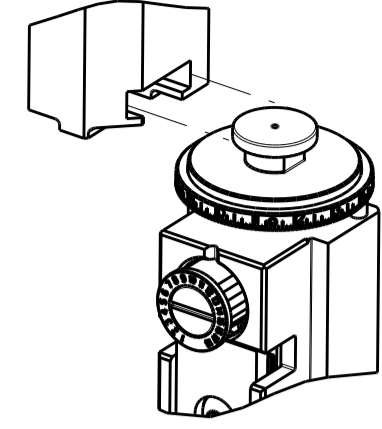


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151973-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151973-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151973-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
7-2151973-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151973-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151973-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm (.050)	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, HF FAKRA 2, RTK031			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.30-2.70 mm (.091-.106 IN)		∅	
TERMINAL APPLICATION SPECIFICATION		114-18622	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418972-1	1418973-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.53mm2	0.93+/-0.03 [.037+/- .001]	7.0
0.35mm2	0.81+/-0.03 [.032+/- .001]	8.2

- ¹ RECOMMENDED SPARE PARTS
- ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ³ 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.
- ⁴ TERMINAL LUBRICANT IS RECOMMENDED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⁶ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

***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	REV	DATE	BY	APPV
		C	ECR-17-014825	09OCT2017	MZ KZ
		D	ECR-19-006462	23APR2019	FJ TE
		E	ECR-19-007109	03MAY2019	LG TE
		F	ECR-20-009518	03JUL2020	FZ TE

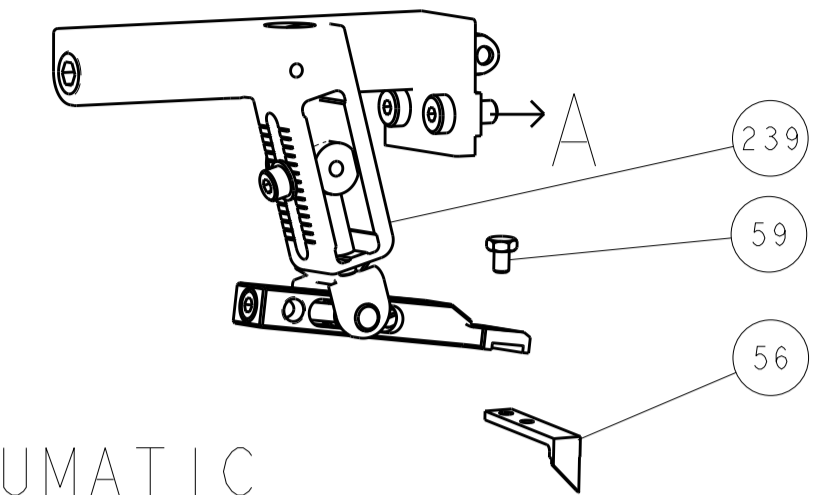
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	82
-	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-8	HOLDER, INS	74
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	3-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	2-1633733-2	ANVIL, WIRE	8
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	2
-	1	2	2	1	1	1803212-1	CRIMPER, WIRE PREMIUM	1

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE CONTROLLED AND DISTRIBUTION IS RESTRICTED TO THE EXTENT SPECIFIED HEREIN. IT IS TO BE CONTROLLED AND DISTRIBUTION IS RESTRICTED TO THE EXTENT SPECIFIED HEREIN.</small>		DWN R. O. WILSON 17JUN2013 CHK K. J. STAKEM 18JUN2013 APPV T. L. ELBIN 18JUN2013	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 Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151973 Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV F

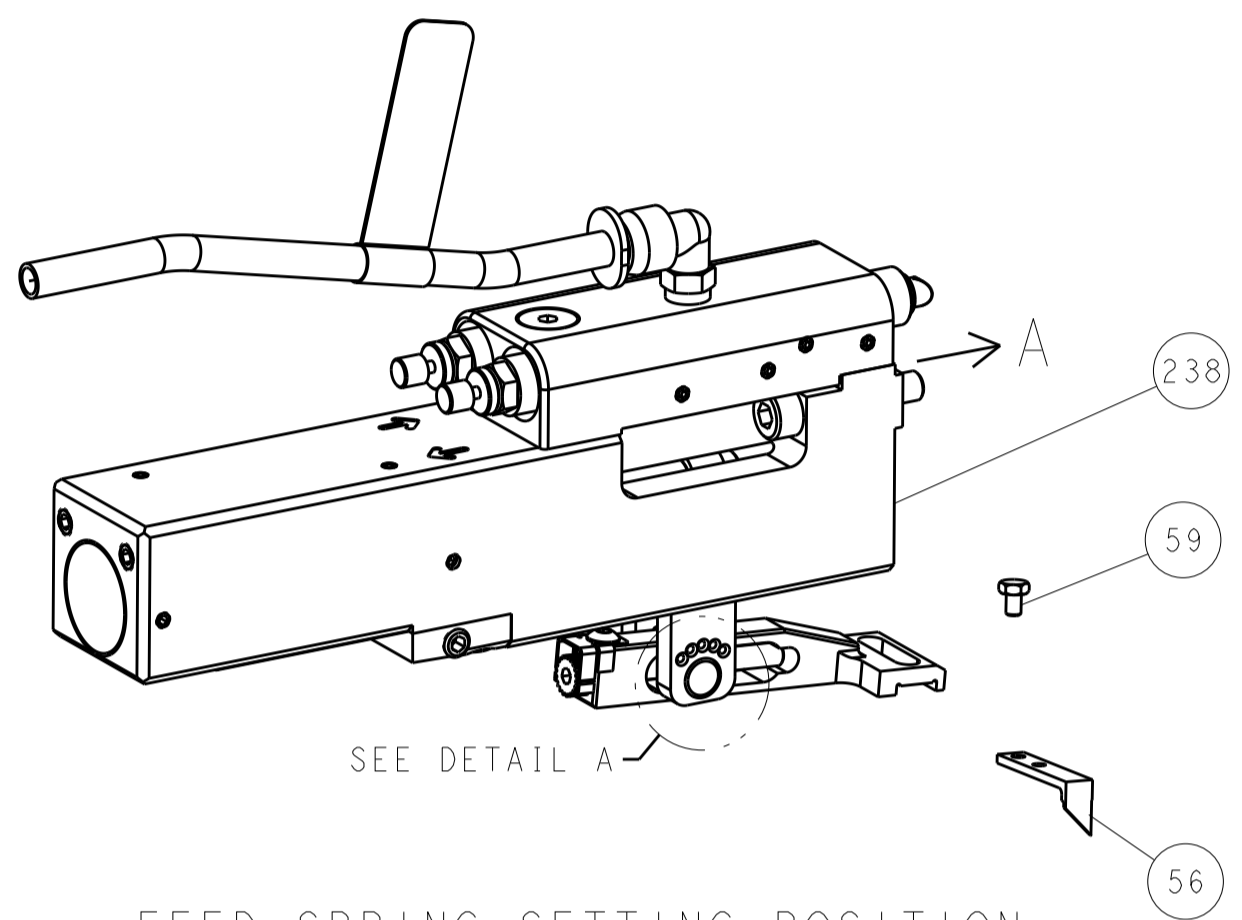
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
REV	DATE	BY	APPV
-	-	-	-
-	-	-	-

