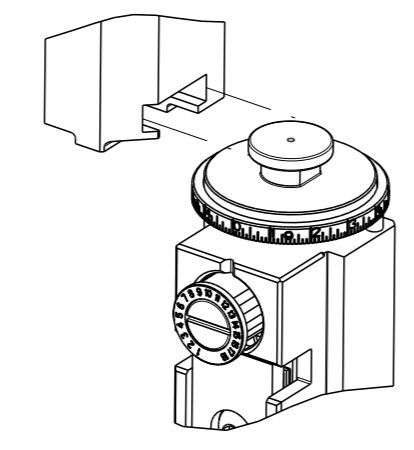


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2151133-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151133-2 | F | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151133-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 2.79 mm [.110] | OV |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---------------------------------------|------------------------------|------------------------|--------------|
| TERMINAL NAME: STANDARD TIMER CONTACT | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.90-4.50 mm [.154-.177 IN] | Ø1.40-2.30 mm [.055-.091 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-18079 | (B)114-18080 | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 927845-1 | (B) 927847-1 | (B) 928753-3 | (B) 964201-2 |
| (A) 927845-2 | (B) 927847-2 | (B) 928820-1 | (B) 964201-3 |
| (A) 927845-3 | (B) 927847-3 | (B) 928820-2 | (B) 964201-4 |
| (A) 927845-4 | (B) 928753-1 | (B) 928820-3 | |
| (A) 927845-5 | (B) 928753-2 | (B) 964201-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.00mm2 | 1.36+/-0.05 [.054+/-0.002] | 8.2 |
| 0.85mm2 | 1.31+/-0.05 [.052+/-0.002] | 8.7 |
| 18 AWG | 1.29+/-0.05 [.051+/-0.002] | 9.0 |
| 0.75mm2 | 1.27+/-0.05 [.050+/-0.002] | 9.2 |
| 0.70mm2 | 1.25+/-0.05 [.049+/-0.002] | 9.3 |
| 20 AWG | 1.19+/-0.05 [.047+/-0.002] | 10.4 |
| 0.50mm2 | 1.18+/-0.05 [.046+/-0.002] | 10.4 |

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 | LYH | DESCRIPTION | DATE | OWN | APVD |
| | | C | | ECR-18-007838 | 22MAY2018 | VLA | JDG |
| | | D | | ECR-19-006810 | 29APR2019 | MZ | YY |
| | | E | | ECR-19-009011 | 07JUN2019 | TB | TE |
| | | F | | ECR-20-006216 | 29APR2020 | LG | TE |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 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 | 1 | 2844940-2 | AIR FEED MODULE | 238 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-5 | 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 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 1803382-6 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1 | 1803583-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | 1 | 1803515-1 | RAM ASSEMBLY, SF ATLANTIC | 44 |
| - | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1752356-6 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | 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 |
| - | 1 | 1 | 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 | 2 | 1-1333204-0 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 3-240641-7 | SPACER | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1-238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 1-2119785-0 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 1-456405-5 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | -72 | -2 | PART NO | ITEM NO |

