

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151956-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151956-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151956-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151956-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151956-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.70 mm [.146]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	2.0-2.9mm
TERMINALS APPLIED		1572283-1	7165-0118	1.5-2.0mm

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1832684-1	1500-0106	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	2.0-2.9mm
TERMINALS APPLIED		1572283-1	7165-0118	1.5-2.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.50+/-0.05 [.059+/- .002]	4.0
0.85mm2	1.40+/-0.05 [.055+/- .002]	4.9
0.50mm2	1.25+/-0.05 [.049+/- .002]	6.7
0.30mm2	1.10+/-0.05 [.043+/- .002]	8.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.2
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.3
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.6
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.4

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	2.0-2.9mm
TERMINALS APPLIED		1572283-1	7165-0118	1.5-2.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.1
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.1
0.75mm2	1.20+/-0.05 [.047+/- .002]	6.2
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.5
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.2

- 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 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.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.

*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)

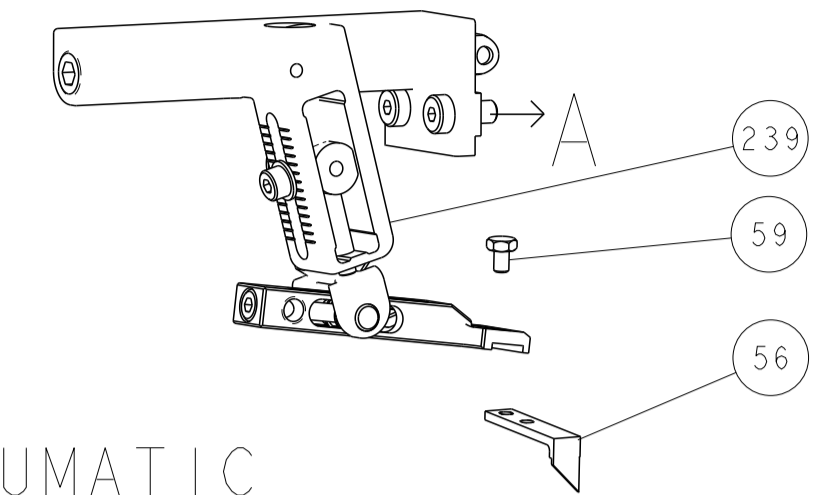
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		D	ECR-21-005103	22JUL2021	JWC RK
		E	ECR-21-118872	27OCT2021	FJ RK
		F	ECR-23-166540	16FEB2023	JWC TE

-	1	1	1	1	1803945-4	TONKER	300	
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1	1	1803944-1	SPACER, TONKER	297	
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	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	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	4-1633711-9	ANVIL, COMBINATION	8
-	1	1	1	1	4-240641-6	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803018-9	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	3-1633305-0	CRIMPER, WIRE PREMIUM	1

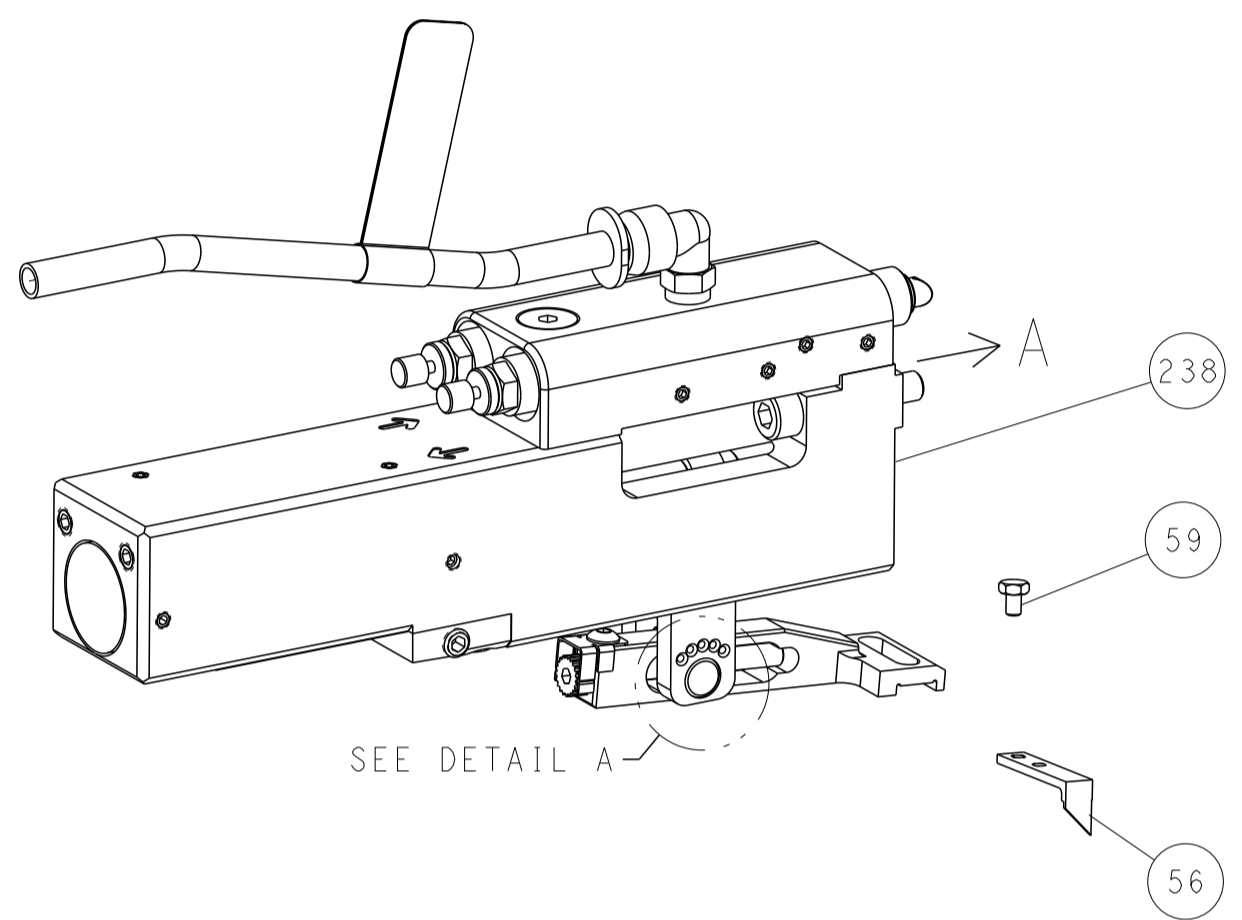
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									1:2	1 OF 4	F

