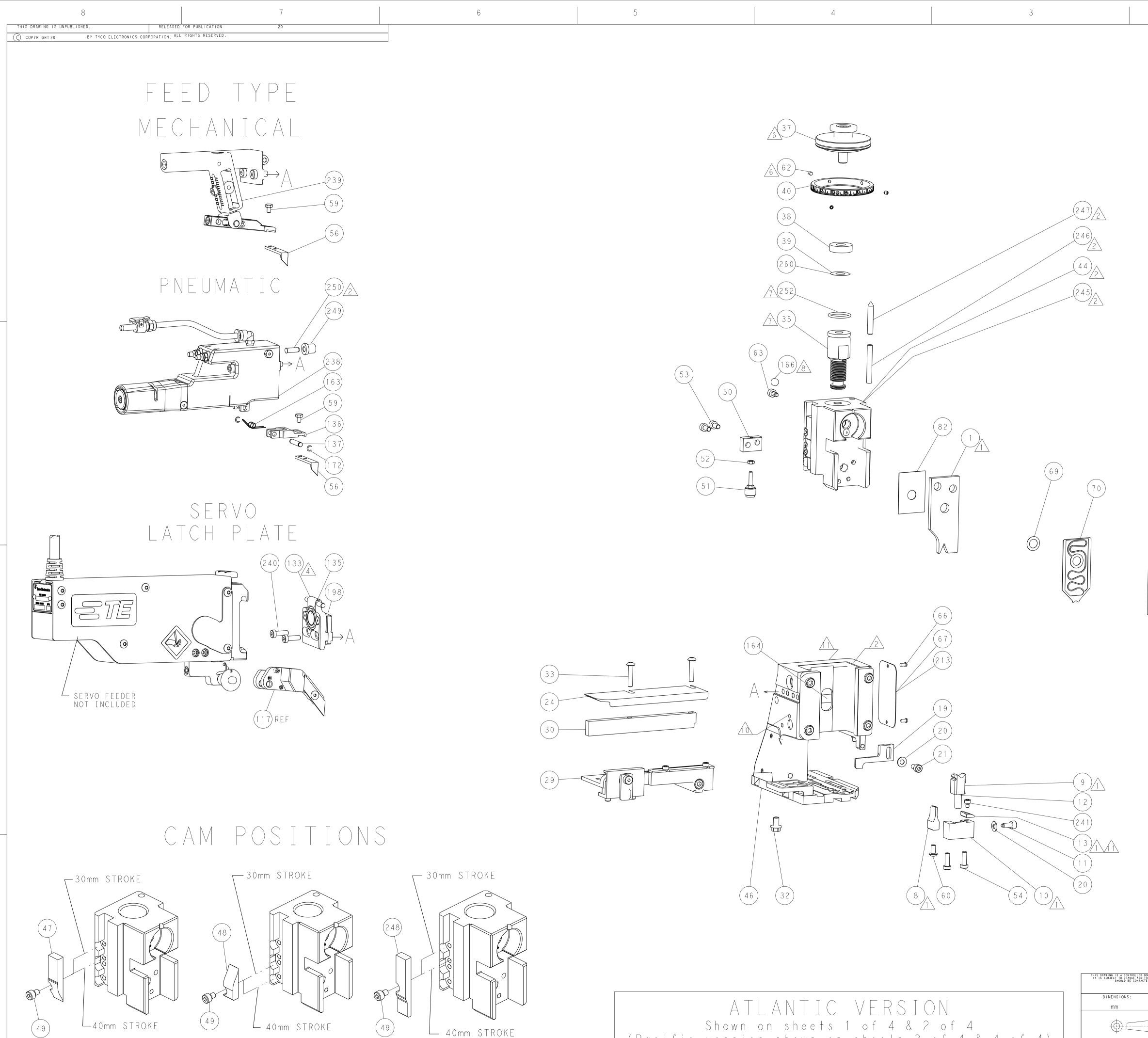
THIS DRAWING IS UNPUBLISHED.	RELEASED	FOR PUBLICATION	7 20		6	5			4		3	
C COPYRIGHT 20 BY TYCO E ATLANTIC VERSION	LECTRONICS CORPORATION. ALL	RIGHTS RESERVED.					APPLIC/	ATOR STYLE COM	IVERSION CHAR	T		SE 2
TERMINATOR INTERFACE ADAPTER	P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO				NUMBERS REQU			
	2837408-1	A F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED SERVO LATCH PLATE SMART APPLICATOR	2119950-1 2119951-1 2161326-1	1338685-1 - -	5-18022-5 8-2837408-5 8-2837408-4	2 1 1 9 6 4 1 - 1 1 9 0 1 0 9 4 - 3 -	2119799-1 - -	2063440-1 2168400-6 (QUANTITY 2 -	<u></u>
	2837408-2	A F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED SERVO LATCH PLATE SMART APPLICATOR	2119949-1 2119951-1 2161326-1	1338685-1 - -	5-18022-5 8-2837408-5 8-2837408-4	2119653-1 1901094-3 -		- 2168400-6 (QUANTITY 2 -	<u> 1</u> <u>- 1 -</u>
	2837408-5	A F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	MECHANICAL FEED PNEUMATIC FEED	2119949-1 2119950-1	1 3 3 8 6 8 5 - 1 1 3 3 8 6 8 5 - 1	5 - 1 8 0 2 2 - 5 5 - 1 8 0 2 2 - 5	2119653-1 2119641-1	- 2119799-1	- 2063440-1	
	2837408-6	A	NON-CRIMP HEIGHT ADJUST	SERVO		-	-			-		- 1 -
	2837408-7 7-2837408-7	A F A	FINE CRIMP HEIGHT ADJUST CRIMP TOOLING KIT	NONE -	-	-	-	-	-	-	-	
TERMINAL NAME: M1 WIRE STRIP LENGT 4.35-5.11 mm [.171201 TERMINAL APPLICATION SPECIFICATION TERMINALS APPL TE TERMINAL HI- 1949948-1 WIRE SIZE	TYPE 62] F - TIONS STAT TERMINAL TERMINAL H INJ NONE Rev - - IED STAT TERMINAL 503-547	ERMINAL INSU - - TE TERMINAL TE TERMINAL	CRIMP HEIGHT									- - 1 - - 1 - 1 1 - 1 1 - 1 1 - - - - - - - - - - - - - - RE - 1 1 - 1 1 - 1 1 - 1 1 - 1 1 - 1 1 - 1 1 - 1 1 - 2 2 - 1 1 - 1 1 - 1 1 - 1 1 - 1 1 - 1 1
