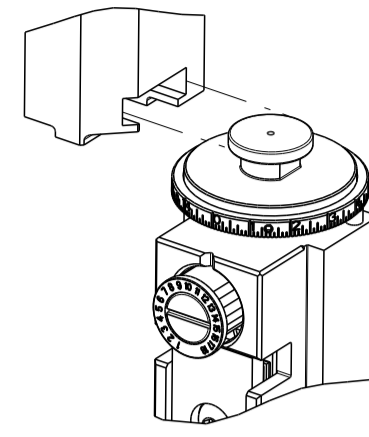


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151314-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151314-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151314-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151314-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151314-*	-	SEE CRIMP TOOLING KITS BELOW	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

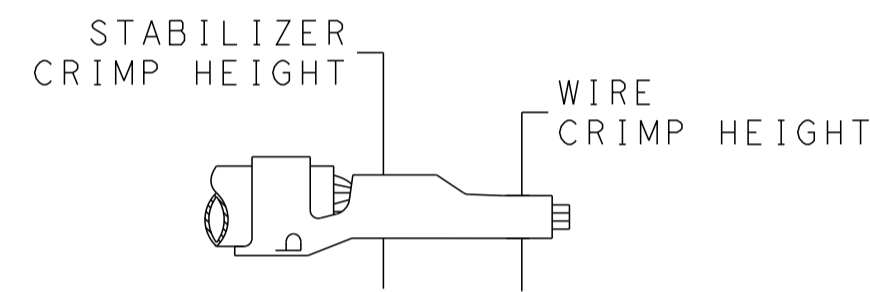


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STABILIZER	2.79 mm [.110]	Ø
INSULATION	3.94 mm [.155]	F

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151314-7	C	12 AWG	7-456408-6	815664-2	6-2119582-7	1633923-5
7-2151314-8	C	14 AWG	2-456408-5	815664-6	6-2119582-7	1633923-5
7-2151314-9	C	18-16 AWG	2-456408-6	815664-7	6-2119582-7	1633923-5

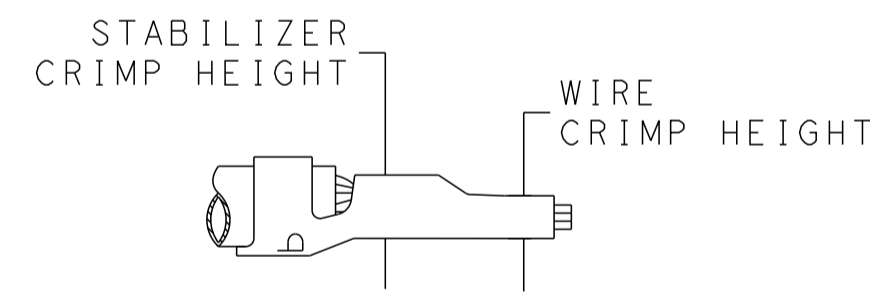
APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		



WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.16 +/- 0.05 [.085 +/- .002]	7-456408-6	2.79 +/- 0.05 [.110 +/- .002]	815664-2	9.1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		



WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40 +/- 0.05 [.055 +/- .002]	2-456408-5	2.75 +/- 0.10 [.108 +/- .004]	815664-6	7.6
18-16 AWG	1.09 +/- 0.05 [.043 +/- .002]	2-456408-6	2.40 +/- 0.10 [.094 +/- .004]	815664-7	7.8

- 7 ITEMS 255 & 256 TO BE USED WITH 18-16 AWG ONLY. APPLICATOR TO BE SET UP WITH THESE ITEMS.
- 8 POSITION ITEM 19 BETWEEN ITEMS 1 AND 3.
- 9. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.



- 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 ITEMS 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.
- ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

**\*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	REV	DATE	DESCRIPTION	DATE	OWN	APVD
		C	09MAY2016	ECR-16-005909		KH	LZ
		D	19APR2018	ECR-18-005882		FZ	KZ
		D1	21MAR2019	ECR-19-004559		TB	GB
		E	21JUL2021	ECR-21-006983		TB	RK

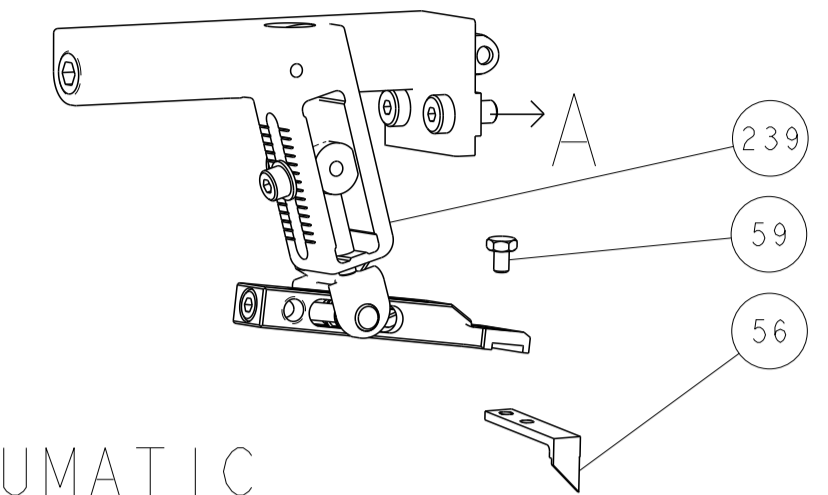
1	-	-	1	1	1	1	2-456408-6	CRIMPER, WIRE PREMIUM	256
1	-	-	1	1	1	1	815664-7	CRIMPER, WIRE-O	255
1	-	1	1	1	1	1	2-456408-5	CRIMPER, WIRE PREMIUM	254
1	-	1	1	1	1	1	815664-6	CRIMPER, WIRE-O	253
-	-	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	-	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
5	1	-	1	1	1	1	7-456408-6	CRIMPER, WIRE PREMIUM	178
-	-	-	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
-	-	-	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	469465-4	STOP, WIRE	34
-	-	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	2	2	2	2	2-2844962-8	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	2119533-3	STRIPPER, SIDE FEED	19
1	-	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	2	2	1	1	1633923-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	-	-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	2	2	1	1	6-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	-	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
5	1	1	2	2	1	1	815664-2	CRIMPER, WIRE-O	1

