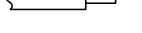


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266290-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266290-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266290-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266290-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266290-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.55 mm [.061]	O
APPLICATOR INSTRUCTIONS 408-35042		

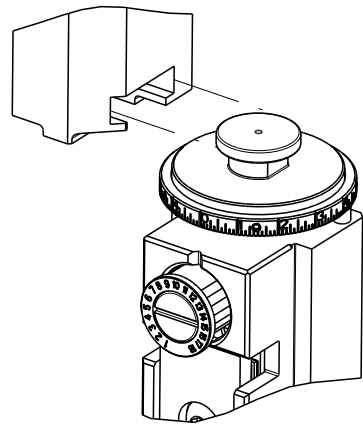
TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: 025 FEMALE TERMINAL			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		 INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION		2009.01.12 Rev -	
			
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE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



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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)

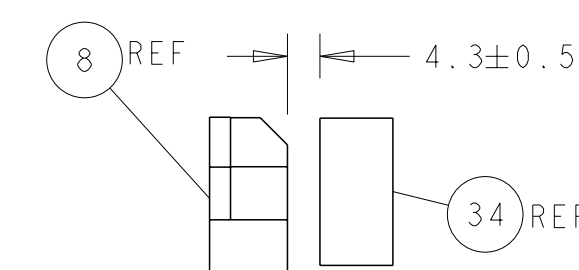
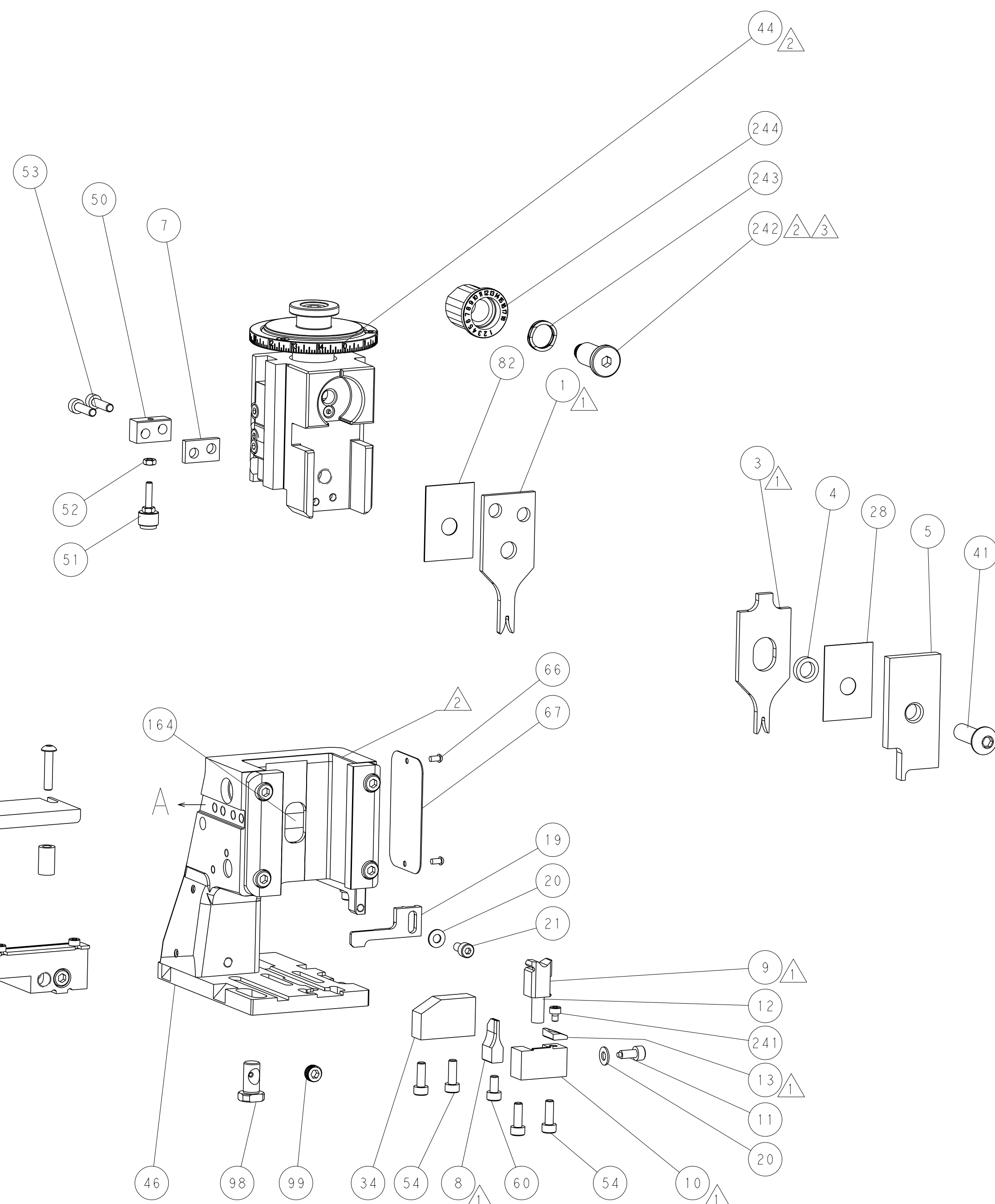
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	25JUL2014	BH	BH
			B	ECR-18-010714	06JUL2018	VLA	CT

