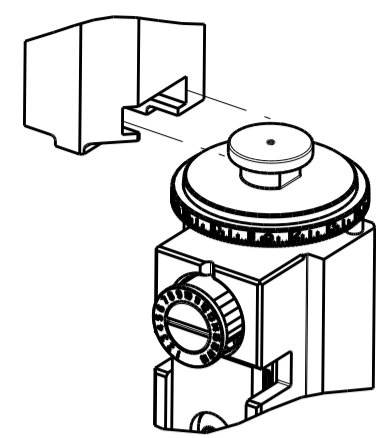


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266117-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266117-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266117-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266117-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266117-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266117-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266117-7	C	CRIMP TOOLING KIT	-
7-2266117-8	C	APPLICATOR CONVERSION KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø2.74-3.18mm [.108-.125]
7-2266117-8	Ø2.31-2.72mm [.091-.107]
7-2266118-8	Ø1.91-2.29mm [.075-.090]
7-2266119-8	Ø1.60-2.16mm [.063-.085]
7-2266120-8	Ø1.27-1.57mm [.050-.062]

TERMINAL DATA: DEUTSCH TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.81-5.08 mm [.150-.200 IN]	Ø2.31-2.72 mm [.091-.107 IN]		
TERMINAL APPLICATION SPECIFICATION	114-151003		

TERMINAL DATA: DEUTSCH TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.81-5.08 mm [.150-.200 IN]	Ø2.31-2.72 mm [.091-.107 IN]		
TERMINAL APPLICATION SPECIFICATION	114-151003		

TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-1	1060-20-0122	1572032-2	1060-20-0144
1572032-7	1060-20-0177		

TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286680-1	1062-20-0122	286680-2	1062-20-0144
286680-9	1062-20-0177	286680-5	1062-20-0322
286680-6	1062-20-0344	1-286680-0	1062-20-0377

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.47+0.03/-0.05 [.058+.001/- .002]	3.4
16 AWG	1.27+0.03/-0.05 [.050+.001/- .002]	5.4
1.00mm2	1.27+0.03/-0.05 [.050+.001/- .002]	5.4
18 AWG	1.24+0.03/-0.05 [.049+.001/- .002]	5.7
0.75mm2	1.22+0.03/-0.05 [.048+.001/- .002]	5.9
0.60mm2	1.07+0.03/-0.05 [.042+.001/- .002]	7.4
20 AWG	0.99+0.03/-0.05 [.039+.001/- .002]	8.2
0.50mm2	0.97+0.03/-0.05 [.038+.001/- .002]	8.4
22 AWG	0.94+0.03/-0.05 [.037+.001/- .002]	8.7
0.35mm2	0.94+0.03/-0.05 [.037+.001/- .002]	8.7

- 1 RECOMMENDED SPARE PARTS
 - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
 - 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
 - 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	D	10JAN2018	YY	GB	
		E	20JUN2018	LG	JD	
		F	08JUL2020	TB	RK	
		G	15SEP2020	FZ	RK	

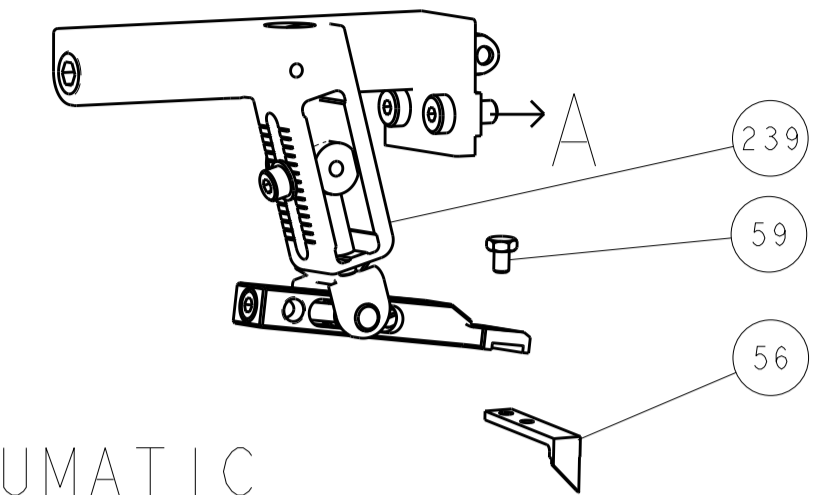
REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO	
-	-	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	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
-	-	-	1	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	-	1-1752354-8	STANDOFF,HOLD-DOWN	180
-	-	-	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	1	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	455888-7	SPACER, CRIMPER	82
1	-	-	-	-	2266117	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	1	1	1338685-1	PAWL, FEED	56
-	-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	1	-	2119653-1	FEED CAM, POST FEED	47
-	-	1	-	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	1	-	-	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1	1320928-2	STRIP GUIDE	24
-	-	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	-	2119533-1	STRIPPER, SIDE FEED	19
-	-	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	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1803293-3	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	-	6
-	-	1	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	-	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1803019-5	CRIMPER, INSULATION O	3
-	-	1	1	1	455888-8	SPACER, CRIMPER	2
-	-	1	2	2	1803364-2	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)

