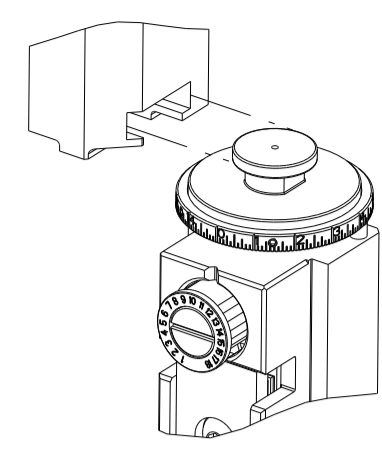


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151973-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151973-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151973-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151973-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151973-2	F	PNEUMATIC AND CRIMP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

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

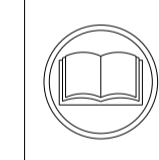


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm (.050)	F
INSUL	-	-

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 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418972-1	1418973-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
LOW LOSS	0.93+/-0.03 [.037+/- .001]	7.0
RTK 031	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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-19-006462	23APR2019	FJ	TE
		E		ECR-19-007109	03MAY2019	LG	TE
		F		ECR-20-009518	03JUL2020	FZ	TE
		F1		ECR-23-179433	26JUN2023	FZ	JAH

-	-	-	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

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

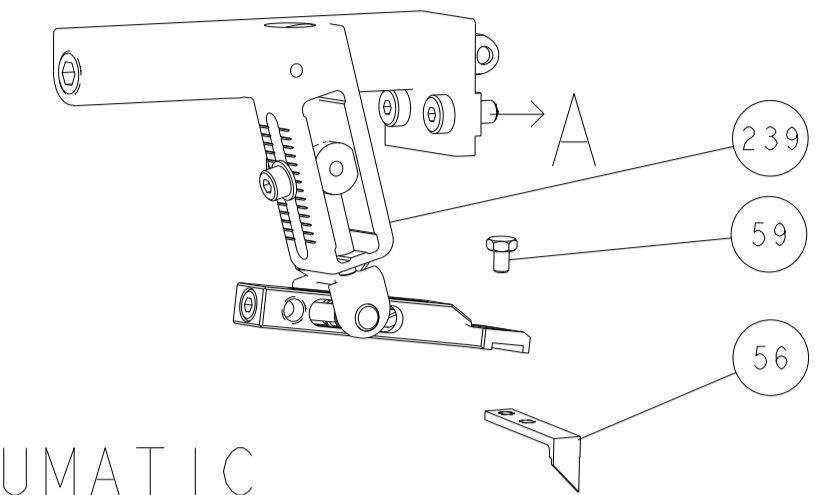
OWN	R. O. WILSON	17JUN2013	
CHK	K. J. STARK	18JUN2013	
APVD	T. L. ELBIN	18JUN2013	

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151973	-

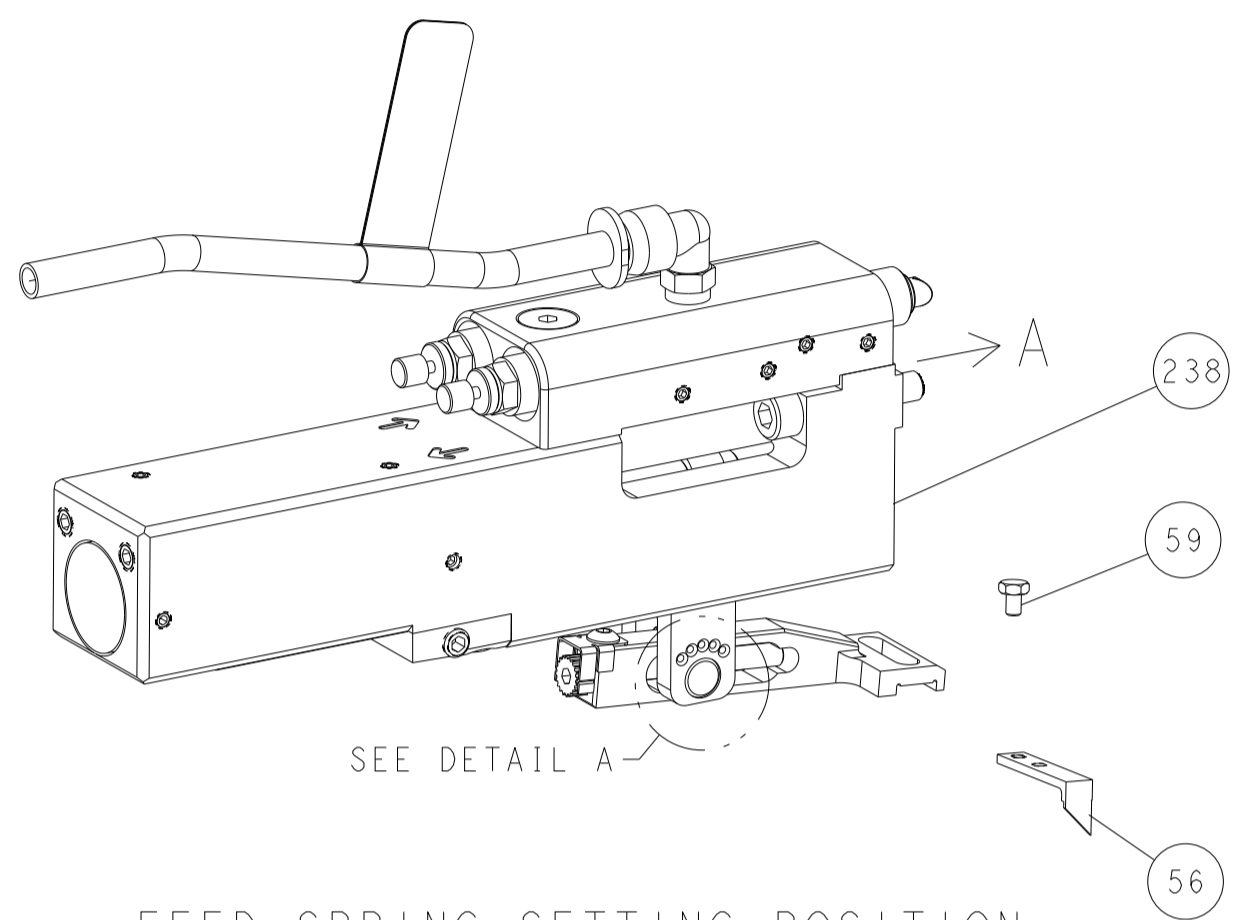
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV F1

