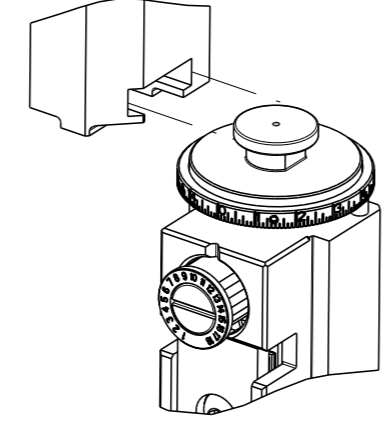


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151974-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151974-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151974-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS <sup>6</sup>
7-2151974-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151974-2	F	PNEUMATIC 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 <sup>4</sup>		
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



- <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 & 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.

LOC	DIST	REVISIONS					
A	66	P	LY#	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

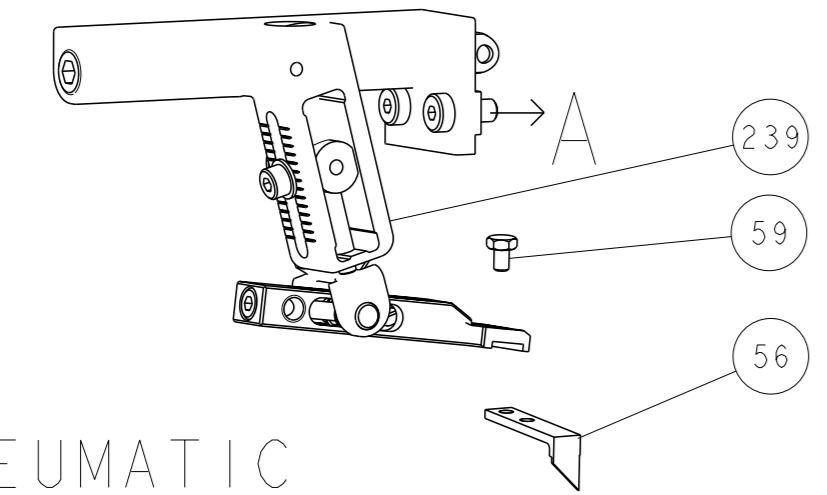
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290	
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1	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

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

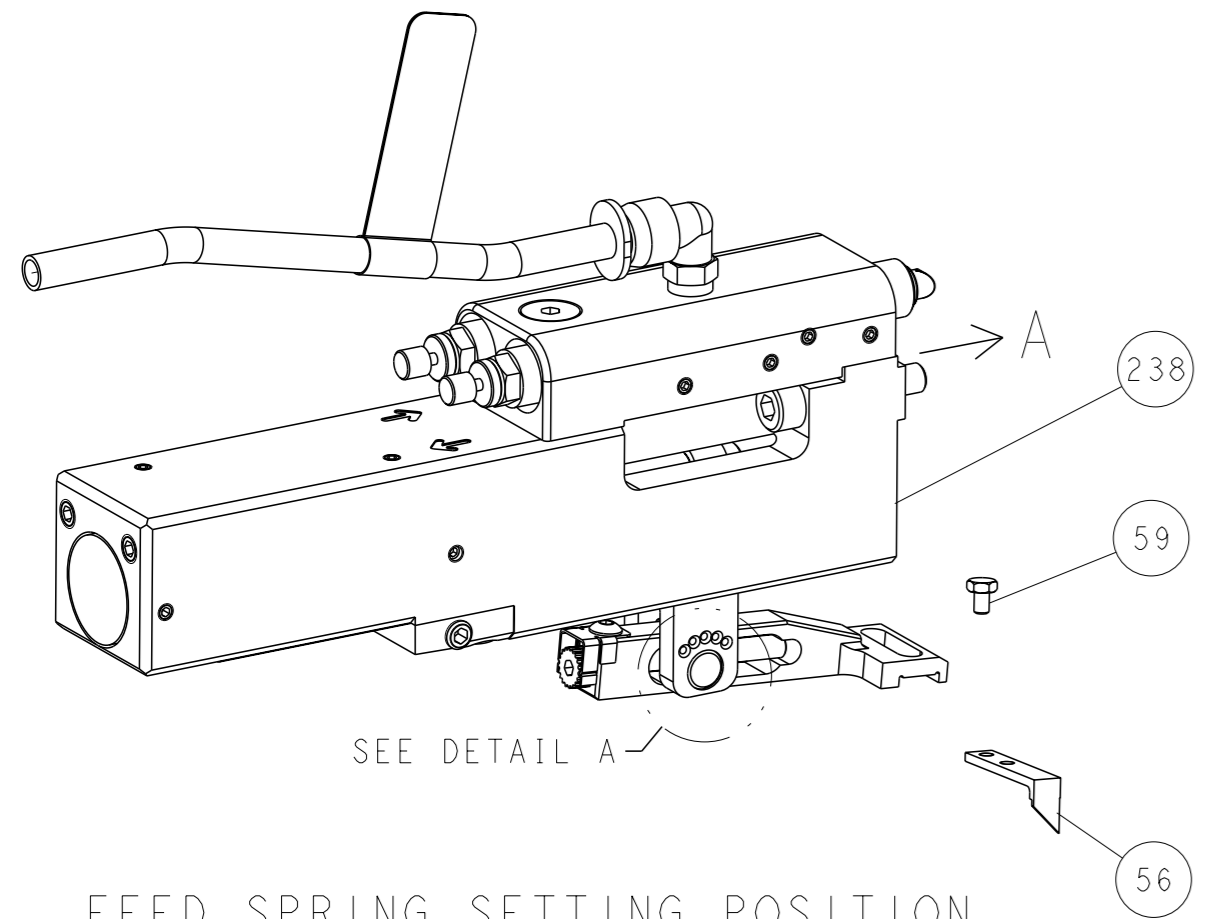
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DWG: R. O. WILSON 20 JUN 2013 CHK: K. J. STAKEM 24 JUN 2013 APVD: T. L. ELBIN 24 JUN 2013		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151974 SCALE: 1:2 SHEET: 1 of 4 REV: F		CUSTOMER ACCESSIBLE PRODUCTION DRAWING RESTRICTED TO:	