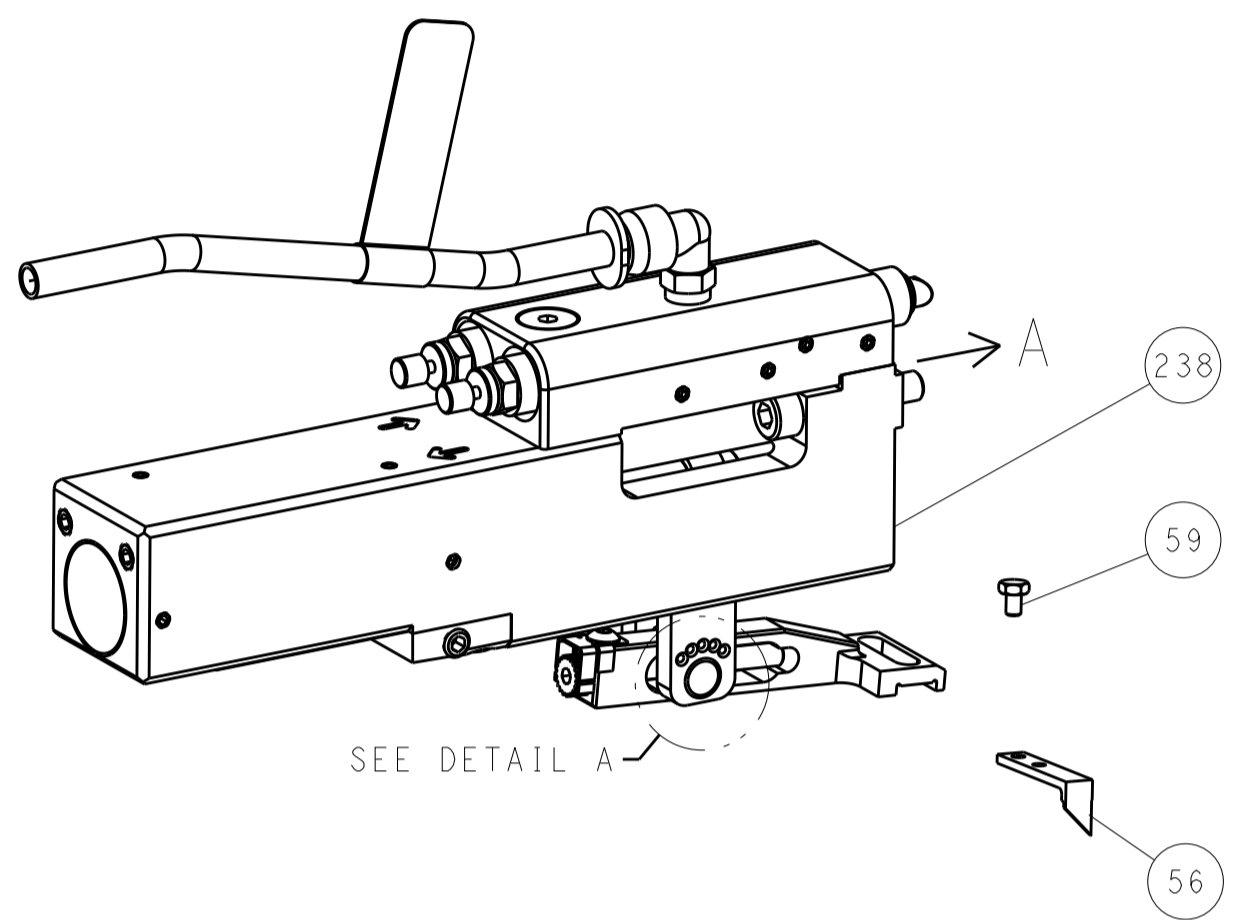
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



