

ATLANTIC VERSION TERMINATOR
 INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151559-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151559-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151559-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151559-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151559-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151559-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151559-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.70-4.30 mm [.146-.169 IN]	Ø1.20-1.40 mm [.047-.055 IN]

TERMINAL APPLICATION SPECIFICATION (A)114-18148 (B)114-18144-0

TERMINALS APPLIED

TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
(A) 1-968882-1	(A) 1-968882-3	828904-1	828904-3
(A) 1-968882-2	(B) 967541-1	828904-2	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.70-4.30 mm [.146-.169 IN]	Ø1.20-1.40 mm [.047-.055 IN]

TERMINAL APPLICATION SPECIFICATION 114-18148-PSA

TERMINALS APPLIED

TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
1-968882-1	1-968882-3	828904-1	828904-3
1-968882-2		828904-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.08+/-0.03 [.043+/- .001]	6.3
0.30mm2	1.01+/-0.03 [.040+/- .001]	7.1
22 AWG	0.97+/-0.05 [.038+/- .002]	7.6
24 AWG	0.92+/-0.03 [.036+/- .001]	8.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.14+/-0.03 [.045+/- .001]	5.7
0.35mm2	1.08+/-0.03 [.043+/- .001]	6.3

- 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 TORQ-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.
- 7. APPLICATION SPECIFICATION 114-18148-PSA IS RESTRICTED TO PEUGEOT CITROËN AND ITS HARNESS MAKERS.
- 8. TERMINAL LUBRICANT IS RECOMMENDED.
- 9. WIRE TYPES CAVS, AESSX-F.

***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)

LOC	DIST	REV	DATE	BY	CHK
A	66	E	12APR2022	JWC	TE
		E1	28JUL2022	FJ	YY
		F	22AUG2022	FJ	JAH
		F1	14NOV2022	FZ	GB

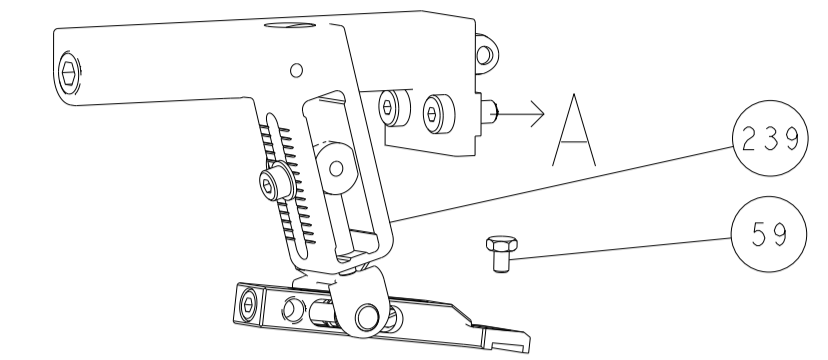
-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	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	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	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	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	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1-1333202-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

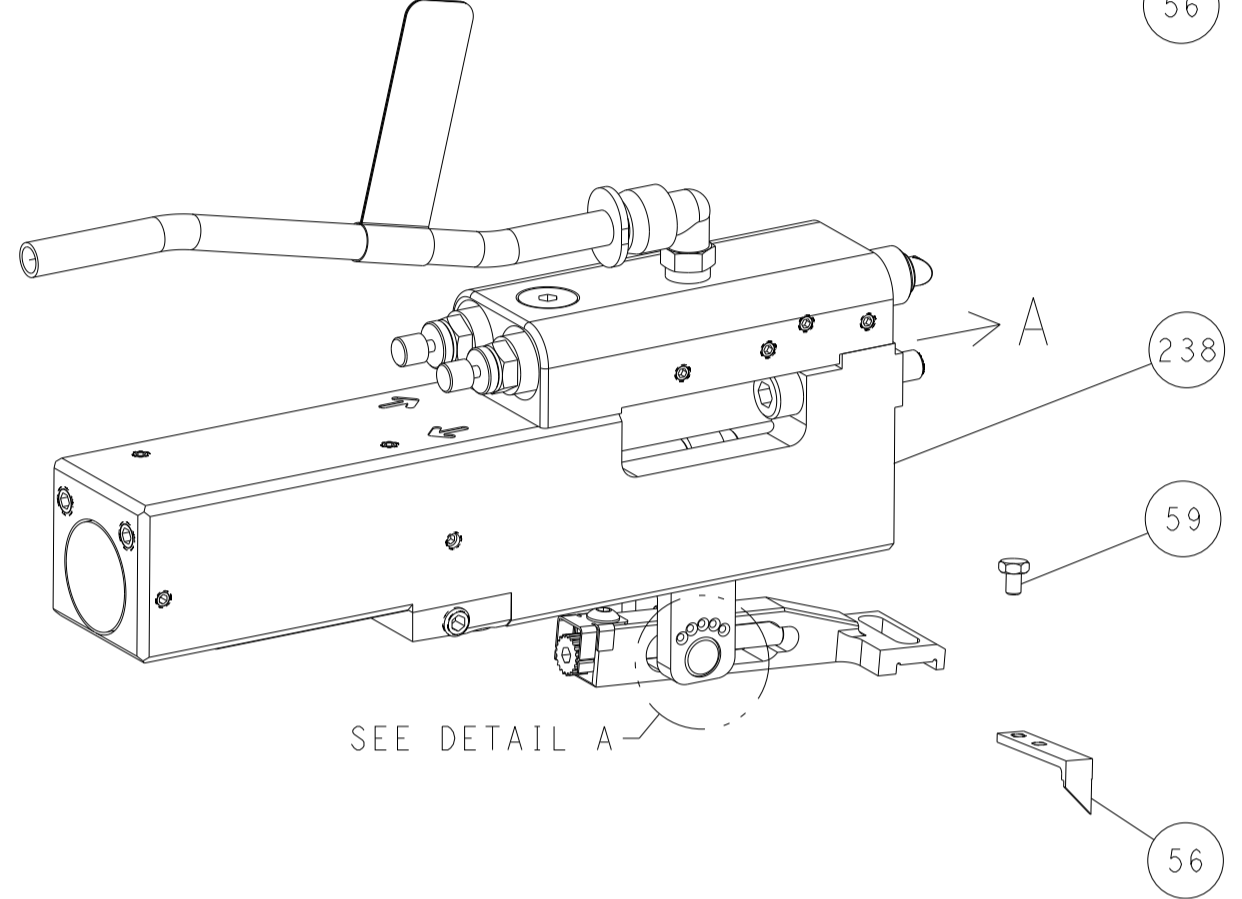
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	OWN: H. HUANG 03DEC2012	TE Connectivity
CHK: S.XI 03DEC2012	DATE: 03DEC2012	Harrisburg, PA 17105-3608
APVD: S.XI 03DEC2012	NAME: Ocean Side Feed	
DIMENSIONS: mm	PRODUCT SPEC	Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPLICATION SPEC	
0 PLC ±		
1 PLC ±		
2 PLC ±		
3 PLC ±		
4 PLC ±		
ANGLES °		
FINISH		
MATERIAL	WEIGHT	RESTRICTED TO
	A1 00779 ©=2151559	
Customer Accessible Production Drawing	SCALE: 1:2	SHEET 1 OF 4 REV: F1