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

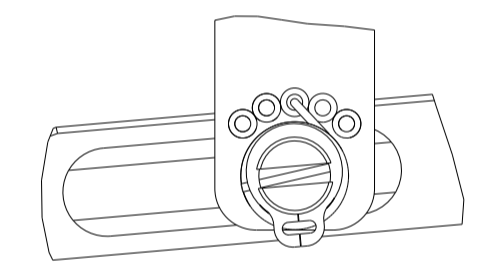
# FEED TYPE MECHANICAL



## PNEUMATIC

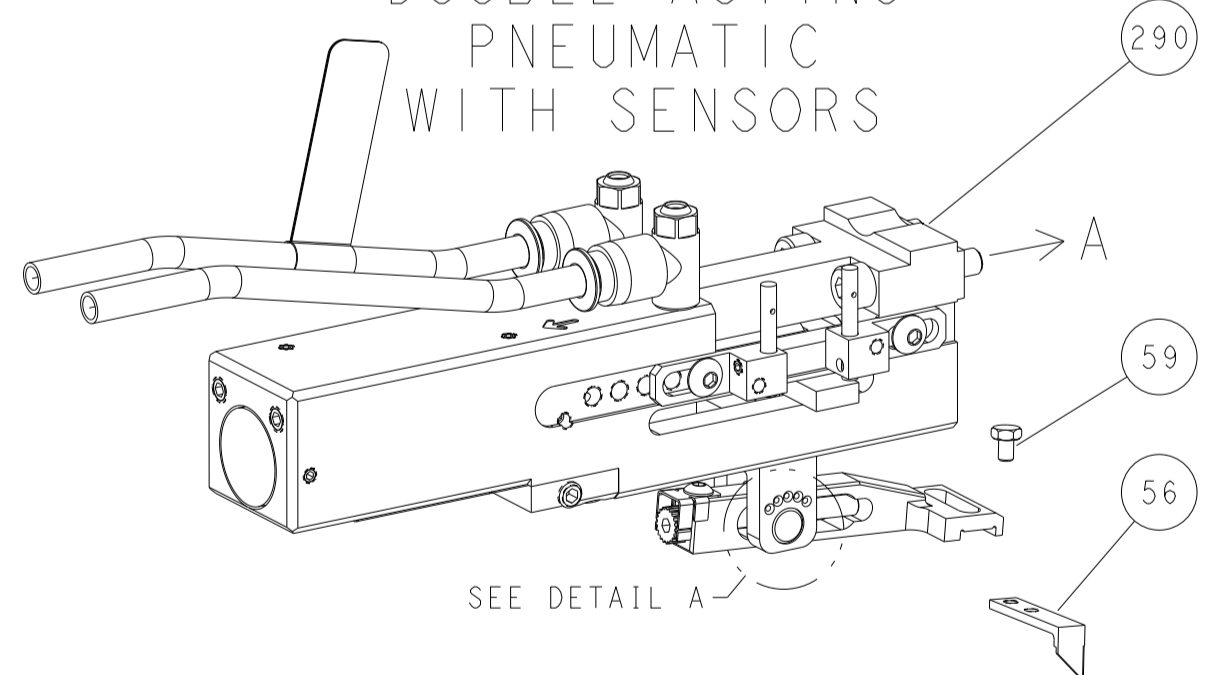


