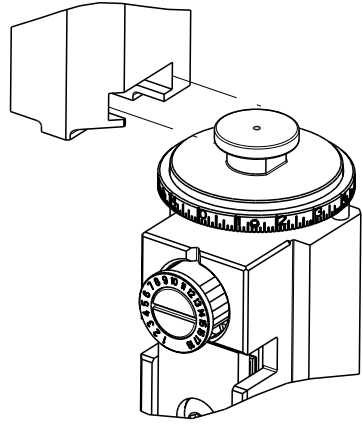


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150774-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150774-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150774-7	A	CRIMP TOOLING KIT	-

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 5.96-6.73 mm [.235-.265 IN]		INSULATION DIAMETER RANGE Ø2.92-3.90 mm [.115-.154 IN]	
TERMINAL APPLICATION SPECIFICATION		B0-245.011A Rev 28/08/02	-
TERMINALS APPLIED			
TE TERMINAL 2303718-1	MTA TERMINAL 17.06720	TE TERMINAL 2303718-2	MTA TERMINAL 17.06730

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		2.70+/-0.05 [1.106+/- .002]		6.0
1.50mm2		2.55+/-0.05 [1.100+/- .002]		7.6
1.00mm2		2.50+/-0.05 [1.098+/- .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.

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

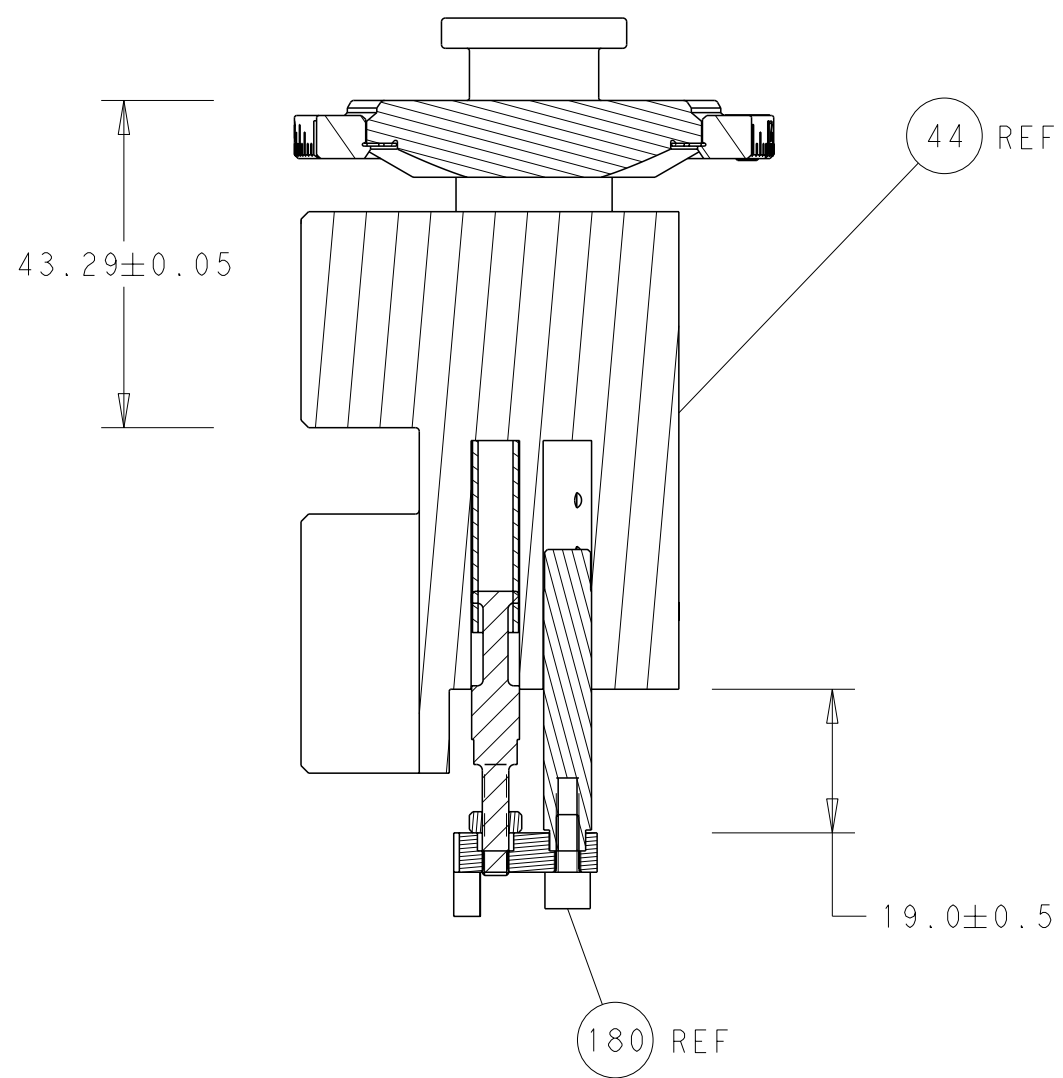
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
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			B	ECR-17-004896	05APR2017	TB	CT
			C	ECR-20-012970	14SEP2020	FJ	TE