LOC	DIST	REV	DATE	BY	APPV
A	66				

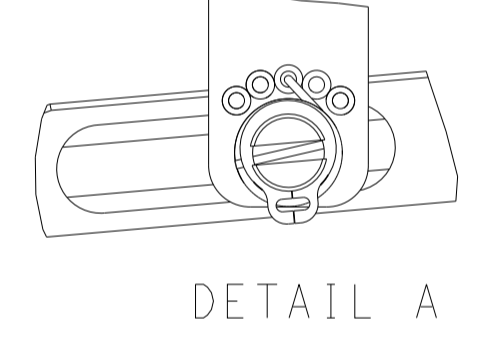
FEED TYPE MECHANICAL



PNEUMATIC

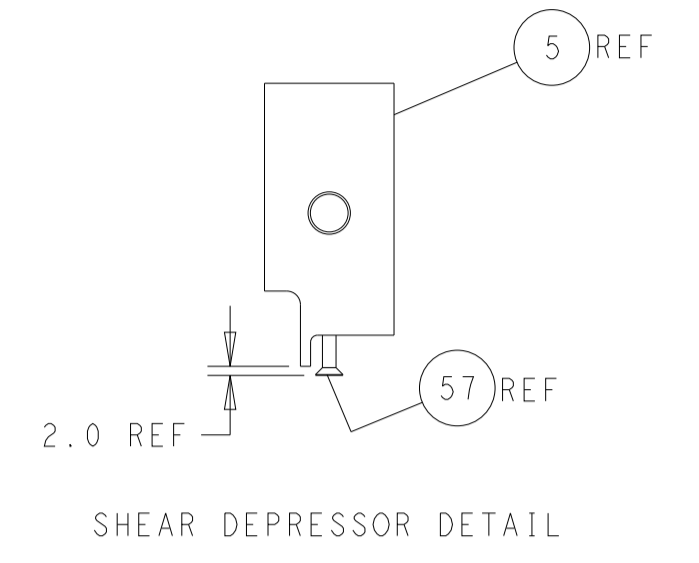
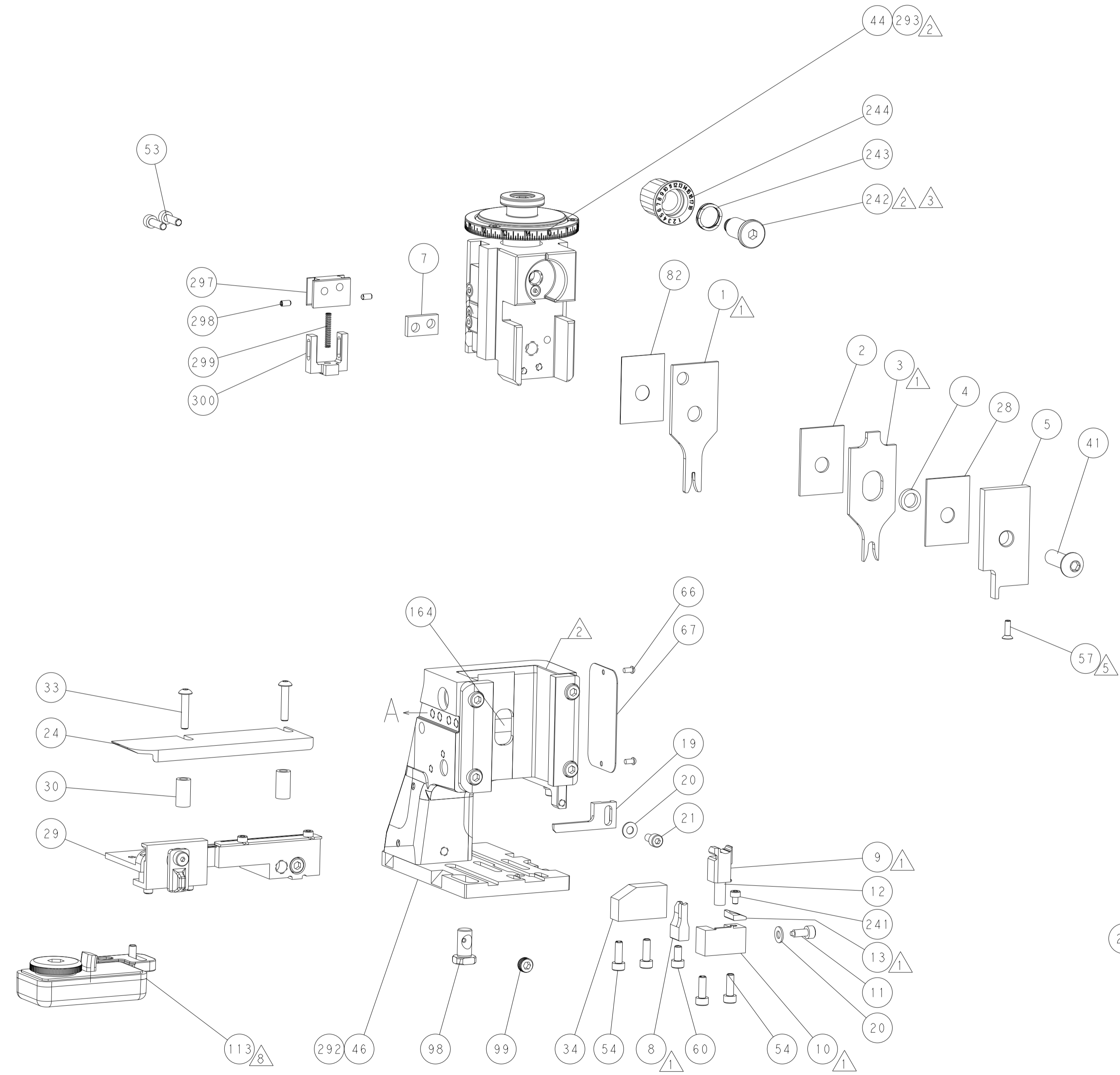
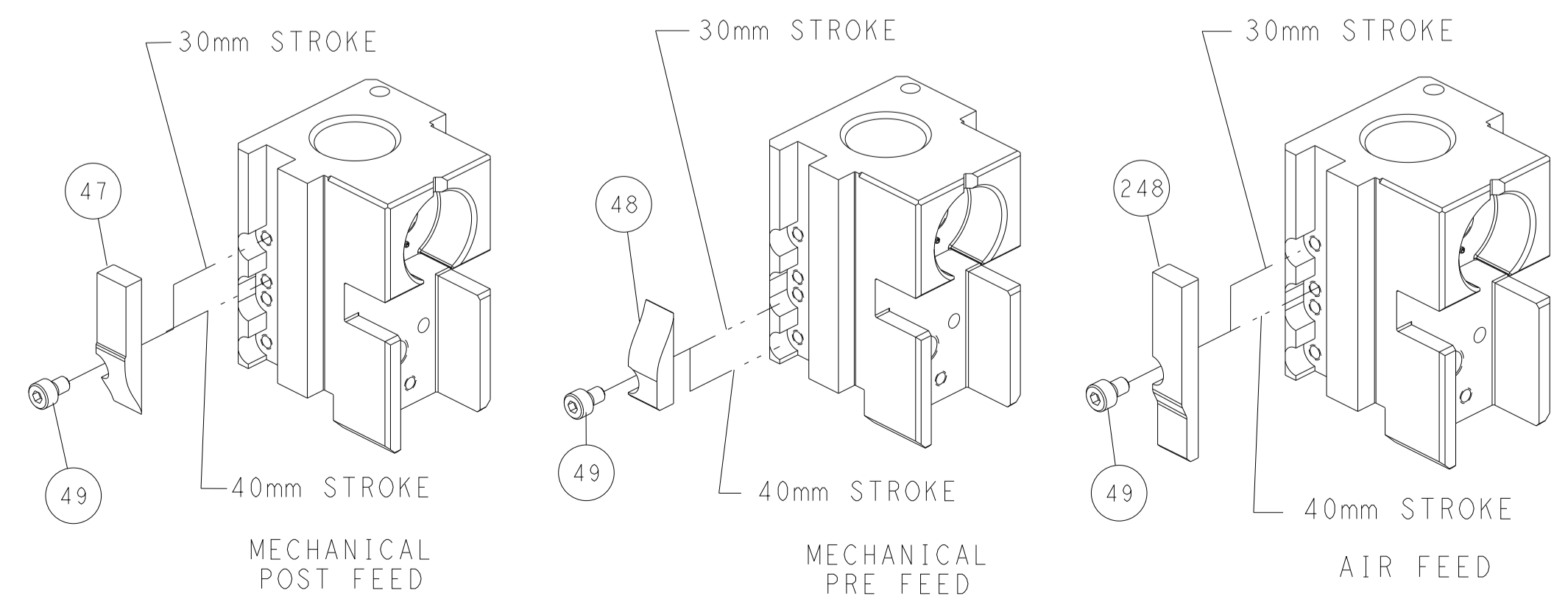


