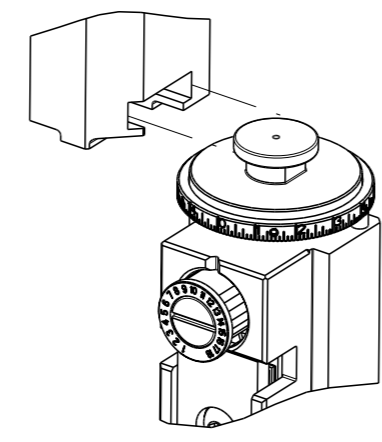


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266166-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266166-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266166-1 | B | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266166-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266166-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

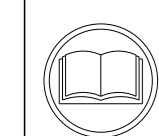


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.98 mm [.078] | F |
| INSUL | 2.50 mm [.098] | O |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: FCL TERMINAL DELPHI CRIMP SPECIFICATION | | | |
|--|---------------------------|-------------|--------------|
| TERMINAL NAME: TERMINAL 1.5mm MALE | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.57-4.95 mm [.180-.195 IN] | ∅ 2.54 mm [.100 IN] MAX | | |
| TERMINAL APPLICATION SPECIFICATION | 13672903 Rev 02 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | FCL TERMINAL | TE TERMINAL | FCL TERMINAL |
| 1832478-1 | 54001845 | 2113414-1 | 54001843 |
| 1832478-2 | 54001841 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 18/20 AWG | 1.27+/-0.05 [.050+/- .002] | 4.8 |



- 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. 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)

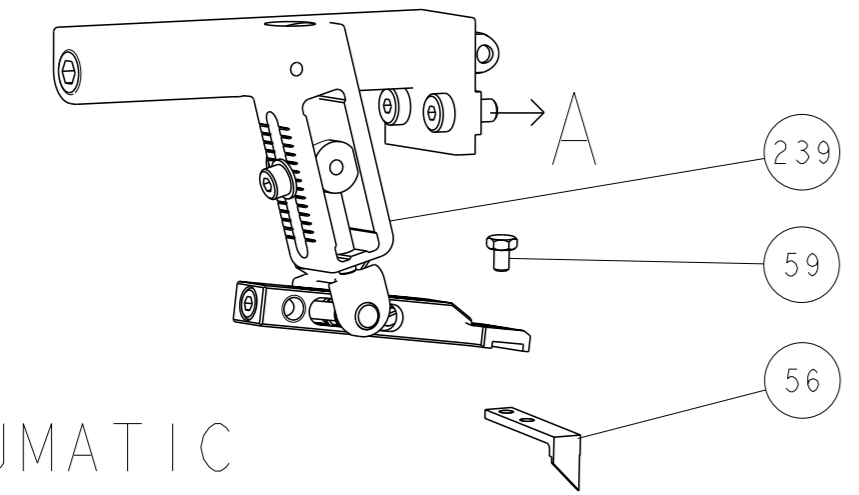
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| | | 1 | | DEVELOPMENT | 04DEC2013 | KH | UG |
| | | A | | RELEASED | 06JAN2014 | BH | TE |
| | | B | | ECR-20-004662 | 30MAR2020 | FJ | TE |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 | |
| - | 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 | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | |
| - | 1 | 1 | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 | |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 | |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 | |
| - | 1 | 1 | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 1 | 1 | 1 | 1 | 1338685-1 | PAWL, FEED | 56 | |
| - | 4 | 4 | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 | |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 | |
| - | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 | |
| - | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 | |
| - | 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 | 1803583-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 | |
| - | 1 | 1 | 1 | 1 | 1803515-1 | RAM ASSEMBLY, SF ATLANTIC | 44 | |
| - | 1 | 1 | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 1 | 1 | 1 | 1 | 1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 | |
| - | 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 | |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 | |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 | |
| - | 1 | 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 | 2 | 2 | 1 | 1 | 7-1633927-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 2-238011-1 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 1 | 1-1803018-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 1 | 8-1633305-0 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | 72 | 71 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