REVISONS		DATE	OWN	APVD
P	LYH			

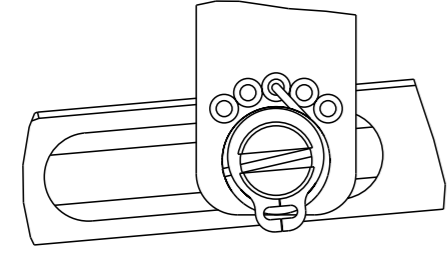
# FEED TYPE MECHANICAL



## PNEUMATIC

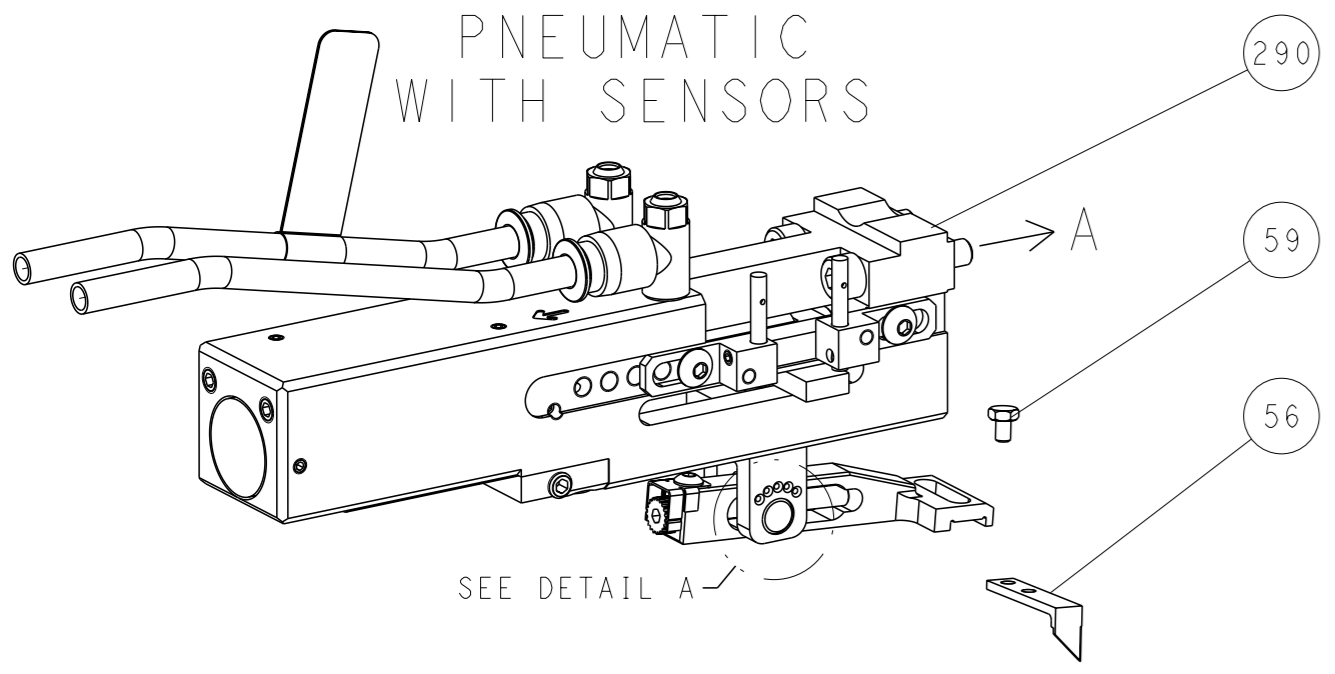