	-	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	1	2	1	7-1803059-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-7	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	5-240641-3	SPACER	5
	-	1	1	2-1803409-5	BLOCK, CRIMPER SPACER	4
1	1	2	1	9-1803187-6	CRIMPER, INSULATION F	3
	-	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	1	1-1803325-9	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

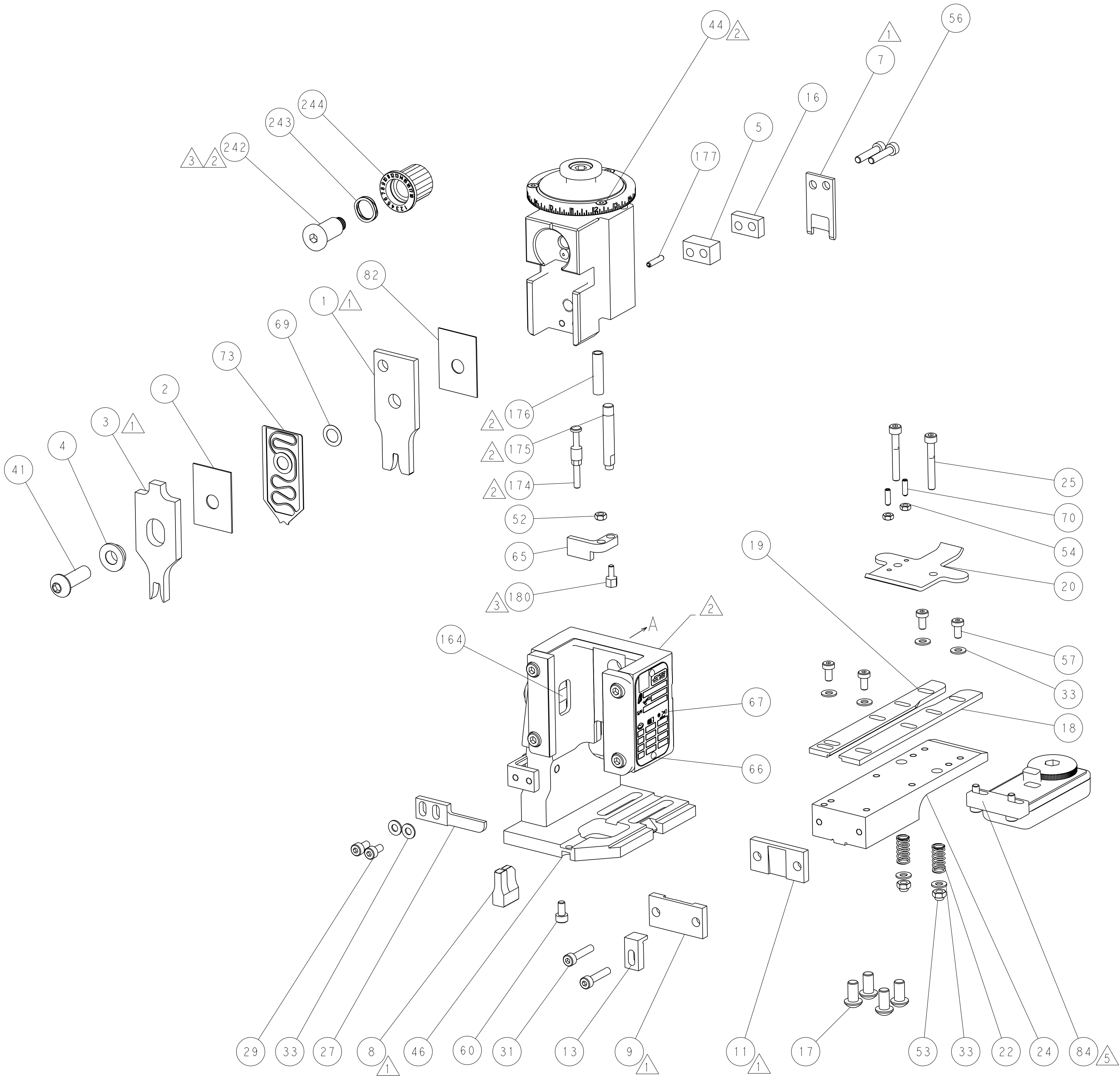
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN M. ZHAO 10FEB2017	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK K. ZHANG 10FEB2017	NAME		
				APVD K. ZHANG 10FEB2017	PRODUCT SPEC		
					APPLICATION SPEC		
MATERIAL -					FINISH -		
					WEIGHT -		
					Customer Accessible Production Drawing		
					SCALE 1:1 SHEET 1 OF 4 REV C		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

