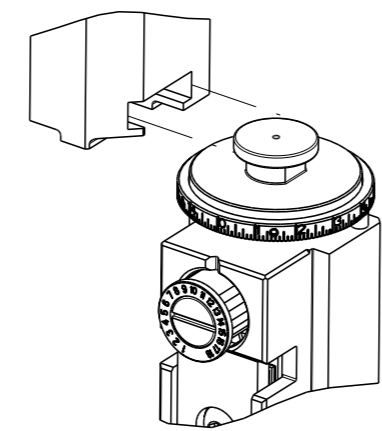


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150775-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150775-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150775-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [1.57]	F
INSUL	5.90 mm [2.32]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING GND L32M6			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.89-6.65 mm [1.232-.262 IN]		3.53-4.70 mm [1.139-.185 IN]	
TERMINAL APPLICATION SPECIFICATION BO-245.012A Rev 09/07/2004			
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2303719-1	1706700	2303720-1	1706710

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.92+/-0.05 [1.54+/-0.002]	6.7
4.00mm2	3.85+/-0.05 [1.52+/-0.002]	6.2

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - CUT TO LENGTH AT ASSEMBLY.
  - TERMINAL LUBRICANT IS RECOMMENDED.
8. 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.

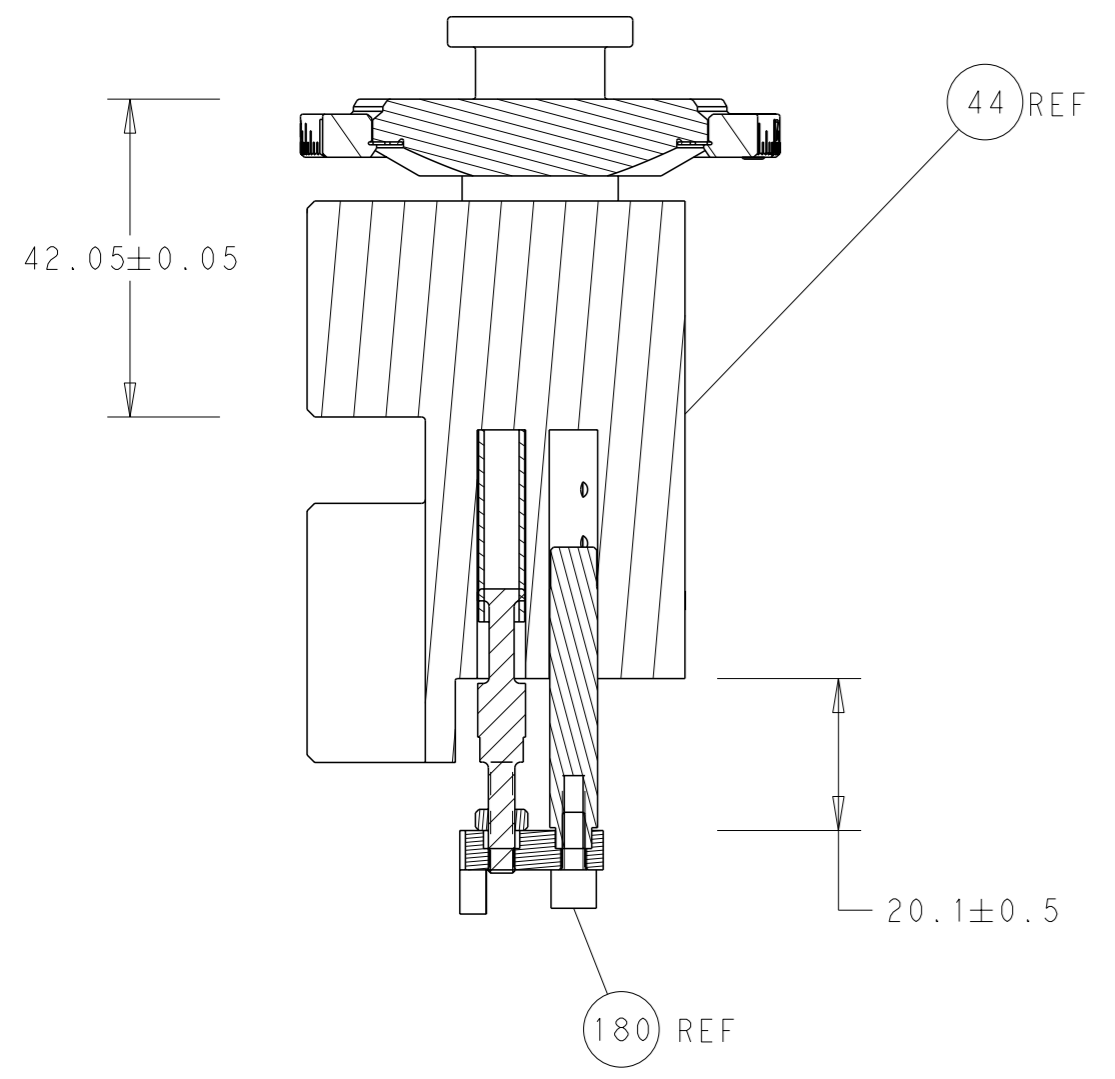
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	23MAR2017	TB	GB
		B		ECR-17-004849	04APR2017	TB	CT
		C		ECR-19-011141	16JUL2019	FZ	TE
		D		ECR-20-012727	09SEP2020	FJ	TE

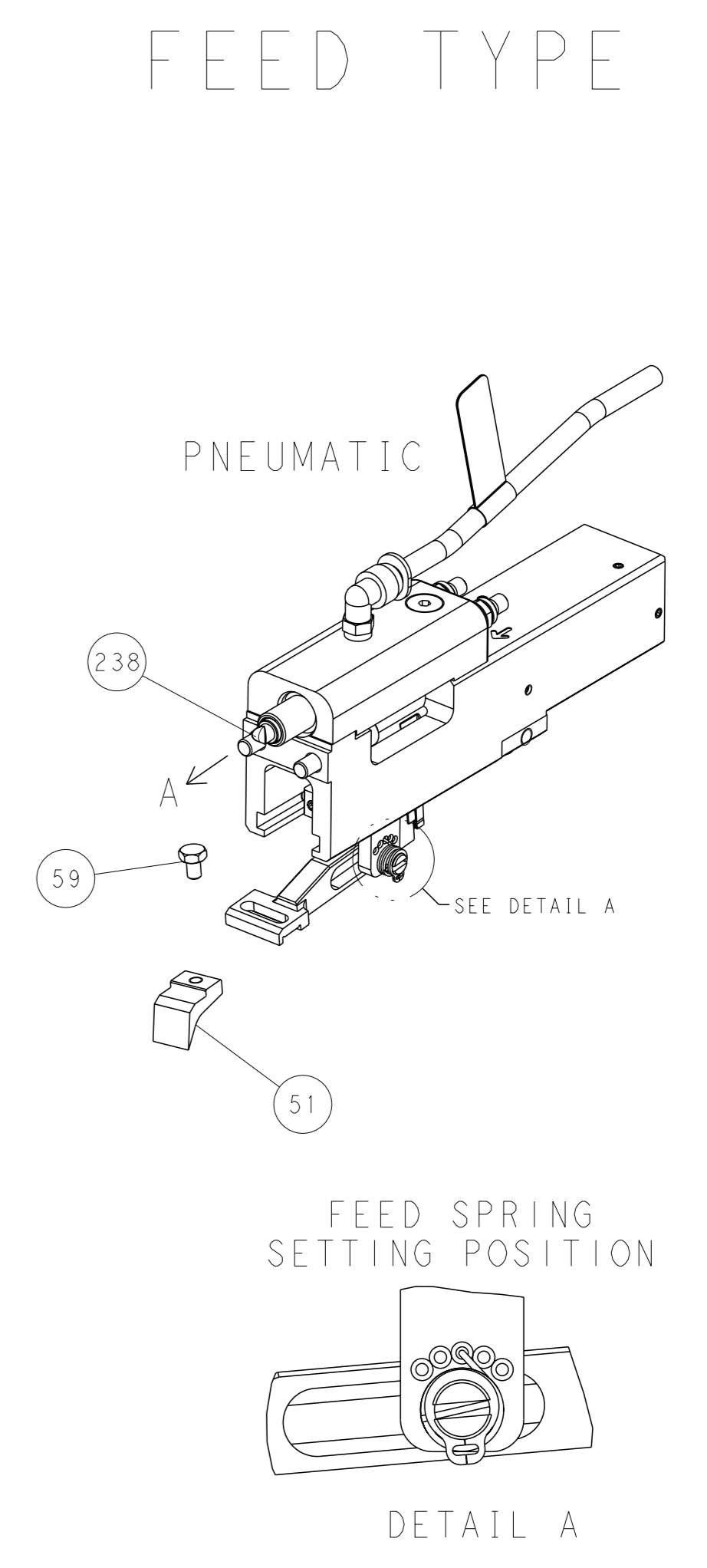
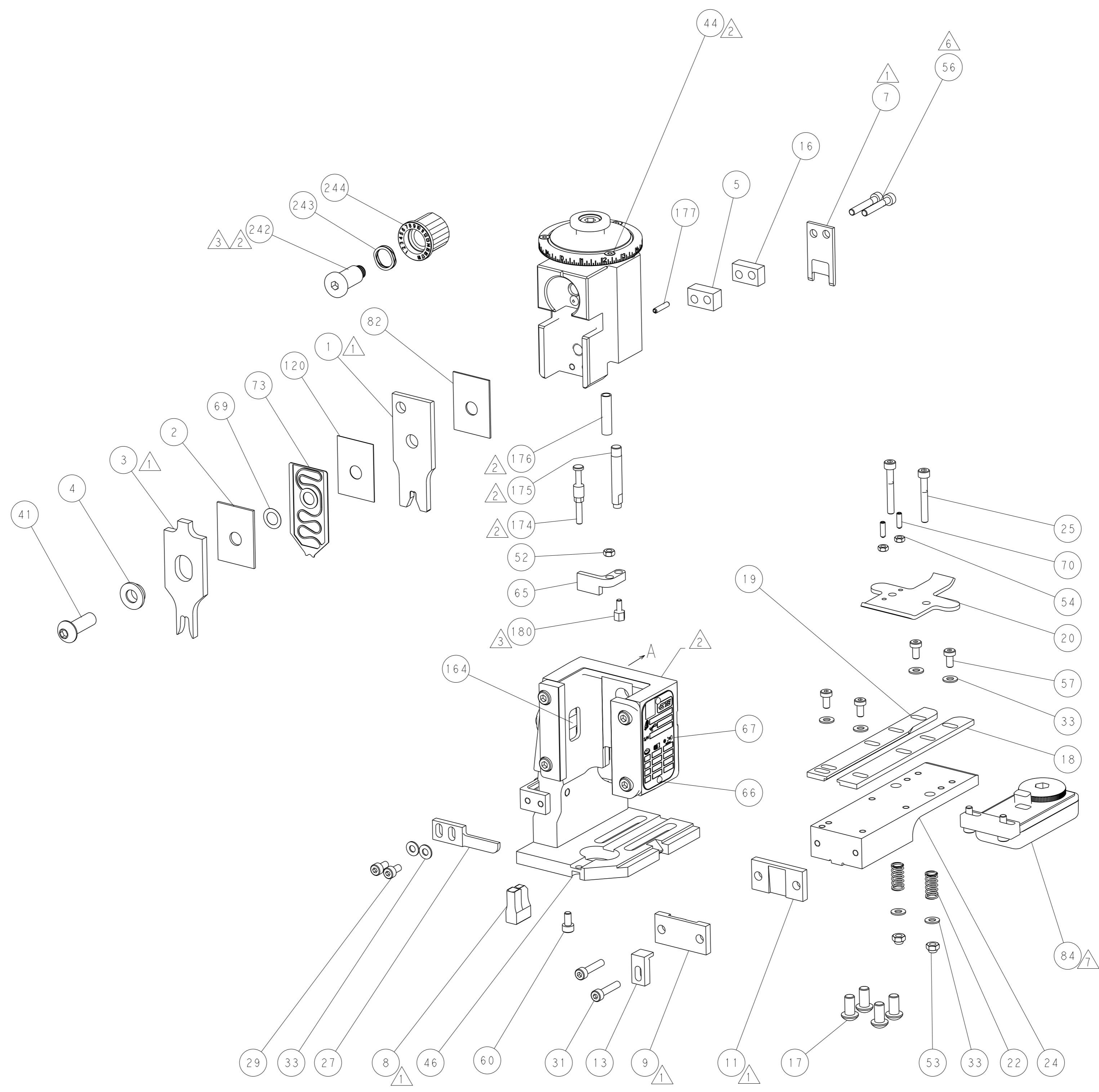
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
	1	1	1752354-5	STANDOFF, HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 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
-	1	1	455888-3	SPACER, CRIMPER	120
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-8	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	2119655-5	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	1-1752371-2	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	1-240641-5	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	1	1	4-690482-6	PLATE, FRONT SHEAR	9
	1	2	1-1803074-2	ANVIL, COMBINATION, END FEED	8
	1	1	1-2217206-6	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-7	SPACER	5
-	1	1	1-1803409-0	BLOCK, CRIMPER SPACER	4
	1	2	1803187-5	CRIMPER, INSULATION F	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
	1	2	1803482-2	CRIMPER, WIRE	1
-	77	72	2	PART NO	ITEM NO

<small>THE DRAWING IS CONTROLLED BY THE REVISIONS CONTROL SYSTEM. ANY CHANGES TO THE DRAWING MUST BE MADE THROUGH THE REVISIONS CONTROL SYSTEM. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE REVISIONS CONTROL SYSTEM FOR THE LATEST REVISION.</small>		OWN: X. ZHAO 14FEB2017 CHK: L. ZHANG 14FEB2017 APVD: L. ZHANG 14FEB2017	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 CASE CODE: 00779 DRAWING NO: C=2150775 RESTRICTED TO: - WEIGHT: - SCALE: 1:1 SHEET: 1 of 4 REV: D
MATERIAL: -		Customer Accessible Production Drawing	

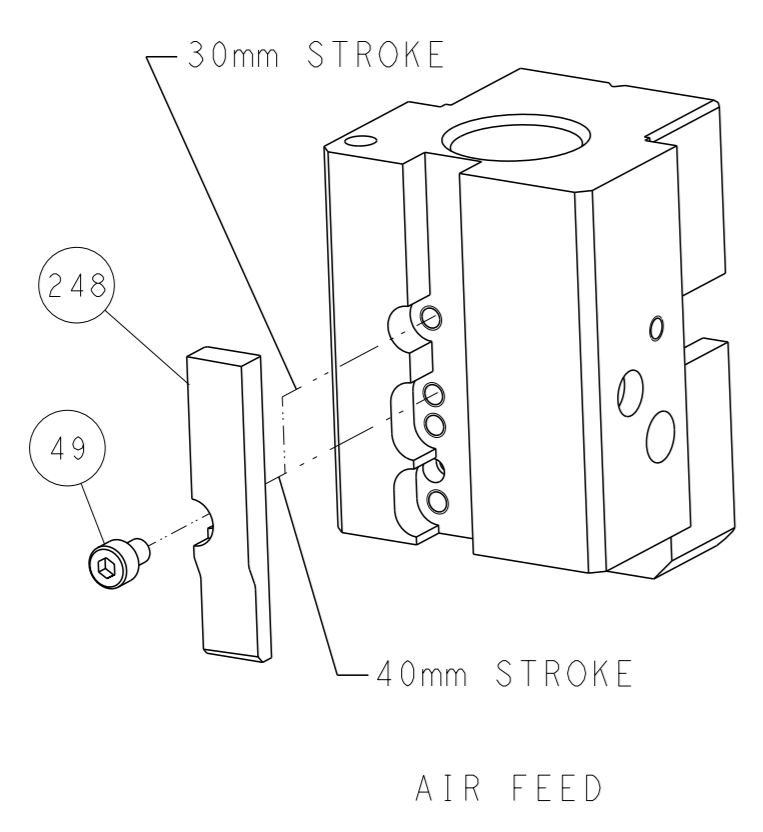
LOC	DIST	REVISIONS				
A	66	REV	DESCRIPTION	DATE	OWN	APVD
-	-	1	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



CAM POSITION



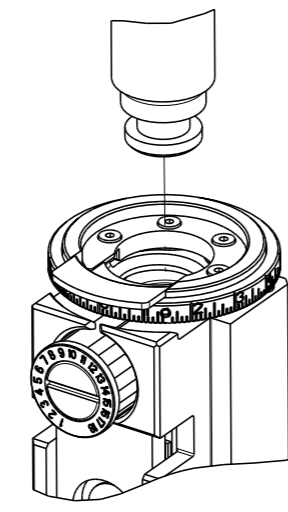
AIR FEED

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150775 SHEET 2 of 4 REV D
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150775-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150775-7	A	CRIMP TOOLING KIT	-

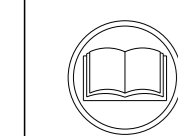
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [ .157 ]	F
INSUL	5.90 mm [ .232 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING GND L32M6			
WIRE STRIP LENGTH 5.89-6.65 mm [ .232-.262 IN ]		INSULATION DIAMETER RANGE 3.53-4.70 mm [ .139-.185 IN ]	
TERMINAL APPLICATION SPECIFICATION B0-245.012A Rev 09/07/2004			
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2303719-1	1706700	2303720-1	1706710

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.92+/-0.05 [ .154+/- .002 ]	6.7
4.00mm2	3.85+/-0.05 [ .152+/- .002 ]	6.2



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - 6 CUT TO LENGTH AT ASSEMBLY.
  - 7 TERMINAL LUBRICANT IS RECOMMENDED.
8. 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.

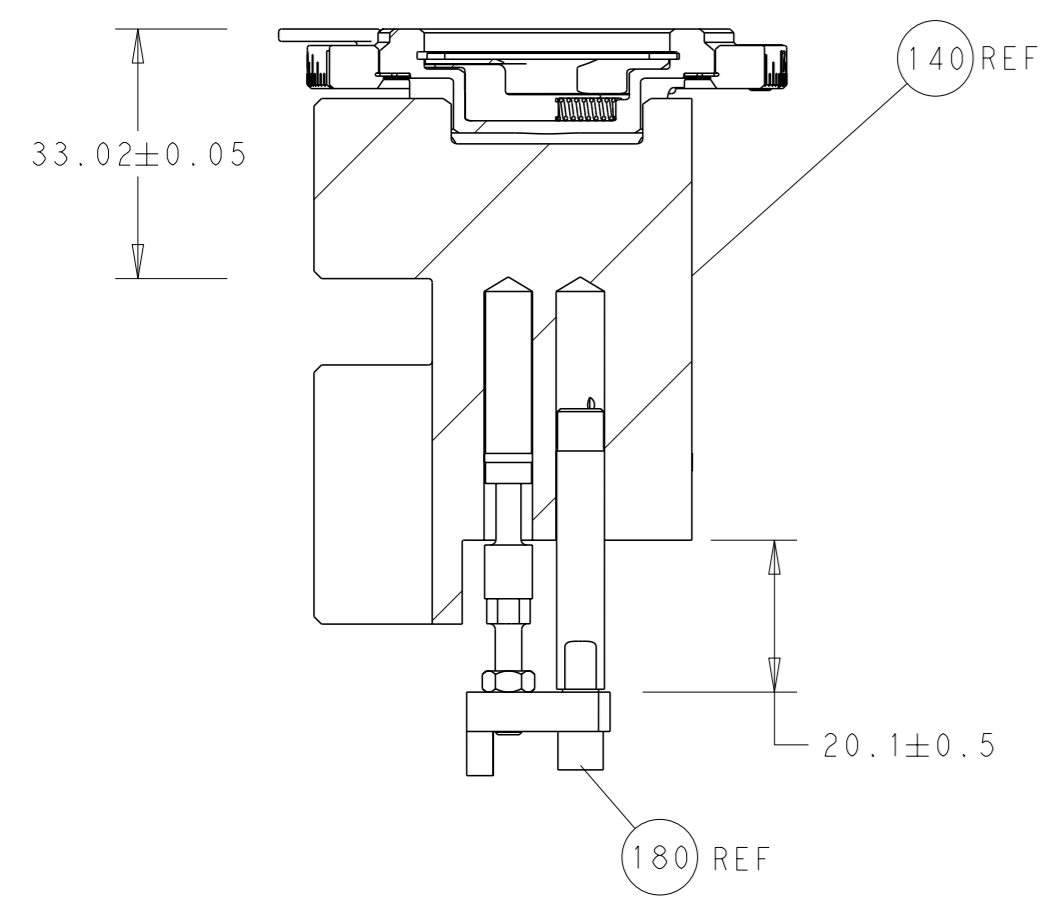
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

3	-	1	2119082-4	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
3	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1752354-5	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	455888-3	SPACER, CRIMPER	120
7	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-8	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
6	-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1-1752371-2	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	1-240641-5	SPACER	16
	-	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	4-690482-6	PLATE, FRONT SHEAR	9
1	1	1	3-1803074-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-6	BLADE, SLUG	7
	-	-	-	-	6
	-	1	4-240641-7	SPACER	5
	-	1	1-1803409-0	BLOCK, CRIMPER SPACER	4
1	1	1	1803187-5	CRIMPER, INSULATION F	3
	-	1	1-455888-2	SPACER, CRIMPER	2
1	1	1	1803482-2	CRIMPER, WIRE	1
	-	77-22	PART NO	DESCRIPTION	ITEM NO

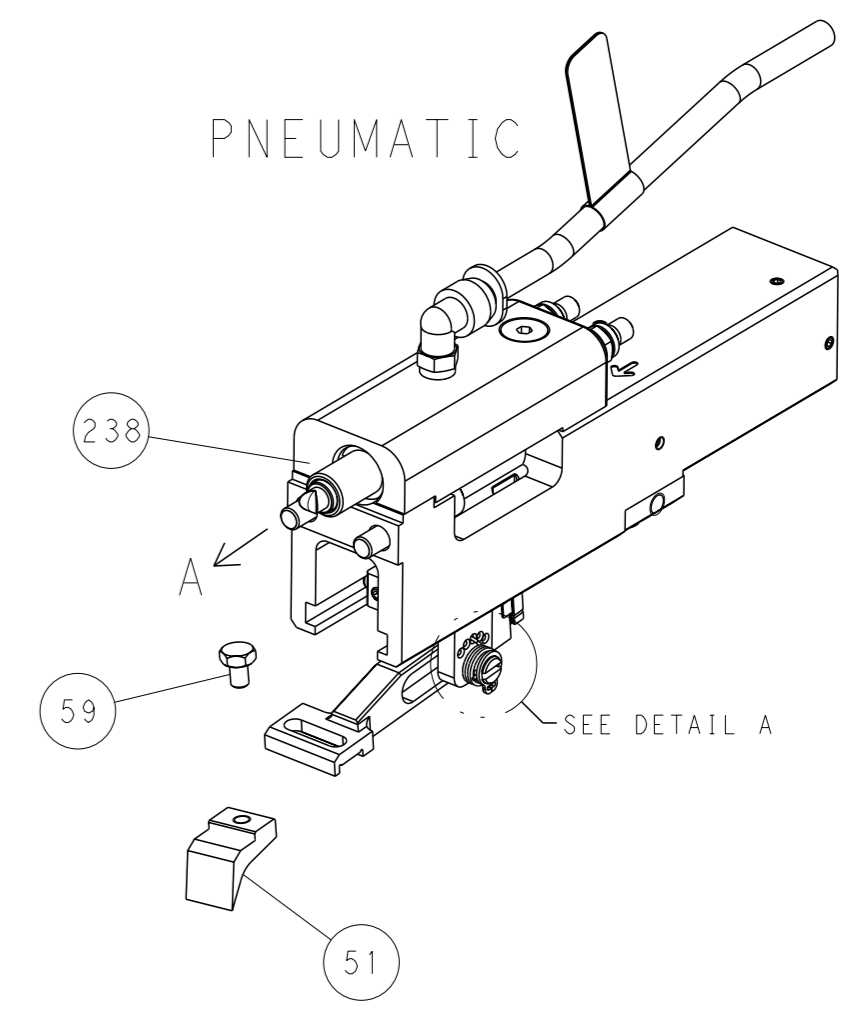
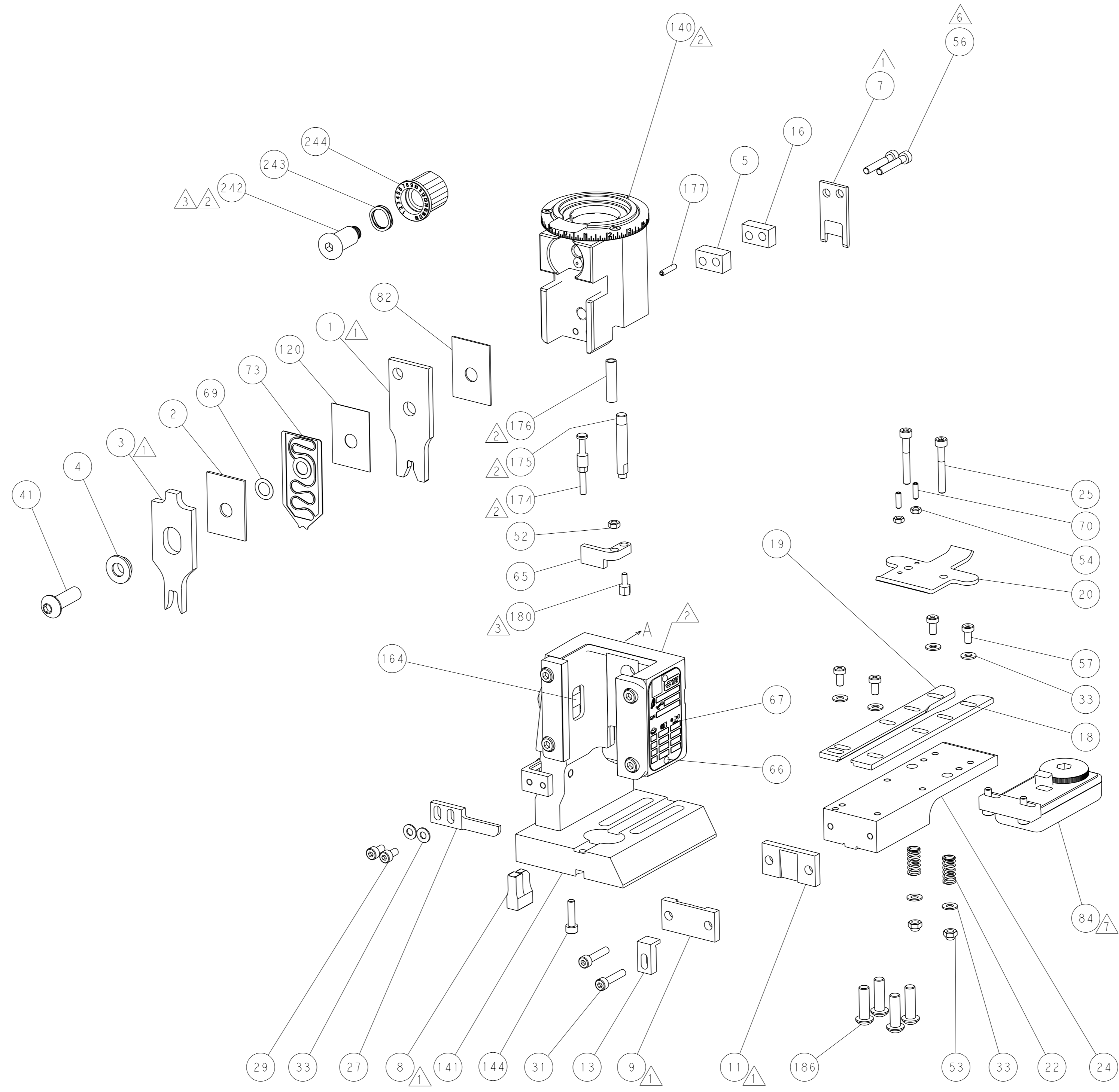
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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE CAGE CODE DRAWING NO A1 00779 C=2150775 SHEET 3 OF 4 REV D

