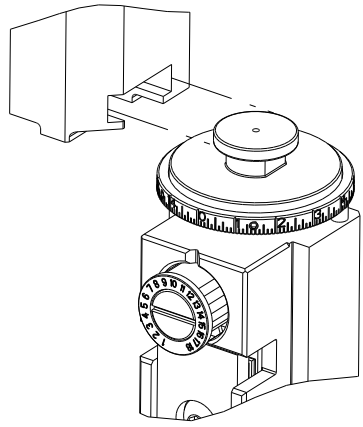


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150399-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150399-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150399-7	A	CRIMP TOOLING KIT	-

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 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		△6	
TE TERMINAL 1544455-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.35+/-0.05 [.093+/- .002]	4.5
1.00mm2	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.

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

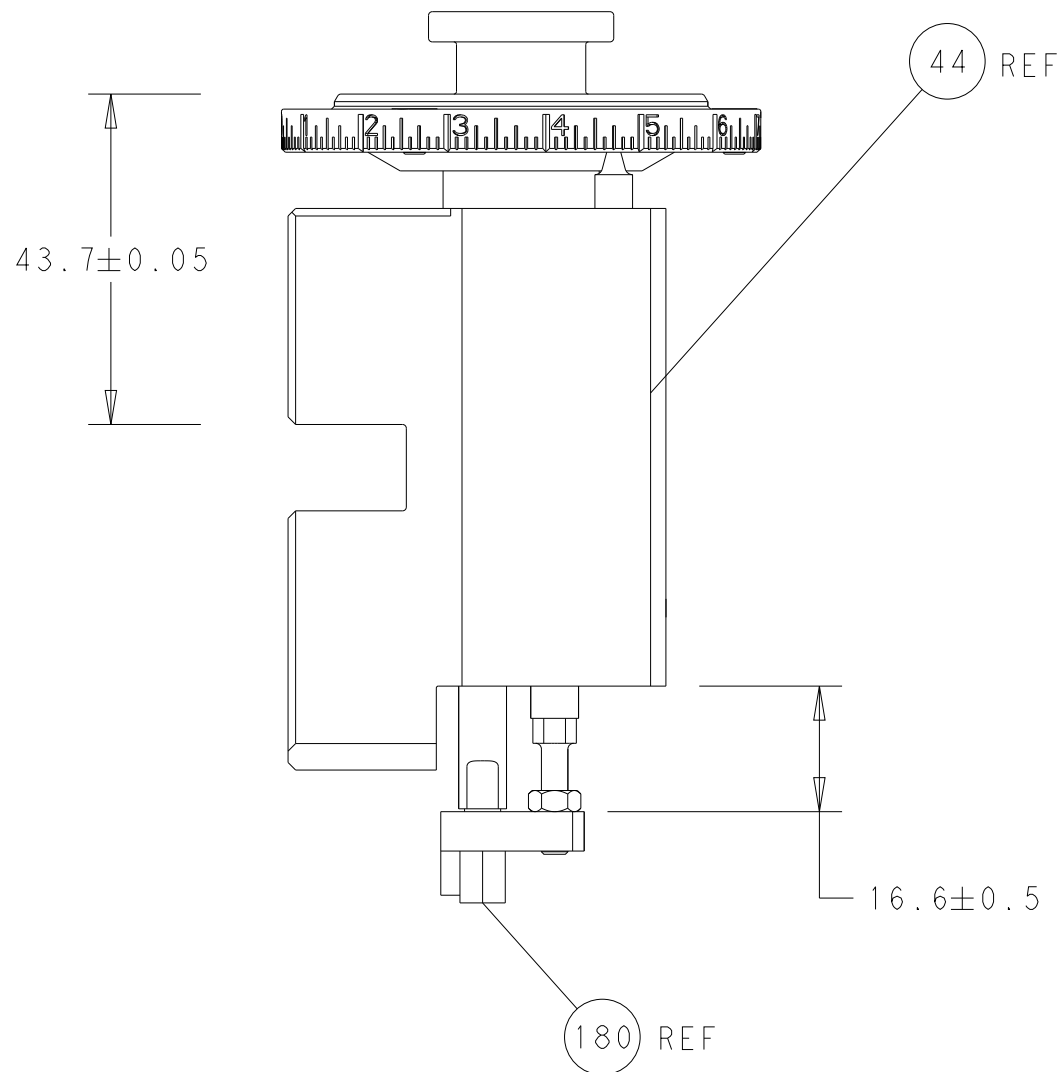
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		B		ECR-21-006868	14JUL2021