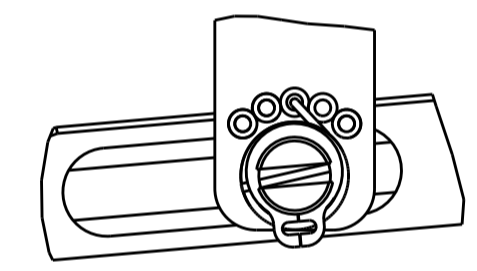
FEED TYPE MECHANICAL



PNEUMATIC

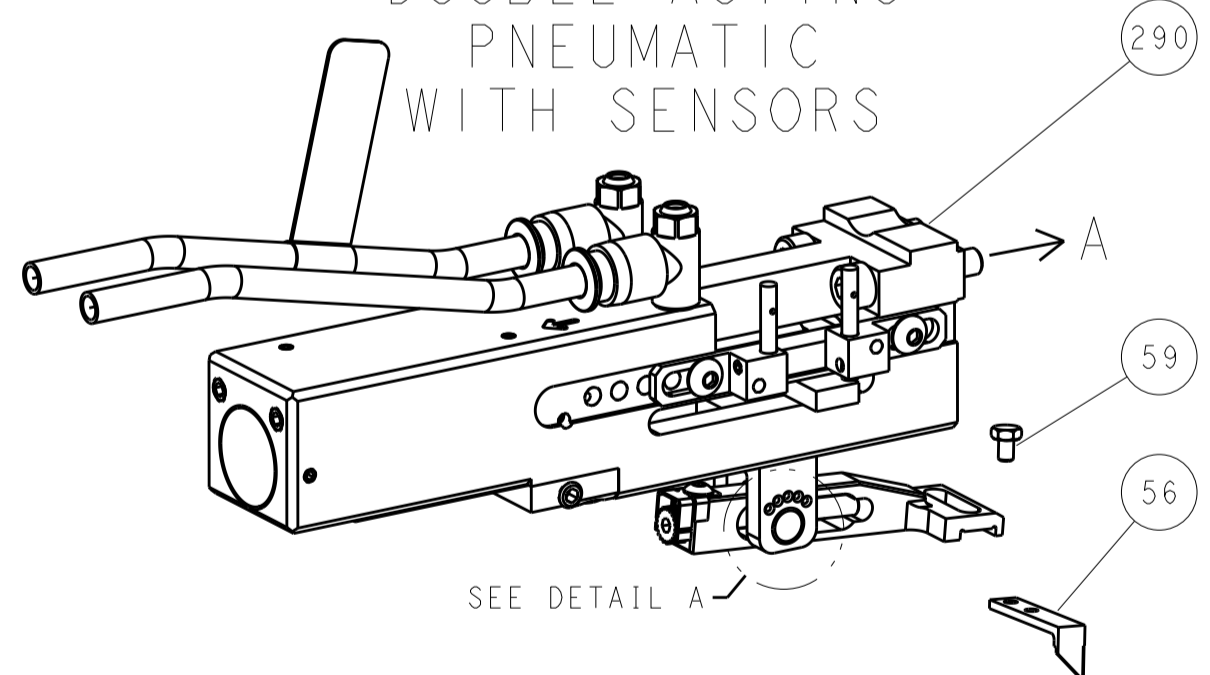


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



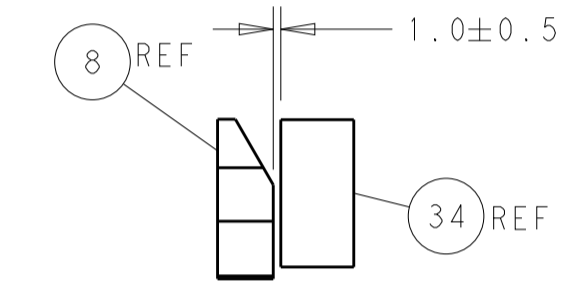
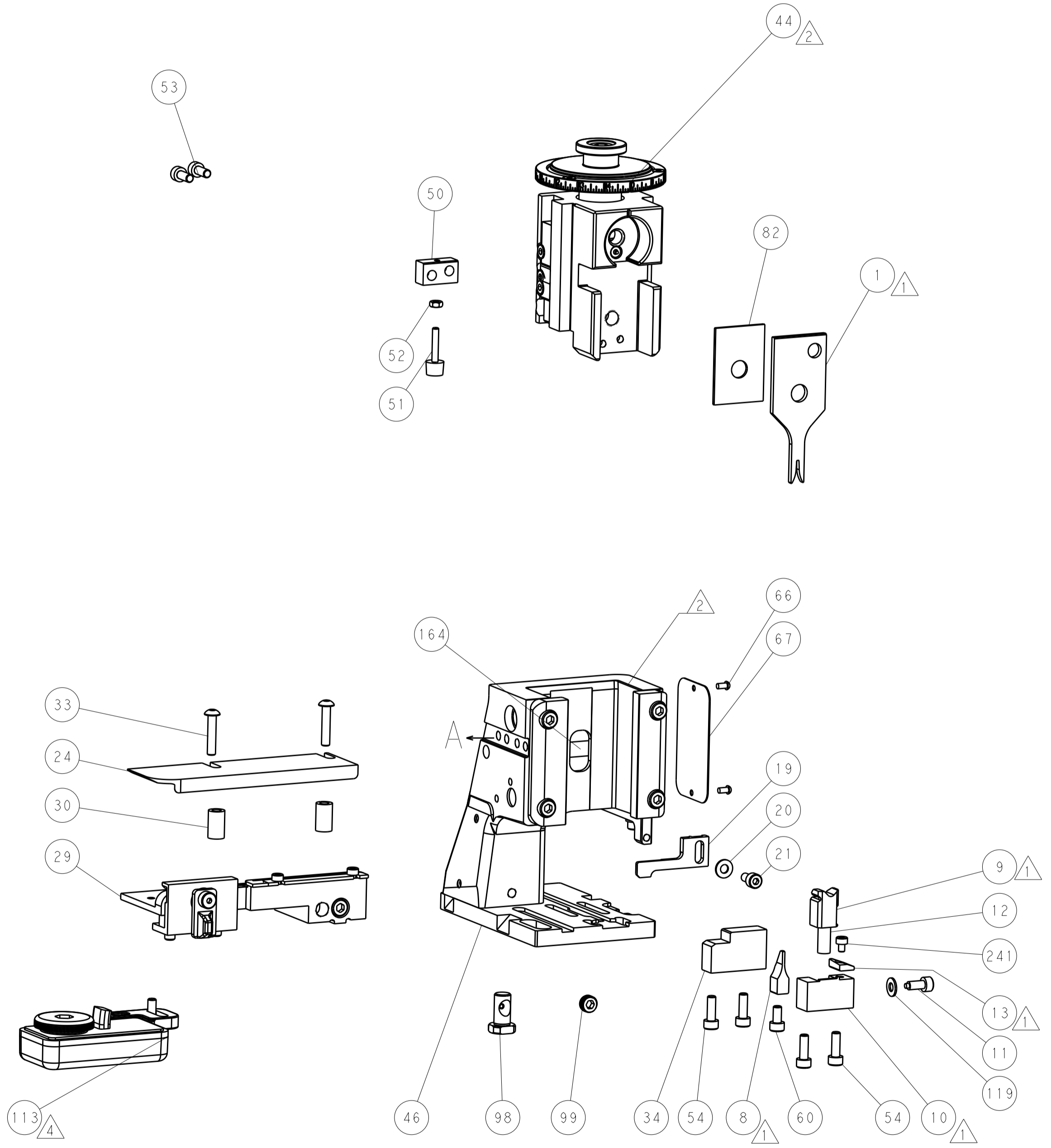
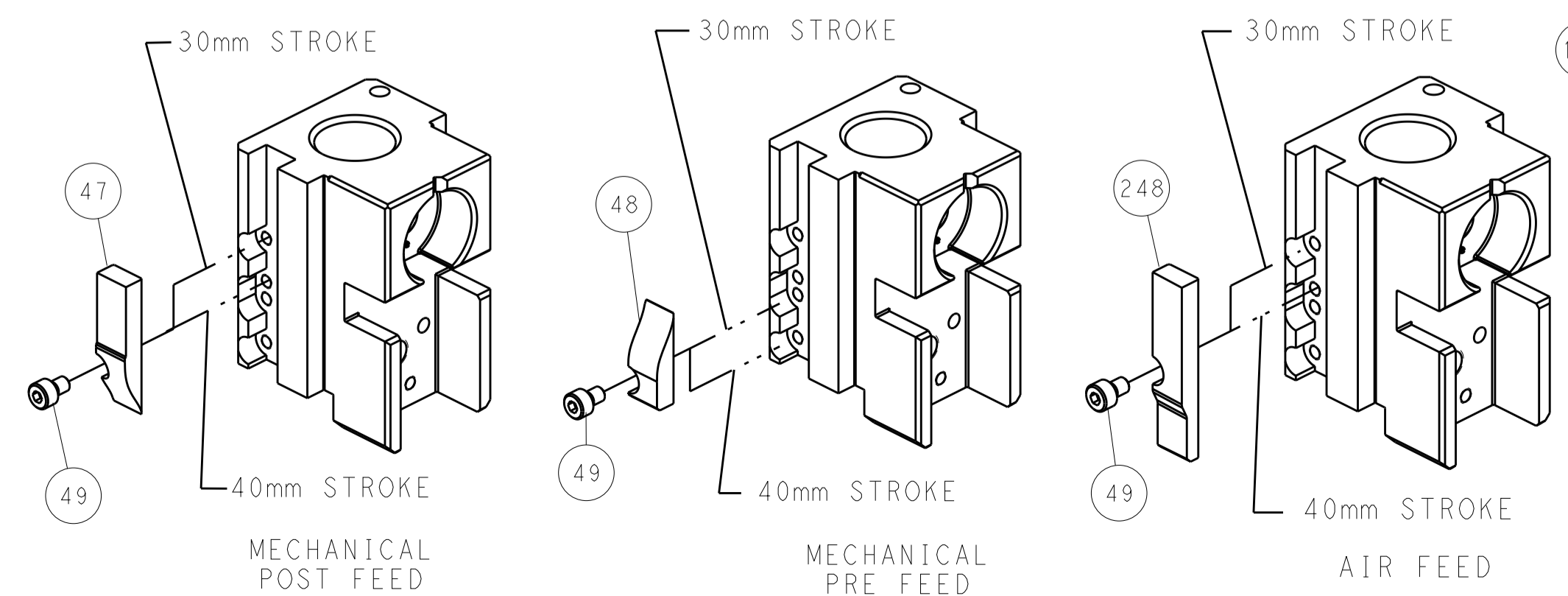
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

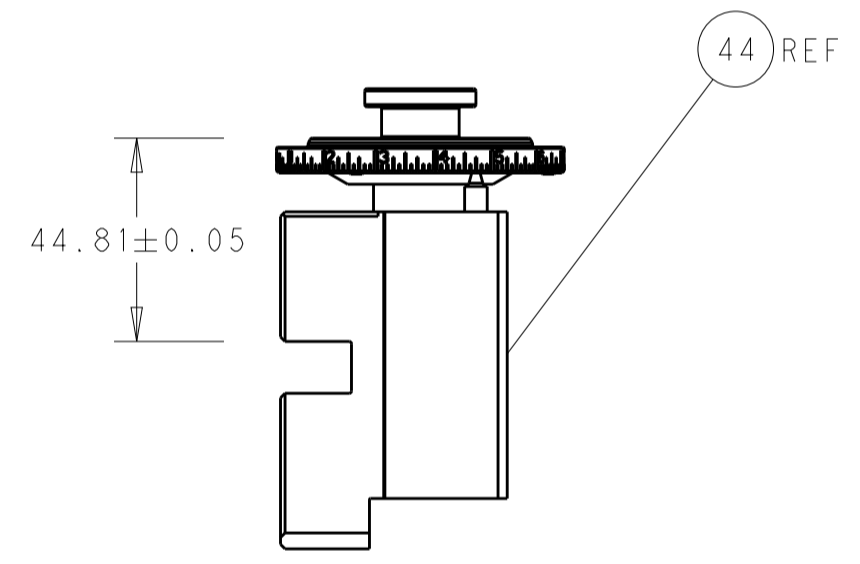
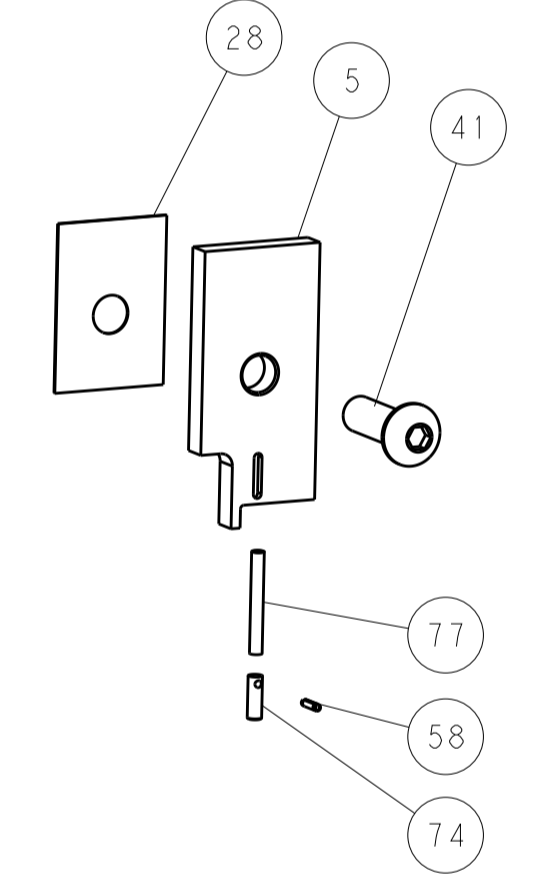


