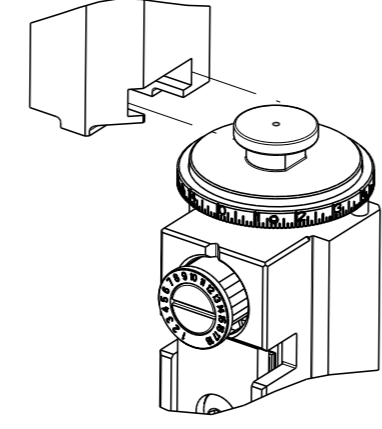


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151974-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151974-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151974-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
7-2151974-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151974-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151974-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

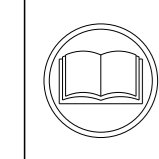


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, HF FARKA 2. RTK031			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.50-3.00 mm [.098-.118 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-18623	-	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418990-1	1418990-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.5mm2 LOW LOSS	1.03+/-0.03 [.041+/- .001]	6.4
RTK031	0.91+/-0.03 [.036+/- .001]	7.5



- 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	P	LYR	DESCRIPTION	DATE	OWN	APVD
		D		ECR-19-006049	19APR2019	MZ	YY
		E		ECR-20-014325	09OCT2020	FJ	TE
		E1		ECR-20-015841	06NOV2020	FZ	RR
		F		ECR-21-003982	02APR2021	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	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	1-455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	1	854769-7	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-9	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	
-	2	2	2	2	2	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	2-1633733-3	ANVIL, WIRE	8
-	1	1	1	1	1	1-240641-9	SPACER	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	-	2	
-	1	2	2	1	1	1	1803212-2	CRIMPER, WIRE PREMIUM	1

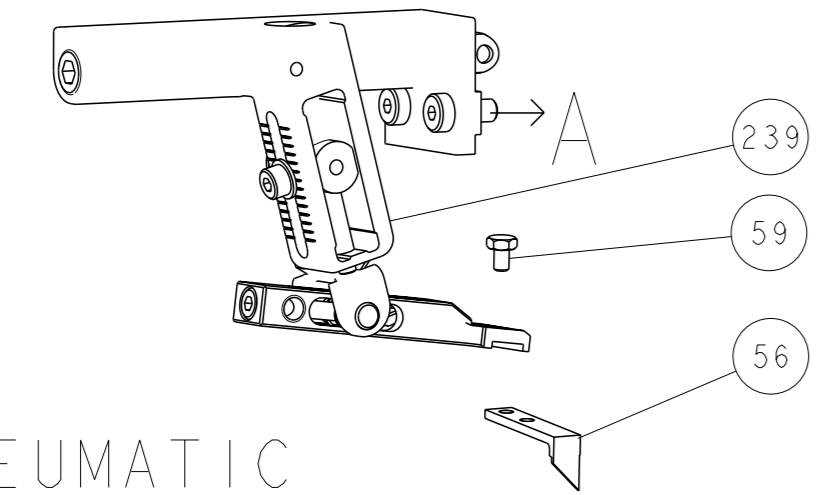
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLS	FINISH	-	-	1:2	SHEET 1 OF 4

OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
R. O. WILSON	K. J. STAKEM	T. L. ELBIN	24 JUN 2013	Ocean Side Feed Applicator	A1	00779	2151974	-