ASSEMBLY. SEE E MECHANICAL F PNEUMATIC FE SERVO FEED V SERVO FEED V 5. ADJUSTMENT OF T APPLICATOR BETV 6 APPLY PART NUM FOR -6 ONLY APF 7 GREASE THREADS 8 MAGNET, ITEM 1 ACTUATE THE COU 9 CRIMP HEIGHT R APPLICATOR WAS NECESSARY WHEN 10 SPARE FEED CAM FOR ADDITIONAL 11 TO CONVERT THE REMOVE ITEM 13 OF THE HOUSING INFORMATION. 4 VHEN ASSEMBLIN USE SHIMS FROM	SURFACES LIGH (PER THE APPL WITH THE APPL CIFIC DATA TO BELOW FOR PART FEED WITH "SMAR FEED WITH "SMAR VITH "FINE CRIM VITH "NON-CRIMA THE STRIPPER MA VEEN BENCH AND BER 1-23419-5 PLY PART NUMBER , GROOVE AND O 66 MUST BE ORI JNTER. EFERENCE SETTI QUALIFIED AT RUNNING APPLIC STORAGE LOCAT INFORMATION. APPLICATOR TO AND ATTACH TO AND ATTACH TO AND ATTACH TO AND CRIMP ITEM 260 TO AC IED OTHERWISE	ICATOR INST ICATOR. BE ENTERED NUMBER: RT APPLICATO MP HEIGHT AD AY BE REQUI LEADMAKER LOCTITE TO R 1-23419-5 D-RING ON IT ENTED CORRE NG WAS THE THE FACTORY CATOR IN TH TON REFER T D A NON-CARP THE LOCATI TRUCTION SH	INTO BLANK MEMORY CHIP AT OR" CONVERSION: 8-2837408-2 OR" CONVERSION: 8-2837408-2 OJUST": 8-2837408-5 OJUST": 8-2837408-6 RED WHEN MOVING THE APPLICATIONS. THREADS OF ITEM 62. CLOCTITE TO THREADS OF ITEM TEMS 35 & 252. ECTLY IN ORDER TO PROPERLY SETTING USED WHEN THE C. ADJUSTMENT MAY BE				INSTALLA GEST WIR DW MINIM CAUSE Sh	TION, SET E SIZE SE UM REQUIR DAMAGE TO A T L A N own on sh	TTING. U ED CRIMP T CRIMP T TIC V e e t s 1 o	SE OF SE HEIGHT OOLING. ERSIO f 4 & 2	TTINGS SETTING N	

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SET UP GAUGE 2119599-1	LOC	DIST 66	P	LTR		REVISIONS	DATE	DWN	APVD
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-		1				2110057 2	ADDI LCATOD SHIM DACK	
-	-	-	-	- 1	- 1		APPLICATOR SHIM PACK O-RING, .676 ID, .070 DIA. MAT.	260
-	_	_	_	1	_		PUSH ROD, AIR FEED	250
-	-	_	-	1	_		BUSHING, FLANGED	249
-	-	_	_	1	_		FEED CAM, AIR FEED	248
-	1	_	1	1	1		DETENT PIN	247
	1	_	1	1	1		SPRING, COMPRESSION	246
	_	1		_	_		RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	1	1	1	1	1	7 - 18023 - 7	SCR, SKT HD CAP M3 X 4.0	241
	-	2	2	_	_		SHCS, LOW HEAD, RoHS, M5 X 16	240
	_			_	1		MECHANICAL FEED ASSEMBLY	239
	_	_		1	_		AIR FEED MODULE	
	_	1	1					238
_			1	-	-		TAG, IDENTIFICATION	213
	-			-	-		SPACER, FEEDER	198