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

FEED TYPE MECHANICAL



PNEUMATIC

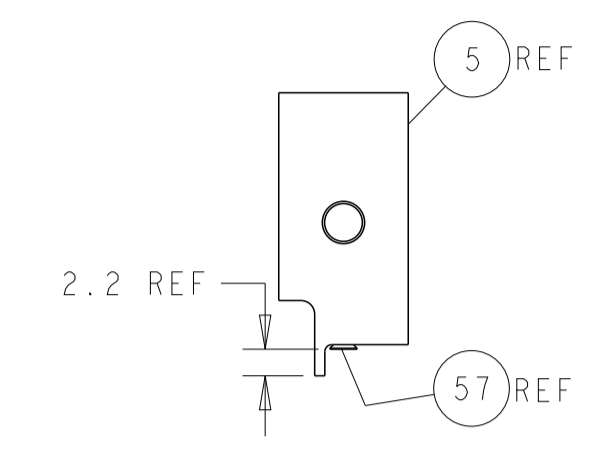
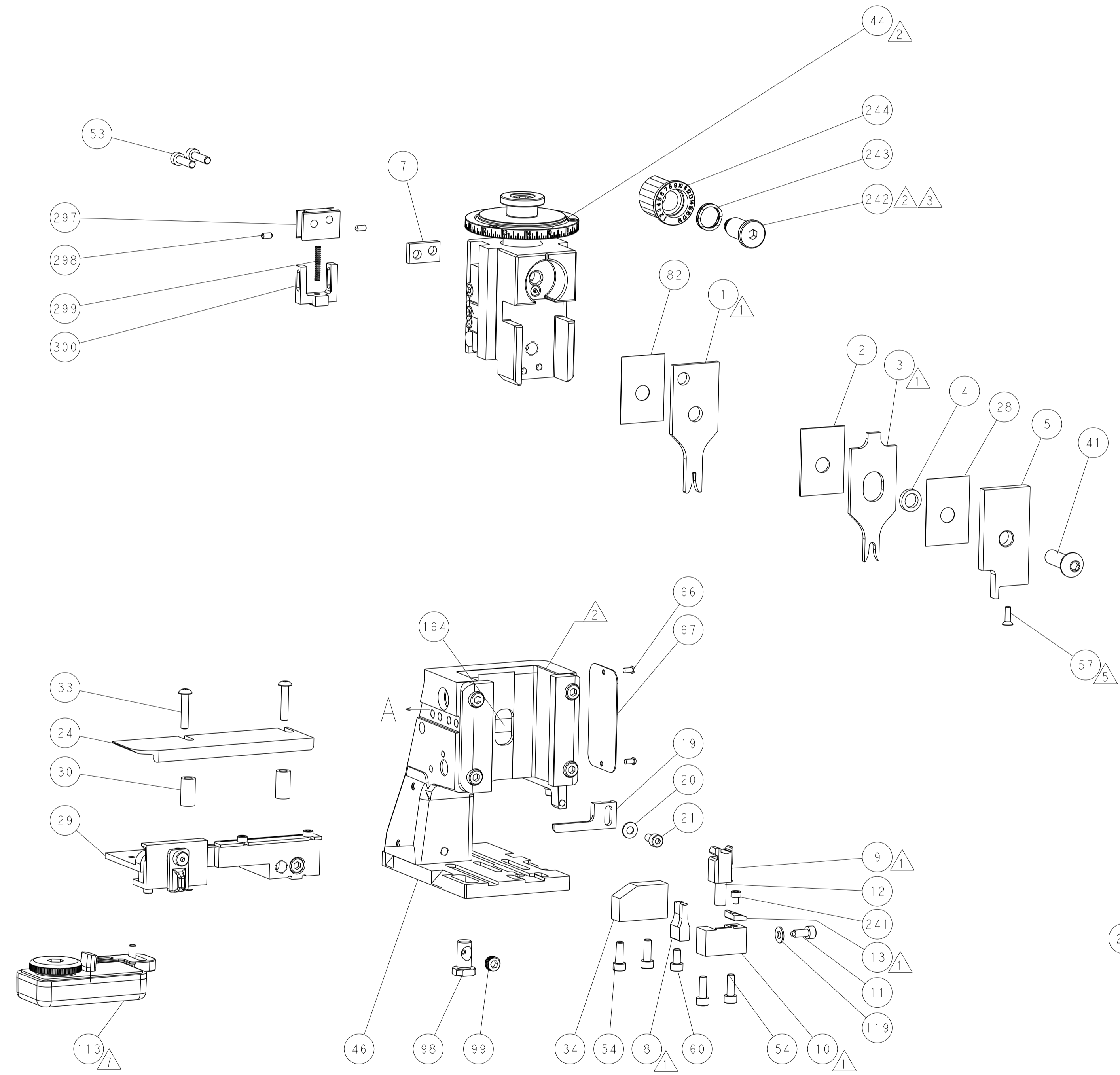
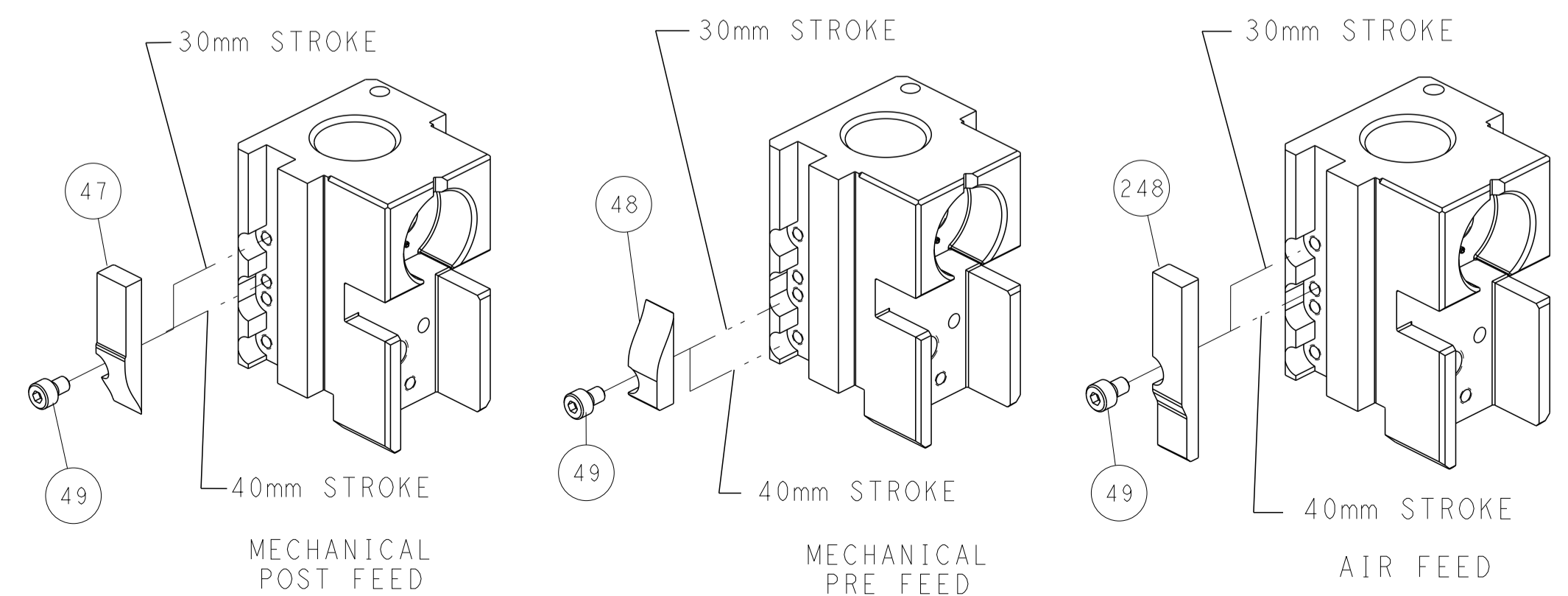


