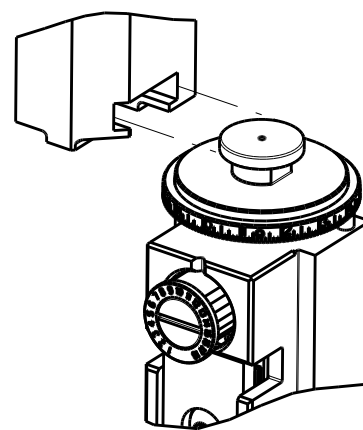




PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151973-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151973-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151973-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS 
7-2151973-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151973-2	F	PNEUMATIC AND 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 2.30-2.70 mm [.091-.106 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION 		114-18622	-
SPECIFICATION		-	-
TERMINALS APPLIED 			
TE TERMINAL 1418972-1	TE TERMINAL 1418973-1	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.53mm2			0.93+/-0.03 [0.037+/-0.001]		7.0
0.35mm2			0.81+/-0.03 [0.032+/-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.

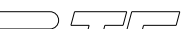
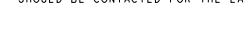
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

- 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

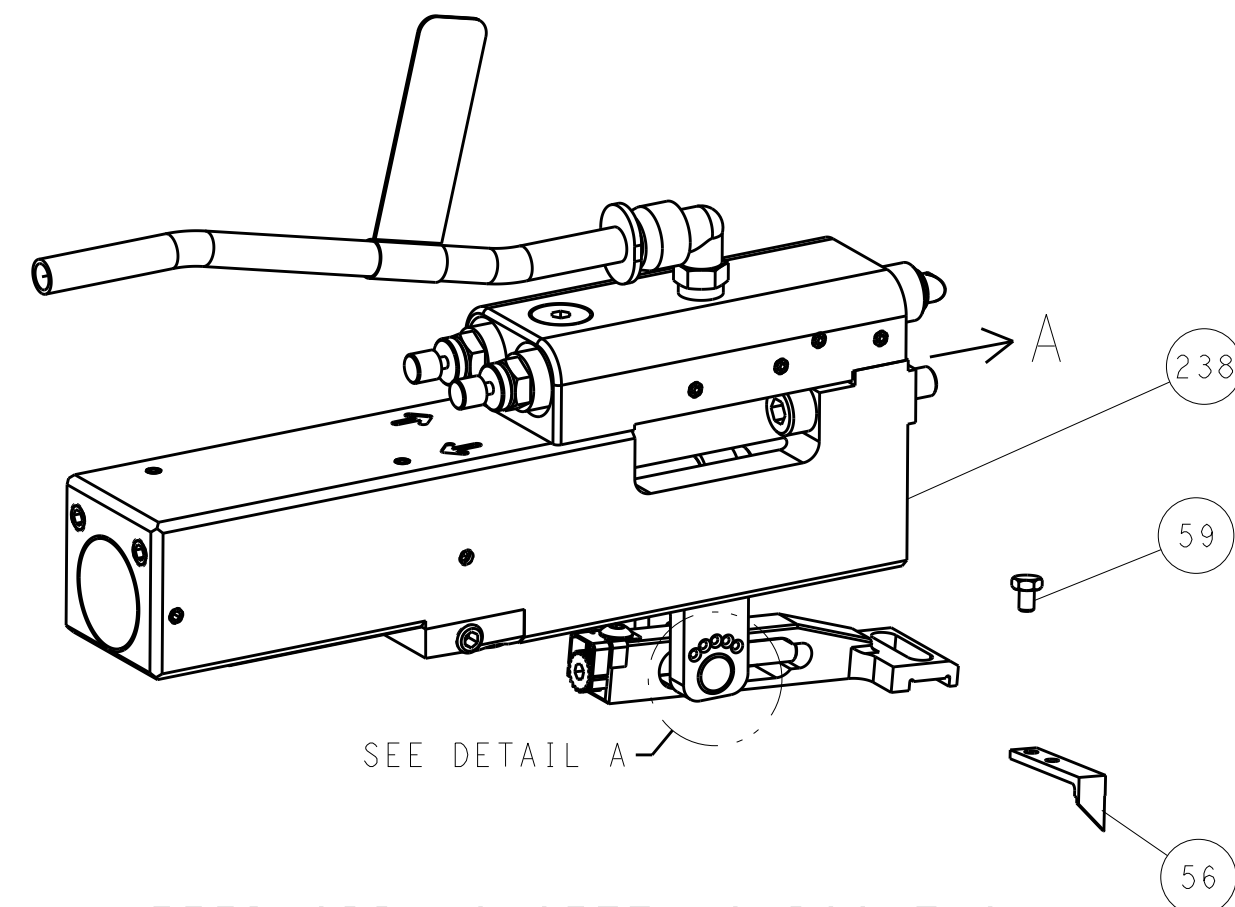
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING.
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