	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
]	1	1	1	1		MAGNET, RARE EARTH HIGH ENERGY	166
	REF	REF	REF	REF			COUNTER, MAGNETIC	164
	-	-	-	1	-		SPRING, FEED FINGER	163
	-	-	-	1	-		PIN, RETAIN, GRVD, 3/16 X .854	137
	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	1	1	_	-	1633743-1	SERVO FEED LATCH ASM	133
	-	REF	REF	-	_	2119944-1	FEED FINGER ASSEMBLY,SF	117
	1	1	1	1	1		SPACER, CRIMPER	82
+	1	1	1	1	1		DOCUMENTATION PACKAGE	71
	1	1	1	1	1		DEPRESSOR, WIRE	70
	1	1	1	1	1		WASHER, SPACER	69
	1	-	_	1	1	2119740-1	TAG, IDENTIFICATION	67
+	2	2	2	2	2		SCREW, DRIVE, RH, RoHS, 2 x .188	66
+	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
+	3	_	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
+	1	1	3	3	3			60
+	-	_	-	1		2079383-4	SCR, BHSC, ROHS (M4 X 8)	
+					1		SCR, HEX HD CAP, M4 X 6.0	59
+	-	-	-	1	1	1338685-1	PAWL, FEED	56
\downarrow	2	2	2	2	2		SHCS, LOW HEAD, Rohs, M4 X 12	54
-	2	2	2	2	2		SCR, SKT HD CAP, Rohs, M4 X 8.0	53
-	1	1	1	1	1		NUT, HEX, REG, Rohs, M3	52
_	1	1	1	1	1		BUMPER, HOLD DOWN	51
\square	1	1	1	1	1		SPACER, TONKER	50
_	-	-	_	1	2		SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	1		FEED CAM, PRE FEED	48
	-	-	-	-	1		FEED CAM, POST FEED	47
	1	1	1	1	1		APPLICATOR BASIC ASSEMBLY, SF	46
	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
	1	1	1	1	1		SCR, BHSC, R₀HS (M8 X 25)	41
	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	1	-	1	1	1		APPLICATOR SHIM PACK	39
	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
T	1	1	1	1	1		FA HEAD, ATLANTIC STYLE	37
T	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
T	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
\uparrow	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	1	1	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
+	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
+	1	1	1	1	1	1320928-2	STRIP GUIDE	24
+	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
+	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
