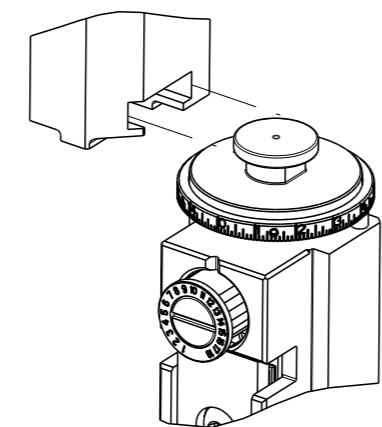


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150774-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150774-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150774-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.45 mm [.136]	F
INSUL	4.75 mm [.187]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING GND L32M6			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.96-6.73 mm [.235-.265 IN]		∅2.92-3.90 mm [.115-.154 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2303718-1	17.06720	2303718-2	17.06730

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.70+/-0.05 [.106+/- .002]	6.0
1.50mm2	2.55+/-0.05 [.100+/- .002]	7.6
1.00mm2	2.50+/-0.05 [.098+/- .002]	8.0



- 1 RECOMMENDED SPARE PARTS
 - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 TERMINAL LUBRICANT IS RECOMMENDED.
 - 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	03APR2017	TB	CT
		B		ECR-17-004896	05APR2017	TB	CT
		C		ECR-20-012970	14SEP2020	FJ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238		
3	-	1	1	1752354-4	STANDOFF,HOLD-DOWN	180	
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177		
-	1	1	8-22280-7	SPRING, COMPRESSION	176		
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175		
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-5	SPACER, CRIMPER	82		
-	1	1	2119791-9	DEPRESSOR, WIRE	73		
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71		
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70		
-	1	1	2119943-1	WASHER, SPACER	69		
-	1	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65		
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60		
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56		
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54		
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53		
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52		
-	1	1	2063961-1	FEED FINGER	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	1	1-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46		
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44		
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	240639-1	STRIPPER (MACHINING)	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1752371-5	PLATE, STRIP GUIDE	24		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19		
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	1-240641-4	SPACER	16		
-	1	1	1752360-1	SPACER,HOLD-DOWN	13		
1	-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10		
1	-	1	1	690482-7	PLATE, FRONT SHEAR	9	
1	2	1	1	7-1803059-9	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1-2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6		
-	1	1	1	5-240641-3	SPACER	5	
-	1	1	1	2-1803409-5	BLOCK, CRIMPER SPACER	4	
1	2	1	1	9-1803187-6	CRIMPER, INSULATION F	3	
-	1	1	1	455888-7	SPACER, CRIMPER	2	
1	2	1	1	1-1803325-9	CRIMPER, WIRE	1	
-	77	72	2	PART NO			
-				DESCRIPTION			ITEM NO

