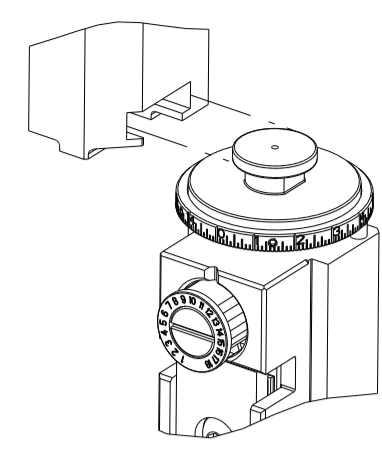


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266302-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266302-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266302-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266302-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266302-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266302-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266302-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.62 mm [.064]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL MALE, 090 II SEALED

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.25-5.01 mm [.167-.197 IN]	Ø1.40-1.90 mm [.055-.075 IN]

TERMINAL APPLICATION SPECIFICATION (A)7114-4025 Rev D

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL FEMALE, 090 II SEALED SOCKET

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.25-5.01 mm [.167-.197 IN]	Ø1.40-1.90 mm [.055-.075 IN]

TERMINAL APPLICATION SPECIFICATION (B)7116-4025 Rev D

TERMINALS APPLIED

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(A) 1572772-1	(A) 7114-4025	(A) 1949770-1	(A) 7157-7812	Ø1.60-2.20mm
(A) 1572772-2	(A) 7114-4025-08	(A) 1949770-5	(A) 7157-3857-60	Ø1.40-2.00mm
(A) 1572772-3	(A) 7114-4028-08	(A) 1572421-3	(A) 7158-3007-10	Ø1.20-1.50mm

TERMINALS APPLIED

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(B) 1572415-1	(B) 7116-4025	(B) 1572460-1	(B) 7158-3006-90	Ø1.40-1.90mm
(B) 1572415-2	(B) 7116-4025-08			
(B) 1572415-3	(B) 7116-4028-08			
(B) 1572415-4	(B) 7116-4028-98			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.05 [.045+/- .002]	6.8
0.30mm2	1.10+/-0.05 [.043+/- .002]	7.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00+/-0.05 [.039+/- .002]	8.3
0.30mm2	0.95+/-0.05 [.037+/- .002]	8.8

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 4 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.
- 5 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A2		ECR-16-007413	23MAY2016	YY	JT
		B		ECR-19-009471	17JUN2019	TB	TE
		C		ECR-21-123943	13DEC2021	JWC	TE
		D		ECR-23-164710	26JAN2023	ROY	GEB

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-0	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	4-1803054-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	2	2	1	1	1	6-1633664-2	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

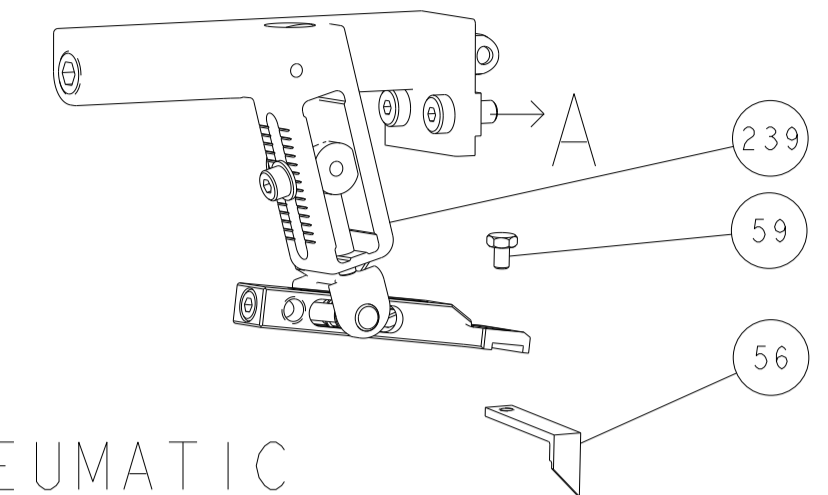
DATE: 04JUNE2014	CHK: H. STAKEM	DATE: 04JUNE2014	NAME: Ocean Side Feed Applicator
DATE: 04JUNE2014	CHK: G. BAILEY	DATE: 04JUNE2014	NAME: I. ELBIN
DATE: 04JUNE2014	CHK: T. ELBIN	DATE: 04JUNE2014	NAME: T. ELBIN

TE Connectivity
 Harrisburg, PA 17105-3608

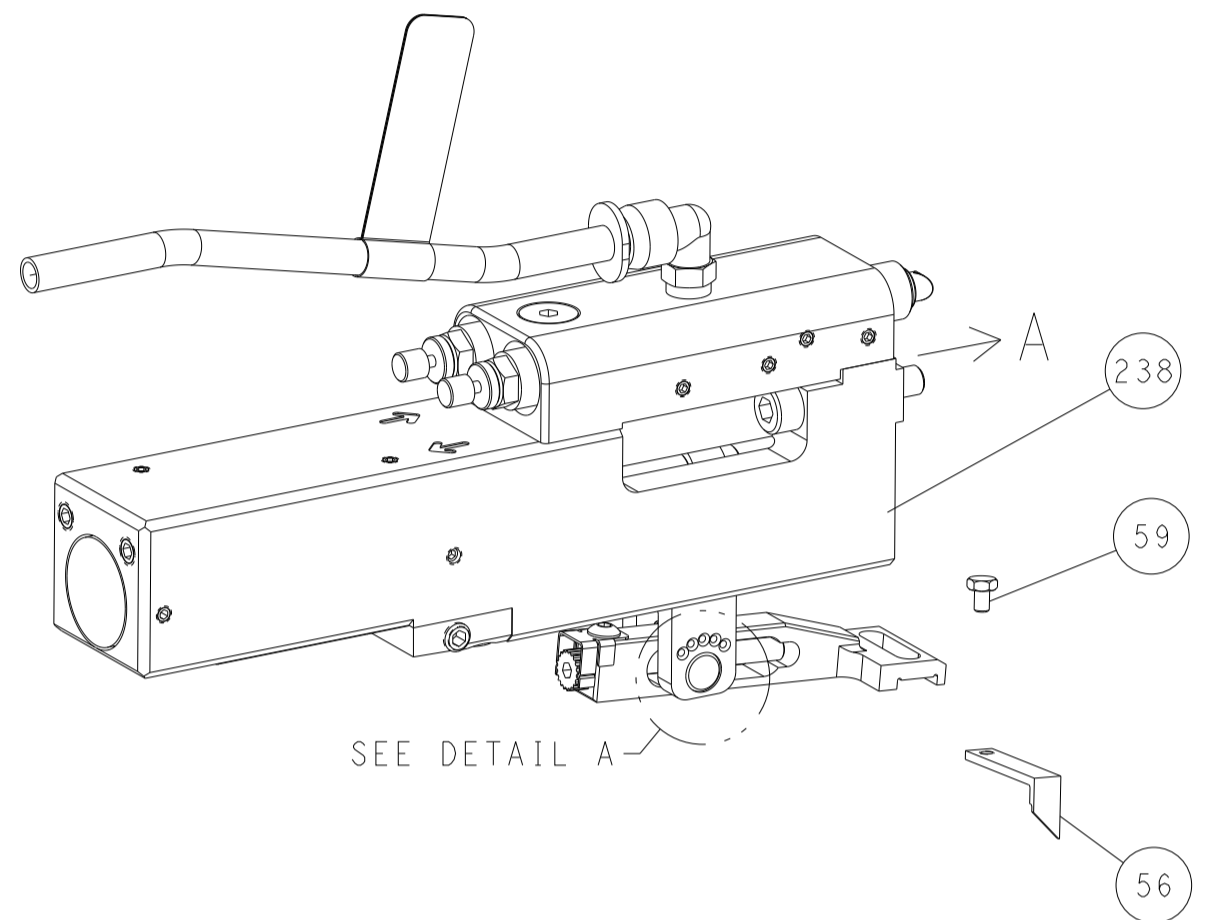
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

