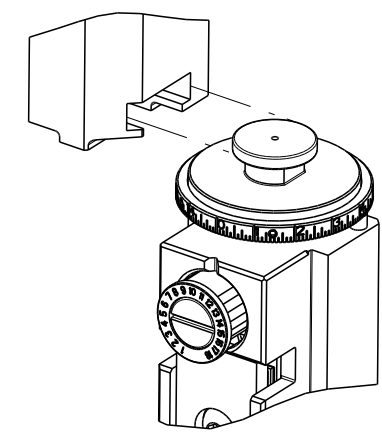


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2836163-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2836163-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836163-1 | B | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2836163-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2836163-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.24 mm [.049] | F |
| INSUL | 1.68 mm [.066] | O |

APPLICATOR INSTRUCTIONS 408-35042

| | | | |
|---|-------------------------------------|------------------------------|-----------------|
| TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION | | | |
| TERMINAL NAME: MALE TERMINAL TTS 1.5 X 0.6 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.48-4.24 mm [.137-.167 IN] | | Ø1.10-1.70 mm [.043-.067 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 15396711 PAGE 5 OF 9 Rev 2014-07-28 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 2113118-1 | 15396711 | 2113118-3 | 13596791 |
| 2113118-2 | 15482338 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2 | 1.05+/-0.03 [.041+/- .001] | 6.0 |
| 0.35mm2 | 0.95+/-0.03 [.037+/- .001] | 6.8 |
| 0.22mm2 | 0.85+/-0.03 [.033+/- .001] | 7.9 |

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

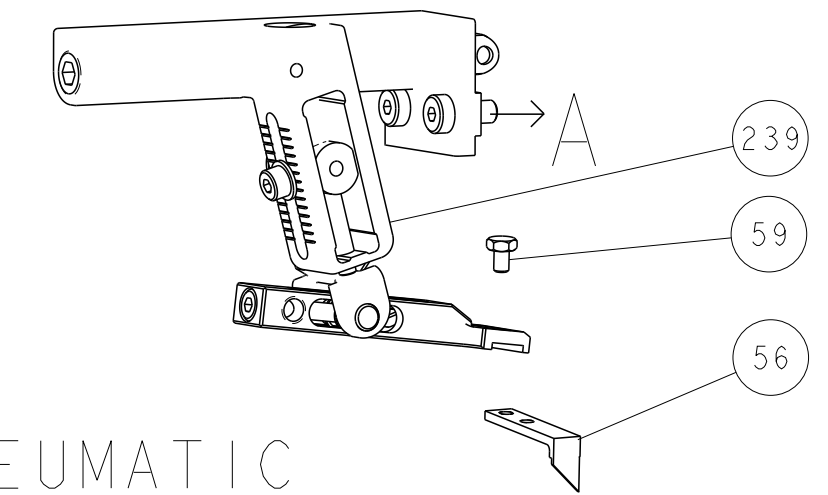
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|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | A | | RELEASED | 04MAR2016 | KH | TE |
| | | B | | ECR-21-004479 | 17APR2021 | TB | RR |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------|---------|
| - | 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 | 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 | 455888-7 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 2 | 2 | 2 | 2 | 2119791-5 | DEPRESSOR, WIRE | 70 | |
| - | 2 | 2 | 2 | 2 | 2119943-1 | WASHER, SPACER | 69 | |
| - | 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 | 1-1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | 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 | 1803095-6 | FLOATING SHEAR, FRONT | 9 | |
| | 1 | 2 | 2 | 1 | 1 | 5-1803055-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| | 1 | 2 | 2 | 1 | 1 | 7-1633966-3 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | - | - | 2 | |
| | 1 | 2 | 2 | 1 | 1 | 7-1633860-5 | CRIMPER, WIRE | 1 |
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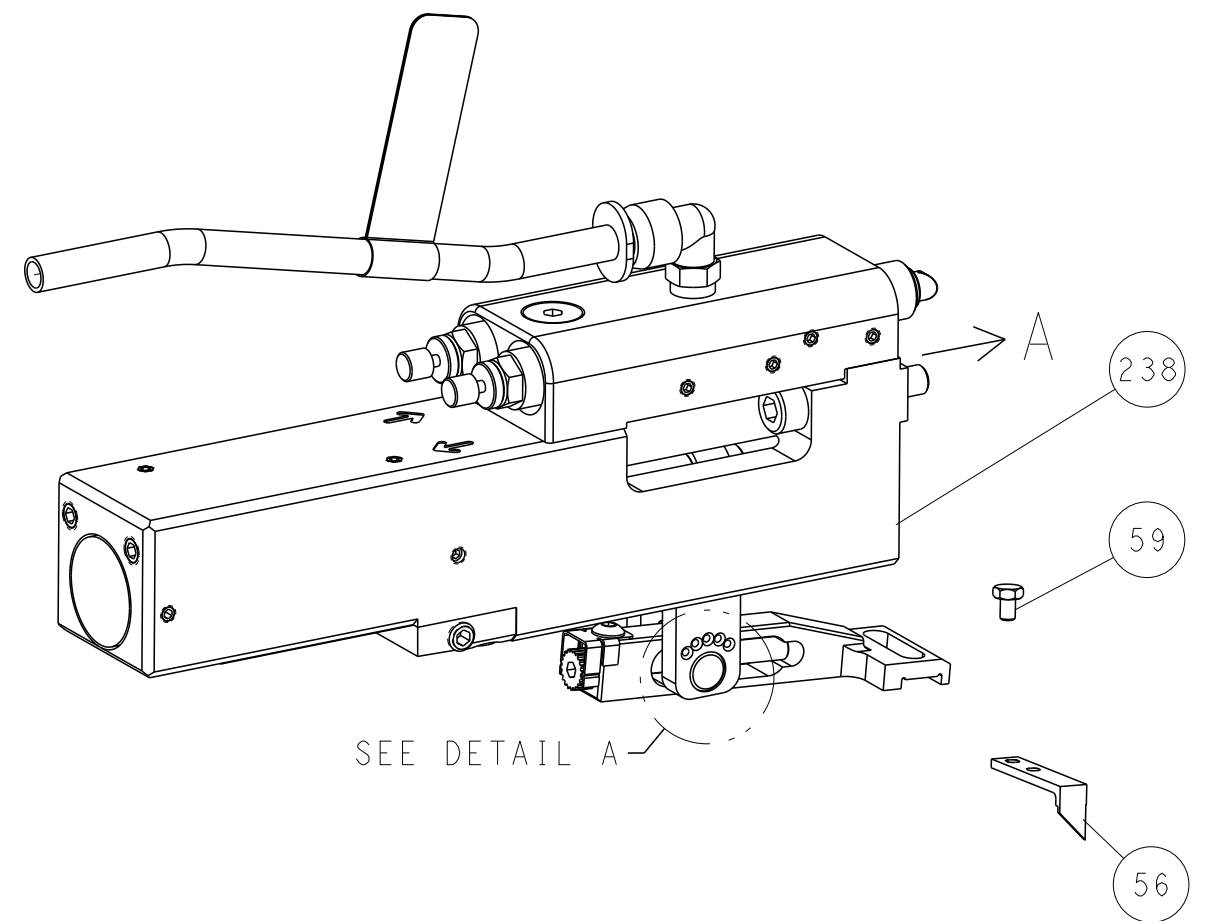
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| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | CHK | 24DEC2015 | |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | APVD | 24DEC2015 | NAME |
| | FINISH | | | U. GUO | | Ocean Side Feed Applicator |
| MATERIAL | | WEIGHT | | PRODUCT SPEC | | SIZE |
| | | | | APPLICATION SPEC | | CAGE CODE |
| | | | | | | DRAWING NO |
| | | | | | | RESTRICTED TO |
| | | | | | | A 00779 C=2836163 |
| | | | | | | Customer Accessible Production Drawing |
| | | | | | | SCALE 1:2 SHEET 1 OF 4 REV B |

