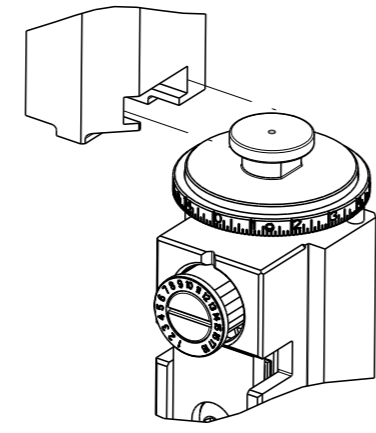


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266290-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266290-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266290-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266290-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266290-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.55 mm [.061]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: 025 FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	2009.01.12 Rev		
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2286185-1	ST731053-3	2113461-1	ST731053-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	1.00+/-0.03 [.039+/-0.001]	8.2
22 AWG OR 0.30mm ²	0.95+/-0.03 [.037+/-0.001]	8.4

- 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.

***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)

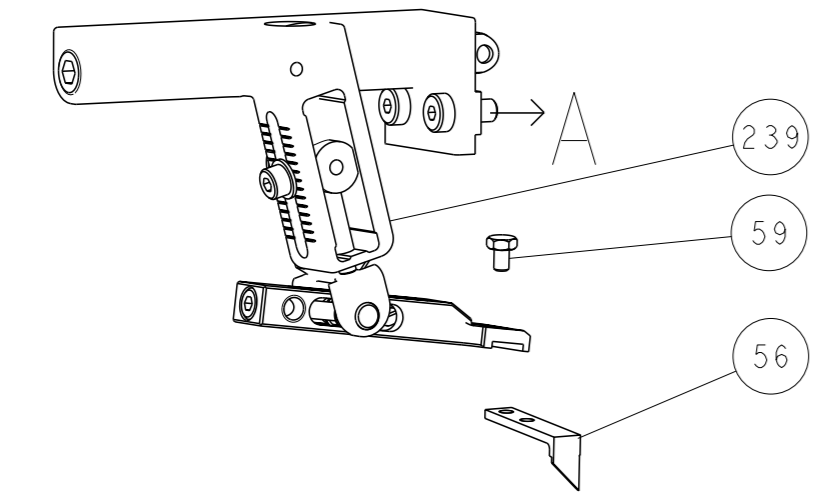
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		B		ECR-18-010714	06JUL2018	VLA	CT

-	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	2119082-4	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	1803607-1	DOCUMENTATION PACKAGE	71	
-	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	6-1633932-0	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-6	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	7-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	6-1633664-3	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