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

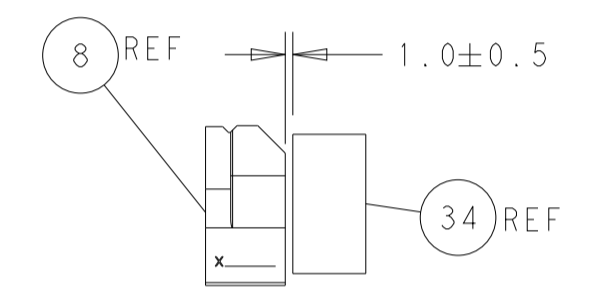


DETAIL A

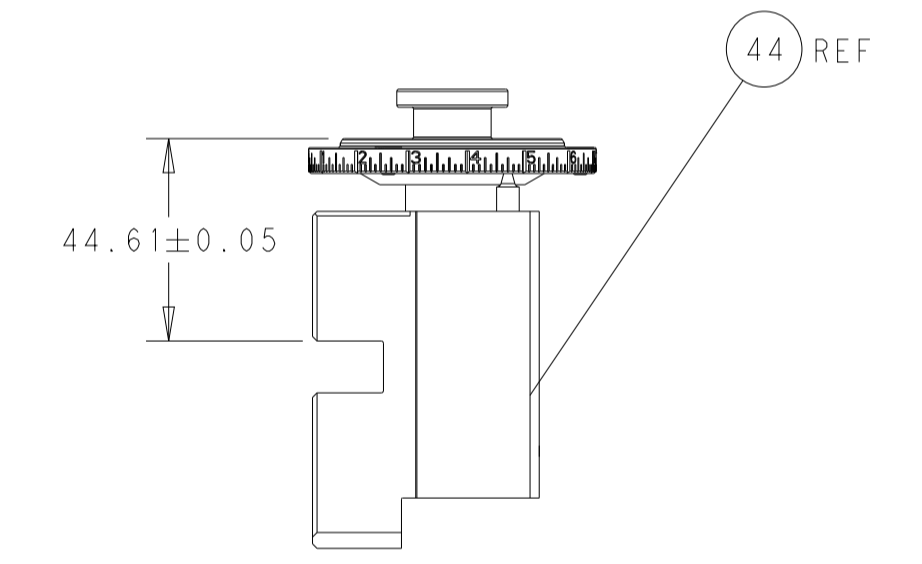
CAM POSITIONS



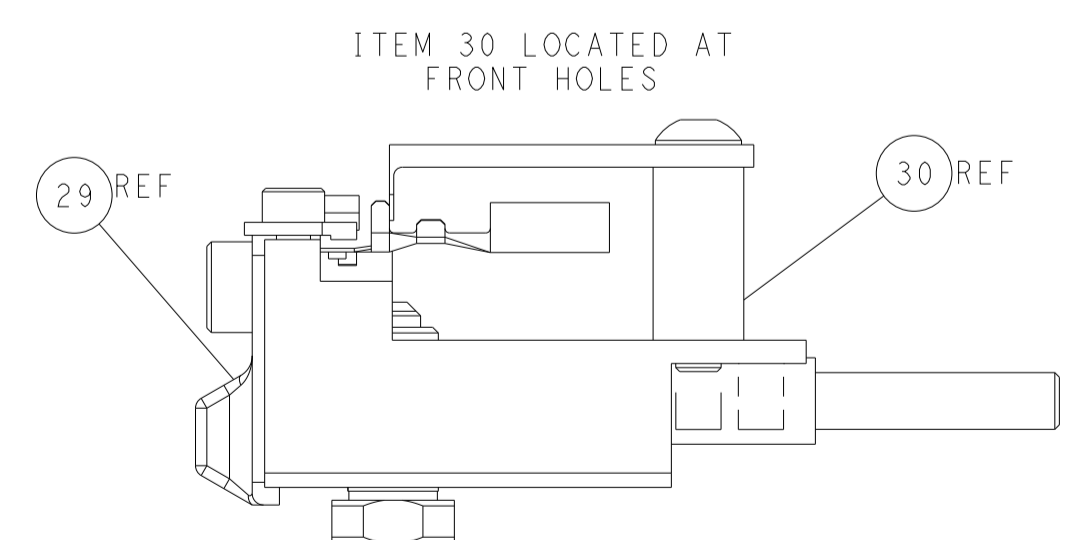
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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	±		H. HUANG	03DEC2012	TE Connectivity	
	1 PLC	±		S. XI	03DEC2012	Harrisburg, PA 17105-3608	
	2 PLC	±		S. XI	03DEC2012	NAME	
	3 PLC	±				Ocean Side Feed	
	4 PLC	±				Applicator	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				A1	00779
						DRAWING NO	©=2151559
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE
						1:2	SHEET 2 OF 4
							REV F1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151559-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151559-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151559-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.70-4.30 mm [.146-.169 IN]	Ø1.20-1.40 mm [.047-.055 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-18148	-	-
	(B)114-18144-0	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
(A) 1-968882-1	(A) 1-968882-3	828904-1	828904-3	1.2- 2.1mm
(A) 1-968882-2	(B) 967541-1	828904-2		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.70-4.30 mm [.146-.169 IN]	Ø1.20-1.40 mm [.047-.055 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18148-PSA	-	-
		-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1-968882-1	1-968882-3	828904-1	828904-3	1.2- 2.1mm
1-968882-2		828904-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.08+/-0.03 [.043+/-0.001]	6.3
0.30mm2	1.01+/-0.03 [.040+/-0.001]	7.1
22 AWG	0.97+/-0.05 [.038+/-0.002]	7.6
24 AWG	0.92+/-0.03 [.036+/-0.001]	8.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.14+/-0.03 [.045+/-0.001]	5.7
0.35mm2	1.08+/-0.03 [.043+/-0.001]	6.3

- 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.
- 7 APPLICATION SPECIFICATION 114-18148-PSA IS RESTRICTED TO PEUGEOT CITROËN AND ITS HARNESS MAKERS.
- 8 TERMINAL LUBRICANT IS RECOMMENDED.
- 9 WIRE TYPES CAVS, AESSX-F.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151559-1	2151559-1	1	WIRE CRIMPER	1-1803547-3
8-2151559-2	2151559-2	3	INSULATION CRIMPER	2-1803604-9
9-2151559-1	2-2151559-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151559-2	2-2151559-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

***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	1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	2119082-3	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	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
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	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	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	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	1-1333202-5	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

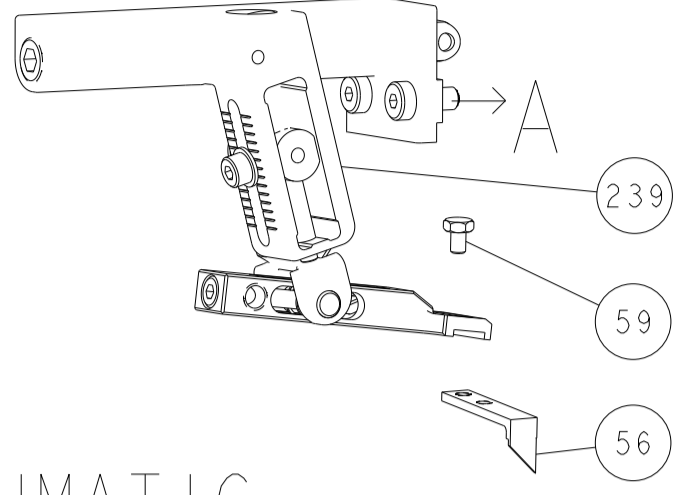
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		DESCRIPTION		ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	
	ANGLES	FINISH						
MATERIAL				WEIGHT				

CHK	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
H. HUANG	03DEC2012	S. XI	A1	00779	2151559	

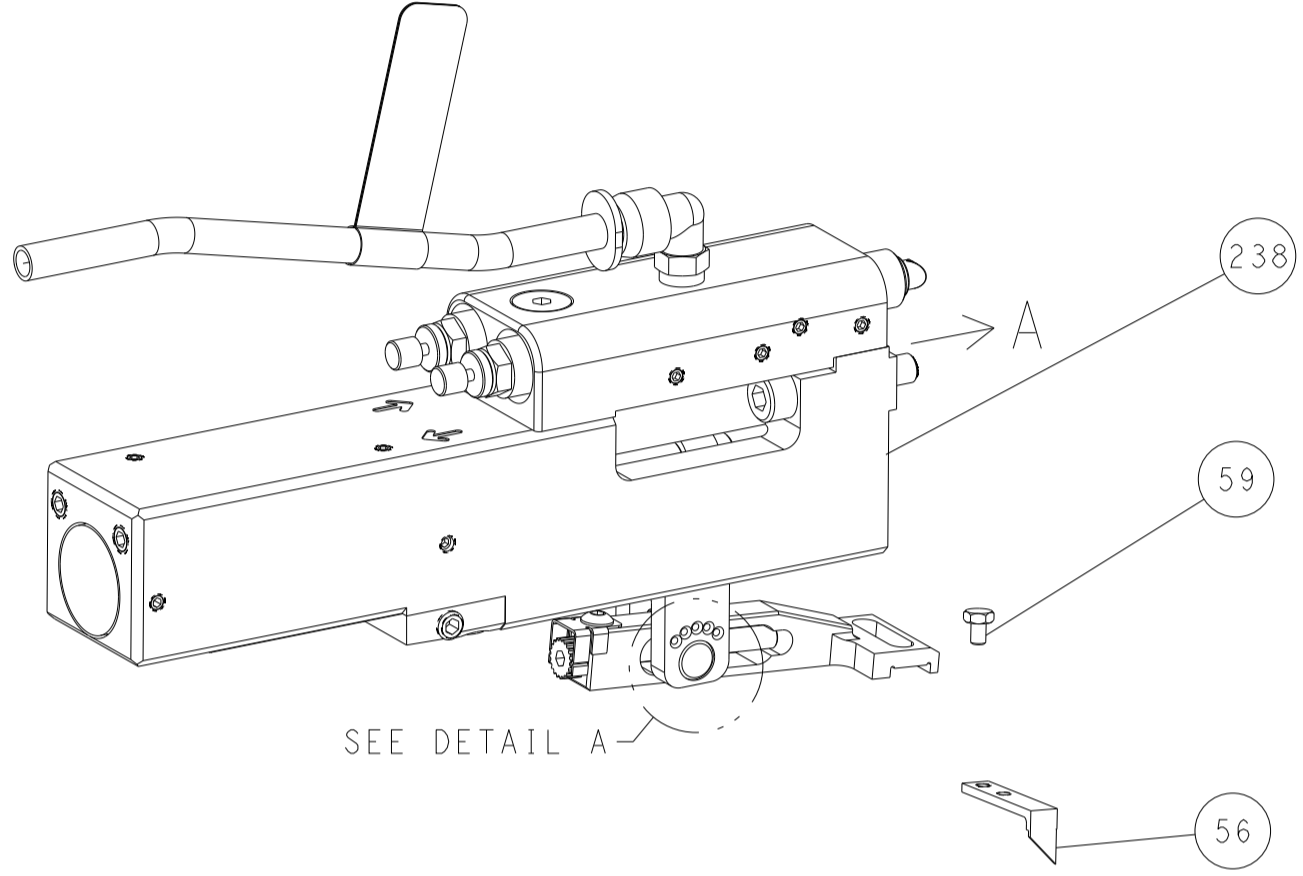
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV F1