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

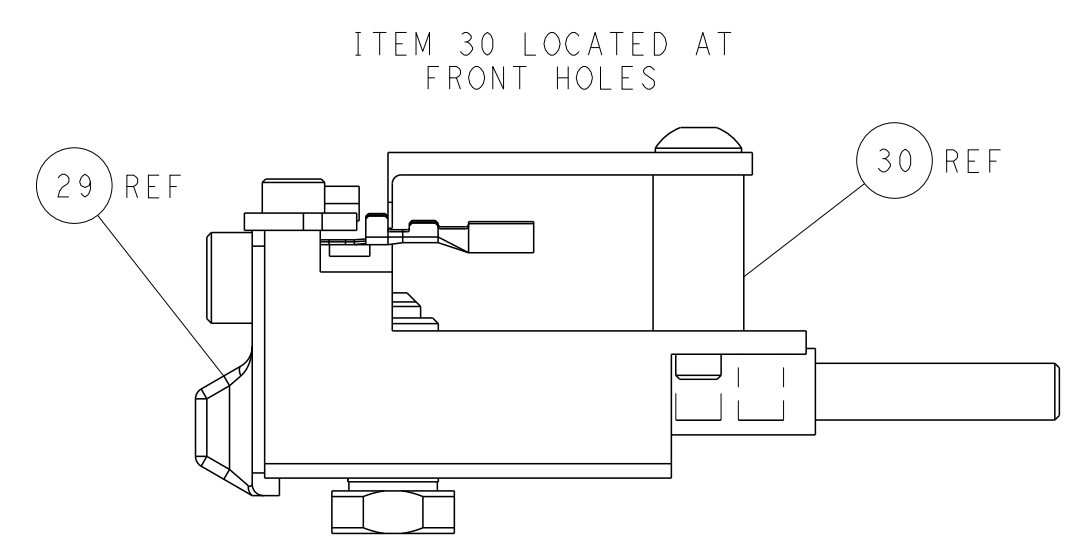
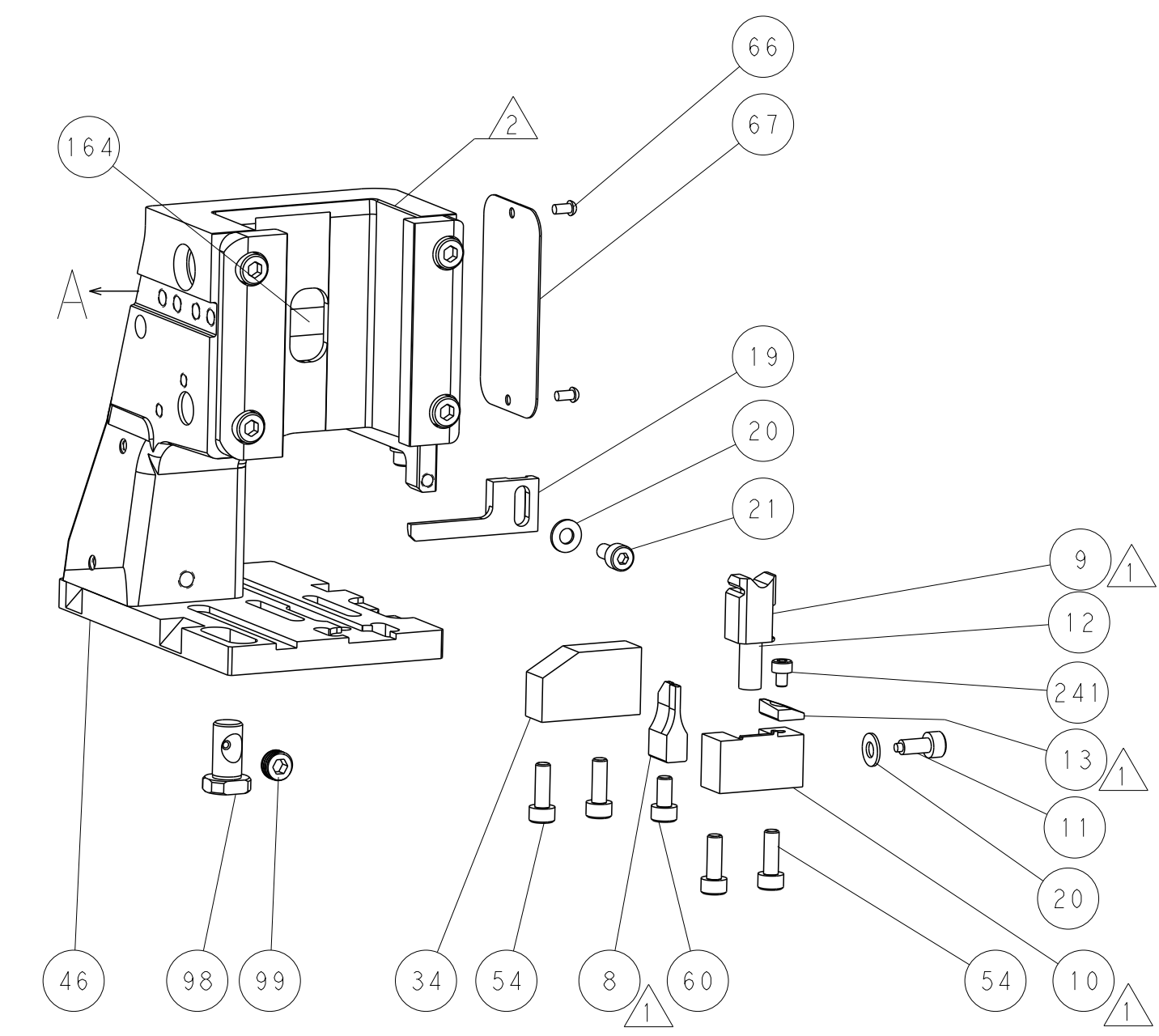
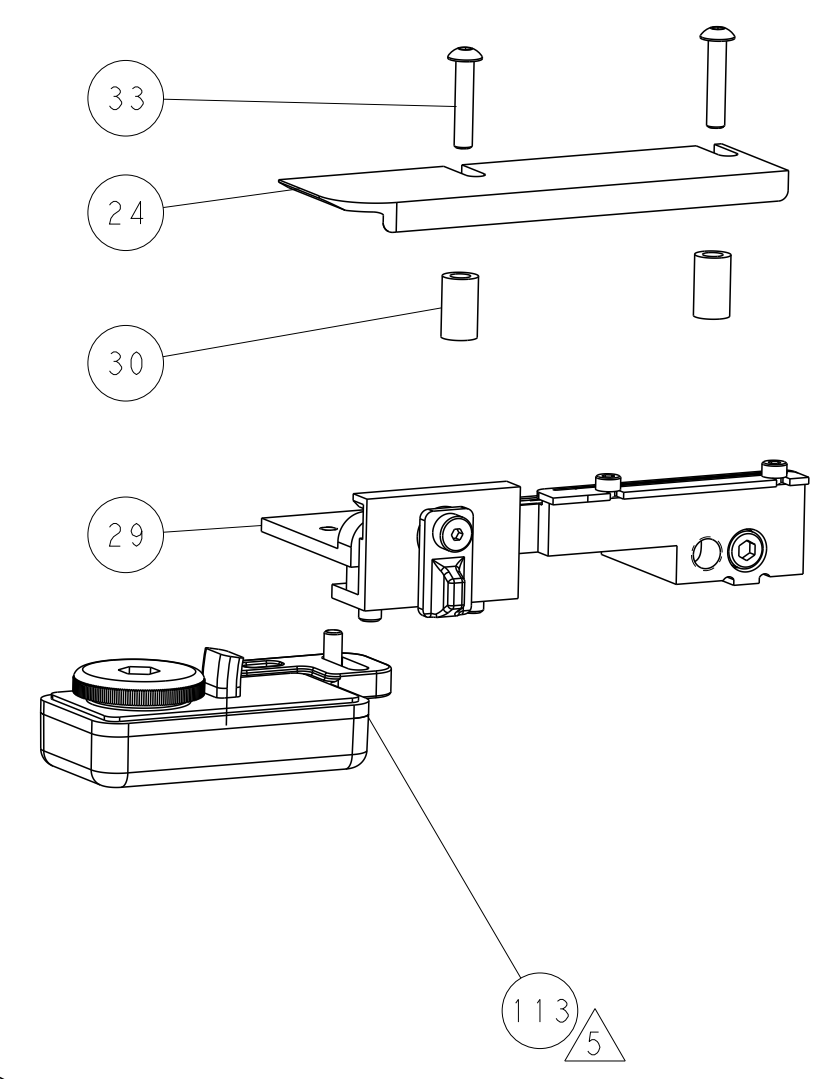