-	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

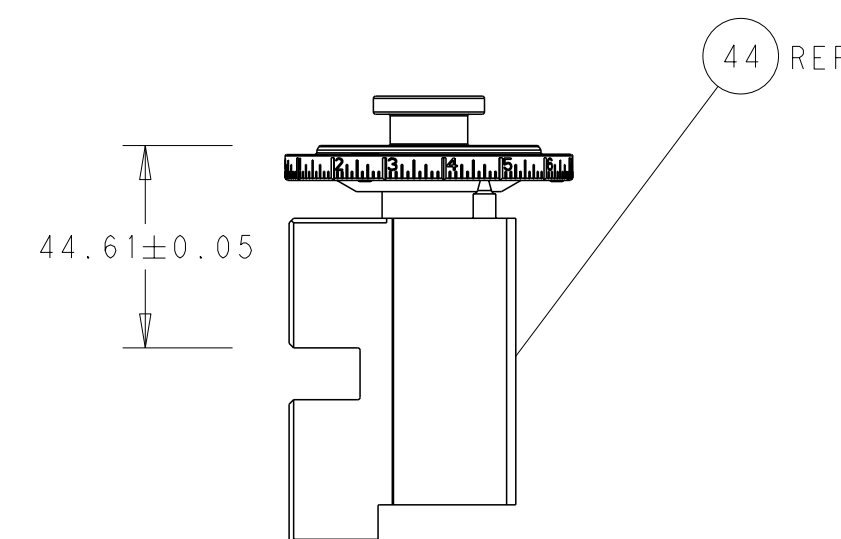
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN BOB HIGHMAN 02JUN2014	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK G.BAILEY 02JUN2014	NAME			
mm				APVD D.STOUGH 02JUN2014	Ocean Side Feed Applicator			
				PRODUCT SPEC	SIZE			
				APPLICATION SPEC	CAGE CODE			
					DRAWING NO			
MATERIAL				WEIGHT	RESTRICTED TO			
					A1 00779 ©=2266290			
				Customer Accessible Production Drawing	SCALE			
					1:2			
					SHEET			
					1 of 4			
					REV			
					B			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