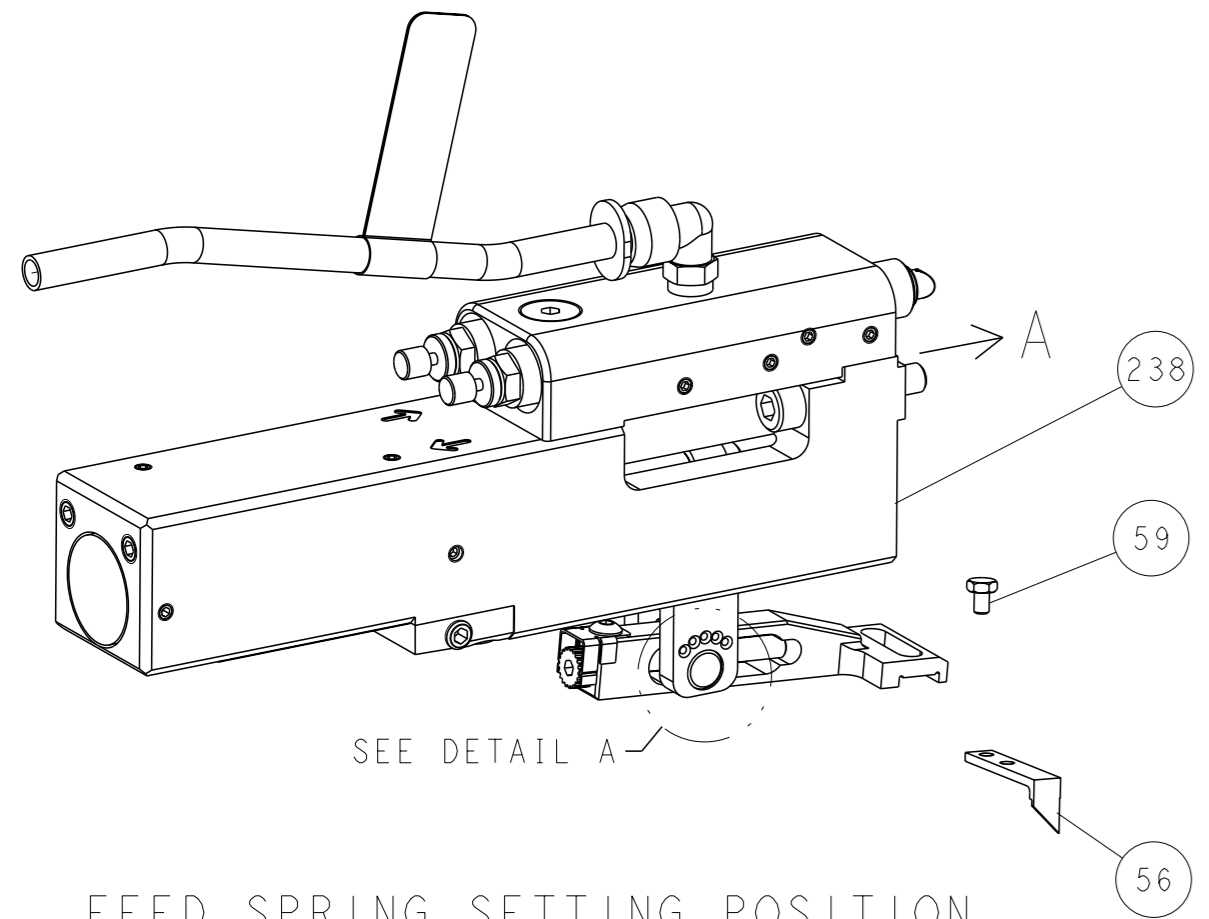
Customer Accessible Production Drawing

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

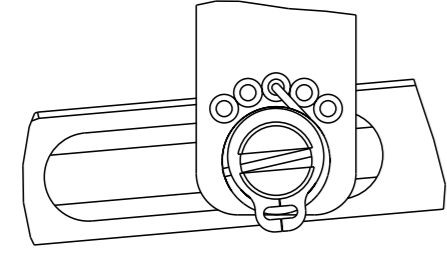
FEED TYPE MECHANICAL



PNEUMATIC

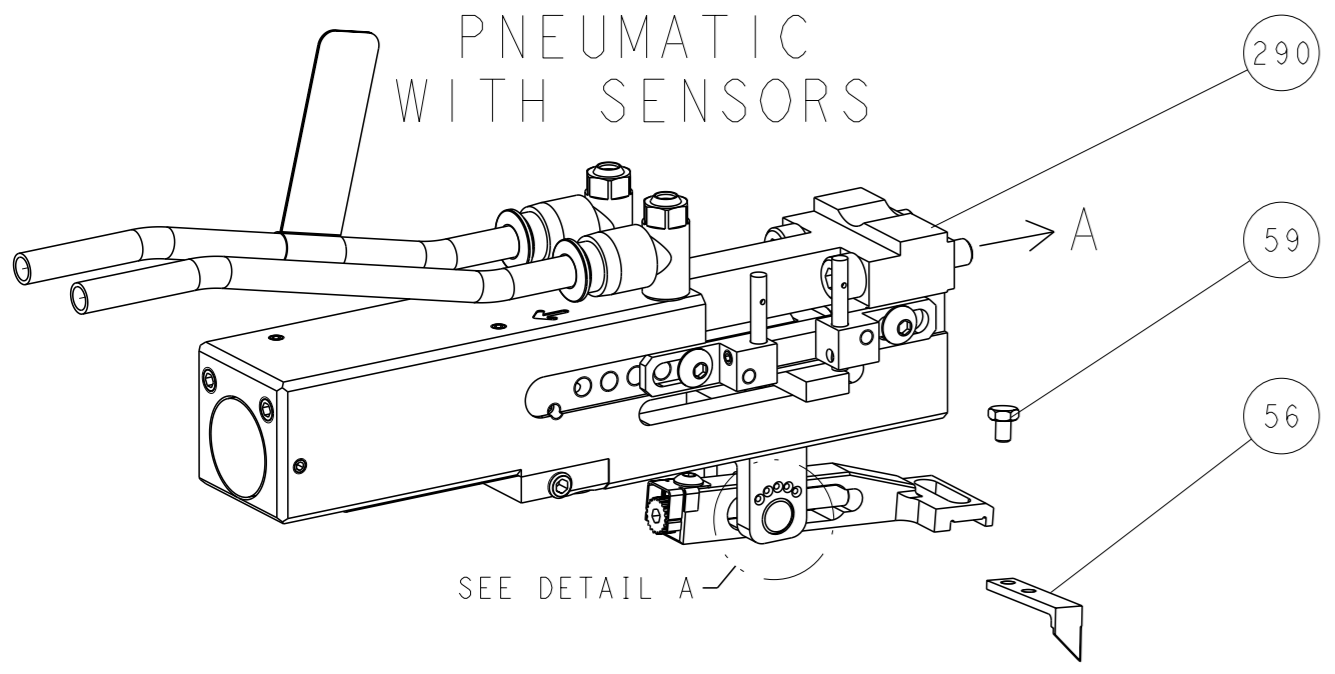