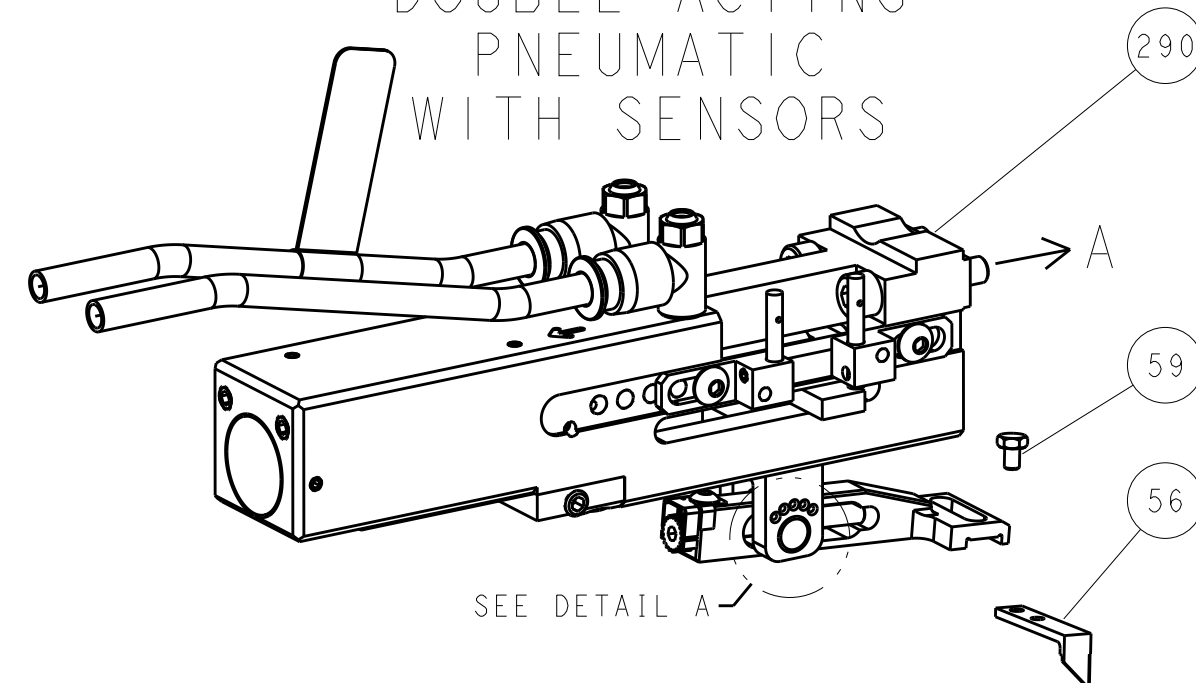
△	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
△	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	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	99
	-	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	1	2	2	1	1	1	1803212-1	CRIMPER, WIRE PREMIUM
	-77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE USED FOR THE SPECIFIC PURPOSE FOR WHICH IT WAS ISSUED. IT IS TO BE KEPT IN THE COMPANY'S FILES AND IS NOT TO BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PERSON OR COMPANY. IT IS TO BE DESTROYED WHEN NO LONGER NEEDED FOR THE COMPANY'S USE.		DWN H. O. WILSON 17JUN2013 CHG K. J. STAREK 18JUN2013 APPR J. L. FIRBIN 18JUN2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm$.01 1 PLC $\pm$.01 2 PLC $\pm$.01 3 PLC $\pm$.01 4 PLC $\pm$.01 ANGLES $\pm$.5°		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A 00779 C=2151973	
MATERIAL -		FINISH -		WEIGHT -	
		Customer Accessible Drawing		SCALE 1:2 SHEET 1 OF 4 REV F	

