

8		7	
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20		20	
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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 
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	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

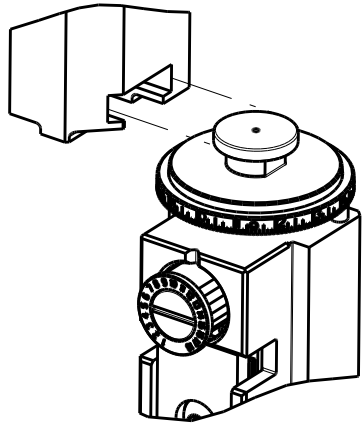
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, HF FAKRA 2. RTK031			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
2.30-2.70 mm [.091-.106 IN]		Ø	
TERMINAL APPLICATION 		114-18622	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL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

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



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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

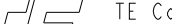


*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

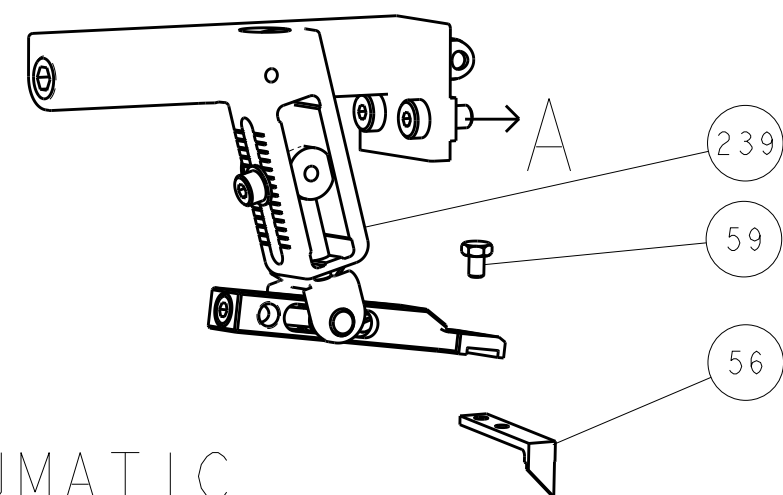
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		C		ECR-17-014825	09OCT2017	MZ	KZ	
		D		ECR-19-006462	23APR2019	FJ	TE	
		E		ECR-19-007109	03MAY2019	LG	TE	
		F		ECR-20-009518	03JUL2020	FZ	TE	

	-	-	-	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	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	1	1803212-1	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

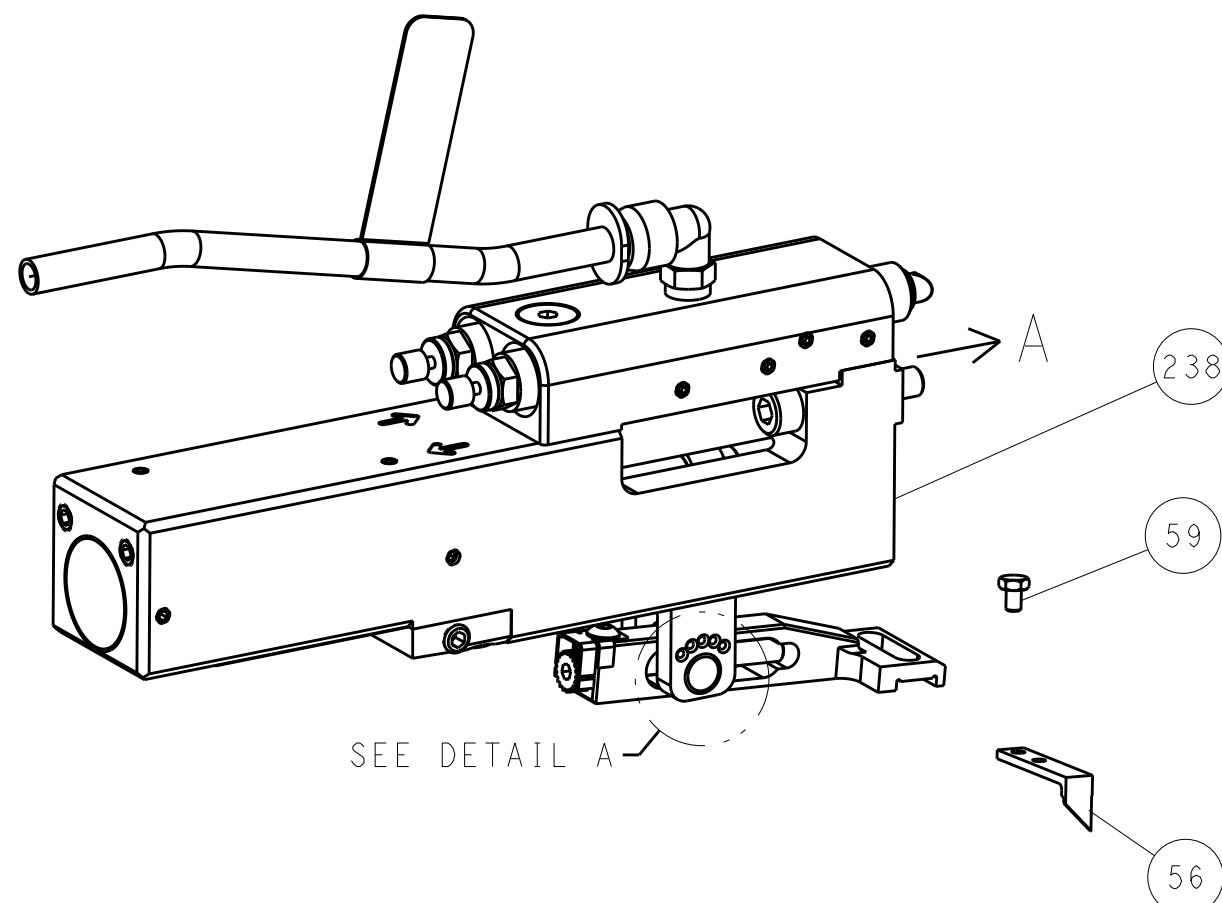
1ST PUBLICATION OF THIS DRAWING FOR THE ATLANTIC VERSION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION SHOWN IN THE LATEST EDITION.				DWN R.O.WILSON CHK K.J.STAKEM APVD T.L.FLIN	17JUN2013 18JUN2013 18JUN2013	 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator					
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		-					
		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A 00779		C-2151973		-	
-		-		-		Customer Accessible Production Drawing		SCALE		1:2	
								SHEET		1 OF 4	
										REV F	