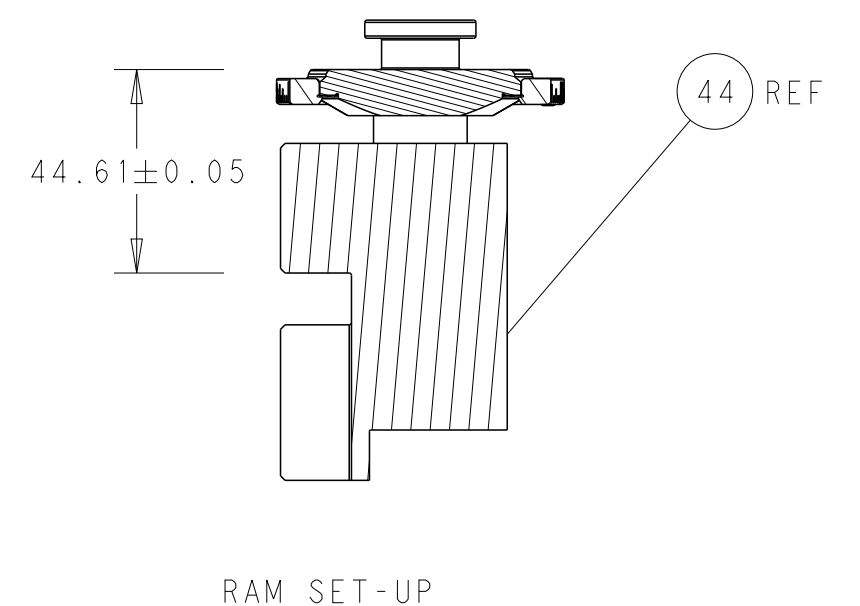
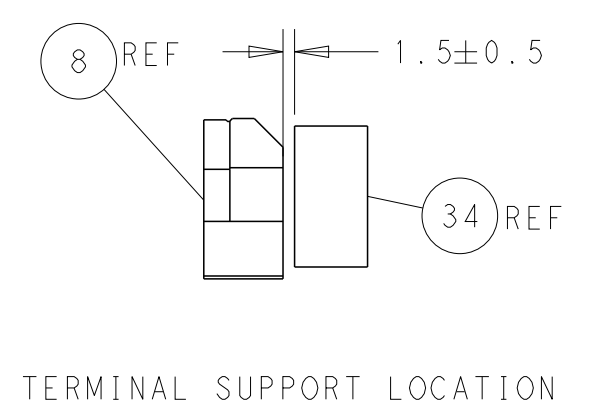
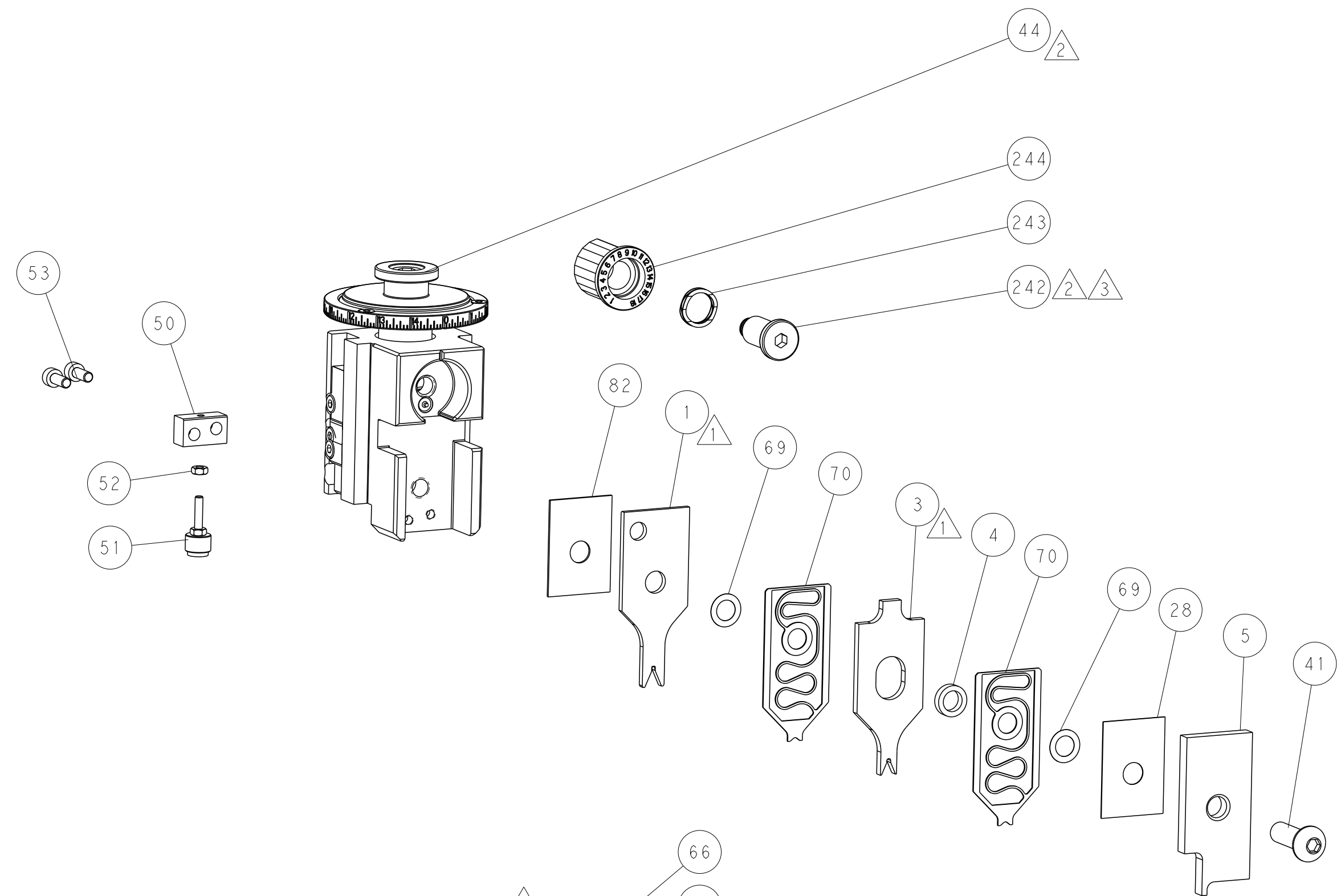
FEED TYPE MECHANICAL



