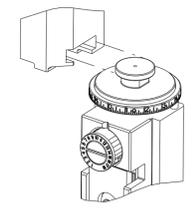


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266112-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266112-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266112-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266112-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266112-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266112-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266112-7	B	CRIMP TOOLING KIT	-
7-2266112-8	B	APPLICATOR CONVERSION KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.62 mm [.103]	F
INSUL	3.20 mm [.126]	O

APPLICATOR INSTRUCTIONS
408-35042

APPLICATOR CONVERSION KITS

PART NUMBER	INSULATION DIAMETER RANGE
7-2266112-8	Ø 3.15-3.56mm [.124-.140]
7-2266113-8	Ø 2.72-3.12mm [.107-.123]
7-2266114-8	Ø 2.29-2.69mm [.090-.106]
7-2266115-8	Ø 1.91-2.26mm [.075-.089]

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: STAMPED CONTACT PIN SIZE 16

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.44-5.72 mm [.175-.225 IN]	Ø 3.15-3.56 mm [.124-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-151001

TERMINALS APPLIED

TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113238-1	1060-16-1222	2113238-2	1060-16-1244
2113238-3	1060-16-1277		

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 16

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.44-5.72 mm [.175-.225 IN]	Ø 3.15-3.56 mm [.124-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-151001

TERMINALS APPLIED

TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1949119-1	1062-16-1222	1949119-2	1062-16-1244
1949119-3	1062-16-1277	1949119-4	1062-16-1422
1949119-5	1062-16-1444	1949119-6	1062-16-1477

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.78+0.03/-0.05 [.070+.001/- .002]	5.6
2.50mm2	1.73+0.03/-0.05 [.068+.001/- .002]	6.1
14 AWG	1.65+0.03/-0.05 [.065+.001/- .002]	6.7
2.00mm2	1.63+0.03/-0.05 [.064+.001/- .002]	6.9
1.50mm2	1.50+0.03/-0.05 [.059+.001/- .002]	8.2
16 AWG	1.47+0.03/-0.05 [.058+.001/- .002]	8.5
1.00mm2	1.40+0.03/-0.05 [.055+.001/- .002]	9.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

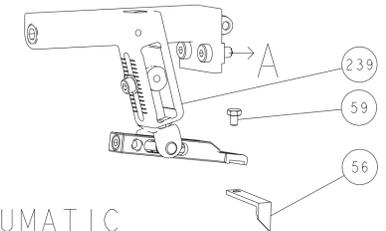
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A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B1		ECR-16-017319	07DEC2016	KH	JDG
		B2		ECR-17-003241	07MAR2017	KH	JDG
		C		ECR-18-018800	30NOV2018	LG	CT
		D		ECR-21-006612	30JUN2021	FJ	TE

-	-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	-	1	1	-	-	2-1752354-1	STANDOFF, HOLD-DOWN	180
-	-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	-	-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	-	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
1	-	-	-	-	-	-	-	2266112	PRINT, APPLICATOR LOG SHEET	72
-	-	-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	2	2	2	2	2	2	2119791-9	DEPRESSOR, WIRE	70
-	-	-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	-	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1	1	1	1338683-8	FEED PAWL	56
-	-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	-	-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	-	-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	2	1	2	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	1	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	-	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	-	1	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	1	1	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	1	1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	-	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	1-356885-4	STOP, SHEAR	11
1	-	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	-	-	1	1	2	2	1	1803293-8	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	-	1	1	1	1	1	3-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	-	6
-	-	-	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	-	-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	1	1803019-3	CRIMPER, INSULATION O	3
-	-	-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	-	-	1	2	2	1	1	4-1633713-2	CRIMPER, WIRE PREMIUM	1

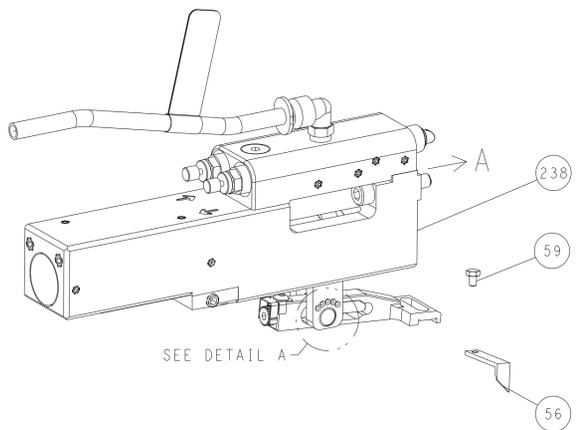
ITEM NO	PART NO	DESCRIPTION	ITEM NO
-78	-77	-72	-71
-52	-51	-2	-1
OWN		TE Connectivity	
R. KNEPPER		Harrisburg, PA 17105-3608	
G. BAILLEY		NAME	
M. CLIFFORD		Ocean Side Feed	
PRODUCT SPEC		Applicator	
APPLICATION SPEC		SIZE	
MATERIAL		CAGE CODE	
FINISH		DRAWING NO	
WEIGHT		RESTRICTED TO	
SCALE		SHEET	
1:2		1 OF 4	
Customer Accessible Production Drawing		REV D	

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

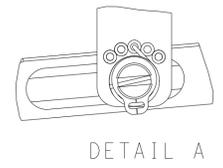
FEED TYPE MECHANICAL



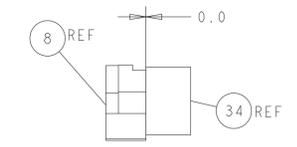
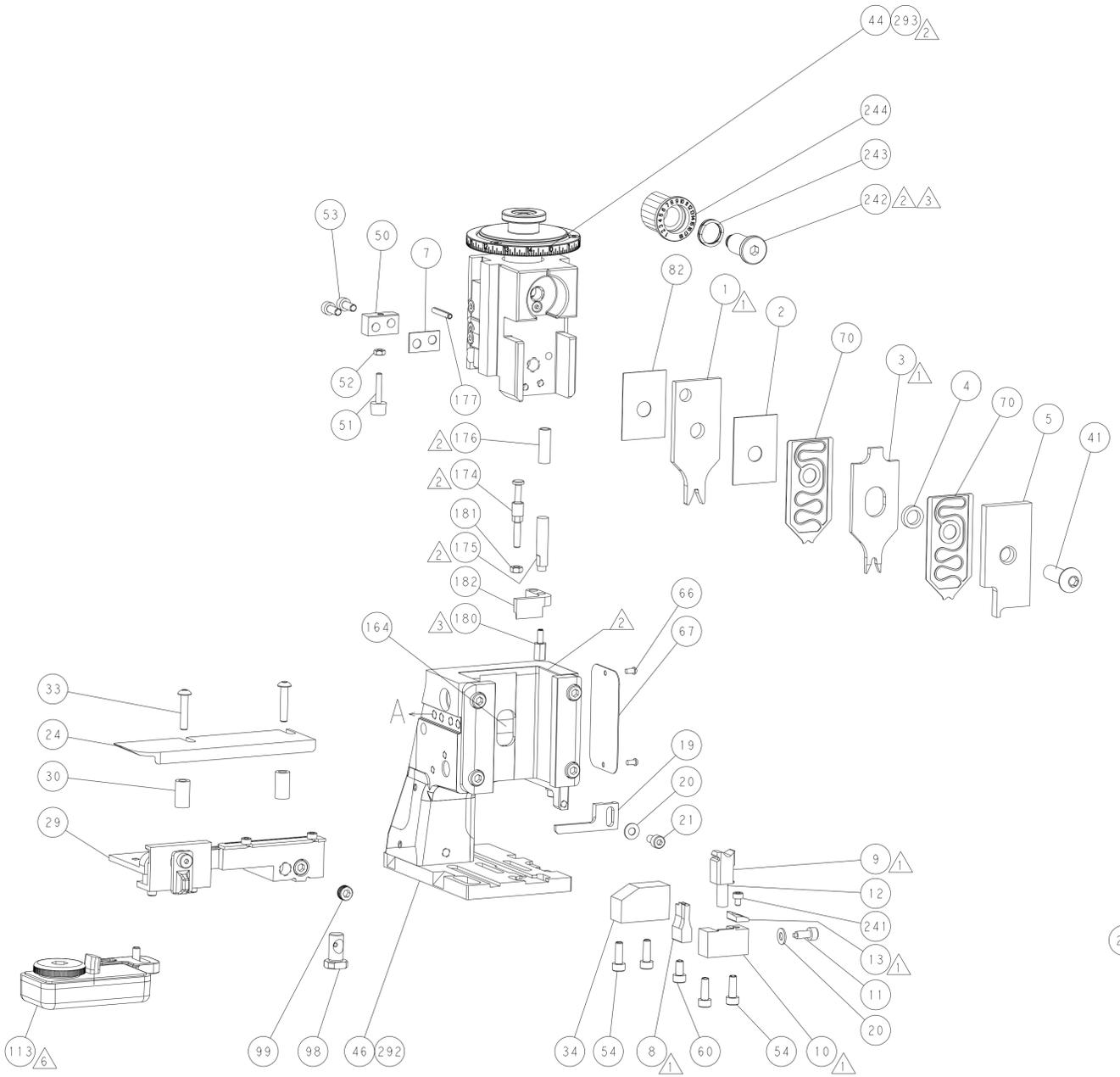
PNEUMATIC



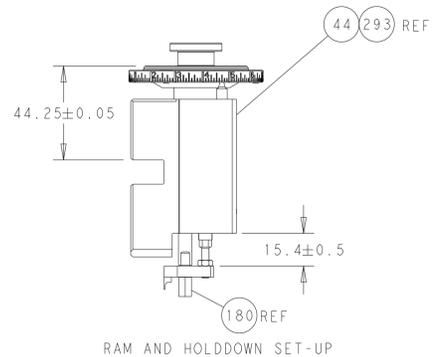
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



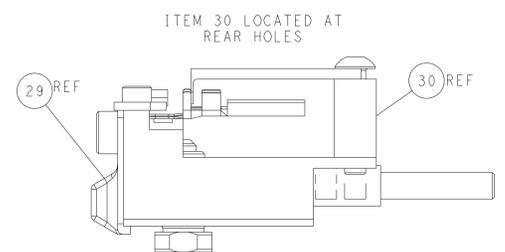
DETAIL A



TERMINAL SUPPORT LOCATION

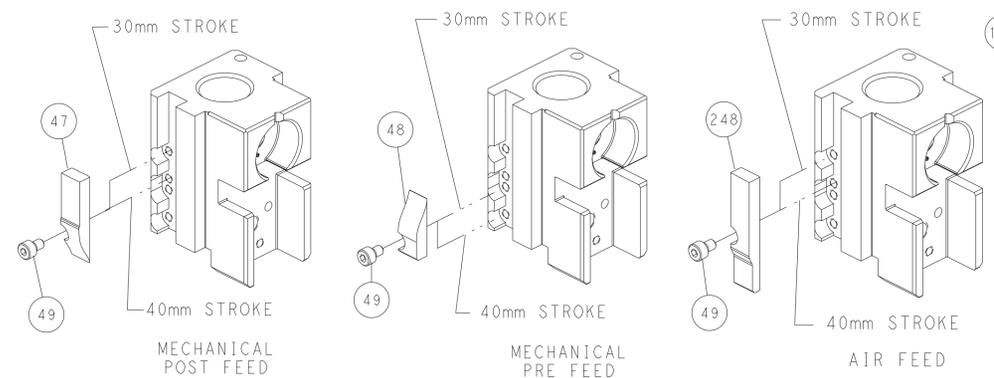


RAM AND HOLDDOWN SET-UP



ITEM 30 LOCATED AT REAR HOLES

CAM POSITIONS

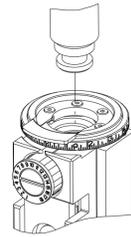


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		R. KNEPPER	10-Oct-13	STE TE Connectivity	
	1 PLC	±		G. BAILEY	10-Oct-13	Harrisburg, PA 17105-3608	
	2 PLC	±		M. CLIFFORD	10-Oct-13	NAME	
	3 PLC	±				Ocean Side Feed	
	4 PLC	±				Applicator	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				A1	00779
MATERIAL						DRAWING NO	©=2266112
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2 SHEET 2 OF 4 REV D

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266112-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266112-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266112-7	B	CRIMP TOOLING KIT	-
7-2266112-8	B	APPLICATOR CONVERSION KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.62 mm [.103]	F
INSUL	3.20 mm [.126]	O

APPLICATOR INSTRUCTIONS
408-35042

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266112-8	Ø3.15-3.56mm [.124-.140]
7-2266113-8	Ø2.72-3.12mm [.107-.123]
7-2266114-8	Ø2.29-2.69mm [.090-.106]
7-2266115-8	Ø1.91-2.26mm [.075-.089]

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 16			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TERMINAL APPLICATION SPECIFICATION	TE CRIMP SPECIFICATION
4.44-5.72 mm [.175-.225 IN]	Ø3.15-3.56 mm [.124-.140 IN]	114-151001	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113238-1	1060-16-1222	2113238-2	1060-16-1244
2113238-3	1060-16-1277		