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



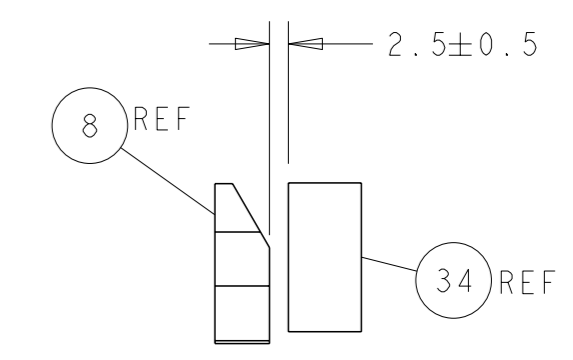
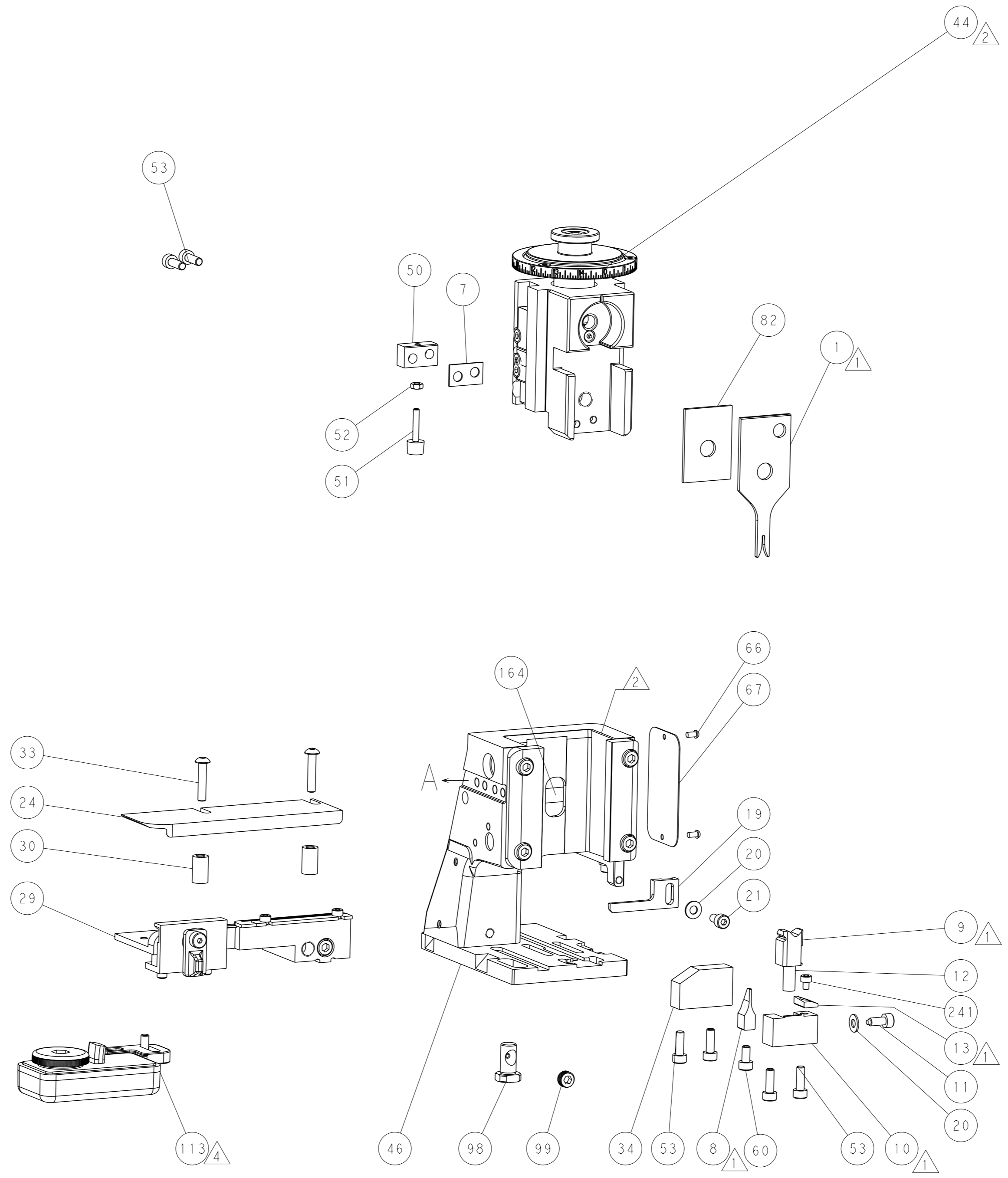
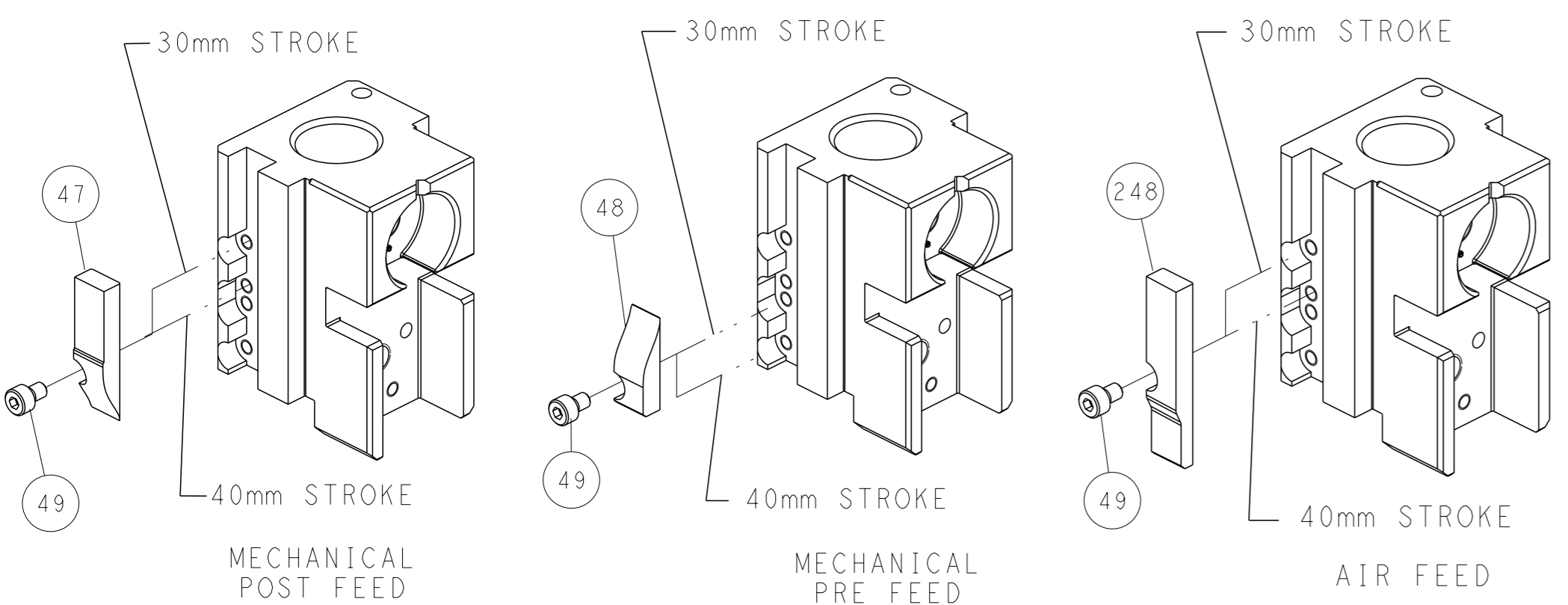
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

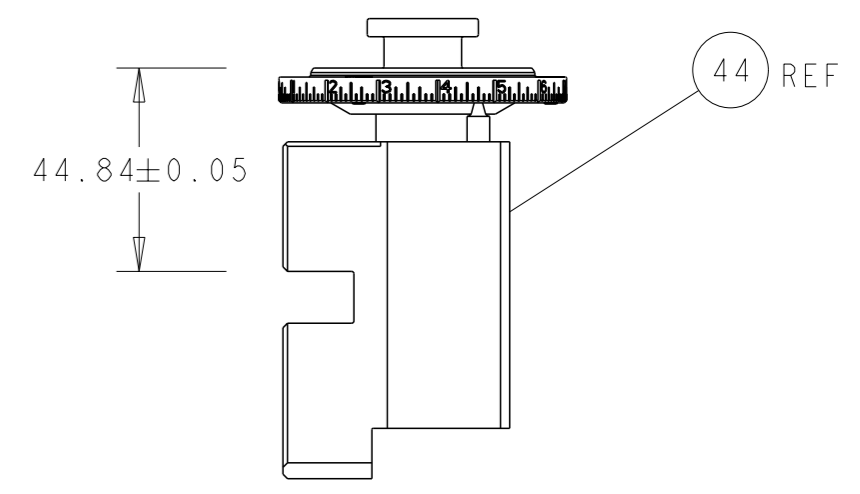


SEE DETAIL A

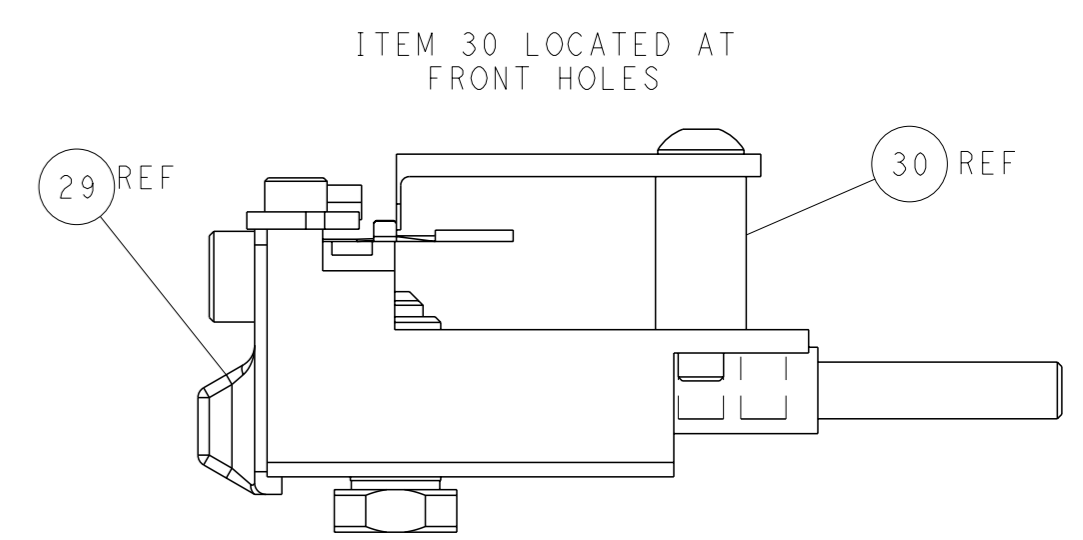
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



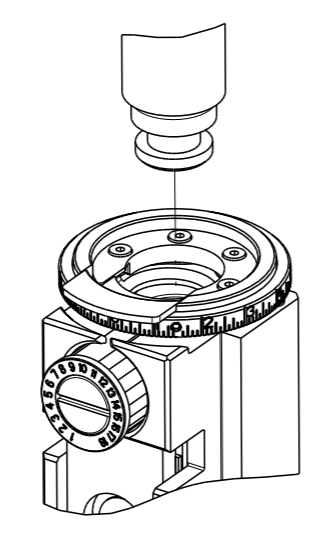
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: J. L. ELBIN	20 JUN 2013 24 JUN 2013 24 JUN 2013	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: A1 CAGE CODE: 00779 DRAWING NO: ©=2151974	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: F	
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151974-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151974-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151974-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
7-2151974-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