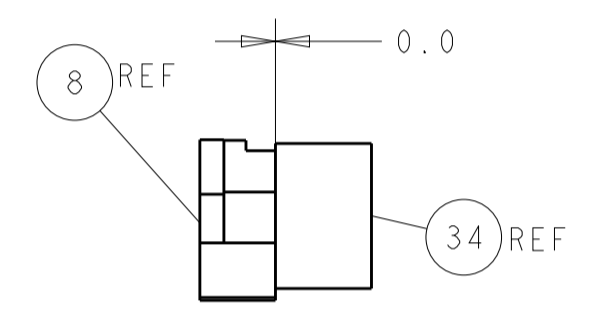
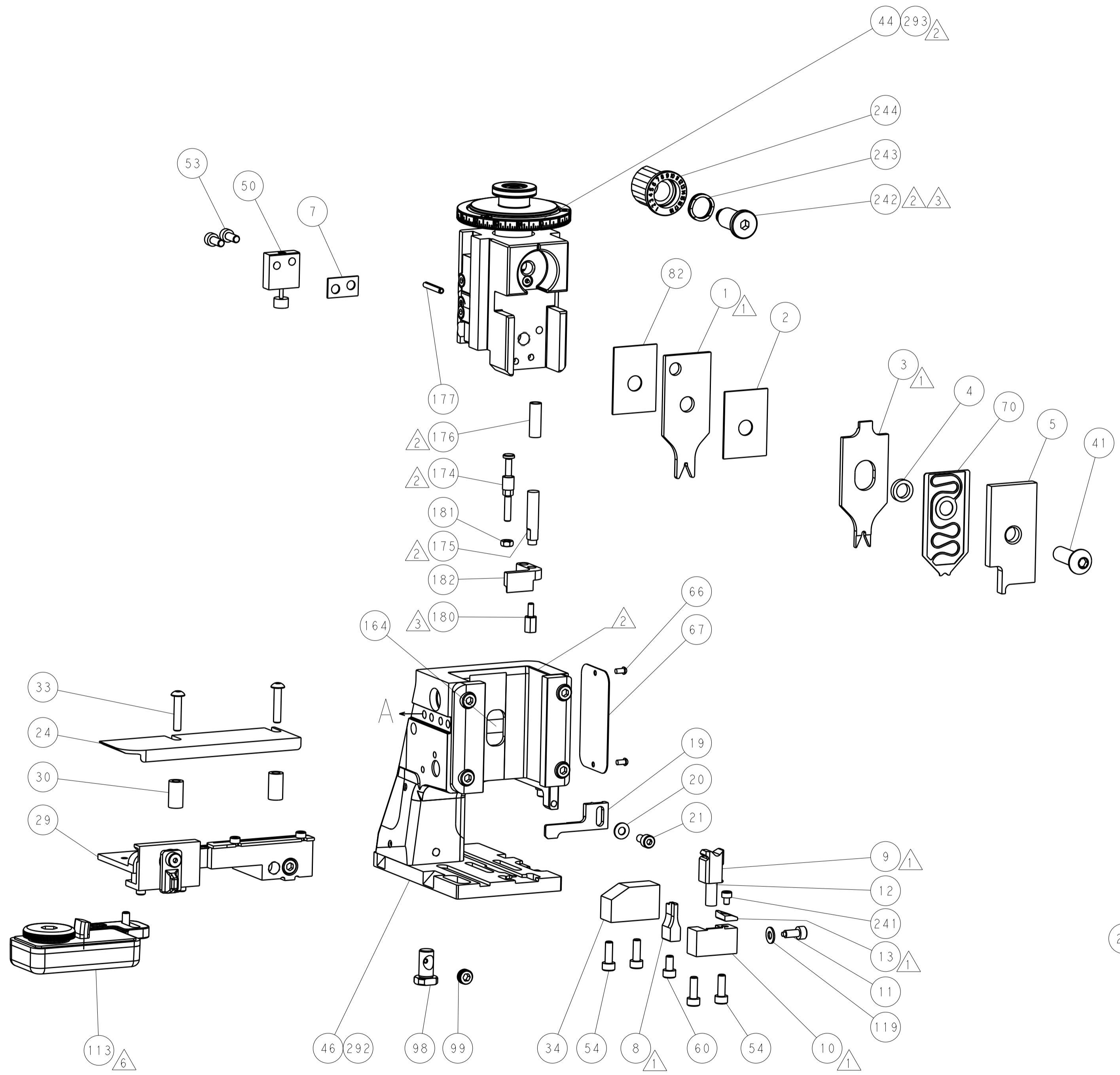
PNEUMATIC



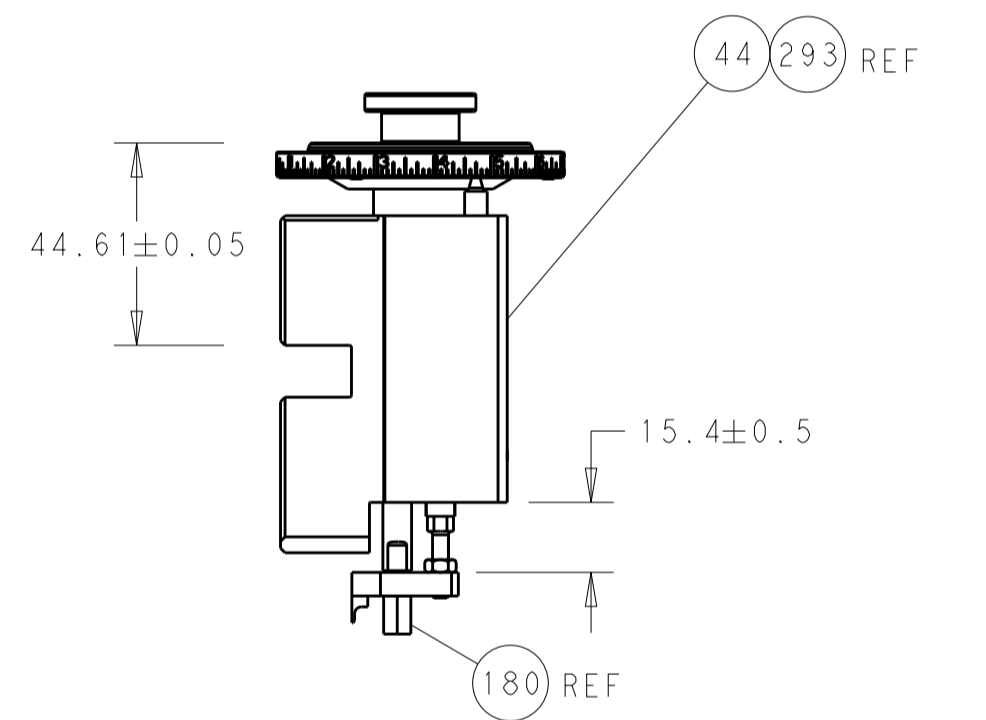
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