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

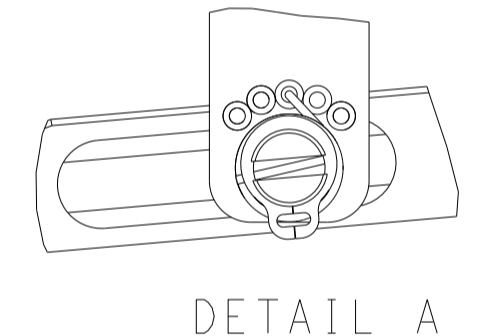
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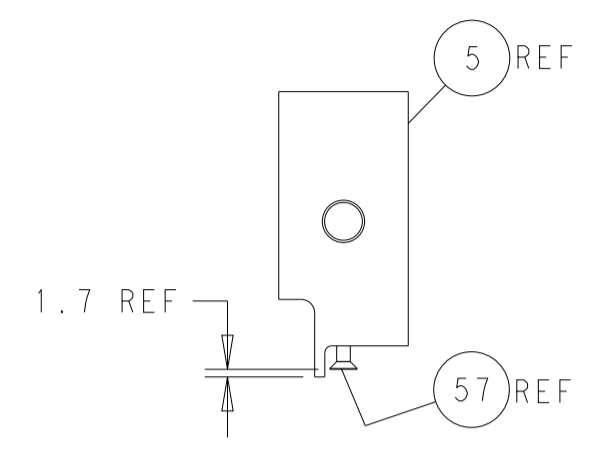
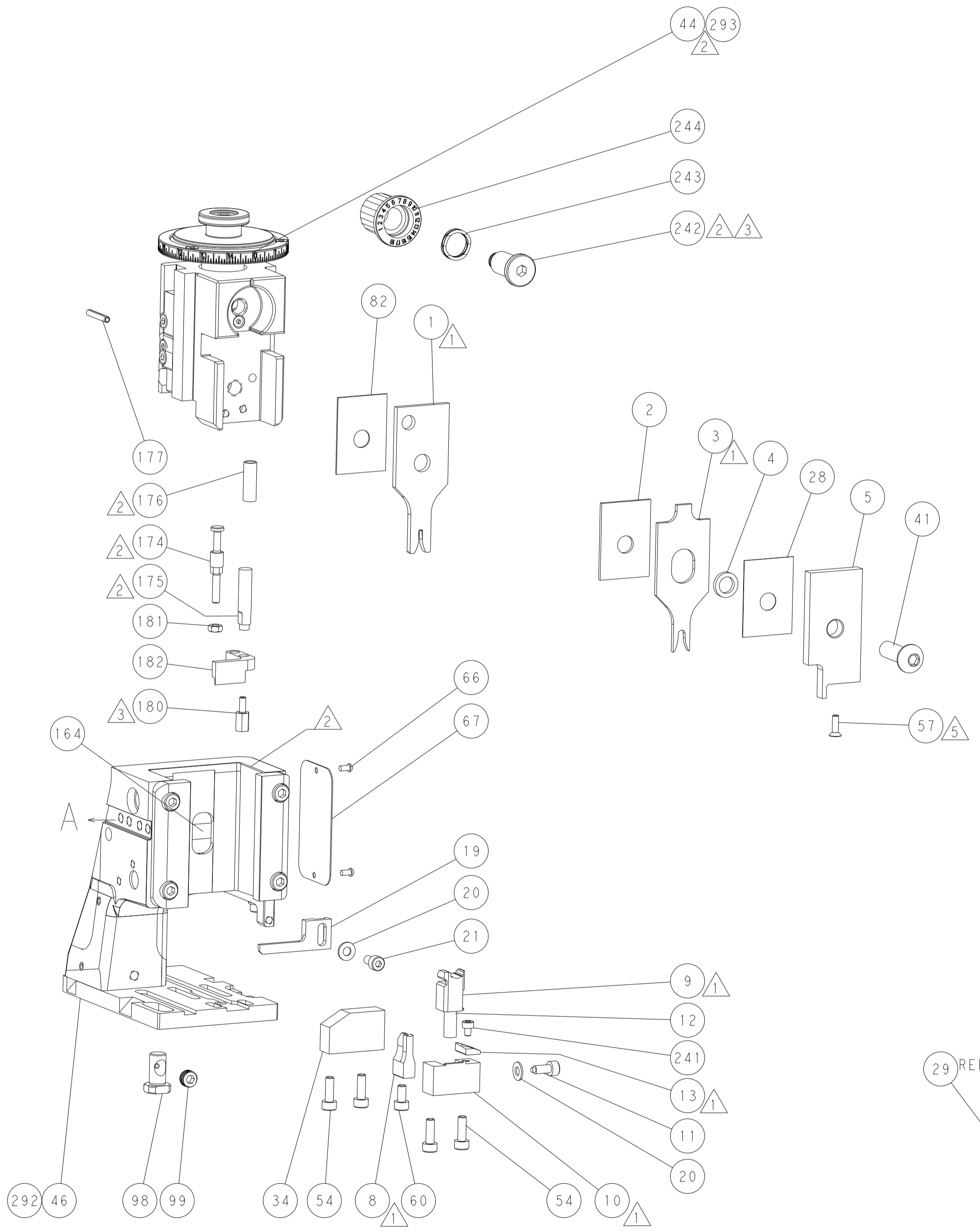
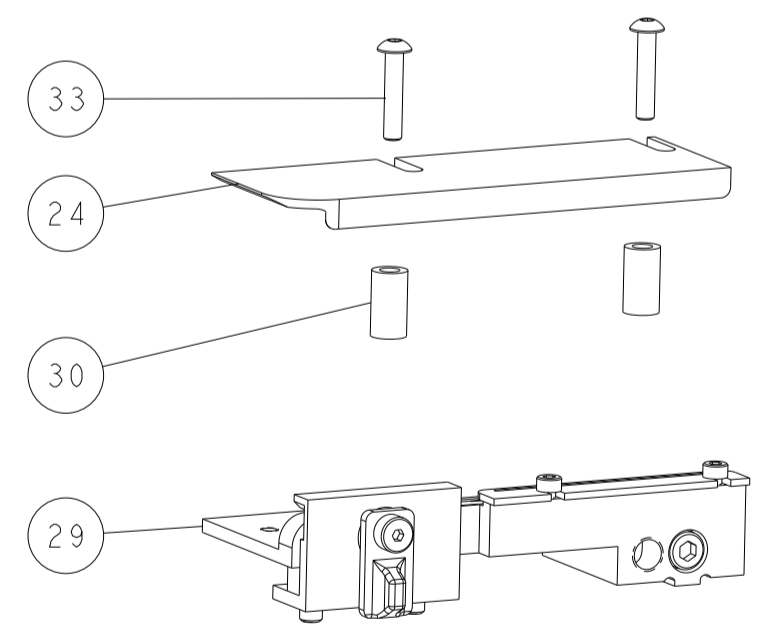
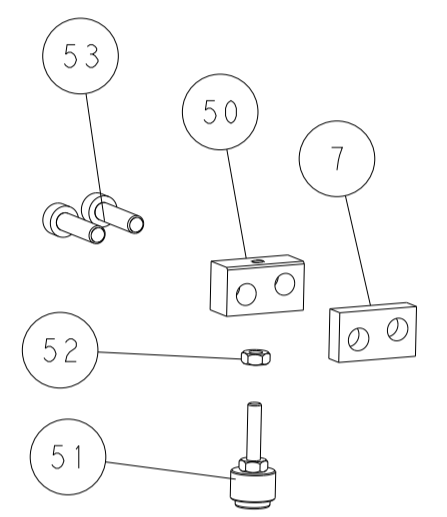
PNEUMATIC