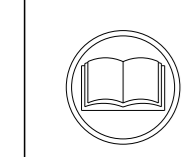


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, HF FARKA 2. RTK031			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.50-3.00 mm [.098-.118 IN]			
TERMINAL APPLICATION SPECIFICATION	114-18623		
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418990-1	1418990-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.5mm2 LOW LOSS	1.03+/-0.03 [.041+/-0.001]	6.4
RTK031	0.91+/-0.03 [.036+/-0.001]	7.5



- 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	REVISIONS					
A	66	P	LYR	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	
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	
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	1-455888-5	SPACER, CRIMPER	82	
-	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	854769-7	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-9	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	
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
¹	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
¹	1	1	1	1	2-1633733-3	ANVIL, WIRE	8
-	1	1	1	1-240641-9	SPACER	7	
-	-	-	-	-	-	6	
-	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	4	
-	-	-	-	-	-	3	
-	-	-	-	-	-	2	
¹	1	1	1	1	1803212-2	CRIMPER, WIRE PREMIUM	1

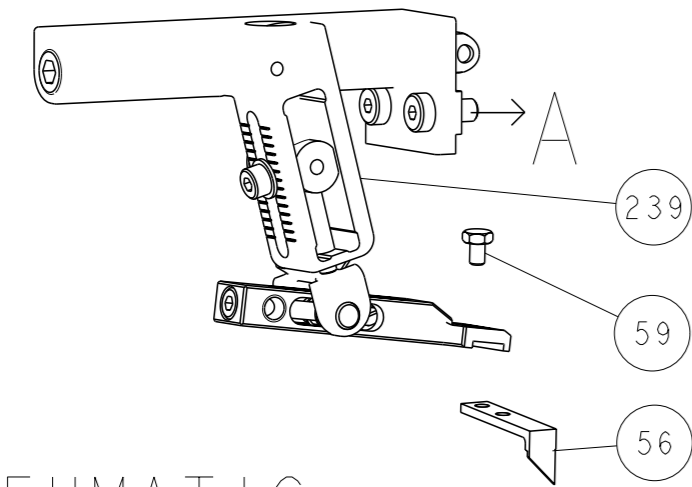
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT			

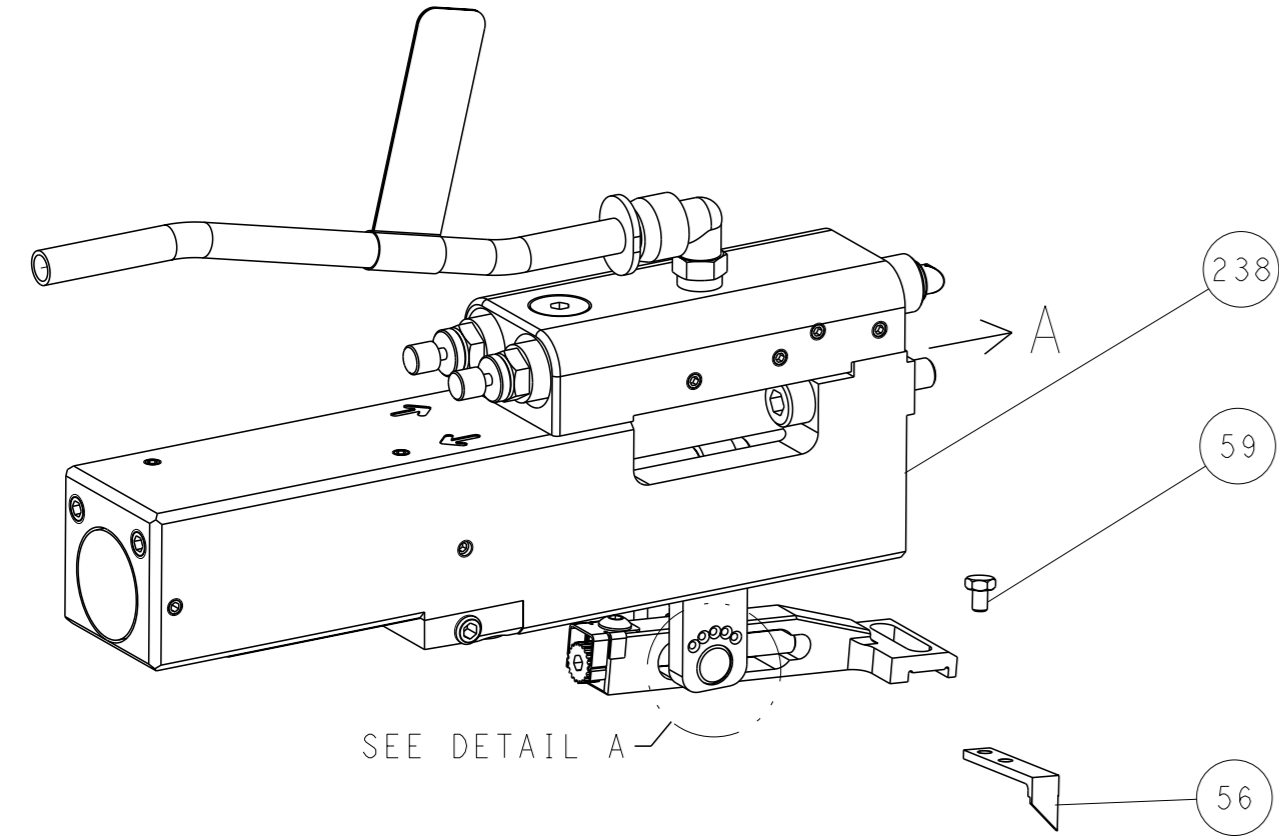
OWN	R. O. WILSON	20 JUN 2013
CHK	K. J. STAKEM	24 JUN 2013
APVD	T. L. ELBIN	24 JUN 2013
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151974
Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 of 4 REV F