+	1	1	1	1	1	2119533-9	STRIPPER, SIDE FEED	19
+	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
+	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
+	1	1	1	1	1			· 1 1
+	1	1	1	1	1	1 - 356885 - 4	STOP, SHEAR	
+	1	1	1	1	1		SHEAR HOLDER, FRONT	10
+	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
+						4 - 1803190 - 7	ANVIL, WIRE	8
\downarrow	-	-	-	-	-	-	-	
_	-	-	-	-	-	-		6
_	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
_	-	-	_	-	-	-	-	4
	-	-	_	-	-	-	-	3
	-	-	_	-	-	-	-	2
	1	1	1	1	1	8-1633713-3	CRIMPER, WIRE PREMIUM	1
-+-	- 7	- 6	- 5	- 2	- 1	PART NO	DESCRIPTION	ITEM
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'	CHANGE AND D BE CONTAC		TOLERAN	CES UNLE SPECIF		снк 15AUG2018 <u>М. HERR</u> АБУУР 15AUG2018	Harrisburg, PA 17105-3608	
S A TO	NS:			SPECIF	IED:	APVD 15AUG2018 T.ELBIN	Ocean Side Feed	
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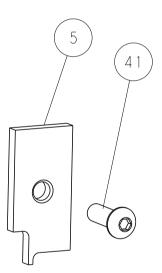


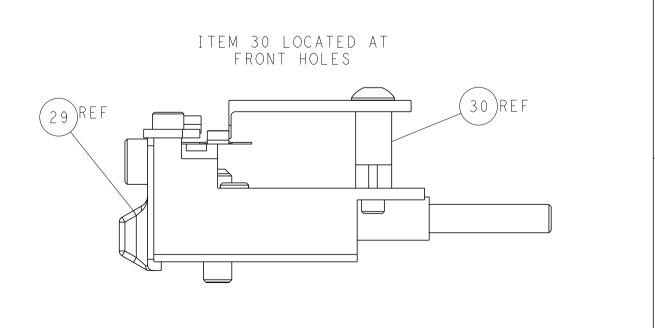
AIR FEED

40mm STROKE

DIMENSIONS: ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) mm

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 LOC	DIST			REVISIONS			
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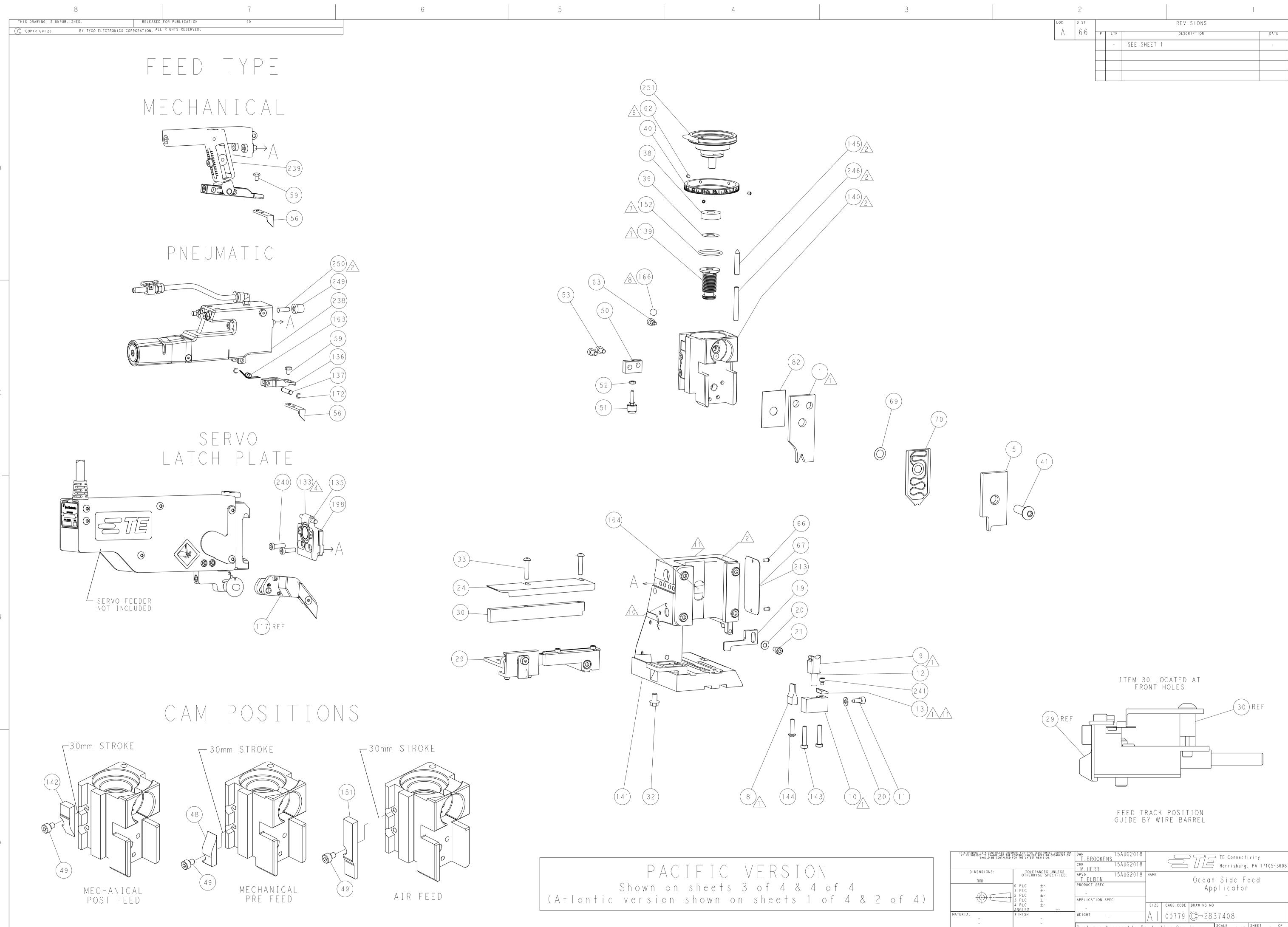
FEED TRACK POSITION GUIDE BY WIRE BARREL

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THE C	ONTROLLING ENG	INEERING ORGA	RPORATION	DWN T.BROOK	15AUG2 ENS	018				TE Connectivity	/	
				снк M.HERR	15AUG2	018				Harrisburg, PA	17105-360	8
	TOLER OTHERW	ANCES UNL	ESS FIED:	APVD T.ELBIN	15AUG2	018	NAME		Ocean	Side Feec	4	
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	4 PLC ANGLES	±- -	+-	-			SIZE	CAGE CODE	DRAWING NO			RESTRICTED TO
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PACIFIC VERSION	LECTRONICS CORPORATION. ALL						APPLIC	CATOR STYLE CON	IVERSION CHAI	R T_		
TERMINATOR INTERFACE ADAPTER	P A R T N U M B E R	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO			PART	NUMBERS REQI	UIRED		