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
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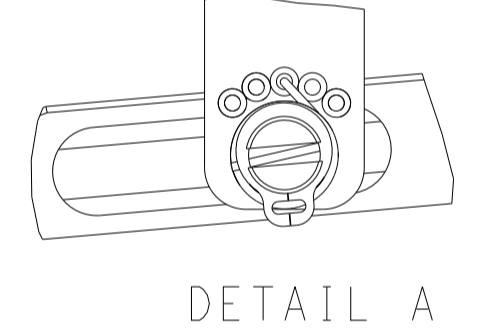
FEED TYPE MECHANICAL



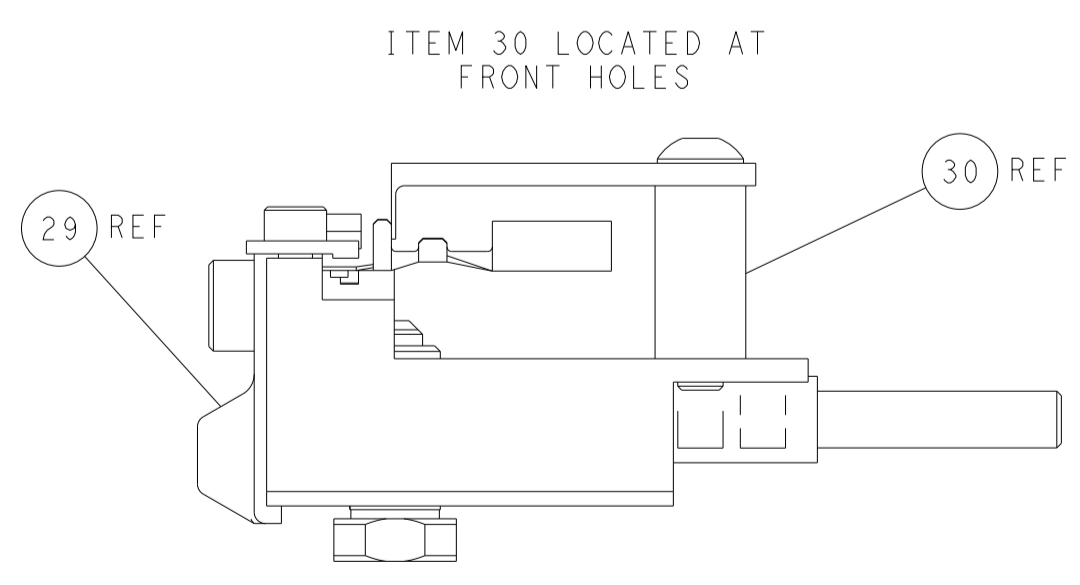