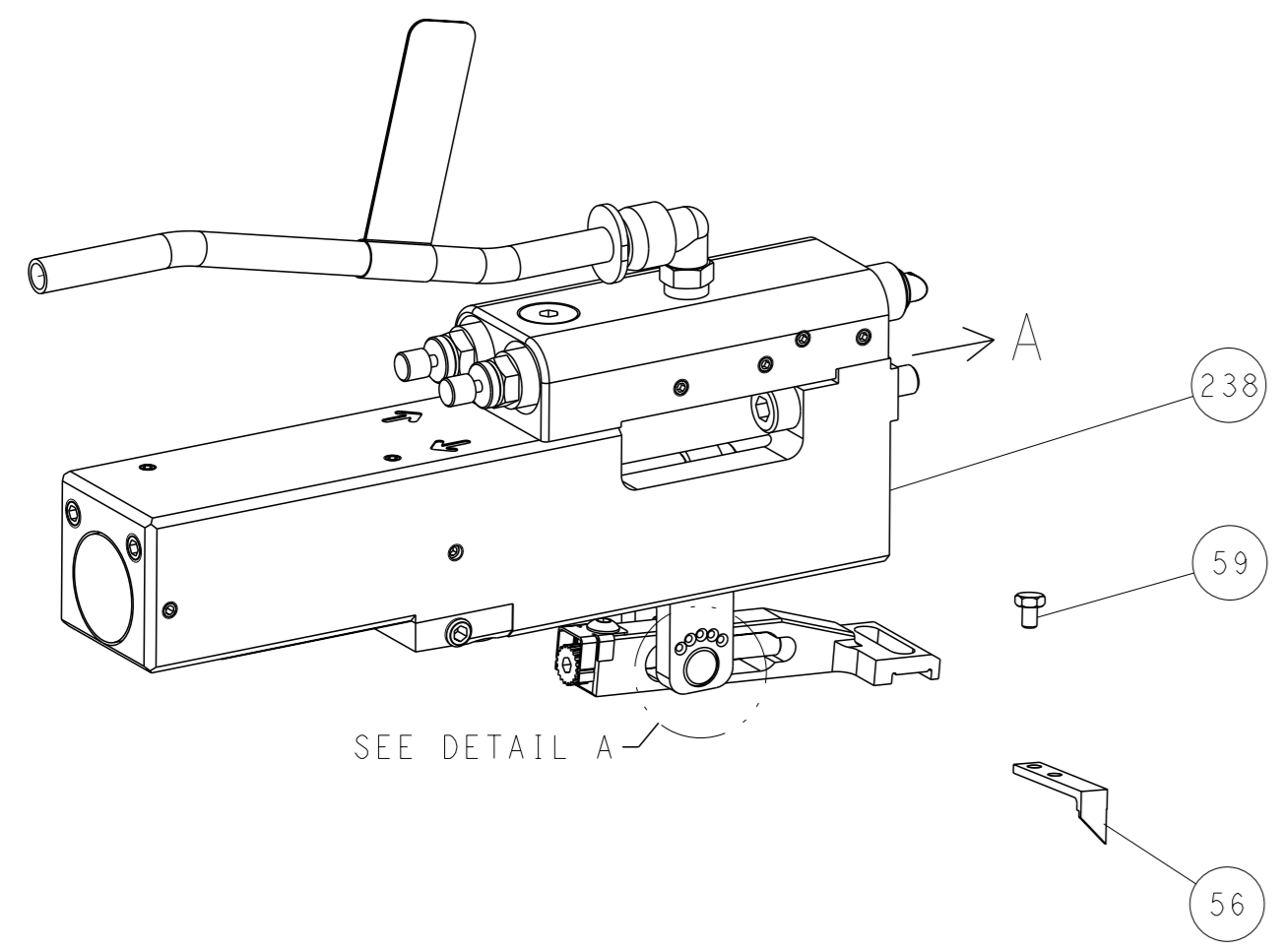
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|-------------|---------|--|---------|---------|---------|--------|--------|-----------|--|-------|-----------|------------|---------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | WT | Customer Accessible Production Drawing | SCALE | 1:2 | SHEET | 1 of 4 |
| MATERIAL | | FINISH | | WEIGHT | | APVD | | U. GUO | | 00779 | | REV B | |

| LOC | DIST | REVISIONS | | | |
|-----|-------------|-----------|------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| - | SEE SHEET 1 | - | - | - | - |