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

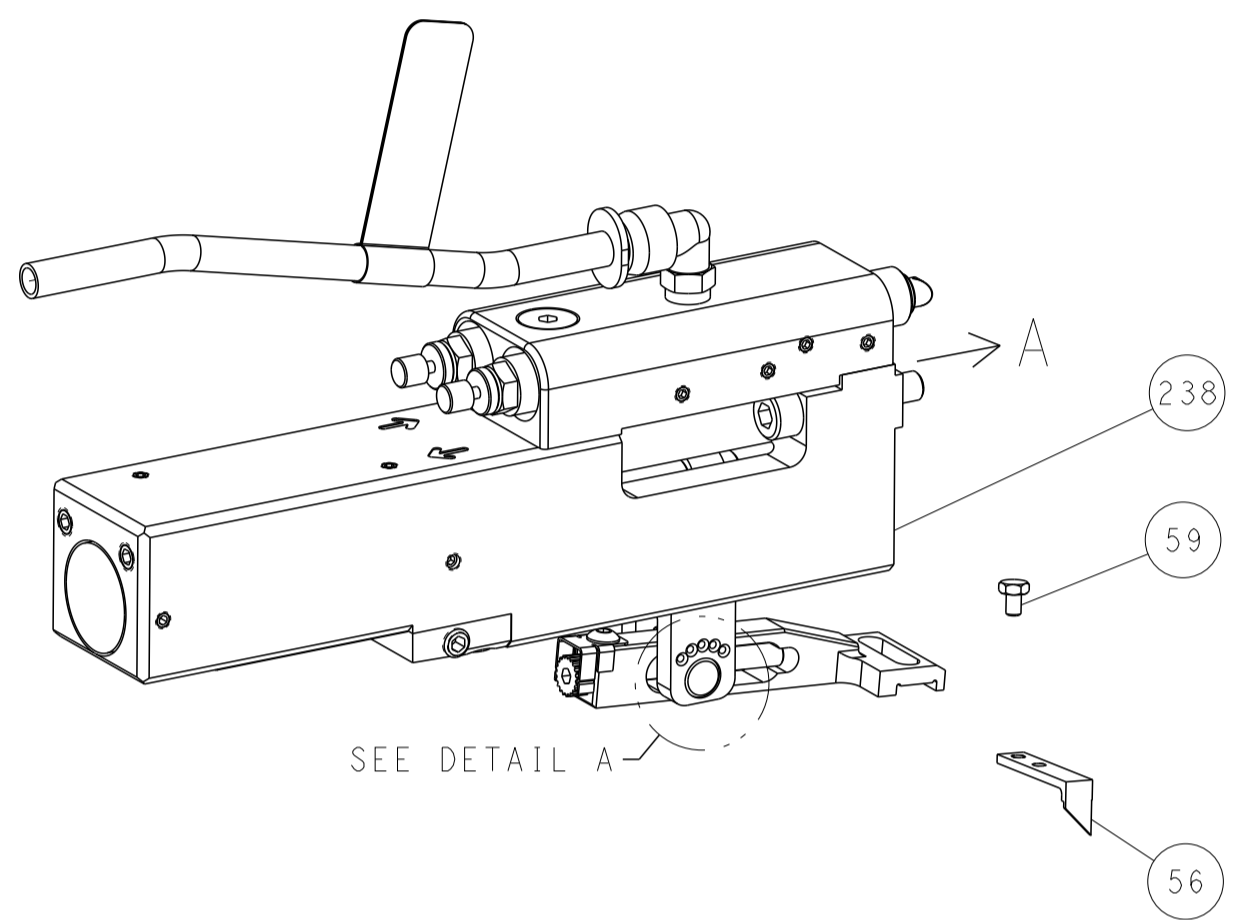
PART NO		DESCRIPTION		ITEM NO
-79	-78	-77	-72	-71
-2	-1	PART NO		DESCRIPTION
DWN		31JAN2013		
CHK		31JAN2013		
APVD		31JAN2013		
M. CLIFFORD		NAME		
		Ocean Side Feed		
		Applicator		
SIZE		CAGE CODE		DRAWING NO
A1		00779		2151314
Customer Accessible Production Drawing		SCALE		1:2
		SHEET		1 of 4
		REV		E