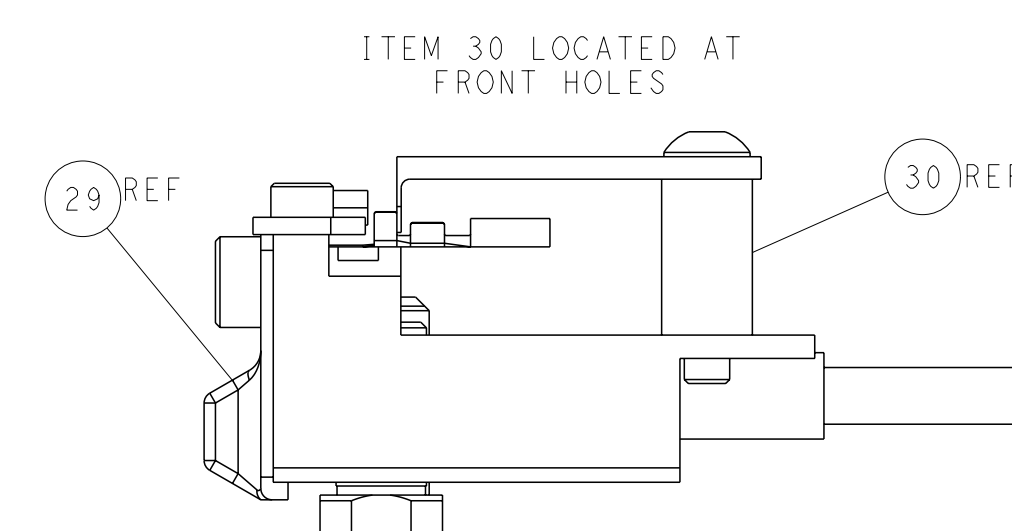
Diagram illustrating the front view of the machine. The front plate (239) is shown being attached to the front plate holder (59) using a screw (56). An arrow points to the front plate holder (59).



TERMINAL SUPPORT LOCATION

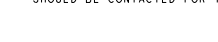


RAM SET-UP



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYPED REVISIONS. INFORMATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE CONTACTED FOR THE LATEST REVISIONS.		DATE 02JUN2014 BY BOB HIGMAN CHK G. BAILEY APVD D. STOUGH		TE Connectivity Harrisburg, PA 17105-3608 	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A1 CAGE CODE 00779 DRAWING NO C-2266290	
WEIGHT -		RESTRICTED TO -		SCALE 1:2 SHEET 2 of 4 REV B	
Customer Accessible Production Drawing					

8		7	
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20		20	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
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	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.55 mm [.061]	O
APPLICATOR INSTRUCTIONS 408-35042		

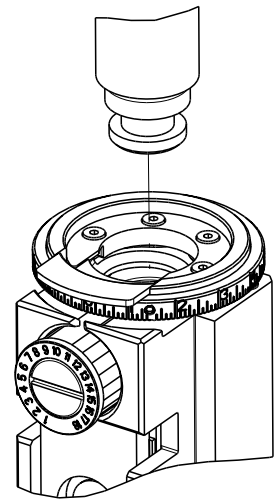
TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: 025 FEMALE TERMINAL			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION		2009.01.12 Rev -	
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL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



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



*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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

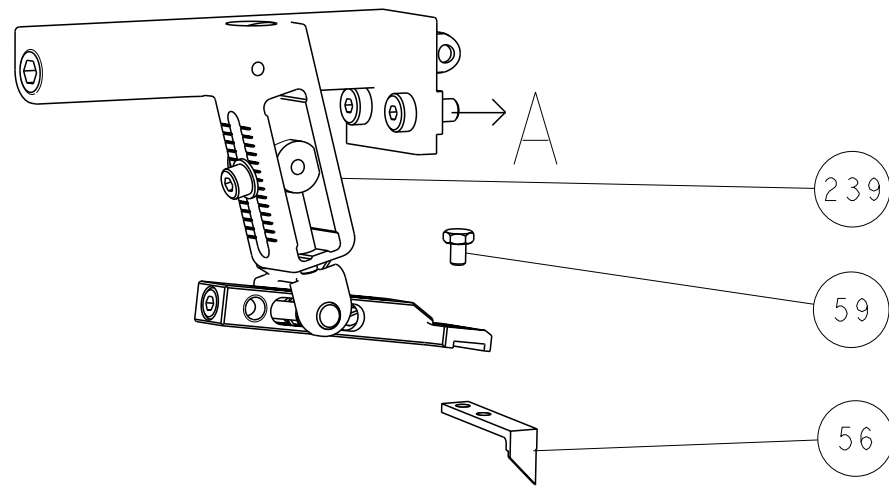
3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	2119580-1	MECHANICAL 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	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	1	7-1633965-5	CRIMPER, INSULATION O PREMIUM	3	
-	-	-	-	-	2	
1	1	1	1	6-1633664-3	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN			02JUN2014	TE Connectivity Harrisburg, PA 17105-3608	
CHK			02JUN2014		
G.BAILEY			02JUN2014		
APVD			02JUN2014		
D.STOUGH			02JUN2014	NAME	
PRODUCT SPEC				Ocean Side Feed Applicator	
APPLICATION SPEC				-	
-				SIZE	
-				CASE CODE	
-				DRAWING NO	
-				RESTRICTED TO	
MATERIAL				A1 00779 ©=2266290	
-				Customer Accessible Production Drawing	
-				SCALE	
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-				3	
-				OF	
-				4	
-				REV	
-				B	