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

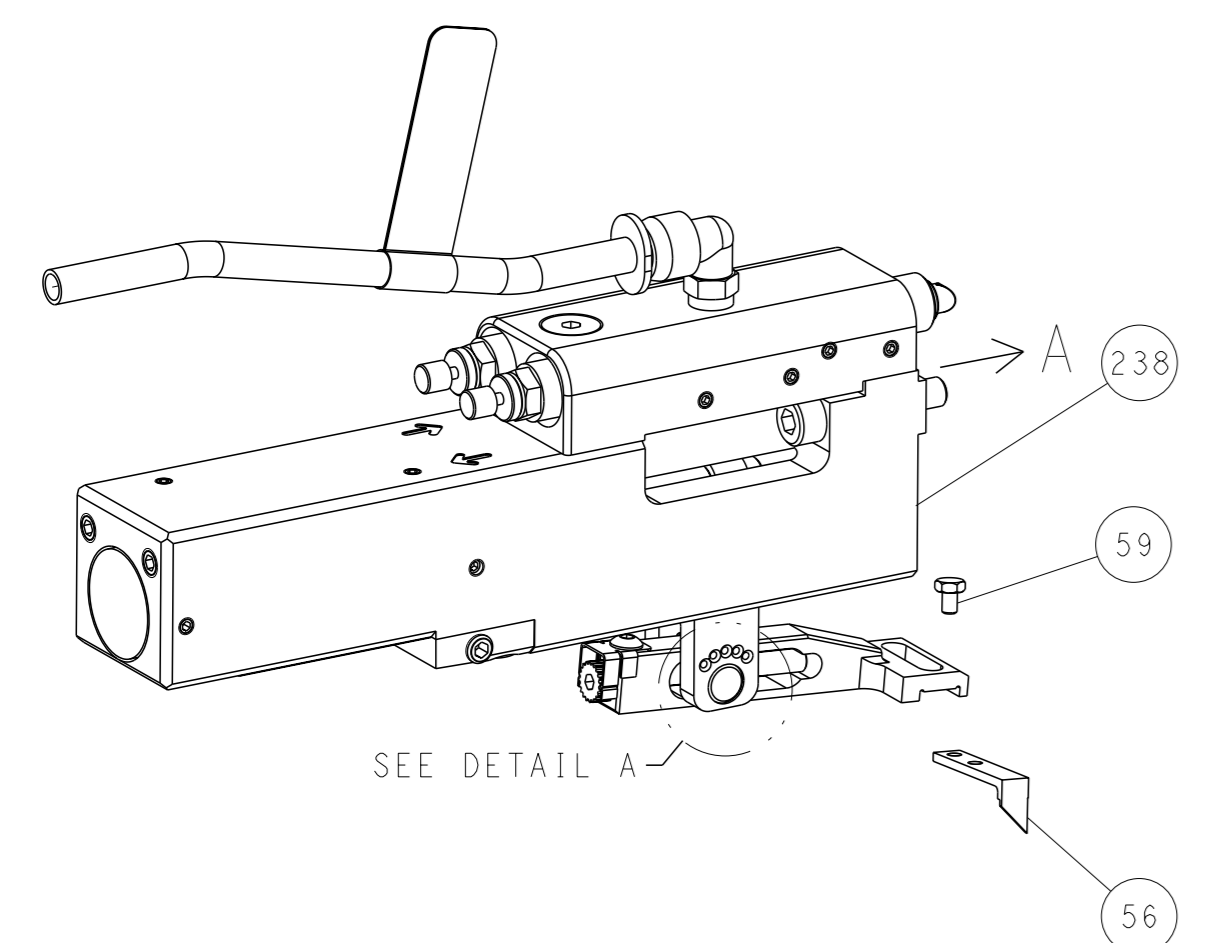
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|-------------|---------|--|---------|-----------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | ANGLES | FINISH | | | |

| | | | |
|--|-----------|------------|------------------------------|
| OWN | Y. YIN | 18OCT2011 | |
| CHK | G. BAILEY | 18OCT2011 | |
| APVD | S. YI | 18OCT2011 | |
| PRODUCT SPEC | | | |
| APPLICATION SPEC | | | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2151133 | |
| Customer Accessible Production Drawing | | | SCALE 1:2 SHEET 1 OF 4 REV F |

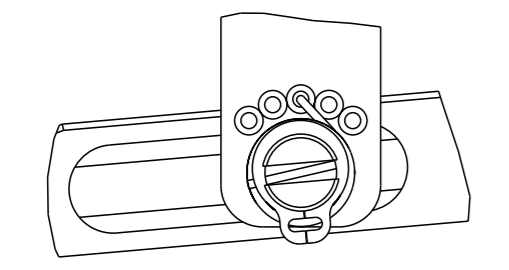
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FEED TYPE