PNEUMATIC



DOUBLE ACTING PNEUMATIC WITH SENSORS



30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

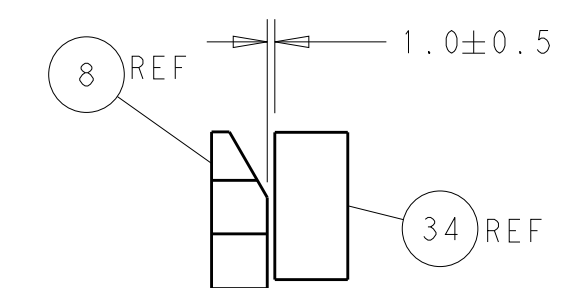
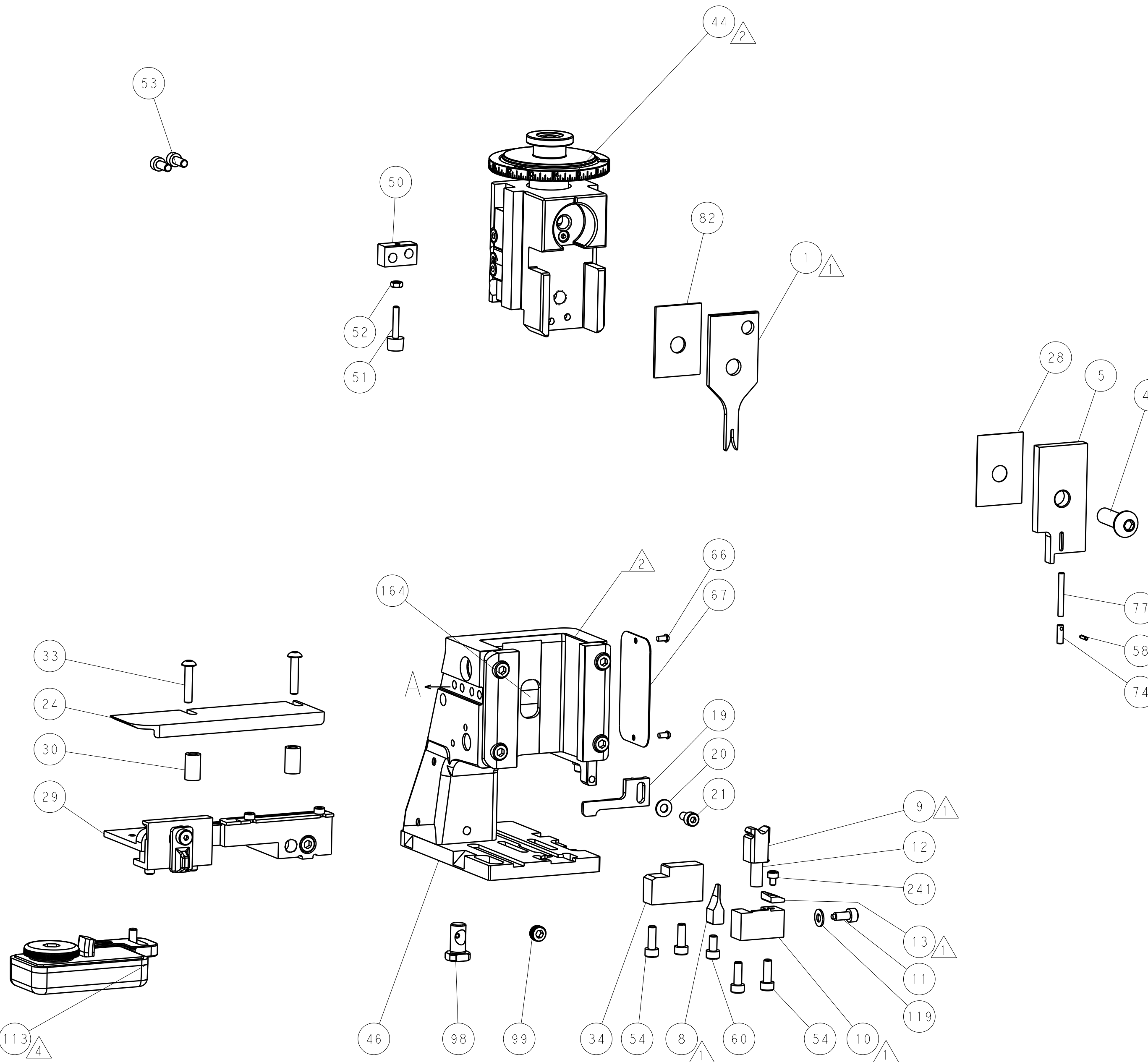
30mm STROKE

248

49

40mm STROKE

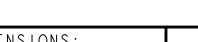
AIR FEED



Technical drawing of a mechanical part. A dimension line indicates a height of 44.81 ± 0.05 . A callout circle labeled "44 REF" points to a feature on the top surface of the part.