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

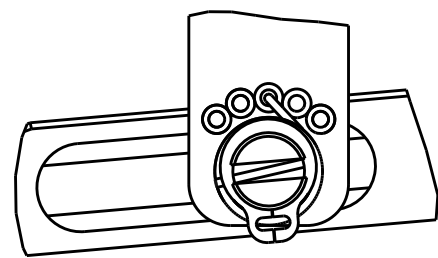
FEED TYPE
MECHANICAL



PNEUMATIC

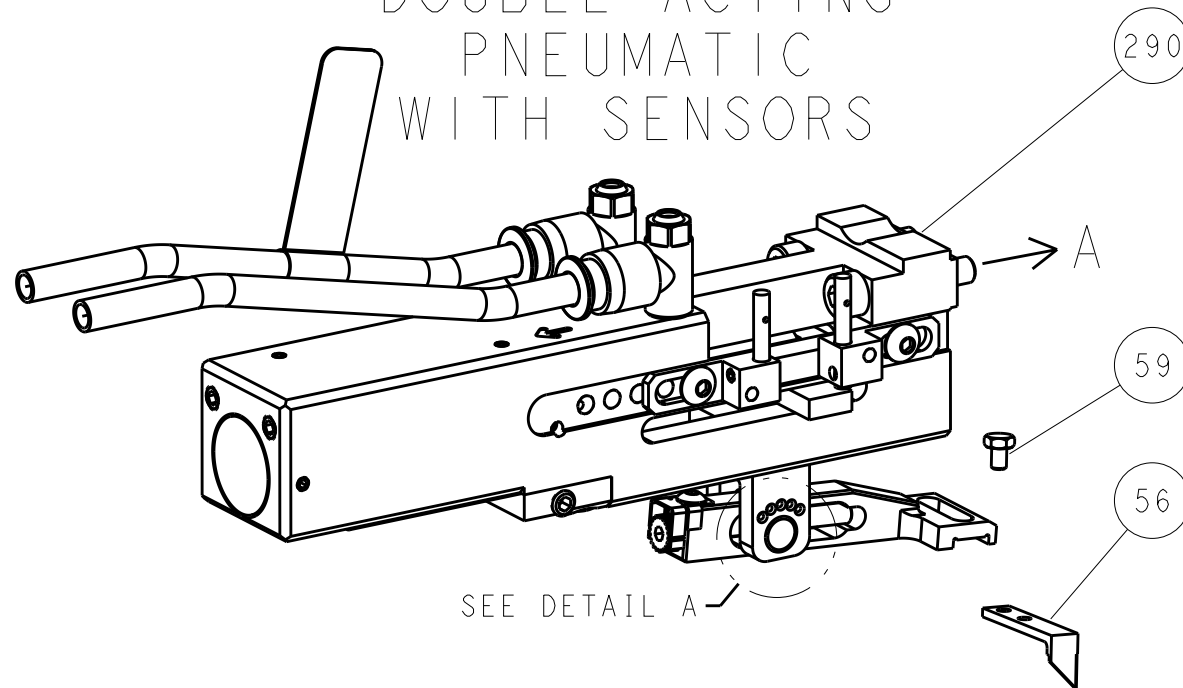


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



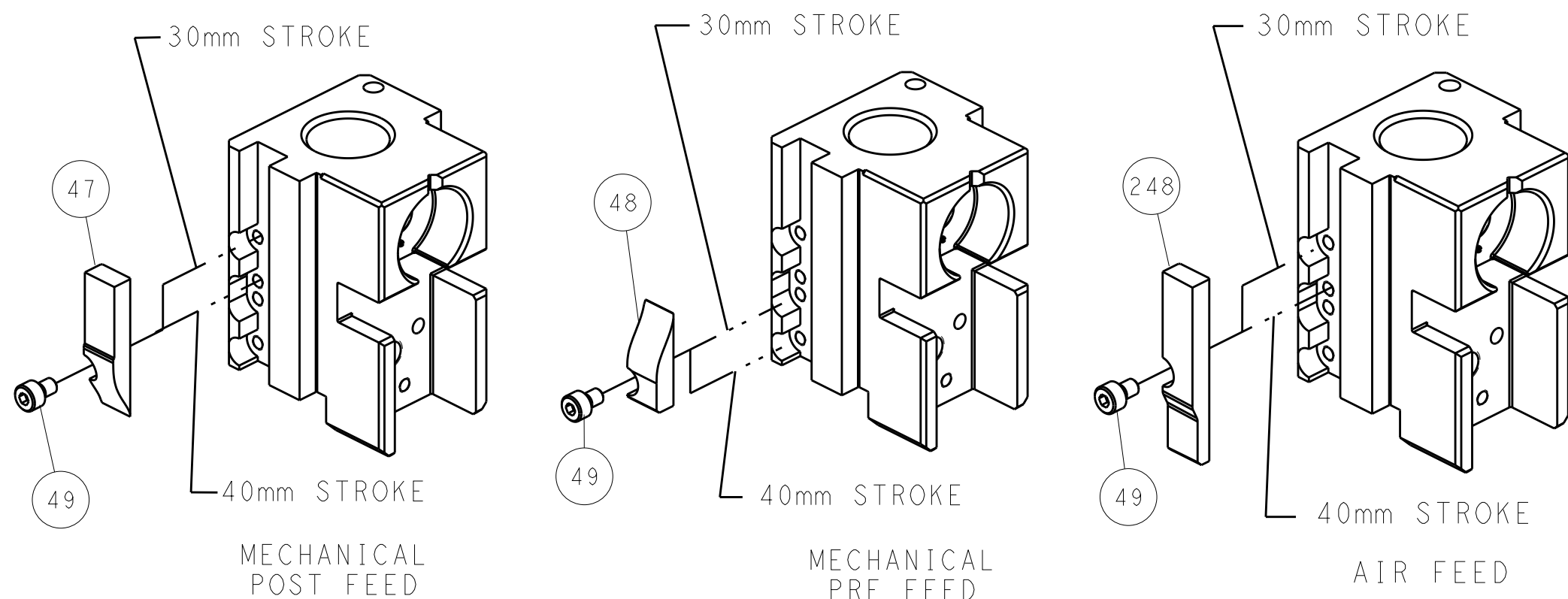
DETAIL A