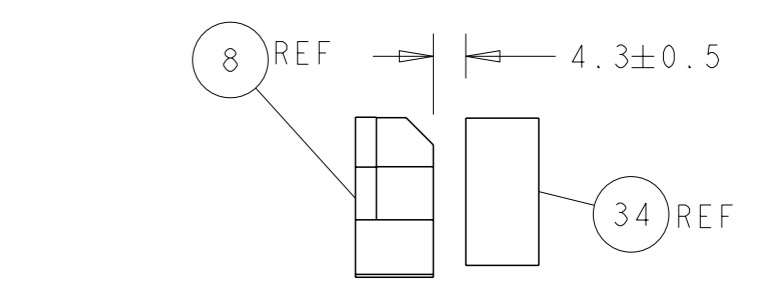
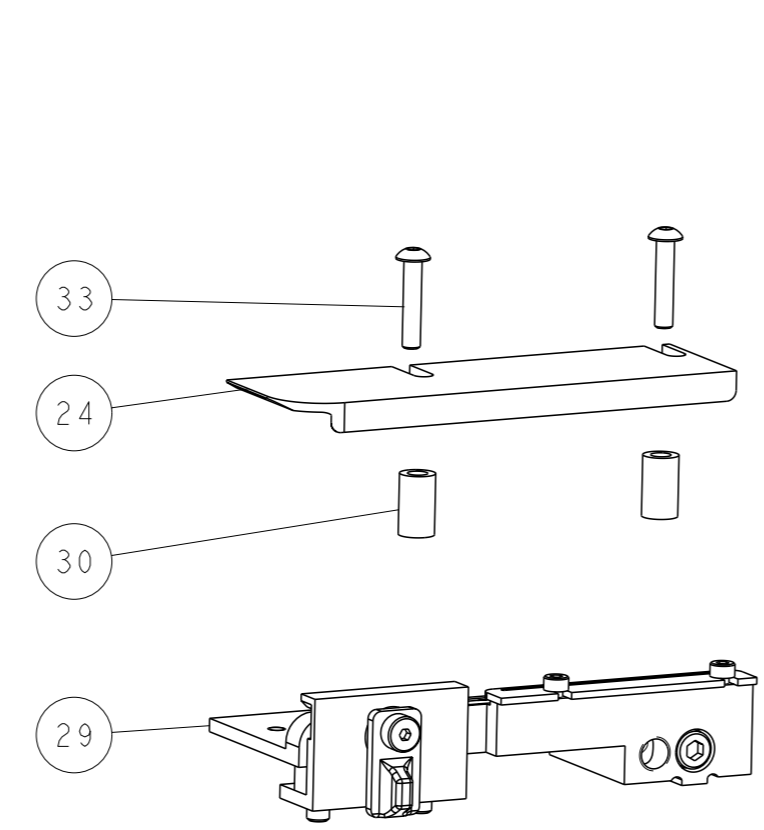
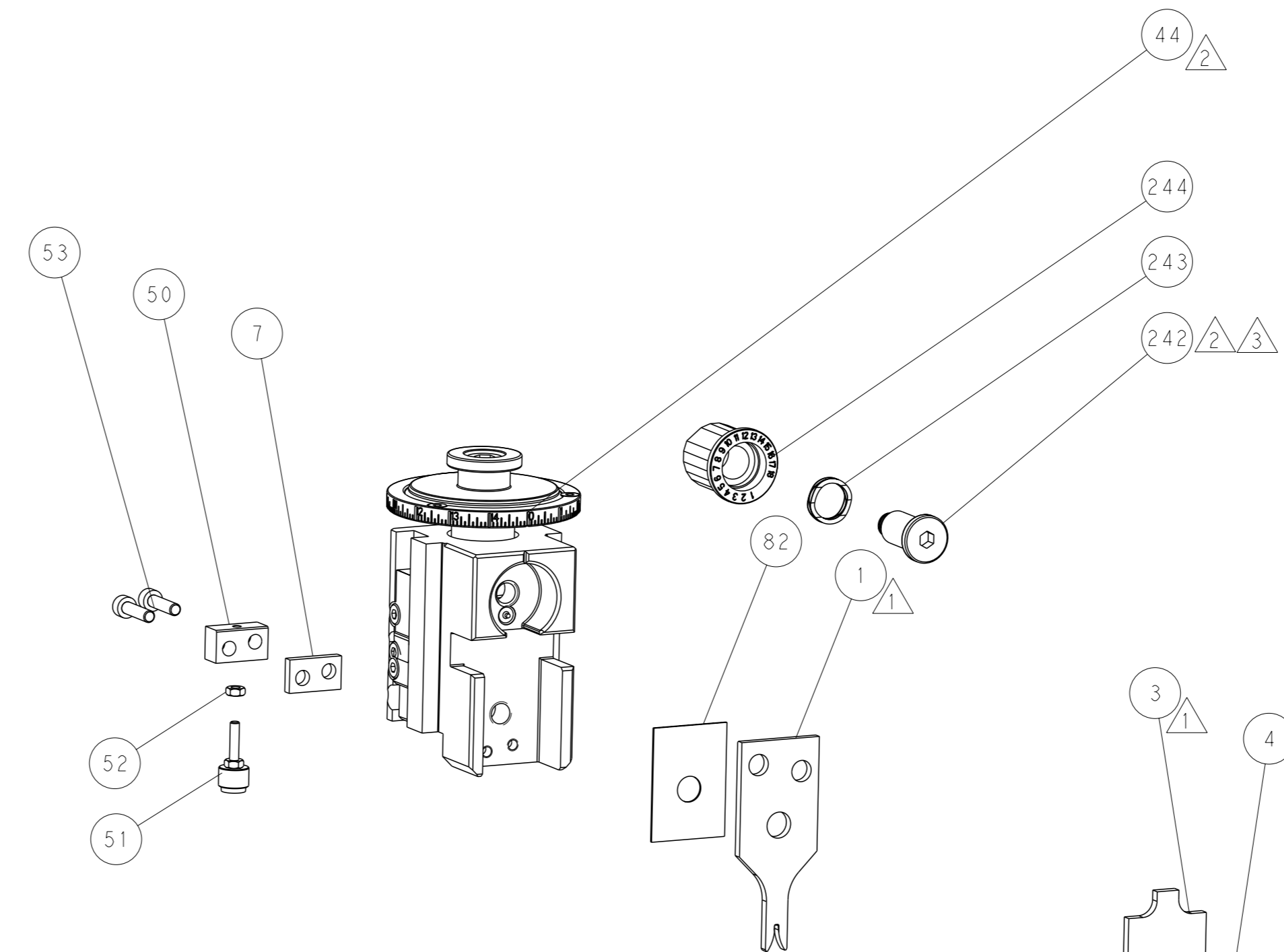
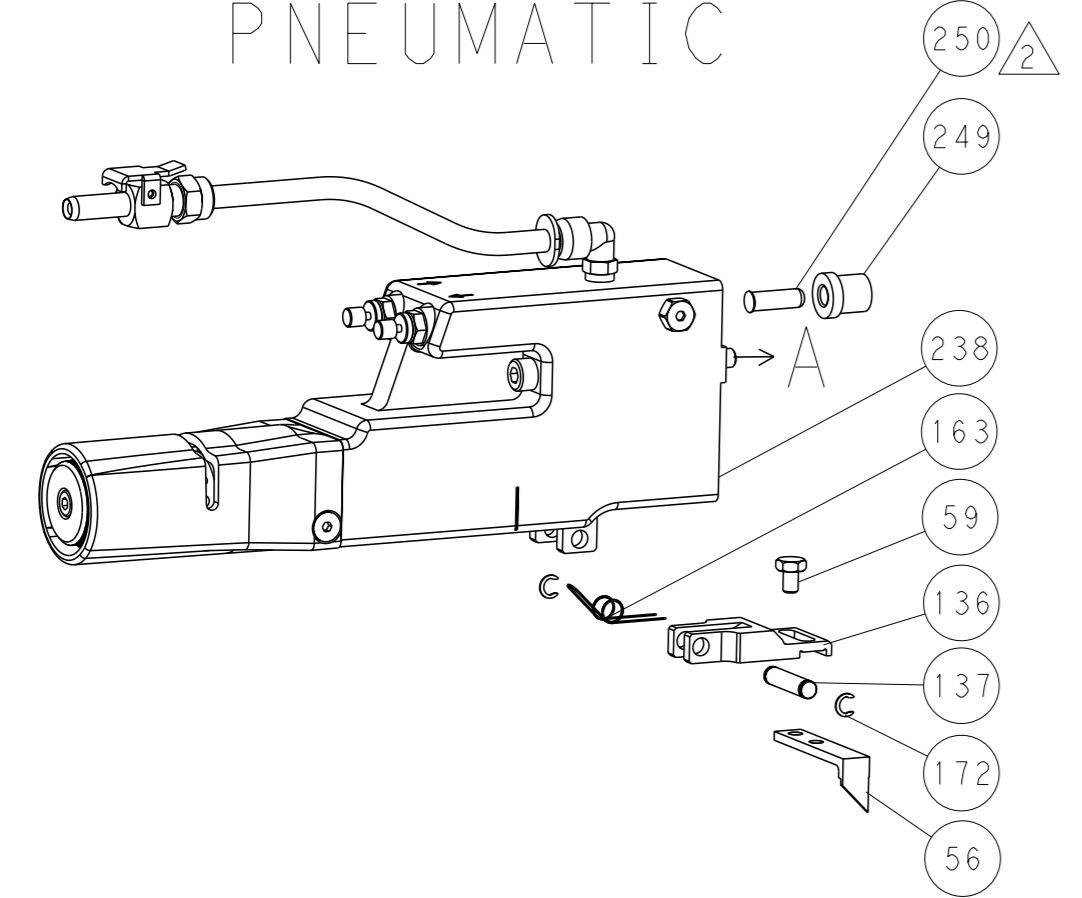
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL		FINISH		WEIGHT		SCALE	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4		REV B	