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

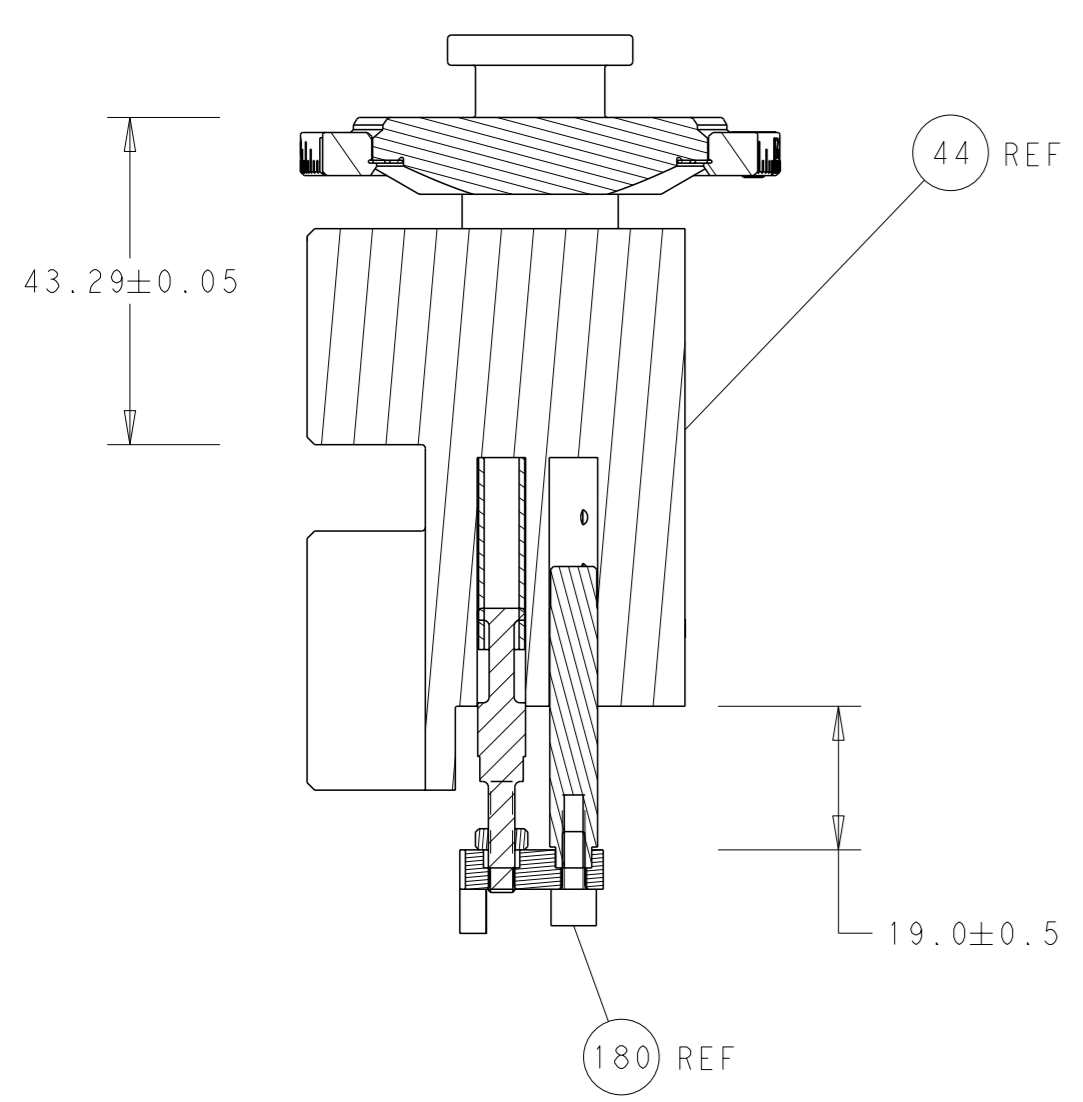


Ocean End Feed Applicator