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

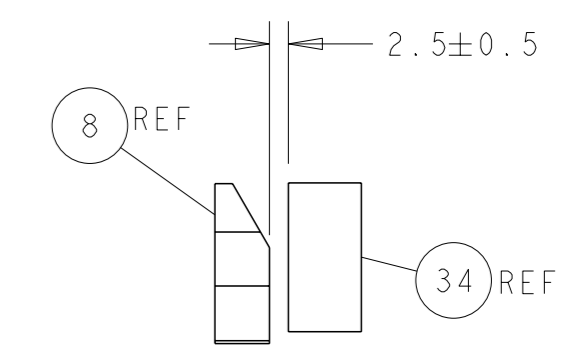
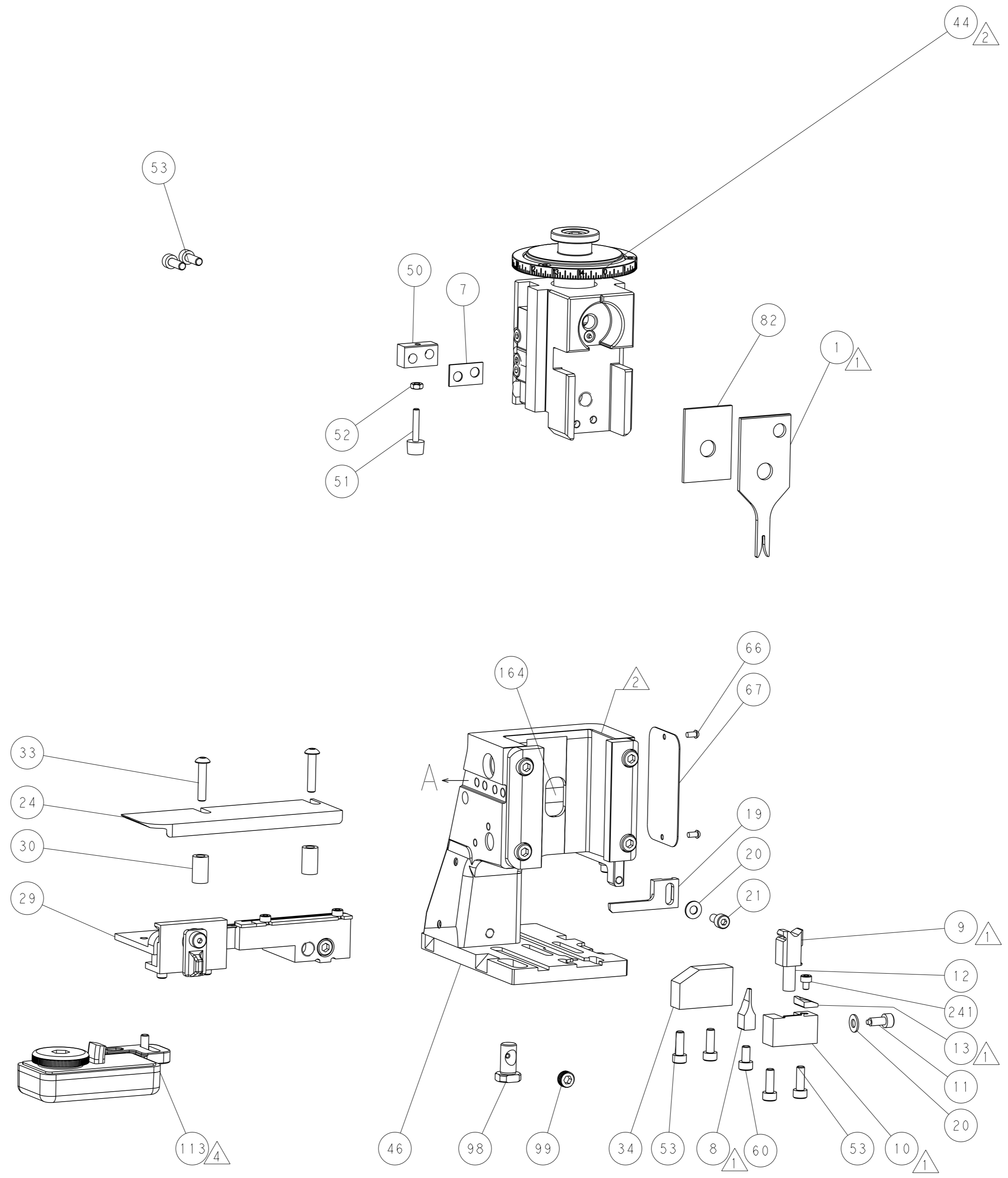
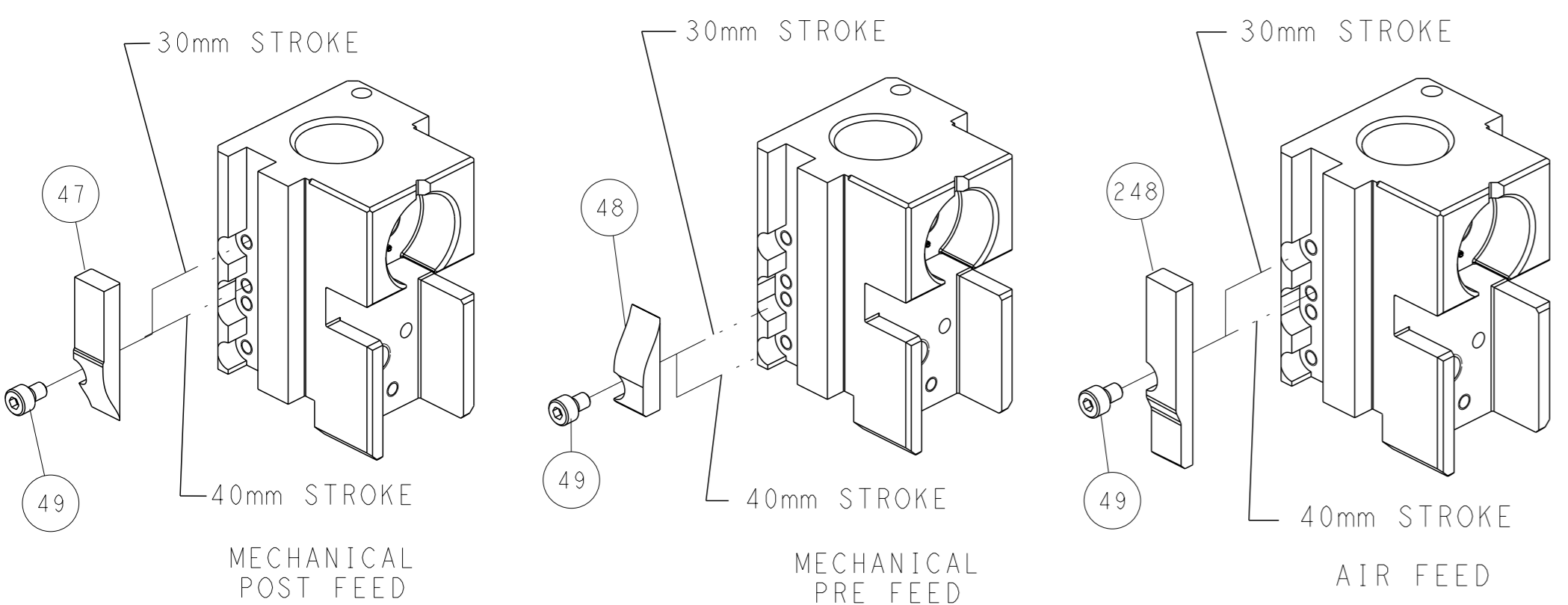