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

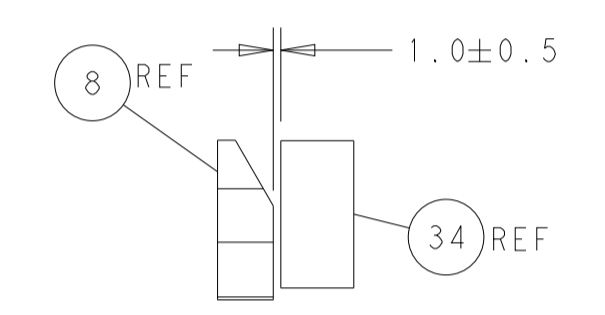
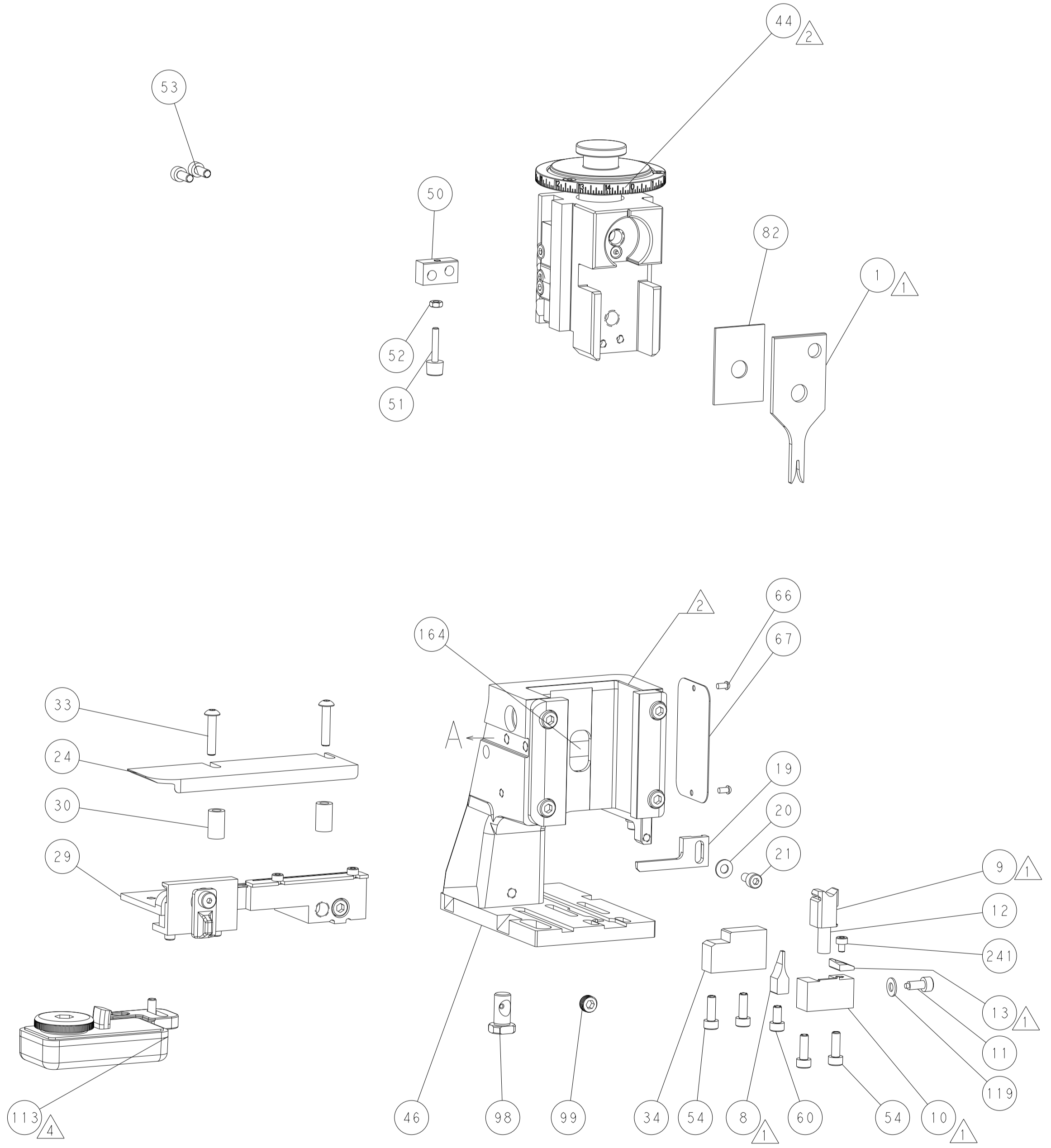
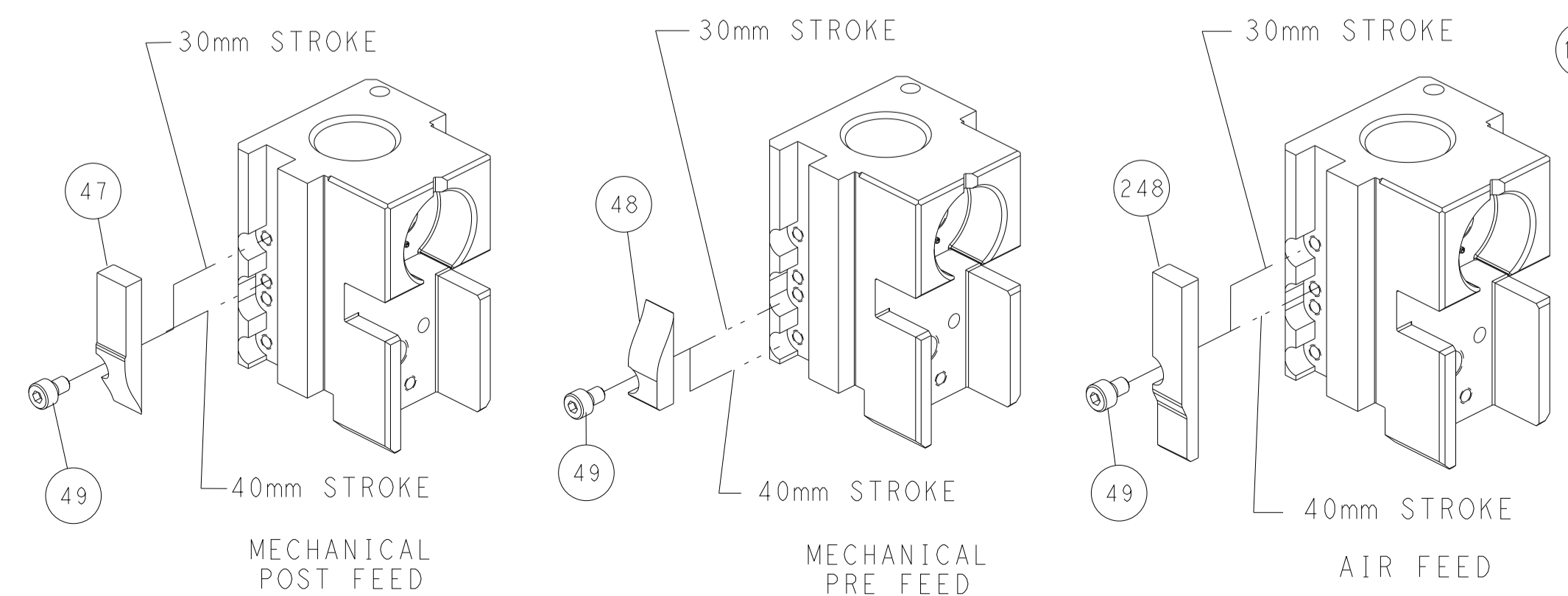