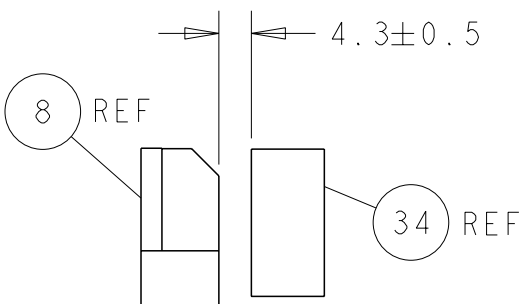
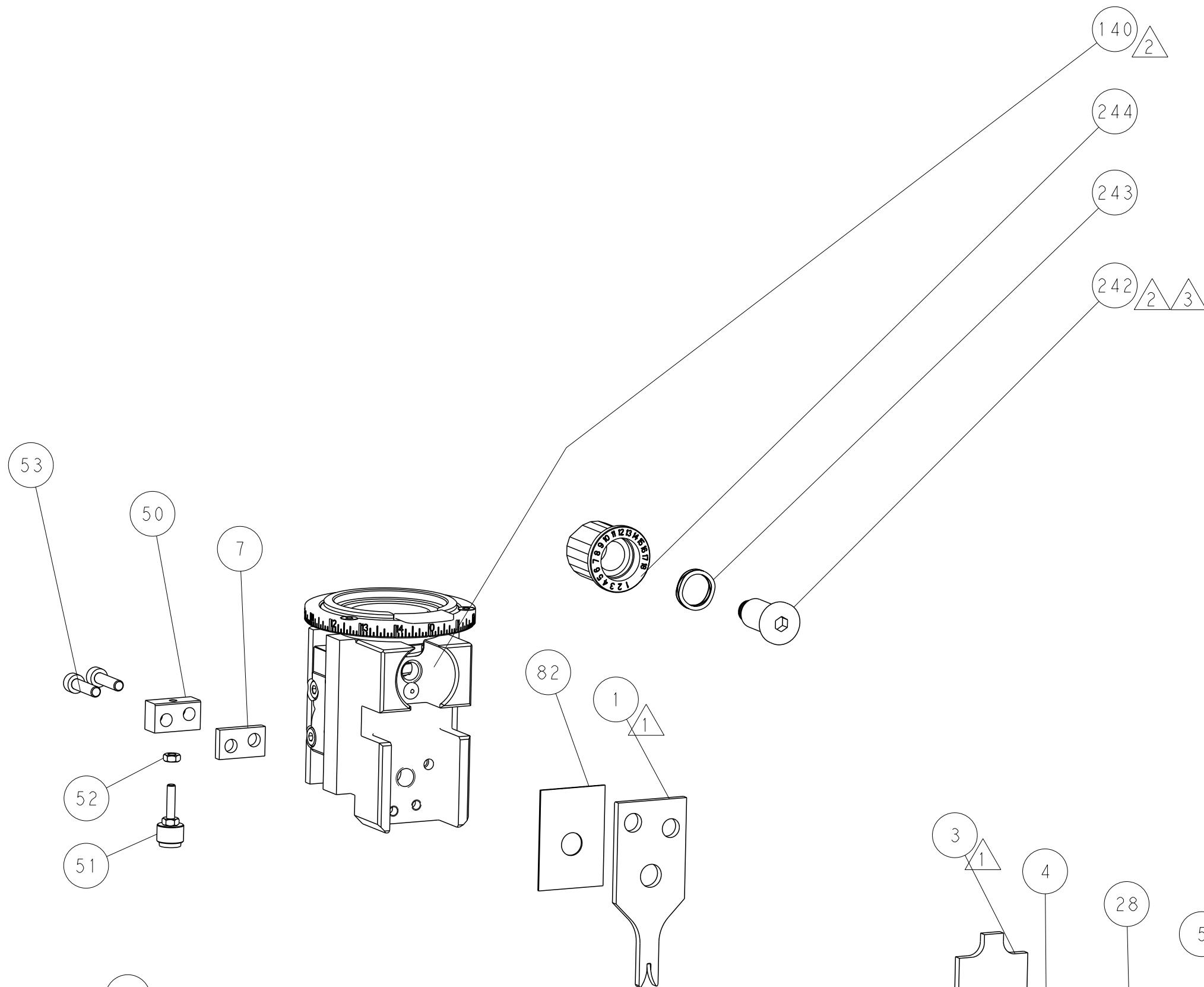