DETAIL A

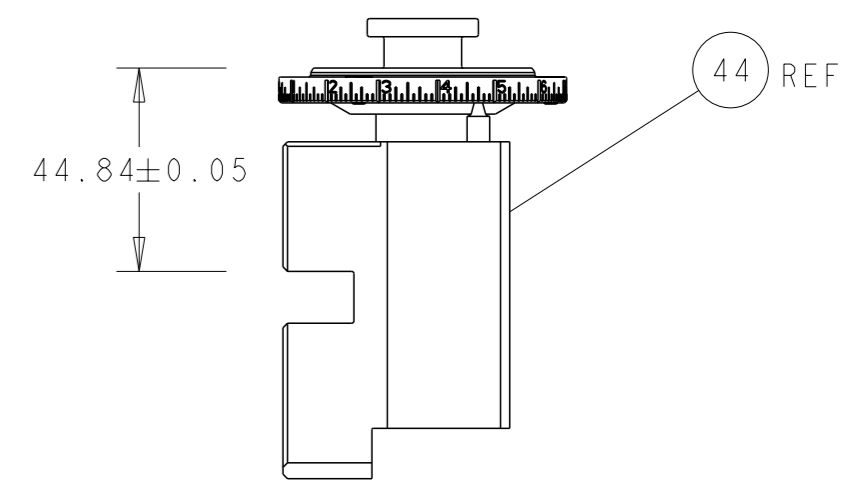
## DOUBLE ACTING PNEUMATIC WITH SENSORS



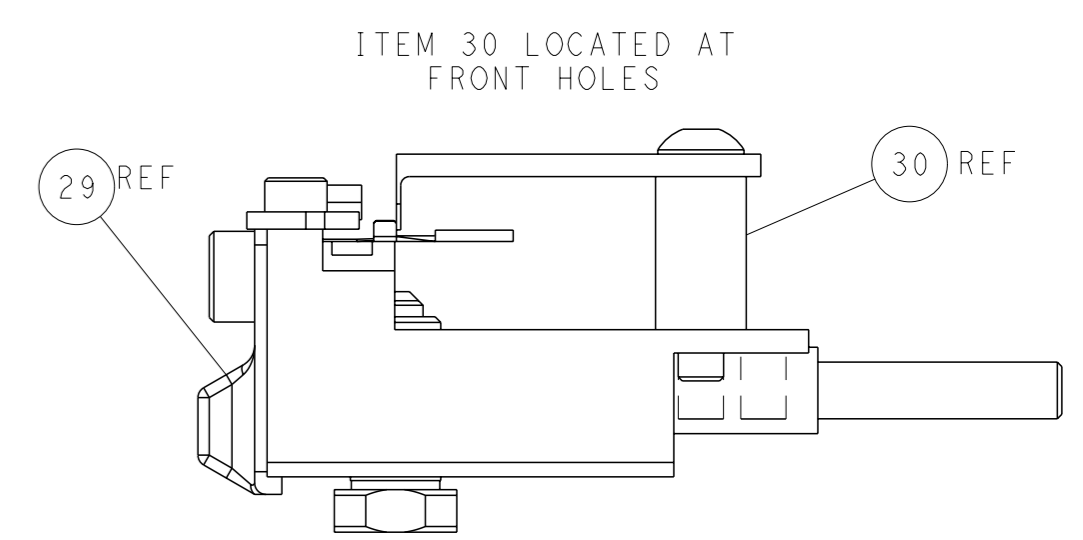
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



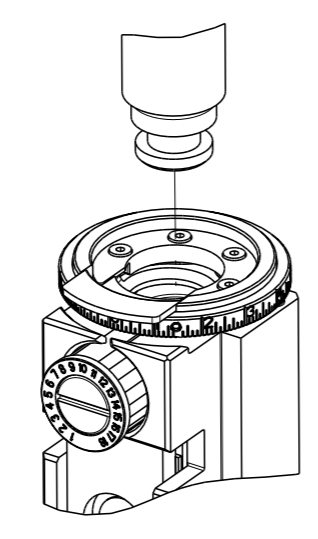
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: R. O. WILSON 20 JUN 2013 CHK: K. J. STAKEM 24 JUN 2013 APVD: J. L. ELBIN 24 JUN 2013 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151974 SCALE: 1:2 SHEET: 2 of 4 REV: F		RESTRICTED TO: -	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
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 <sup>6</sup>
7-2151974-7	B	CRIMP TOOLING KIT	-

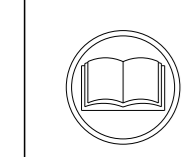
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



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]		Ø -	
TERMINAL APPLICATION SPECIFICATION		114-18623	
TERMINALS APPLIED <sup>4</sup>			
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



- <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.