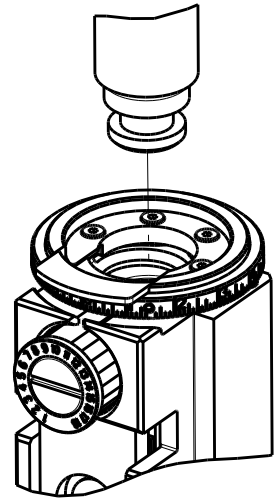
ITEM 30 LOCATED AT FRONT HOLES

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

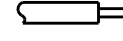
THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN P. O. WILSON 17JUN2013 CHK K. J. STAKEM 18JUN2013 APVD J. L. FLINN 18JUN2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC -		SIZE A 00779	
MATERIAL -		APPLICATION SPEC -		DRAWING NO C=2151973	
FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing					
				SCALE 1:2	SHEET 2 OF 4
				REV F	

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 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 3
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				
		P	LTR	DESCRIPTION	DATE	OWN
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
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R.O.WILSON CHK K.J.STAKEM APVD T.L.ELGIN	17JUN2013 18JUN2013 18JUN2013	STE TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator		
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		
MATERIAL		-		APPLICATION SPEC		
-		-		SIZE CASE CODE DRAWING NO A1 00779 C=2151973		
-		-		RESTRICTED TO		
-		-		Customer Accessible Production Drawing		
-		-		SCALE 1:2 SHEET 3 OF 4 REV F		

Diagram of the robot arm assembly with callouts 239, 59, and 56.

DOUBLE ACTING
PNEUMATIC
WITH SENSORS

290

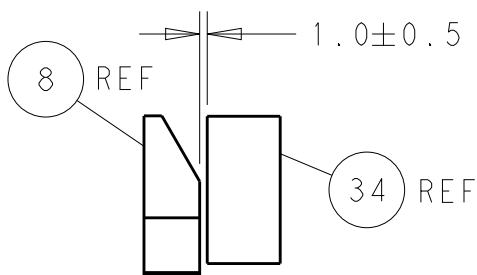
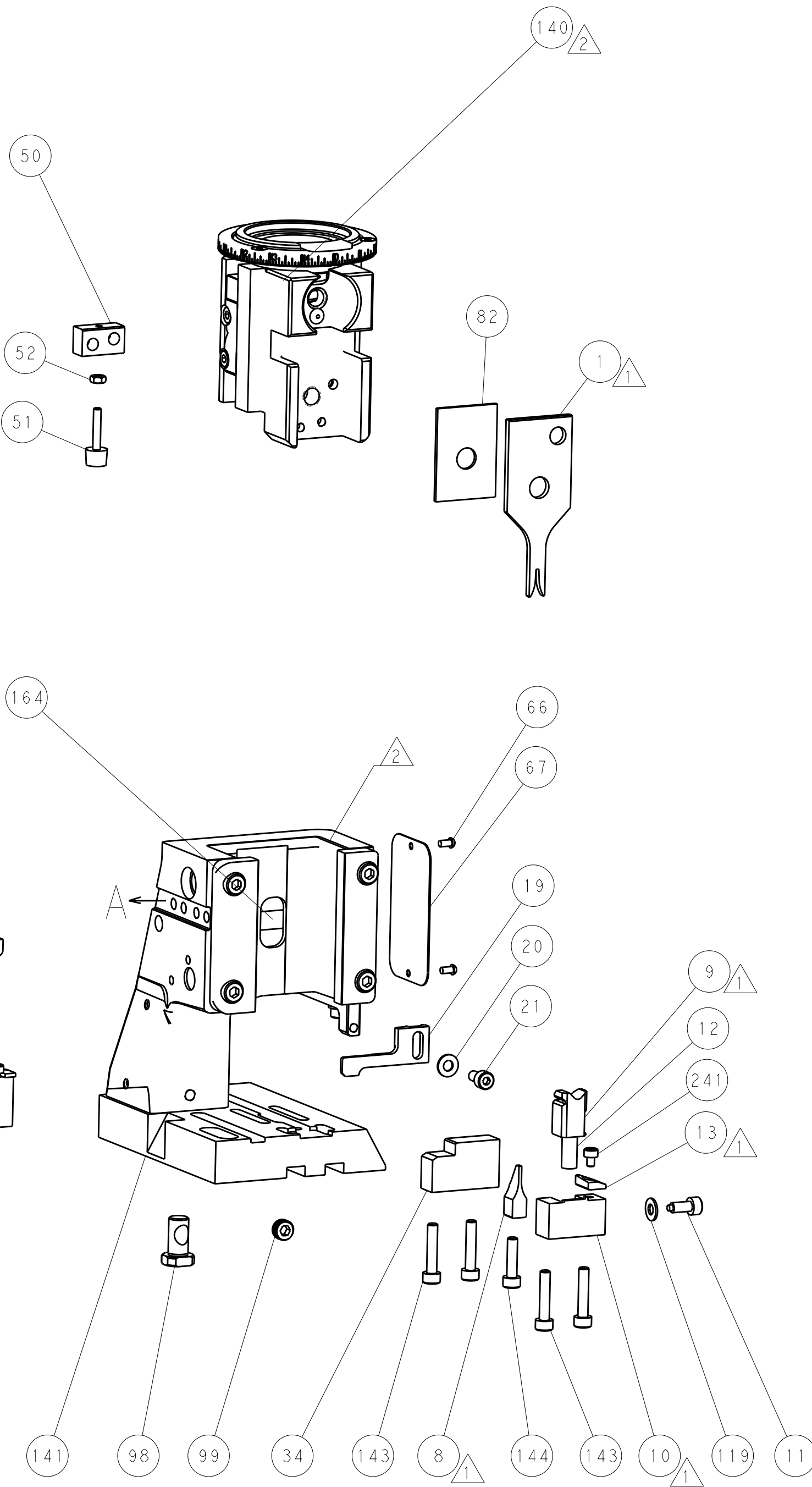
A →