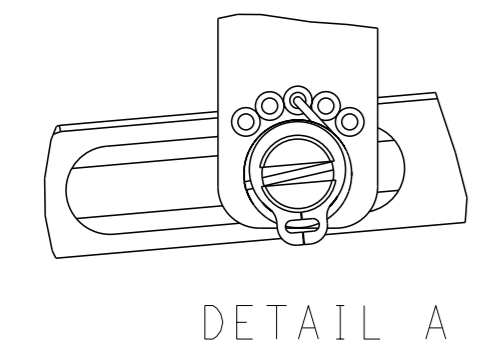
FEED TYPE MECHANICAL



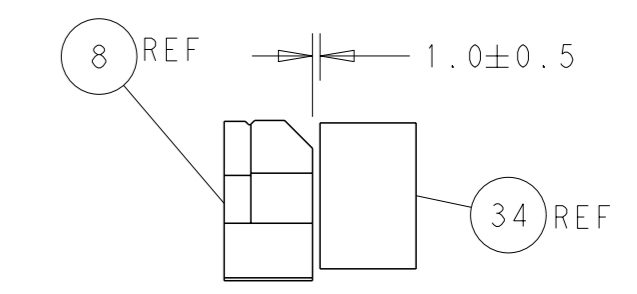
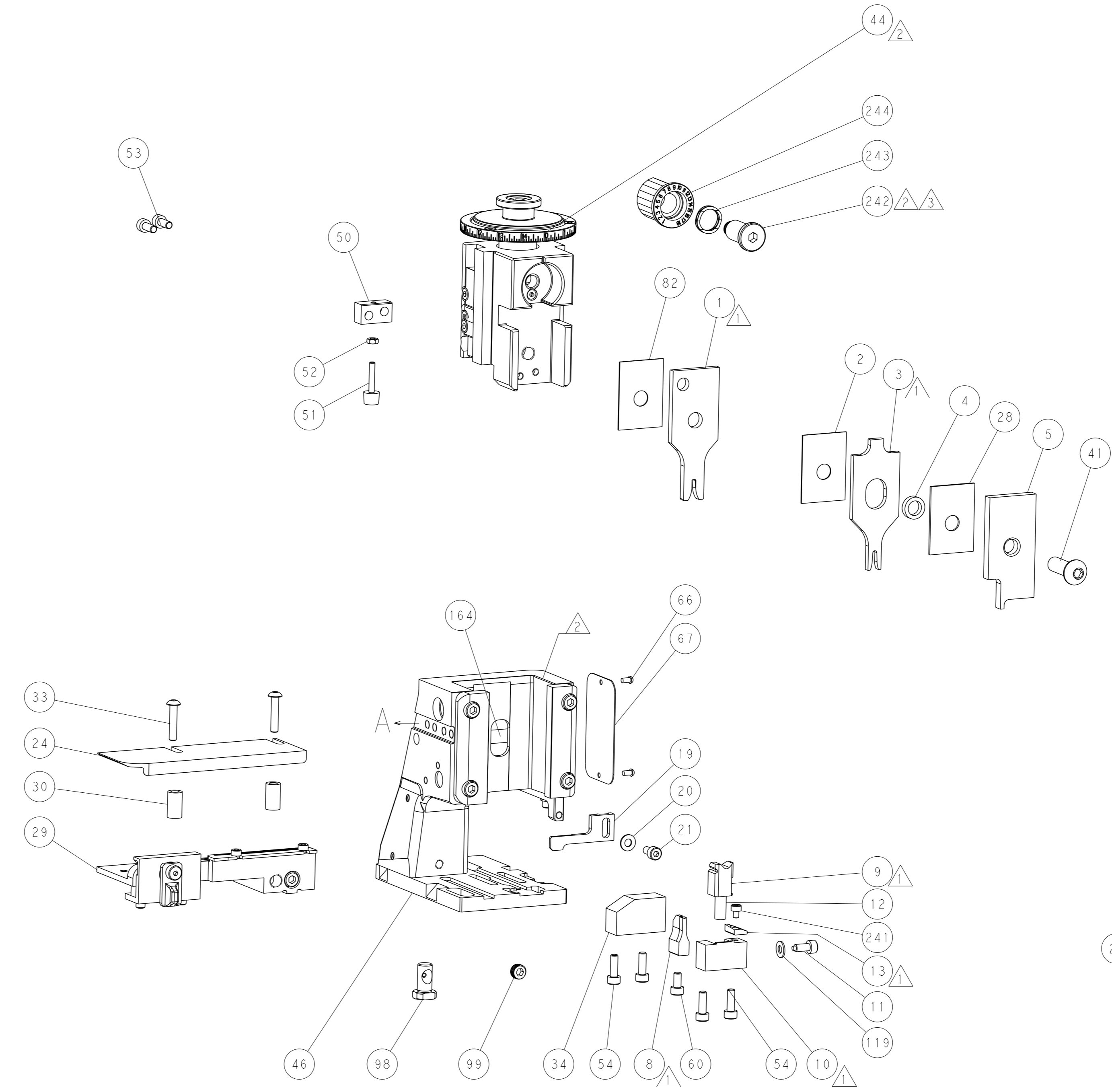
PNEUMATIC



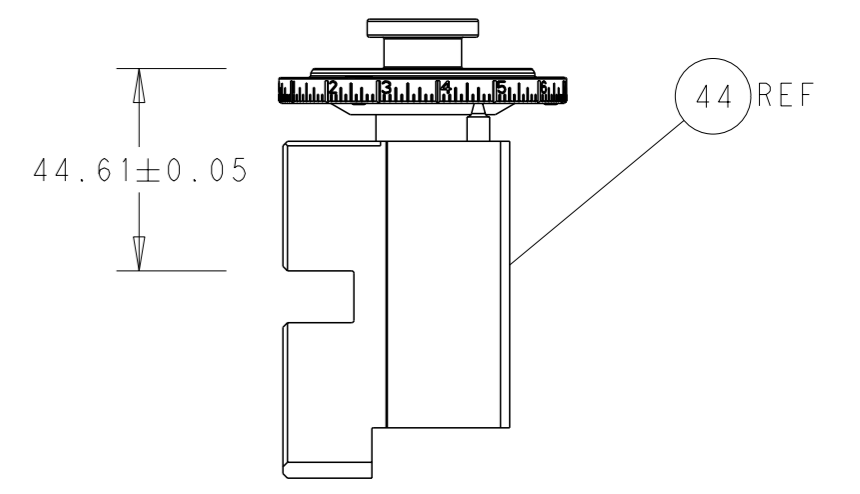
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



