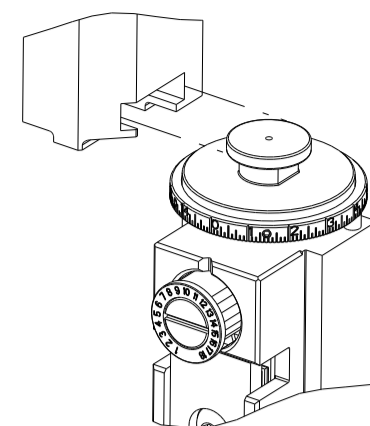


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150399-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150399-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150399-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.18 mm [.125]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PRONER CLIP 8 mm (GAMME 1)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.00-6.80 mm [.236-.268 IN]		∅2.15-3.80 mm [.085-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	PRONER C10657/C1544455		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544455-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.35+/-0.05 [.093+/-0.002]	4.5
1.00mm2	1.85+/-0.05 [.073+/-0.002]	9.0



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

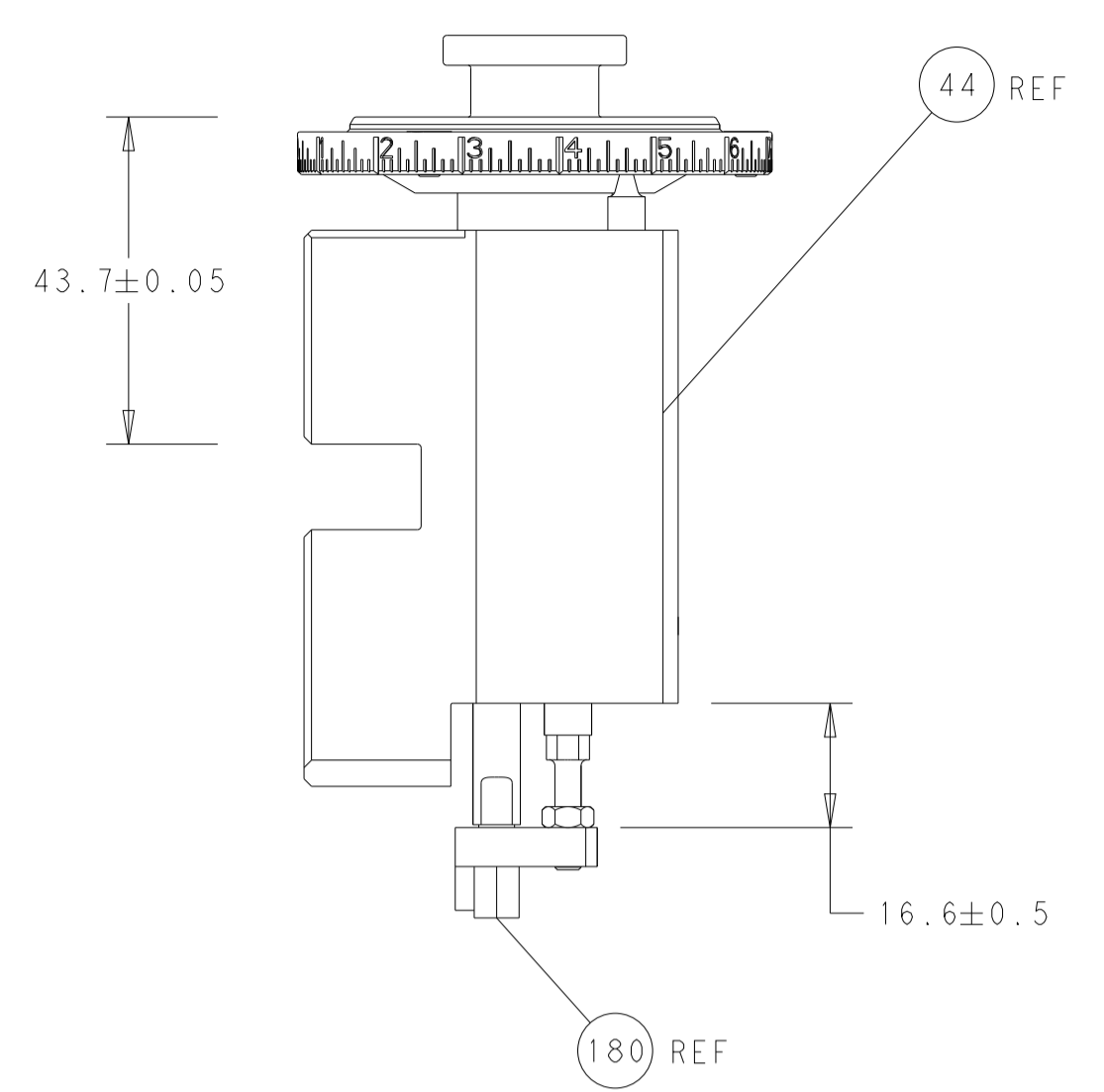
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		B		ECR-21-006868	14JUL2021	JAH	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	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	1-18028-0	WASHER, FLAT, REG M8	192	
	1	1	1-1752354-2	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	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-5	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	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	
-	7	7	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	2-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-5	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	1	240833-4	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	2-690495-2	PLATE, FRONT SHEAR	9	
	1	2	1333226-9	ANVIL EF SPECIAL	8	
	1	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-7	SPACER	5	
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	1	5-1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2	
	1	2	1	5-1633305-0	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO		
-				DESCRIPTION	ITEM NO	

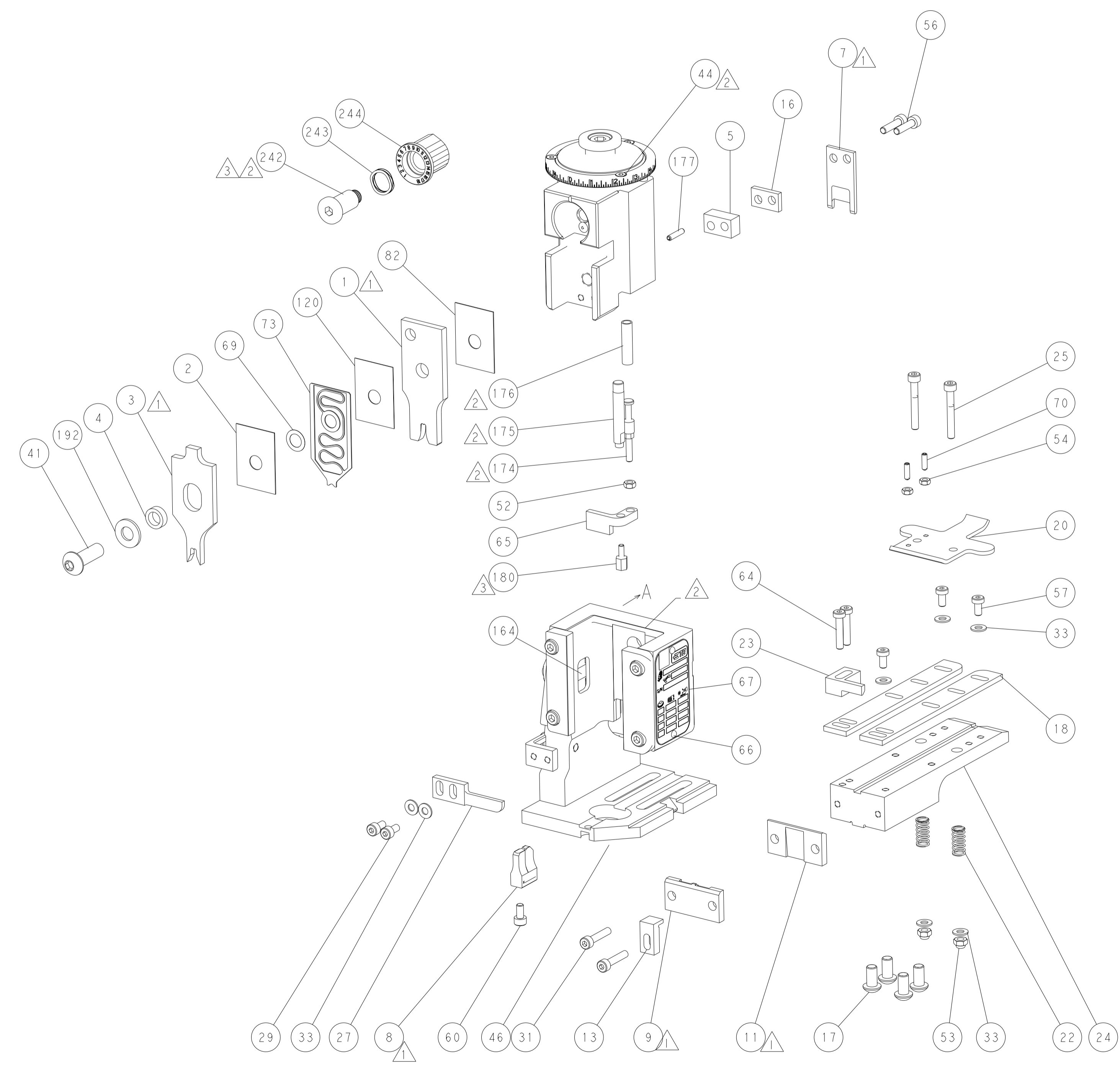
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	1	4	B	

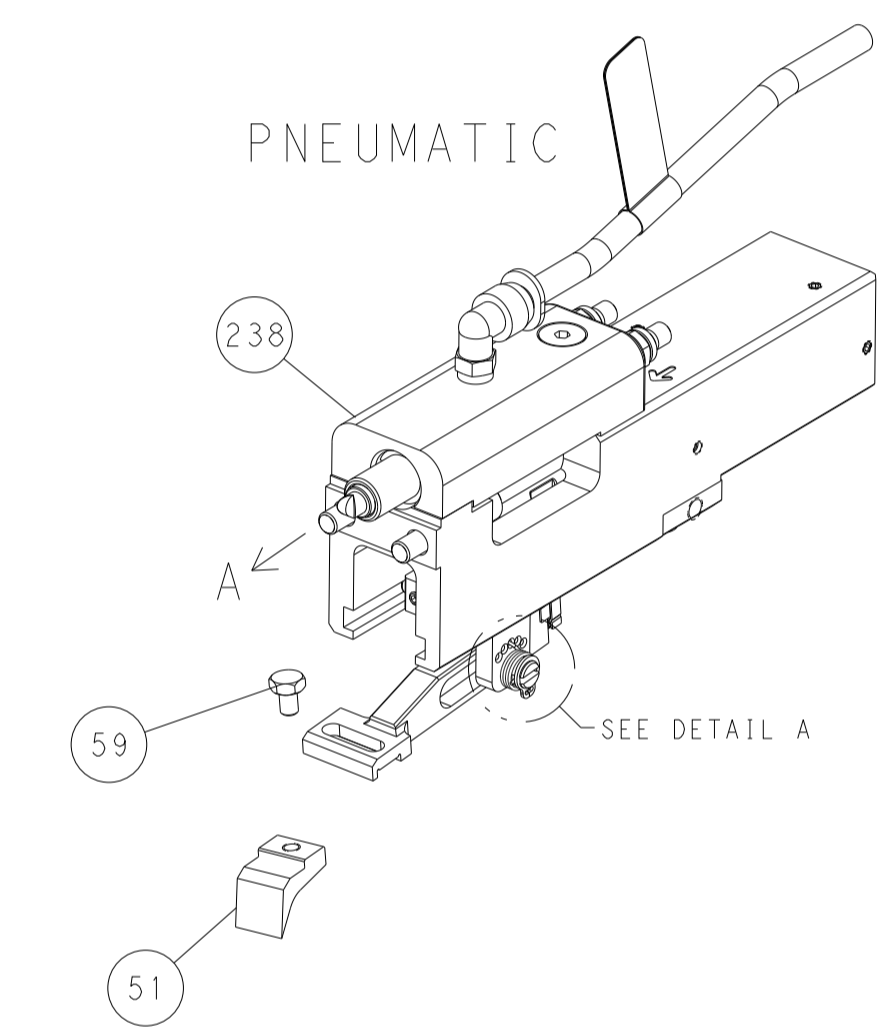
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1			



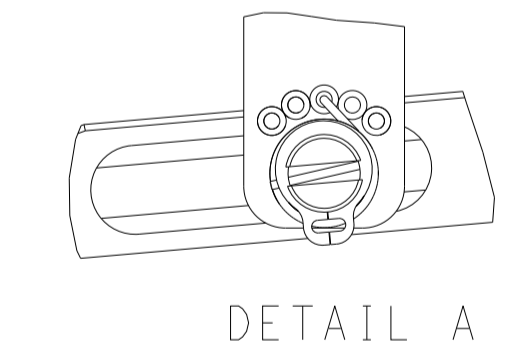
RAM AND HOLDDOWN SET-UP



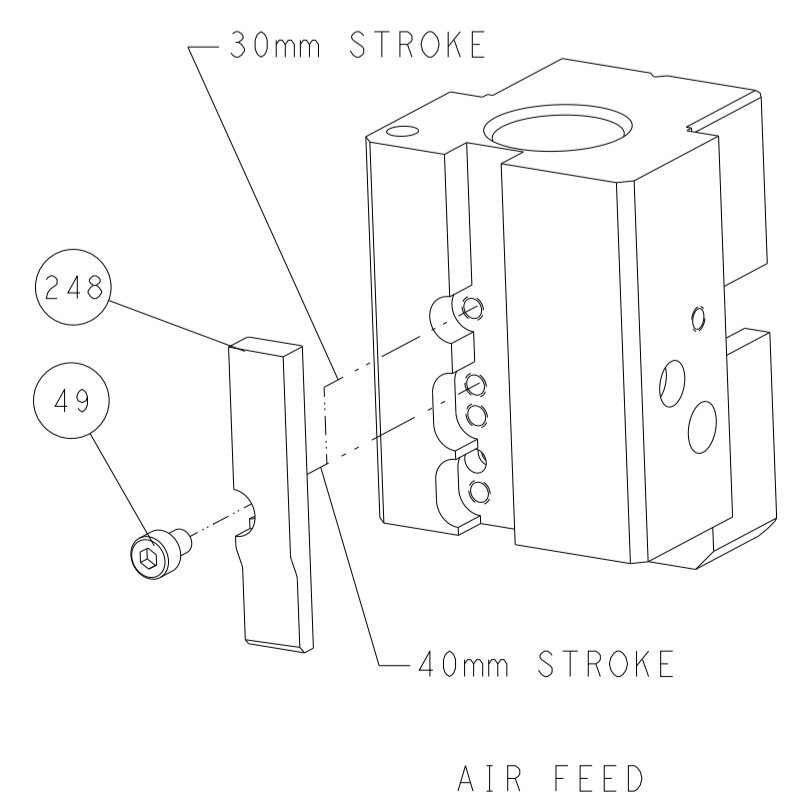
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



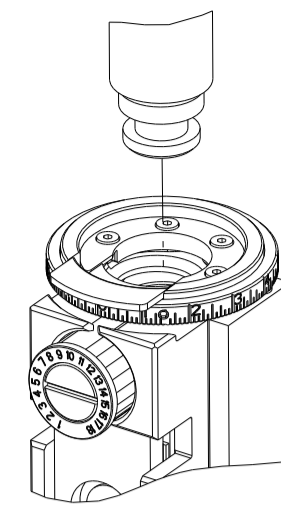
AIR FEED

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

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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 Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150399 SCALE: 1:1 SHEET: 2 of 4 REV: B	RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150399-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150399-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.18 mm [ .125 ]	F
INSUL	4.06 mm [ .160 ]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PRONER CLIP 8 mm (GAMME 1)			
WIRE STRIP LENGTH 6.00-6.80 mm [ .236-.268 IN ]		INSULATION DIAMETER RANGE Ø2.15-3.80 mm [ .085-.150 IN ]	
TERMINAL APPLICATION SPECIFICATION PRONER C10657/C1544455			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544455-1			

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
3.00mm <sup>2</sup>	2.35+/-0.05 [ .093+/- .002 ]	4.5
1.00mm <sup>2</sup>	1.85+/-0.05 [ .073+/- .002 ]	9.0

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

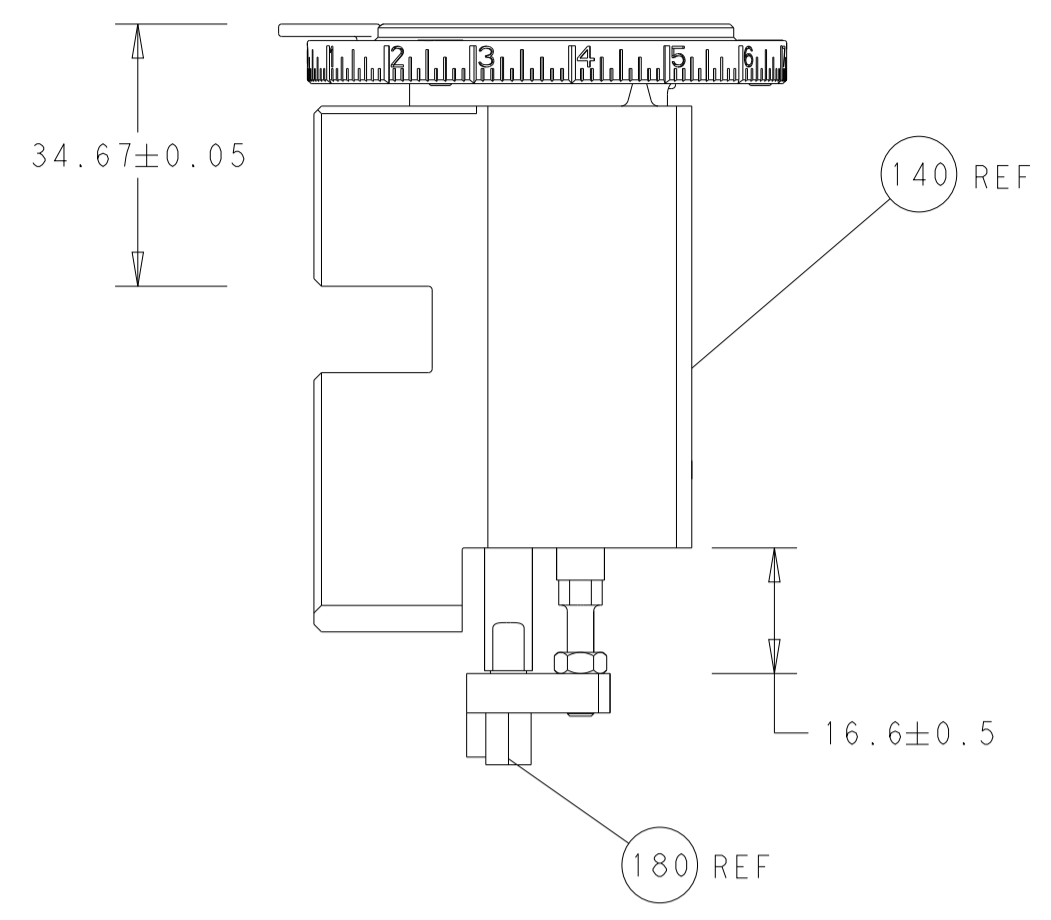
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

	-	1	2119082-7	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
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
△	-	1	1-1752354-2	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
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	2119791-5	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
	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
	-	7	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	2-1752371-2	PLATE, STRIP GUIDE	24
	-	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-1	DRAG	20
	-	2	1901259-6	GUIDE, LOWER STRIP	18
	-	1	240641-5	SPACER	16
	-	1	1752360-1	SPACER, HOLD-DOWN	13
△	-	1	240833-4	PLATE, REAR SHEAR	11
	-	-	-	-	10
△	-	1	2-690495-2	PLATE, FRONT SHEAR	9
△	1	1	1333226-9	ANVIL EF SPECIAL	8
△	-	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	6
	-	1	4-240641-7	SPACER	5
	-	1	4-238011-2	BLOCK, CRIMPER SPACER	4
△	1	1	5-1633962-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-4	SPACER, CRIMPER	2
△	1	1	5-1633305-0	CRIMPER, WIRE PREMIUM	1
	-	77-22	PART NO	DESCRIPTION	ITEM NO

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

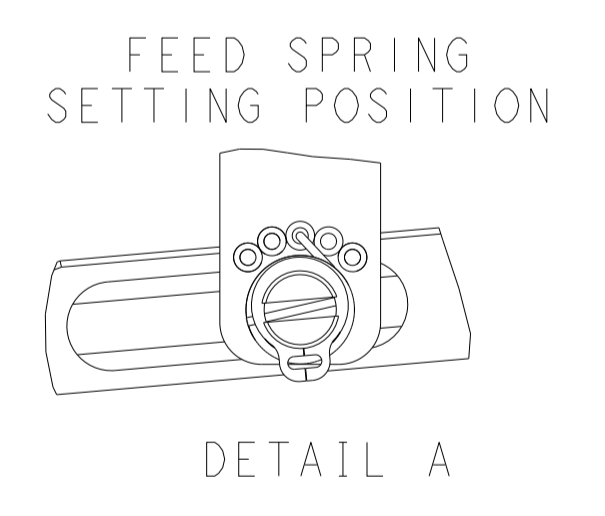
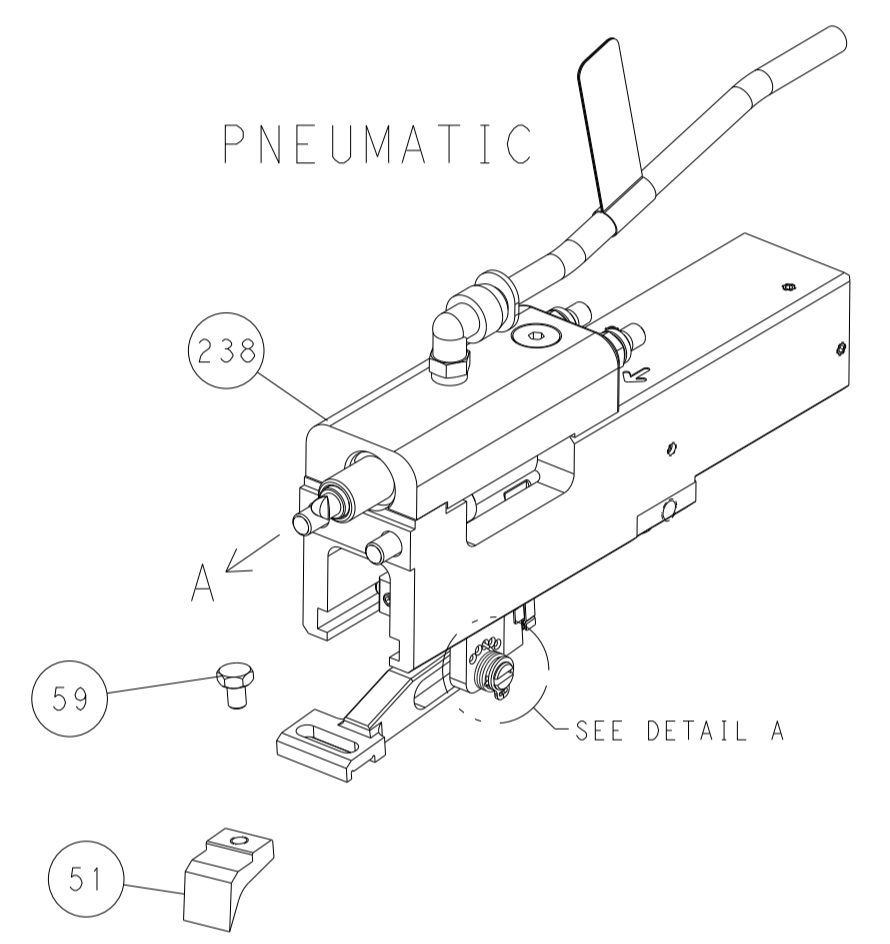
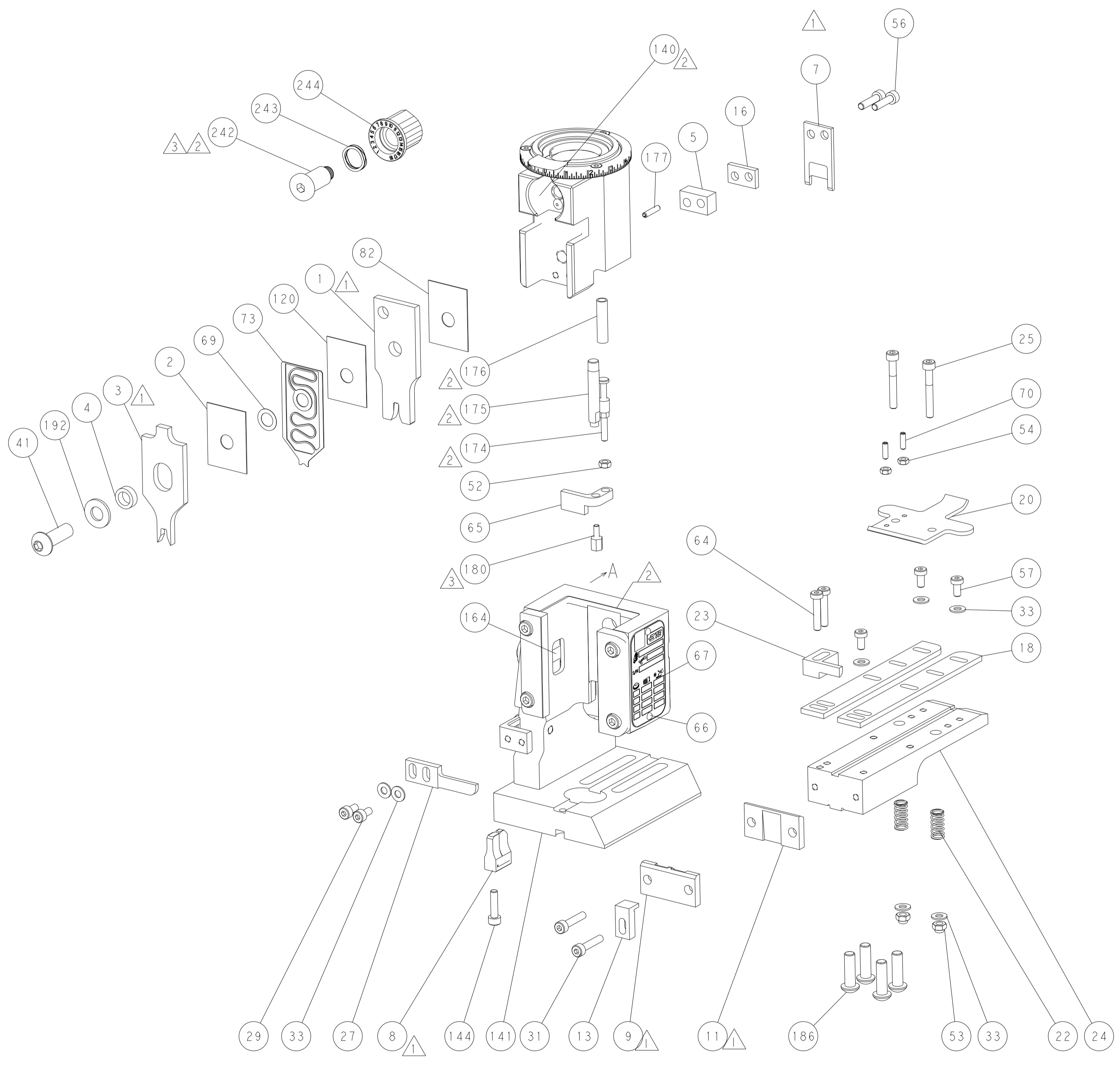
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1 PLC	±	1 PLC	±	00779	26NOV2013
2 PLC	±	2 PLC	±	00779	26NOV2013
3 PLC	±	3 PLC	±	00779	26NOV2013
4 PLC	±	4 PLC	±	00779	26NOV2013
ANGLES	±	ANGLES	±	00779	26NOV2013
FINISH	±	FINISH	±	00779	26NOV2013
MATERIAL		WEIGHT		SCALE	
				1:1	
Customer Accessible Production Drawing		SCALE		SHEET 3 OF 4	
				REV B	

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-

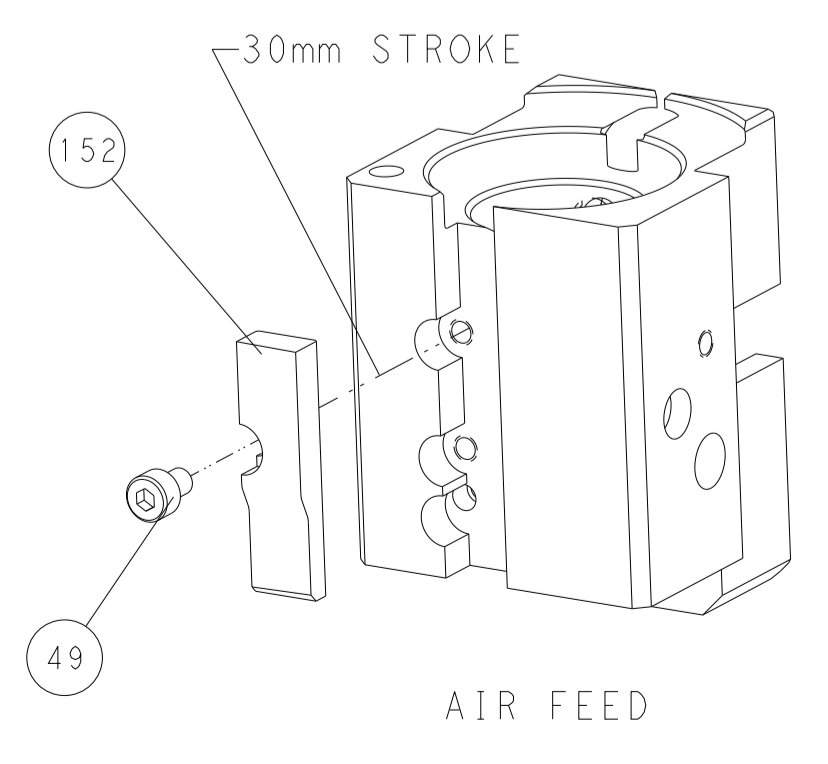


RAM AND HOLDDOWN SET-UP

FEED TYPE



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 ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1 SHEET: 4 OF 4 REV: B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1 SHEET: 4 OF 4 REV: B	RESTRICTED TO: B