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

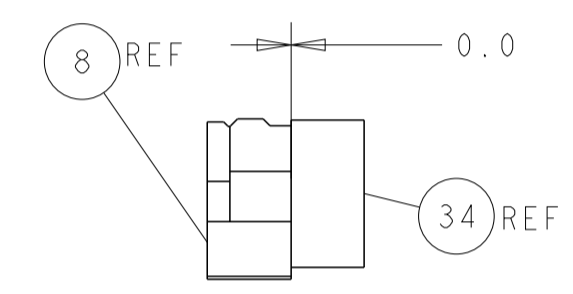


DETAIL A

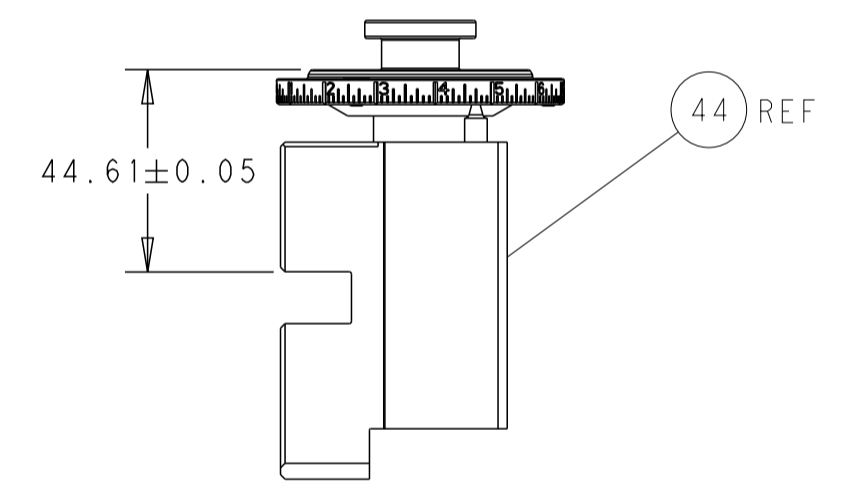
CAM POSITIONS



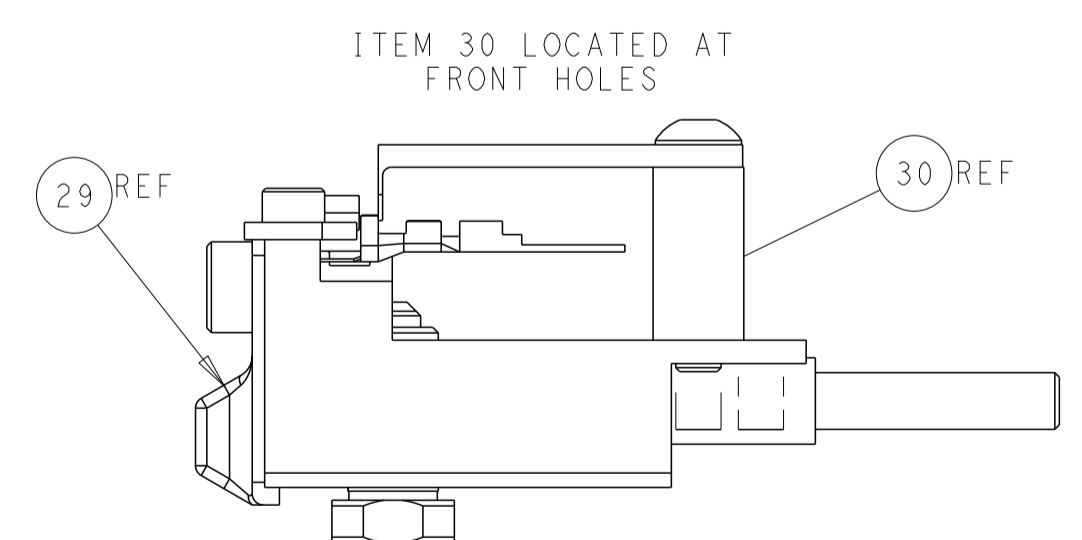
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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 ±		DWN C. CHEN 09JUN2013 CHK U. GUO 09JUN2013 APVD J. CRUZ 09JUN2013		NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO A1 00779 C=2151956	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 of 4 REV F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151956-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151956-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151956-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.70 mm [.146]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION				
TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
1642775-1	1500-0105	1949371-1	7160-8234	1.7-2.7mm
		1949636-1	7165-0119	2.0-2.9mm
		1572283-1	7165-0118	1.5-2.0mm

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION				
TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
1832684-1	1500-0106	1949371-1	7160-8234	1.7-2.7mm
		1949636-1	7165-0119	2.0-2.9mm
		1572283-1	7165-0118	1.5-2.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.50+/-0.05 [.059+/- .002]	4.0
0.85mm2	1.40+/-0.05 [.055+/- .002]	4.9
0.50mm2	1.25+/-0.05 [.049+/- .002]	6.7
0.30mm2	1.10+/-0.05 [.043+/- .002]	8.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.2
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.3
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.6
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.4

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION				
TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
1572692-1	1500-0110	1949371-1	7160-8234	Ø1.7-2.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.1
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.1
0.75mm2	1.20+/-0.05 [.047+/- .002]	6.2
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.5
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.2

- 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 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		1803945-4 TONKER	300
-	1	1		22278-9 SPRING, COMPRESSION	299
-	2	2		4-18032-3 SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1		1803944-1 SPACER, TONKER	297
-	1	1		2119082-8 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		455888-4 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		985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1		1338685-1 PAWL, FEED	56
-	2	2		2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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		1752356-1 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		3-2844962-0 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-3 SPACER, CRIMPER	28
-	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		318707-1 FLOATING SHEAR, FRONT	9
-	1	1		4-1633711-9 ANVIL, COMBINATION	8
-	1	1		4-240641-6 SPACER	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
-	1	1		2-1803018-9 CRIMPER, INSULATION O	3
-	1	1		1-455888-2 SPACER, CRIMPER	2
-	1	1		3-1633305-0 CRIMPER, WIRE PREMIUM	1