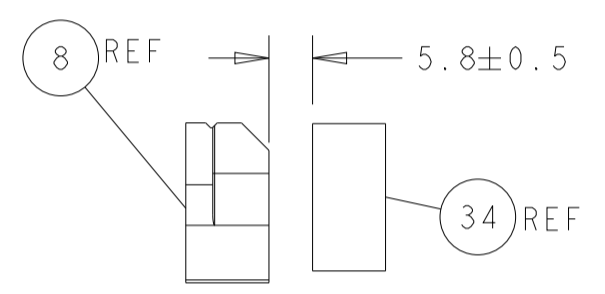
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



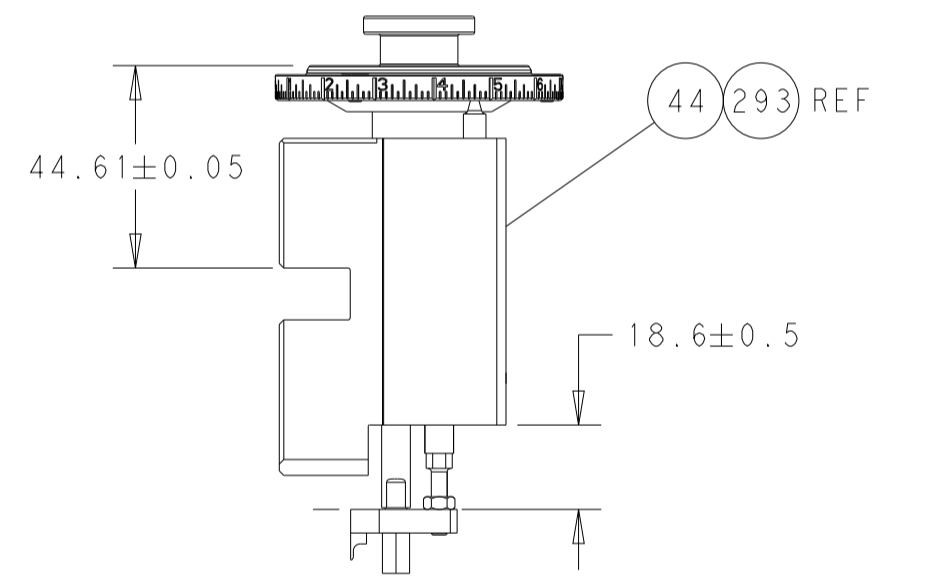
DETAIL A



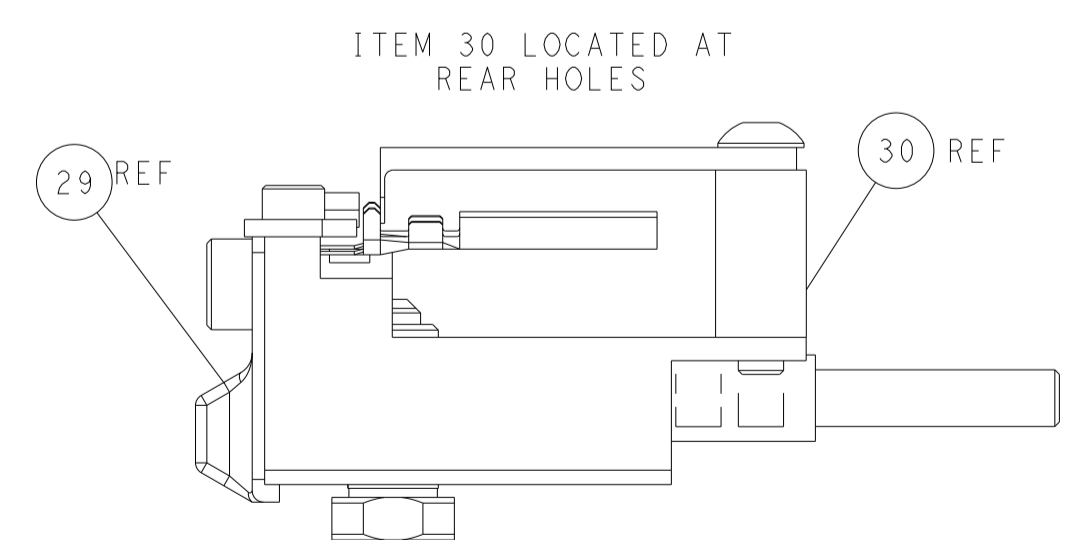
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

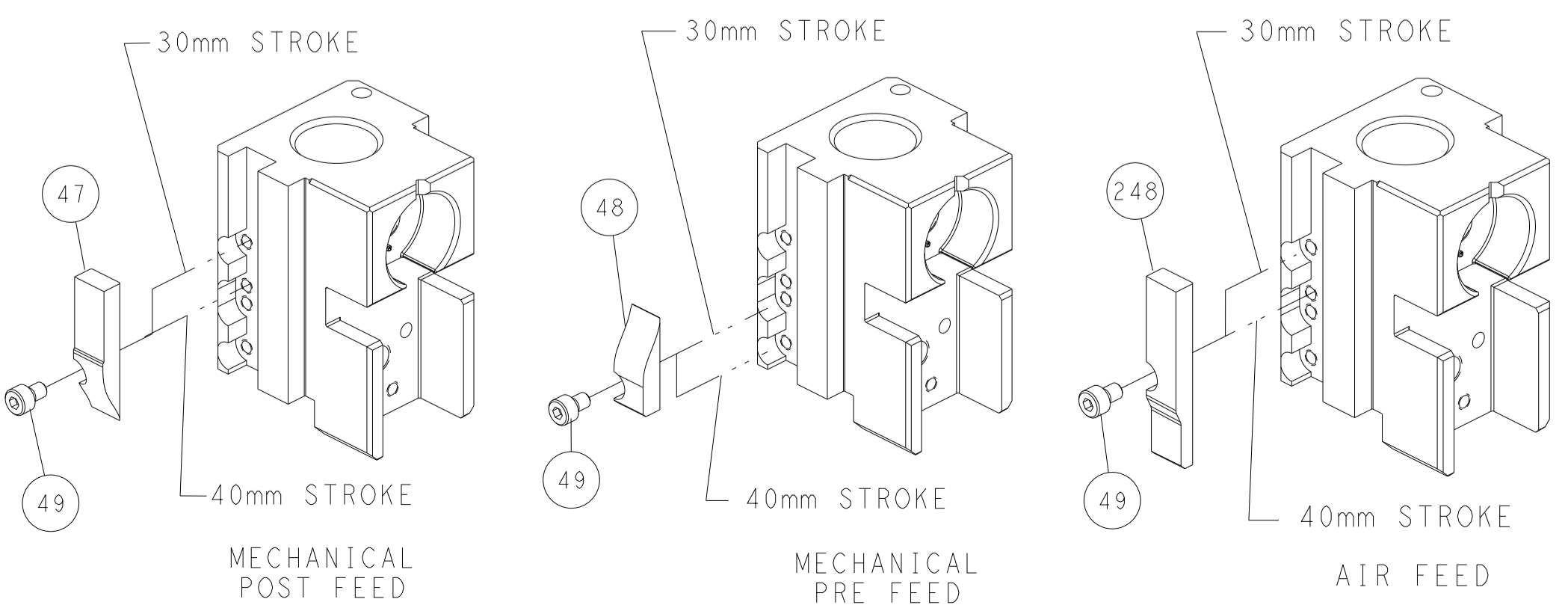


RAM AND HOLDDOWN SET-UP



ITEM 30 LOCATED AT REAR HOLES

CAM POSITIONS



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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. STAKEM 04JUNE2014 CHK: G. BAILEY 04JUNE2014 APVD: T. ELBIN 04JUNE2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266302	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: D	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266302-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266302-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266302-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.62 mm [.064]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MALE, 090 II SEALED	
WIRE STRIP LENGTH 4.25-5.01 mm [.167-.197 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION (A)7114-4025 Rev D	

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(A) 1572772-1	(A) 7114-4025	(A) 1949770-1	(A) 7157-7812	Ø1.60-2.20mm
(A) 1572772-2	(A) 7114-4025-08	(A) 1949770-5	(A) 7157-3857-60	Ø1.40-2.00mm
(A) 1572772-3	(A) 7114-4028-08	(A) 1572421-3	(A) 7158-3007-10	Ø1.20-1.50mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.05 [.045+/-0.002]	6.8
0.30mm2	1.10+/-0.05 [.043+/-0.002]	7.3

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL FEMALE, 090 II SEALED SOCKET	
WIRE STRIP LENGTH 4.25-5.01 mm [.167-.197 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION (B)7116-4025 Rev D	

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(B) 1572415-1	(B) 7116-4025	(B) 1572460-1	(B) 7158-3006-90	Ø1.40-1.90mm
(B) 1572415-2	(B) 7116-4025-08			
(B) 1572415-3	(B) 7116-4028-08			
(B) 1572415-4	(B) 7116-4028-98			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00+/-0.05 [.039+/-0.002]	8.3
0.30mm2	0.95+/-0.05 [.037+/-0.002]	8.8



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4. 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.
- 5. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	1	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	1	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
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1338683-8	FEED PAWL	56
-	2	2	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1	2-2844962-8	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	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
7	-	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
8	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
9	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
10	1	1	1	4-1803054-6	ANVIL, COMBINATION	8
-	1	1	1	240641-3	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
11	1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-4	SPACER, CRIMPER	2
12	1	1	1	6-1633664-2	CRIMPER, WIRE	1

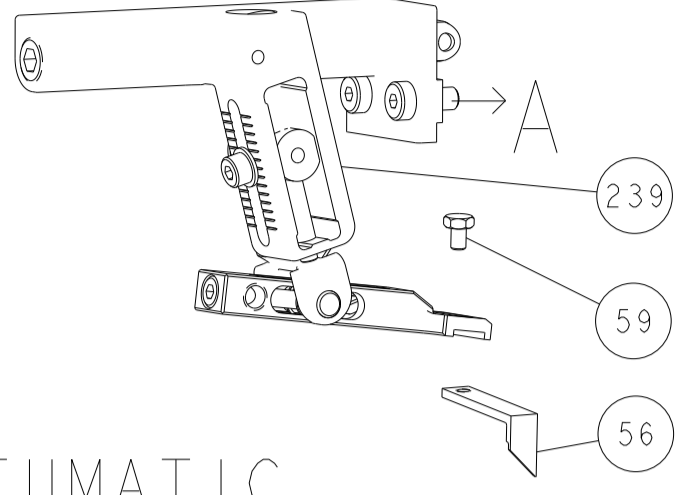
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	1:2	3	4	D	