DOUBLE ACTING
PNEUMATIC
WITH SENSORS

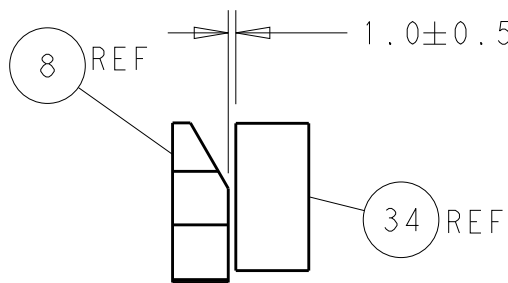
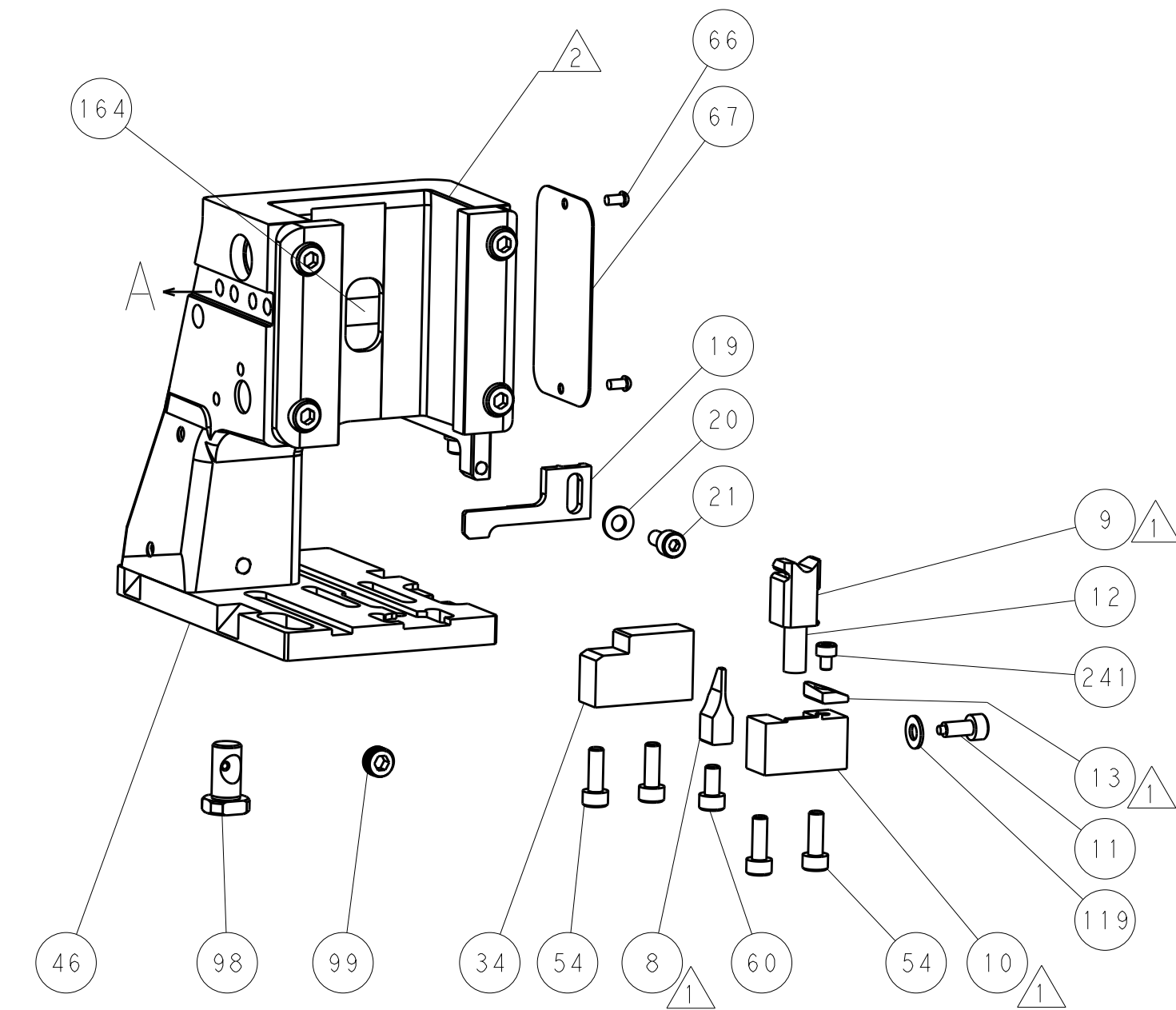
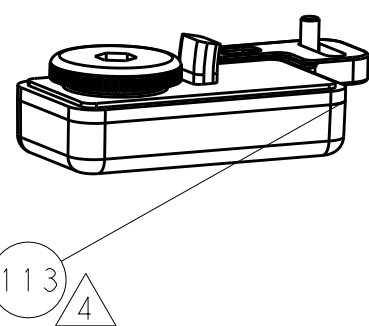
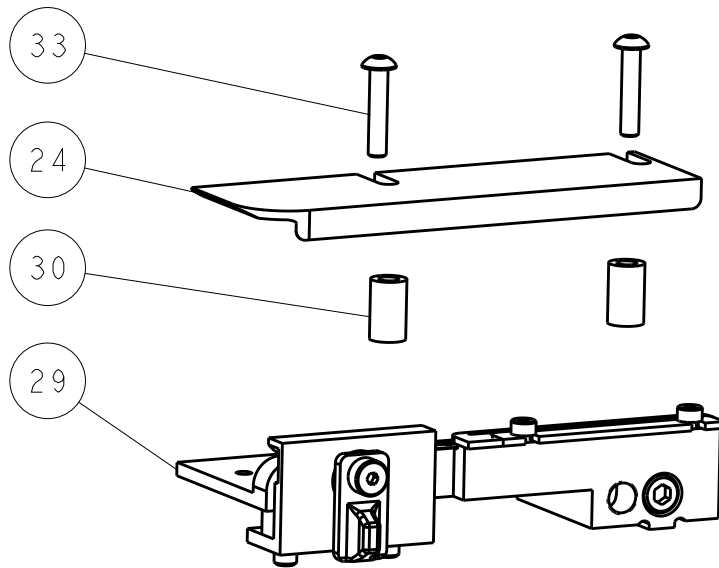
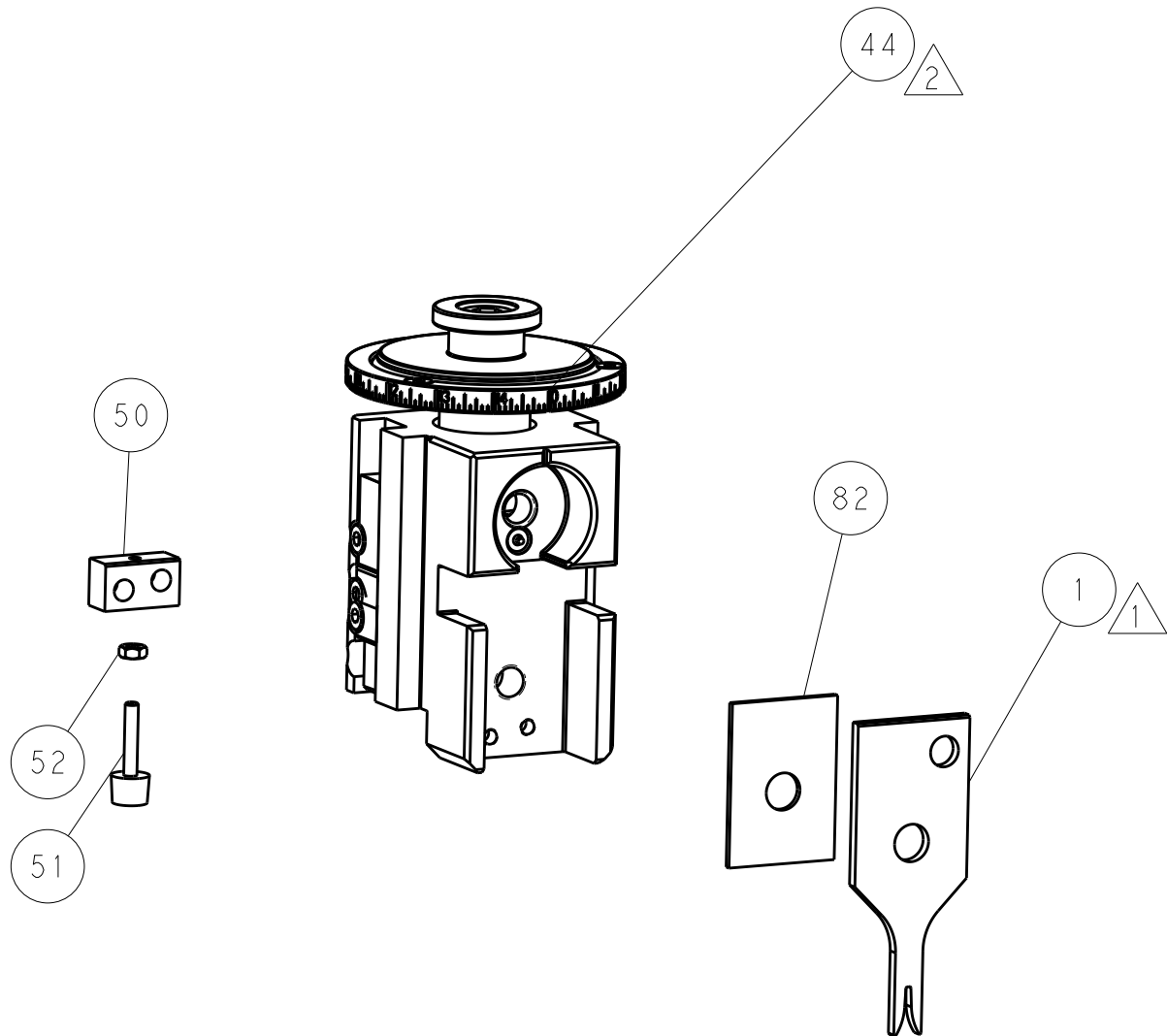
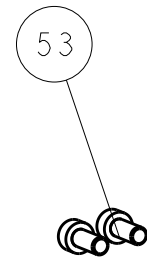