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

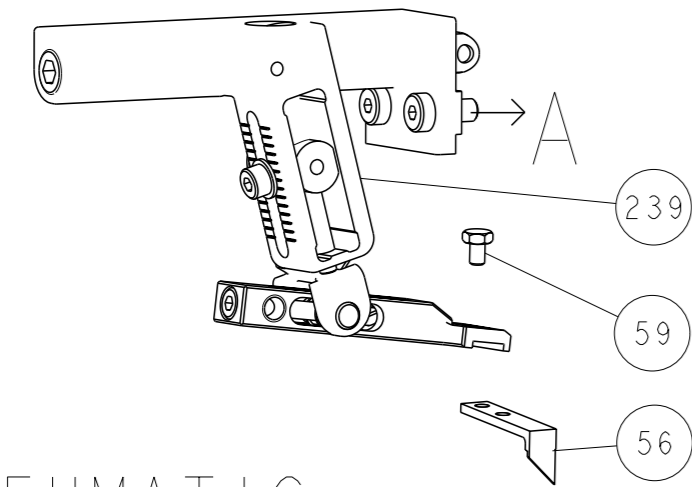
-	1	-	-	2844950-1	AIR FEED MODULE	290	
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
<sup>6</sup>	-	1	-	2119641-2	FEED CAM, AIR FEED	151	
-	1	1	1	2168083-8	SCR, SKT HD 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	
<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	1-455888-5	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	
<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	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	
<sup>1</sup>	-	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	
<sup>1</sup>	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
<sup>1</sup>	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	
<sup>1</sup>	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)

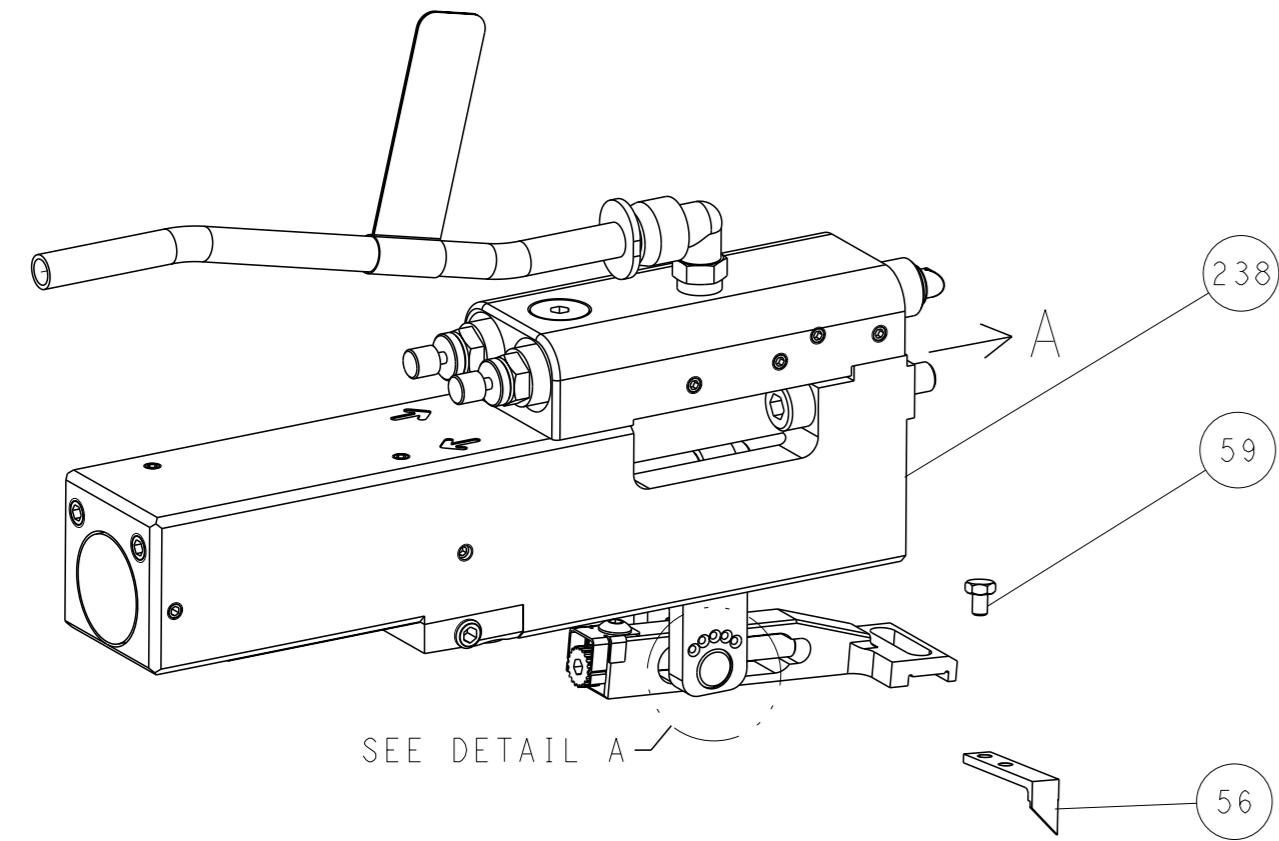
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0 PLC ±		1 PLC ±		CHK K. J. STAKEM 24 JUN 2013		NAME Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD T. L. ELBIN 24 JUN 2013		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
4 PLC ±		5 PLC ±		APPLICATION SPEC		A1 00779 ©=2151974	
MATERIAL		FINISH		WEIGHT		SCALE 1:2 SHEET 3 OF 4 REV F	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			