	2 - 2837408 - 1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED SERVO LATCH PLATE SMART APPLICATOR	2119950-1 2119951-1 2161326-1	1 3 3 8 6 8 5 - 1 - -	5-18022-5 8-2837408-5 8-2837408-4	2119641-2 1901094-3 -	2119799-1 - -	2063440-1 2168400-6 (QUANTITY 2) -	
	2 - 2837408 - 2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED SERVO LATCH PLATE SMART APPLICATOR	2119949-1 2119951-1 2161326-1	1 3 3 8 6 8 5 - 1 - -	5-18022-5 8-2837408-5 8-2837408-4	2119653-2 1901094-3 -	- - -	- 2168400-6 (QUANTITY 2) -	Г
	2-2837408-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED PNEUMATIC FEED	2119949-1 2119950-1	1 3 3 8 6 8 5 - 1 1 3 3 8 6 8 5 - 1	5-18022-5 5-18022-5	2119653-2 2119641-2	- 2119799-1	- 2063440-1	_
	2 - 2837408 - 7 7 - 2837408 - 7	A A	FINE CRIMP HEIGHT ADJUST CRIMP TOOLING KIT	NONE -		-	-	-	-	-		-
PPLICATION PECIFICATION ERMINALS APPL TE TERMINAL HI- 1949948-1 /IRE SIZE	TIONS TIONS STAT TERMINAL TERMINAL H INJ NONE Rev - - ED STAT TERMINAL 503-547	ERMINAL IN - - TE TERMIN	ER CRIMP SPECIFICATION SULATION DIAMETER RANGE IAL HI-STAT TERMINAL I CRIMP HEIGHT REFERENCE SETTING 8.8									
APPLICATOR S ASSEMBLY. MECHANICA PNEUMATIC SERVO FEE 5. ADJUSTMENT O APPLICATOR B 6 APPLY PART N 7 GREASE THREA 8 MAGNET MUST ACTUATE THE 9 CRIMP HEIGHT APPLICATOR W NECESSARY WH 1 SPARE FEED C FOR ADDITION 1 TO CONVERT T REMOVE ITEM	NG SURFACES LI ILY PER THE AP ED WITH THE AP PECIFIC DATA T SEE BELOW FOR L FEED WITH "S FEED WITH "SM D WITH "FINE C F THE STRIPPER ETWEEN BENCH A UMBER 1-23419- DS, GROOVE AND BE ORIENTED CO COUNTER. REFERENCE SET AS QUALIFIED A EN RUNNING APP AM STORAGE LOC AL INFORMATION HE APPLICATOR 13 AND ATTACH	PLICATOR PLICATOR. TO BE ENTE PART NUME MART APPL ART APPLIC RIMP HEIGE MAY BE RE ND LEADMAN O O-RING O ORRECTLY I TTING WAS T THE FACT LICATOR IN CATION REF CATION REF CATION REF	RED INTO BLANK MEMORY CHIP AT BER: ICATOR" CONVERSION: 8-2837408- CATOR" CONVERSION: 8-2837408- HT ADJUST": 8-2837408- EQUIRED WHEN MOVING THE KER APPLICATIONS. TO THREADS OF ITEM 62. N ITEMS 139 & 152. N ORDER TO PROPERLY THE SETTING USED WHEN THE TORY. ADJUSTMENT MAY BE	4			LARGES BELOW	STALLATION St wire si	ZE SETTI EQUIRED	NG. USE CRIMP HE		
