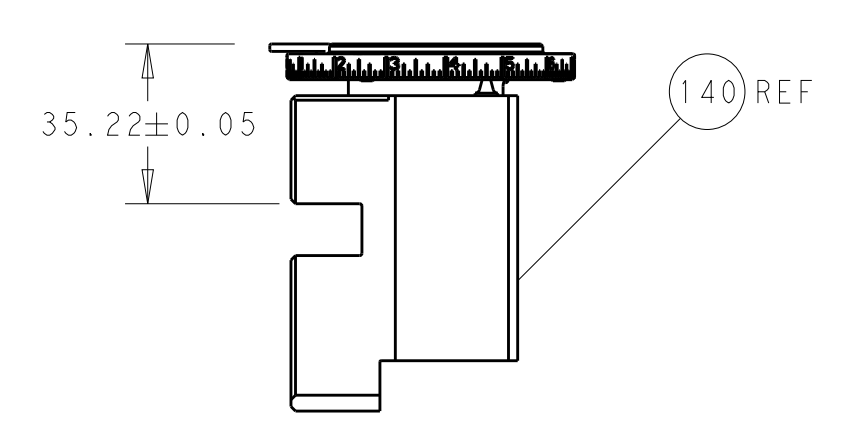
FEED TYPE MECHANICAL



PNEUMATIC

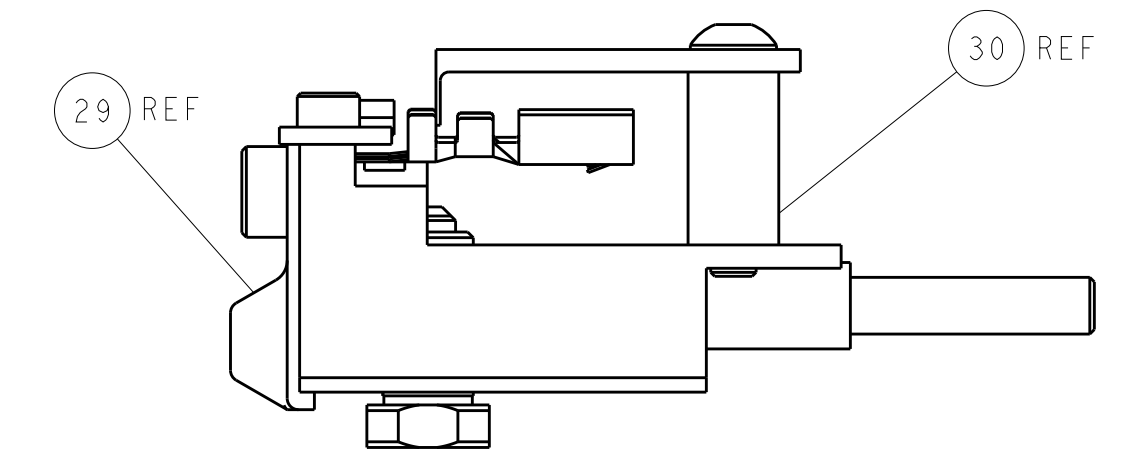


TERMINAL SUPPORT LOCATION



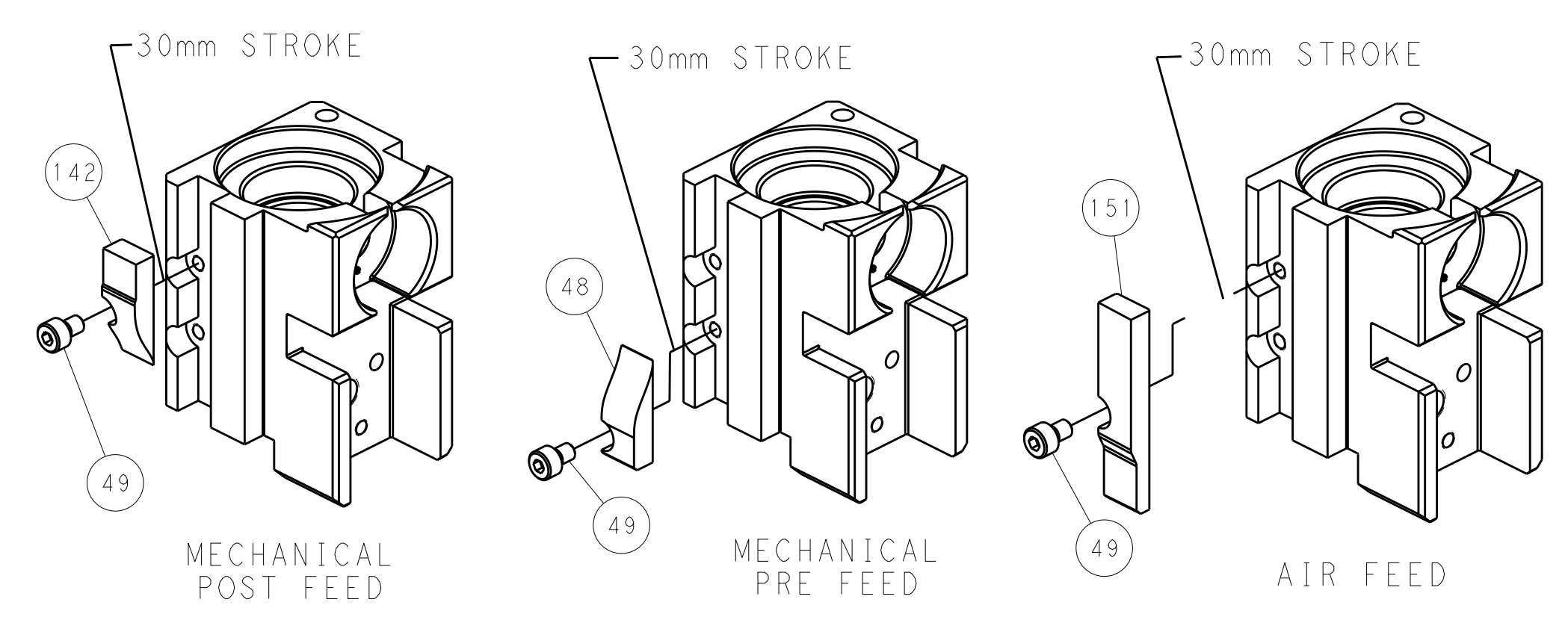
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 16OCT2013		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: L. ZHANG 16OCT2013		NAME: Ocean Side Feed Applicator	
				APVD: H. GUO 16OCT2013		SIZE: CAGE CODE: DRAWING NO: A1 00779 C=2266076	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV B	