SEE DETAIL A

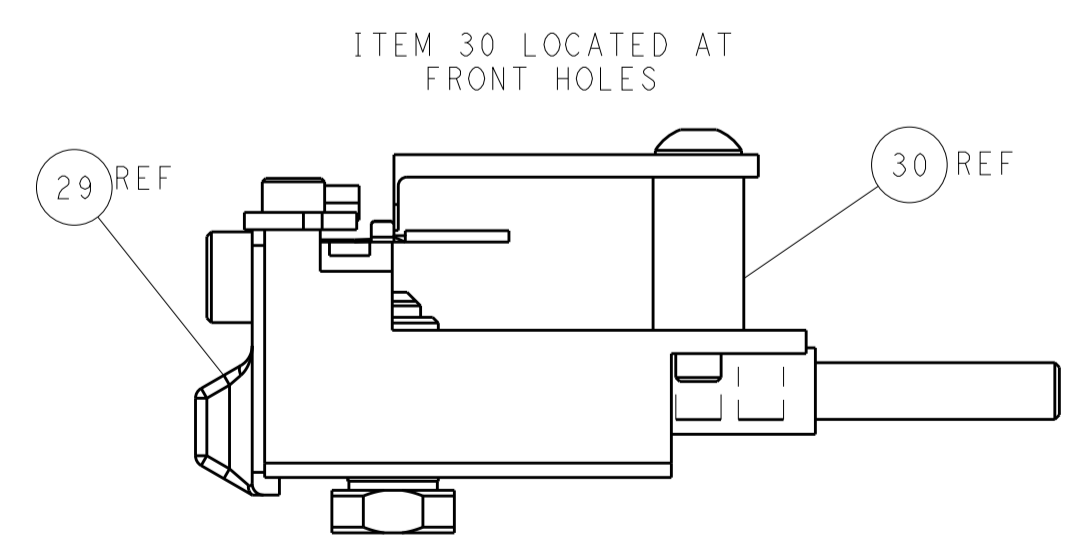
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. O. WILSON 17JUN2013 CHK K. J. STAKEM 18JUN2013 APVD T. L. ELBIN 18JUN2013 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 2 OF 4 REV F		TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151973 RESTRICTED TO	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151973-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151973-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151973-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
7-2151973-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, HF FAKRA 2, RTK031			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.30-2.70 mm [.091-.106 IN]		ϕ	
TERMINAL APPLICATION SPECIFICATION	114-18622	-	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418972-1	1418973-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ³
0.53mm2	0.93+/-0.03 [.037+/-0.001]	7.0
0.35mm2	0.81+/-0.03 [.032+/-0.001]	8.2



- ¹ RECOMMENDED SPARE PARTS
- ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ³ 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.
- ⁴ TERMINAL LUBRICANT IS RECOMMENDED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⁶ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

***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	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

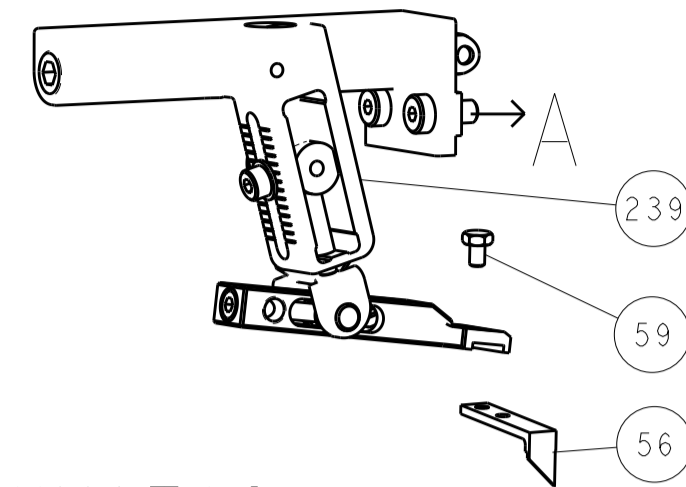
-	1	-	-	2844950-1	AIR FEED MODULE		290
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	1	-	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
⁶	-	1	-	2119641-2	FEED CAM, AIR FEED		151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		119
⁴	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	2844908-1	SCREW, LOCKING		99
-	1	1	1	2844907-1	POST, LOCKING		98
-	1	1	1	1-455888-1	SPACER, CRIMPER		82
-	1	1	1	5-547505-2	SPRING, COMPRESSION		77
-	1	1	1	854769-8	HOLDER, INS		74
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250		58
-	1	1	1	1338685-1	PAWL, FEED		56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	1	1	811242-5	BUMPER, HOLD DOWN		51
-	1	1	1	690753-2	SPACER, TONKER		50
⁶	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	1	2119652-1	FEED CAM, PRE FEED		48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	3-1752356-8	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	455888-3	SPACER, CRIMPER		28
-	1	1	1	1320928-2	STRIP GUIDE		24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
¹	-	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
¹	-	1	1	2119805-1	SHEAR HOLDER, FRONT		10
¹	-	1	1	1803095-6	FLOATING SHEAR, FRONT		9
¹	1	1	1	2-1633733-2	ANVIL, WIRE		8
-	-	-	-	-	-		6
-	1	1	1	2119780-9	DEPRESSOR, SHEAR		5
-	-	-	-	-	-		4
-	-	-	-	-	-		3
-	-	-	-	-	-		2
¹	1	1	1	1803212-1	CRIMPER, WIRE PREMIUM		1