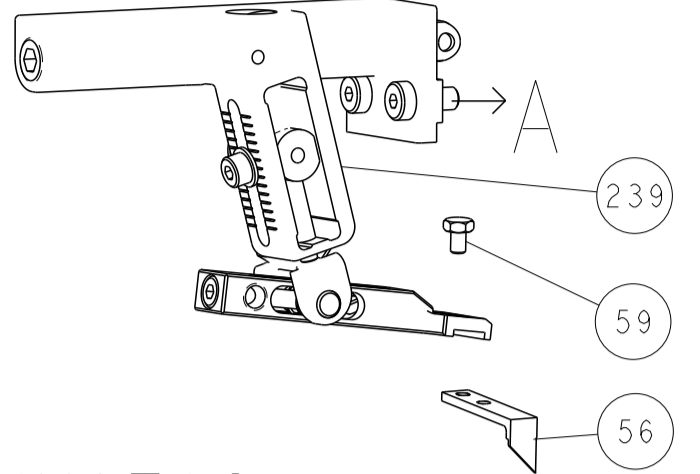
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH ±			

CHK	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
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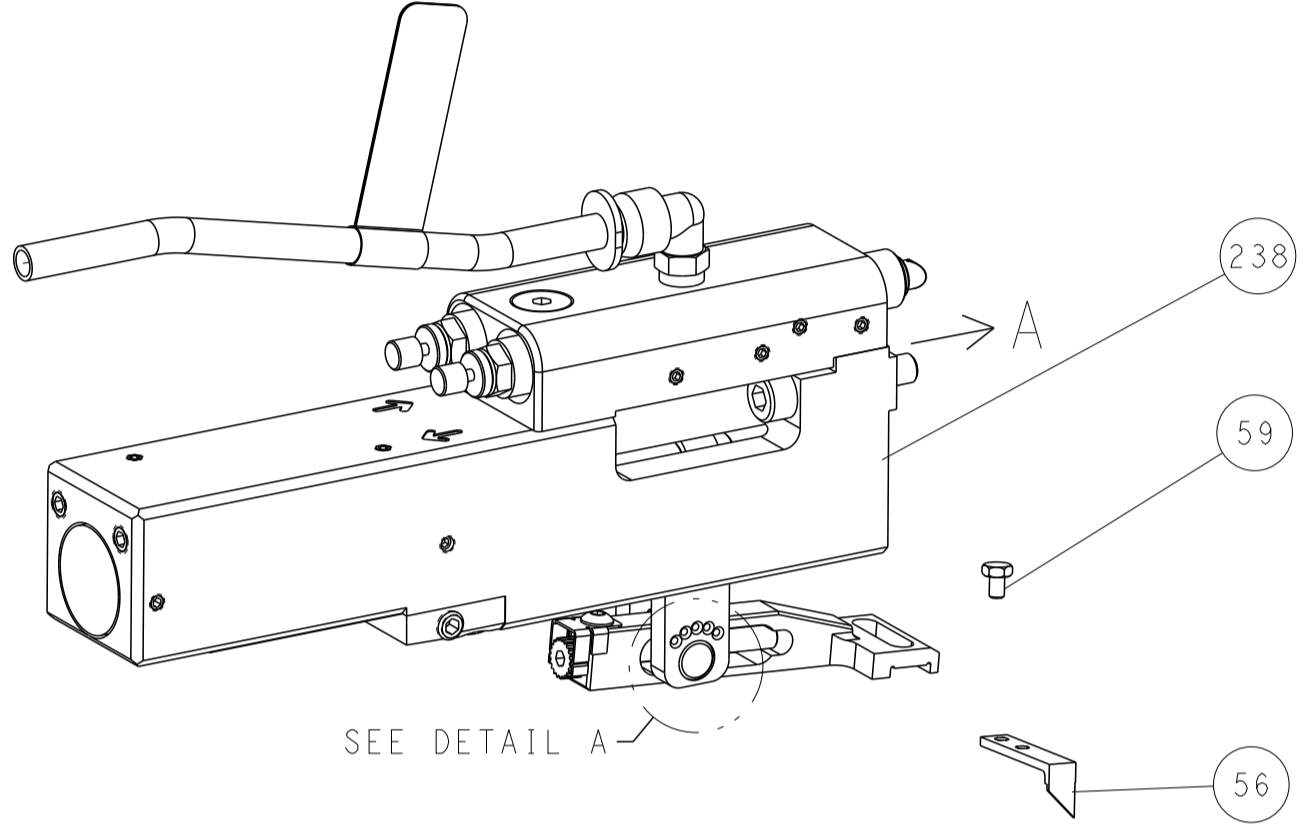
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV F

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
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FEED TYPE MECHANICAL