DETAIL A

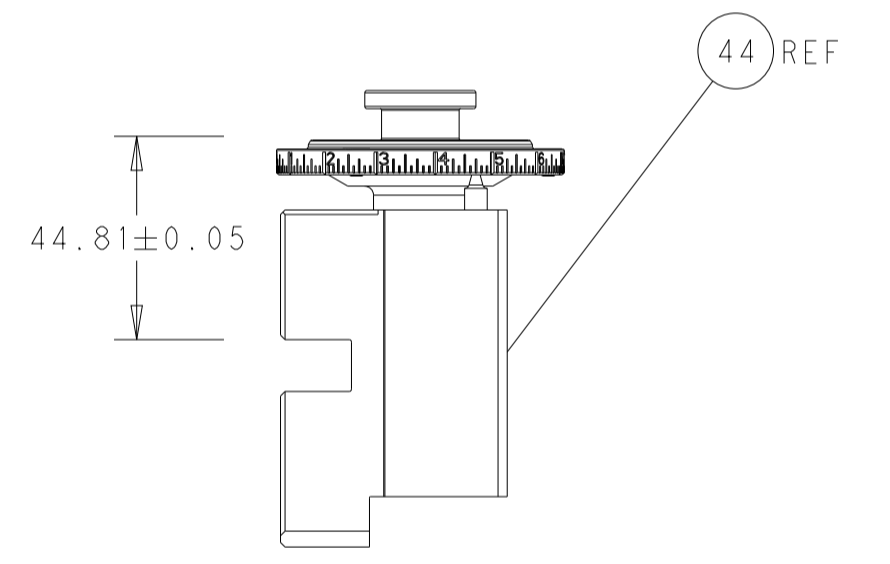
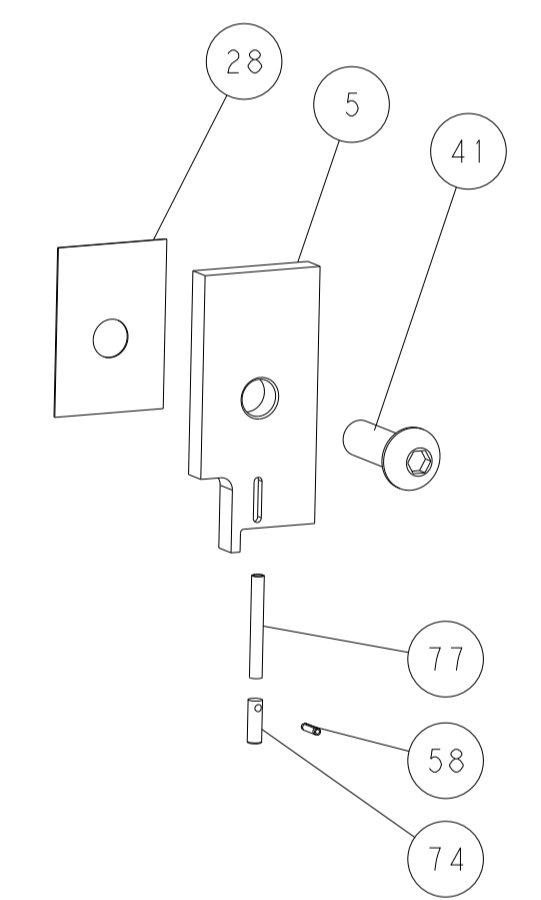
## DOUBLE ACTING PNEUMATIC WITH SENSORS



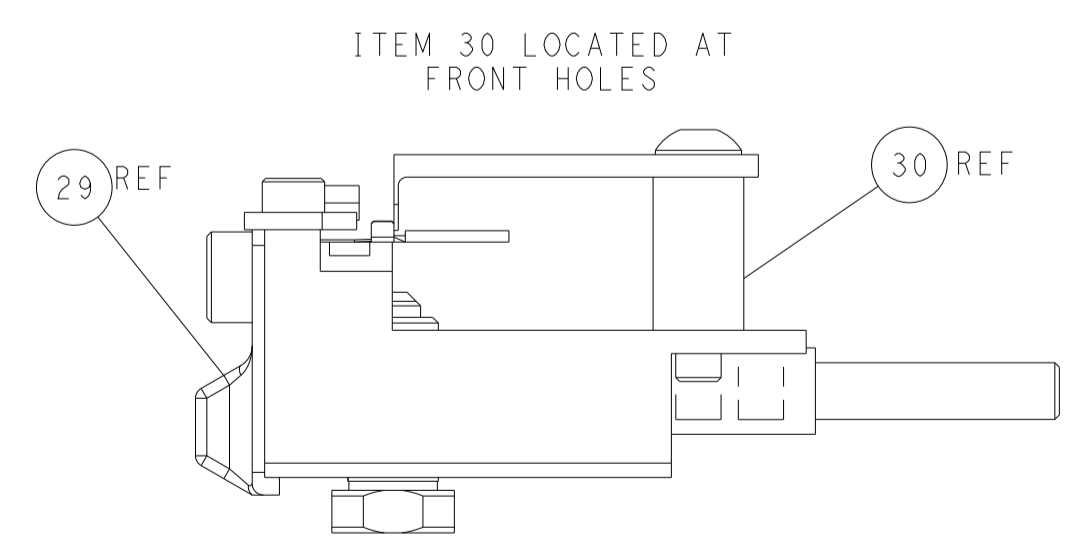
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



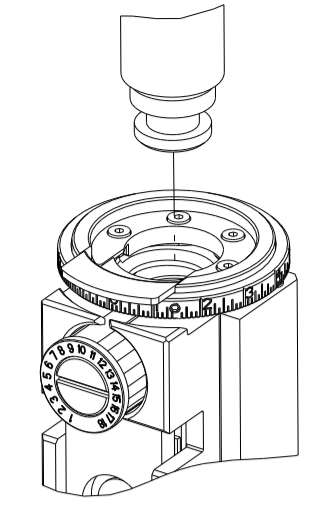
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151973 SHEET 2 OF 4 REV F1
MATERIAL:		Customer Accessible Production Drawing	