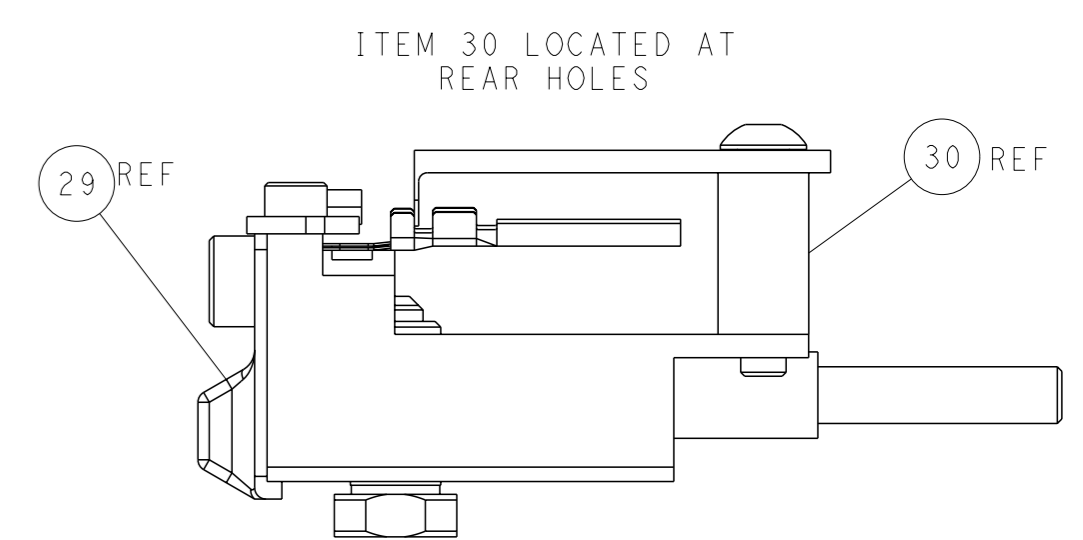
DETAIL A



TERMINAL SUPPORT LOCATION



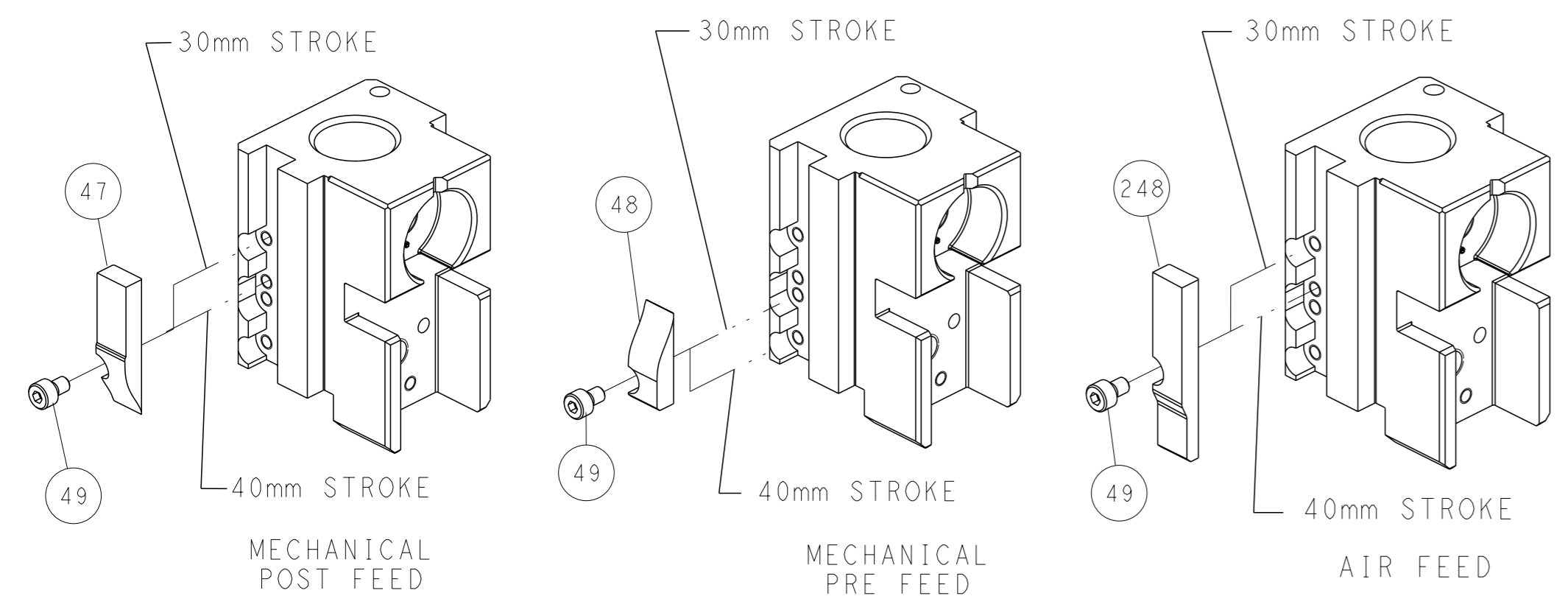
RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

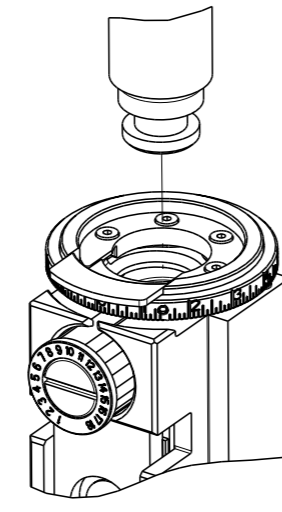


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | |
|---|--|---|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: H. HUANG 04DEC2013 CHK: L. ZHANG 04DEC2013 APVD: J. GUO 04DEC2013 | 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: C=2266166 | RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: B |
| MATERIAL: - FINISH: - | | WEIGHT: - Customer Accessible Production Drawing | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

| THIS DRAWING IS UNPUBLISHED. | RELEASED FOR PUBLICATION | | |
|--|--------------------------|--------------------------|------------|
| © COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | 20 | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2266166-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266166-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266166-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.98 mm [.078] | F |
| INSUL | 2.50 mm [.098] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | |
|--|---|
| TERMINAL DATA: FCL TERMINAL DELPHI CRIMP SPECIFICATION | |
| TERMINAL NAME: TERMINAL 1.5mm MALE | |
| WIRE STRIP LENGTH 4.57-4.95 mm [.180-.195 IN] | INSULATION DIAMETER RANGE Ø 2.54 mm [.100 IN] MAX |
| TERMINAL APPLICATION SPECIFICATION 13672903 Rev 02 | |
| TERMINALS APPLIED | |
| TE TERMINAL | FCL TERMINAL |
| 1832478-1 | 54001845 |
| 1832478-2 | 54001841 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 18/20 AWG | 1.27+/-0.05 [.050+/-0.002] | 4.8 |



- ▲ RECOMMENDED SPARE PARTS
- ▲ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ▲ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ▲ 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. 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)

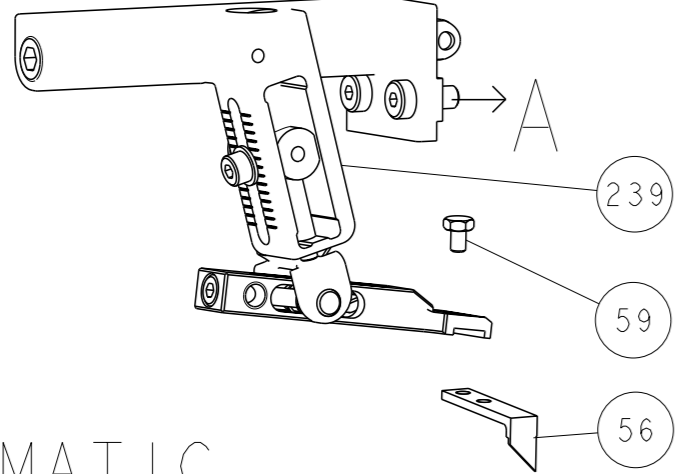
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| A | 66 | REV | DATE | BY | APPV |
| | | - | SEE SHEET 1 | - | - |

| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----------------------|---|
| - | 1 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| ▲ | - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 | |
| - | 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 | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 151 | |
| - | 1 | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 144 | |
| - | 4 | 4 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 143 | |
| - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 | |
| - | 1 | 1 | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 | |
| - | 1 | 1 | 1803516-1 | RAM ASSEMBLY, SF PACIFIC | 140 | |
| - | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 | |
| - | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 | |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 | |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 | |
| - | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 | |
| - | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 | |
| - | 1 | 1 | 690753-2 | SPACER, TONKER | 50 | |
| - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 | |
| - | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 1 | 1 | 1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 | |
| - | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 | |
| - | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 | |
| - | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 | |
| ▲ | - | 1 | 2119806-1 | INSERT, SHEAR | 13 | |
| - | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 | |
| - | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 | |
| ▲ | - | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 | |
| ▲ | - | 1 | 1803095-6 | FLOATING SHEAR, FRONT | 9 | |
| ▲ | 1 | 1 | 1 | 7-1633927-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 2-238011-1 | BLOCK, CRIMPER SPACER | 4 | |
| ▲ | 1 | 1 | 1 | 1-1803018-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 | |
| ▲ | 1 | 1 | 1 | 8-1633305-0 | CRIMPER, WIRE PREMIUM | 1 |

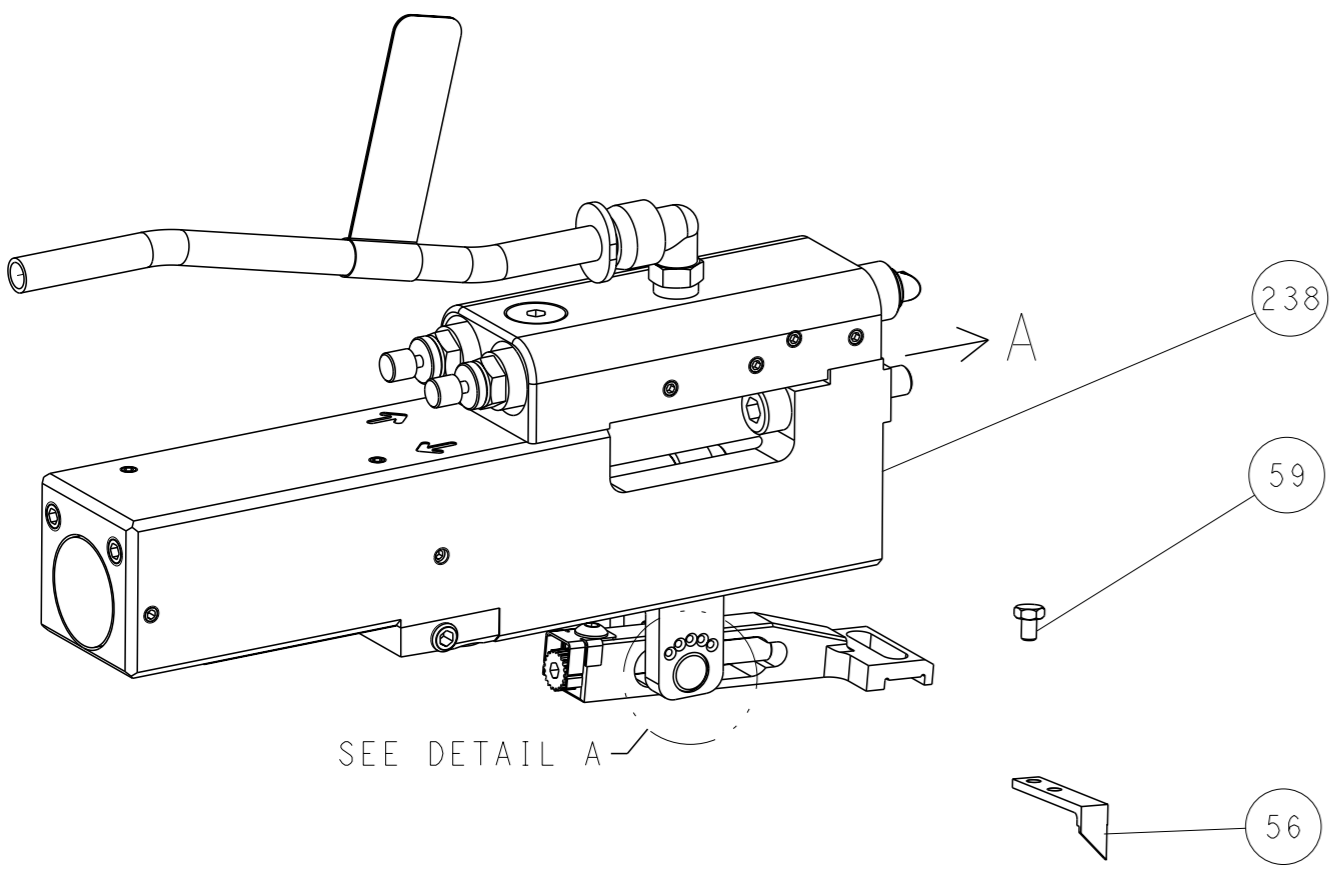
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| <small>THE DRAWING IS CONTROLLED DOCUMENT FROM THE REVISIONS INFORMATION SYSTEM. IF THERE IS A CHANGE TO THE DRAWING, THE REVISIONS INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: H. HUANG 04DEC2013 CHK: L. ZHANG 04DEC2013 APV: U. GUO 04DEC2013 | NAME: TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2 | SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266166 SHEET 3 OF 4 |