LOC	DIST	REV	DATE	BY	APPV
A	66				

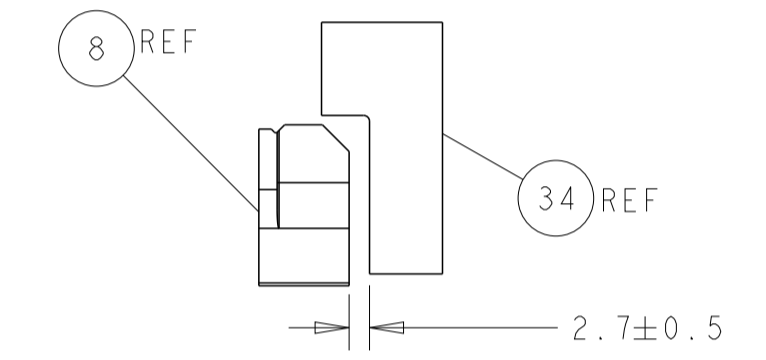
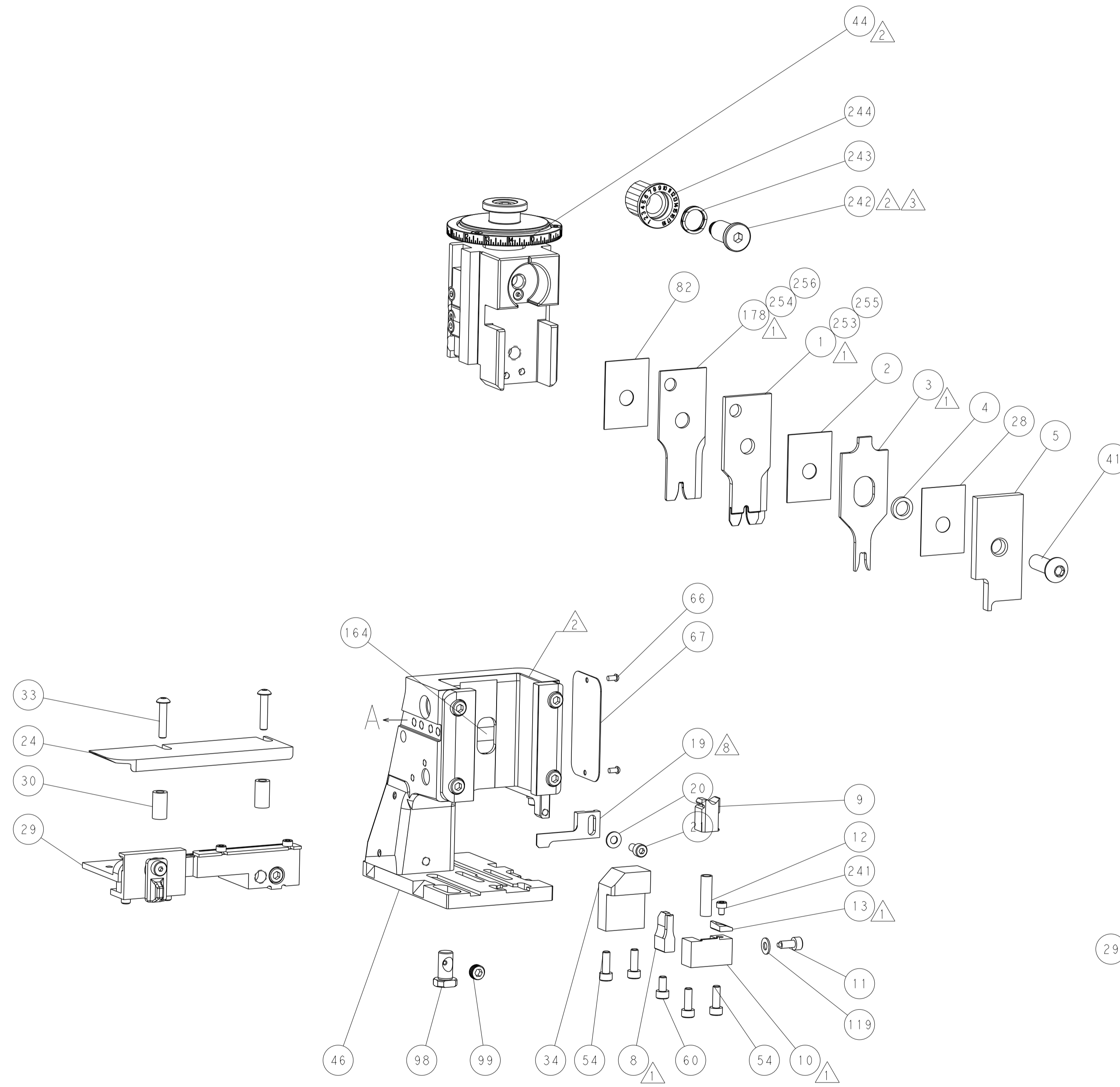
# FEED TYPE MECHANICAL