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		INSULATION DIAMETER RANGE	
2.30-2.70 mm [.091-.106 IN]			
TERMINAL APPLICATION SPECIFICATION	114-18622	-	-
TERMINALS APPLIED <sup>4</sup> / <sub>6</sub>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418972-1	1418973-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
LOW LOSS	0.93+/-0.03 [.037+/-0.001]	7.0
RTK 031	0.81+/-0.03 [.032+/-0.001]	8.2



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- <sup>3</sup> 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.
- <sup>4</sup> TERMINAL LUBRICANT IS RECOMMENDED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- <sup>6</sup> 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)

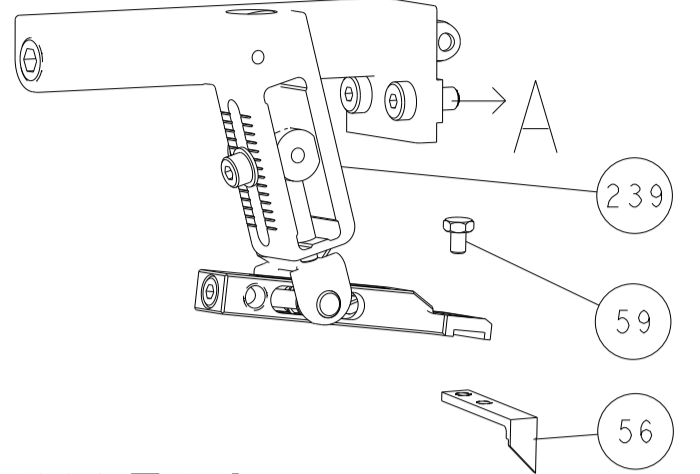
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	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
<sup>6</sup>	-	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
<sup>4</sup>	-	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
<sup>6</sup>	-	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
<sup>1</sup>	-	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
<sup>1</sup>	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	1	2-1633733-2	ANVIL, WIRE	8
-	-	-	-	-	-	6
-	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	4
-	-	-	-	-	-	3
-	-	-	-	-	-	2
<sup>1</sup>	1	1	1	1803212-1	CRIMPER, WIRE PREMIUM	1

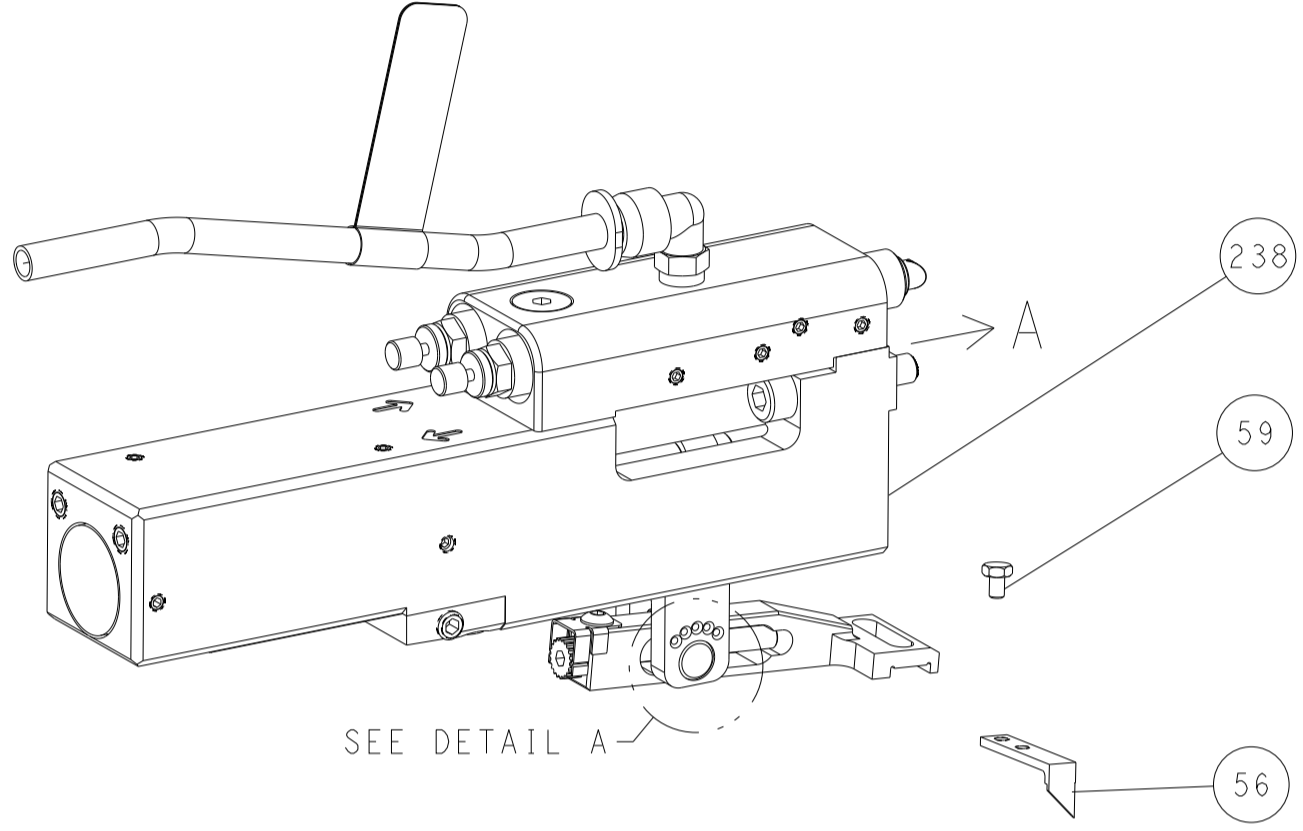
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		DESCRIPTION		ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	
MATERIAL				WEIGHT	SCALE	SHEET	OF	REV
Customer Accessible Production Drawing				00779	1:2	3	4	F1