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

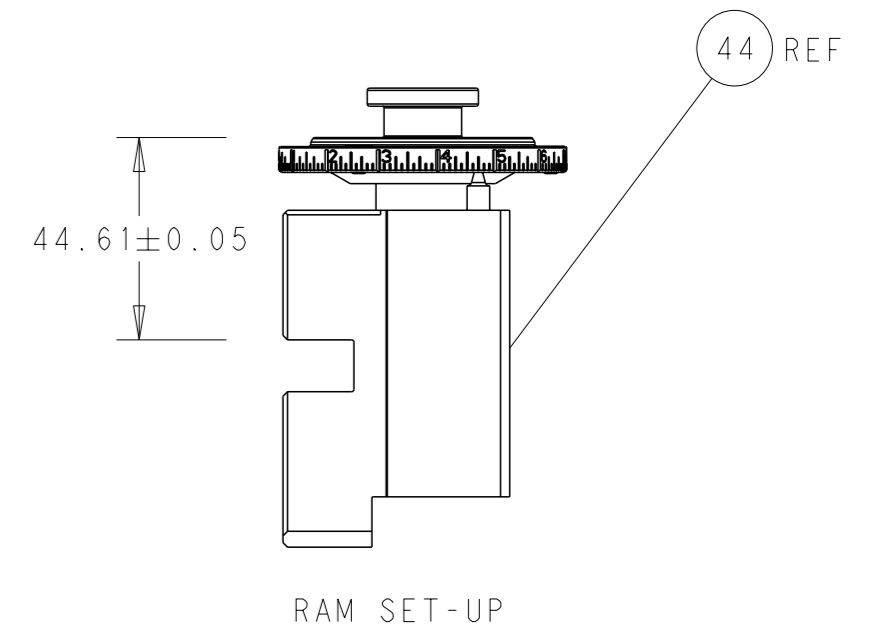
FEED TYPE MECHANICAL



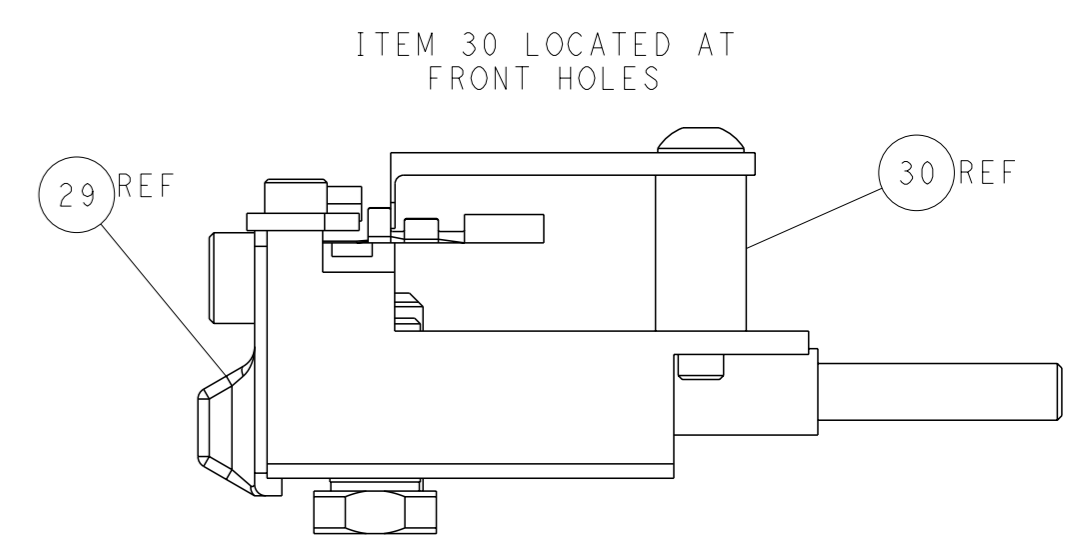
PNEUMATIC



TERMINAL SUPPORT LOCATION

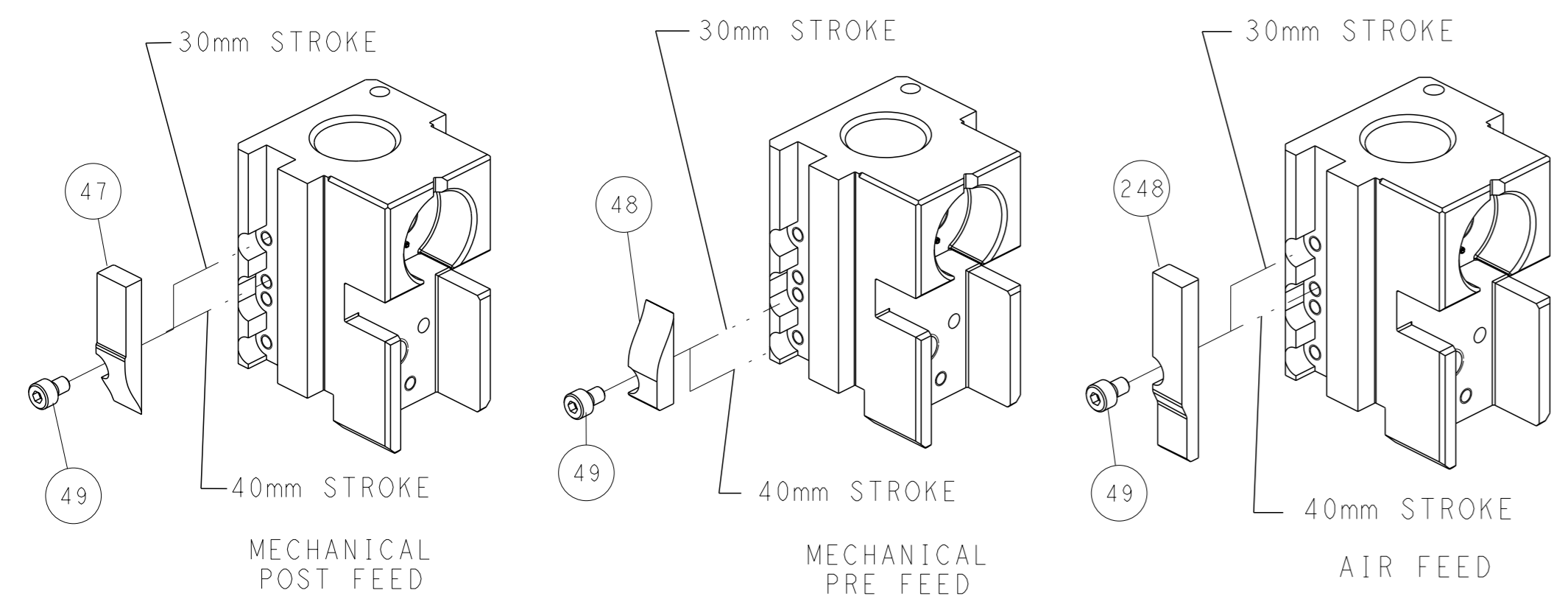


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

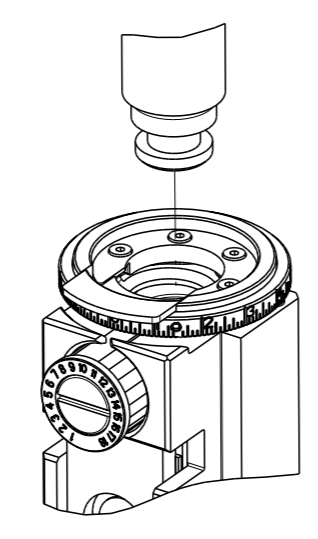


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 02JUN2014 CHK: G. BAILEY 02JUN2014 APVD: D. STOUGH 02JUN2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266290	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL:	WEIGHT:	RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 2 of 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266290-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266290-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266290-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.55 mm [.061]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: KET TERMINAL KET CRIMP SPECIFICATION

TERMINAL NAME: 025 FEMALE TERMINAL

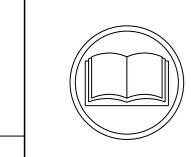
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.50-4.50 mm [1.38-.177 IN]	Ø1.40-1.70 mm [.055-.067 IN]

TERMINAL APPLICATION SPECIFICATION 2009.01.12 Rev -

TERMINALS APPLIED

TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2286185-1	ST731053-3	2113461-1	ST731053-G

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.00 +/- 0.03 [.039 +/- .001]	8.2
22 AWG OR 0.30mm2	0.95 +/- 0.03 [.037 +/- .001]	8.4



- 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.