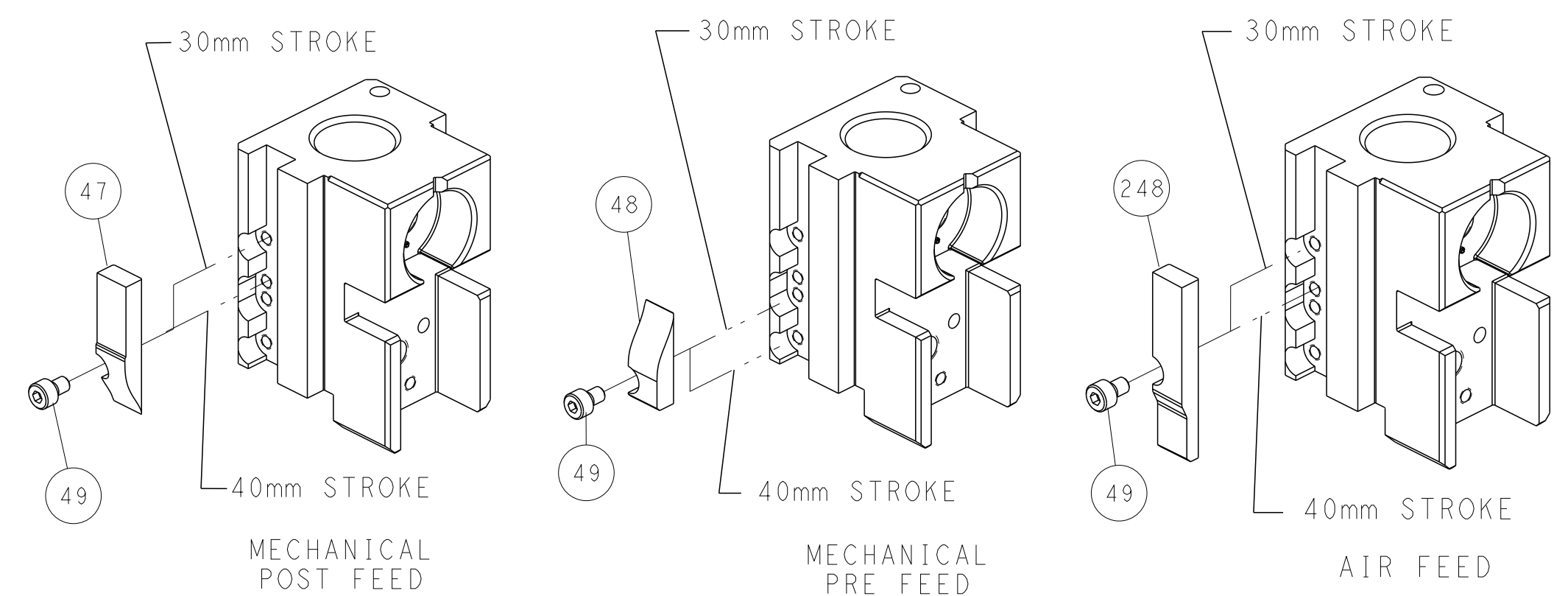
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 R. HUANG 24DEC2015 CHK L. ZHANG 24DEC2015 APVD J. GUO 24DEC2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2836163 SCALE 1:2 SHEET 2 OF 4 REV B | | TE Connectivity Harrisburg, PA 17105-3608 | |
|-----------------------|--|---|--|---|--|--|--|--|--|

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2836163-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2836163-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836163-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.24 mm [.049] | F |
| INSUL | 1.68 mm [.066] | O |

APPLICATOR INSTRUCTIONS
408-35042

| | | | |
|---|-------------------------------------|------------------------------|-----------------|
| TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION | | | |
| TERMINAL NAME: MALE TERMINAL TTS 1.5 X 0.6 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.48-4.24 mm [1.37-.167 IN] | | ∅1.10-1.70 mm [.043-.067 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 15396711 PAGE 5 OF 9 Rev 2014-07-28 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 2113118-1 | 15396711 | 2113118-3 | 13596791 |
| 2113118-2 | 15482338 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2 | 1.05+/-0.03 [.041+/-0.001] | 6.0 |
| 0.35mm2 | 0.95+/-0.03 [.037+/-0.001] | 6.8 |
| 0.22mm2 | 0.85+/-0.03 [.033+/-0.001] | 7.9 |



- △ 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.
 - △ TERMINAL LUBRICANT IS RECOMMENDED.
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.