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

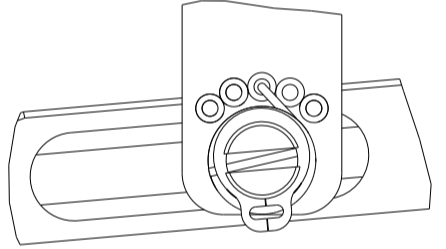
# FEED TYPE MECHANICAL



## PNEUMATIC

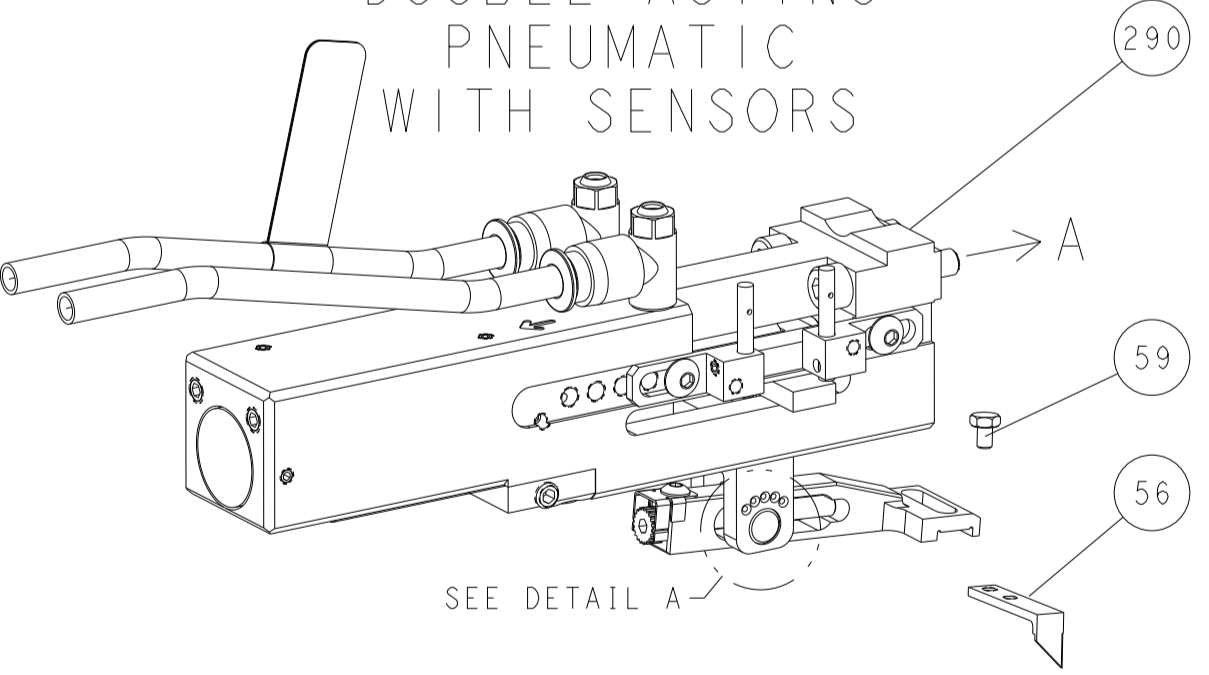


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



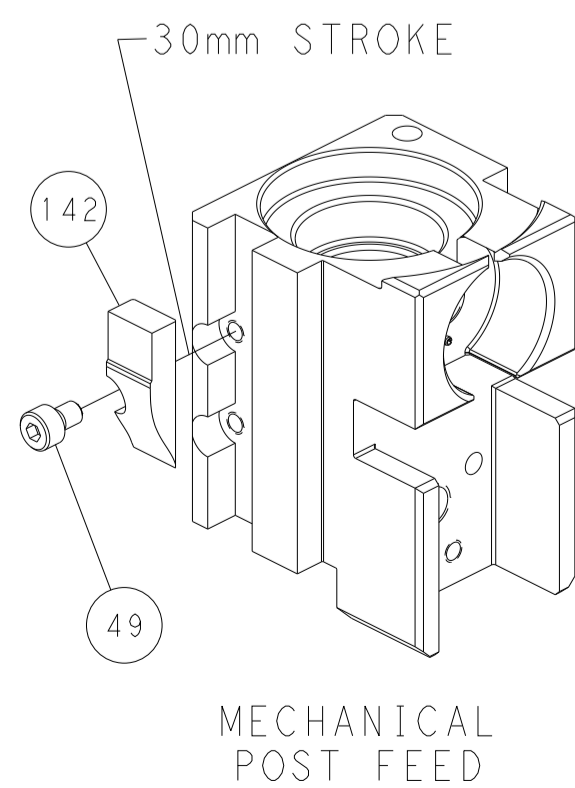
DETAIL A