SEE DETAIL A

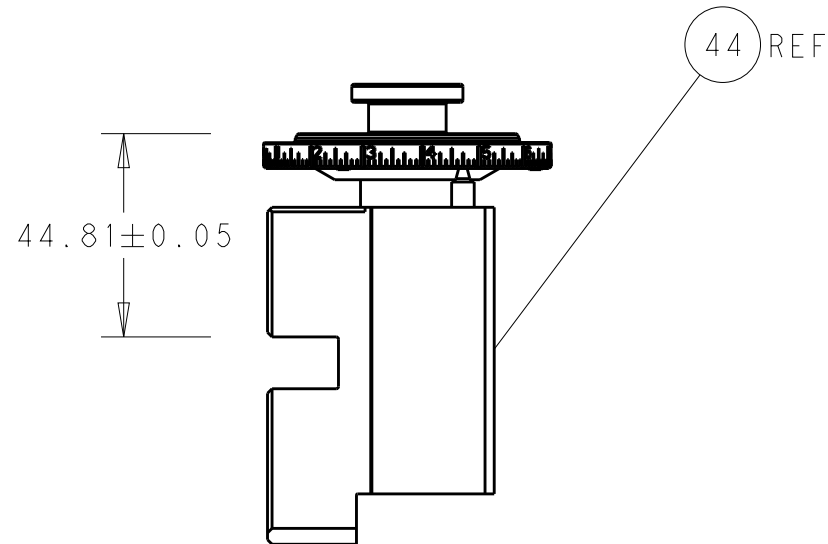
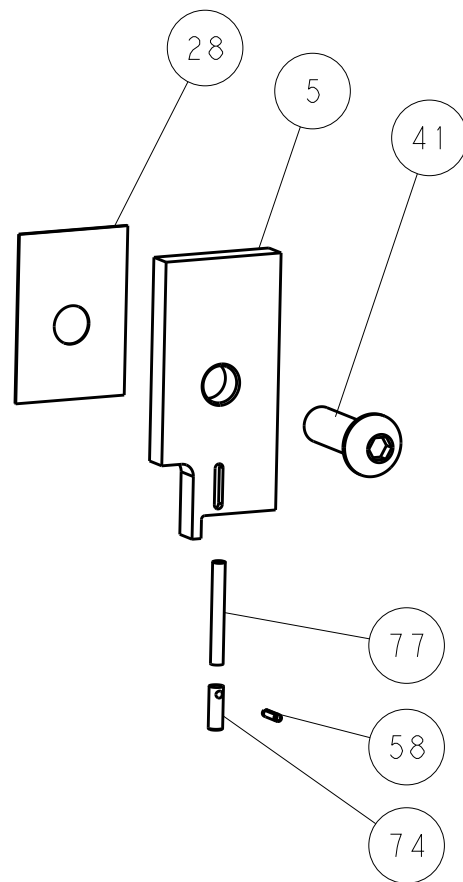
CAM POSITIONS