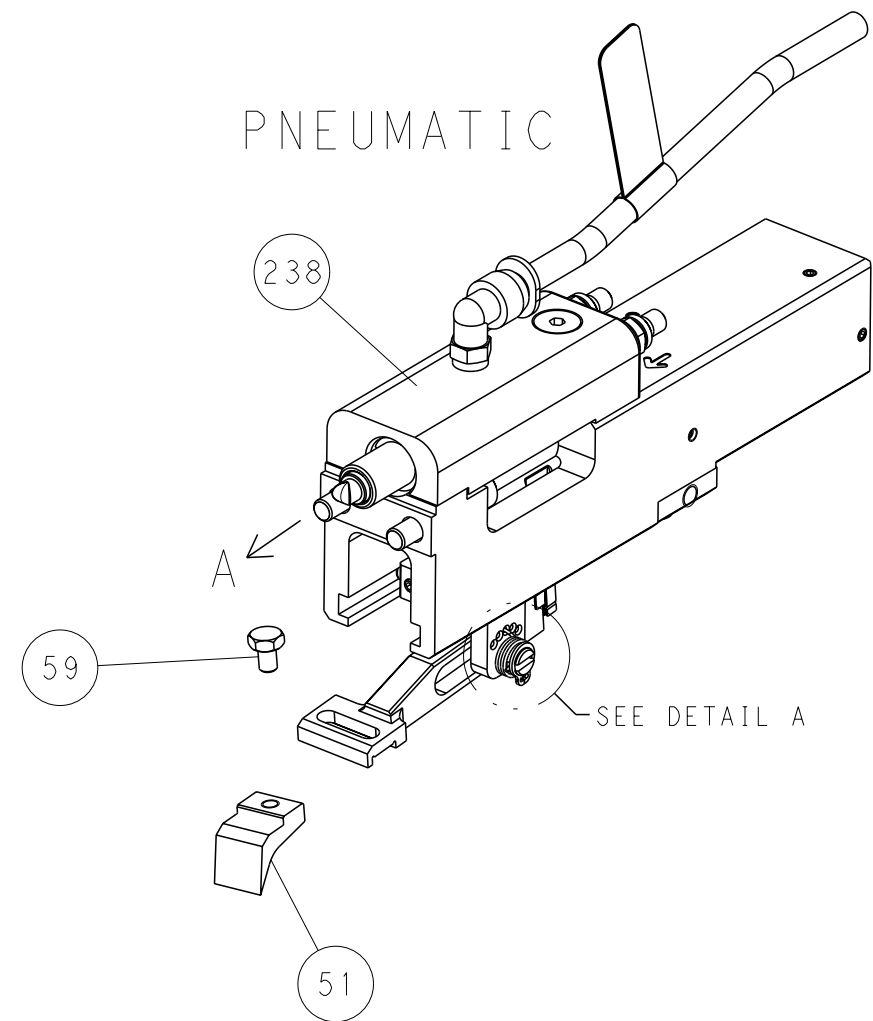
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