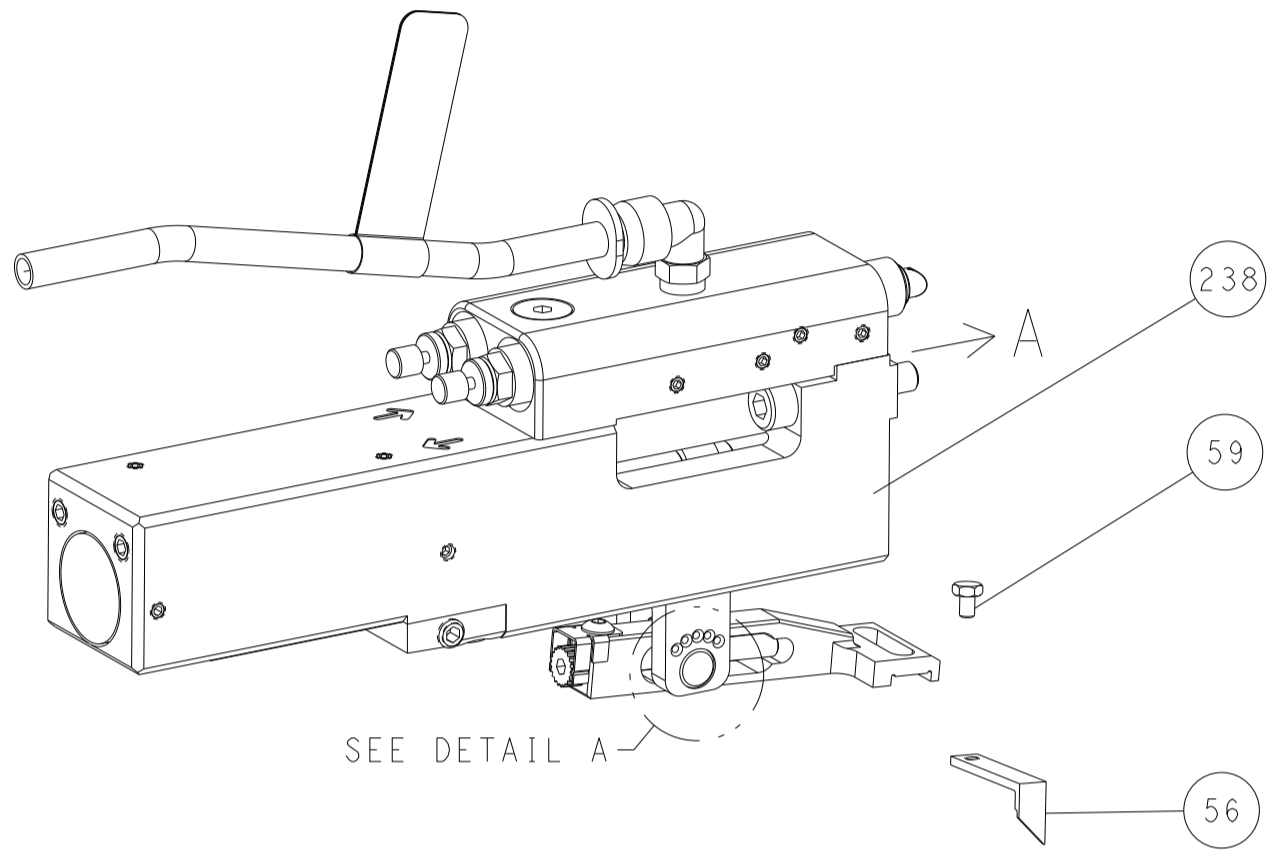
Ocean Side Feed
 Applicator

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

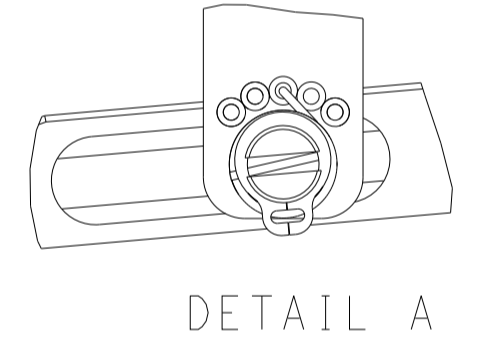
FEED TYPE MECHANICAL



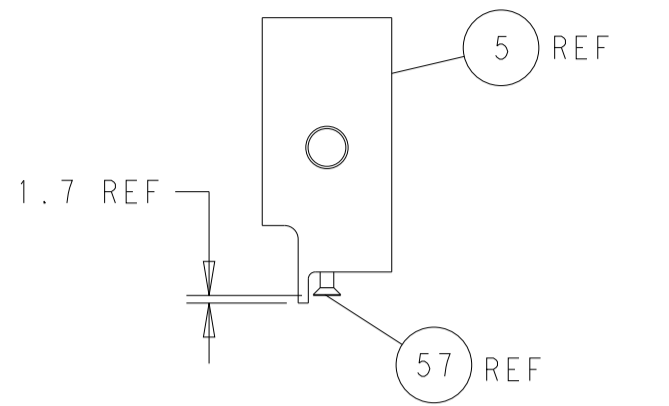
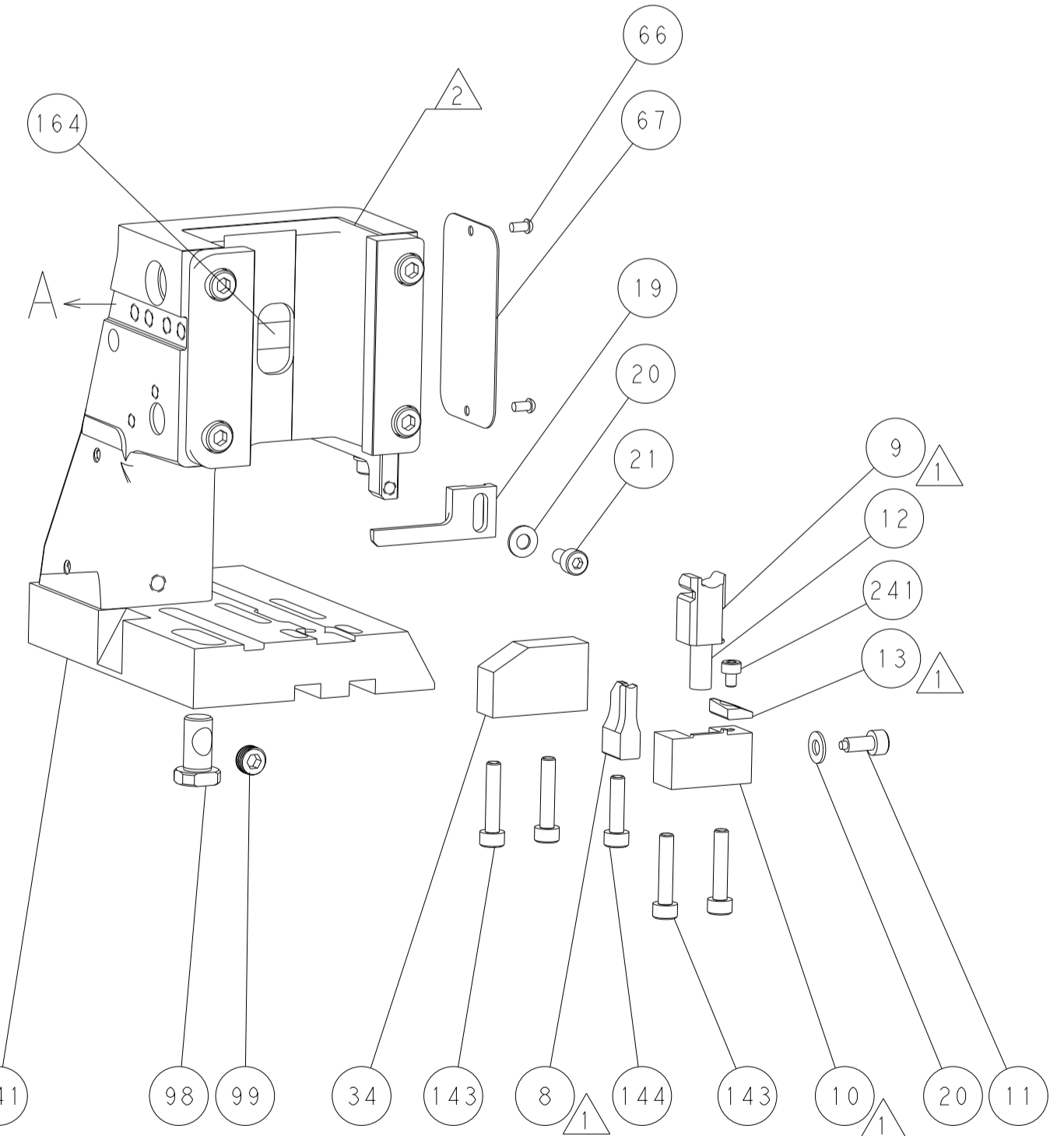
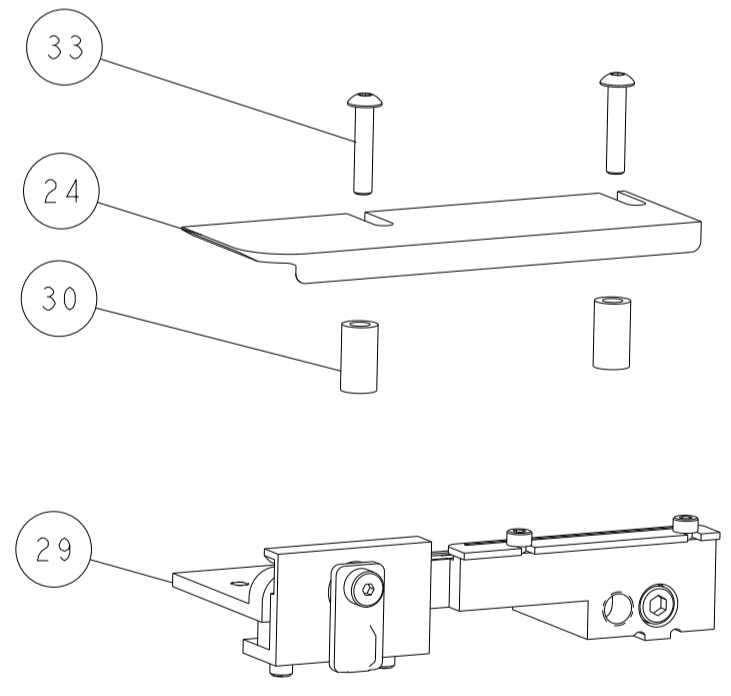
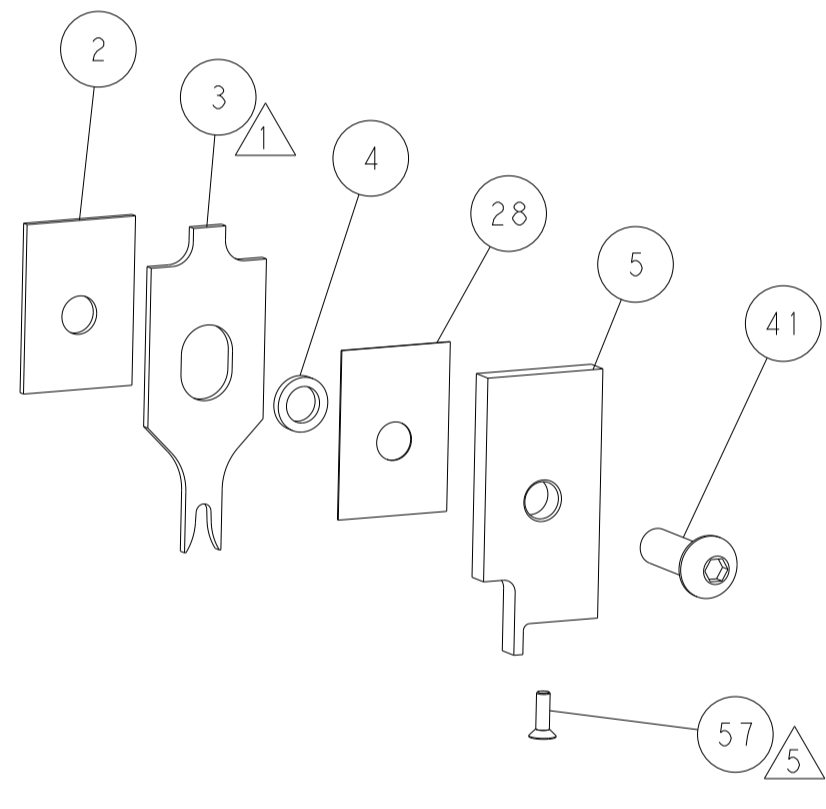
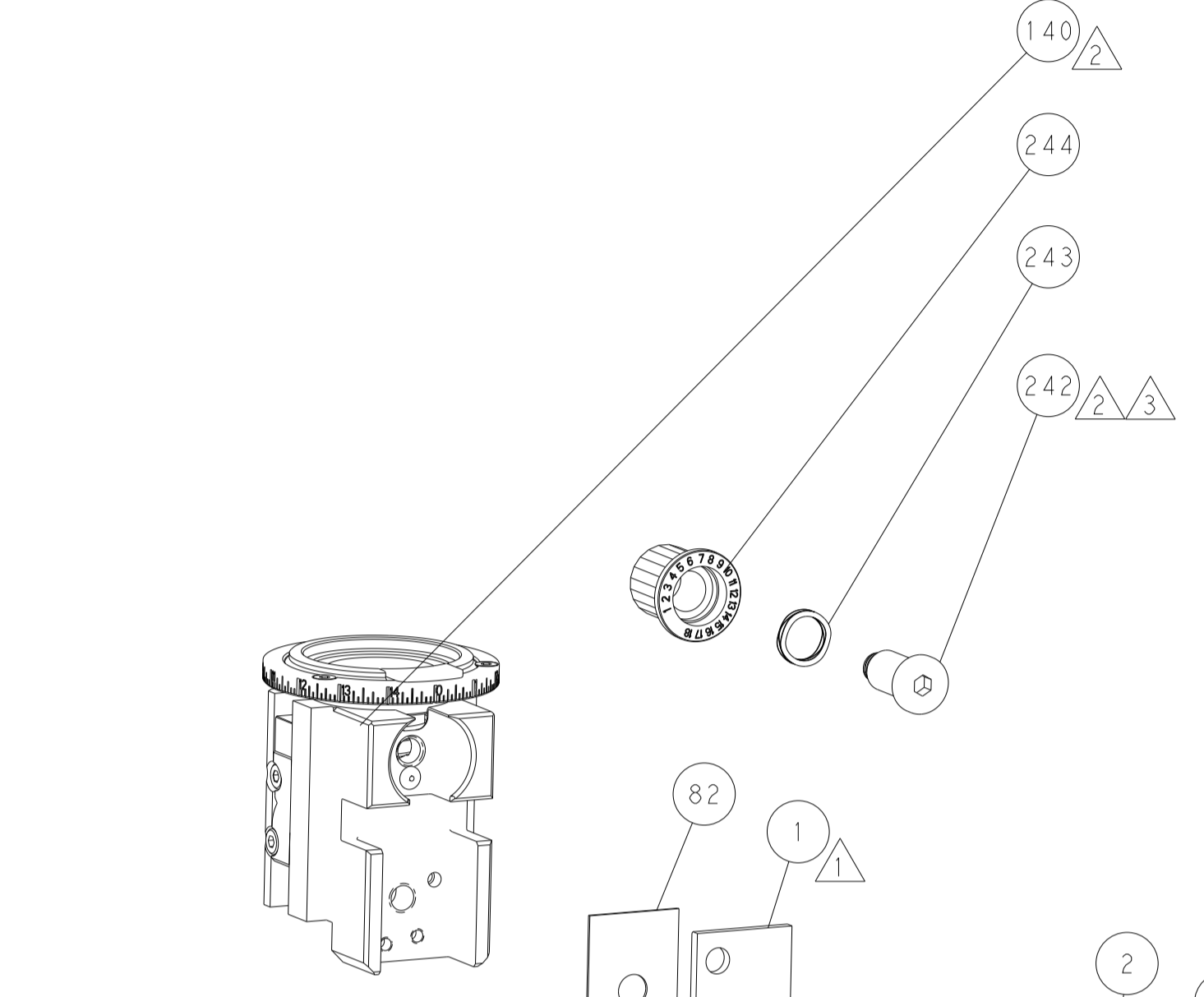
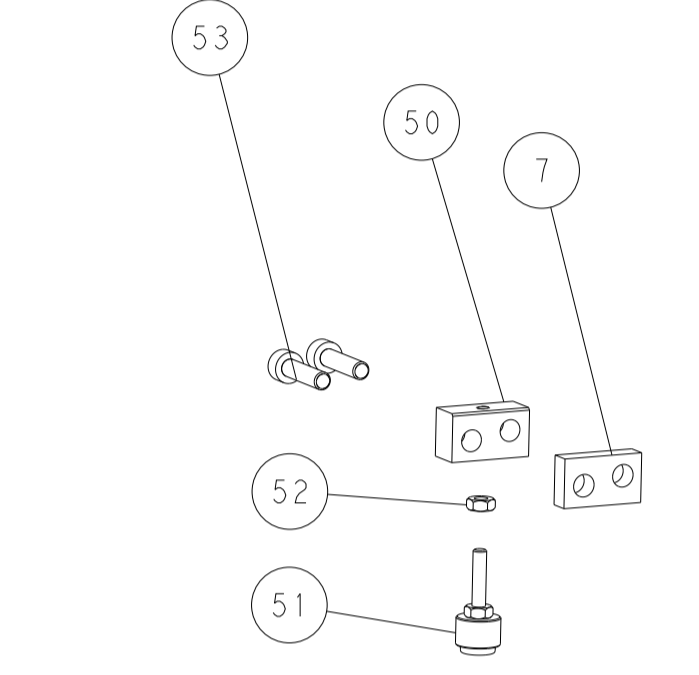
PNEUMATIC