	IFIED OTHERWIS 1-35000.	E TORQUE V	VALUES SHALL BE USED PER					PACI hown on st		ERSIO	N	THIS DRAWING IS S IT IS SUBJECT TO SHOT DIMENSI MM

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SET UP GAUGE 2119599-1	LOC	DIST		REVISIONS								
2119599-1	A	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD				
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-	-	-	 -	1	-	2119782-1 2119640-1	FINE ADJUST HEAD ASM, PACIFIC STYLE [®] PUSH ROD, AIR FEED	251 250	
-	-	-	- 1	1	-	1803259-1 1-22279-3	BUSHING, FLANGED 'SPRING, COMPRESSION '	249 246	
-	-	1	1	1	1	7 - 1 8 0 2 3 - 7	SCR, SKT HD CAP M3 X 4.0	241	D
-	-	-	2 -	-	- 1	2168400-6 2119580-1	SHCS, LOW HEAD, Rohs, M5 X 16 Mechanical feed assembly	240 239	
-	-	-	_	1	-	2063440-1	AIR FEED MODULE	238	
-	-	-	1	-	-		TAG, IDENTIFICATION SPACER, FEEDER	213	
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT [.]	172	
-	-	REF	REF	REF	1 REF		MAGNET, RARE EARTH HIGH ENERGY [·] COUNTER, MAGNETIC [·]	166	
-	-	-	-	1	-	240638-1 8-21084-1	SPRING, FEED FINGER	163 152	
-	_	-	-	1	-		O-RING, .801 ID, .070 DIA. MAT. FEED CAM, AIR FEED	151	
-	-	1	1	1	1	2119798-2 2079383-8	DETENT PIN SCR, BHSC, RoHS (M4 X 16)	145	
-	-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20 .	143	
-	-	- 1	- 1	-	1	2119653-2 1-2119656-0	FEED CAM, POST FEED	142	
-	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
-	-	1	1 –	1	1 -	2119092-2 3-23627-7	BOLT, ADJUSTMENT PIN, RETAIN, GRVD, 3/16 X .854	139	
-	-	-	-	1	_		HOLDER, FEED FINGER, AF	136	
	-	-	REF 1	_	-		MEMORY CHIP, PROGRAMMED - SERVO FEED LATCH ASM -	135 133	С
-	-	-	REF	-	-		FEED FINGER ASSEMBLY,SF [.] SPACER, CRIMPER [.]	117 82	
-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
	-	1	1	1	1	2119791-9 2119943-1	DEPRESSOR, WIRE " WASHER, SPACER "	70	