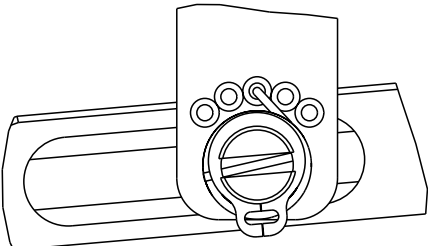
RAM AND HOLDDOWN SET-UP



FEED TYPE

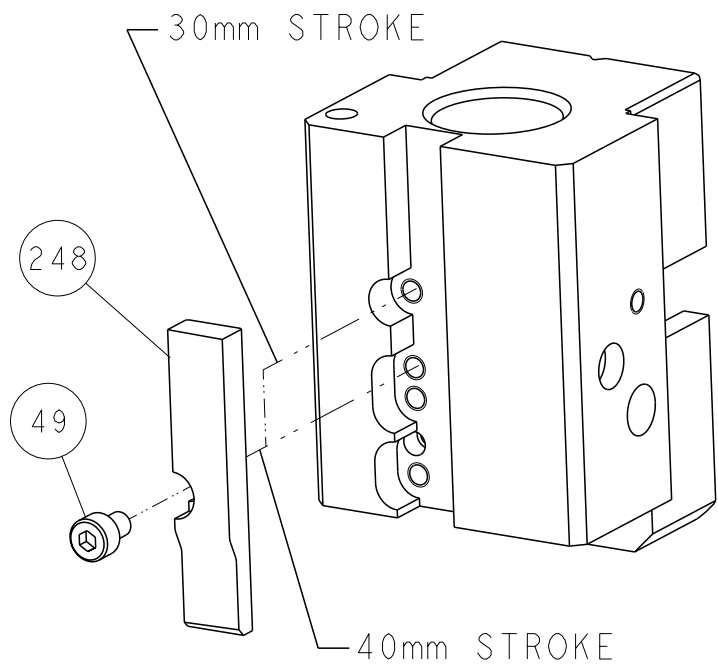


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



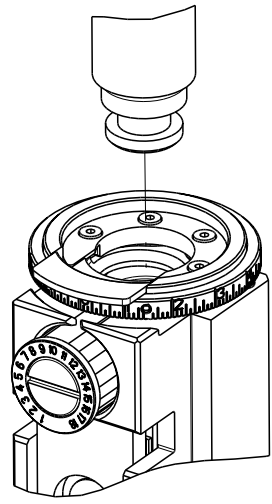
AIR FEED

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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				CHK K. ZHANG	10FEB2017		
				APVD K. ZHANG	10FEB2017	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2150774	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1		SHEET 2 of 4	
						REV C	

8		7	
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20		20	
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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 [.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 5.96-6.73 mm [.235-.265 IN]		INSULATION DIAMETER RANGE Ø2.92-3.90 mm [.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 [.106+/- .002]		6.0
1.50mm2		2.55+/-0.05 [.100+/- .002]		7.6
1.00mm2		2.50+/-0.05 [.098+/- .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.

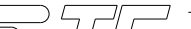
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*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)

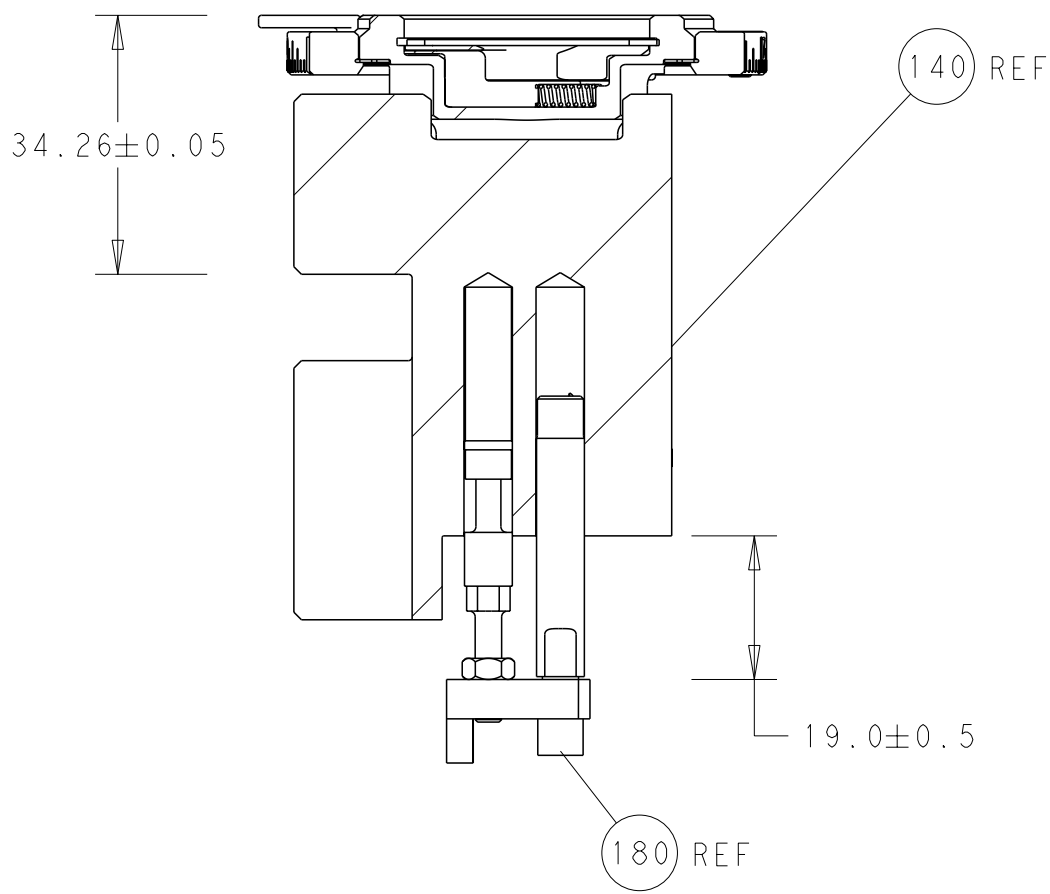
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LOC	DIST	REVISIONS						
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

	-	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

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		SIZE			
		ANGLES		APPLICATION SPEC		CAGE CODE		DRAWING NO	
MATERIAL		FINISH		WEIGHT		A 00779		C=2150774	
-		-		-		-		-	
Customer Accessible Production Drawing						SCALE		1:1	
						SHEET		3 OF 4	
						REV		C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