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

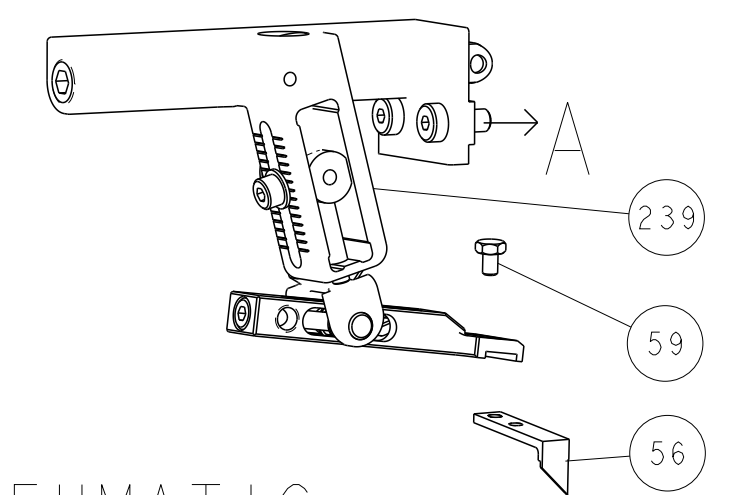
| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----------------------|---|
| - | 1 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| △ | - | 1 | 2119083-1 | RETAINER, INSULATION 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 | 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 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 2 | 2 | 2119791-5 | DEPRESSOR, WIRE | 70 | |
| - | 2 | 2 | 2119943-1 | WASHER, SPACER | 69 | |
| - | 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 | 1-1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2-2844962-4 | 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 | 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 | 5-1803055-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| △ | 1 | 1 | 1 | 7-1633966-3 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | 2 | |
| △ | 1 | 1 | 1 | 7-1633860-5 | CRIMPER, WIRE | 1 |

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

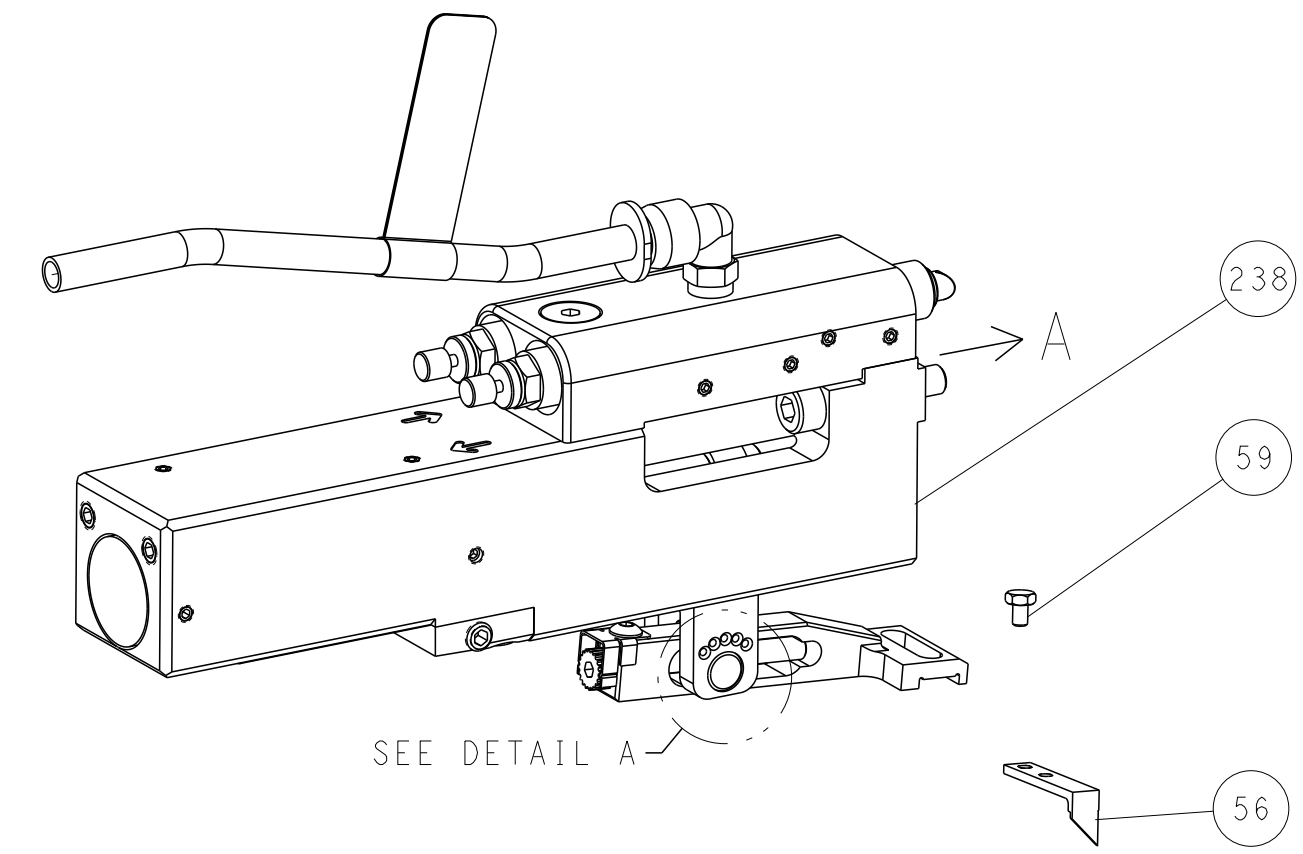
| | | | |
|--|---|--|---|
| <small>THIS DRAWING IS CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF STE CONNECTIVITY. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED IN THIS DOCUMENT. IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION.</small> | | DWN H. HUANG 24DEC2015 CHK L. ZHANG 24DEC2015 APVD J. GUO 24DEC2015 | NAME Ocean Side Feed Applicator |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | PRODUCT SPEC - APPLICATION SPEC - WEIGHT - | SIZE A1 CAGE CODE 00779 DRAWING NO C=2836163 RESTRICTED TO - |
| MATERIAL - | | SCALE 1:2 | SHEET 3 OF 4 REV B |