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

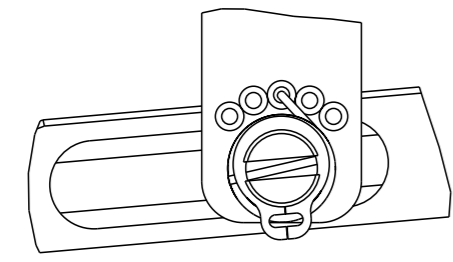
FEED TYPE MECHANICAL



PNEUMATIC

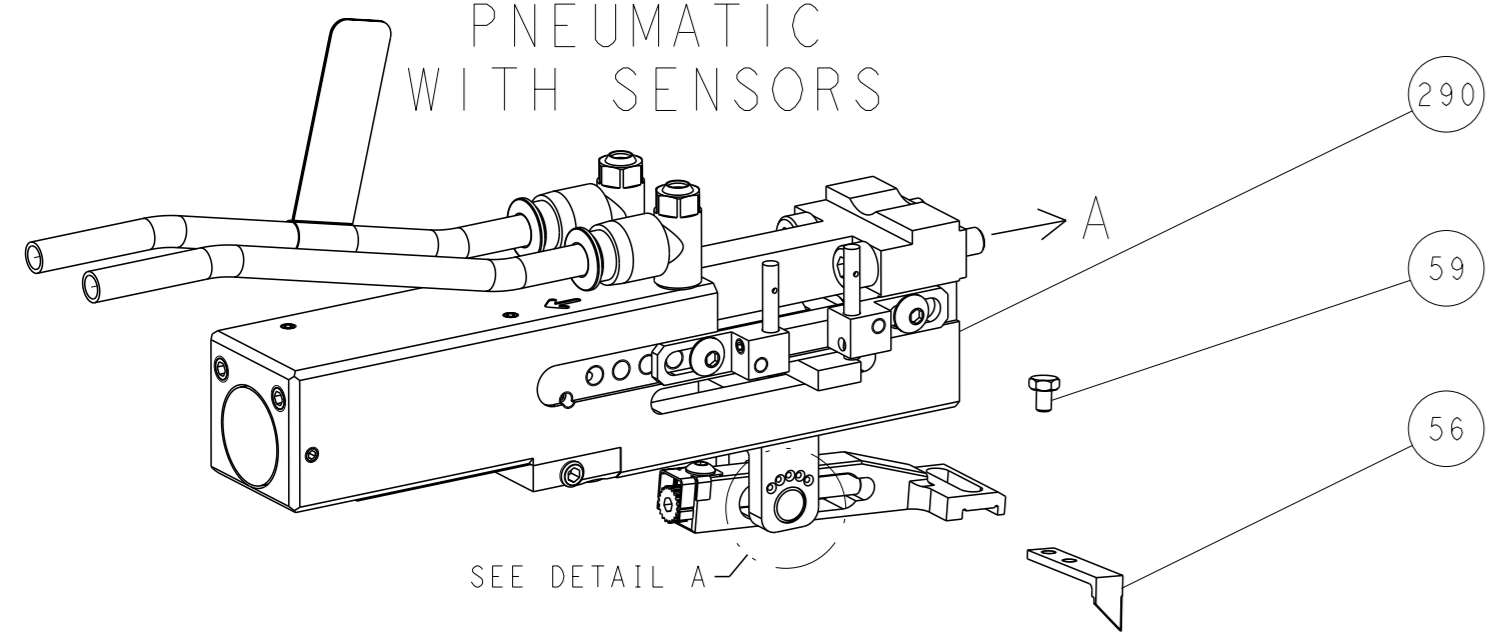


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