59

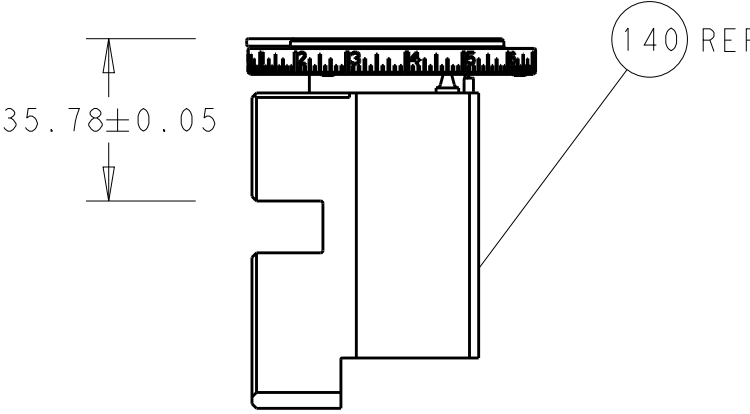
56

SEE DETAIL A

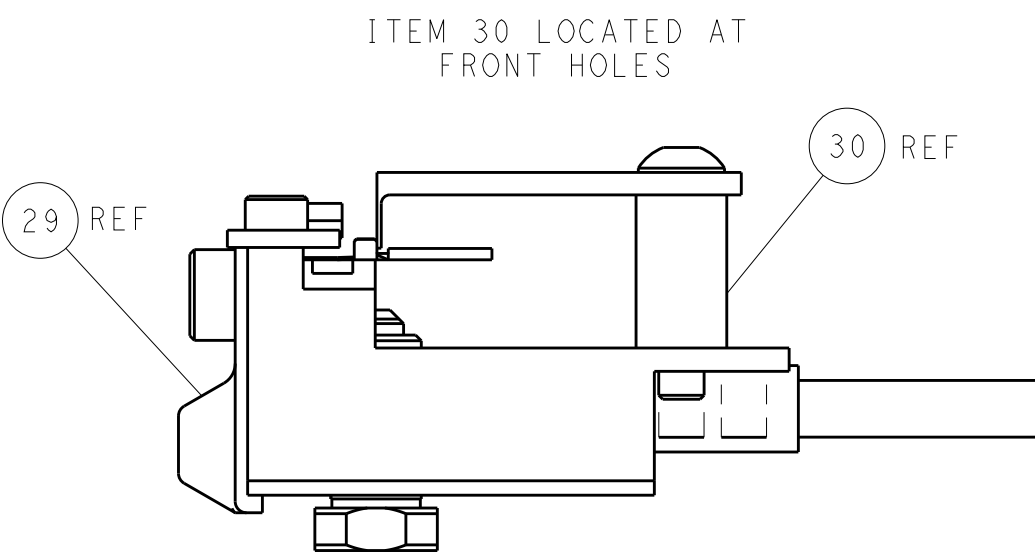
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT
FRONT HOLES

FEED TRACK POSITION
GUIDE BY WIRE BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR FPD ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ISSUING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.									
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG R.O. WILSON 18JUN2013		 TE Connectivity Harrisburg, PA 17105-3608			
		0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		APVD T.L. ELBIN 18JUN2013		NAME Ocean Side Feed Applicator -			
MATERIAL FINISH		WEIGHT		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1		CAGE CODE 00779	
						DRAWING NO C=2151973		RESTRICTED TO -	
Customer Accessible Production Drawing						SCALE 1:2		SHEET 4 OF 4	
						REV F			

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[TE Connectivity:](#)

[2151973-1](#)