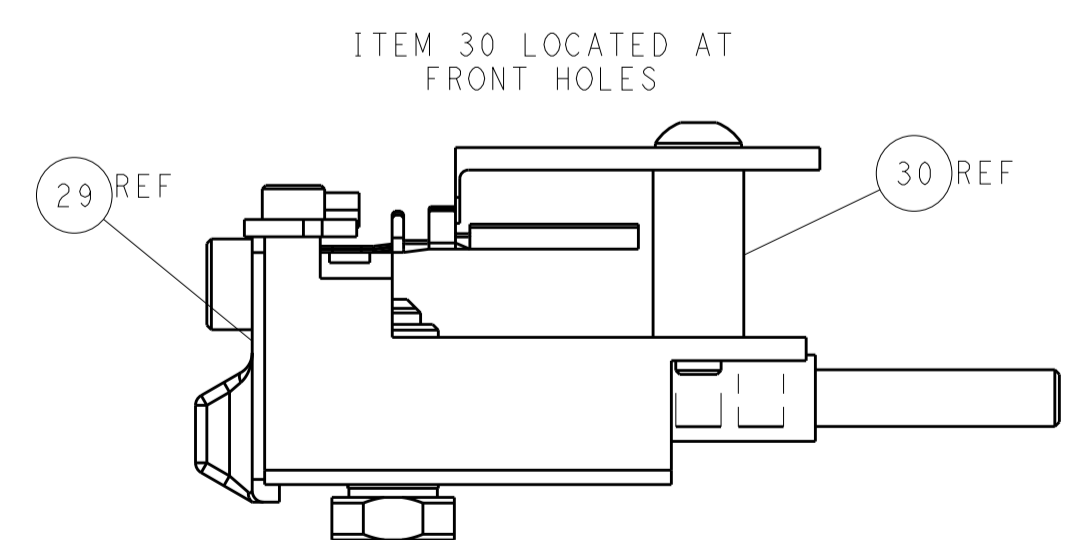
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 16-Oct-13		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 16-Oct-13		NAME: Ocean Side Feed Applicator	
CUSTOMER DRAWING		SCALE: 1:2		APVD: M. CLIFFORD 16-Oct-13		RESTRICTED TO: A1 00779 ©=2266117	
				PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
				APPLICATION SPEC		SHEET 2 OF 4 REV G	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266117-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266117-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266117-7	C	CRIMP TOOLING KIT	-
7-2266117-8	C	APPLICATOR CONVERSION KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS
408-35042

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø 2.74-3.18mm [.109-.125]
7-2266117-8	Ø 2.31-2.72mm [.091-.107]
7-2266118-8	Ø 1.91-2.29mm [.075-.090]
7-2266119-8	Ø 1.60-2.16mm [.063-.085]
7-2266120-8	Ø 1.27-1.57mm [.050-.062]

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT CONTACT PIN SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE TERMINAL	DEUTSCH TERMINAL
3.81-5.08 mm [1.50-.200 IN]	Ø 2.31-2.72 mm [.091-.107 IN]	1572032-1	1060-20-0122
114-151003	-	1572032-2	1060-20-0144
114-151003	-	1572032-7	1060-20-0177

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE TERMINAL	DEUTSCH TERMINAL
3.81-5.08 mm [1.50-.200 IN]	Ø 2.31-2.72 mm [.091-.107 IN]	286680-1	1062-20-0122
114-151003	-	286680-2	1062-20-0144
114-151003	-	286680-5	1062-20-0322
114-151003	-	286680-6	1062-20-0377

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.47+0.03/-0.05 [.058+.001/-0.002]	3.4
16 AWG	1.27+0.03/-0.05 [.050+.001/-0.002]	5.4
1.00mm2	1.27+0.03/-0.05 [.050+.001/-0.002]	5.4
18 AWG	1.24+0.03/-0.05 [.049+.001/-0.002]	5.7
0.75mm2	1.22+0.03/-0.05 [.048+.001/-0.002]	5.9
0.60mm2	1.07+0.03/-0.05 [.042+.001/-0.002]	7.4
20 AWG	0.99+0.03/-0.05 [.039+.001/-0.002]	8.2
0.50mm2	0.97+0.03/-0.05 [.038+.001/-0.002]	8.4
22 AWG	0.94+0.03/-0.05 [.037+.001/-0.002]	8.7
0.35mm2	0.94+0.03/-0.05 [.037+.001/-0.002]	8.7

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
 - SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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	REV	DATE	BY	APPD
A	66	-	-	-	-

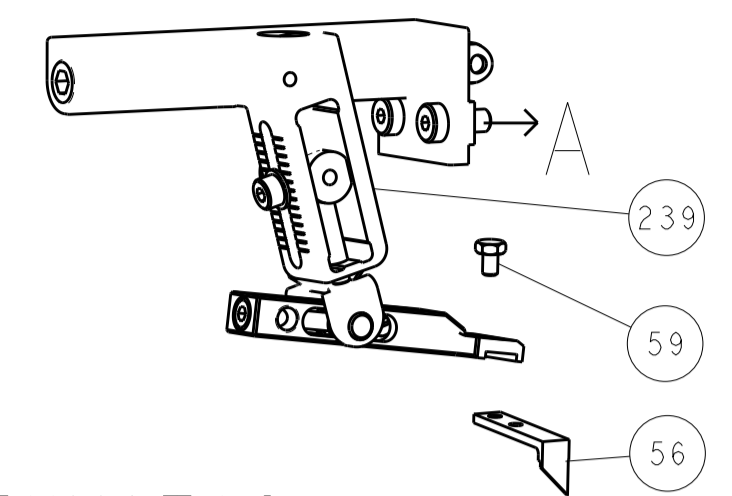
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	1	1	2844908-1	SCREW, LOCKING	99
-	-	1	1	2844907-1	POST, LOCKING	98
-	-	1	1	455888-7	SPACER, CRIMPER	82
1	-	-	-	2266117	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	-	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	1803382-6	HOLD DOWN, SPRING LOADED	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	2-1752356-0	SUPPORT, TERMINAL	34
-	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1320928-2	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	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1-356885-4	STOP, SHEAR	11
-	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1803293-3	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	6
-	-	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
-	-	1	1	455888-8	SPACER, CRIMPER	2
-	-	1	1	1803364-2	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
mm	0.01	0.02	0.05	0.10	0.15
mm	0.01	0.02	0.05	0.10	0.15
mm	0.01	0.02	0.05	0.10	0.15
mm	0.01	0.02	0.05	0.10	0.15
mm	0.01	0.02	0.05	0.10	0.15

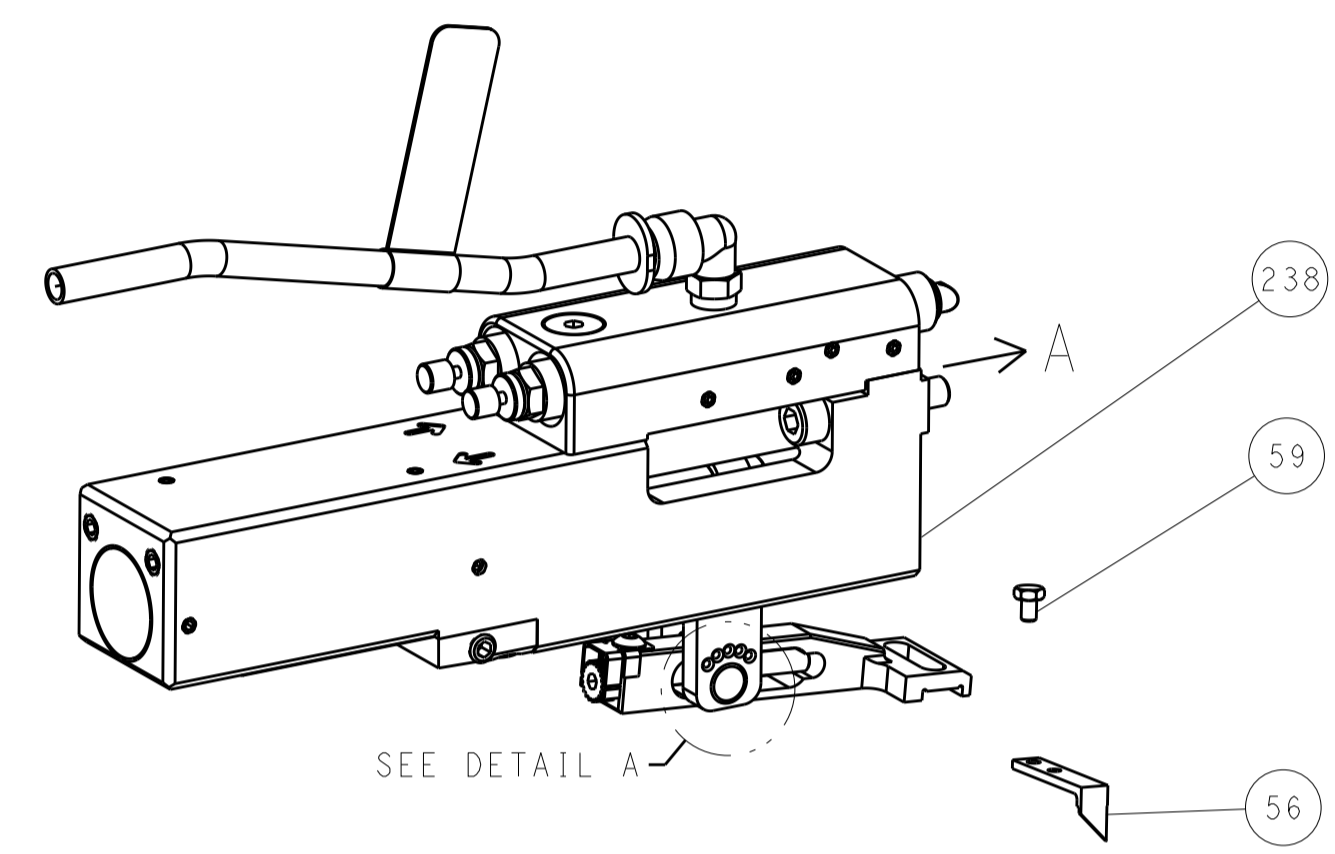
OWN	R. KNEPPER	16-Oct-13
CHK	G. BAILEY	16-Oct-13
APPD	M. CLIFFORD	16-Oct-13
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266117
CUSTOMER DRAWING	SCALE	SHEET 3 OF 4
	1:2	REV G

LOC		DIST		REVISIONS			
				REV	DATE	BY	APPV
A	66						
					SEE SHEET 1		

FEED TYPE MECHANICAL



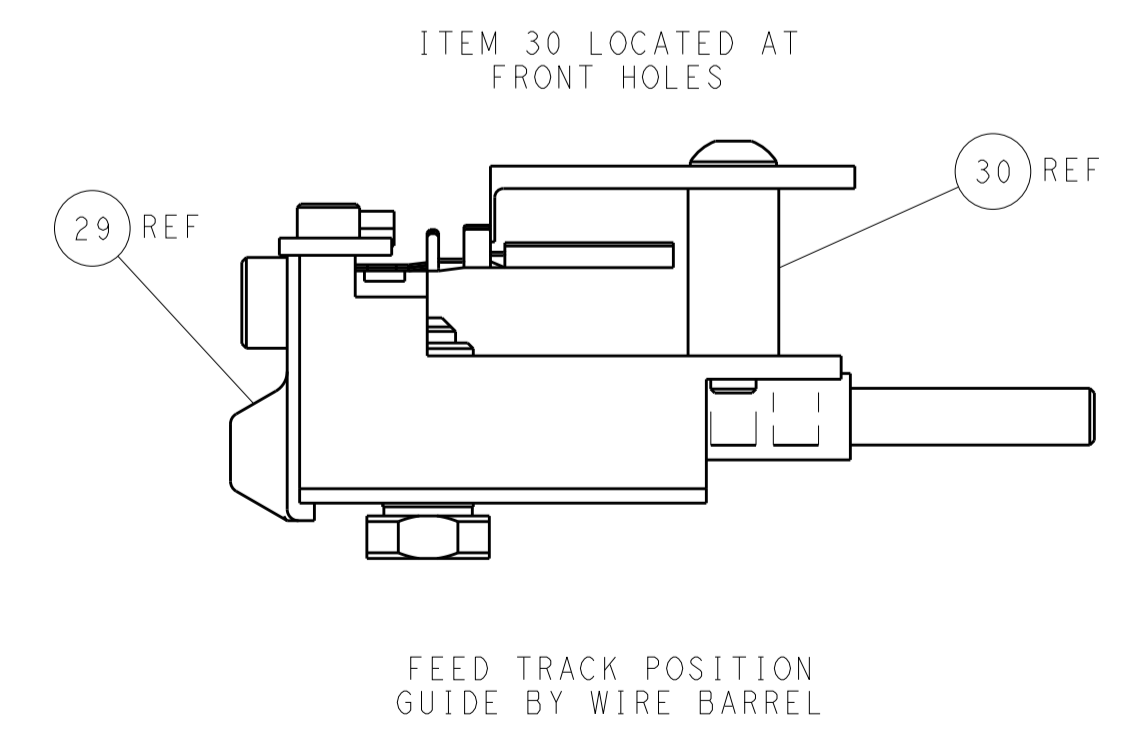
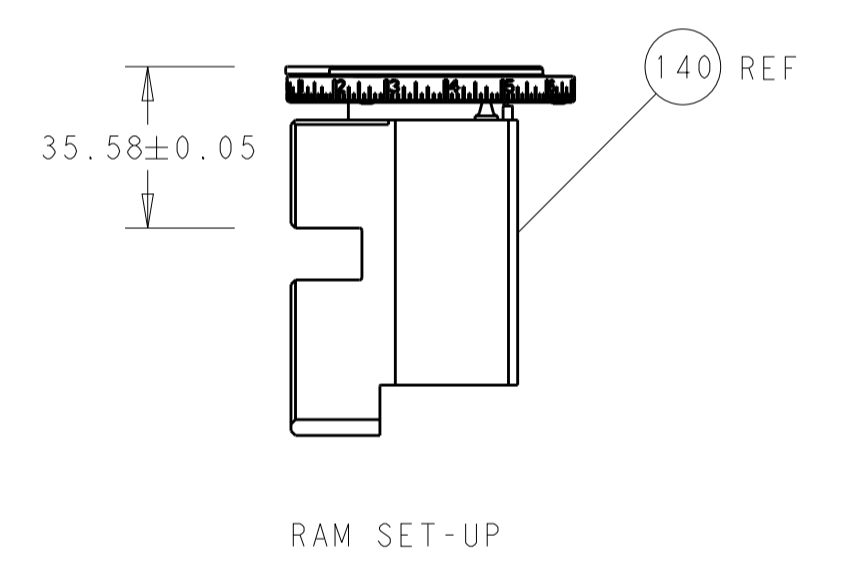
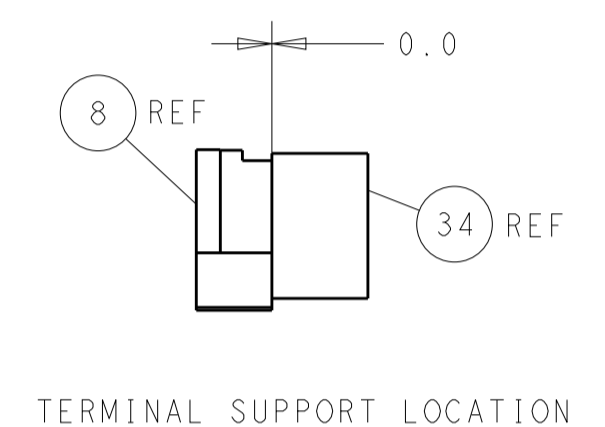
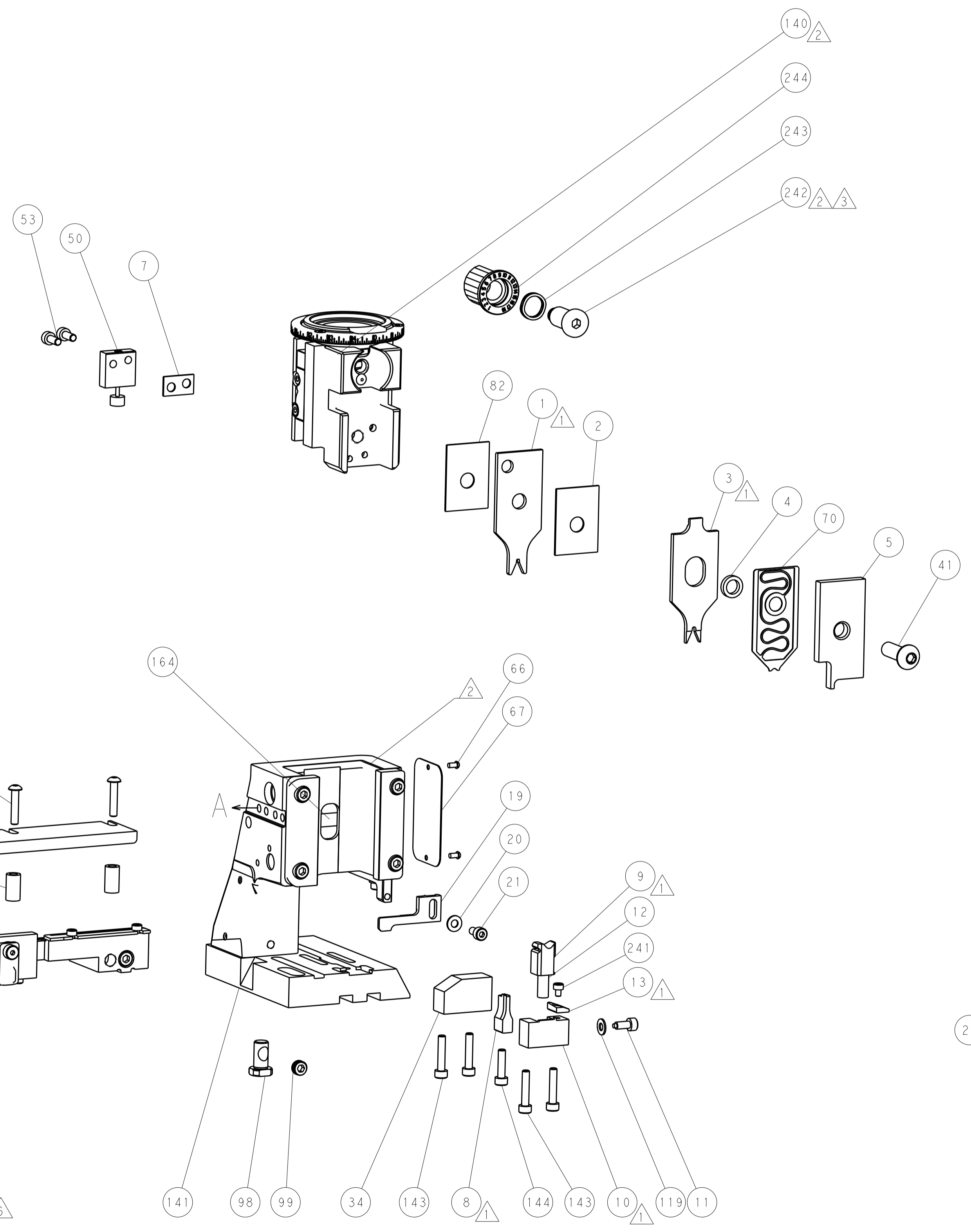