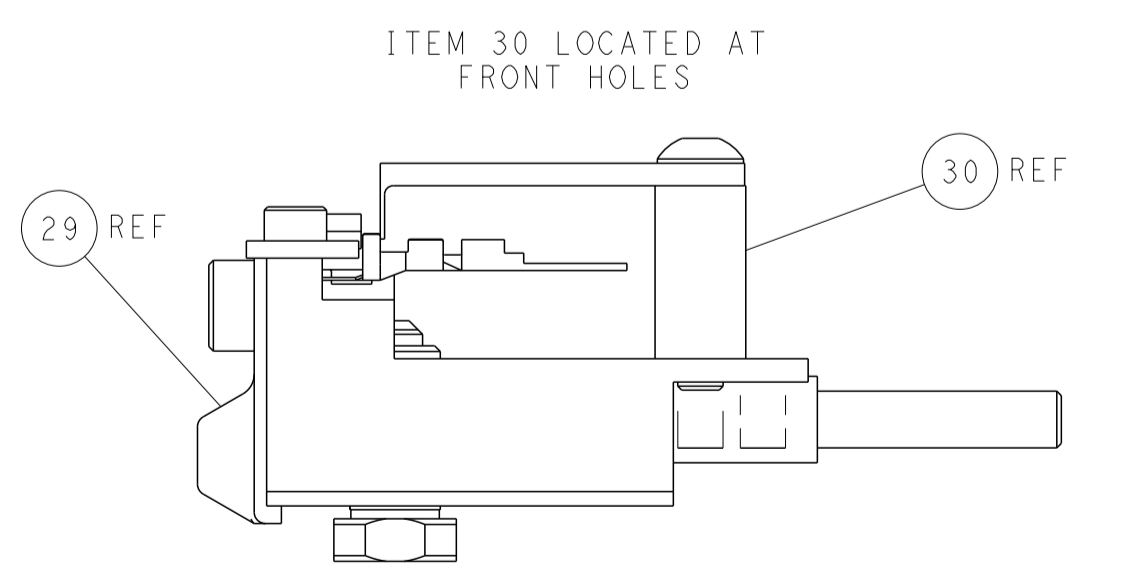
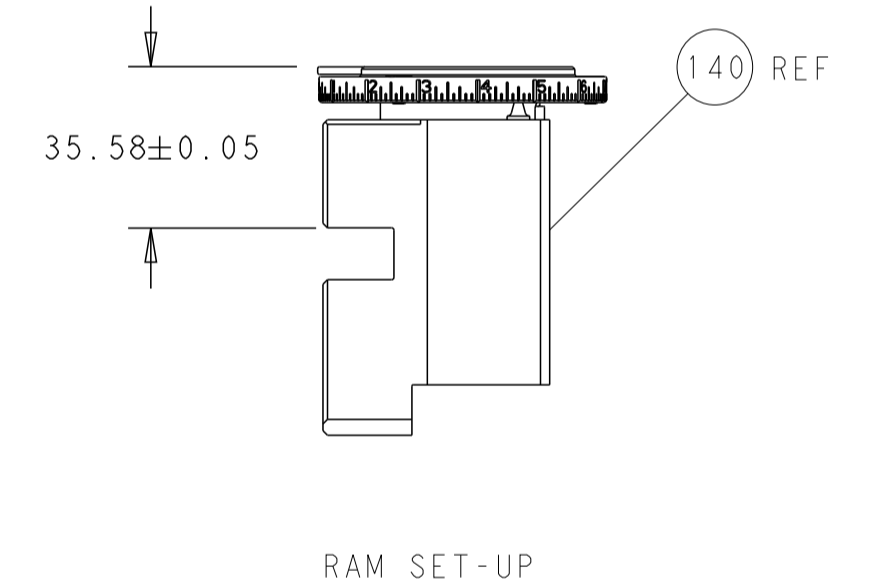
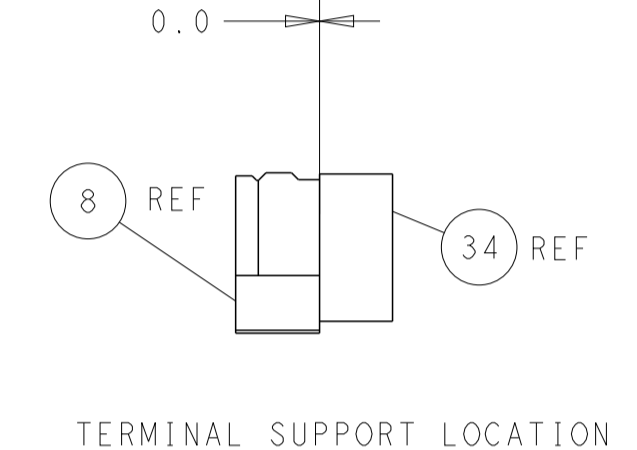
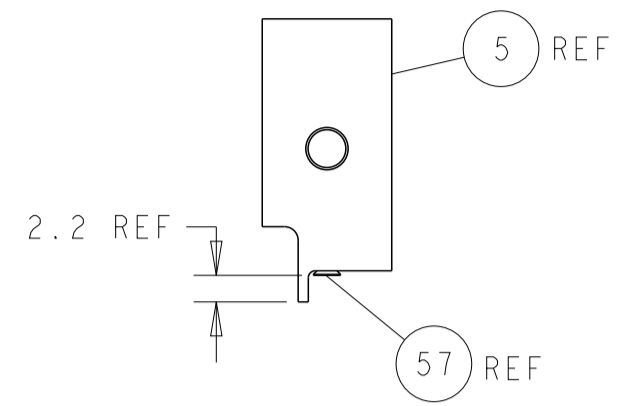
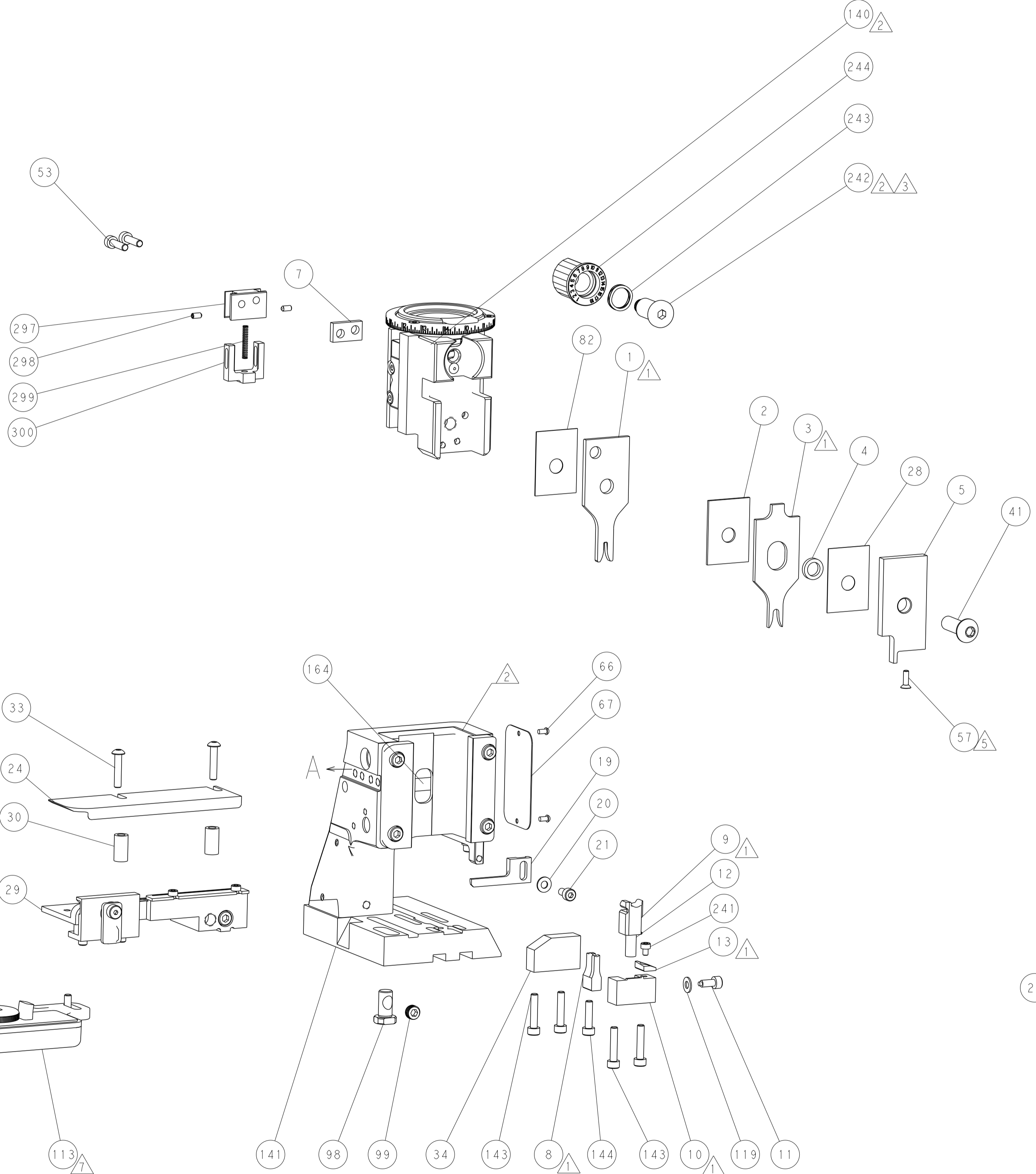