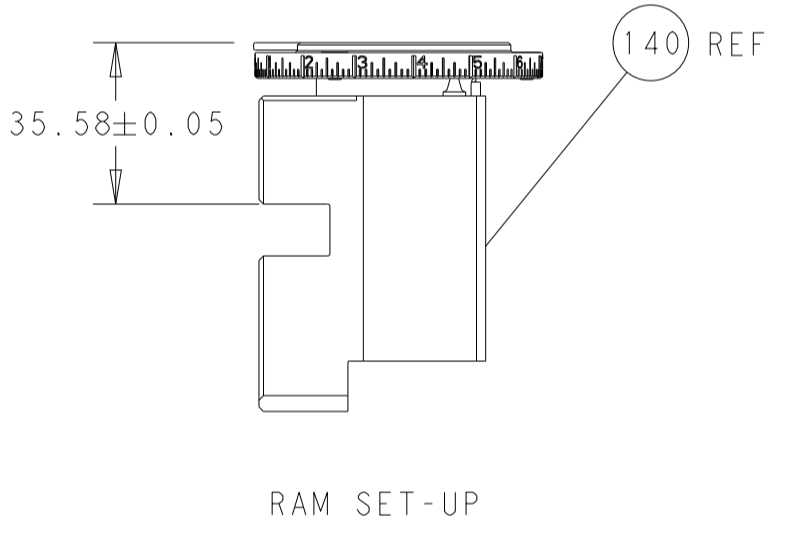
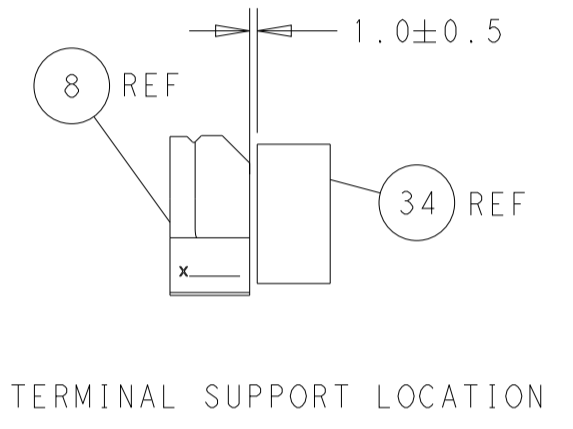
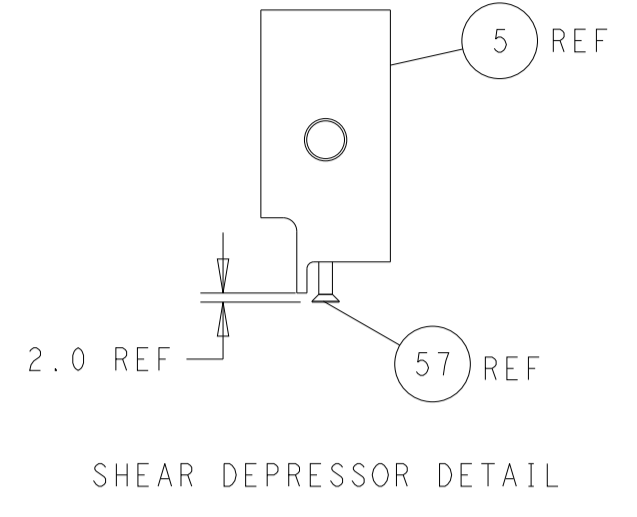
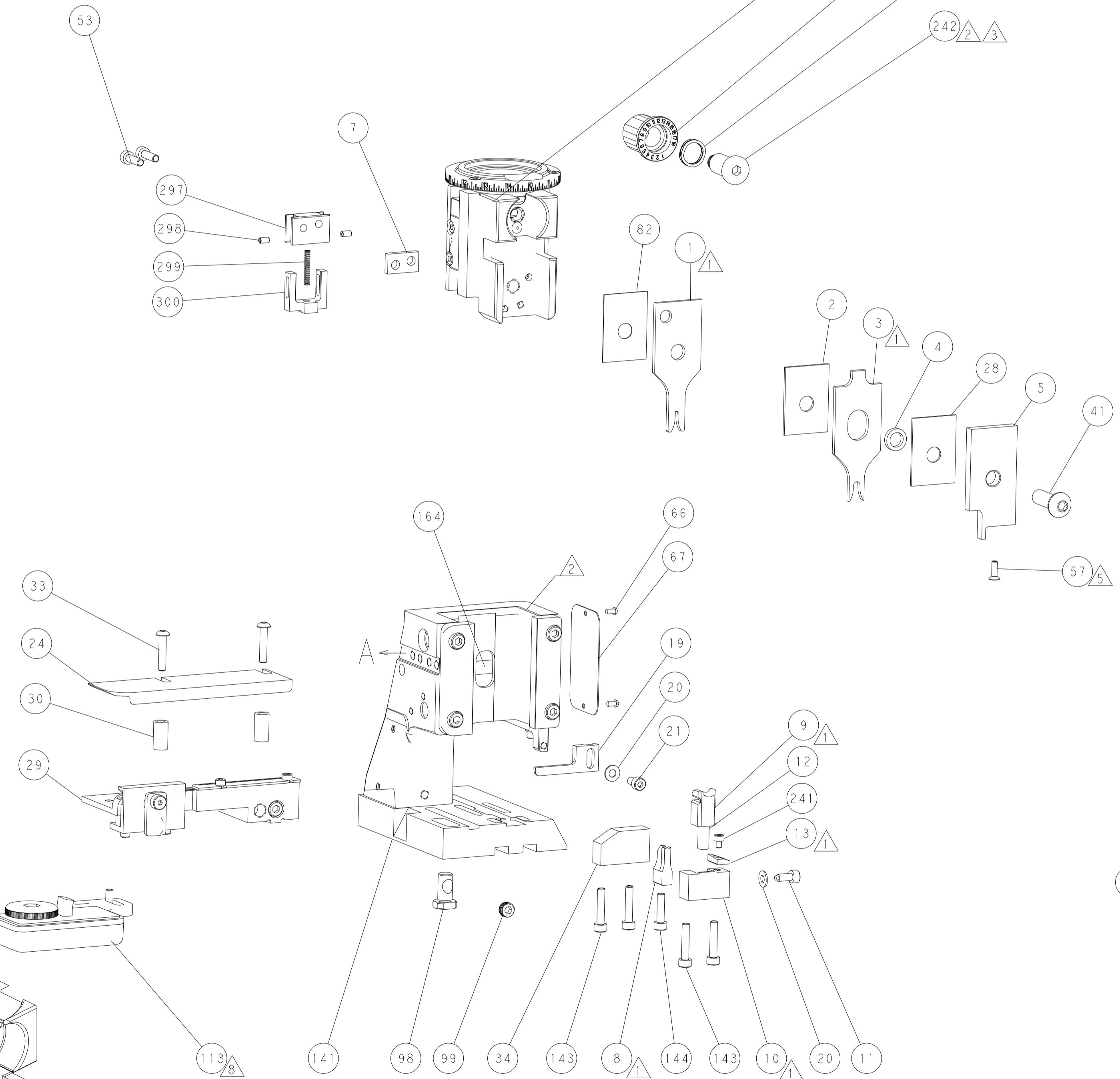
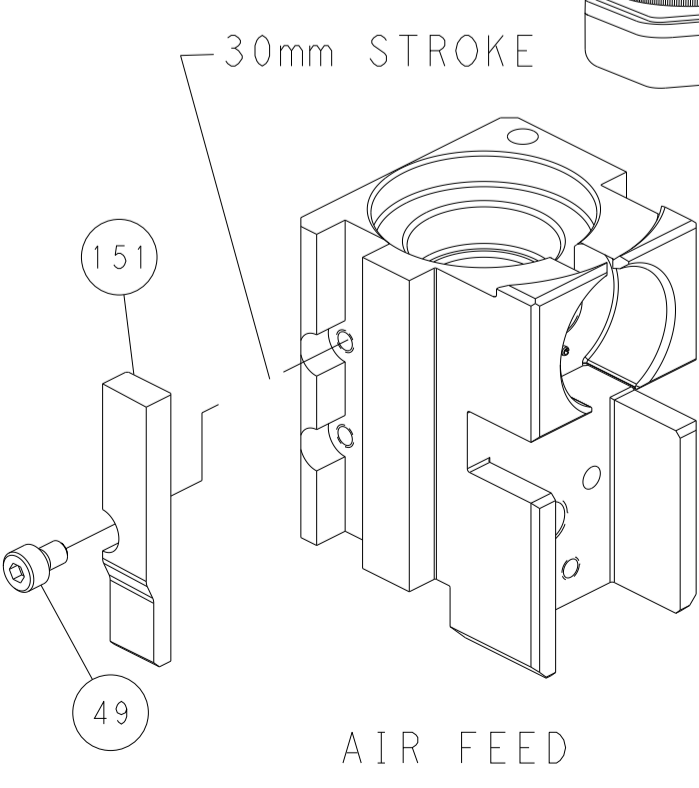