***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.

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

LOC	DIST	REV	DATE	BY	APPV
A	66				

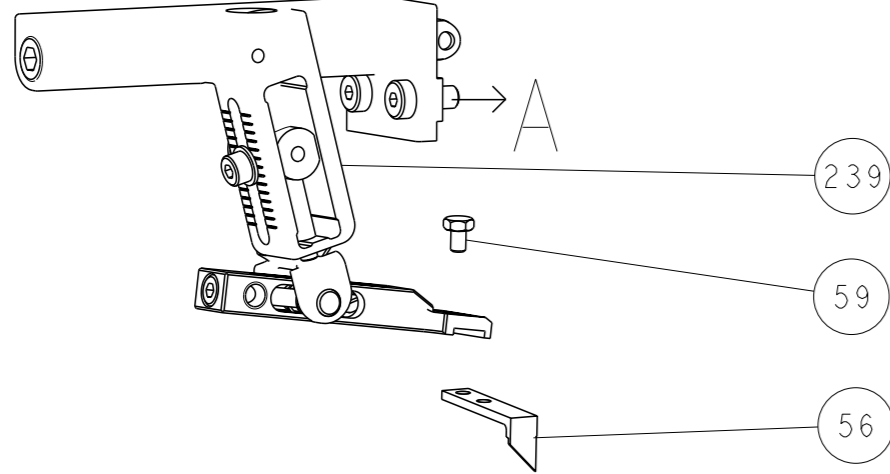
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	-		2119640-1	PUSH ROD, AIR FEED	250
-	1	-		1803259-1	BUSHING, FLANGED	249
-	1	1		2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1	RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7	SCR, SKT 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		1803607-1	DOCUMENTATION PACKAGE	71
-	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		1338685-1	PAWL, FEED	56
-	2	2		2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1		5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1		811242-5	BUMPER, HOLD DOWN	51
-	1	1		690753-2	SPACER, TONKER	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		1752356-1	SUPPORT, TERMINAL	34
-	2	2		2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-4	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		1803095-1	FLOATING SHEAR, FRONT	9
-	1	1		6-1633932-0	ANVIL, COMBINATION	8
-	1	1		240641-5	SPACER	7
-	-	-		-	-	6
-	1	1		2119757-6	DEPRESSOR, SHEAR	5
-	1	1		2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1		7-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	-	-		-	-	2
-	1	1		6-1633664-3	CRIMPER, WIRE	1

DATE	BY	APPV	DESCRIPTION	ITEM NO
02JUN2014	BOB HIGMAN		TE Connectivity	
02JUN2014	G. BAILEY		Harrisburg, PA 17105-3608	
02JUN2014	D. STOUGH		Ocean Side Feed	
			Applicator	