	-	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
3	-	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
3	-	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	1	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

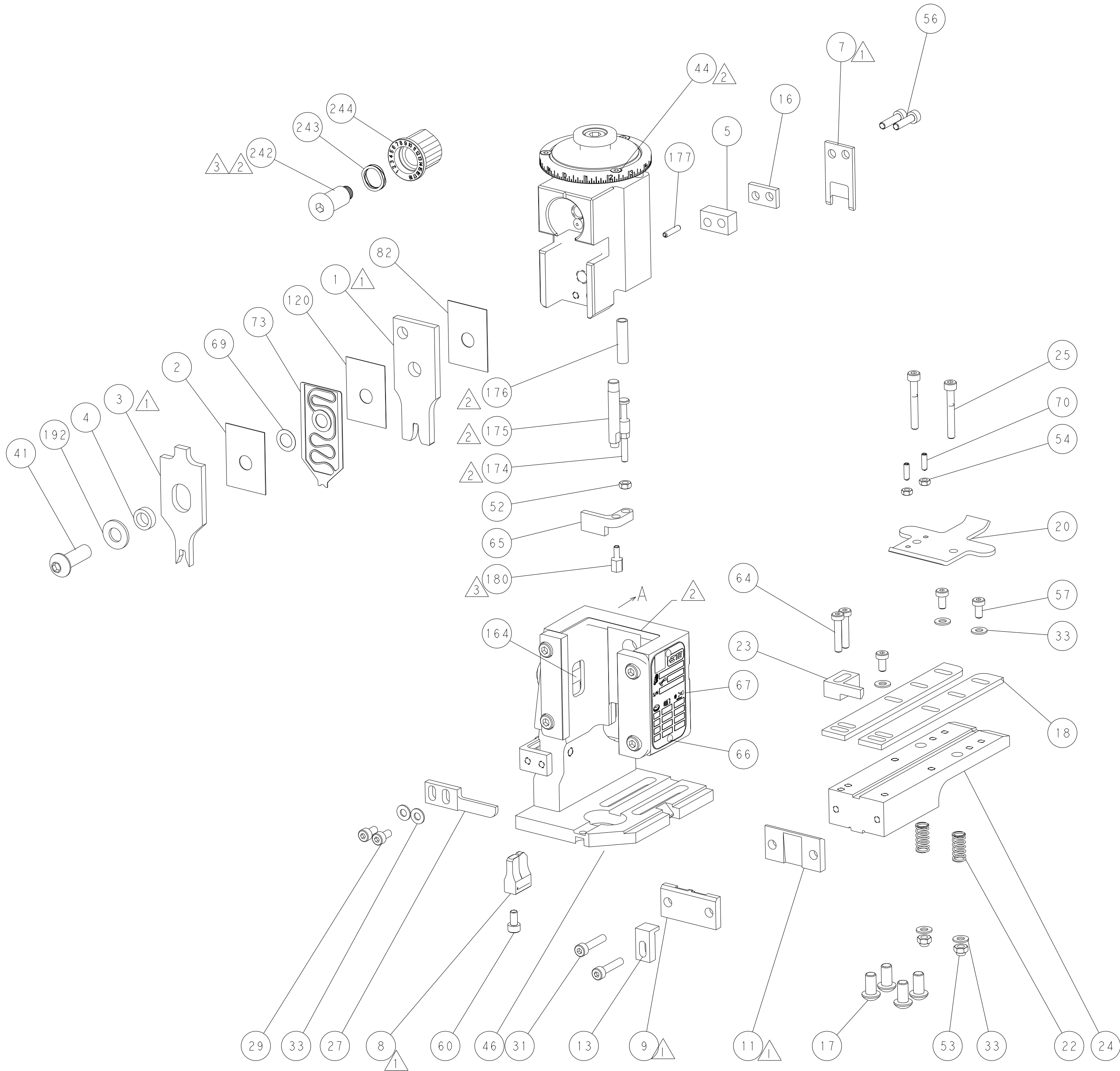
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST EDITION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	26NOV2013 26NOV2013 26NOV2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A	
				CAGE CODE 00779	
				DRAWING NO 2150399	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 1	
				OF 4	
				REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