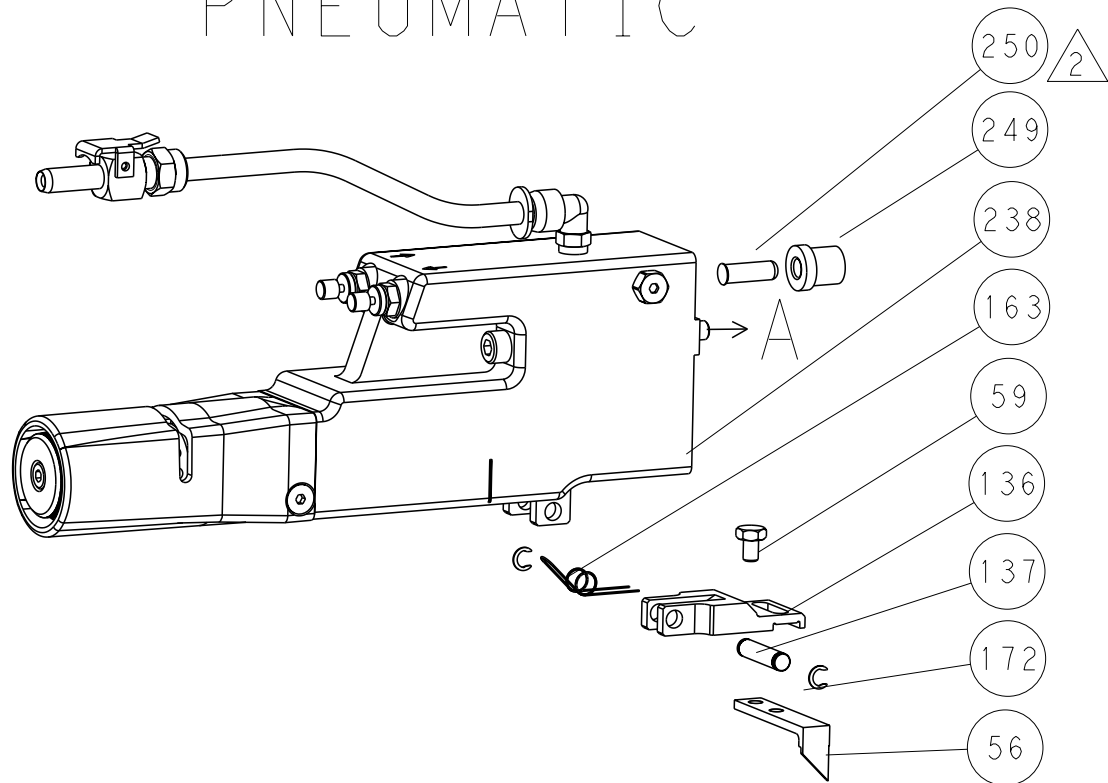
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