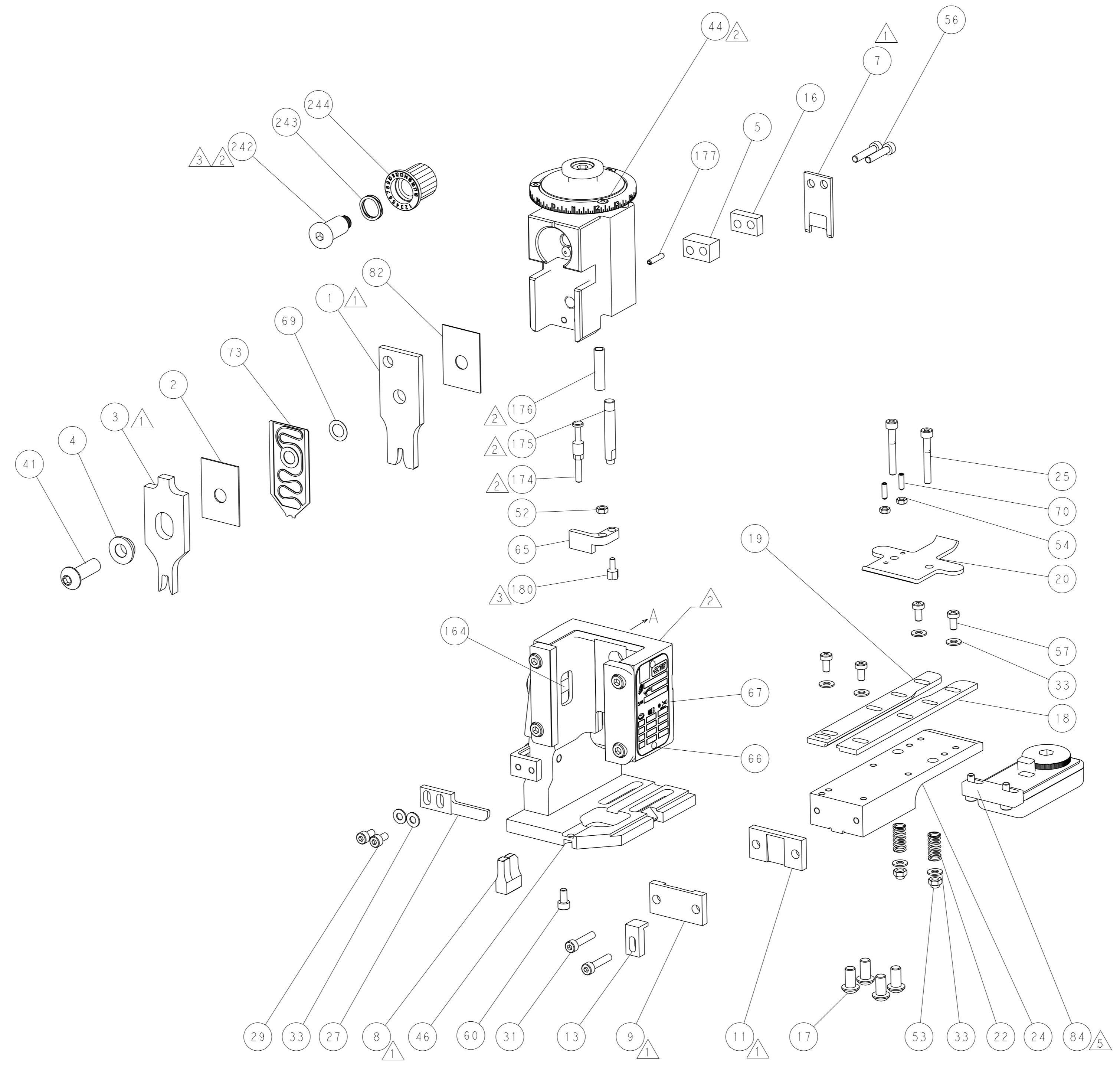
SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150774

