

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150406-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2150406-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150406-5	-	2168400-7 (QUANTITY 2)
	2150406-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-
	2150406-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2150406-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE WITH INSULATION SUPPORT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.54-6.35 mm [.218-.250 IN]		Ø4.00-4.50 mm [1.57-.177 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160921-1	160921-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.93+/-0.000 [.115+/- .000]	4.8
3.50mm2	2.83+/-0.000 [.111+/- .000]	6.1
3.00mm2	2.73+/-0.000 [1.107+/- .000]	7.1

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150406-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150406-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150406-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT.
- 12. TERMINAL LUBRICANT IS RECOMMENDED.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			1	ORIGINAL	20DEC2013	GH TE
			A	RELEASED	30JAN2014	GH TE

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119798-1	DETENT PIN	247
-	-	1	-	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	-	2	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF	REFREF	REFREF	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REFREF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	-	1	1	1	455888-4	SPACER, CRIMPER	82
-	-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	-	1	-	-	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	-	1	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	-	1	-	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	1	-	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	1	1	1	2119644-3	RAM WASHER, PRECISION	38
-	-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	-	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	-	2	2	2	1320906-1	STUD, THREADED	25
-	-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	-	1	1	1	1752373-4	DRAG	20
-	-	1	1	1	2-1901696-1	STRIP GUIDE, REAR	19
-	-	1	1	1	2-1901695-1	STRIP GUIDE, FRONT	18
-	-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	-	1	1	1	3-240641-7	SPACER	16
-	-	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	-	1	1	1	6-690482-3	PLATE, FRONT SHEAR	9
-	-	1	1	1	3-1333223-1	ANVIL, COMBINATION	8
-	-	1	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	-	1	1	1	6-240641-0	SPACER	5
-	-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	-	1	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	1	1-455888-7	SPACER, CRIMPER	2
-	-	1	1	1	456414-5	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

**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 ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH
MATERIAL				FINISH		WEIGHT	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 OF 4	

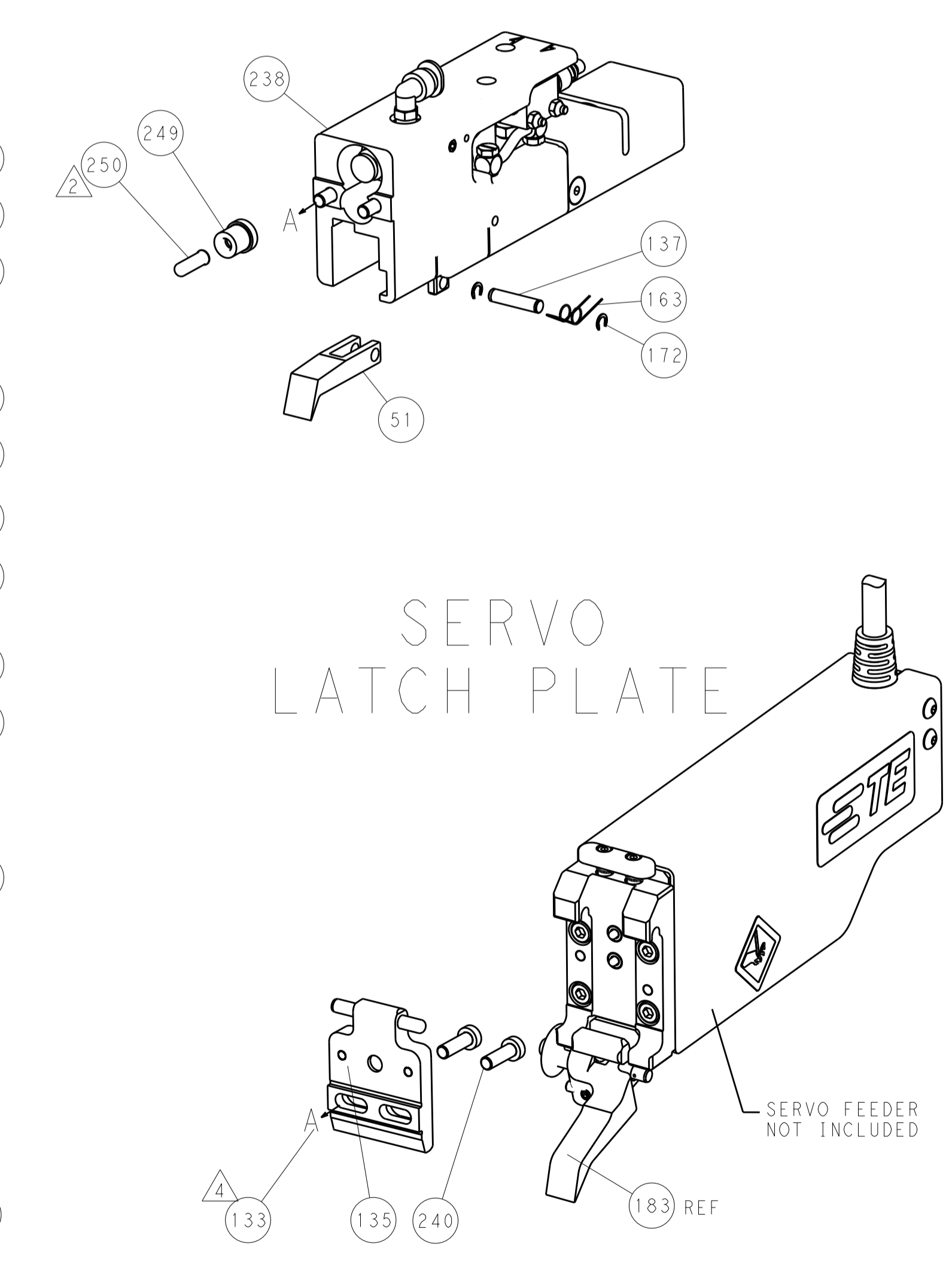
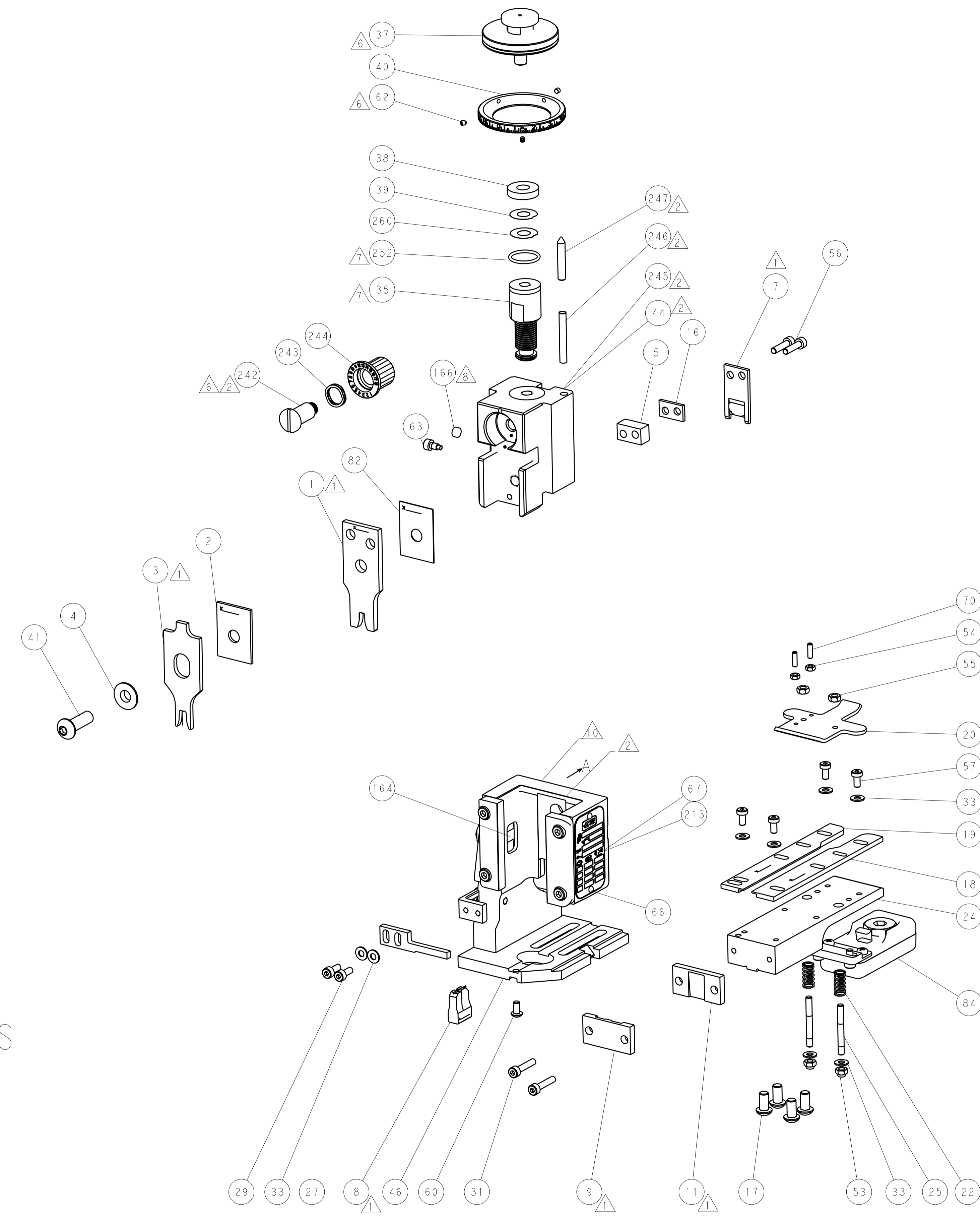
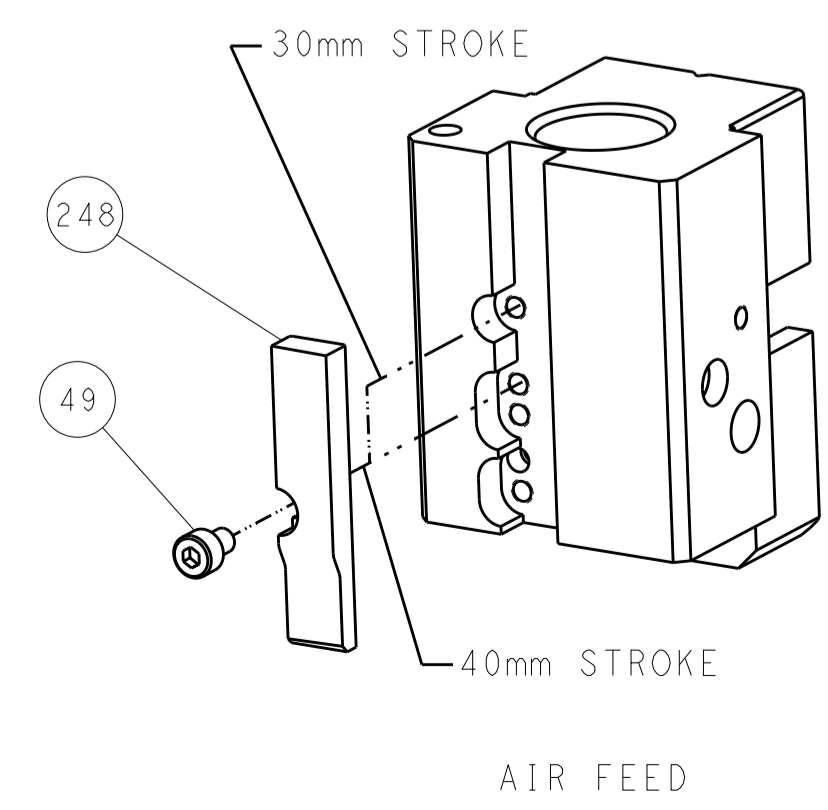
LOC	DIST	REV	DATE	BY	APPV
A	66				

### FEED TYPE

### PNEUMATIC

### SERVO LATCH PLATE

### CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: HOFFNER 20DEC2013 CHK: T. ELBIN 23DEC2013 APVD: T. ELBIN 23DEC2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.013 3 PLC ±0.001 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150406 RESTRICTED TO:
MATERIAL:		FINISH:	SCALE: 1:1 SHEET 2 OF 4 REV A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150406-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150406-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150406-4	-	-
	2-2150406-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-
2-2150406-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150406-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [ .160 ]	F
INSUL	5.59 mm [ .220 ]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE WITH INSULATION SUPPORT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.54-6.35 mm [ .218-.250 IN ]		4.00-4.50 mm [ .157-.177 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED <sup>10</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160921-1	160921-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
4.00mm2	2.93 +/- 0.000 [ .115 +/- .000 ]	4.8
3.50mm2	2.83 +/- 0.000 [ .111 +/- .000 ]	6.1
3.00mm2	2.73 +/- 0.000 [ .107 +/- .000 ]	7.1

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150406-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150406-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11. TERMINAL LUBRICANT IS RECOMMENDED.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

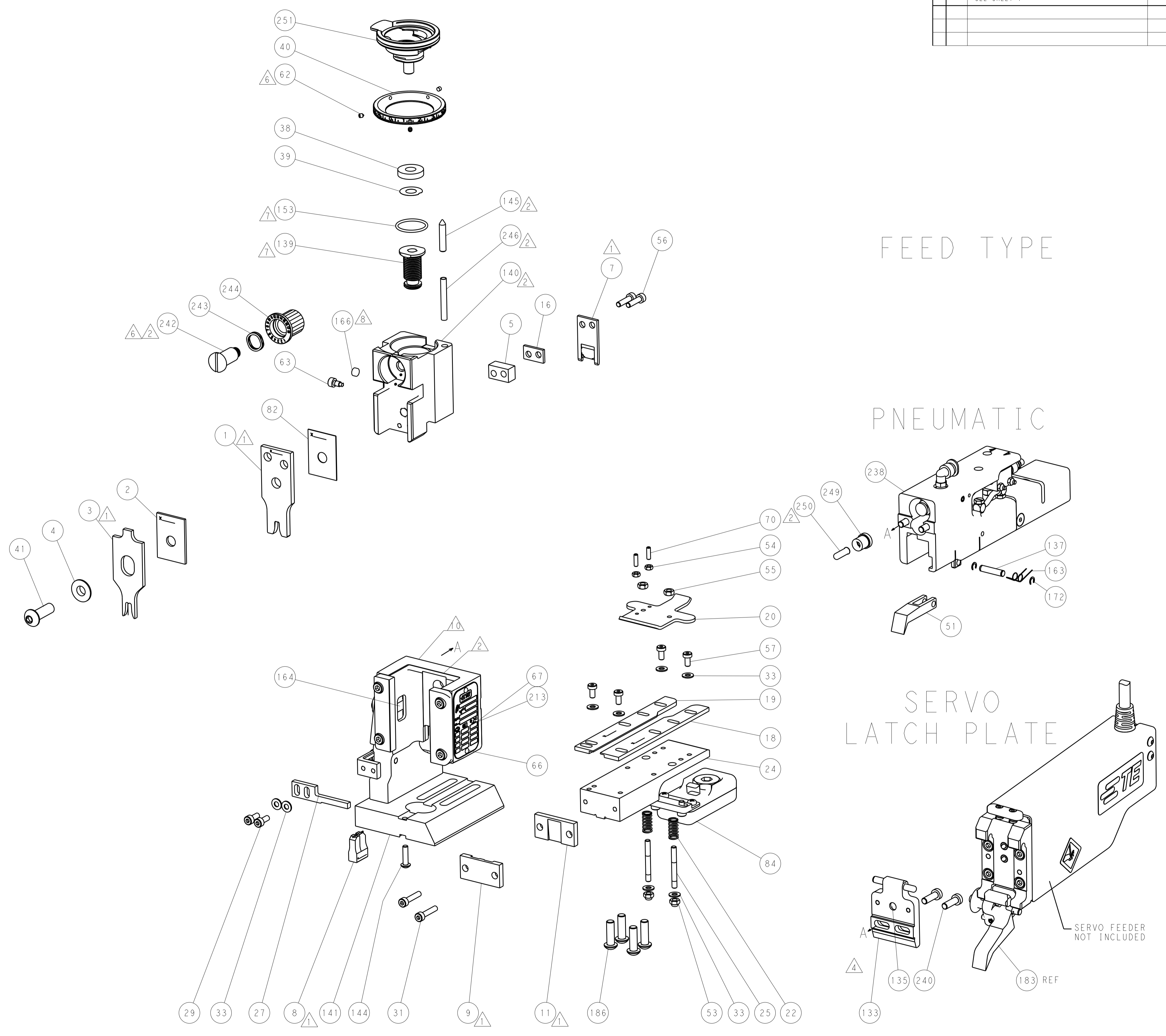
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

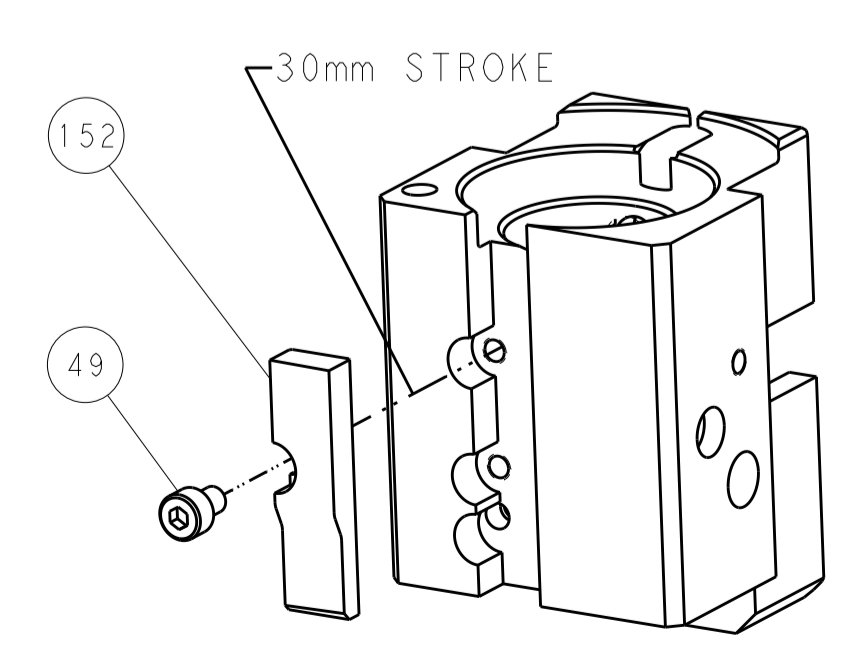
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153	
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70	
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55	
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	-	-	1	2119792-2	PAWL, EF, AIR	51	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	2119644-3	RAM WASHER, PRECISION	38	
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	690455-1	STRIPPER, FRONT CASTING	27	
-	2	2	2	1320906-1	STUD, THREADED	25	
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1752373-4	DRAG	20	
-	1	1	1	2-1901696-1	STRIP GUIDE, REAR	19	
-	1	1	1	2-1901695-1	STRIP GUIDE, FRONT	18	
-	1	1	1	3-240641-7	SPACER	16	
-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	10	
-	1	1	1	6-690482-3	PLATE, FRONT SHEAR	9	
-	1	1	1	3-1333223-1	ANVIL, COMBINATION	8	
-	1	1	1	1-2217206-2	BLADE, SLUG	7	
-	-	-	-	-	-	6	
-	1	1	1	6-240641-0	SPACER	5	
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1-455888-7	SPACER, CRIMPER	2	
-	1	1	1	456414-5	CRIMPER, WIRE	1	
-	77	27	25	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013
	ANGLES ±.0001				
MATERIAL:		FINISH:		WEIGHT:	
				A1 00779 ©=2150406	
Customer Accessible Production Drawing				SCALE	SHEET 3 OF 4
				REV	A

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



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: HOFFNER 20DEC2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: T. ELBIN 23DEC2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.5		APPV: T. ELBIN 23DEC2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.13		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±0.013		APPLICATION SPEC:		RESTRICTED TO:	
R		4 PLC ±0.001		WEIGHT:		A1 00779 C=2150406	
ANGLES:		FINISH:		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV A	