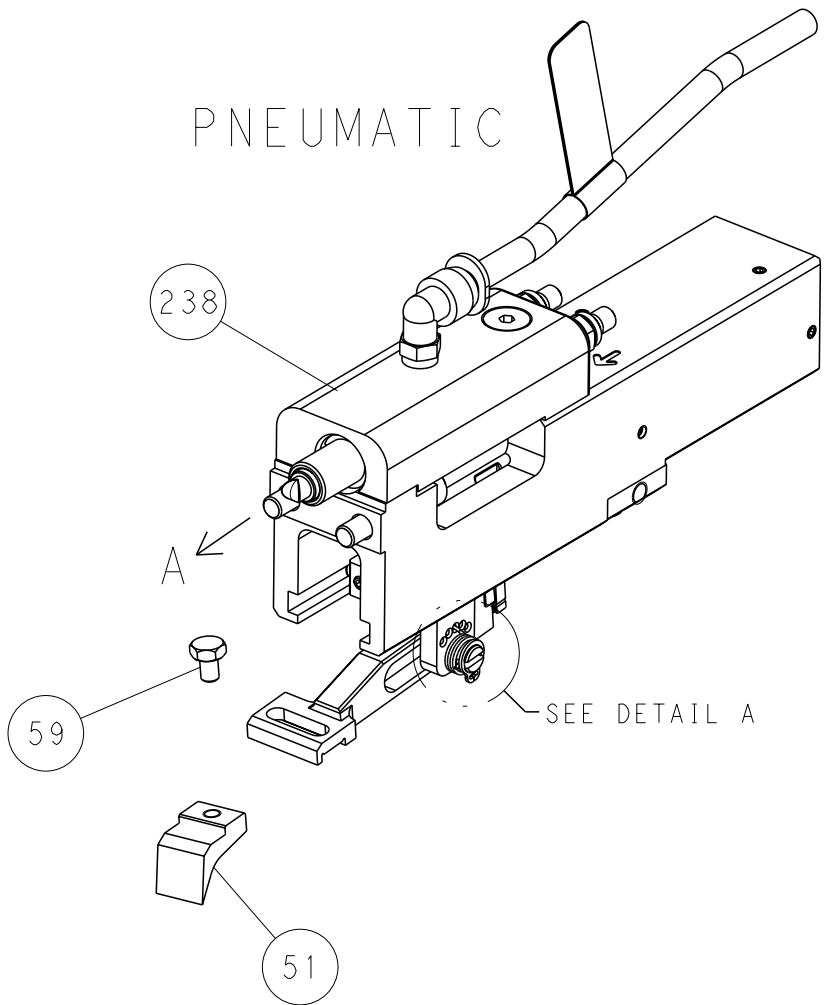
LOC		DIST		REVISIONS					
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				-	-	SEE SHEET 1	-	-	-