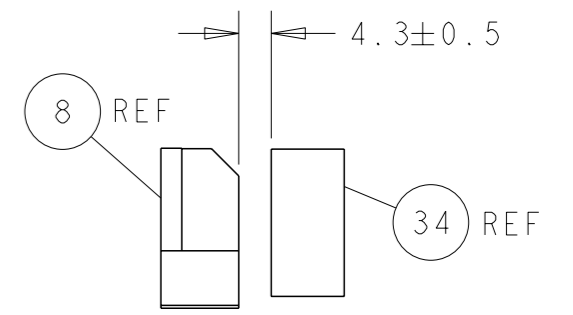
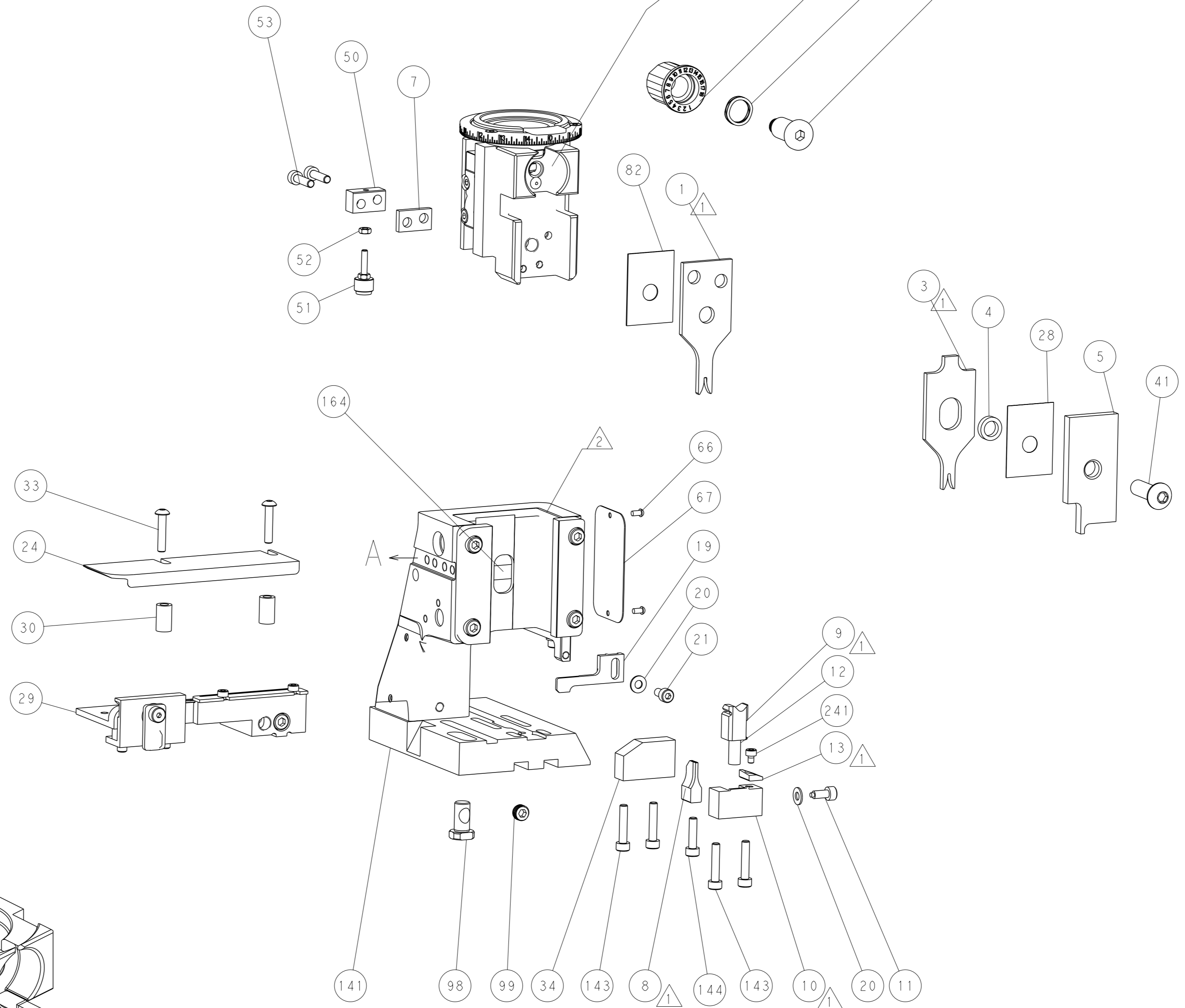
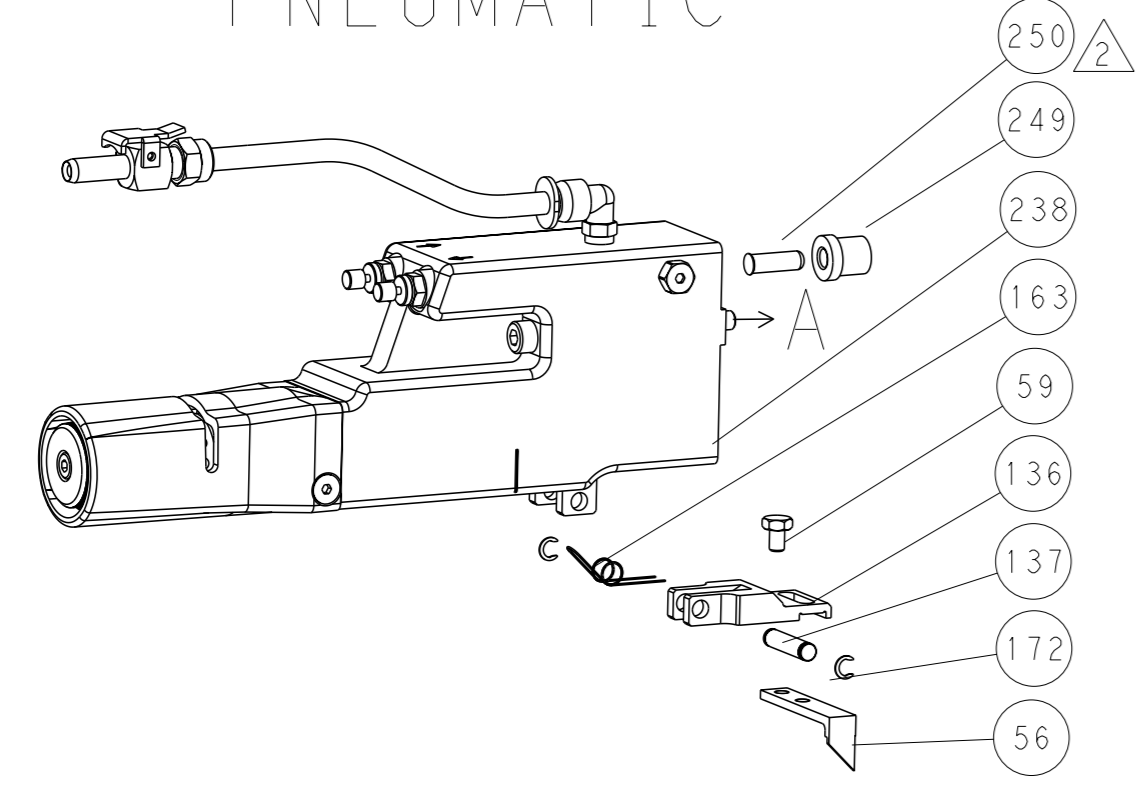
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