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

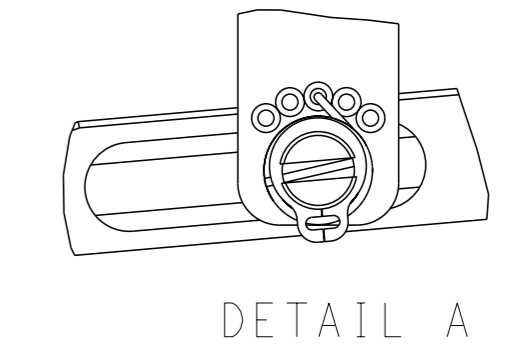


RAM AND HOLDDOWN SET-UP

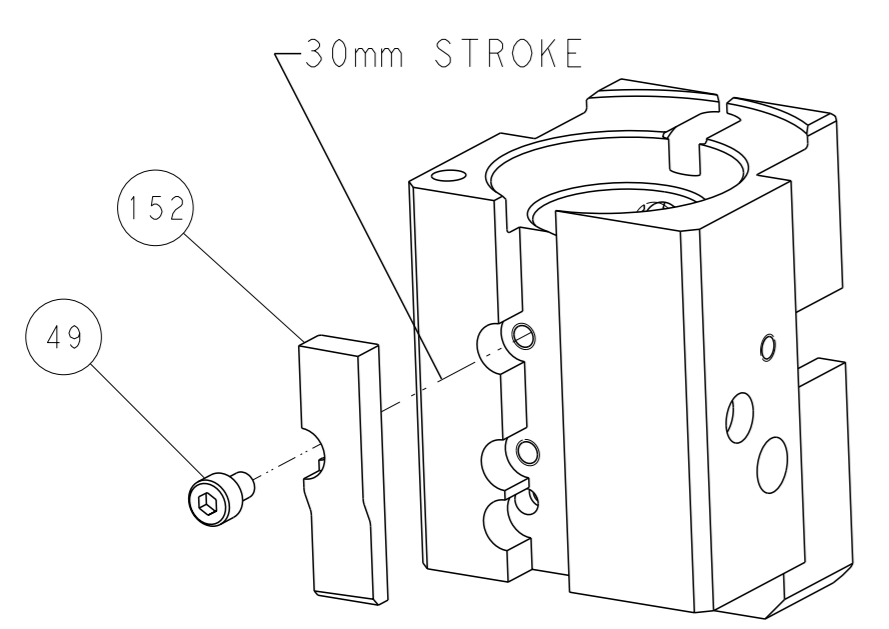
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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 ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	CAGE CODE: 00779 DRAWING NO: C=2150775 WEIGHT: -	RESTRICTED TO: - SHEET 4 OF 4 REV D