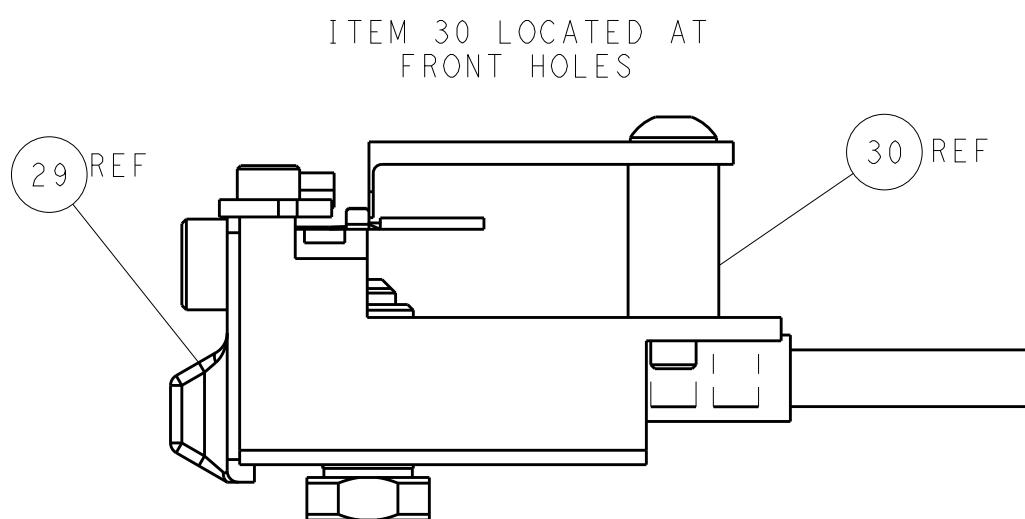
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



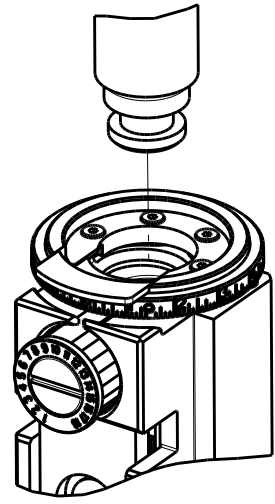
FEED TRACK POSITION
GUIDE BY WIRE BARREL

1ST PUBLISHED BY: COMPANY USE ONLY FOR YOUR ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE TO THE CUSTOMER SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN R.O. WILSON 17JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK K.J. STAKEM 18JUN2013		NAME T.L. ELBIN 18JUN2013	Ocean Side Feed Applicator	
PRODUCT SPEC		SIZE A1	CAGE CODE 00779	DRAWING NO. C=2151973
APPLICATION SPEC		RESTRICTED TO	-	
WEIGHT		SCALE 1:2	SHEET 2	REV F
Customer Accessible Production Drawing				

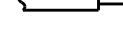
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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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
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 2.30-2.70 mm [.091-.106 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION		114-18622	-
		-	-
TERMINALS APPLIED 			
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 & 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.

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	LTR	DESCRIPTION	DATE	OWN	APVD
		-	-	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
-	-	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
-	1	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
-	-	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	2-1633733-2	ANVIL, WIRE	8
-	-	-	-	-	-	6
-	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	4
-	-	-	-	-	-	3
-	-	-	-	-	-	2
-	1	1	1	1803212-1	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN R.O.WILSON CHK K.J.STAKEM APVD T.L.FLRIN	17JUN2013 18JUN2013 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	
MATERIAL		WEIGHT		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4	
REV F		DRAWING NO 00779		REV F	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