## DOUBLE ACTING PNEUMATIC WITH SENSORS

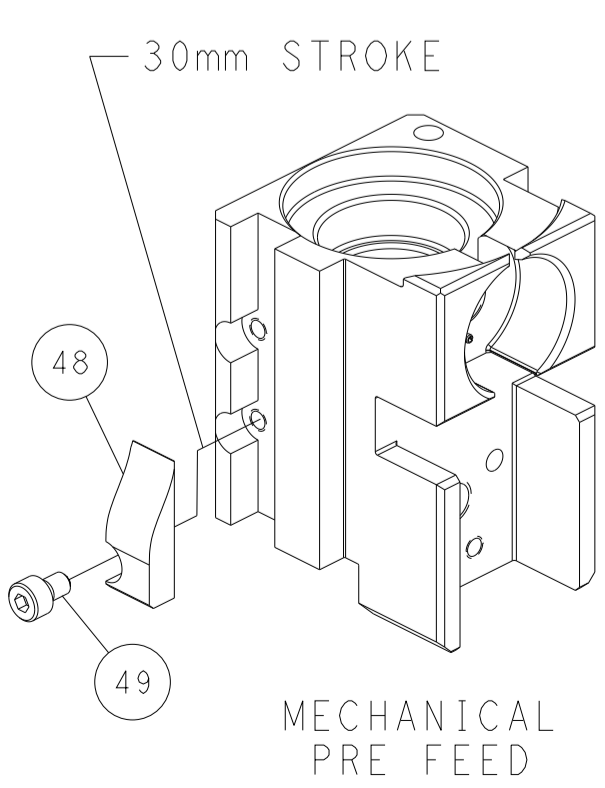


SEE DETAIL A

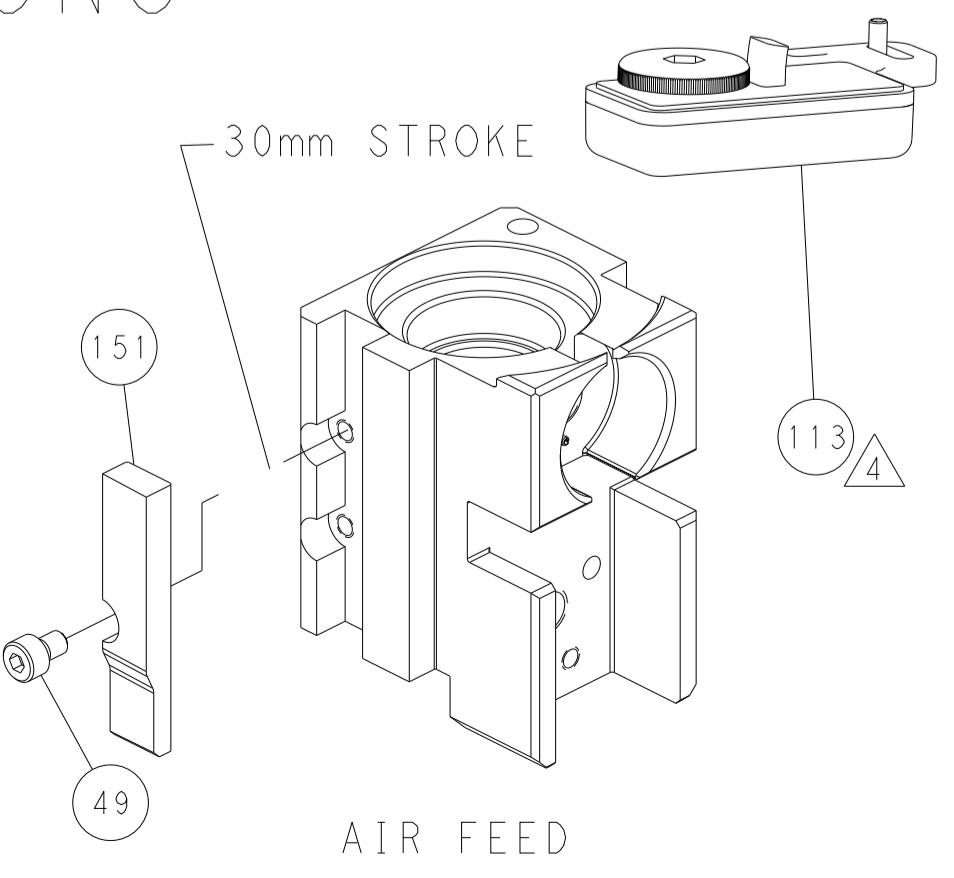
# CAM POSITIONS



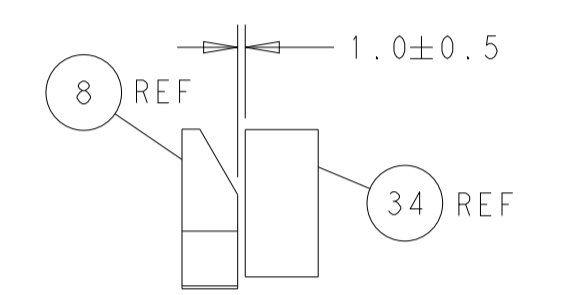
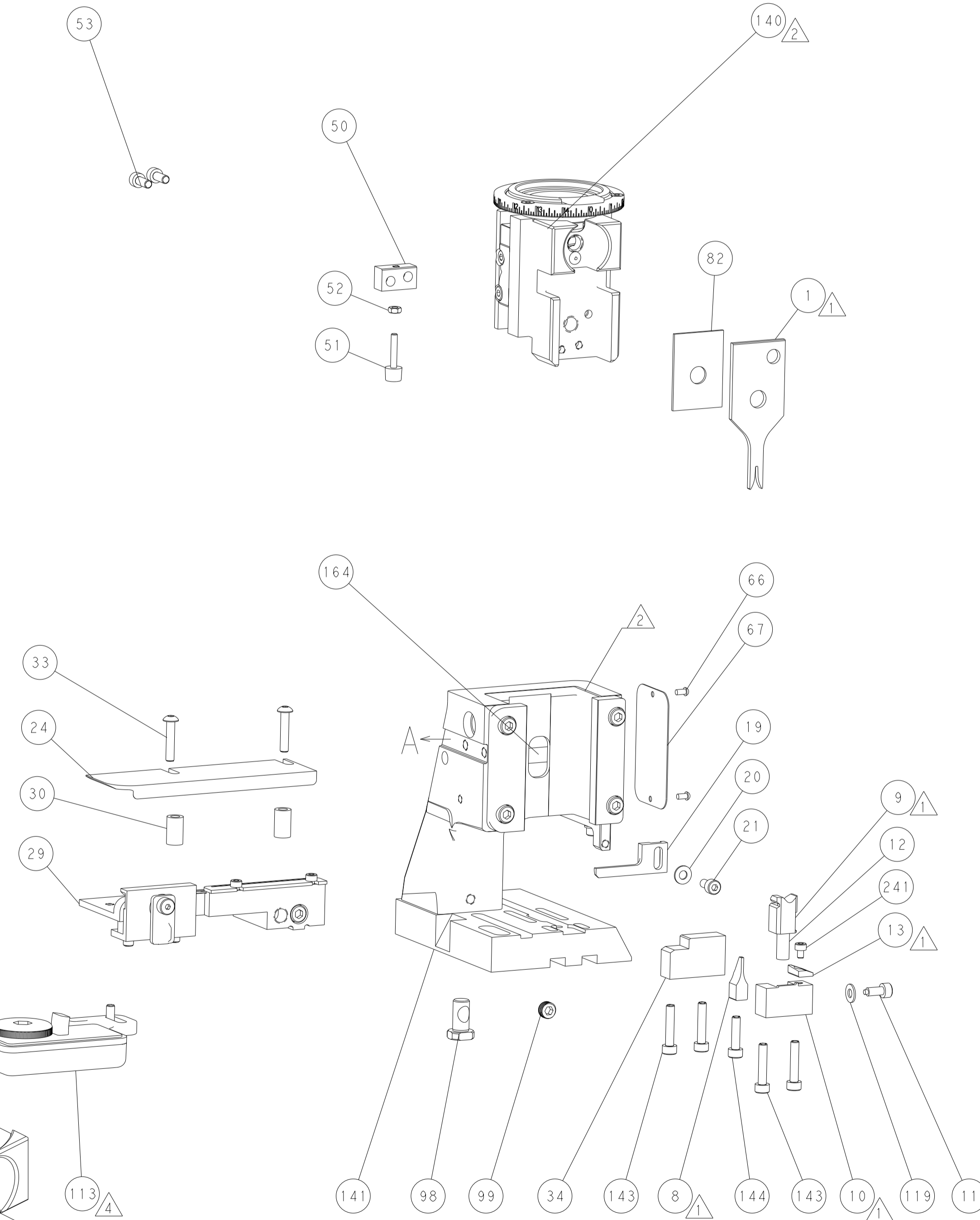
MECHANICAL  
POST FEED



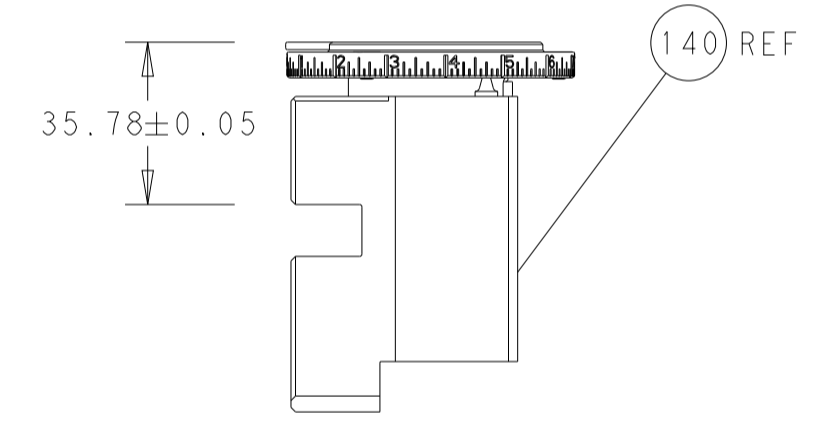
MECHANICAL  
PRE FEED



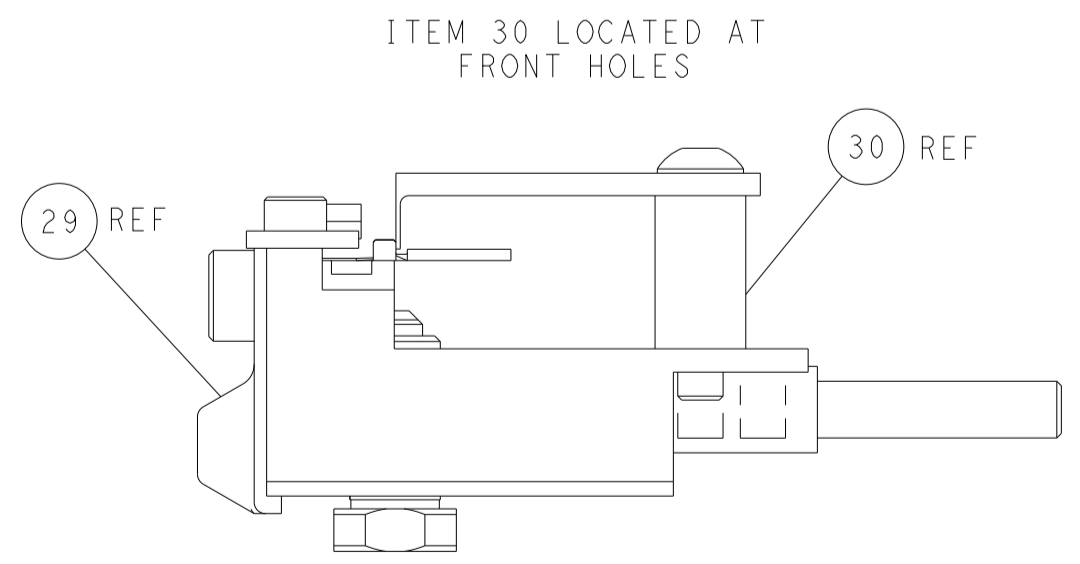
AIR FEED



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean Side Feed Applicator	RESTRICTED TO
MATERIAL:		SIZE CAGE CODE DRAWING NO A1 00779 ©=2151973	SCALE 1:2 SHEET 4 OF 4 REV F1
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		Customer Accessible Production Drawing	