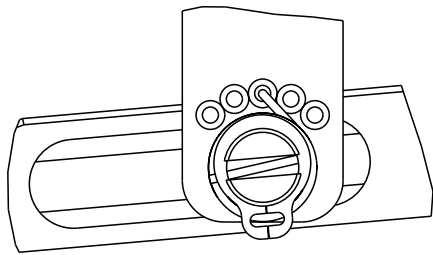
RAM AND HOLDDOWN SET-UP

FEED TYPE

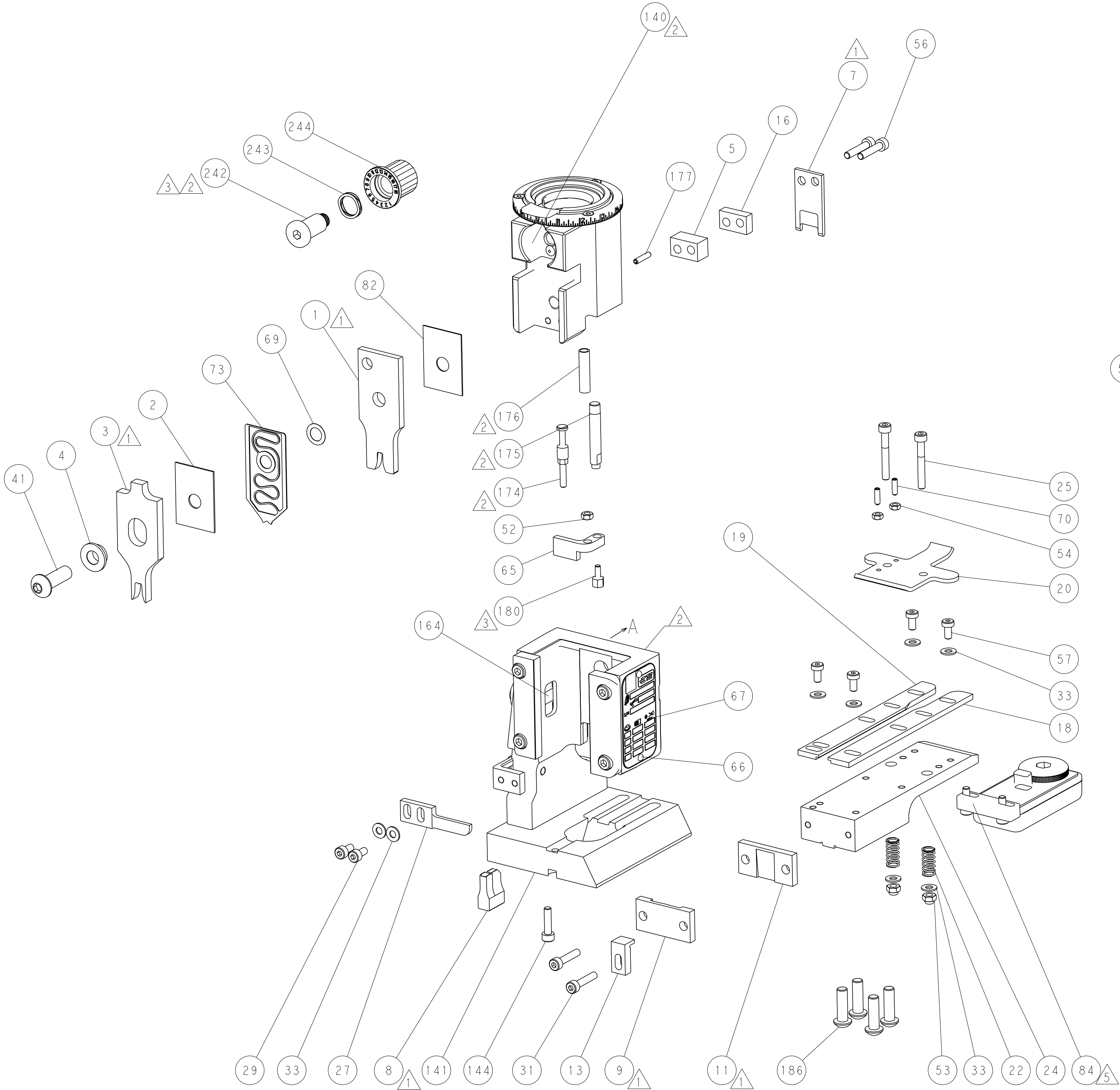
PNEUMATIC



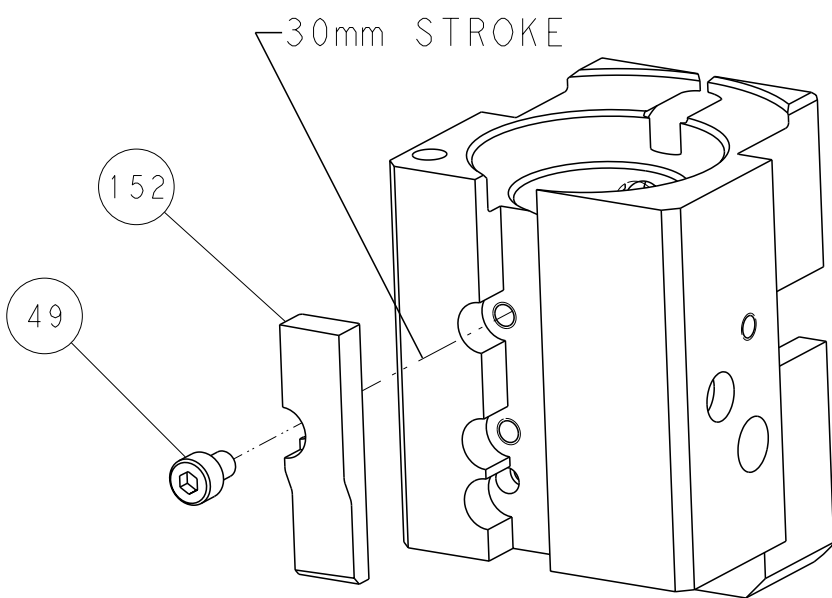
FEED SPRING SETTING POSITION



DETAIL A



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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				CHK K. ZHANG	10FEB2017			
				APVD K. ZHANG	10FEB2017	NAME	Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE	CAGE CODE	DRAWING NO
				APPLICATION SPEC		A1	00779	C=2150774
				WEIGHT		Customer Accessible Production Drawing		SCALE
						1:1	SHEET	4 OF 4
							REV	C

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2150774-2](#)