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

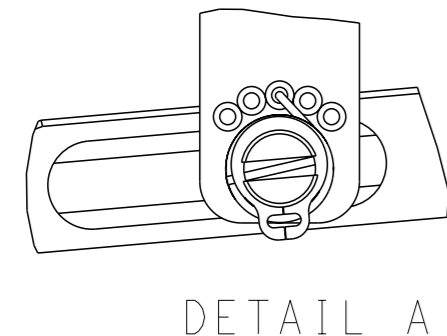
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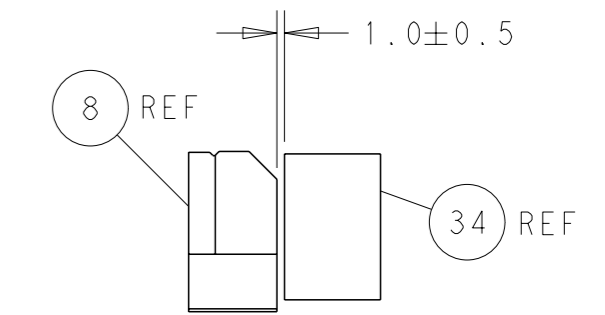
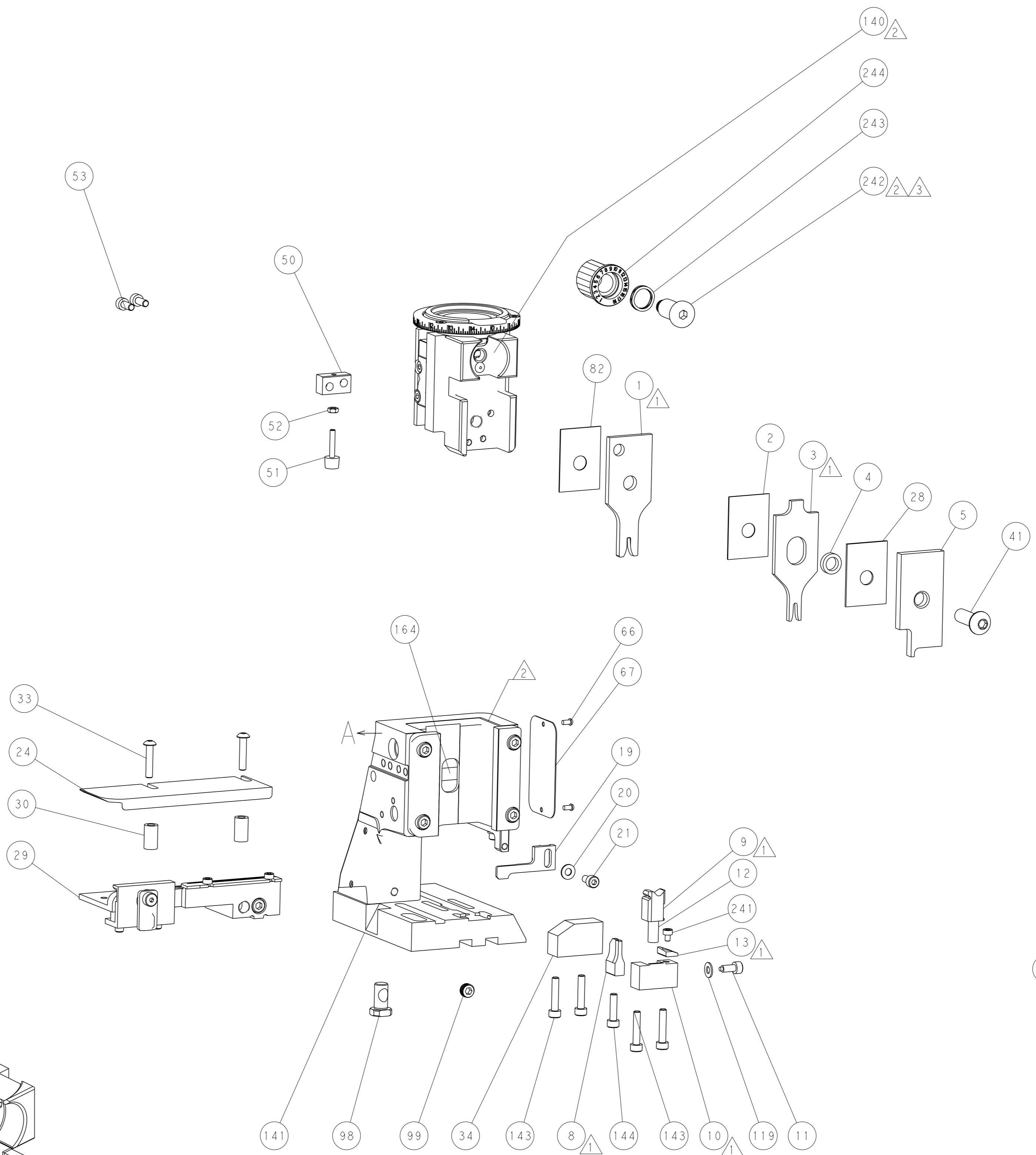
PNEUMATIC



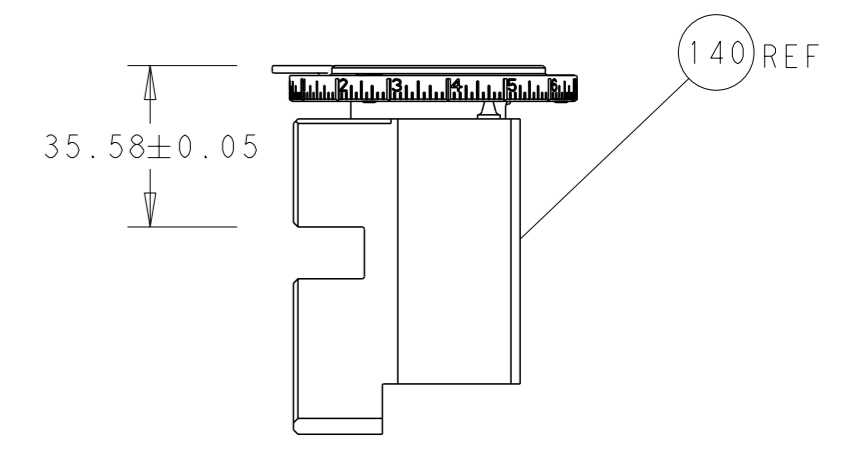
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



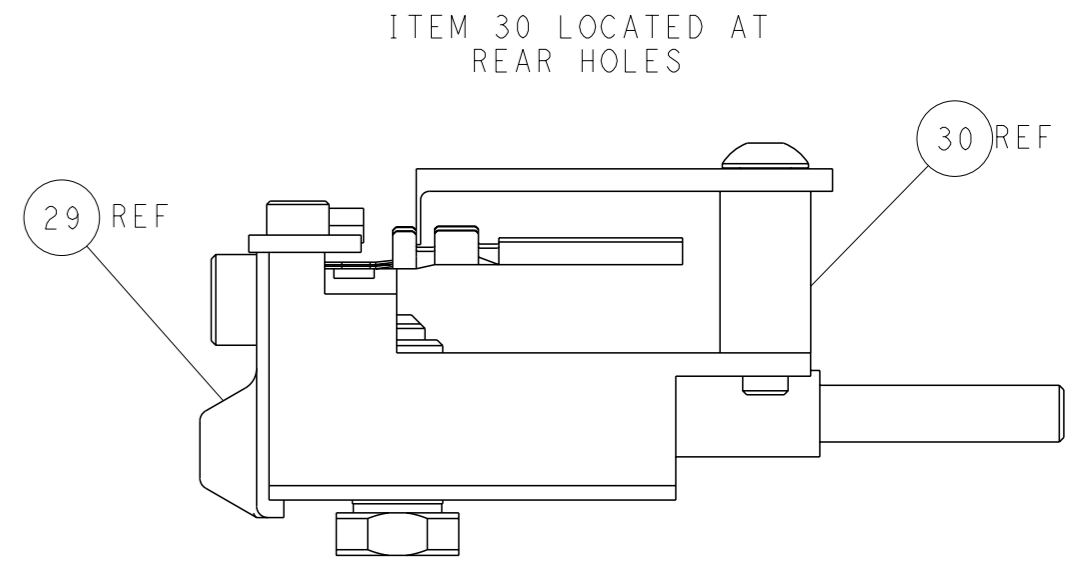
DETAIL A



TERMINAL SUPPORT LOCATION

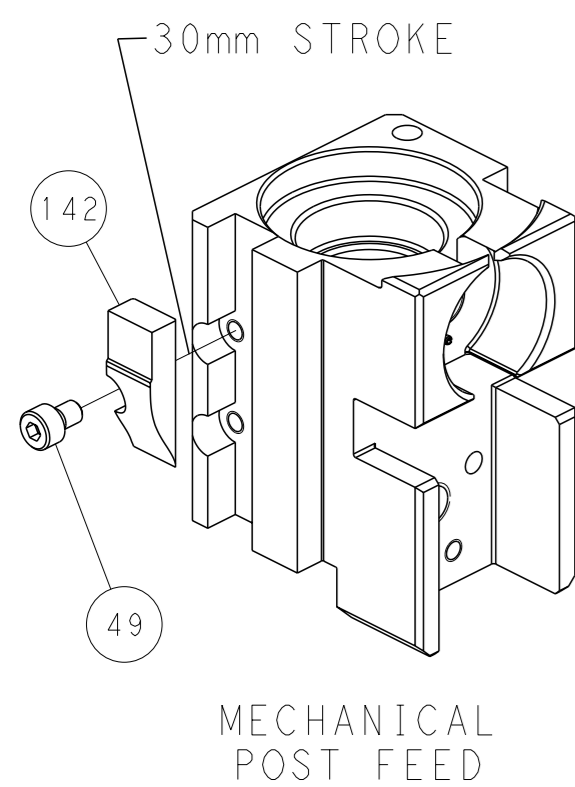


RAM SET-UP

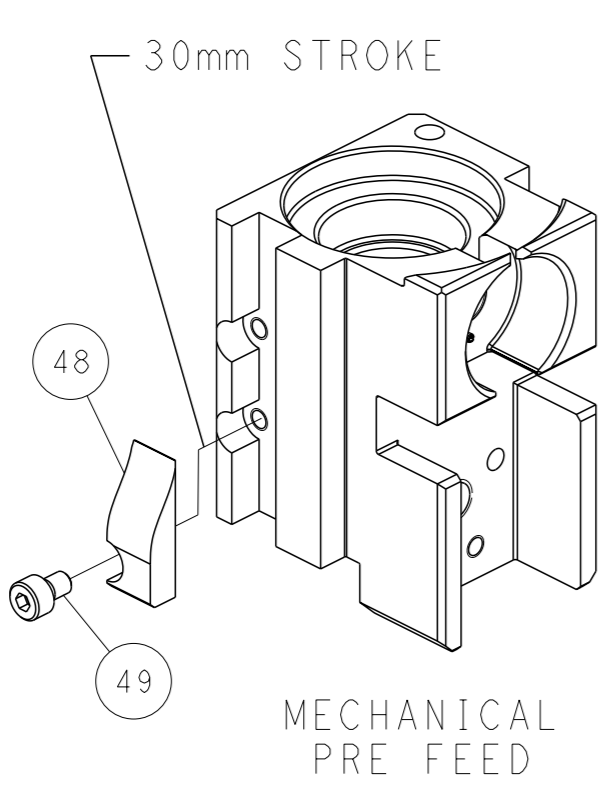


FEED TRACK POSITION GUIDE BY INSULATION BARREL

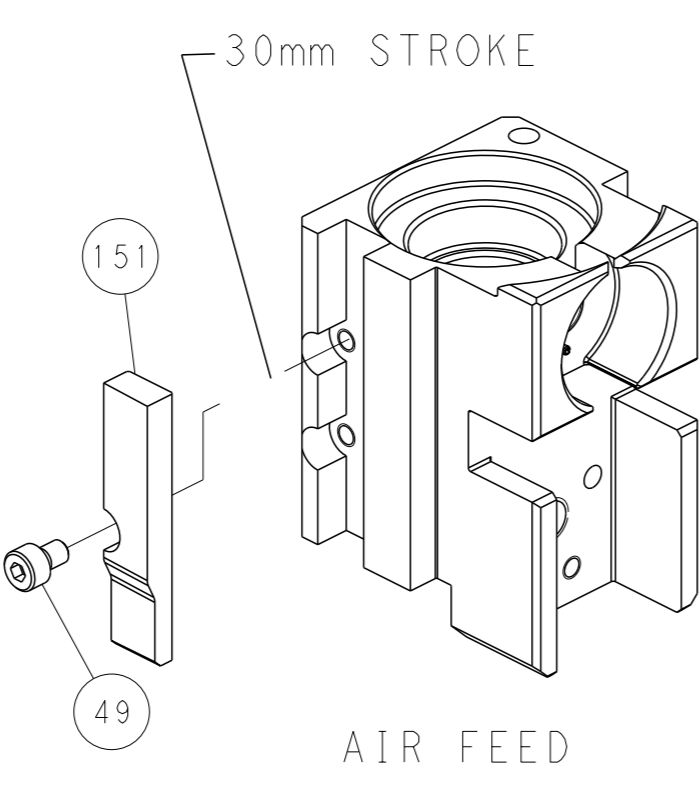
CAM POSITIONS



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)

| | | | |
|---|---|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: H. HUANG 04DEC2013 CHK: L. ZHANG 04DEC2013 APVD: J. GUO 04DEC2013 | NAME: TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | APPLICATION SPEC PRODUCT SPEC RESTRICTED TO | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266166 | SCALE: 1:2 SHEET: 4 of 4 REV: B |
| MATERIAL: | | WEIGHT: Customer Accessible Production Drawing | |