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

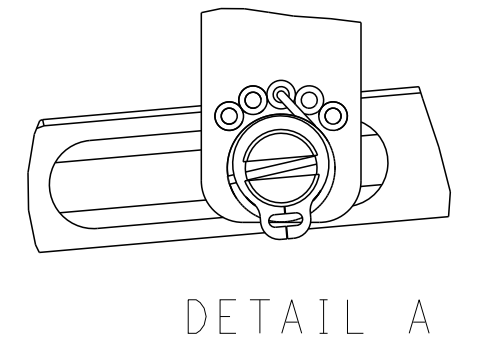
FEED TYPE MECHANICAL



PNEUMATIC

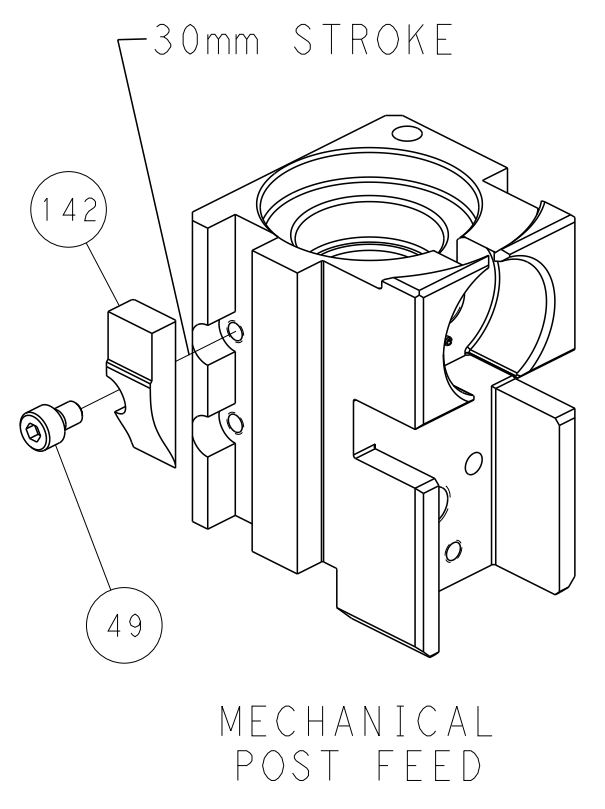


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

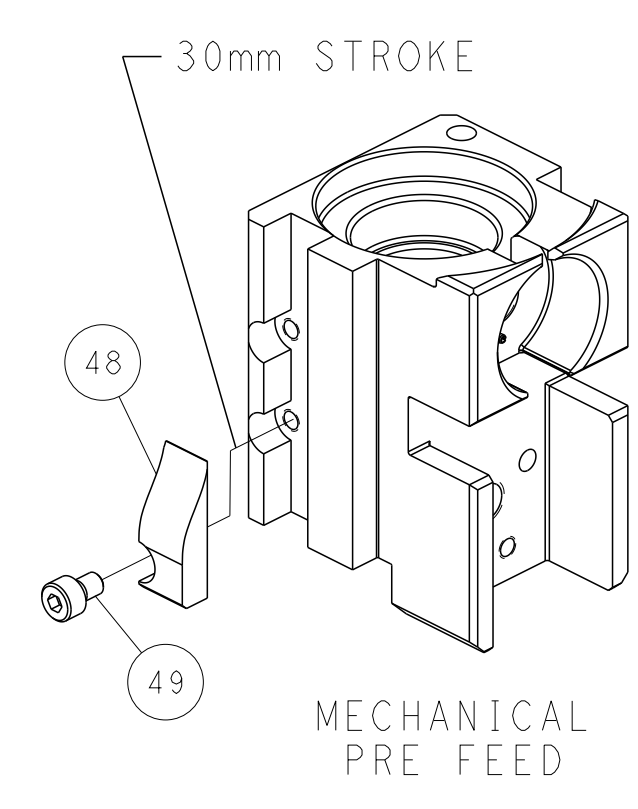


DETAIL A