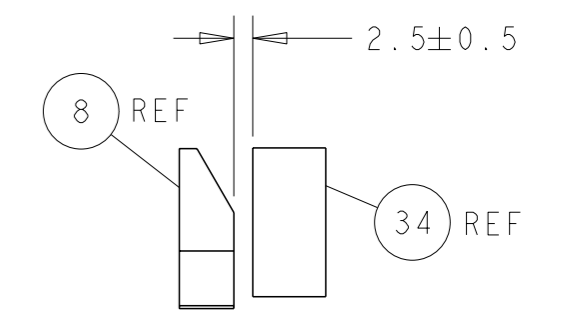
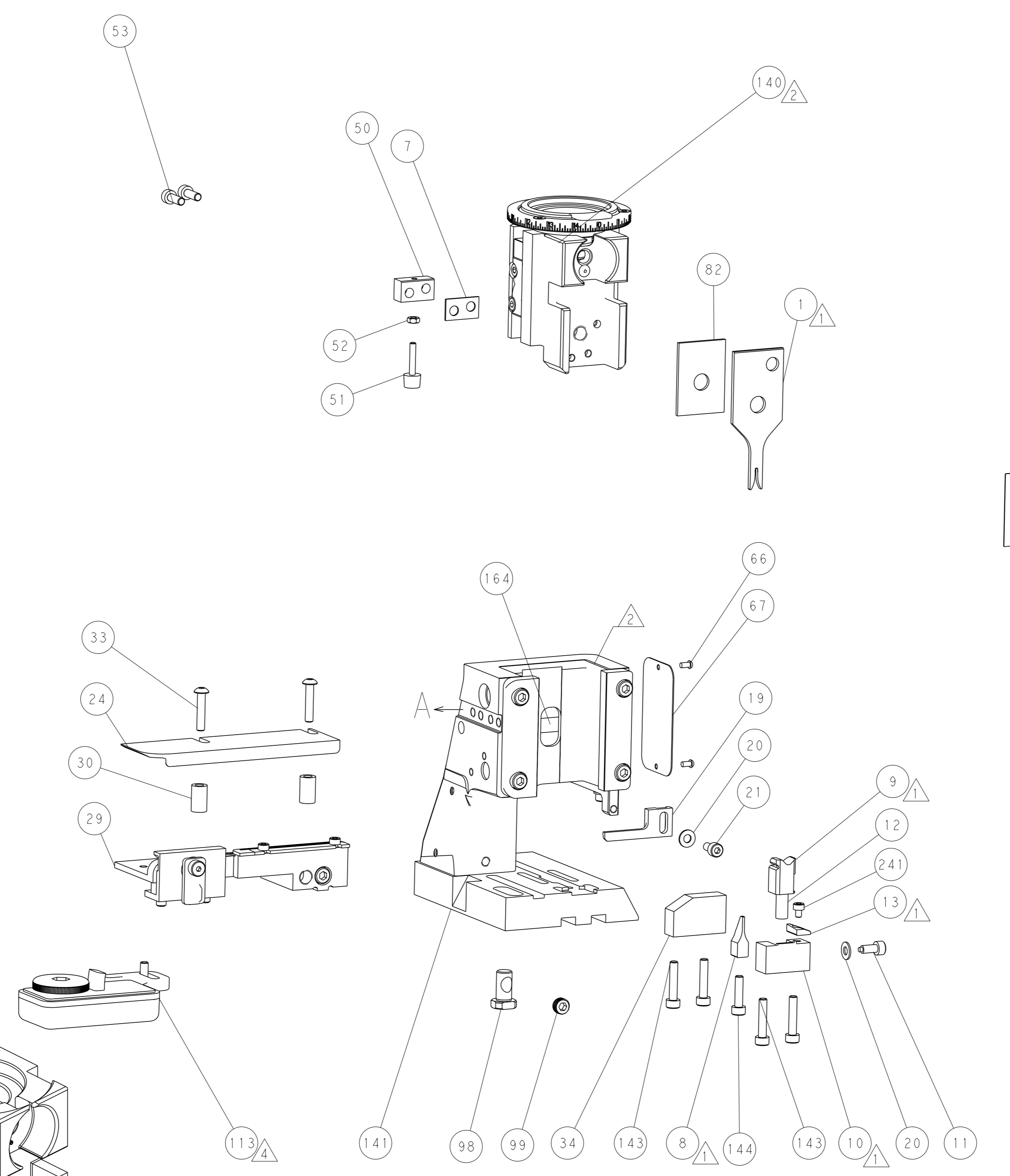
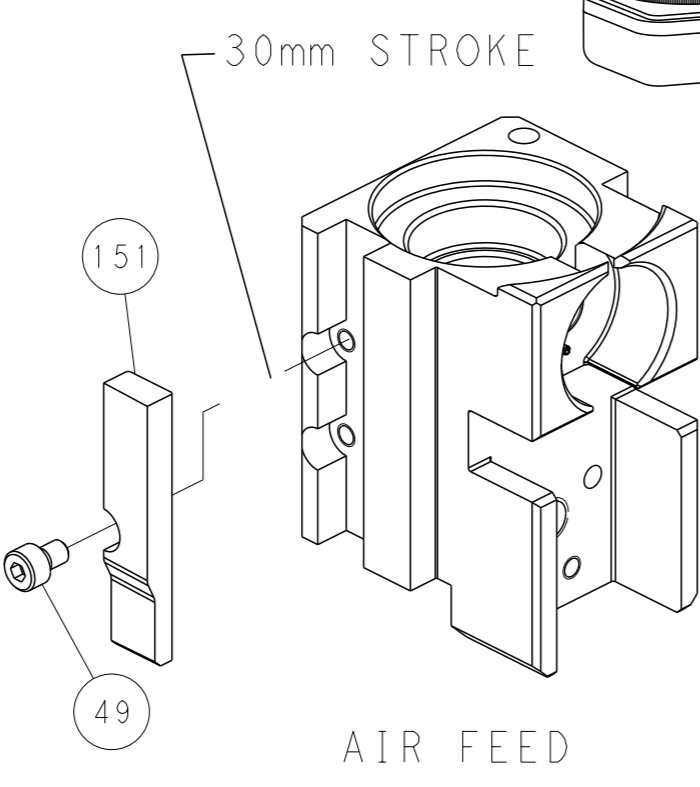
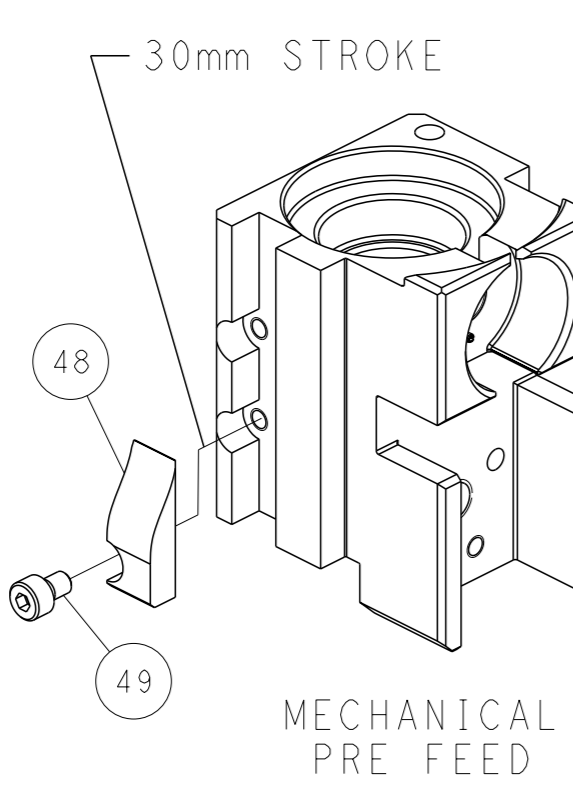
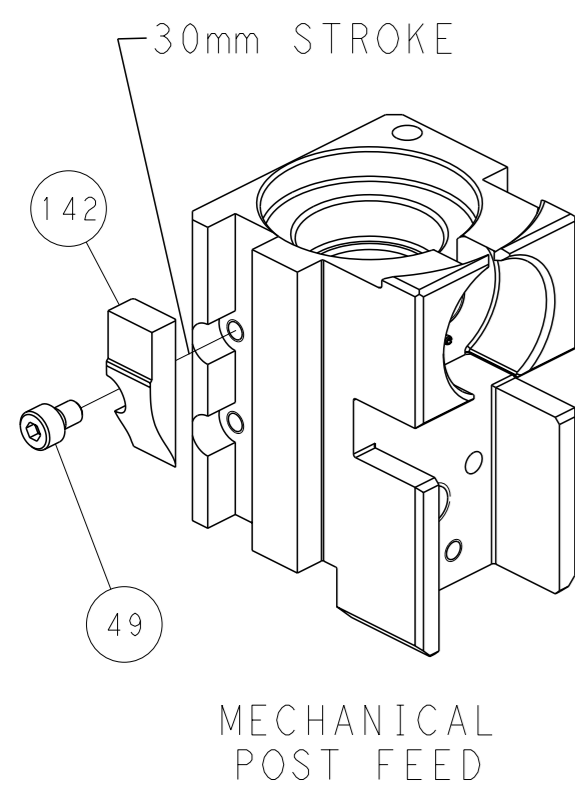