-	-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	-	2	2	2	2		SCREW, DRIVE, RH, R⊙HS, 2 x .188 LIMITER, ADJUSTMENT BOLT	66 63	
-	-	3	3	3	3	992763-5 5-18022-5	SCR, SET, SOC, CONE PNT, M3 x 4.0 ⁻ SCR, HEX HD CAP, M4 X 6.0 ⁻	62 59	
-	-	-	-	1	1	1 3 3 8 6 8 5 - 1	PAWL, FEED .	56	
-	-	2	2	2	2	2168083-2 5018030-1	SCR, SKT HD CAP, RoHS, M4 X 8.0	53 52	
-	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
	-	-	-	1	2	690753-6 18023-9	SPACER, TONKER SCR, SKT HD CAP M4 X 6.0	50 49	
-	-	-	- 1	-	1	2119652-1 2079383-7	FEED CAM, PRE FEED ' SCR, BHSC, RoHS (M8 X 25) '	48	
-	-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	-	1	1	1	1	2119957-1 2119644-1	APPLICATOR SHIM PACK	39 38	В
-	-	2	2	2	2	2079383-5	SCR, BHSC, ROHS (M4 X 20)	33 32	
-	_	1	1	1	1	2161328-1 1320908-2	HEX HEAD, FLANGED, M5 x 8mm LONG SPACER, STRIP GUIDE	30	
-	-	1	1	1	1	2119959-1 1320928-2	ASSEMBLY, STRIP GUIDE	29 24	
-	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	-	2	2	2	2	1 - 18028 - 2 2119533 - 9	WASHER, FLAT, REG M4	20	
$\boxed{1}$	-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
	_	1	1	1	1	3-22280-3 1-356885-4	SPRING, COMPRESSION STOP, SHEAR	12	
	-	1	1	1	1	2119805-1 1803095-3	SHEAR HOLDER, FRONT ' FLOATING SHEAR, FRONT - '	10	
	1	1	1	1	1	4 - 1803190 - 7	ANVIL, WIRE	8	
-	-	-		-	-	-	- -	76	
-	-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
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A 66 P LTR DESCRIPTION DA	TE DWN	APVD
- SEE SHEET 1 -	-	-

DOCU THE TED	MENT FOR TYCO ELECTRONICS CORPORATION CONTROLLING ENGINEERING ORGANIZATION FOR THE LATEST REVISION.	DWN 15AUG2018 T.BROOKENS CHK 15AUG2018 M.HERR Harrisburg,	vity PA 17105-3608	
	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±- 2 PLC ±- 3 PLC ±-	APVD 15AUG2018 NAME Ocean Side Fe PRODUCT SPEC Applicator	e e d	
	4 PLC ±- ANGLES ±-	- SIZE CAGE CODE DRAWING NO		RESTRICTED TO
	FINISH -	WEIGHT - A 00779 C-2837408		-
	-	Customer Accessible Production Drawing SCALE 1:2	sheet of 4 2	1 REV A
		SHEETS 1 & 2 ARE NOT REQUIRED FOR	PACIFIC	VERSION