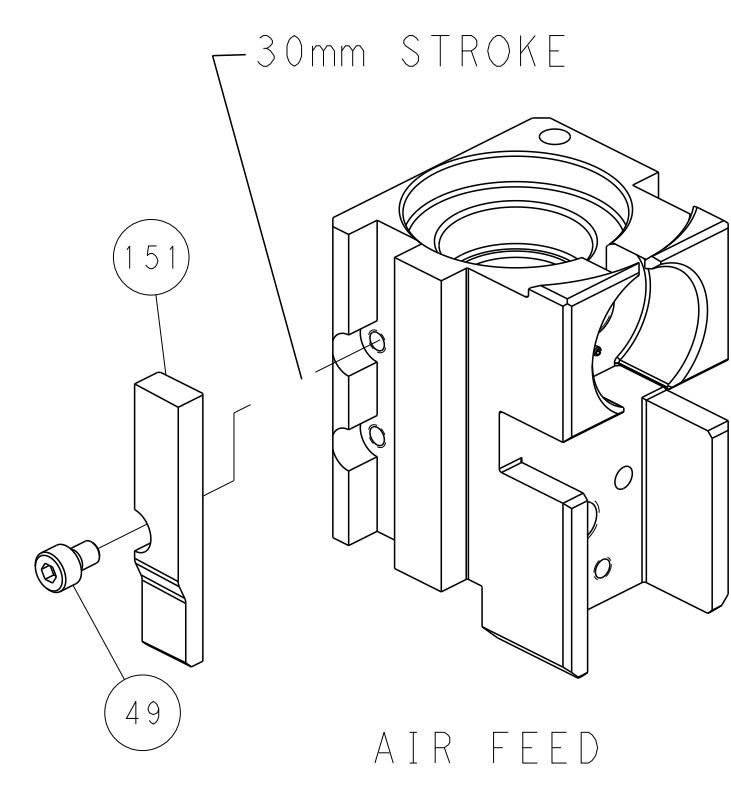
CAM POSITIONS



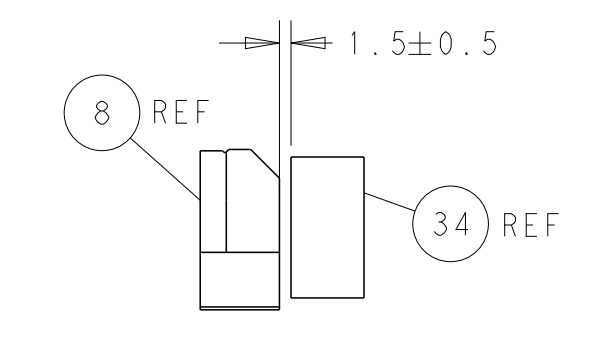
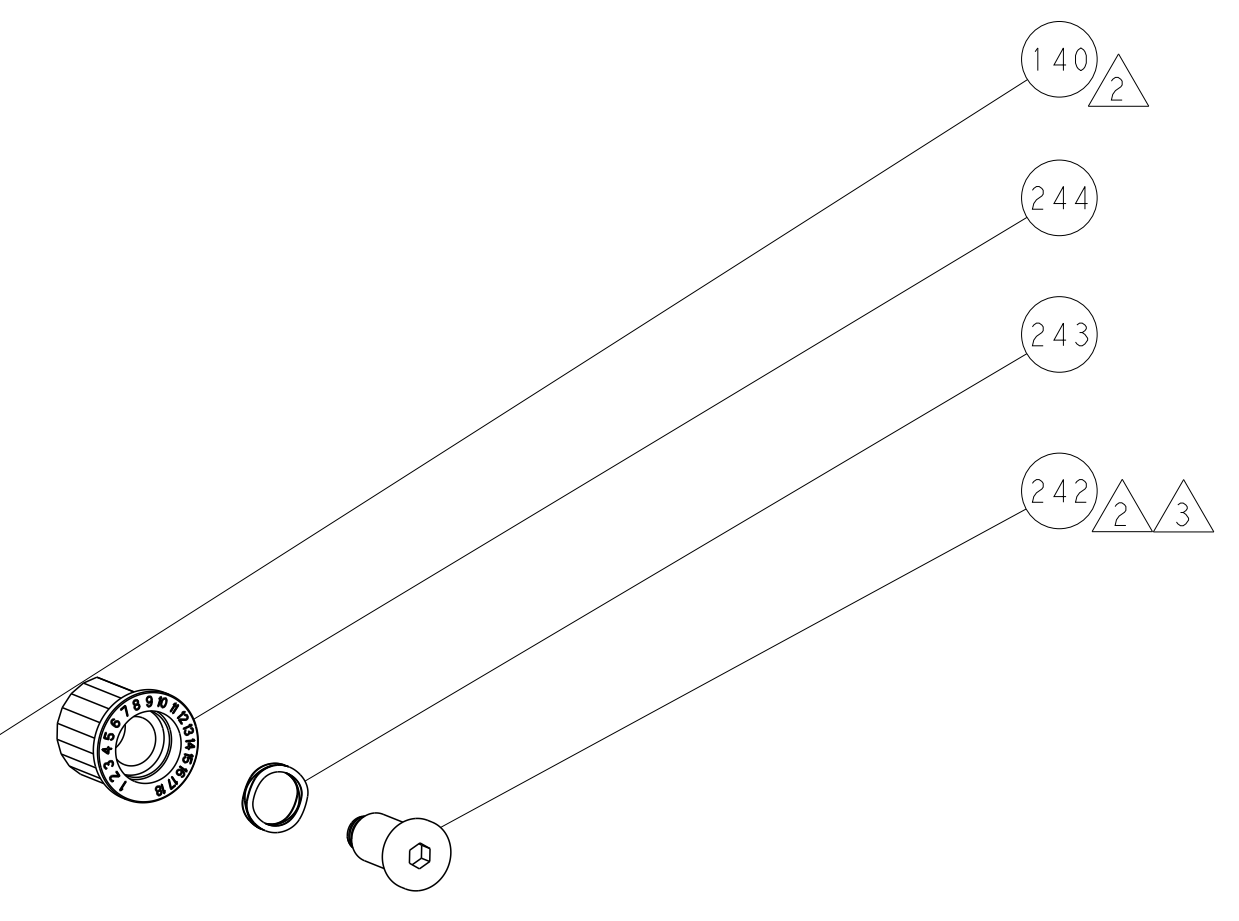
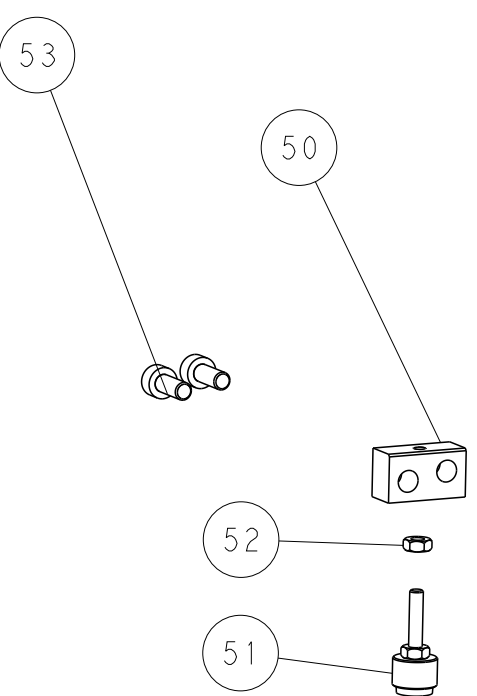
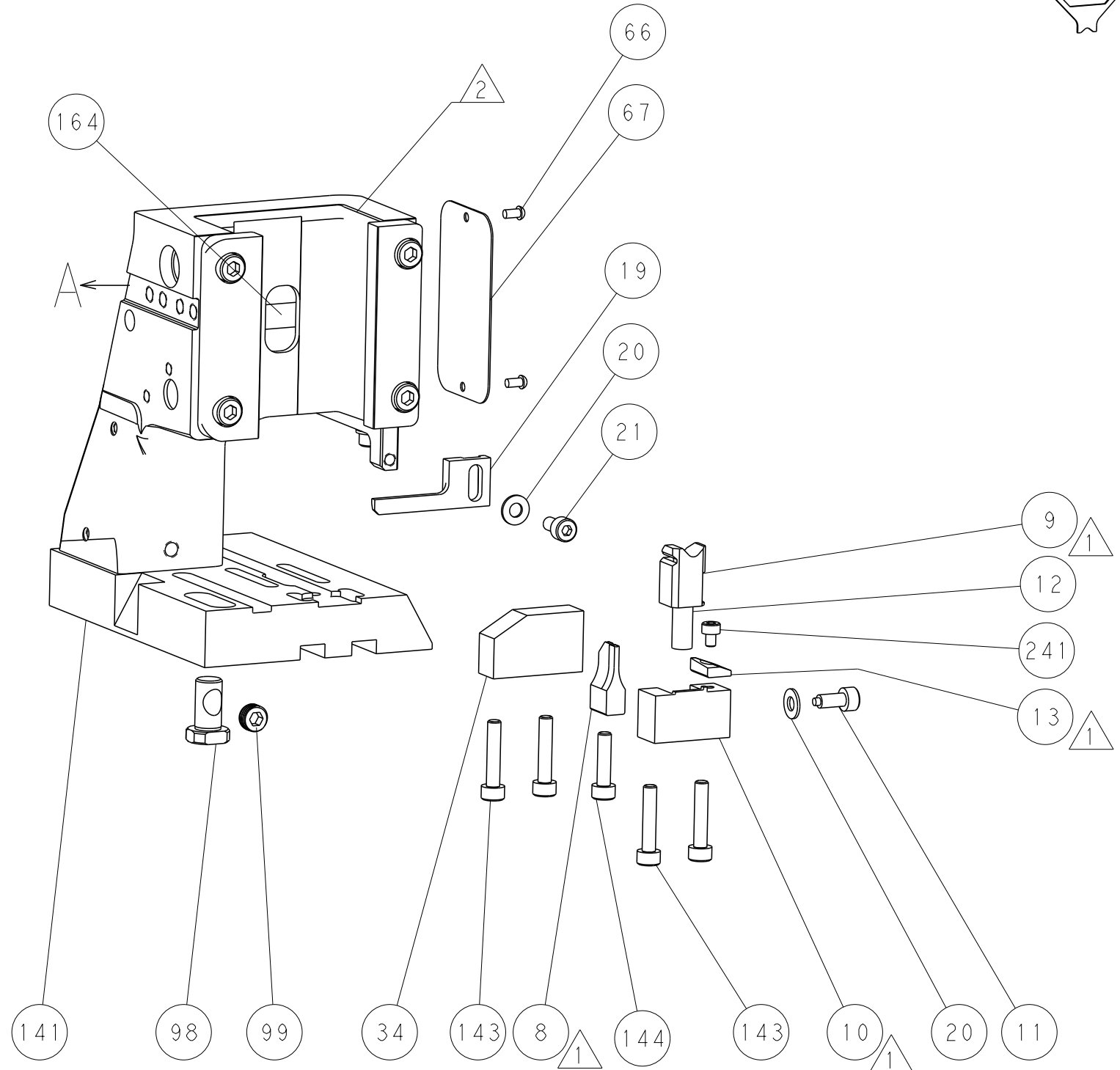
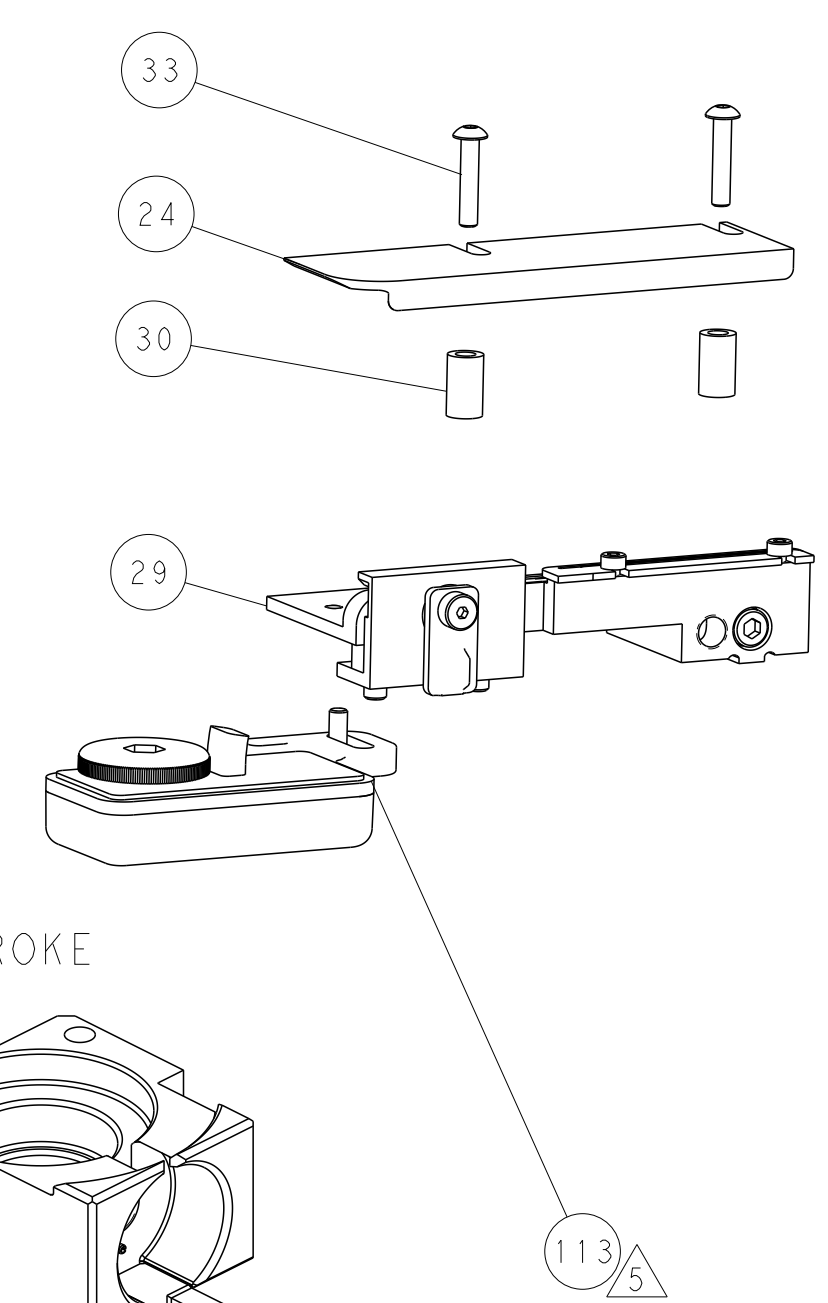
MECHANICAL
POST FEED