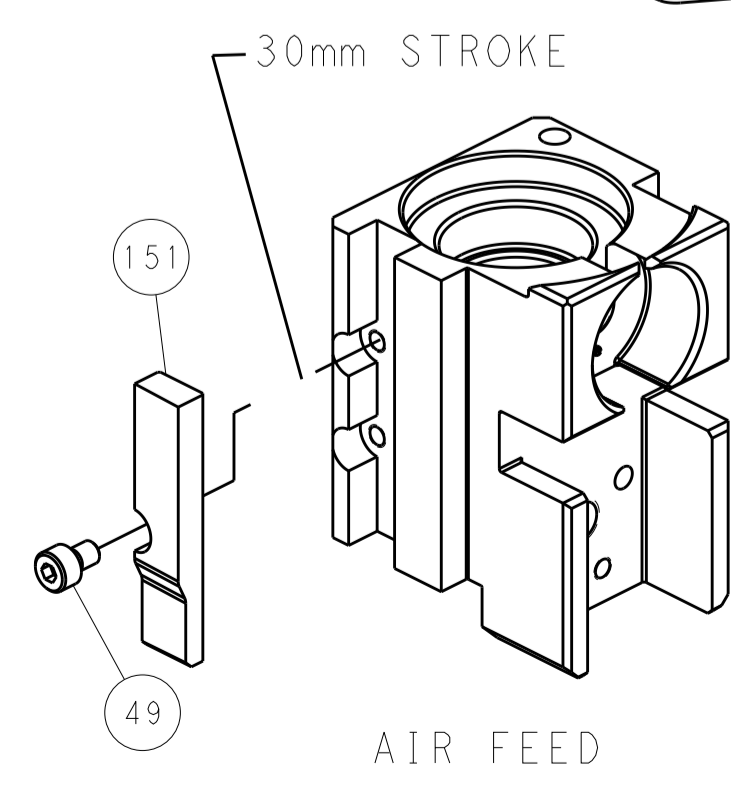
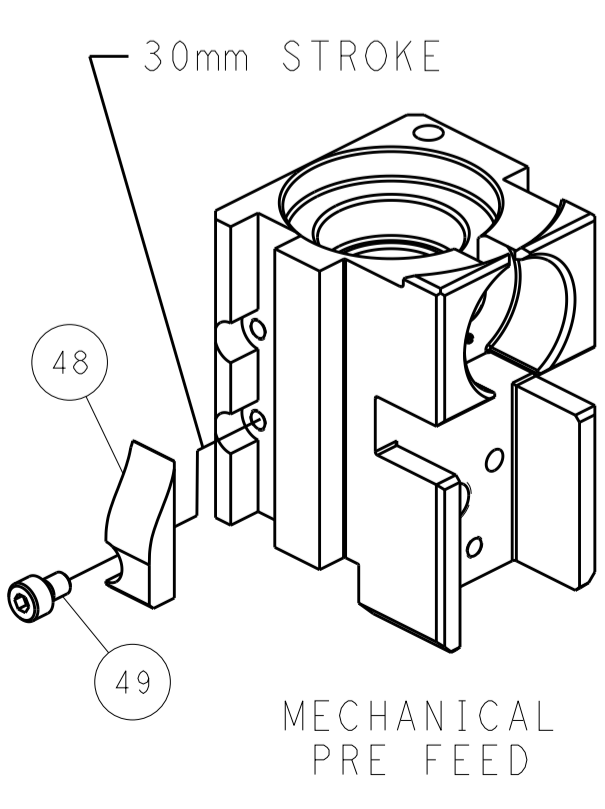
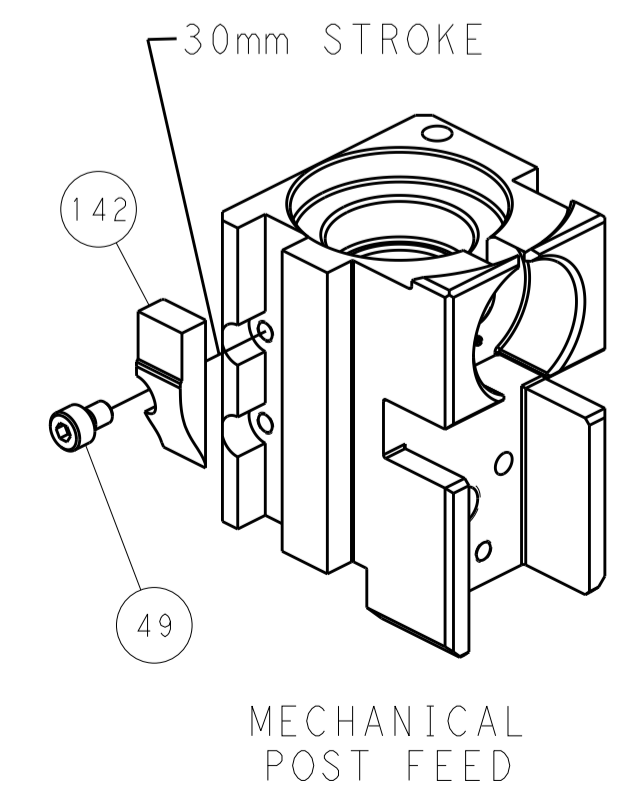
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

<small>THE DRAWING IS CONTROLLED THROUGHOUT THE ENTIRE ORGANIZATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: R. KNEPPER 16-Oct-13 CHK: G. BAILEY 16-Oct-13 APVD: M. CLIFFORD 16-Oct-13	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: CUSTOMER DRAWING:	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266117 SCALE: 1:2 SHEET: 4 of 4 REV: G