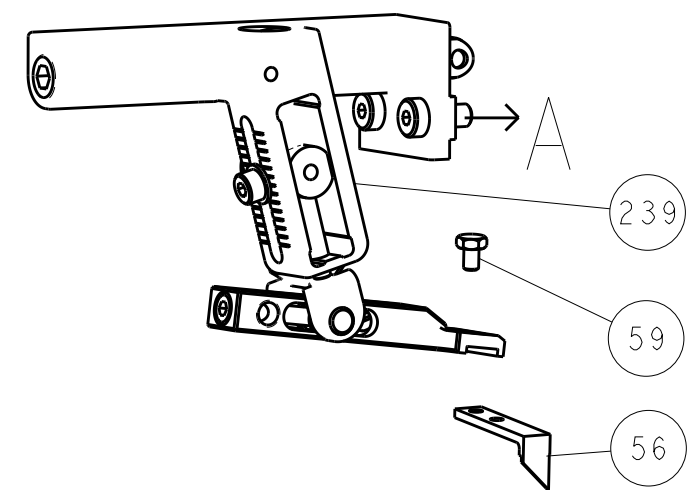
D

C

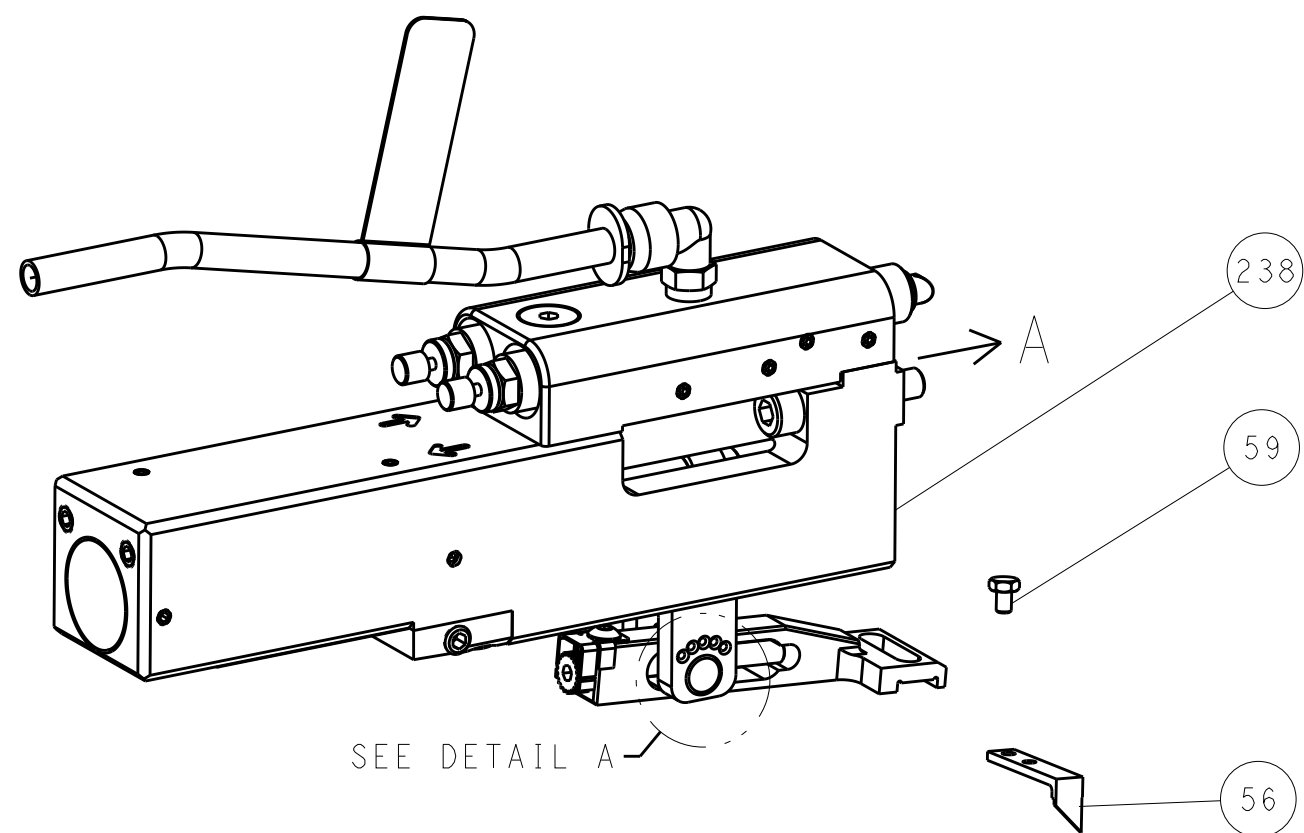
B

A

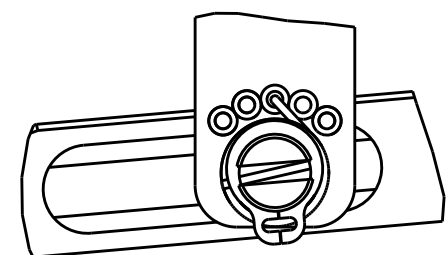
FEED TYPE MECHANICAL



PNEUMATIC

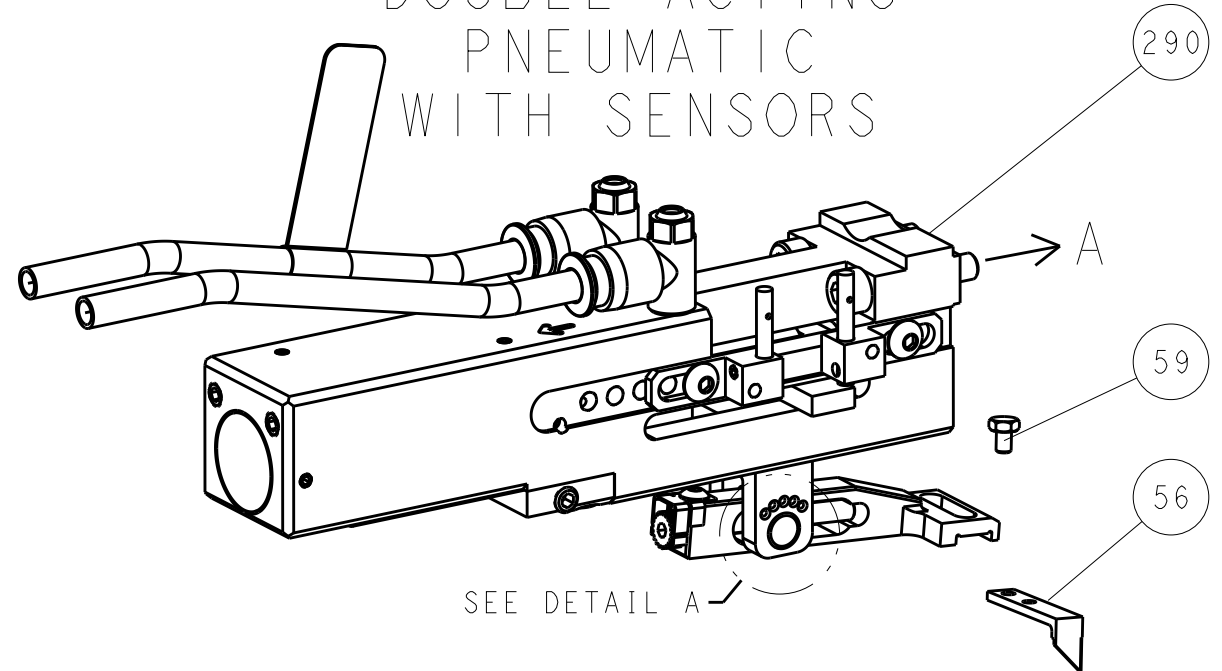


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

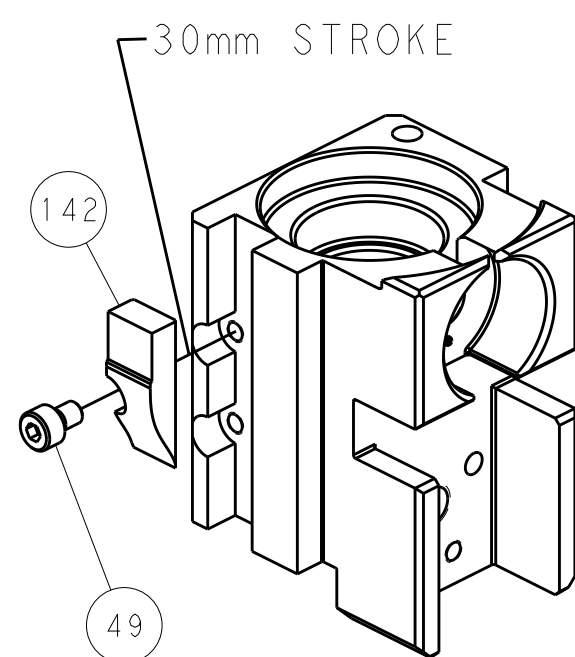


DETAIL A

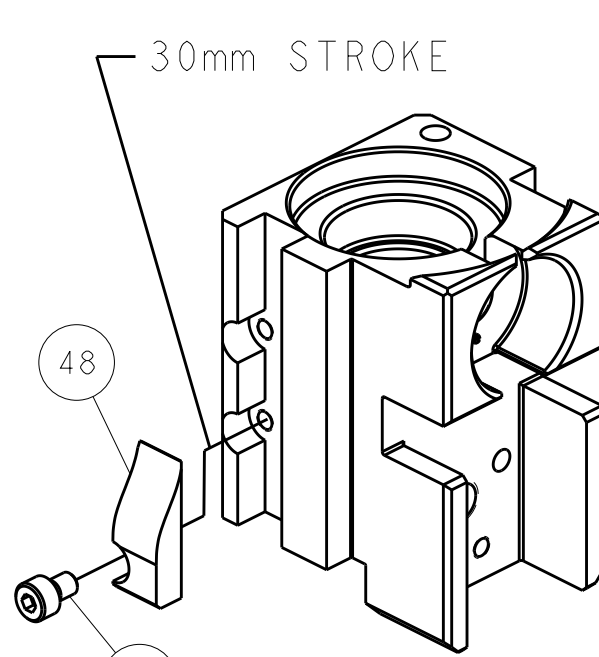
DOUBLE ACTING PNEUMATIC WITH SENSORS



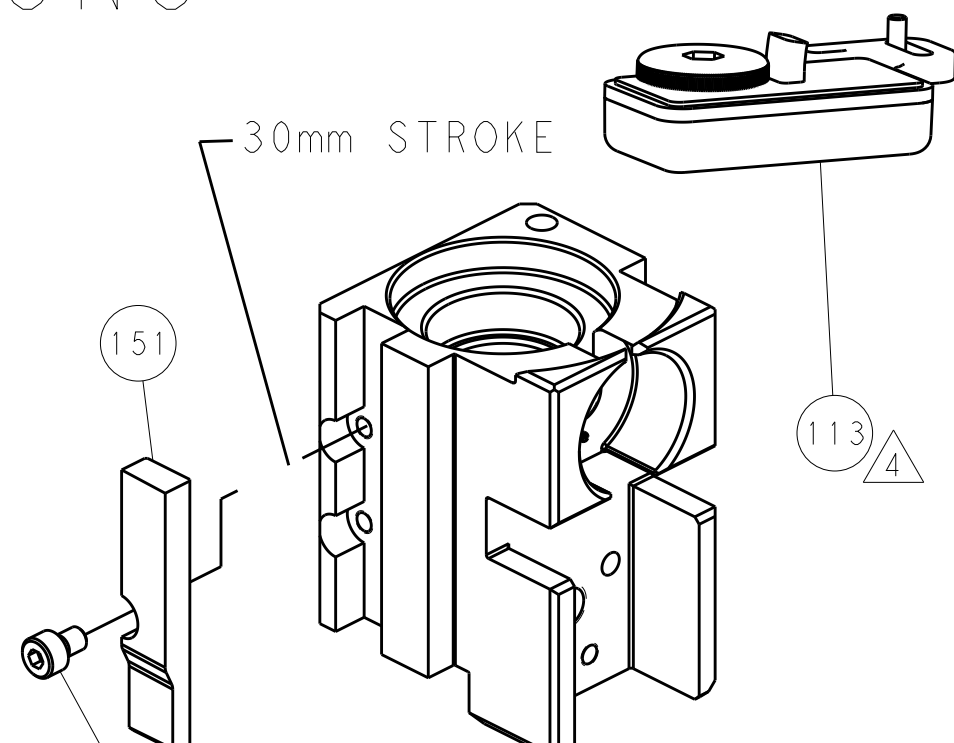