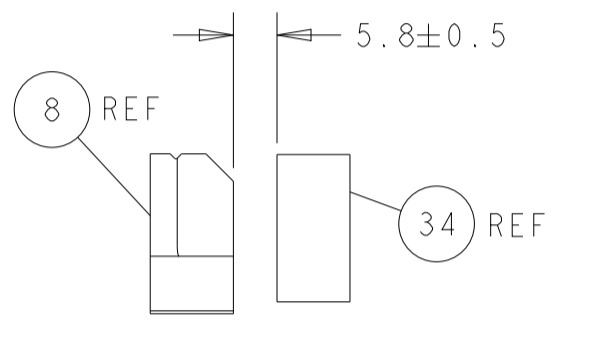
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



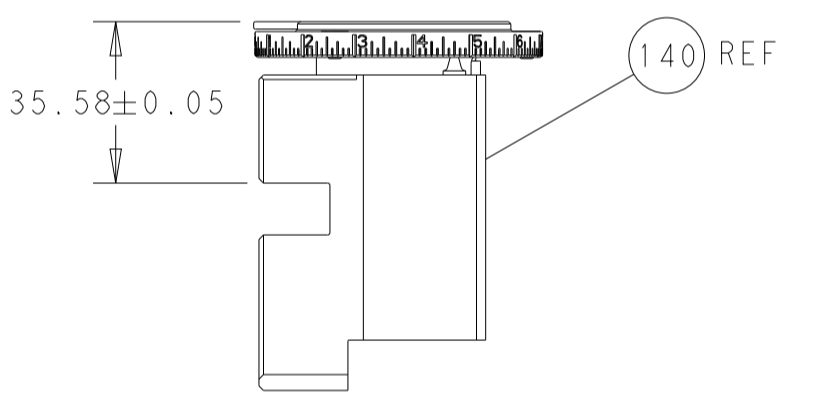
DETAIL A



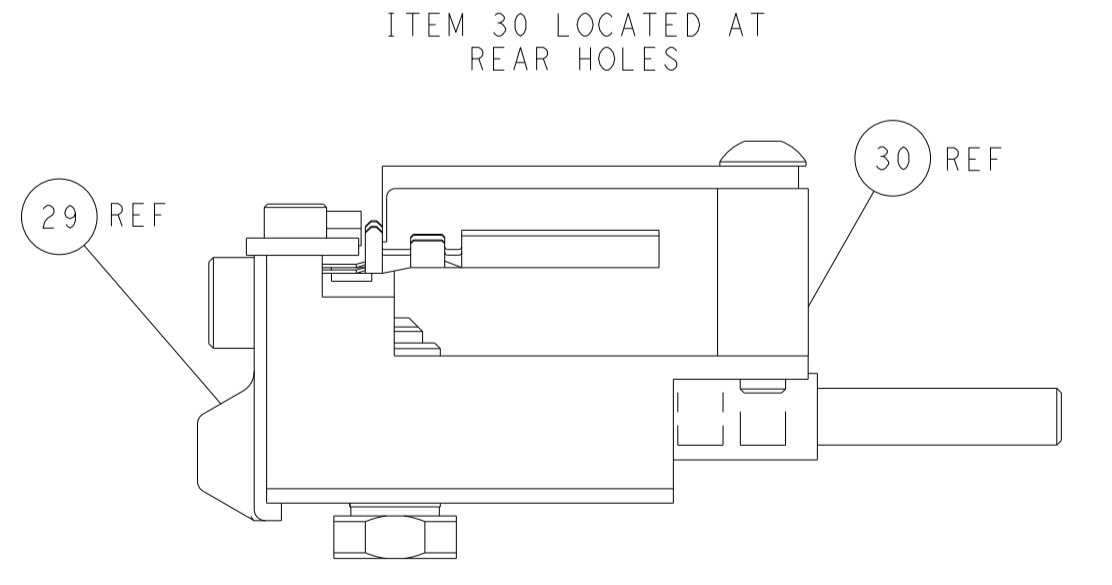
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

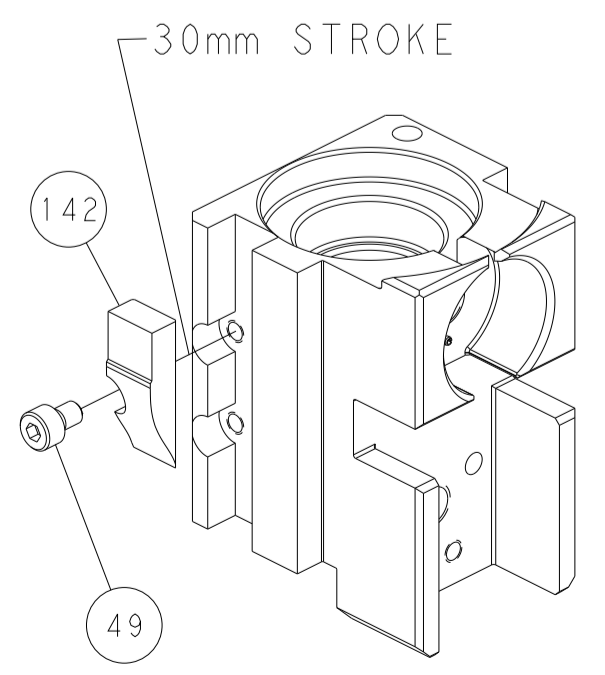


RAM SET-UP

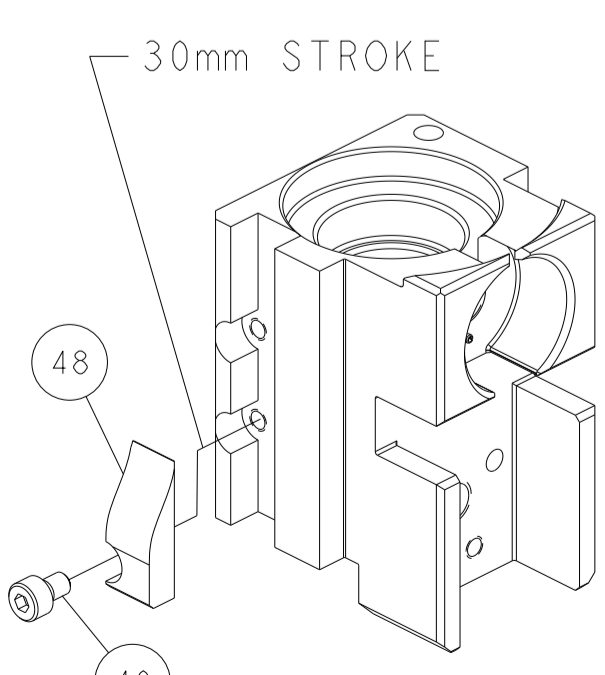


FEED TRACK POSITION GUIDE BY INSULATION BARREL

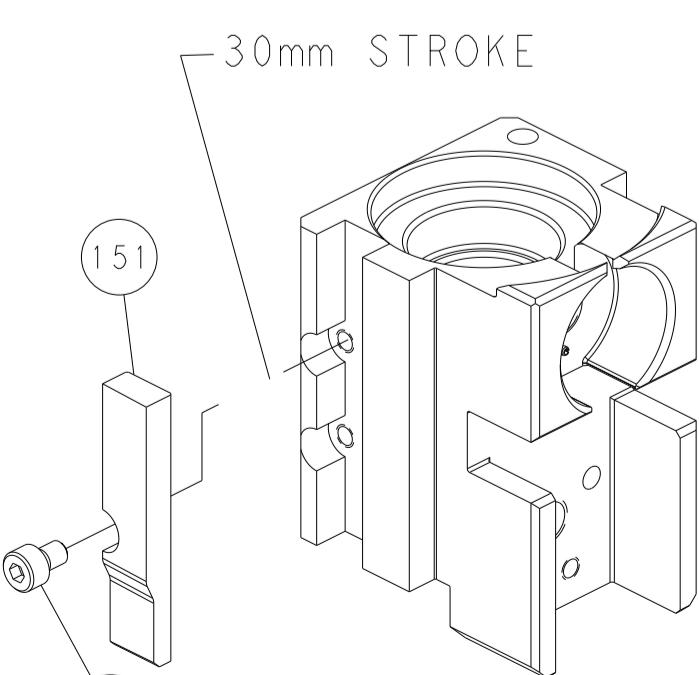
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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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