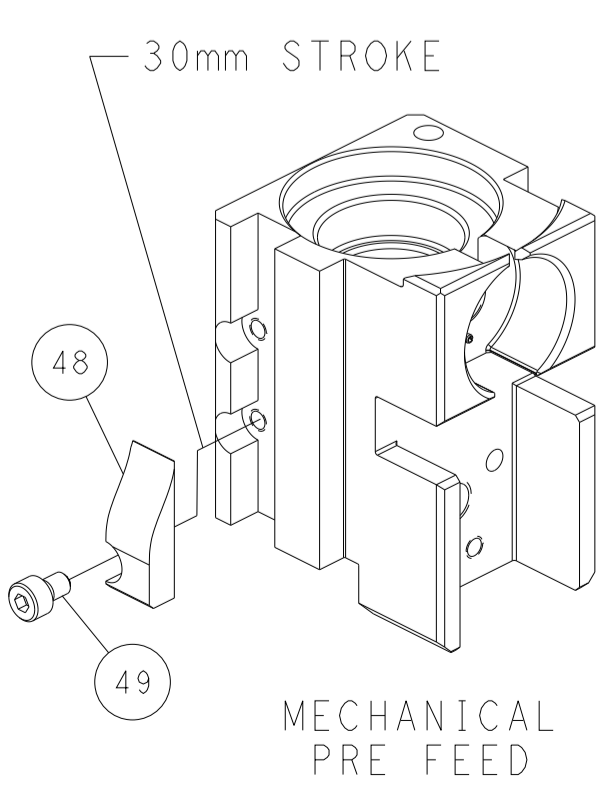
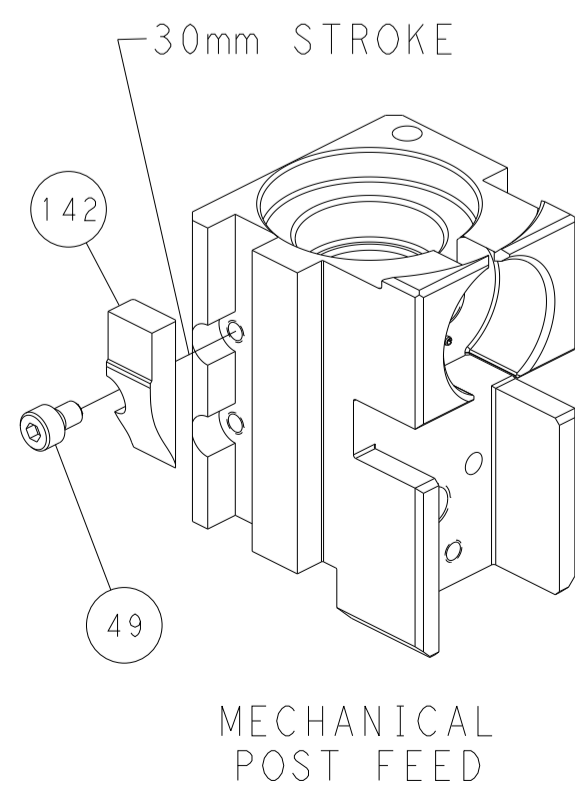
PNEUMATIC



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151559 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: 1