CAM POSITIONS



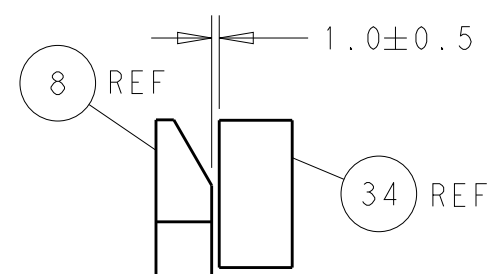
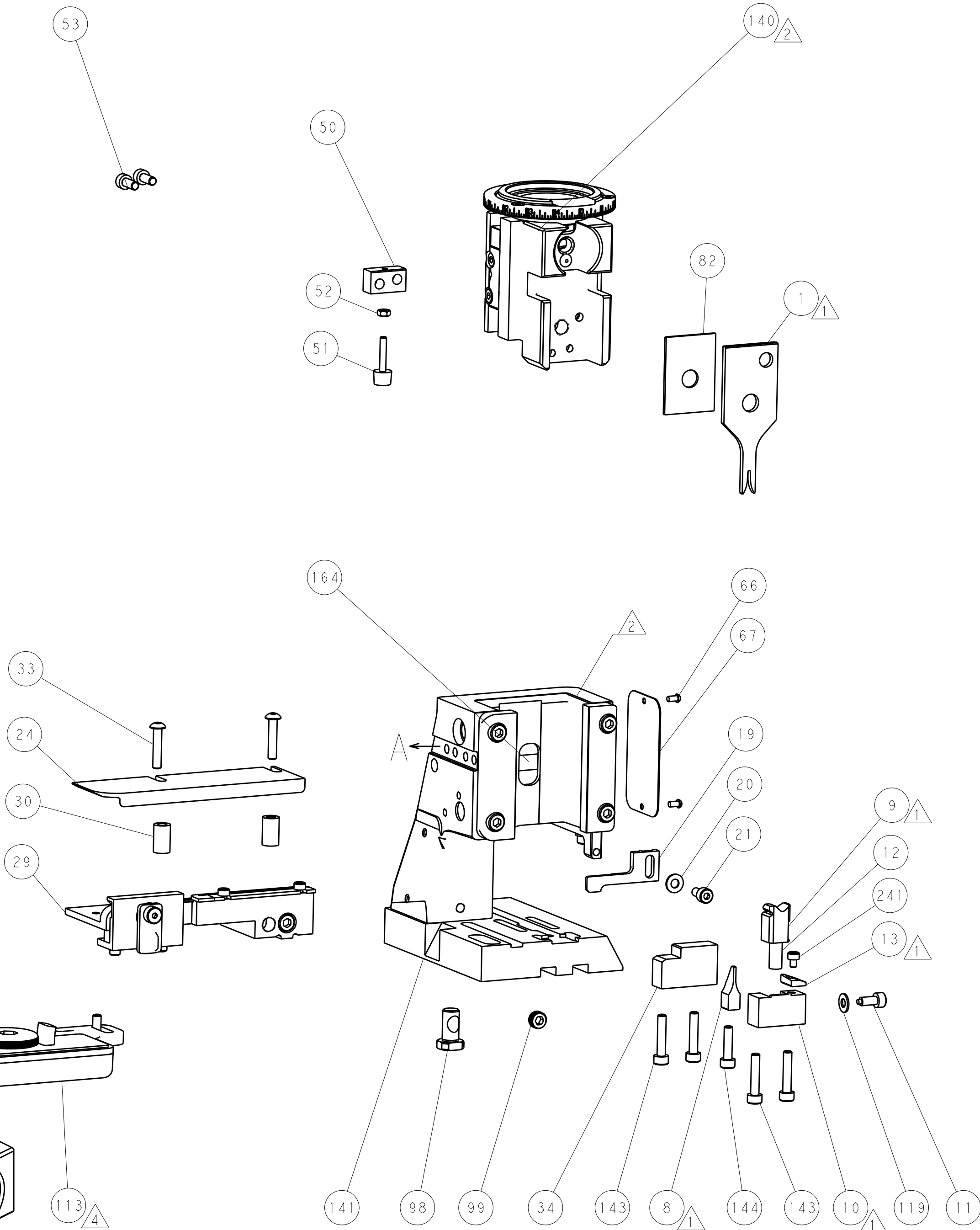
MECHANICAL
POST FEED



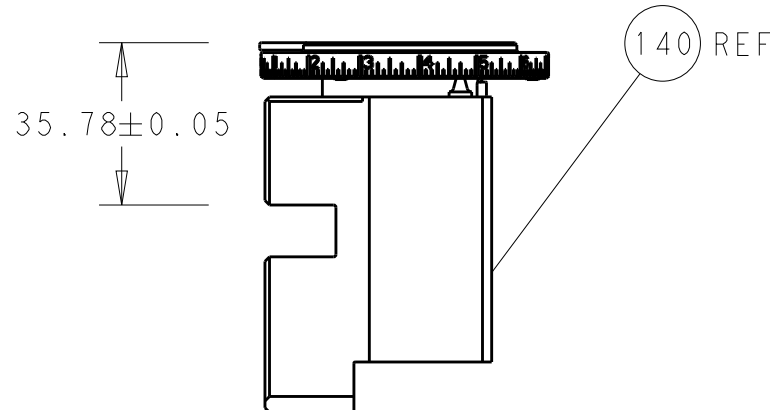
MECHANICAL
PRE FEED



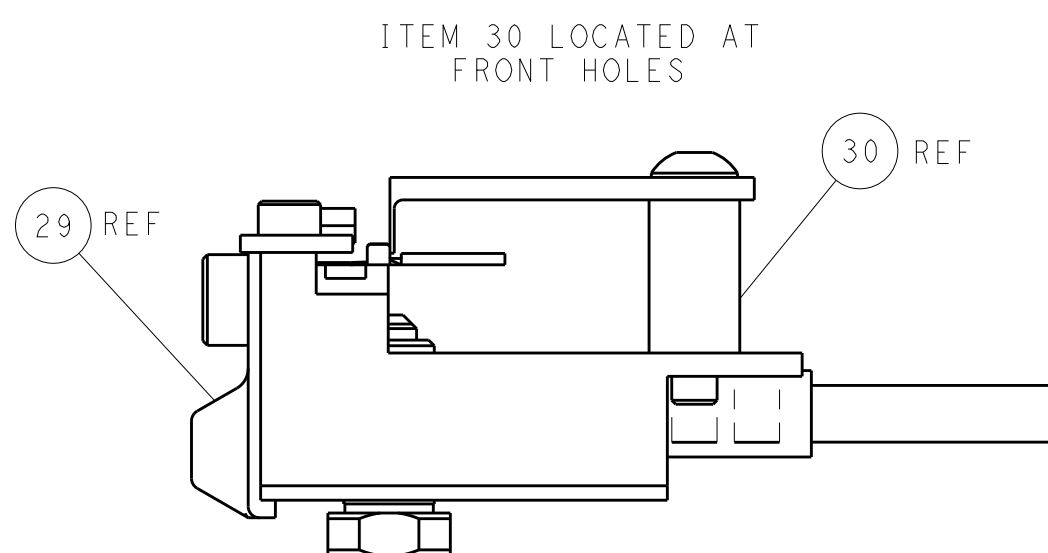
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

FIRST PUBLISHED BY: COMPANY RELEASED FOR PUBLICATION: THIS IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST POSITION.		DWN R.O. WILSON CHK K.J. STAKEM APVD T.L. ELGIN	17JUN2013 18JUN2013 18JUN2013	NAME	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		PRODUCT SPEC	
MATERIAL		WEIGHT		APPLICATION SPEC	
		Customer Accessible Production Drawing		SIZE A1	CAGE CODE 00779
		SCALE 1:2		DRAWING NO. C=2151973	RESTRICTED TO F
		SHEET 4		OF 4	REV F

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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