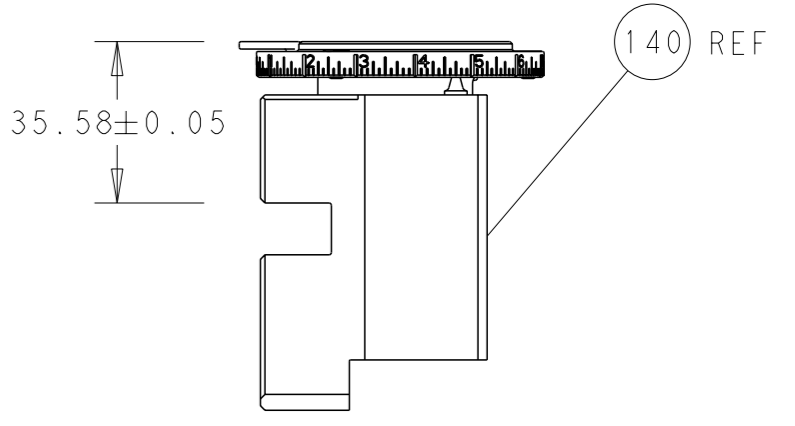
FEED TYPE MECHANICAL



PNEUMATIC

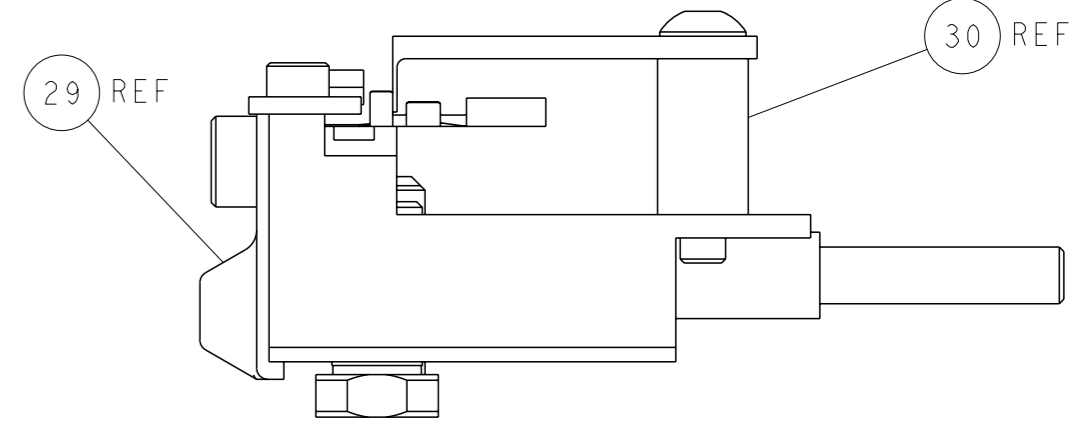


TERMINAL SUPPORT LOCATION



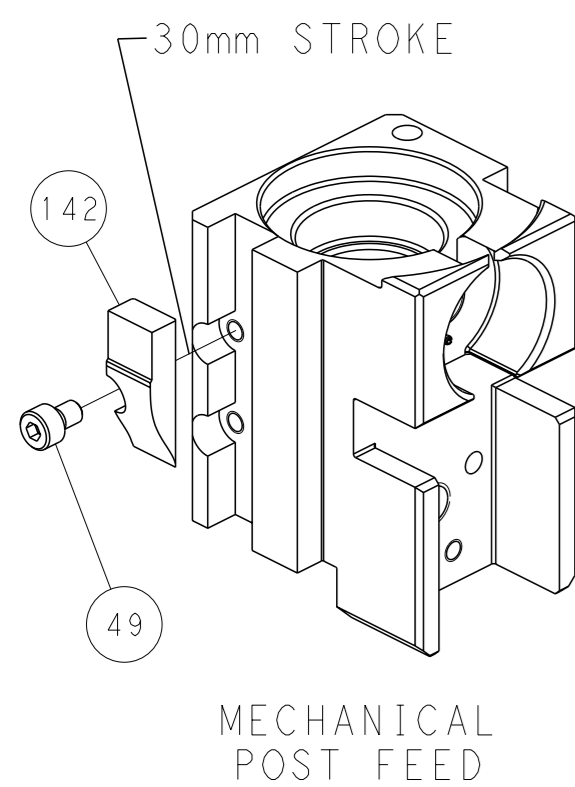
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES

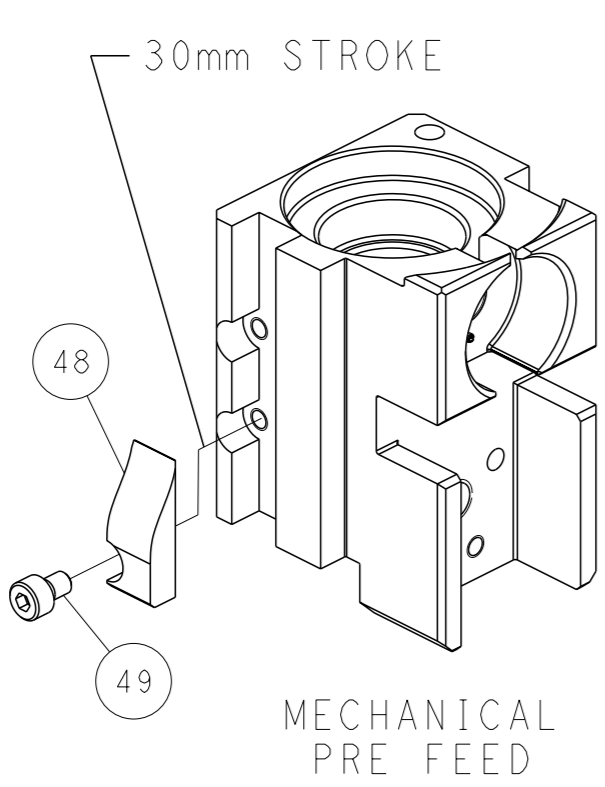


FEED TRACK POSITION GUIDE BY INSULATION BARREL