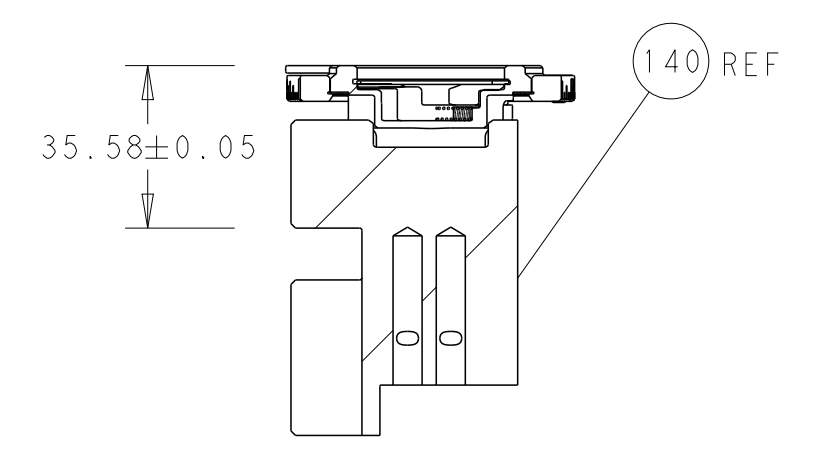
MECHANICAL
PRE FEED



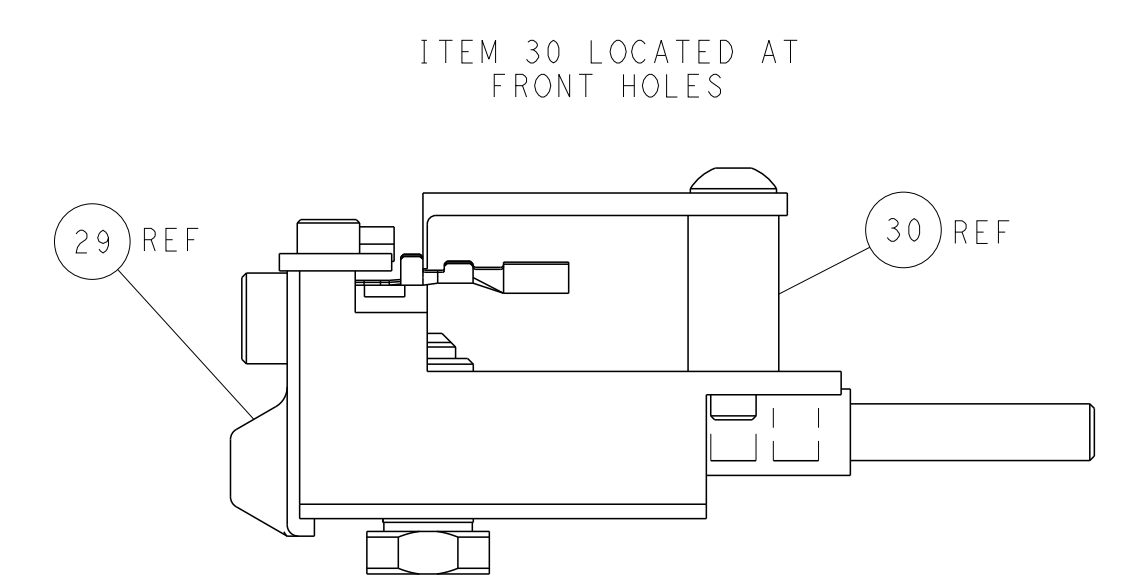
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 | MATERIAL: | PRODUCT SPEC: APPLICATION SPEC: WEIGHT: | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836163 SCALE: 1:2 SHEET: 4 OF 4 REV: B |