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

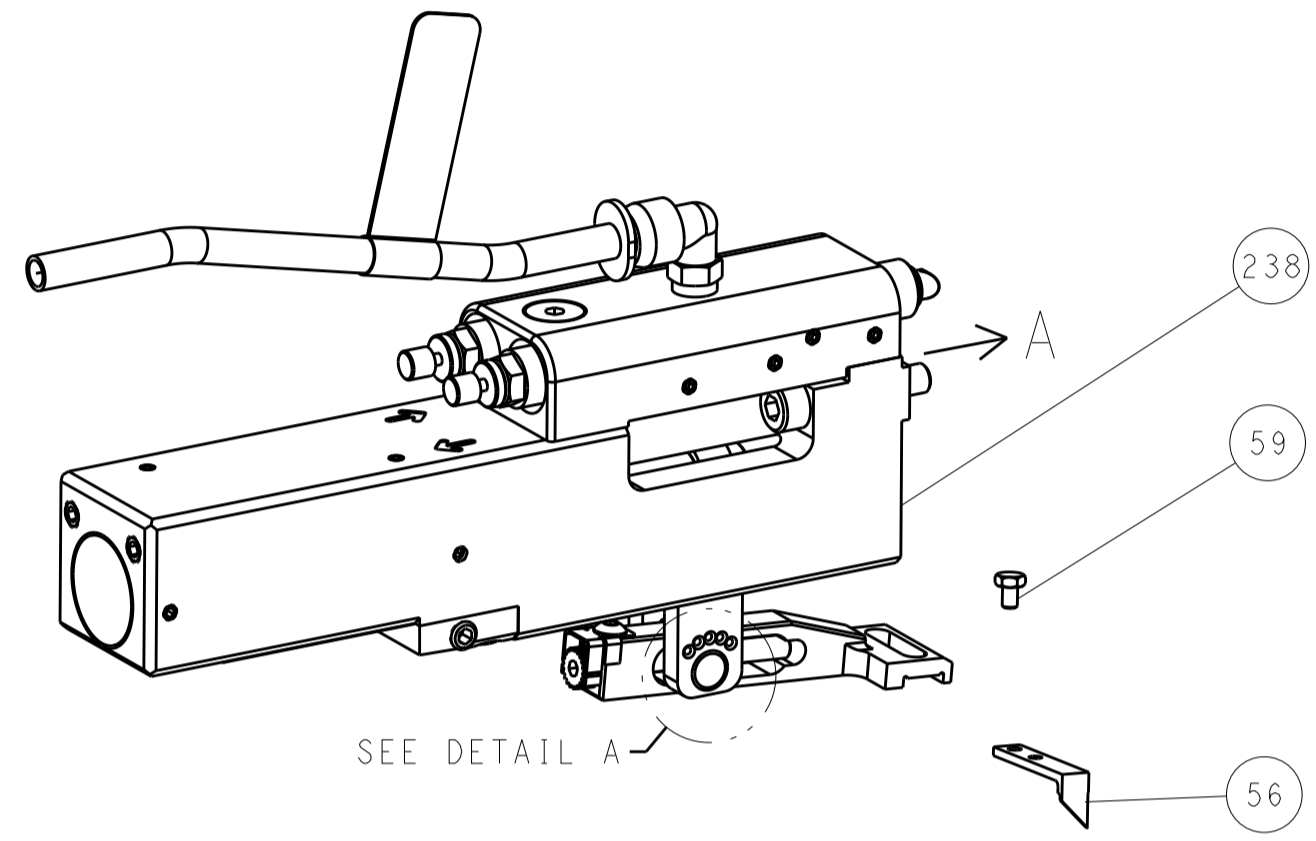
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: R. O. WILSON 17JUN2013		TE Connectivity Harrisburg, PA 17105-3608	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK: K. J. STAKEM 18JUN2013		NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD: T. L. ELBIN 18JUN2013		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2151973	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 3 OF 4	