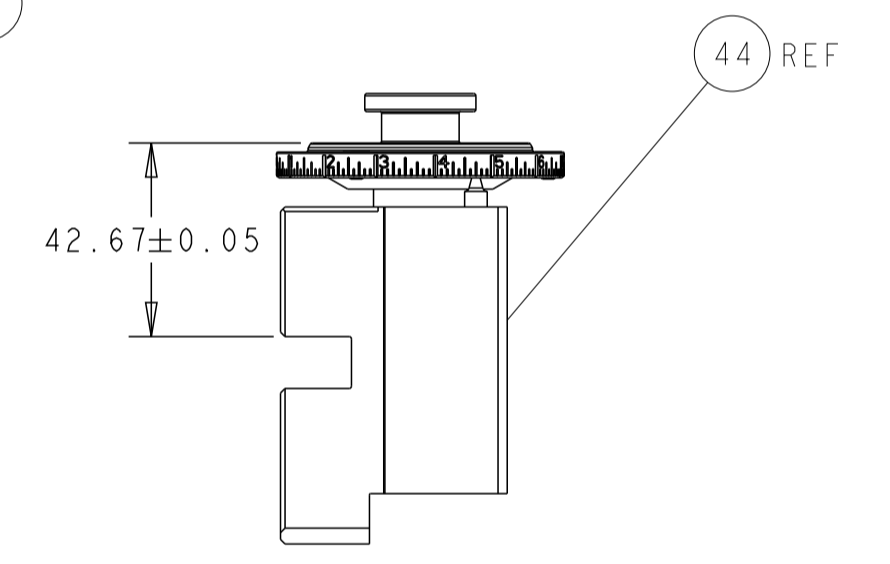
## PNEUMATIC



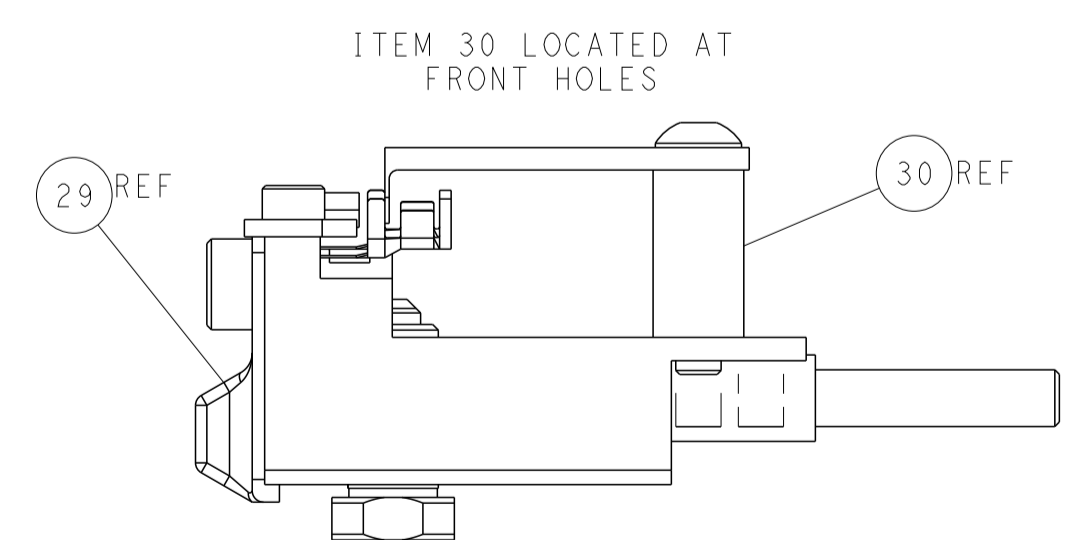
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



WIRE STOP LOCATION

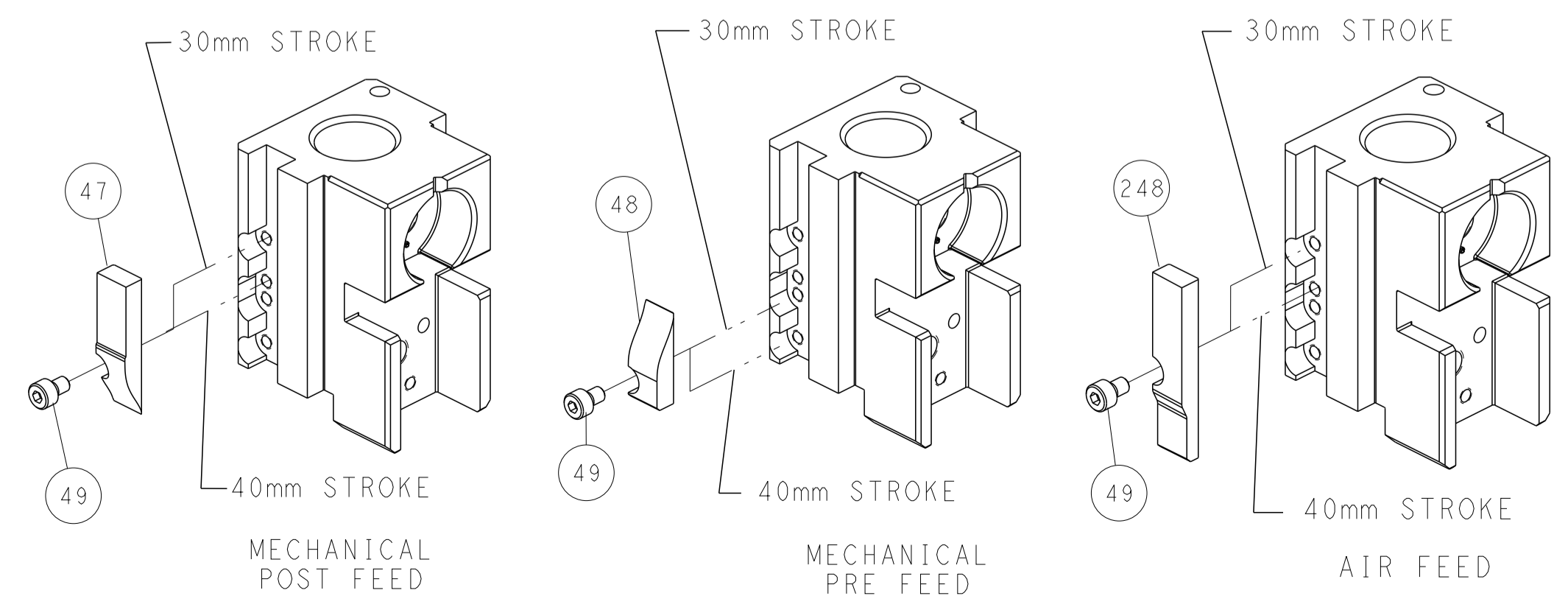


RAM SET-UP



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN L. GROSS 31JAN2013 CHK T. ELBIN 31JAN2013 APVD M. CLIFFORD 31JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151314 SCALE 1:2 SHEET 2 OF 4 REV E	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151314-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151314-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151314-*	-	SEE CRIMP TOOLING KITS BELOW	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

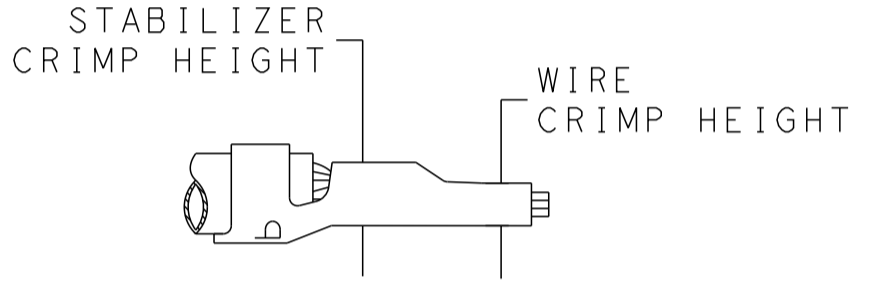


APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STABILIZER	2.79 mm [.110]	O
INSULATION	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS  
408-35042

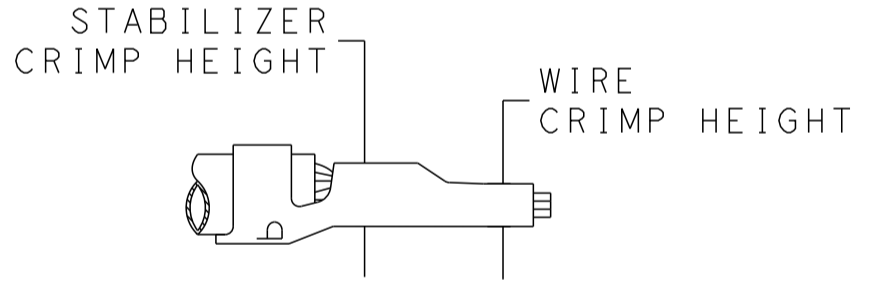
PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151314-7	C	12 AWG	7-456408-6	815664-2	6-2119582-7	1633923-5
7-2151314-8	C	14 AWG	2-456408-5	815664-6	6-2119582-7	1633923-5
7-2151314-9	C	18-16 AWG	2-456408-6	815664-7	6-2119582-7	1633923-5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		∅2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-794013-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.16+/-0.05 [.085+/- .002]	7-456408-6	2.79+/-0.05 [.110+/- .002]	815664-2	9.1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		∅2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-770060-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/- .002]	2-456408-5	2.75+/-0.10 [.108+/- .004]	815664-6	7.6
18-16 AWG	1.09+/-0.05 [.043+/- .002]	2-456408-6	2.40+/-0.10 [.094+/- .004]	815664-7	7.8

- ⚠ ITEMS 255 & 256 TO BE USED WITH 18-16 AWG ONLY. APPLICATOR TO BE SET UP WITH THESE ITEMS.
- ⚠ POSITION ITEM 19 BETWEEN ITEMS 1 AND 3.
- 9. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.



- 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 ITEMS 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 ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ⑥ ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

**\*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	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

7-1	1	-	-	1	1	2-456408-6	CRIMPER, WIRE PREMIUM	256
7-1	1	-	-	1	1	815664-7	CRIMPER, WIRE-O	255
6-1	-	1	-	1	1	2-456408-5	CRIMPER, WIRE PREMIUM	254
6-1	-	1	-	1	1	815664-6	CRIMPER, WIRE-O	253
-	-	-	-	1	1	2119082-6	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	-	2844940-1	AIR FEED MODULE	238
5-1	-	-	1	1	1	7-456408-6	CRIMPER, WIRE PREMIUM	178
-	-	-	-	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	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
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	-	1	1	469465-4	STOP, WIRE	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	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	2119533-3	STRIPPER, SIDE FEED	19
1	-	-	-	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	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1633923-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	-	-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	-	-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	6-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	1	1	455888-7	SPACER, CRIMPER	2
5-1	-	-	-	1	1	815664-2	CRIMPER, WIRE-O	1

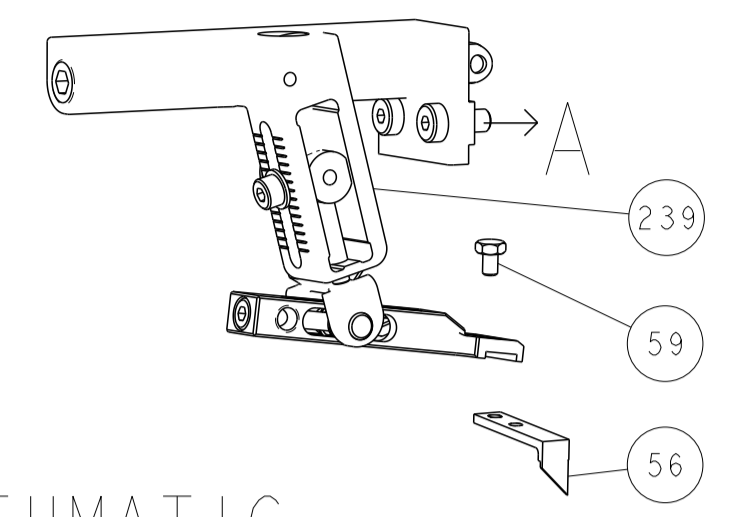
ITEM NO	PART NO	DESCRIPTION	ITEM NO				
-79	-78	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DWN	31JAN2013	TE Connectivity
mm	0 PLC ±	EL GROSS	31JAN2013	Harrisburg, PA 17105-3608
1 PLC ±	1 PLC ±	T. ELBIN	31JAN2013	
3 PLC ±	3 PLC ±	M. CLIFFORD	31JAN2013	
4 PLC ±	4 PLC ±			
ANGLES	FINISH			
MATERIAL				

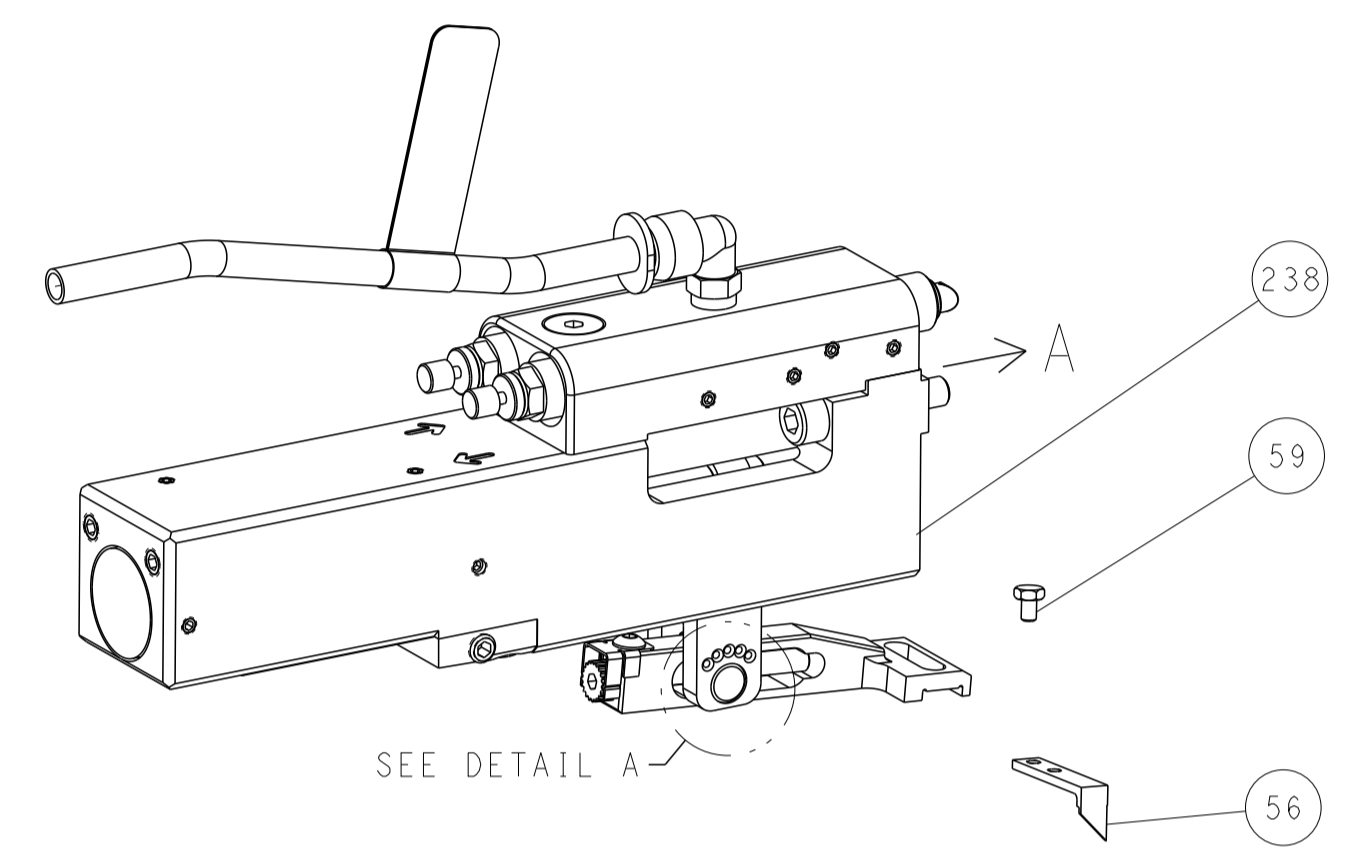
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151314	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 3 OF 4 REV E

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

# FEED TYPE MECHANICAL



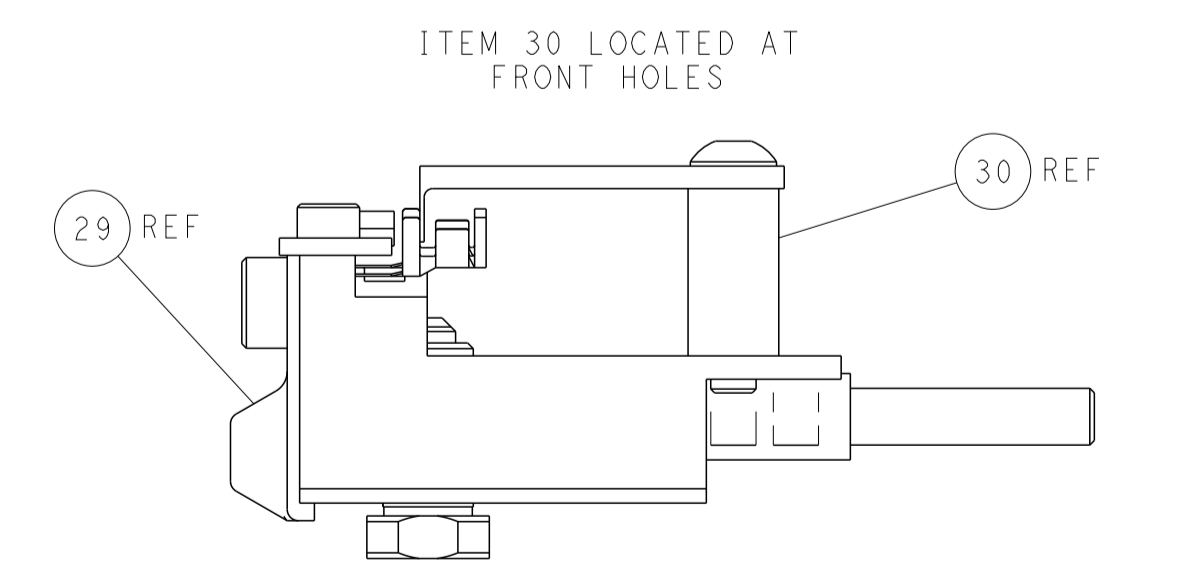
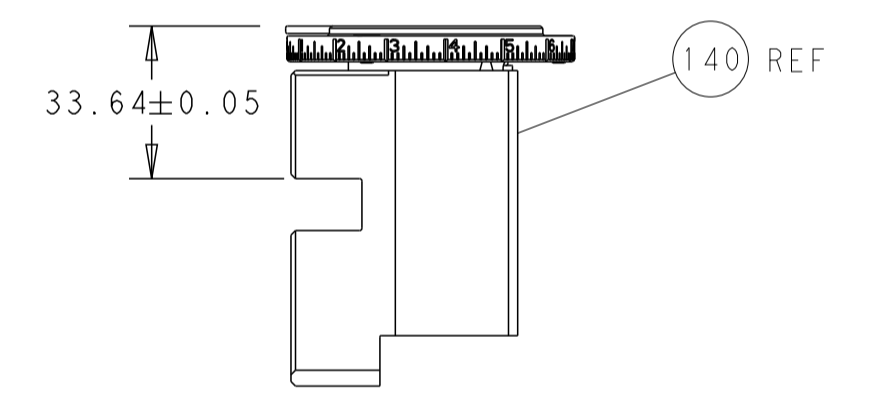
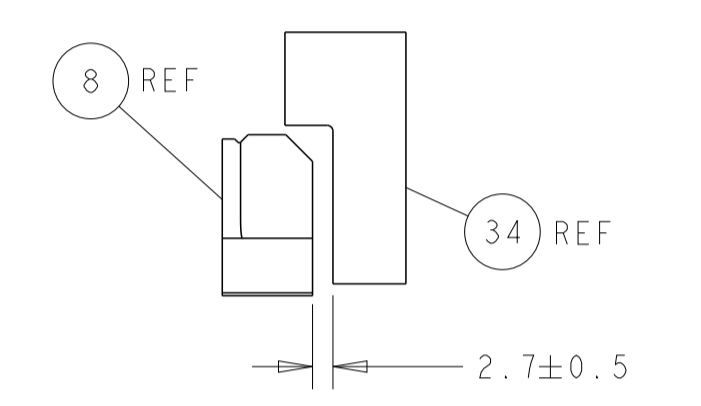
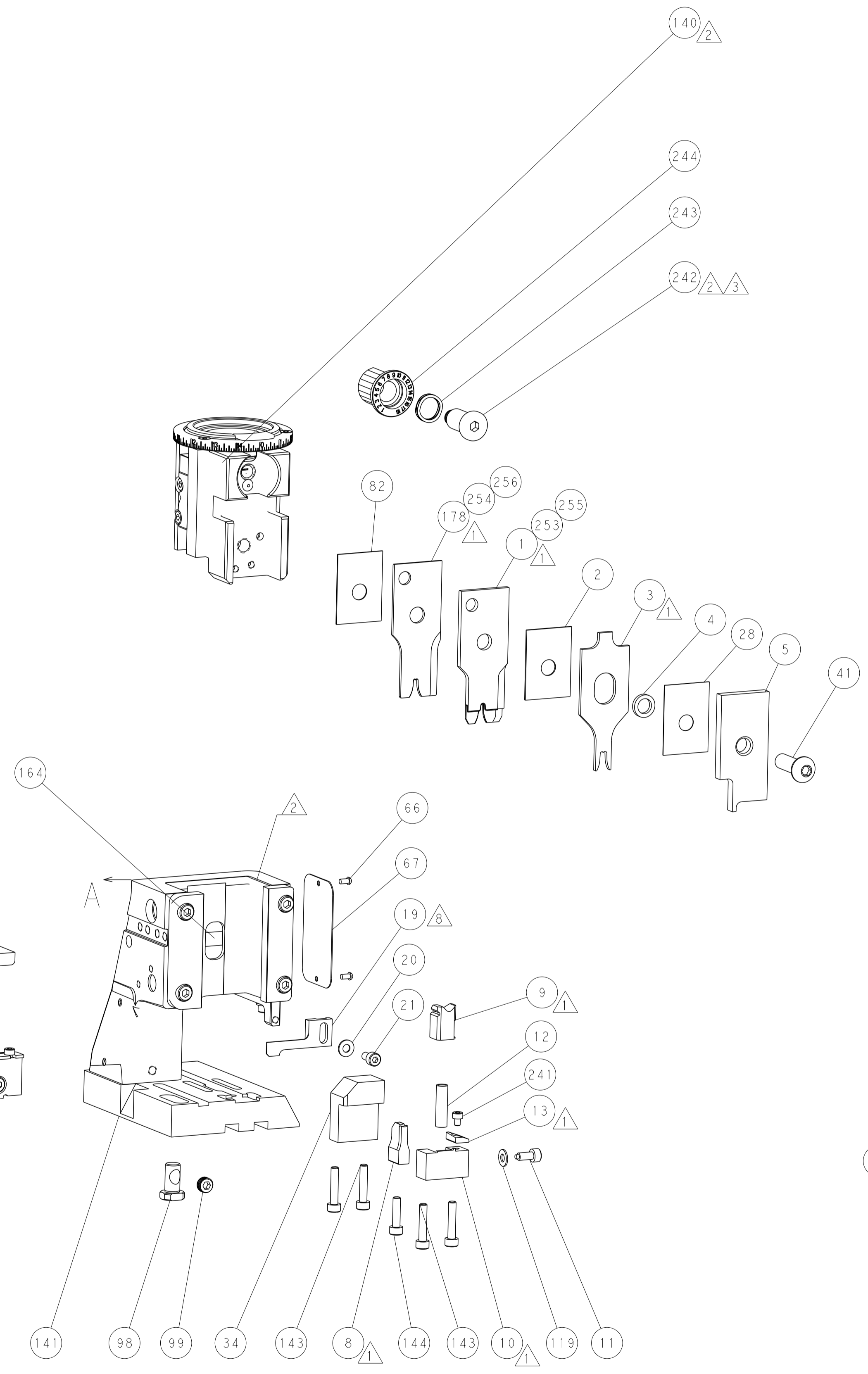
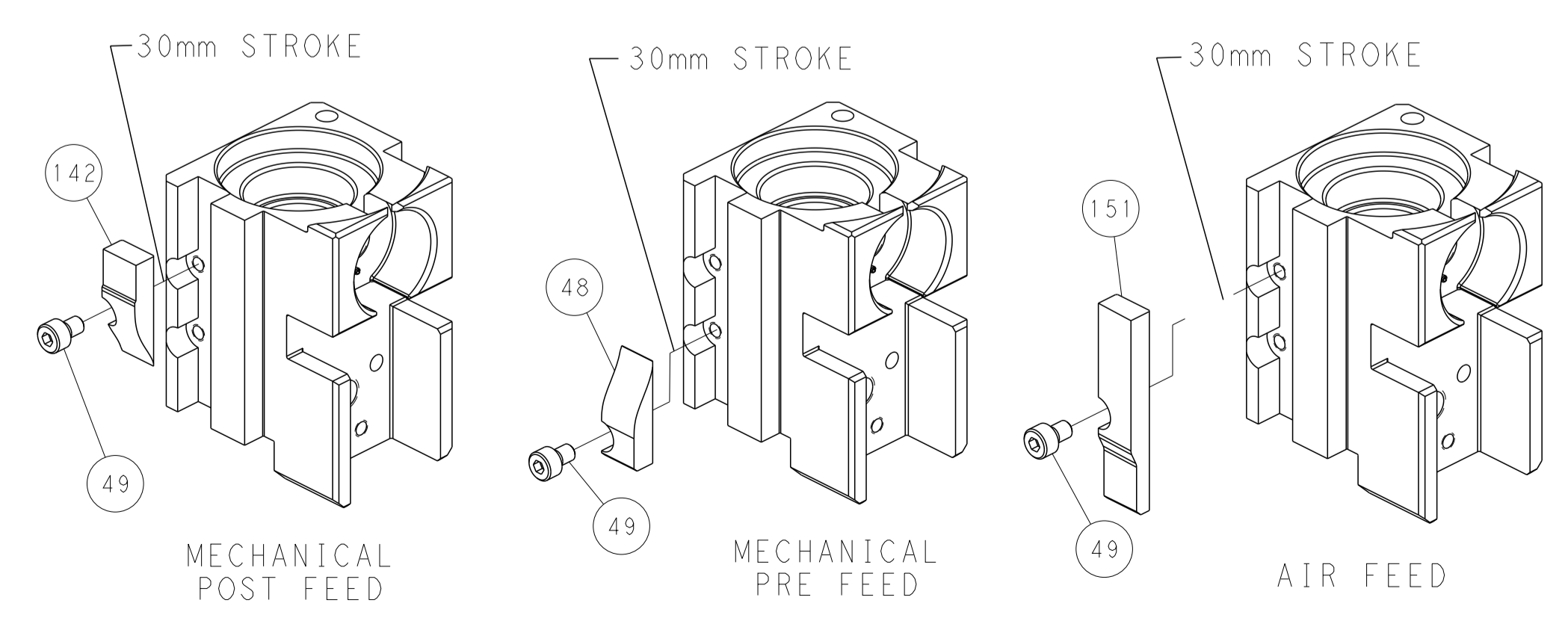
## PNEUMATIC



## 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)

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DIMENSIONS: mm		CHK T. ELBIN 31 JAN 2013	TE Connectivity Harrisburg, PA 17105-3608
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD M. CLIFFORD PRODUCT SPEC	APPLICATION SPEC
MATERIAL:		WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151314
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2	SHEET 4 OF 4 REV E