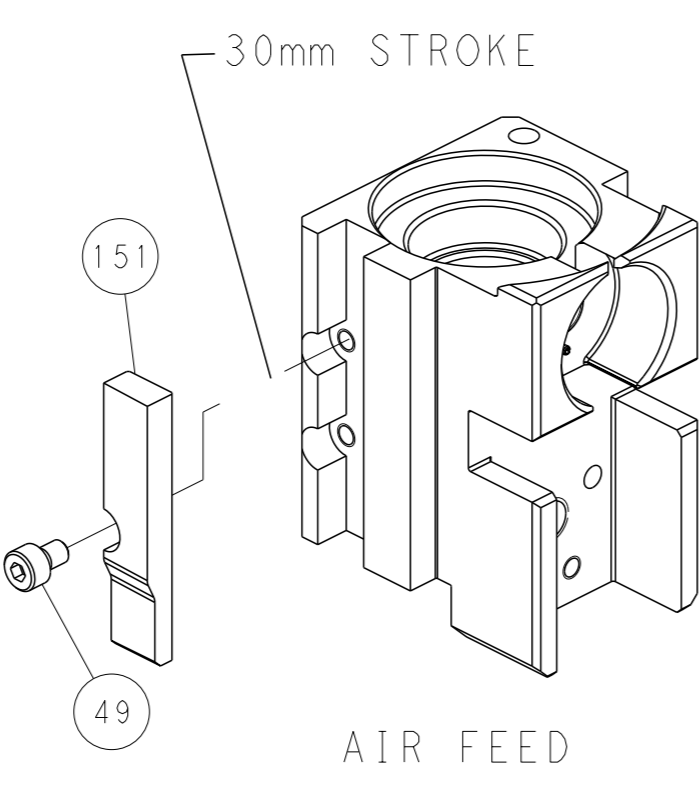
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 02JUN2014 CHK: G. BAILEY 02JUN2014 APVD: D. STOUGH 02JUN2014 PRODUCT SPEC	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC WEIGHT MATERIAL	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266290	RESTRICTED TO: B SCALE: 1:2 SHEET: 4 of 4 REV: B