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

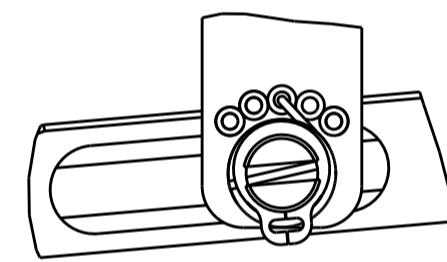
FEED TYPE MECHANICAL



PNEUMATIC

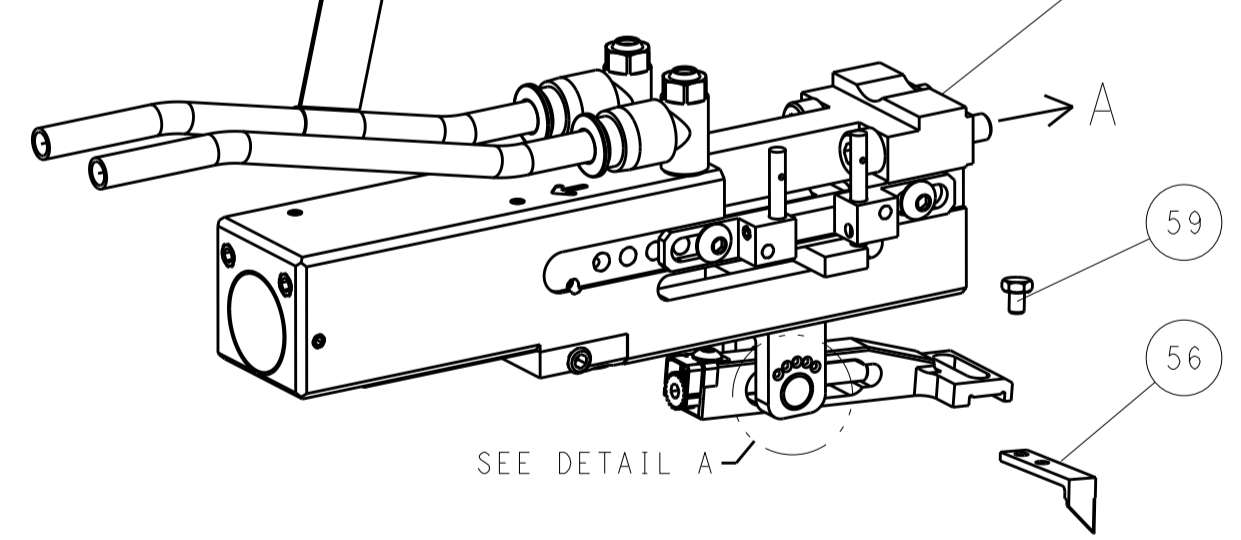


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



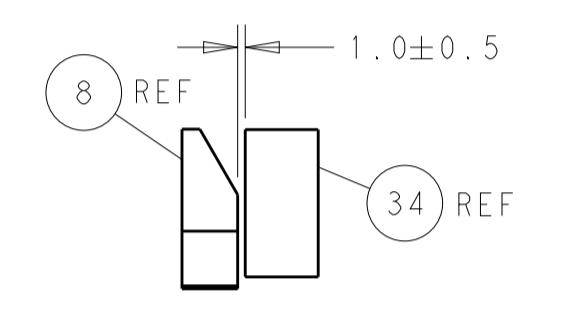
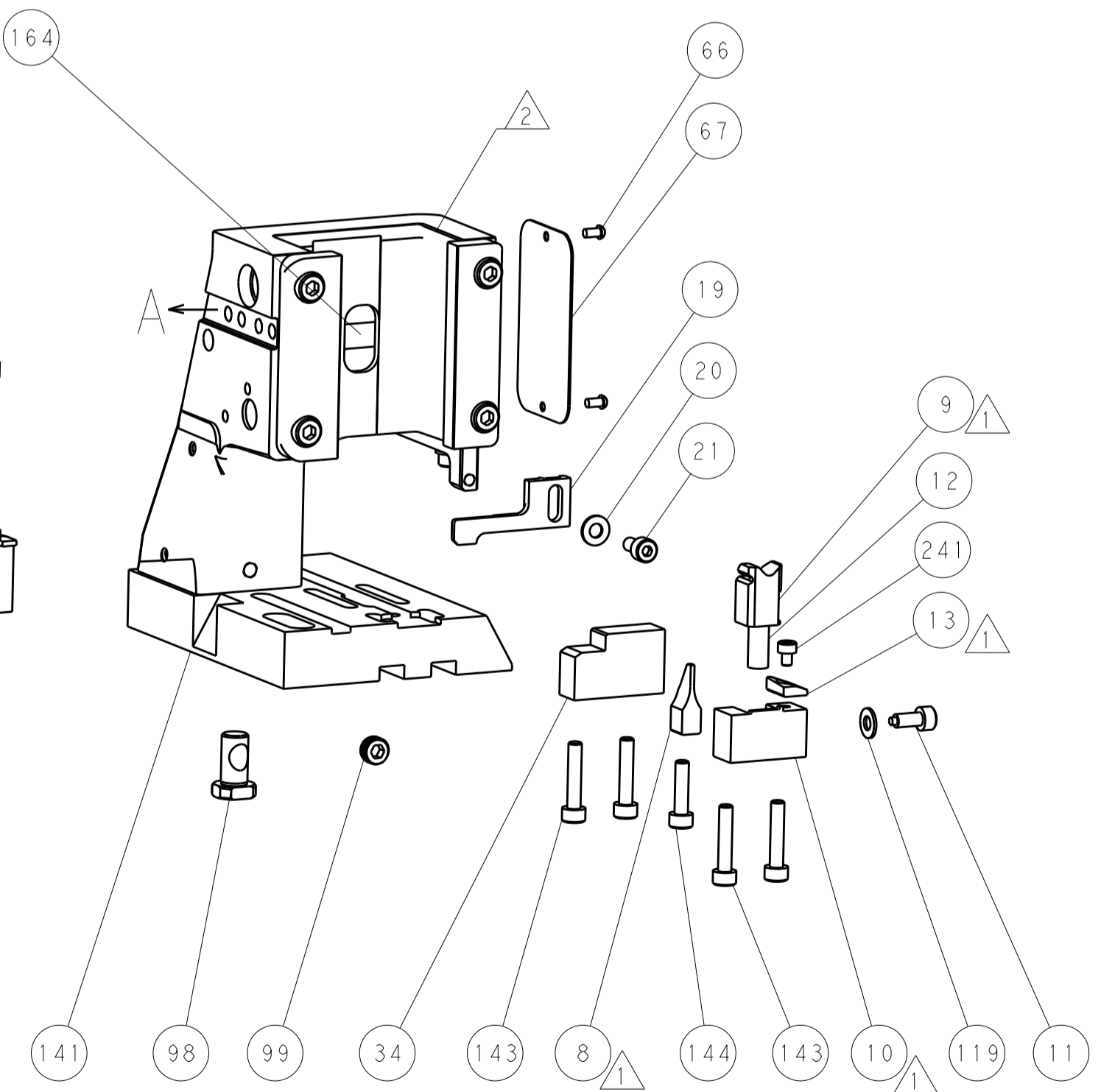
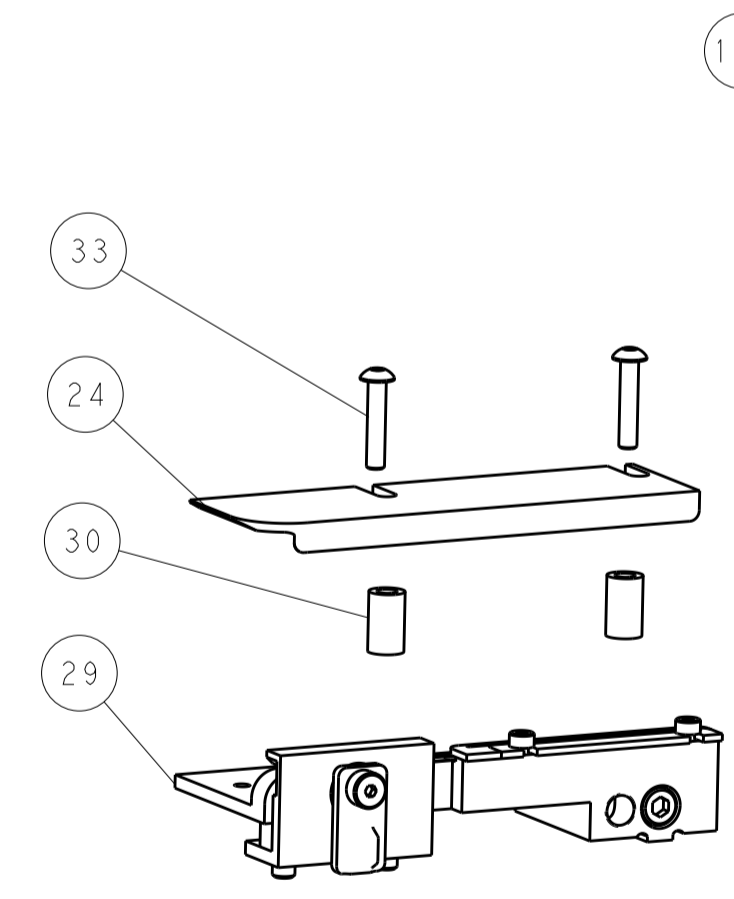
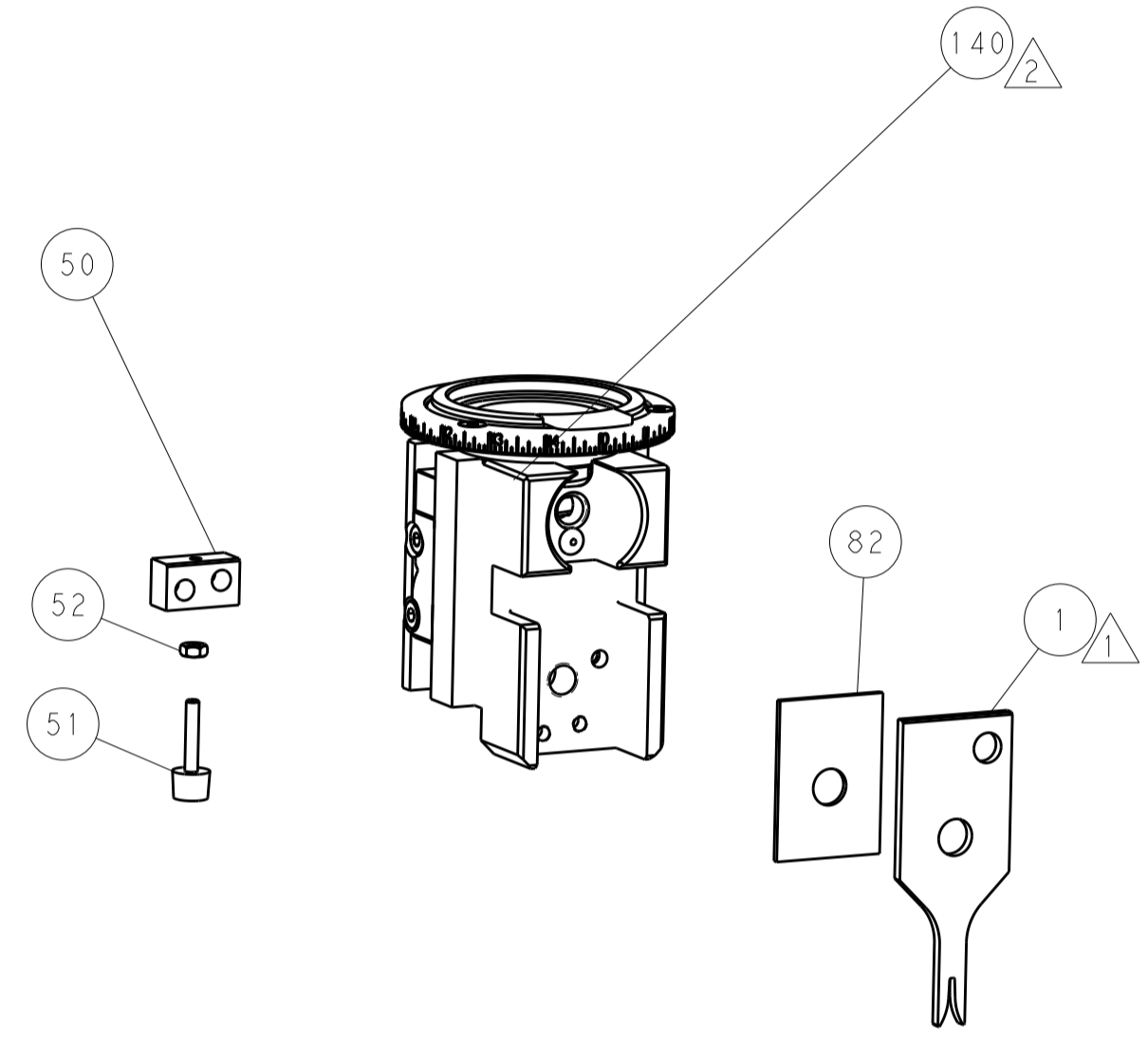
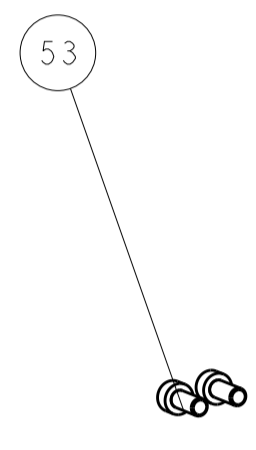
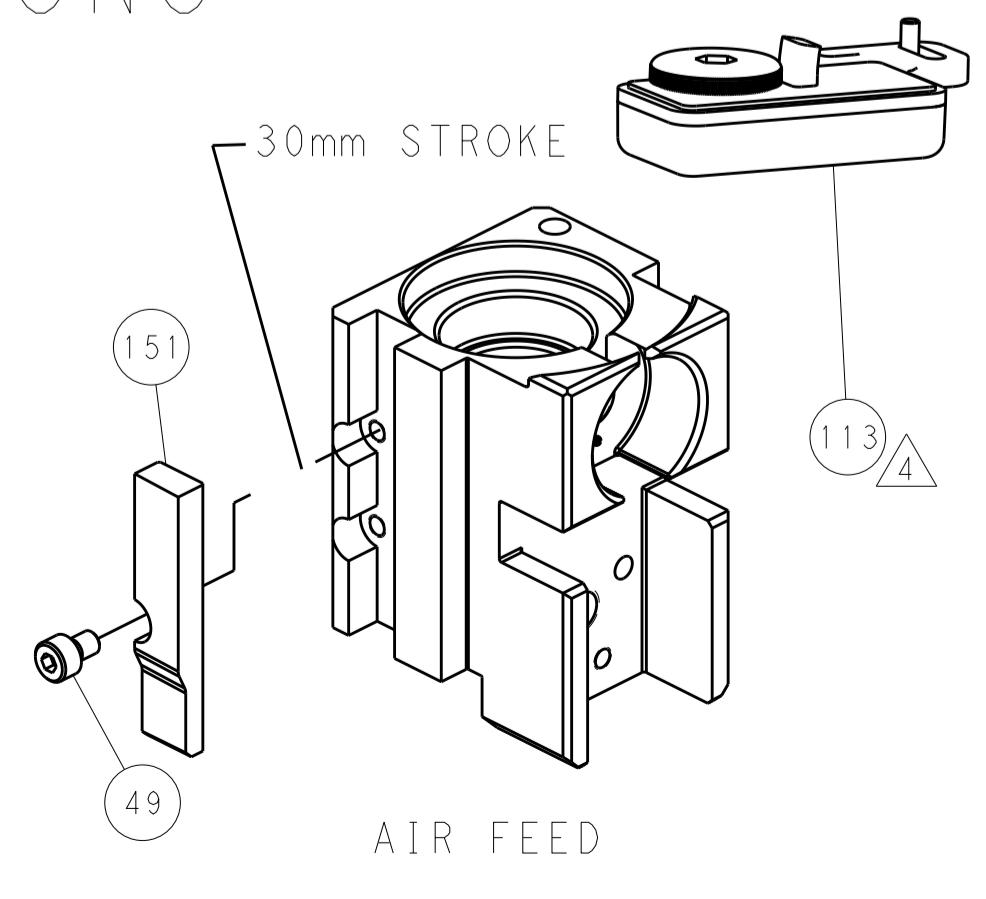
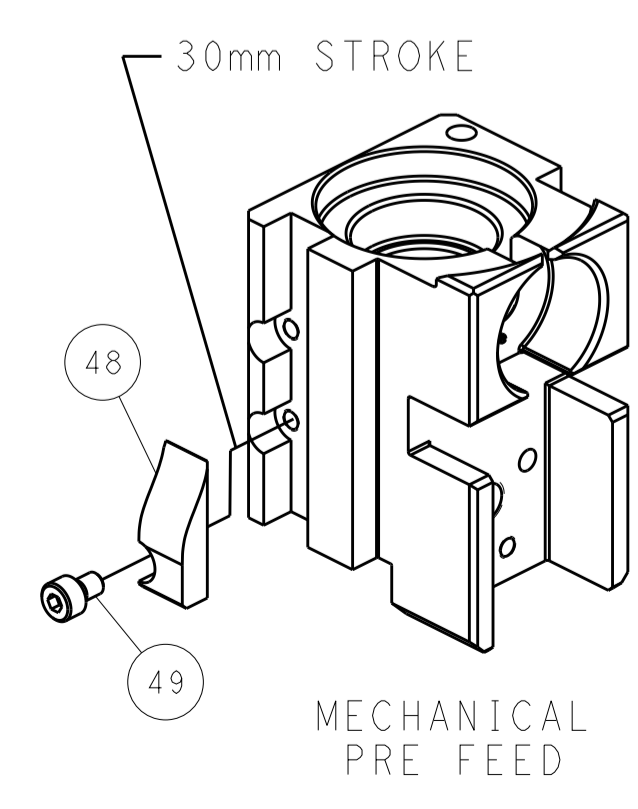
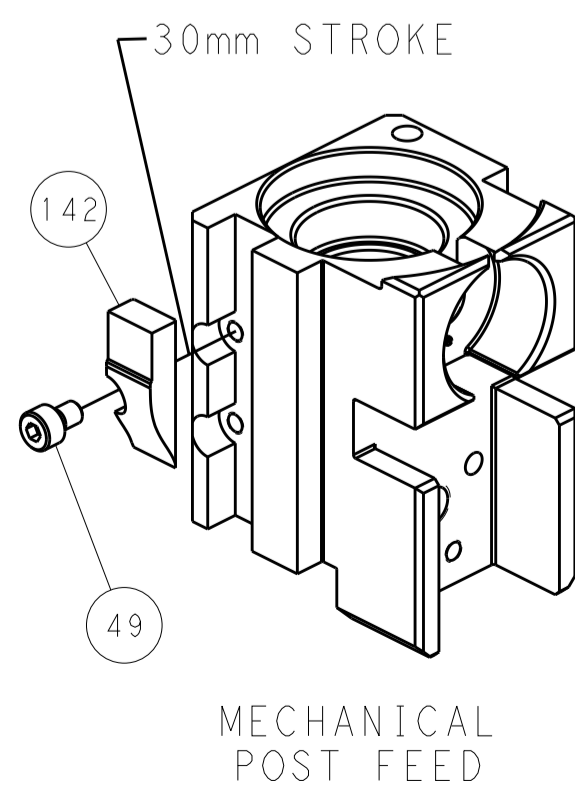
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

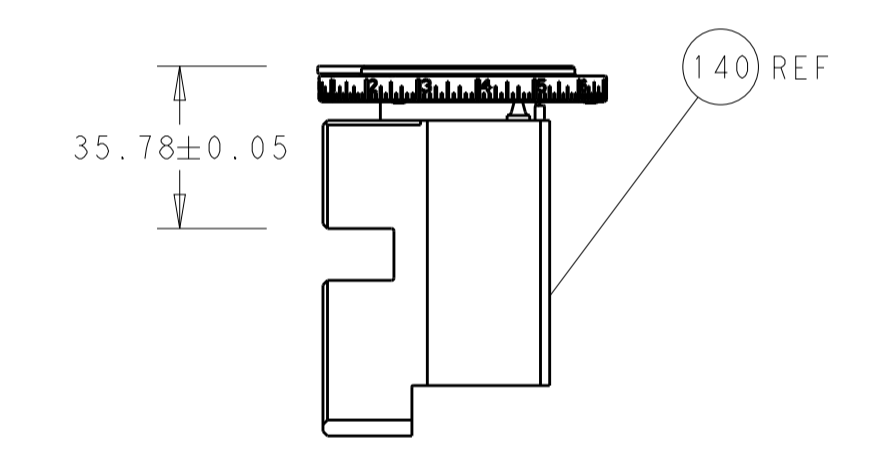
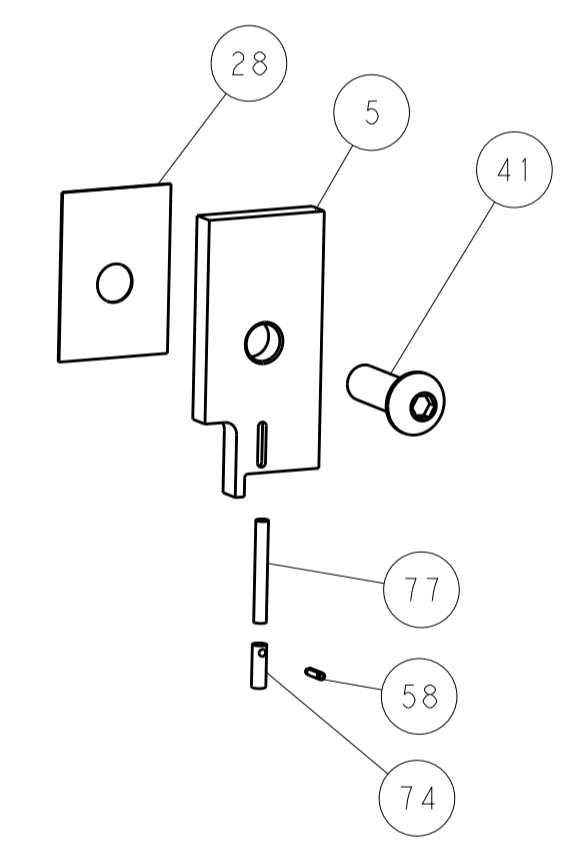


SEE DETAIL A

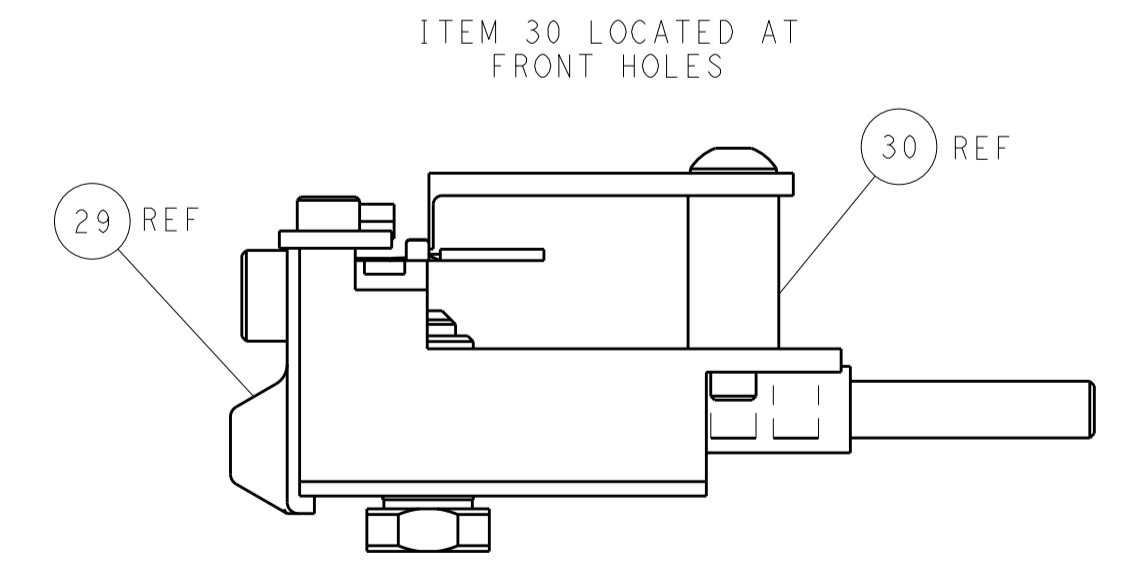
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT
FRONT HOLES

FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R.O. WILSON 17JUN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: K.J. STAKEM 18JUN2013	NAME: T.L. ELBIN 18JUN2013	Ocean Side Feed Applicator	
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SIZE: A1	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:2	DRAWING NO: 2151973	RESTRICTED TO: F
Customer Accessible Production Drawing				SHEET 4 OF 4 REV F			