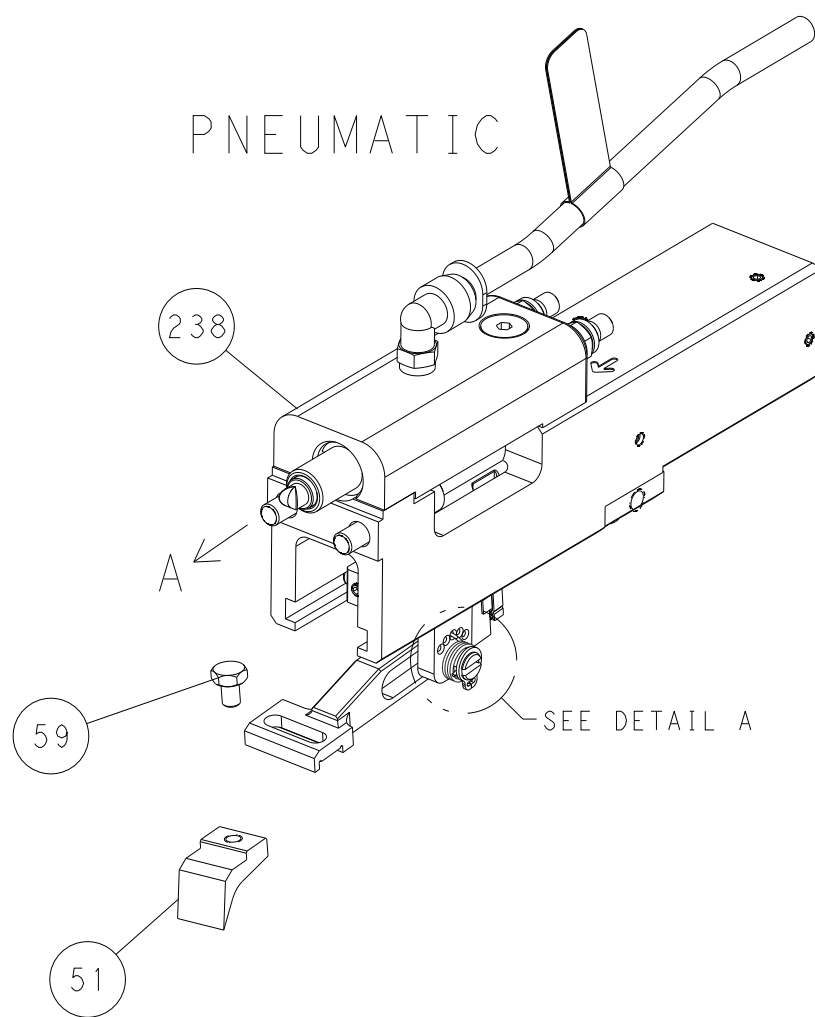
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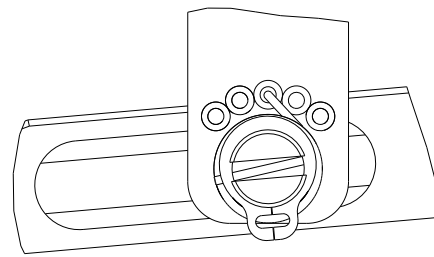
RAM AND HOLDDOWN SET-UP



FEED TYPE

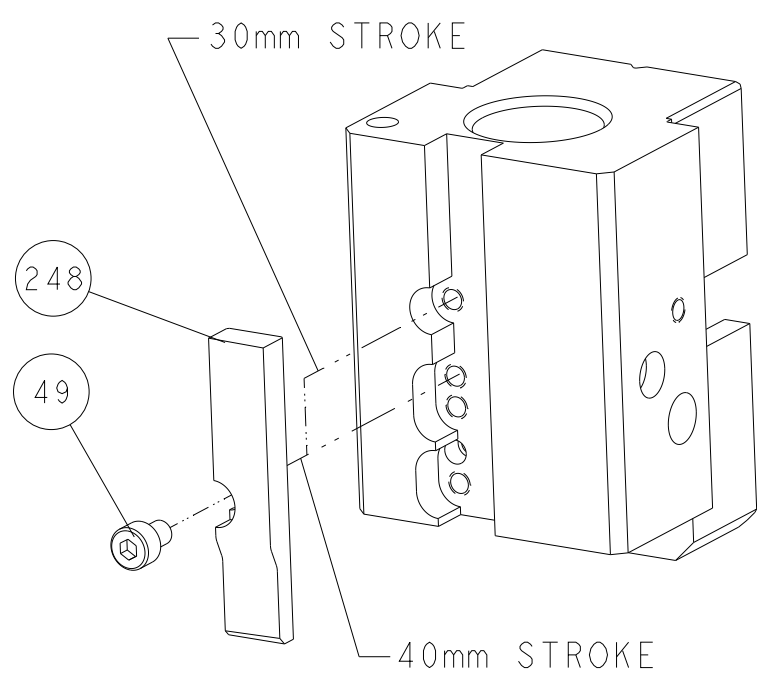


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



AIR FEED

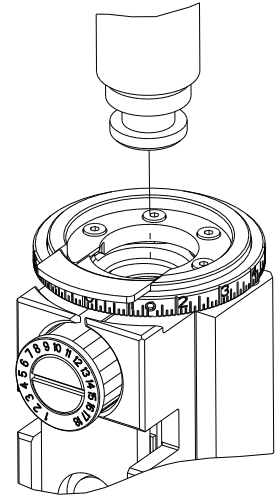
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK L. ZHANG 26NOV2013		NAME		
APVD J. GUO 26NOV2013		PRODUCT SPEC	Ocean End Feed Applicator	
		APPLICATION SPEC		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	SIZE A1	
		0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH	CAGE CODE 00779	
MATERIAL -		WEIGHT -	DRAWING NO C=2150399	
		Customer Accessible Production Drawing		RESTRICTED TO -
		SCALE 1:1	SHEET 2	REV B

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

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 1544455-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
3.00mm2		2.35+/-0.05 [.093+/- .002]		4.5	
1.00mm2		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.
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.

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

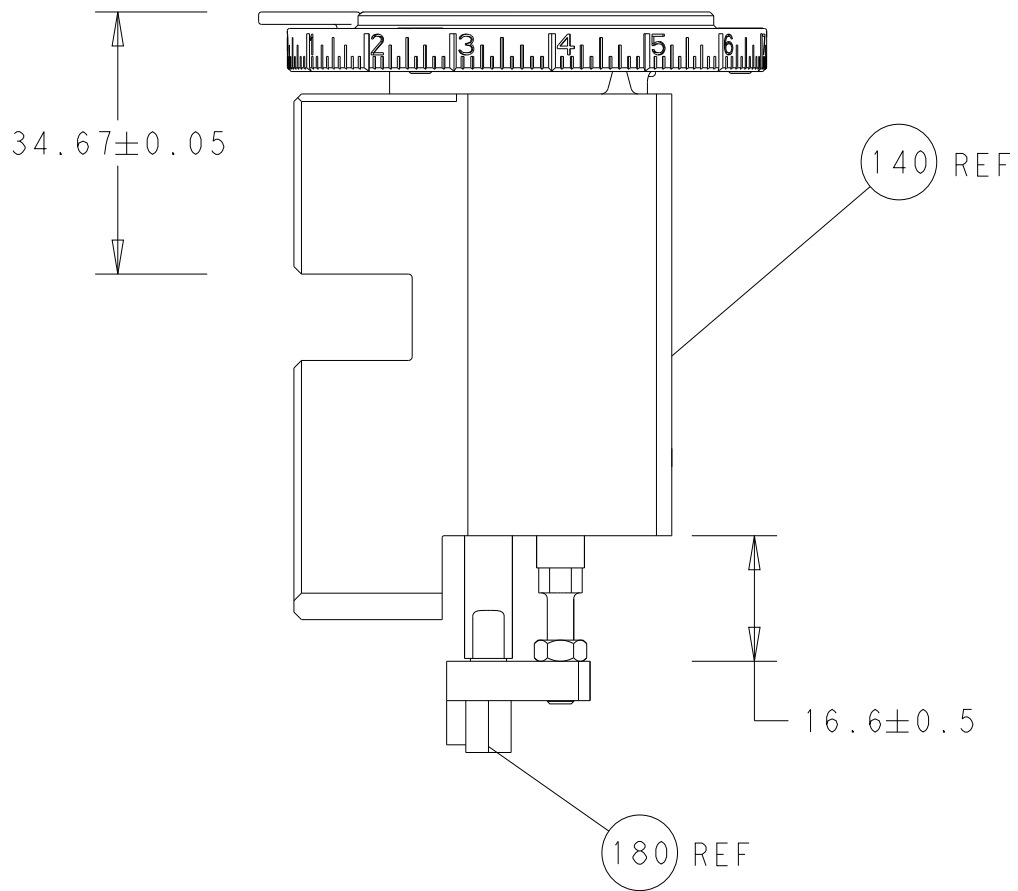
LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

	-	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

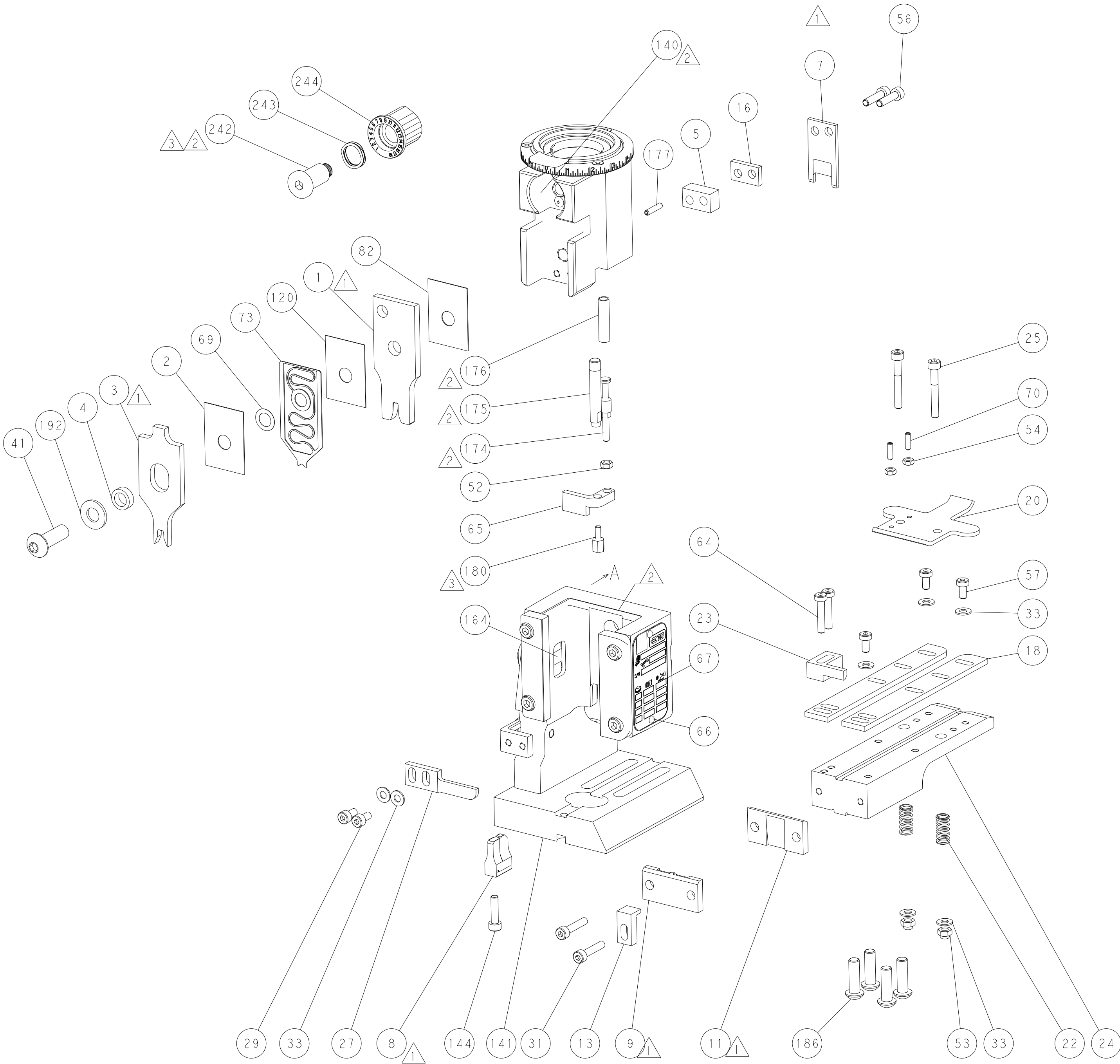
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A	
				CAGE CODE 00779	
				DRAWING NO C=2150399	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3	
				OF 4	
				REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

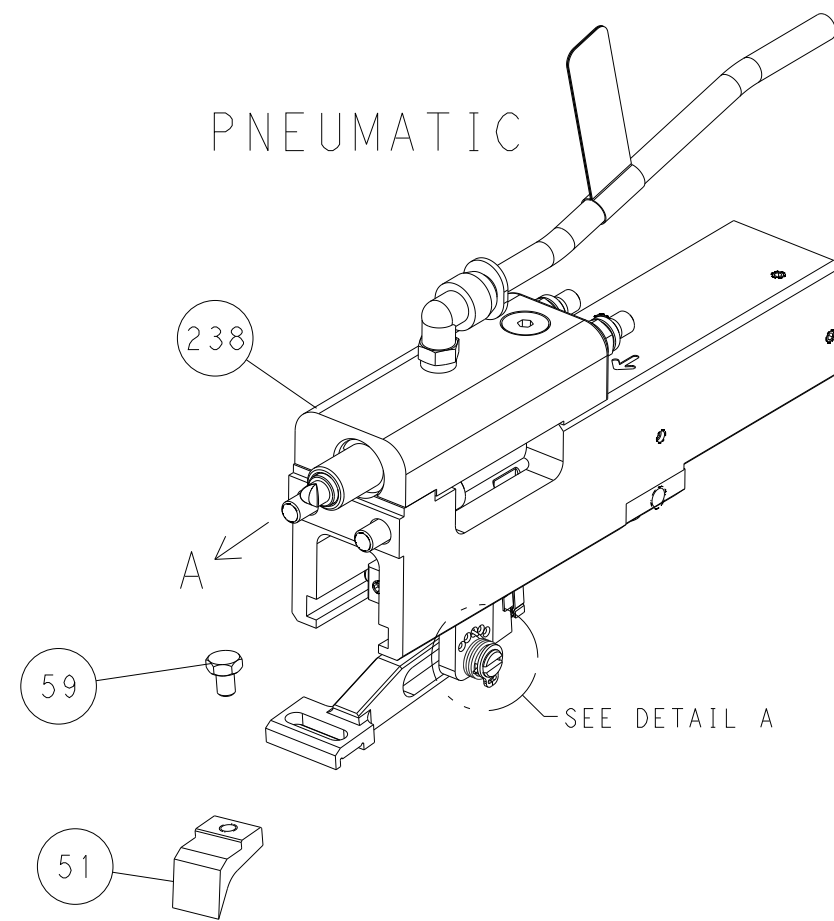
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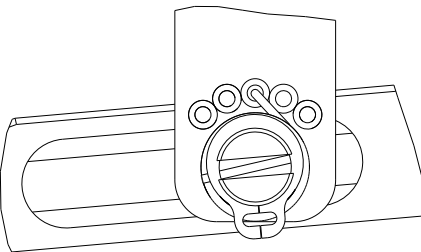
RAM AND HOLDDOWN SET-UP



FEED TYPE

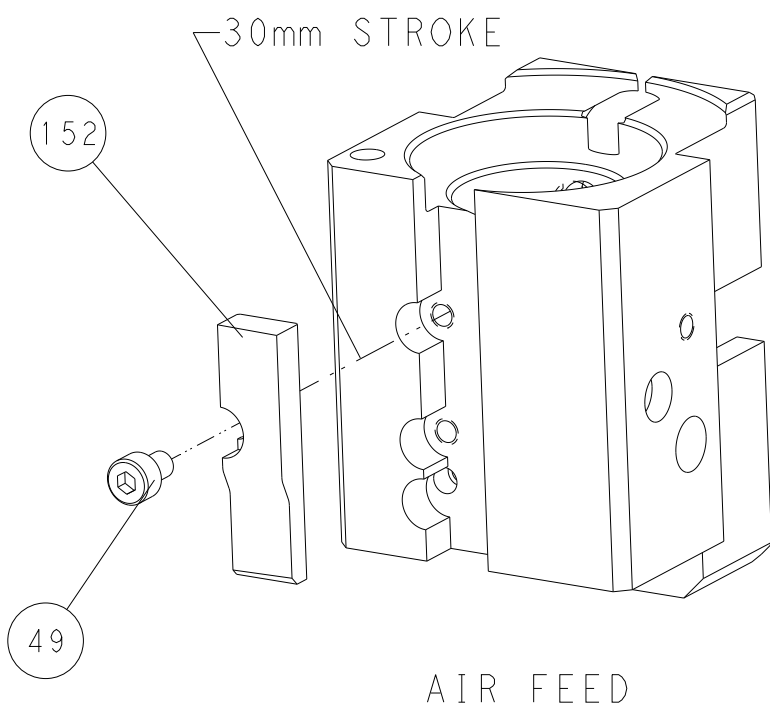


FEED SPRING SETTING POSITION



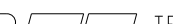
DETAIL A

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	L. ZHANG	26NOV2013					
										APVD	J. GUO	26NOV2013	NAME				
										PRODUCT SPEC				Ocean End Feed Applicator			
										APPLICATION SPEC							
										WEIGHT				SIZE			
										Customer Accessible Production Drawing							
										SCALE				SHEET			
										1:1				4 of 4			
										REV				B			