DETAIL A

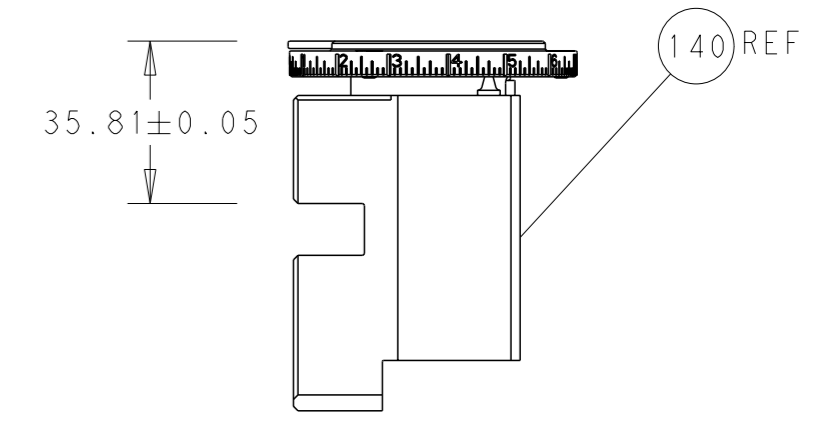
DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS

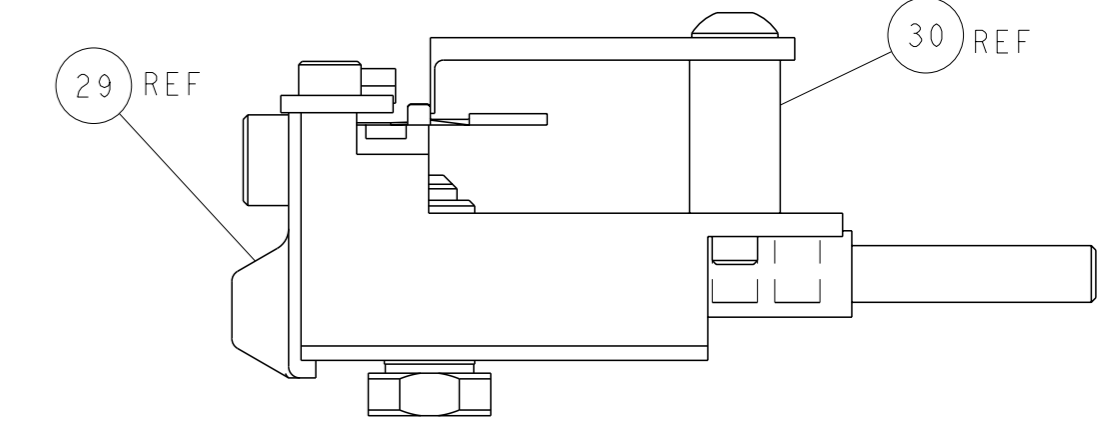


TERMINAL SUPPORT LOCATION



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: J. L. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - WEIGHT: -	20 JUN 2013 24 JUN 2013 24 JUN 2013 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151974 SCALE: 1:2 SHEET: 4 of 4 REV: F	TE Connectivity Harrisburg, PA 17105-3608
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