RESTRICTED TO: -

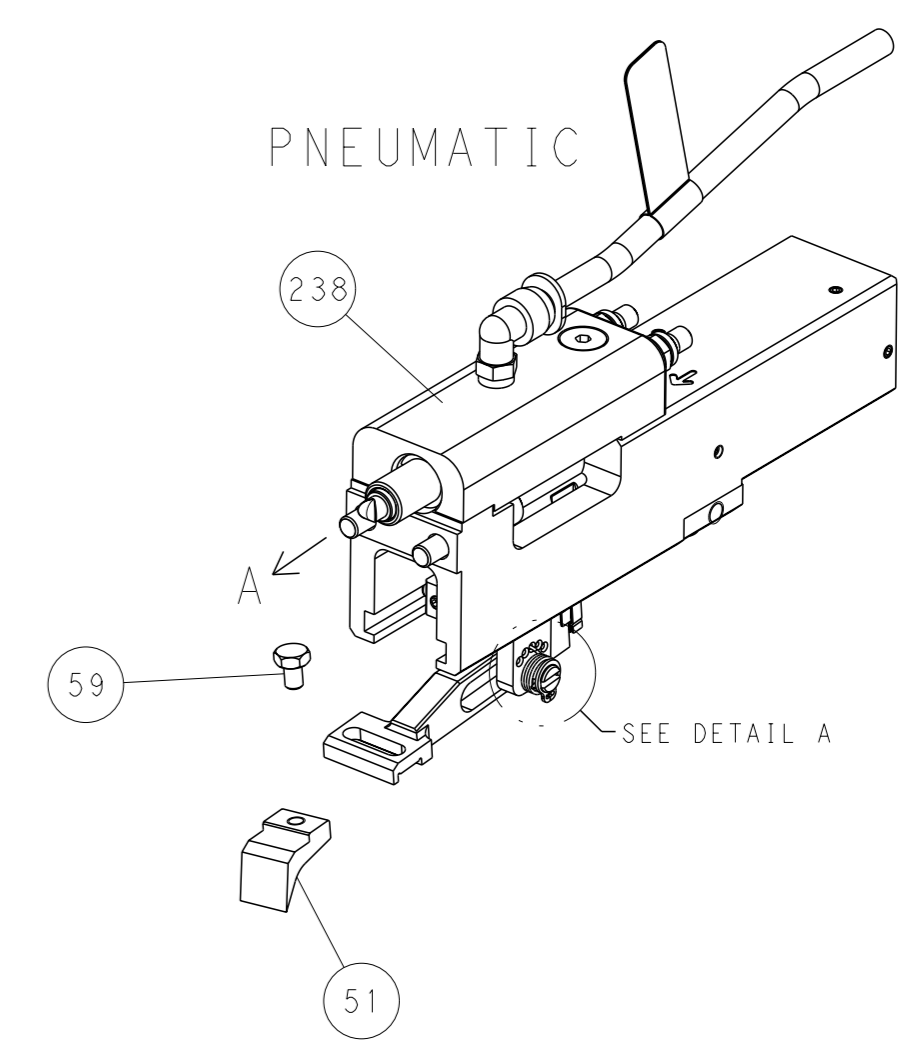
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-



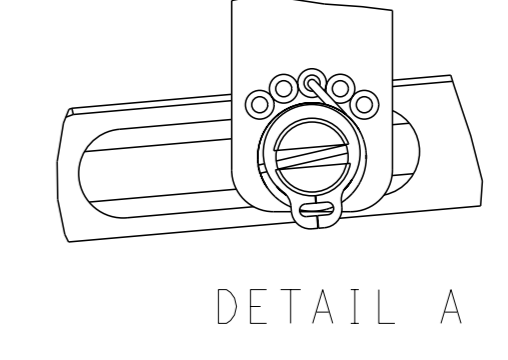
RAM AND HOLDDOWN SET-UP



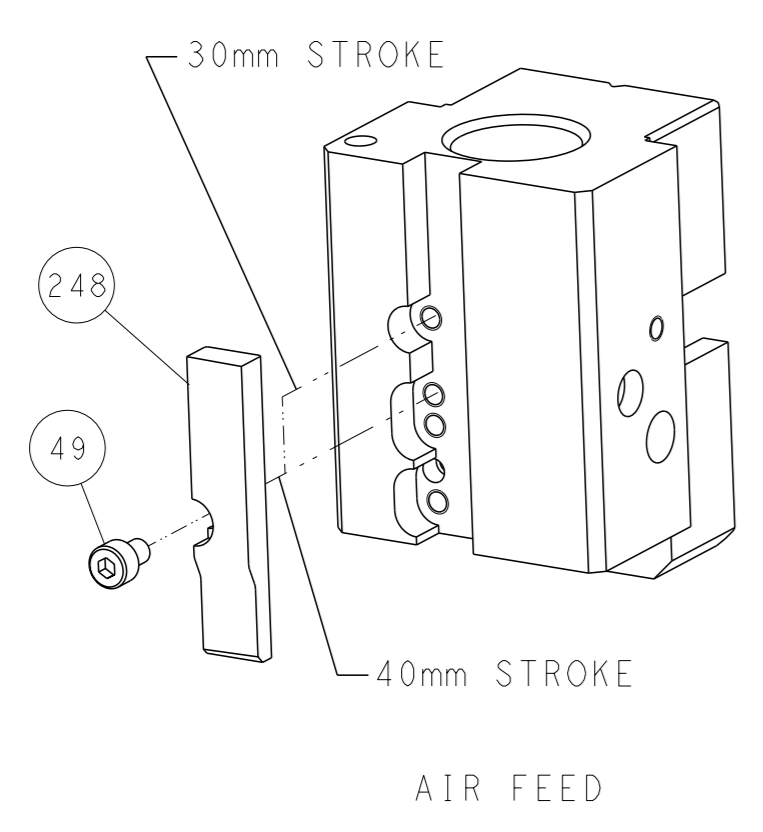
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



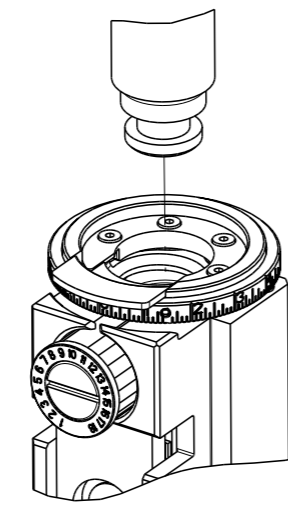
AIR FEED

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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. ZHAO 10FEB2017 CHK: K. ZHANG 10FEB2017 APVD: K. ZHANG 10FEB2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150774	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150774-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150774-7	A	CRIMP TOOLING KIT	-

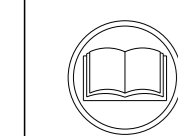
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.45 mm [1.136]	F
INSUL	4.75 mm [1.187]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING GND L32M6			
WIRE STRIP LENGTH 5.96-6.73 mm [1.235-.265 IN]		INSULATION DIAMETER RANGE 2.92-3.90 mm [1.115-.154 IN]	
TERMINAL APPLICATION SPECIFICATION B0-245.011A Rev 28/08/02			
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2303718-1	17.06720	2303718-2	17.06730

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.70+/-0.05 [1.106+/-0.002]	6.0
1.50mm2	2.55+/-0.05 [1.100+/-0.002]	7.6
1.00mm2	2.50+/-0.05 [1.098+/-0.002]	8.0



- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
 - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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.

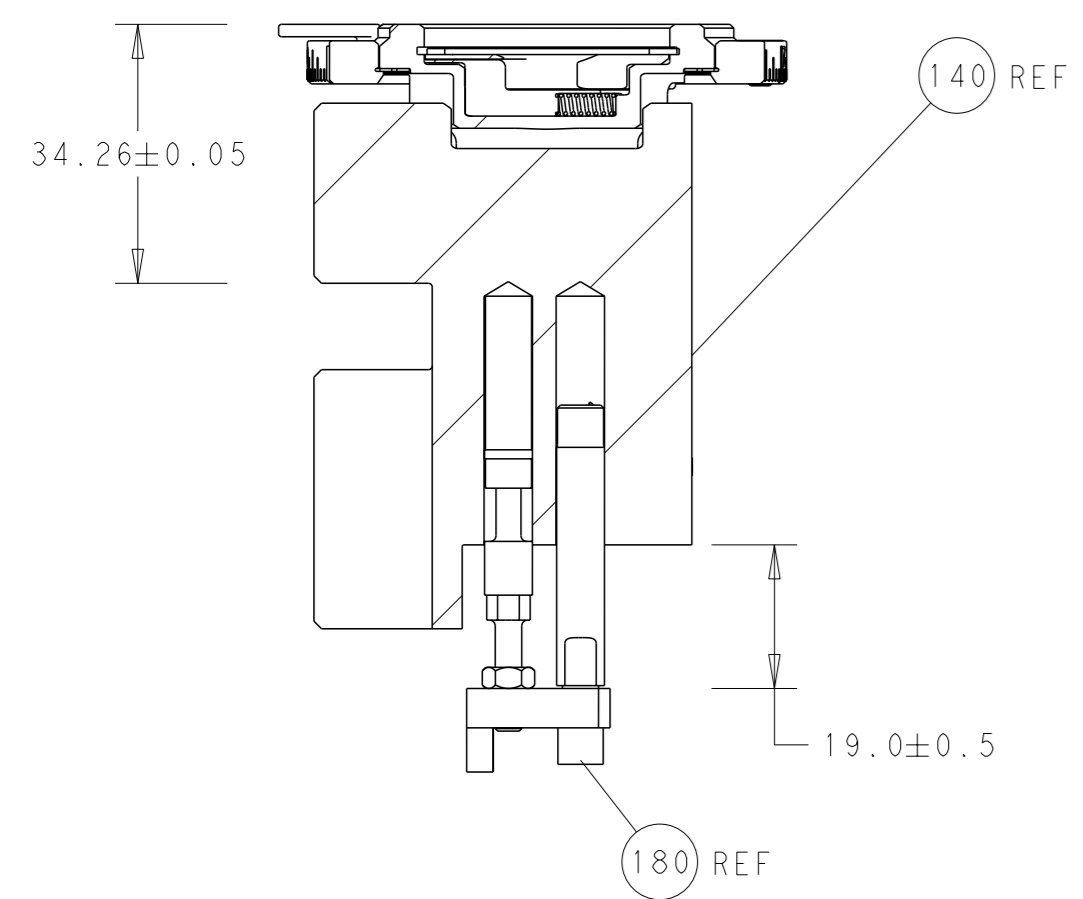
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1752354-4	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	2119791-9	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	1-240641-4	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-7	PLATE, FRONT SHEAR	9
1	1	7-1803059-9	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	5-240641-3	SPACER	5
-	1	2-1803409-5	BLOCK, CRIMPER SPACER	4
1	1	9-1803187-6	CRIMPER, INSULATION F	3
-	1	455888-7	SPACER, CRIMPER	2
1	1	1-1803325-9	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: M. ZHAO 10FEB2017		CHK: K. ZHANG 10FEB2017		APVD: K. ZHANG 10FEB2017		NAME: STE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	TE Connectivity Harrisburg, PA 17105-3608		PRODUCT SPEC		Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2150774	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET: 3 of 4		REV: C					

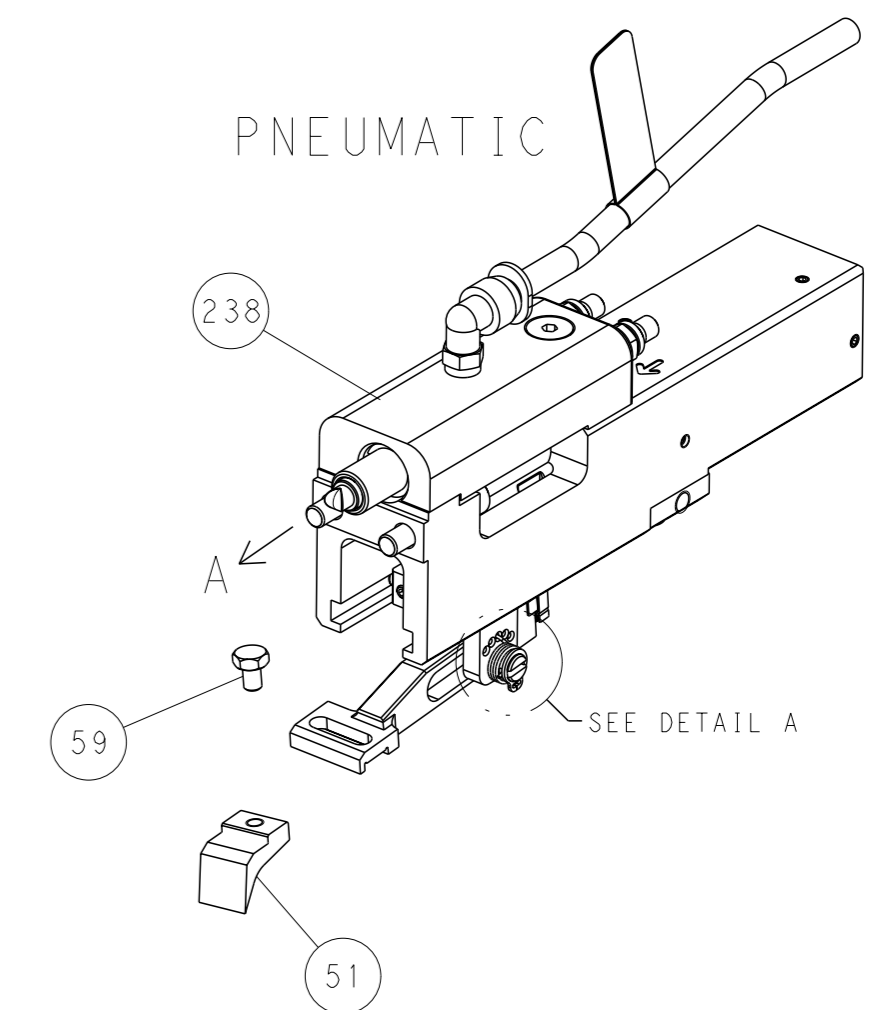
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



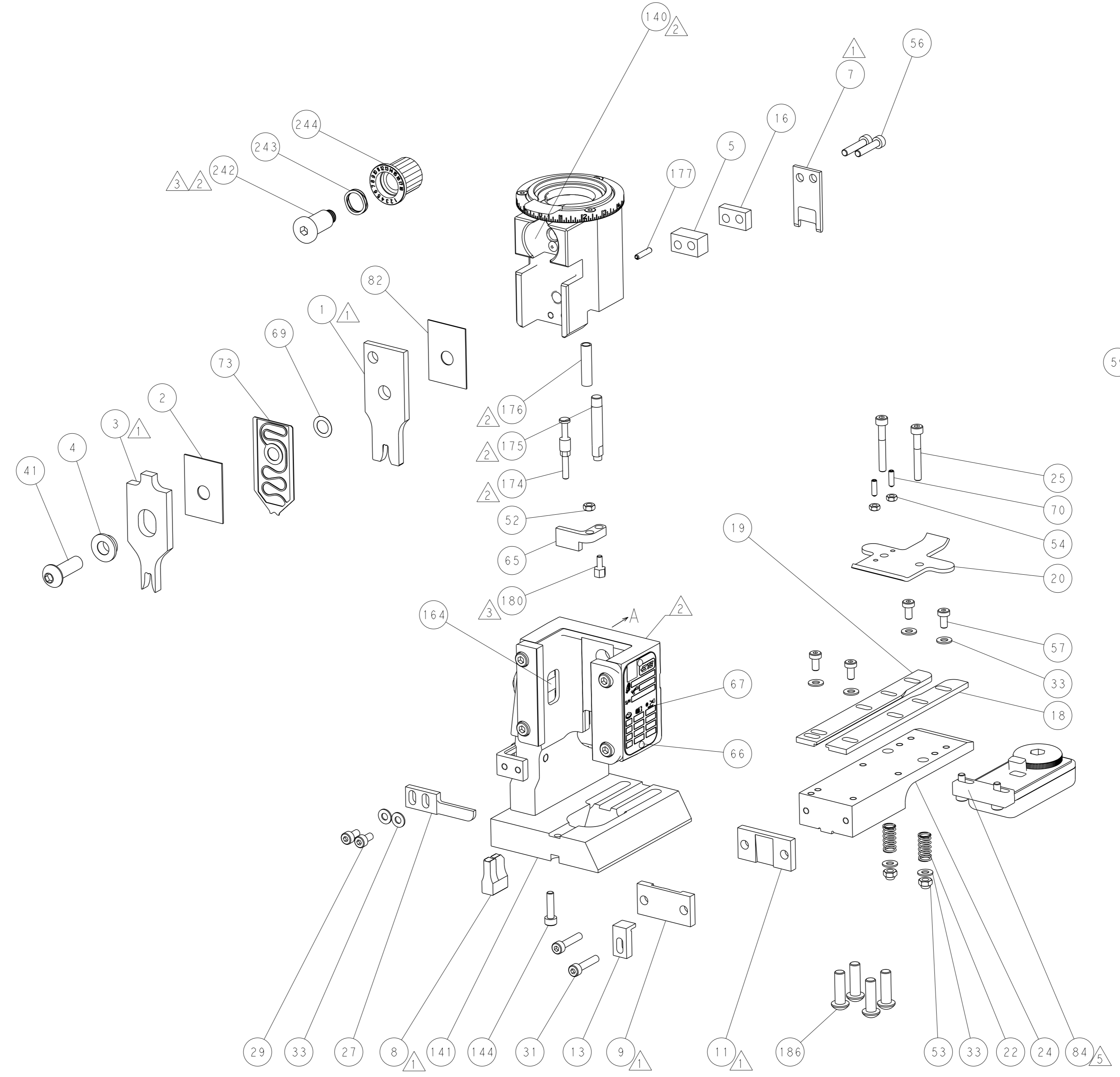
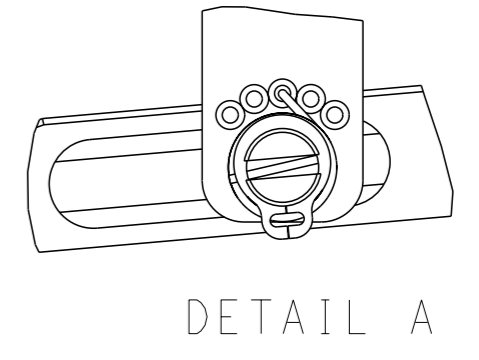
RAM AND HOLDDOWN SET-UP

FEED TYPE

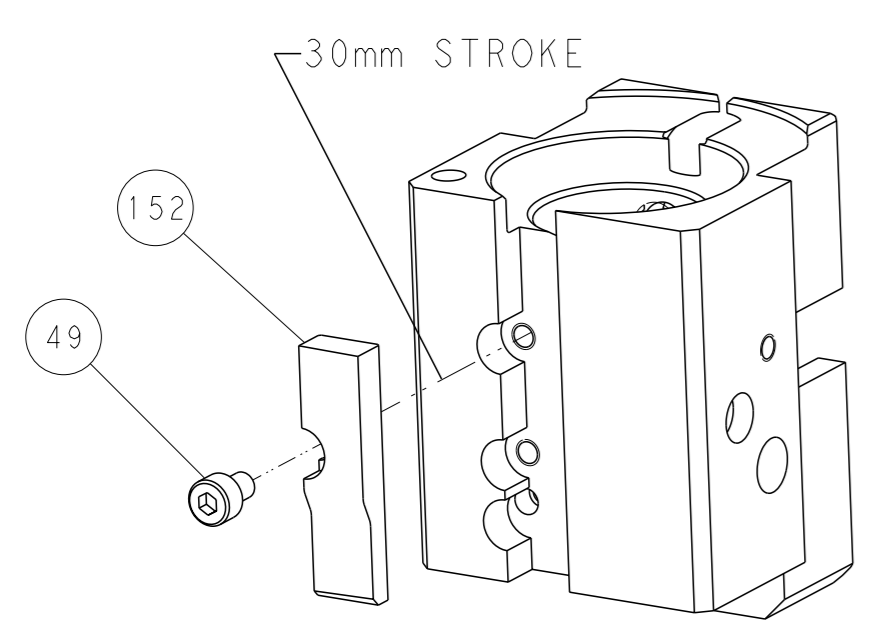
PNEUMATIC



FEED SPRING SETTING POSITION



CAM POSITION



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 USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. ZHAO 10FEB2017 CHK: K. ZHANG 10FEB2017 APVD: K. ZHANG 10FEB2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME: Ocean End Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150774 SHEET: 4 of 4 REV: C
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	