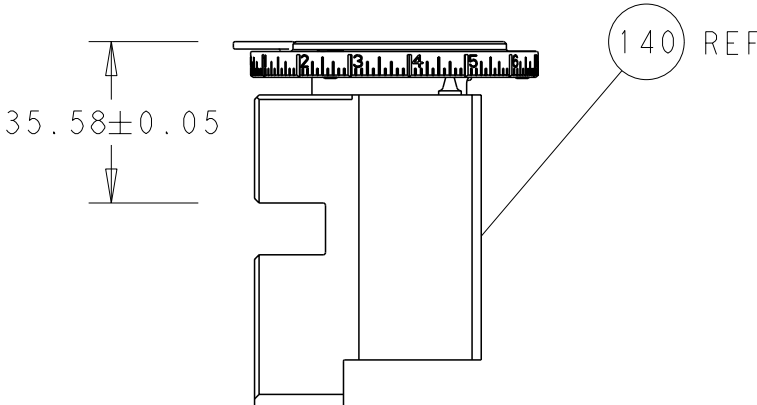
FEED TYPE
MECHANICAL



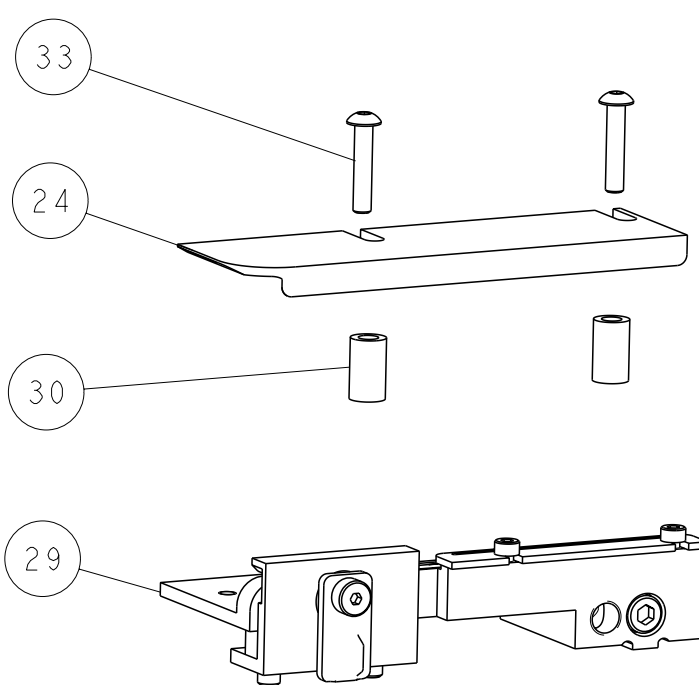
PNEUMATIC



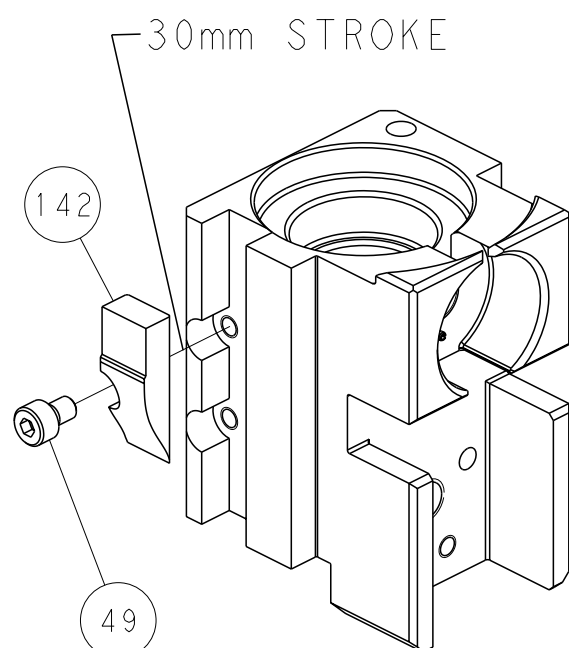
TERMINAL SUPPORT LOCATION



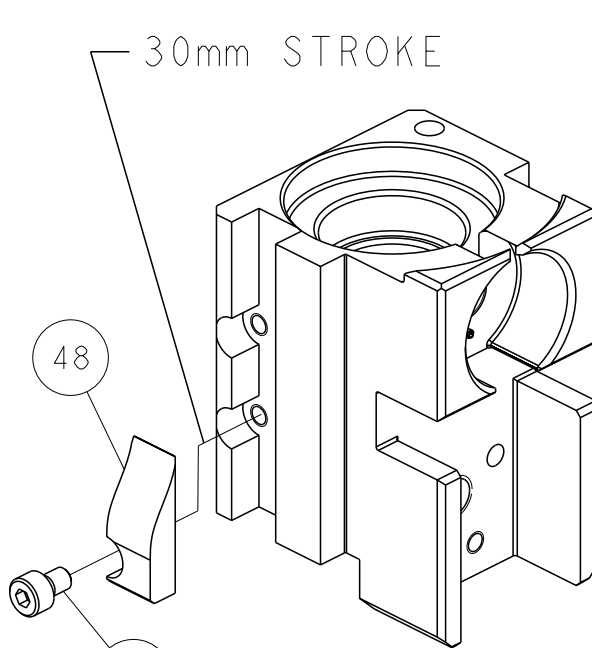
RAM SET-UP



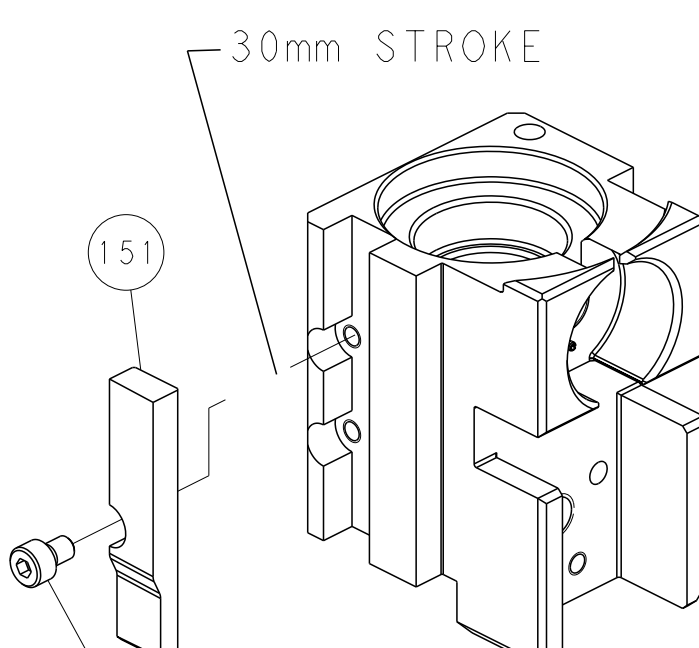
CAM POSITIONS



MECHANICAL
POST FEED

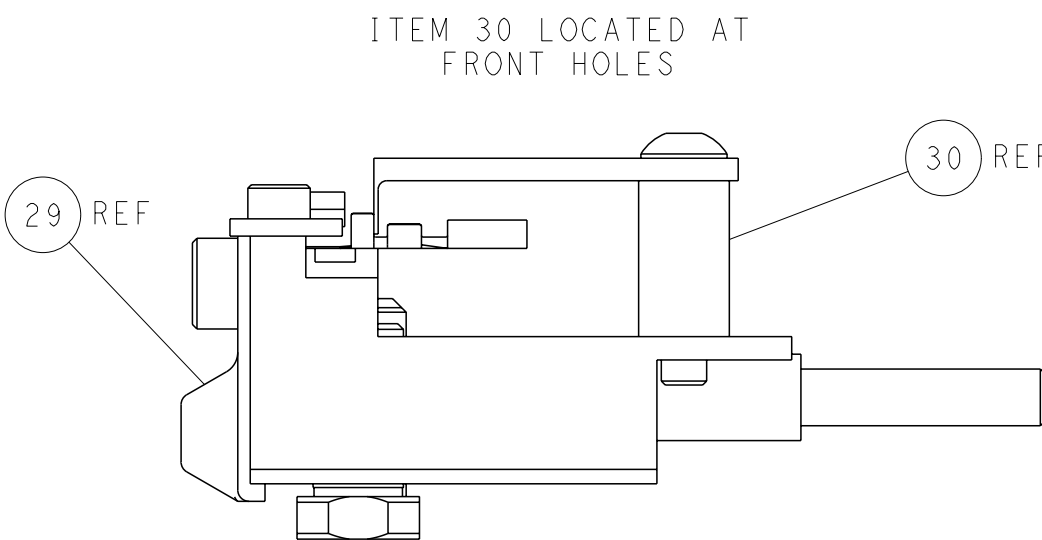


MECHANICAL
PRE FEED



AIR FEED

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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN BOB HIGMAN 02JUN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 02JUN2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD D. STOUGH 02JUN2014	SIZE A1	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	CAGE CODE 00779	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2266290-1](#)