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 16			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TERMINAL APPLICATION SPECIFICATION	TE CRIMP SPECIFICATION
4.44-5.72 mm [.175-.225 IN]	Ø3.15-3.56 mm [.124-.140 IN]	114-151001	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1949119-1	1062-16-1222	1949119-2	1062-16-1244
1949119-3	1062-16-1277	1949119-4	1062-16-1422
1949119-5	1062-16-1444	1949119-6	1062-16-1477

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.78+0.03/-0.05 [.070+.001/-0.002]	5.6
2.50mm2	1.73+0.03/-0.05 [.068+.001/-0.002]	6.1
14 AWG	1.65+0.03/-0.05 [.065+.001/-0.002]	6.7
2.00mm2	1.63+0.03/-0.05 [.064+.001/-0.002]	6.9
1.50mm2	1.50+0.03/-0.05 [.059+.001/-0.002]	8.2
16 AWG	1.47+0.03/-0.05 [.058+.001/-0.002]	8.5
1.00mm2	1.40+0.03/-0.05 [.055+.001/-0.002]	9.3

- 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.
 - SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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)

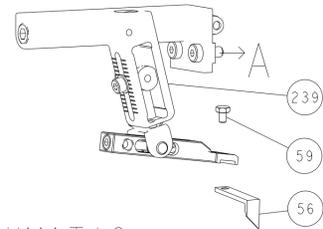
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	-	1	1	2119082-9	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	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	-	-	-	2266112	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	2	2	2119791-9	DEPRESSOR, WIRE	70
-	-	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	1338683-8	FEED PAWL	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	2-1752356-0	SUPPORT, TERMINAL	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	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1803293-8	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	1	1	3-240641-8	SPACER	7
-	-	-	-	-	-	6
-	-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803019-3	CRIMPER, INSULATION O	3
-	-	1	1	455888-7	SPACER, CRIMPER	2
-	-	1	1	4-1633713-2	CRIMPER, WIRE PREMIUM	1

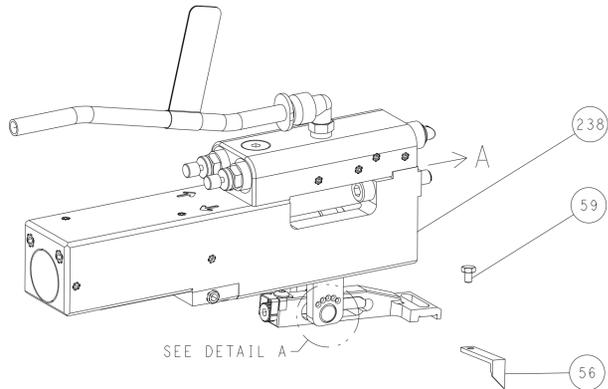
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	3	4	D	

LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	-	SEE SHEET 1	-	-

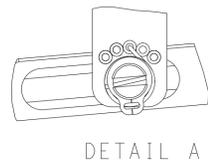
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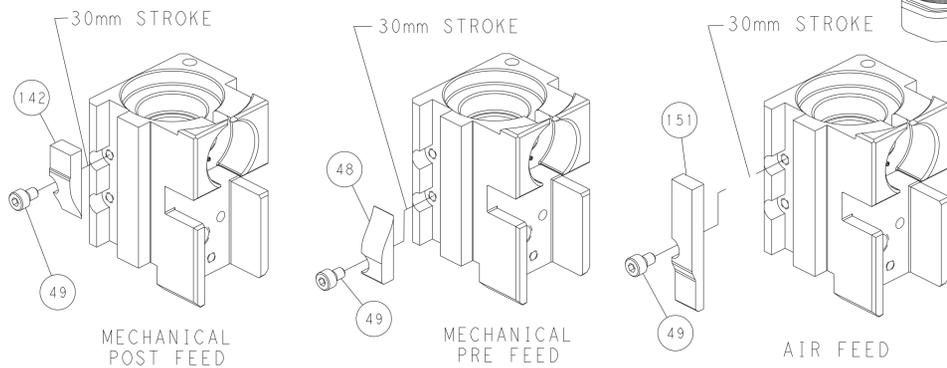
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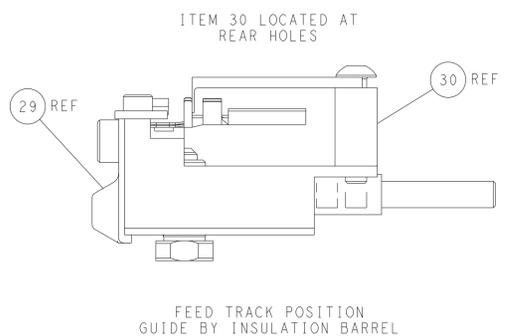
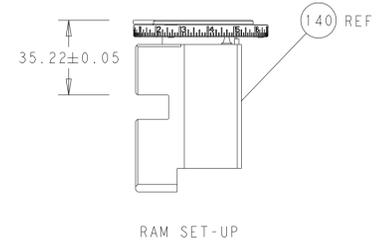
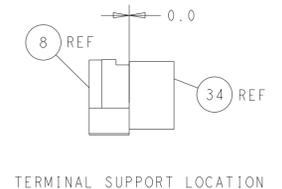
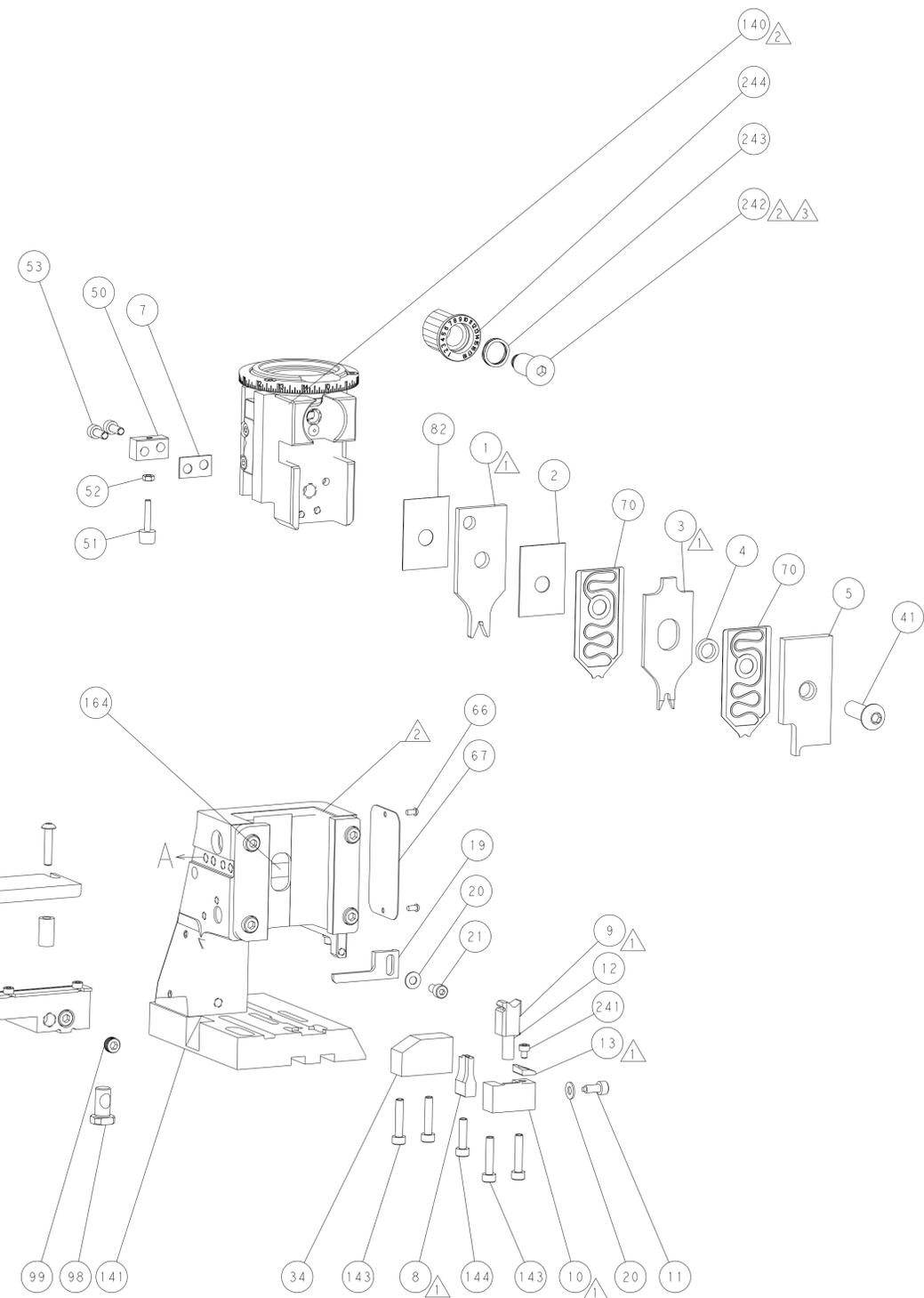
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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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