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

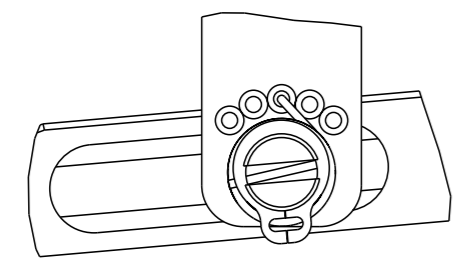
# FEED TYPE MECHANICAL



# PNEUMATIC

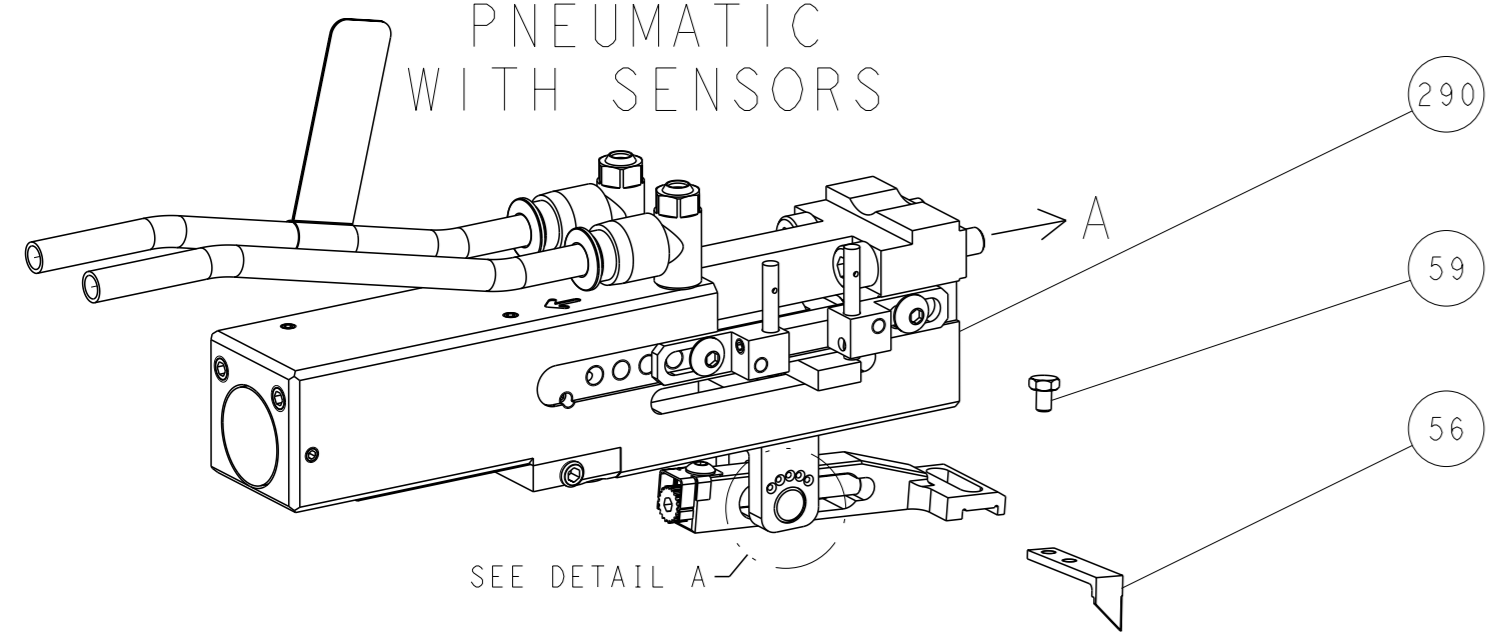


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

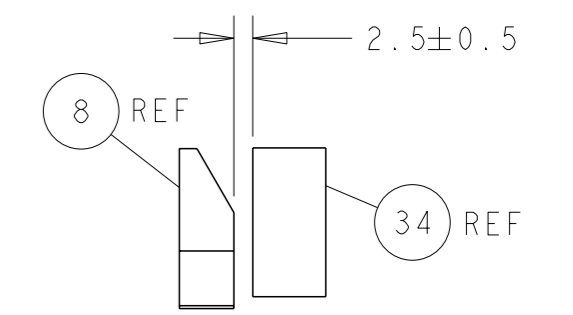
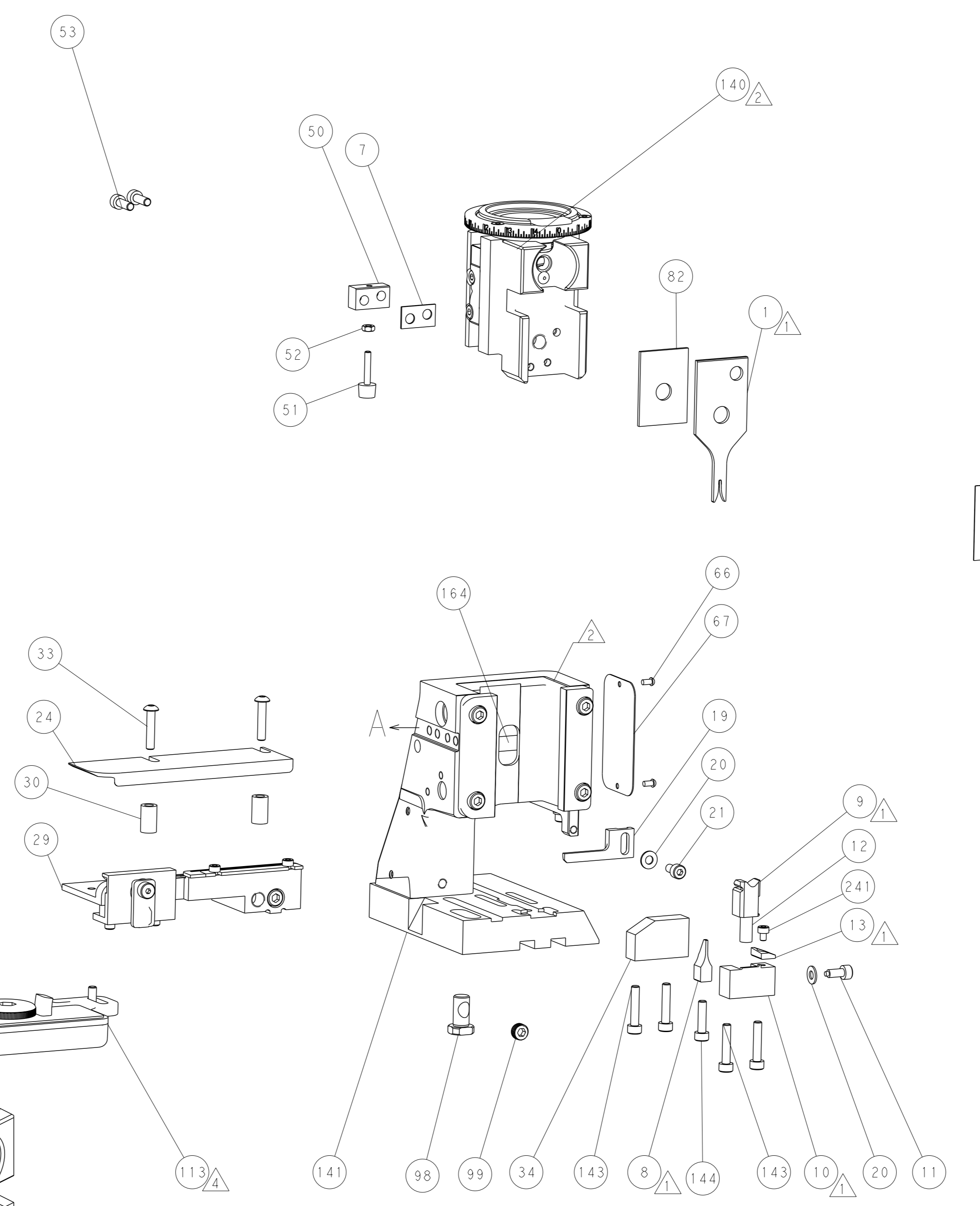
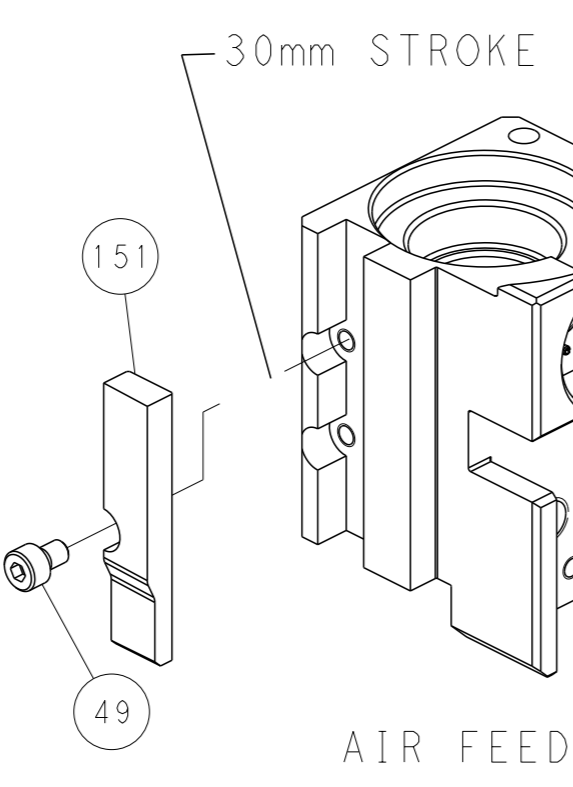
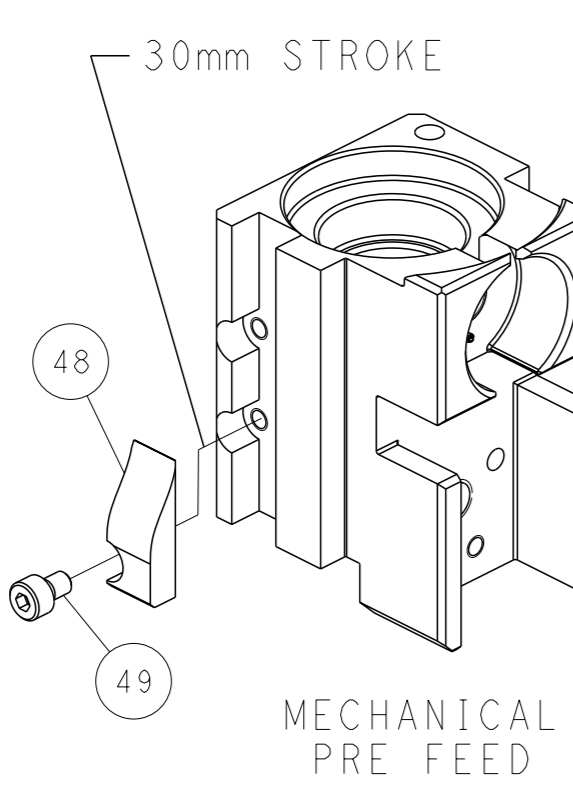
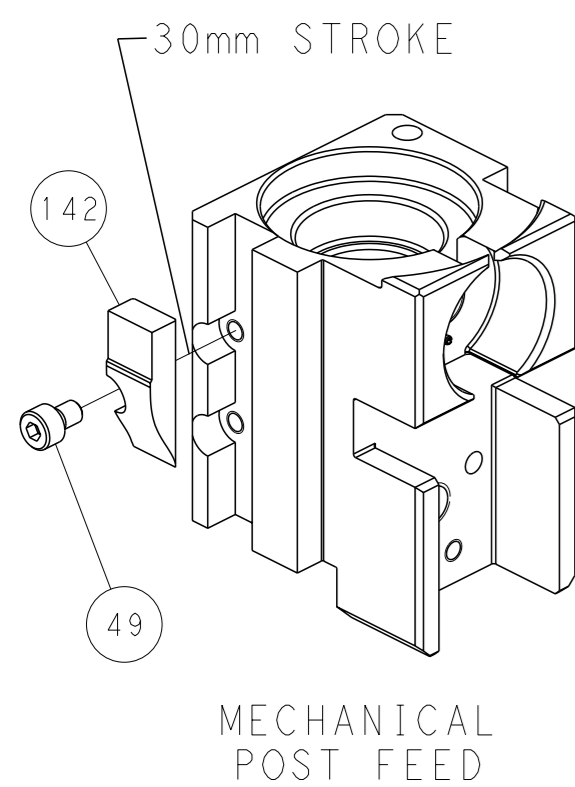


DETAIL A

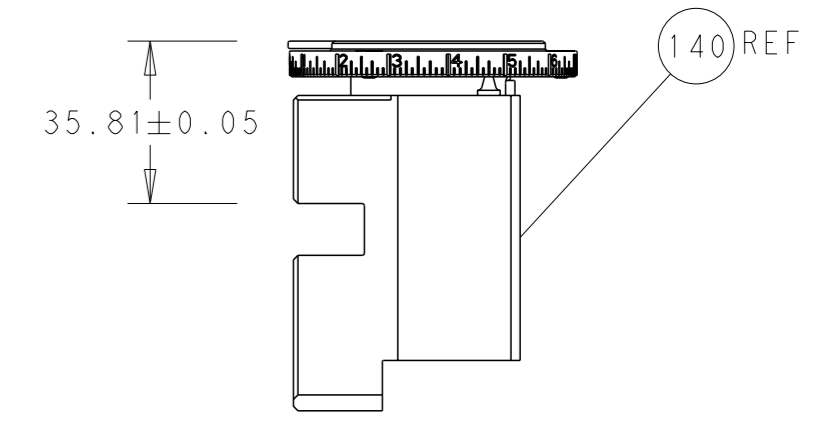
# DOUBLE ACTING PNEUMATIC WITH SENSORS



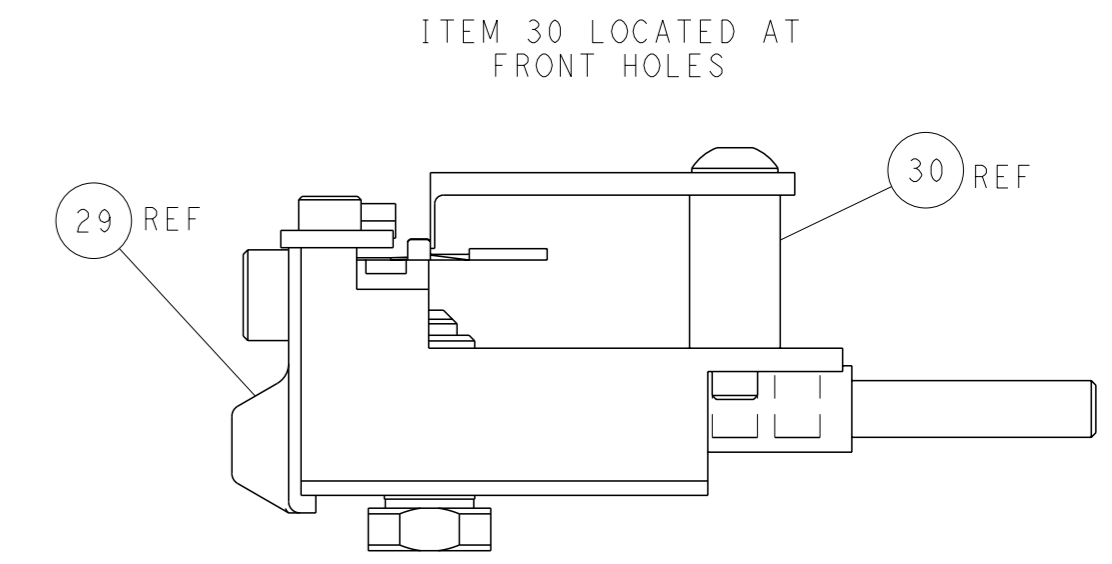
# CAM POSITIONS



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)

<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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# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2151974-1](#)