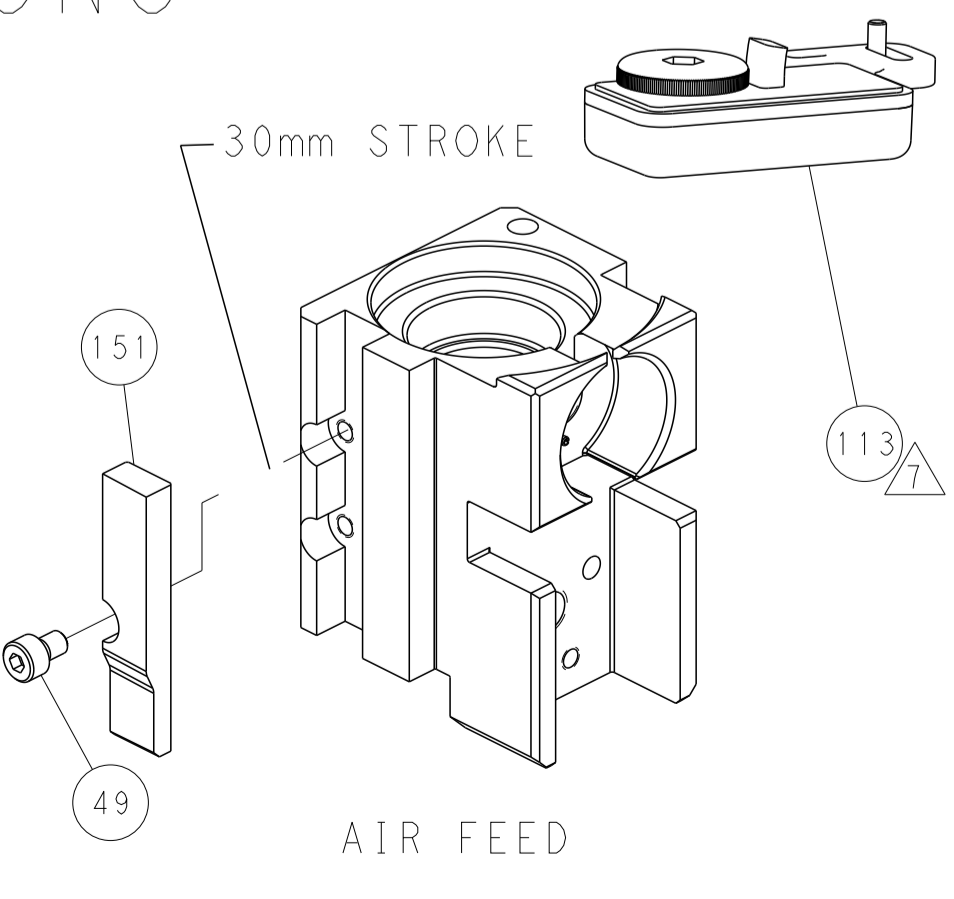
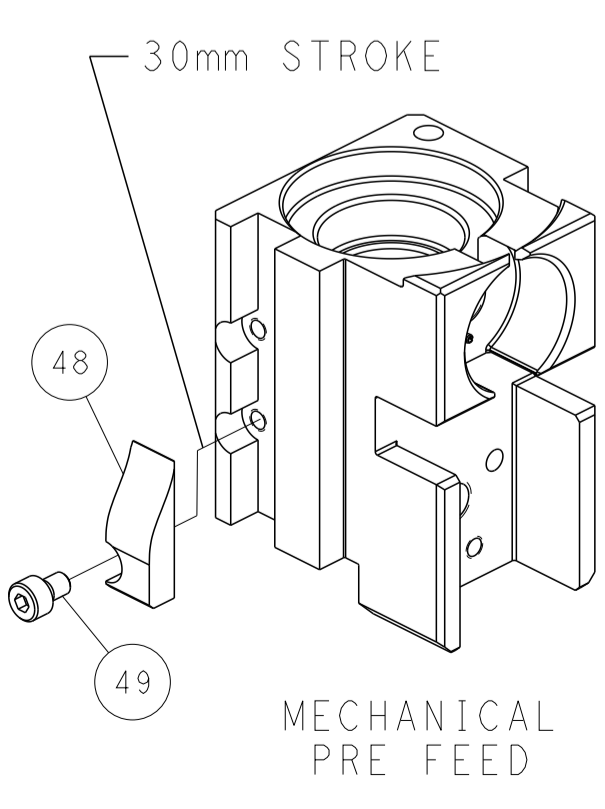
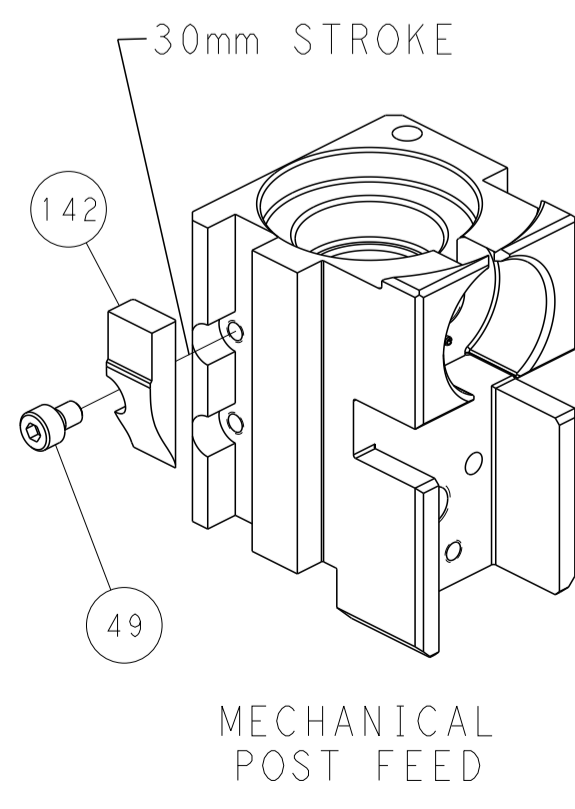
PNEUMATIC



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)

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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 APPLICATION SPEC: - PRODUCT SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151956	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION