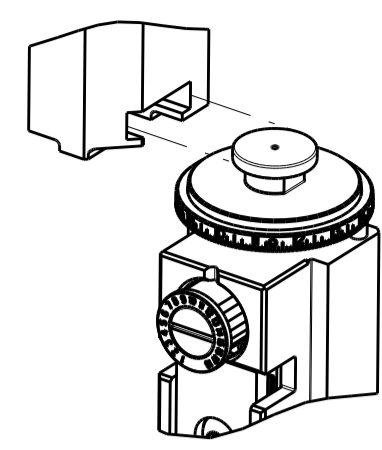


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2836023-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2836023-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836023-1 | B | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2836023-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2836023-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.50 mm [.059] | F |
| INSUL | 2.72 mm [.107] | O |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: KET TERMINAL | | KET CRIMP SPECIFICATION | |
|------------------------------------|------------------------------|-------------------------|--|
| TERMINAL NAME: TERMINAL, 91 RK REC | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.00-4.50 mm [.157-.177 IN] | Ø1.40-2.20 mm [.055-.087 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | KET Rev 2004.06.21 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | KET TERMINAL | TE SEAL | KET SEAL |
| 2113889-1 | ST730924-3 | 2113890-1 | MG682620 |
| | | | SEAL INSULATION DIAMETER RANGE Ø1.4-1.7 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------|-------------------------------|--------------------------------|
| AVSS 0.5mm ² | 0.95 +/- 0.05 [.037 +/- .002] | 8.2 |
| AEXF 0.5mm ² | 0.95 +/- 0.05 [.037 +/- .002] | 7.9 |
| AVSS 0.3mm ² | 0.85 +/- 0.05 [.033 +/- .002] | 9.2 |

- △ 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.
- △ 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)

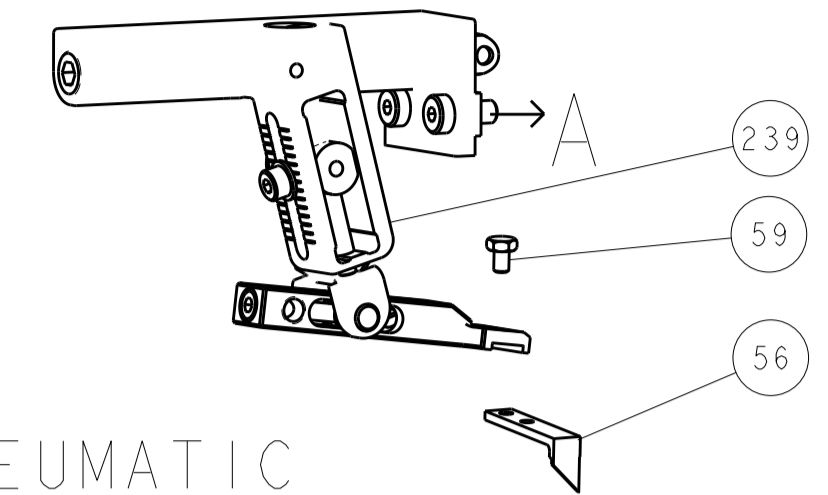
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| | | A | | RELEASED | 03NOV2015 | GH | GB |
| | | B | | ECR-20-012913 | 14SEP2020 | FJ | TE |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 1 | 1 | 2119082-3 | 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 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 1 | 1 | 455888-6 | 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 | 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 | 1752356-1 | 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 | 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 |
| - | 2 | 2 | 2 | 2 | 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 | 7-1803056-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119781-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 2 | 2 | 1 | 1 | 6-1633966-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| 1 | 2 | 2 | 1 | 1 | 8-1633730-0 | CRIMPER, WIRE | 1 |
| - | 77 | -72 | -71 | -2 | -1 | PART NO | ITEM NO |

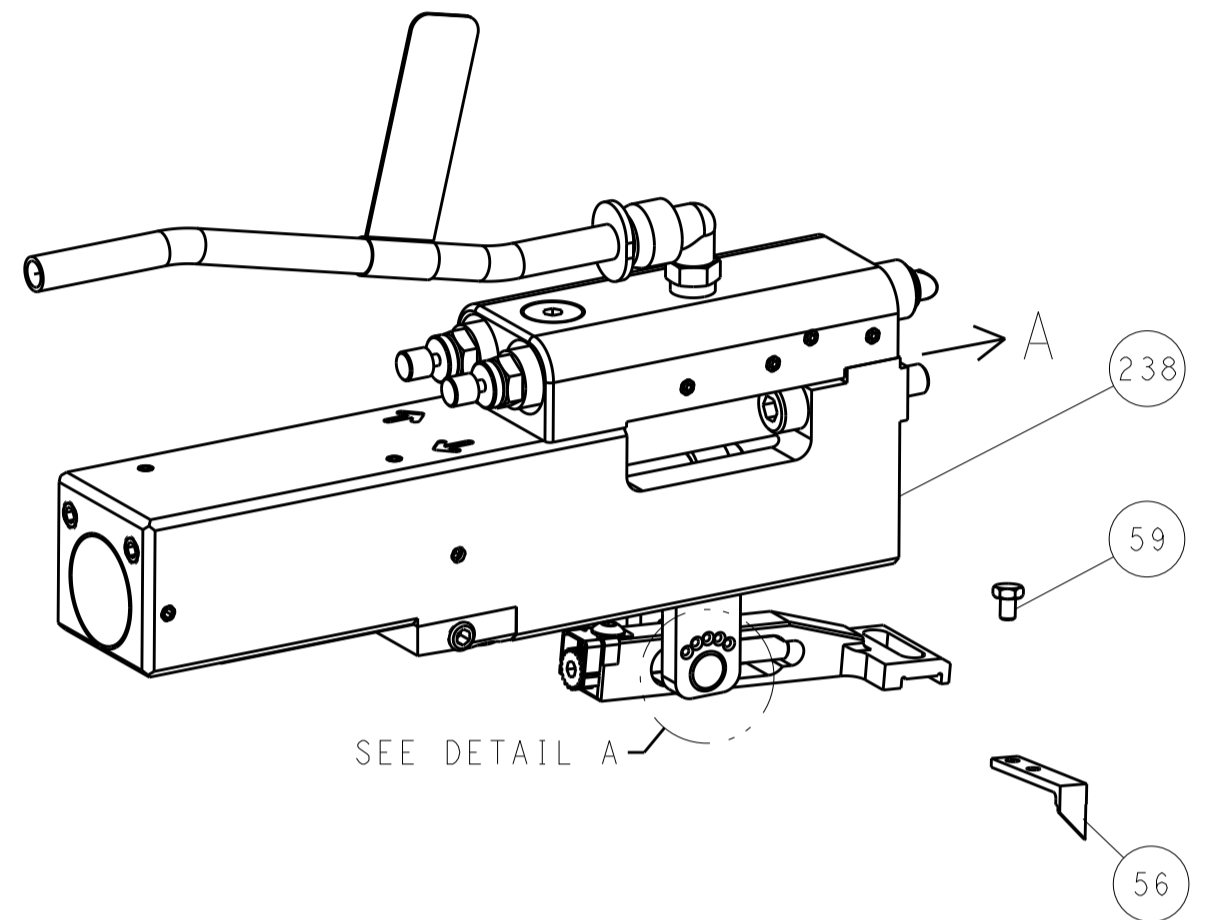
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|-----------------|---------|--|---------|---------------|---------|---------------|--------|---------------|--|---------------|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | | | | |
| APPLICATOR DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | |
| APPLICATOR DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | | TERMINAL DATA | |

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

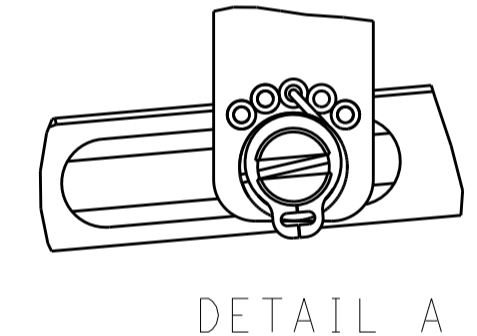
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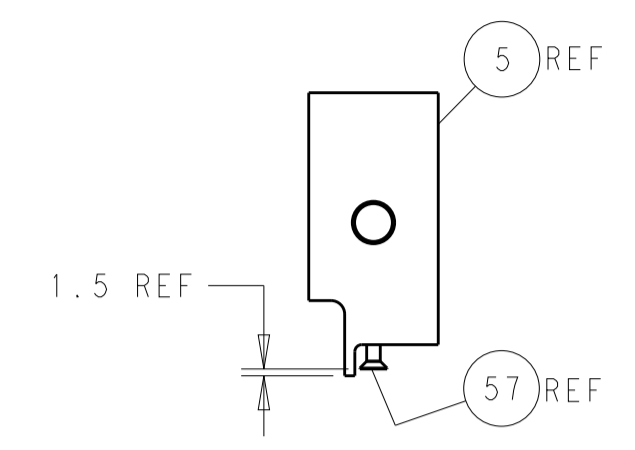
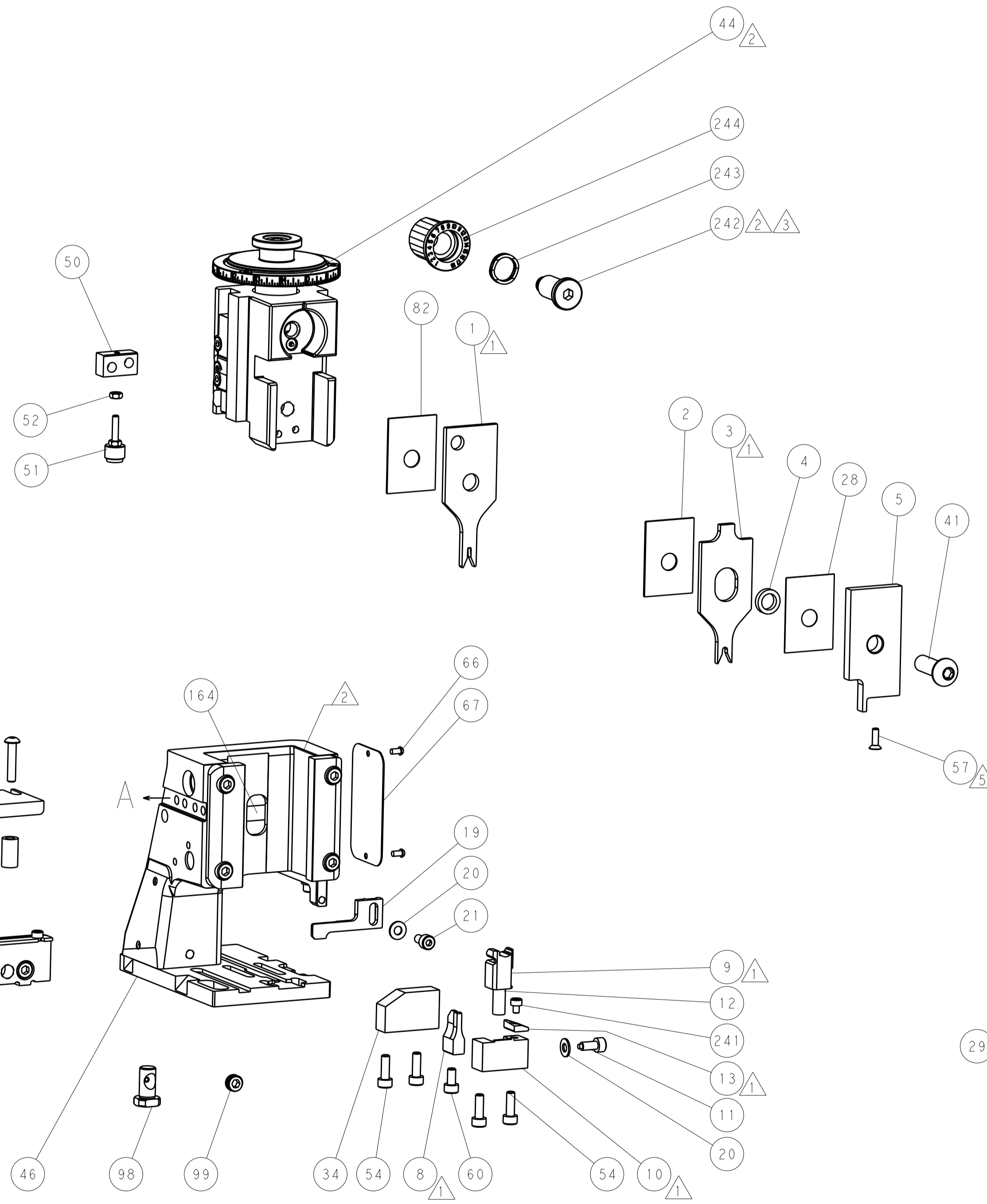
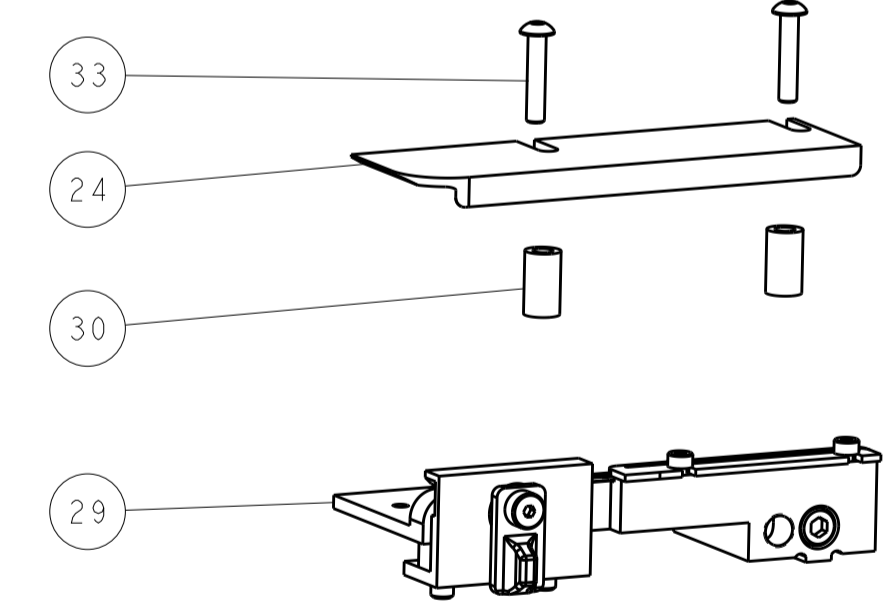
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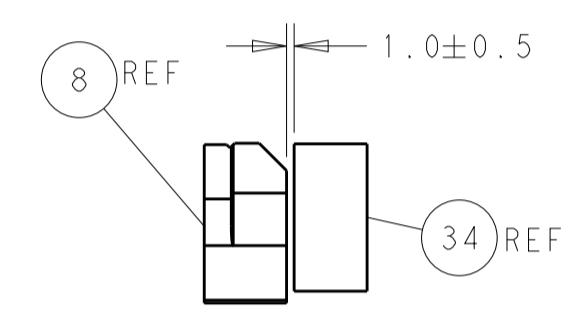
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



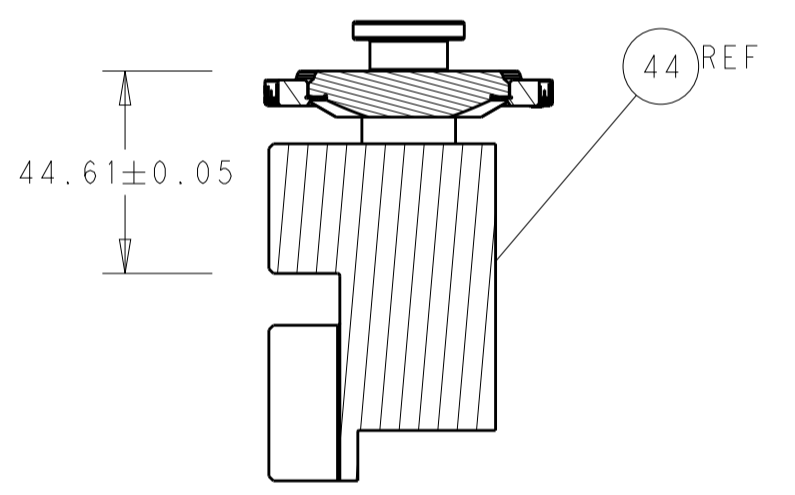
DETAIL A



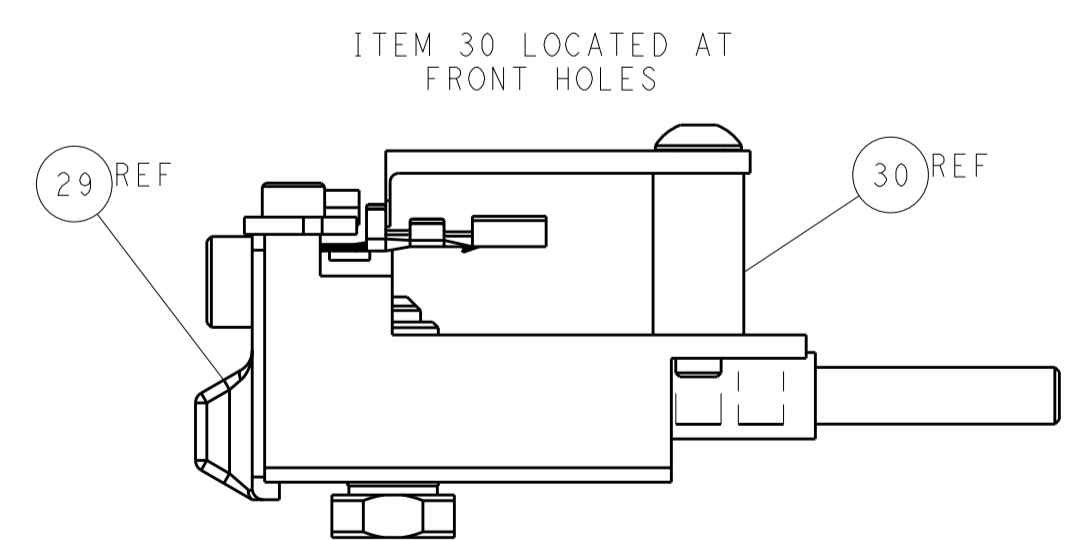
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

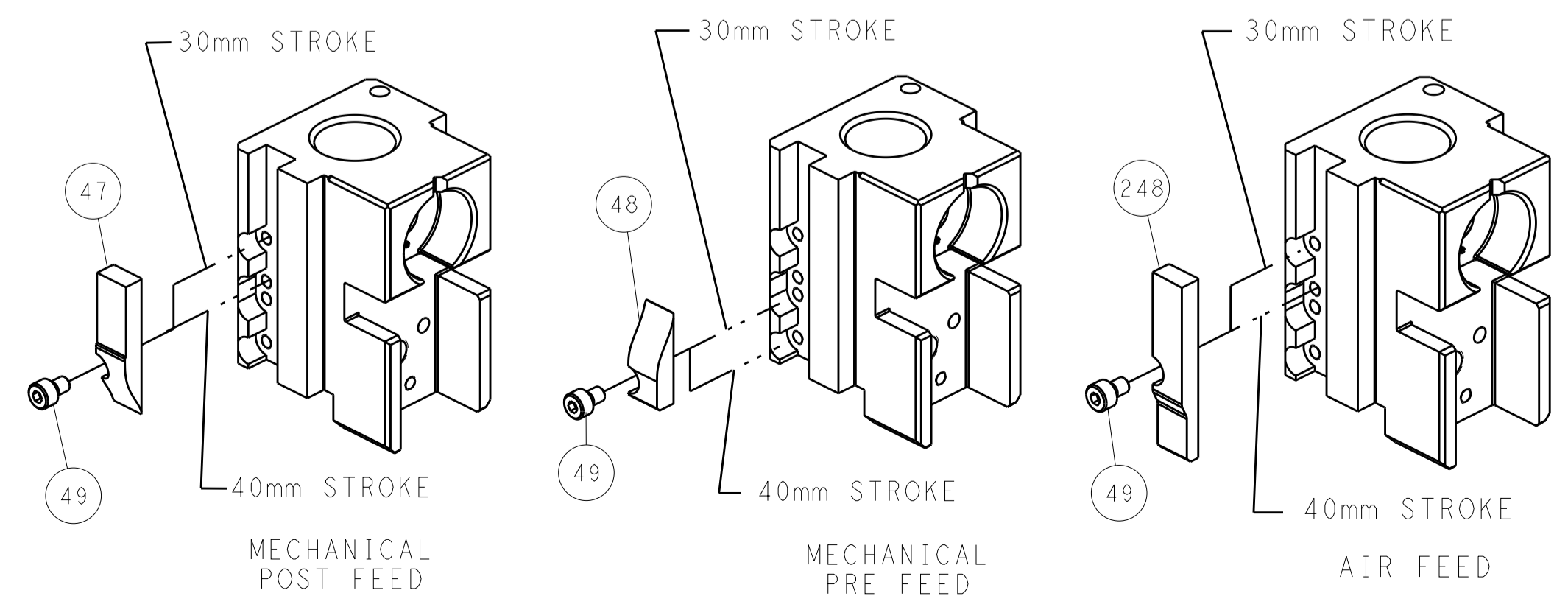


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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: HOFFNER 30SEP2015 CHK: T. ELBIN 01OCT2015 APVD: T. ELBIN 01OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836023 SCALE: 1:2 SHEET: 2 of 4 REV: B | |
|--------------------|--|---|--|---|--|--|--|

| THIS DRAWING IS UNPUBLISHED. | RELEASED FOR PUBLICATION | | |
|--|--------------------------|--------------------------|------------|
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2836023-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2836023-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836023-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

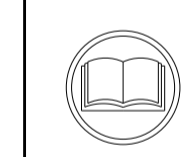


| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.50 mm [.059] | F |
| INSUL | 2.72 mm [.107] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|--|--|---|--|
| TERMINAL DATA: KET TERMINAL | | KET CRIMP SPECIFICATION | |
| TERMINAL NAME: TERMINAL, 91 RK REC | | | |
| WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN] | | INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN] | |
| TERMINAL APPLICATION SPECIFICATION KET Rev 2004.06.21 | | | |

| TERMINALS APPLIED | | | | SEAL INSULATION DIAMETER RANGE |
|-------------------|--------------|-----------|----------|-----------------------------------|
| TE TERMINAL | KET TERMINAL | TE SEAL | KET SEAL | |
| 2113889-1 | ST730924-3 | 2113890-1 | MG682620 | Ø1.4-1.7 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------|----------------------------|-----------------------------------|
| AVSS 0.5mm ² | 0.95+/-0.05 [.037+/-0.002] | 8.2 |
| AEXF 0.5mm ² | 0.95+/-0.05 [.037+/-0.002] | 7.9 |
| AVSS 0.3mm ² | 0.85+/-0.05 [.033+/-0.002] | 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.

***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)

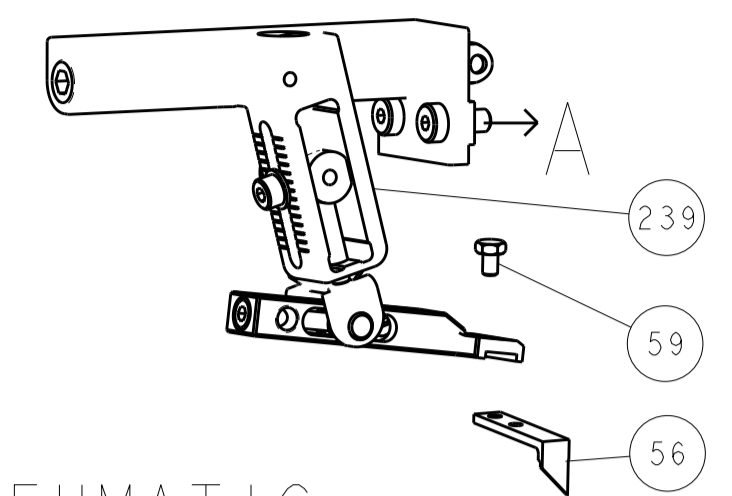
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|-----|------|-----------|-------------|----|------|
| A | 66 | REV | DATE | BY | APPD |
| | | - | SEE SHEET 1 | - | - |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119082-3 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 3 | - | 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 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-6 | 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 |
| 5 | - | 1 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | 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 | 1752356-1 | 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 | 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 |
| - | 2 | 2 | 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 | 1 | 7-1803056-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119781-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 6-1633966-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 8-1633730-0 | CRIMPER, WIRE | 1 |

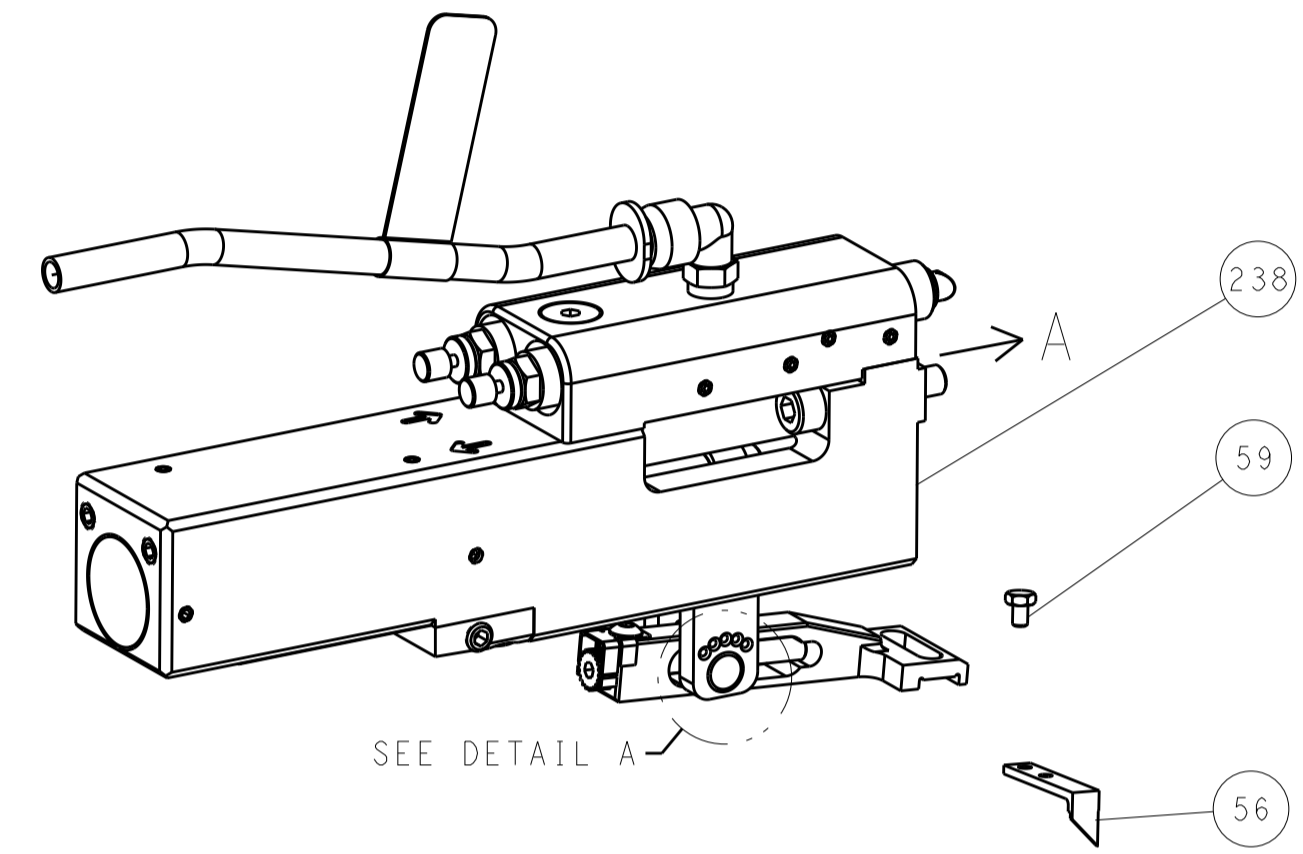
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|-------------|---------|--|---------|------------------------|---------|--|----------------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: HOFFNER 30SEP2015 | | TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | APVD: T. ELBIN 01OCT2015 | NAME: Ocean Side Feed Applicator |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:2 SHEET 3 OF 4 REV B | |

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

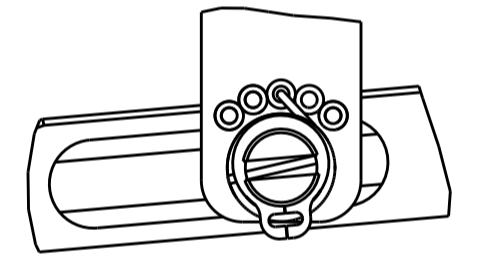
FEED TYPE MECHANICAL



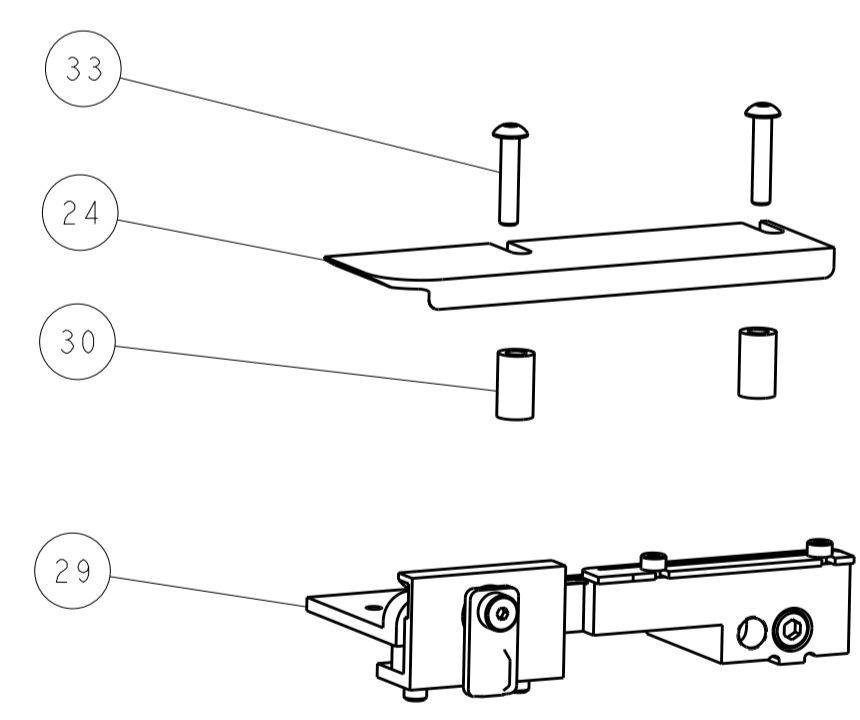
PNEUMATIC



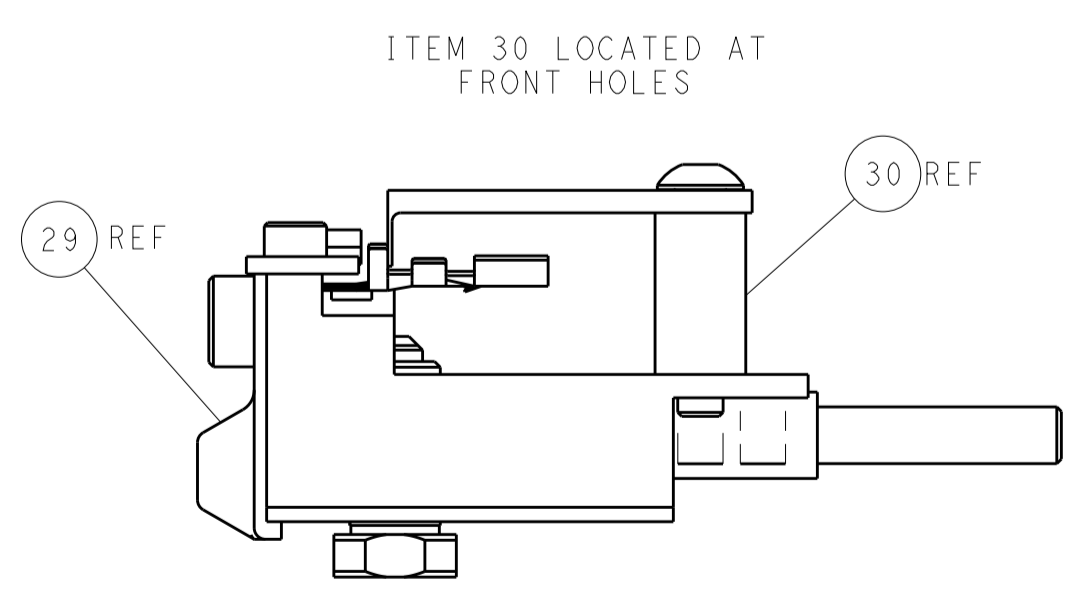
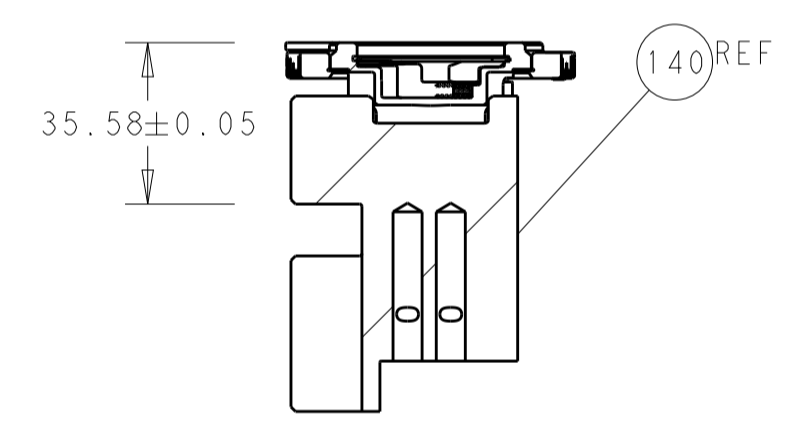
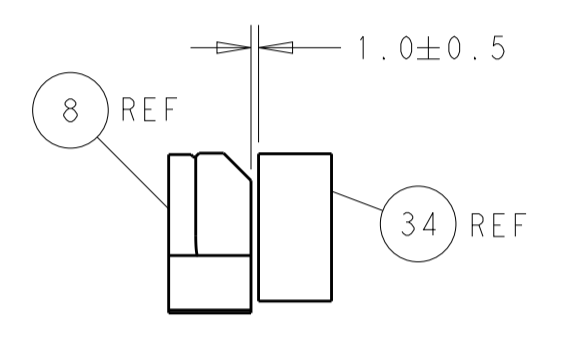
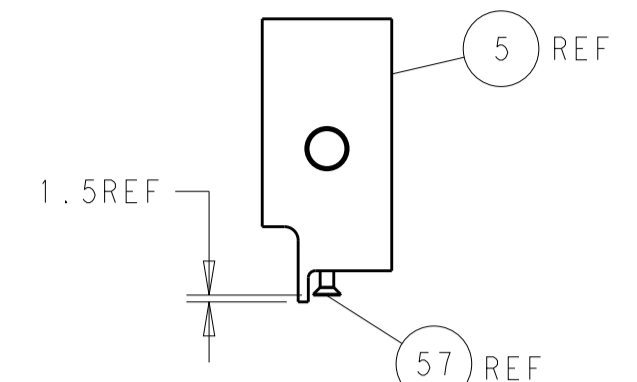
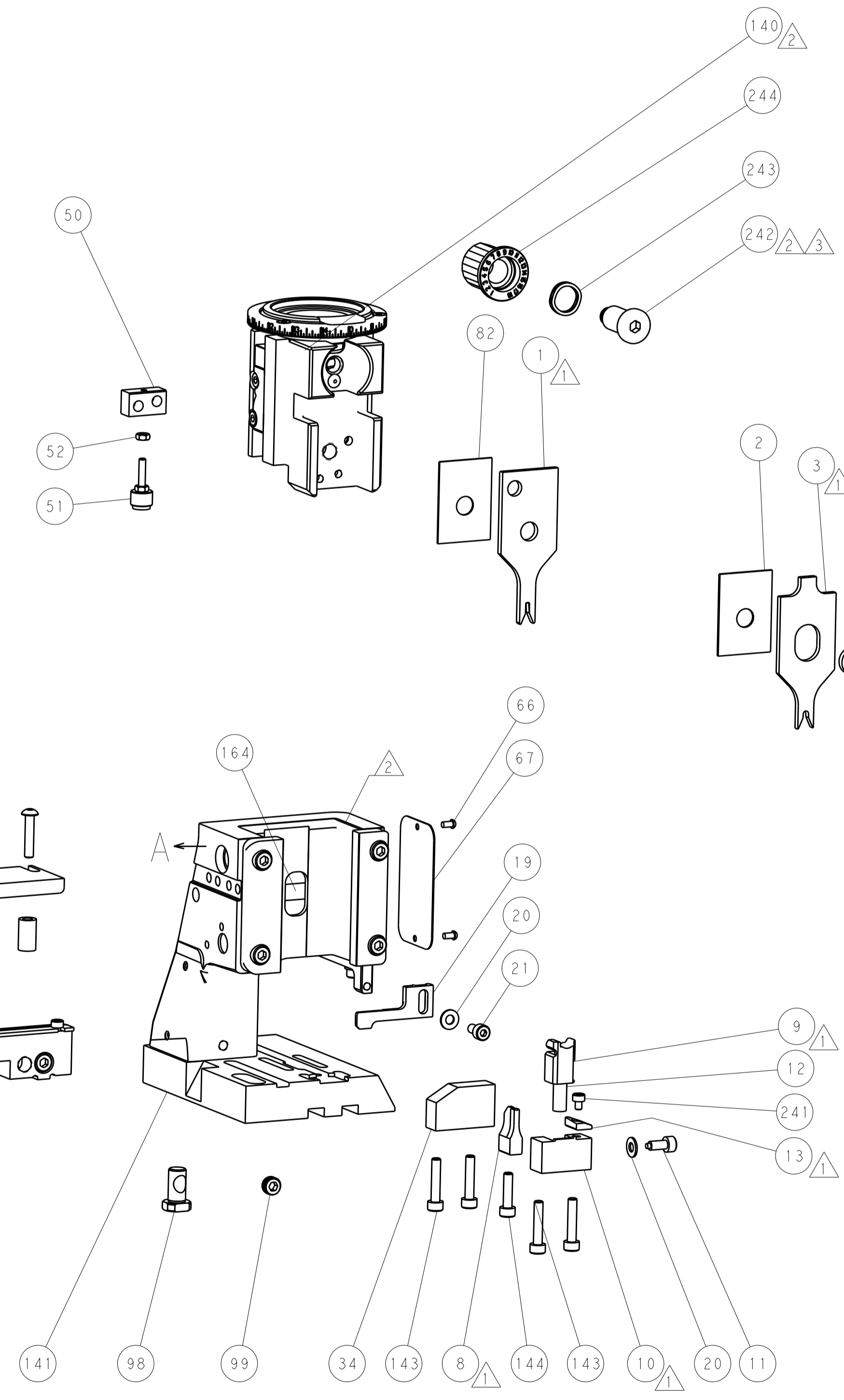
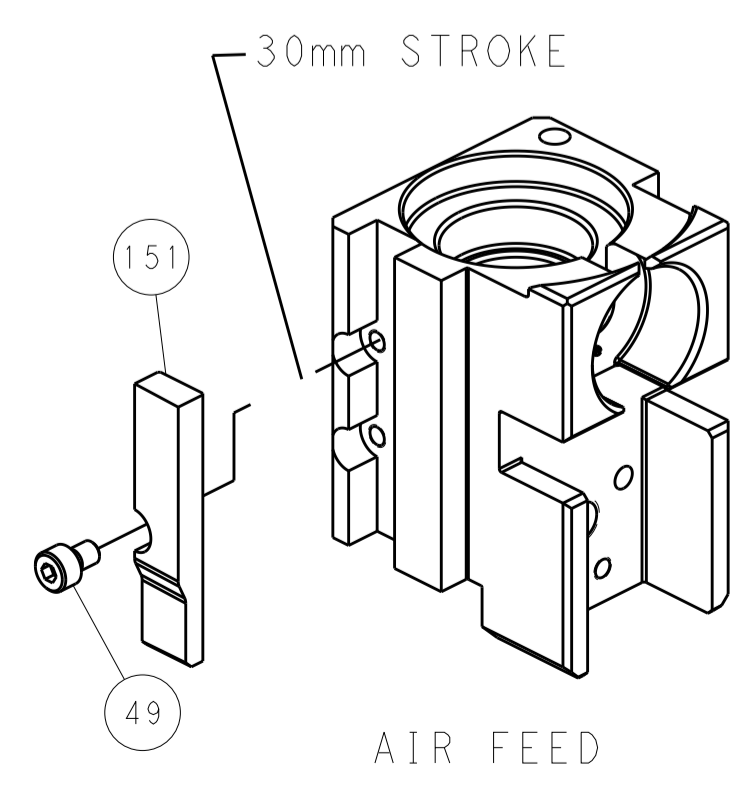
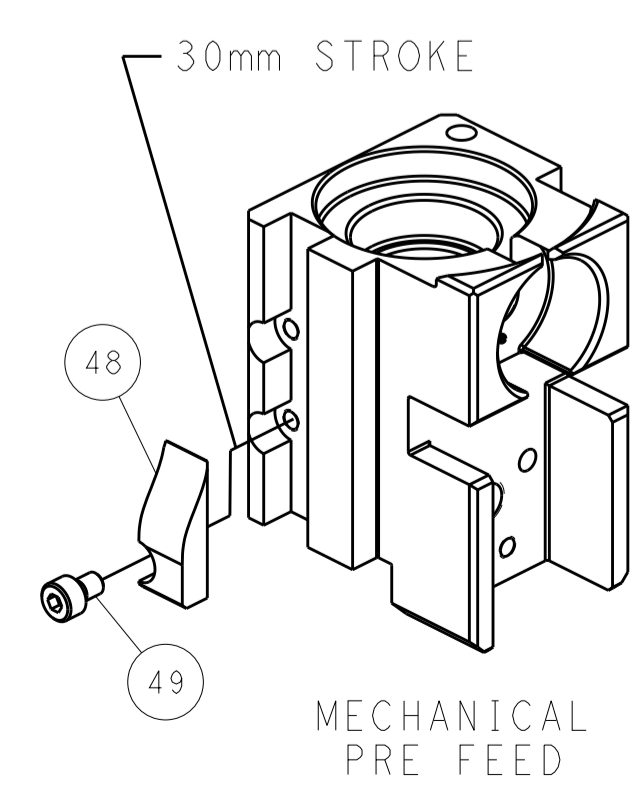
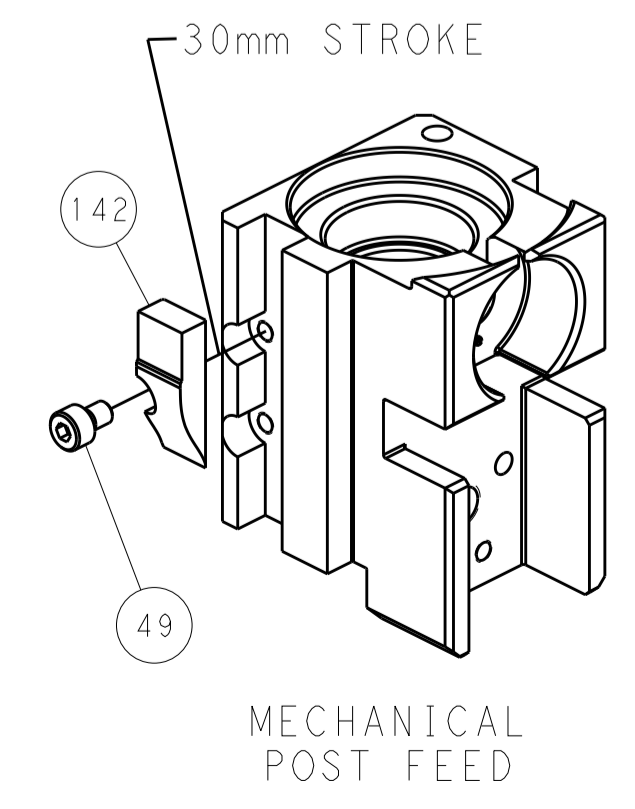
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



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 PRESENCE OF A CONTROL SYMBOL ON THIS DRAWING INDICATES THAT THE DRAWING IS A CONTROL DRAWING. IT IS SUBJECT TO CHANGE TO REFLECT THE LATEST REVISIONS. CHANGES WILL BE CONTACTED FOR THE LATEST POSITION.</small> | | DWN: HOFFNER 30SEP2015 CHK: T. ELBIN 01OCT2015 APVD: T. ELBIN 01OCT2015 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | NAME: Ocean Side Feed Applicator APPLICATION SPEC: | SIZE: CAGE CODE DRAWING NO: A1 00779 ©=2836023 RESTRICTED TO: |
| MATERIAL: FINISH: | | WEIGHT: SCALE: 1:2 SHEET 4 OF 4 REV B | Customer Accessible Production Drawing |