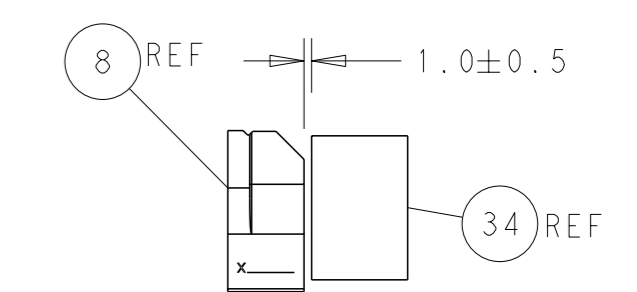
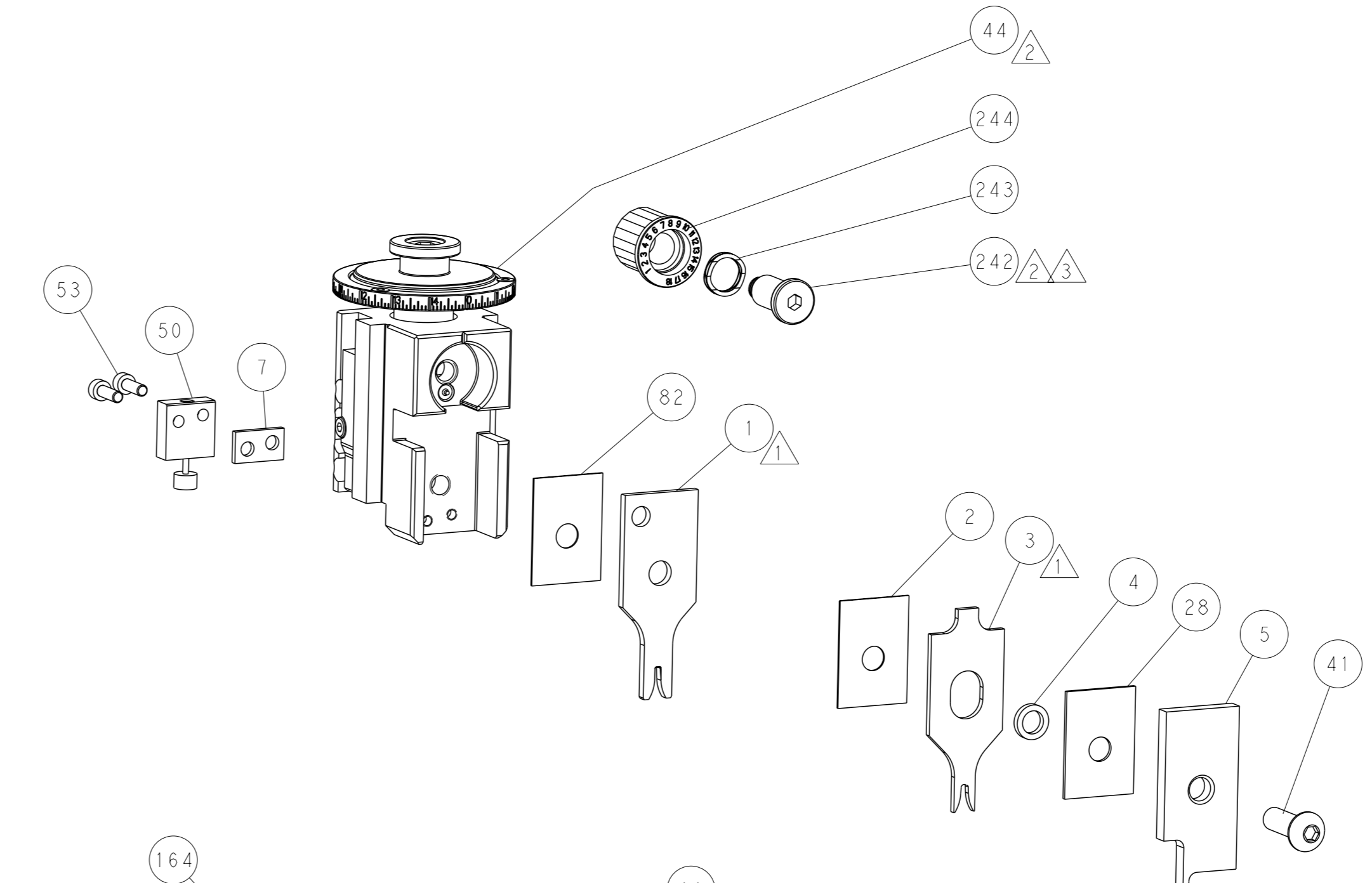
PNEUMATIC



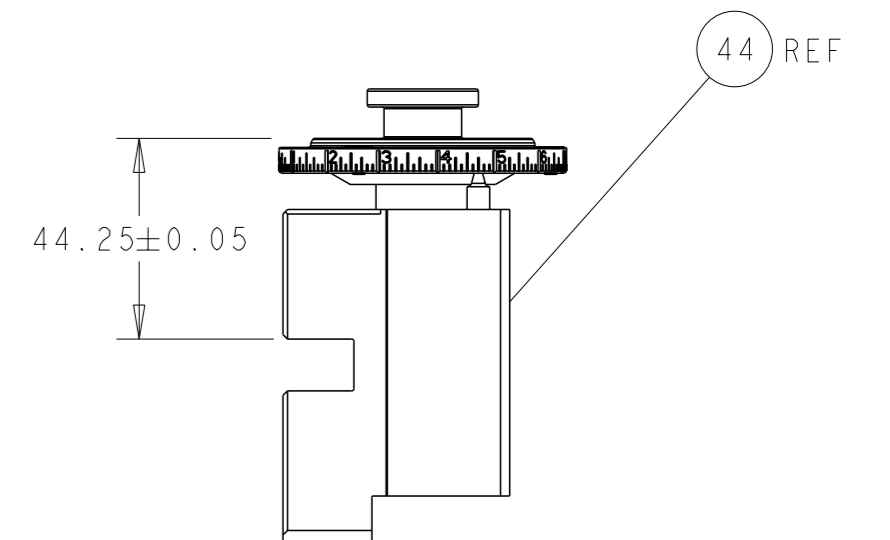
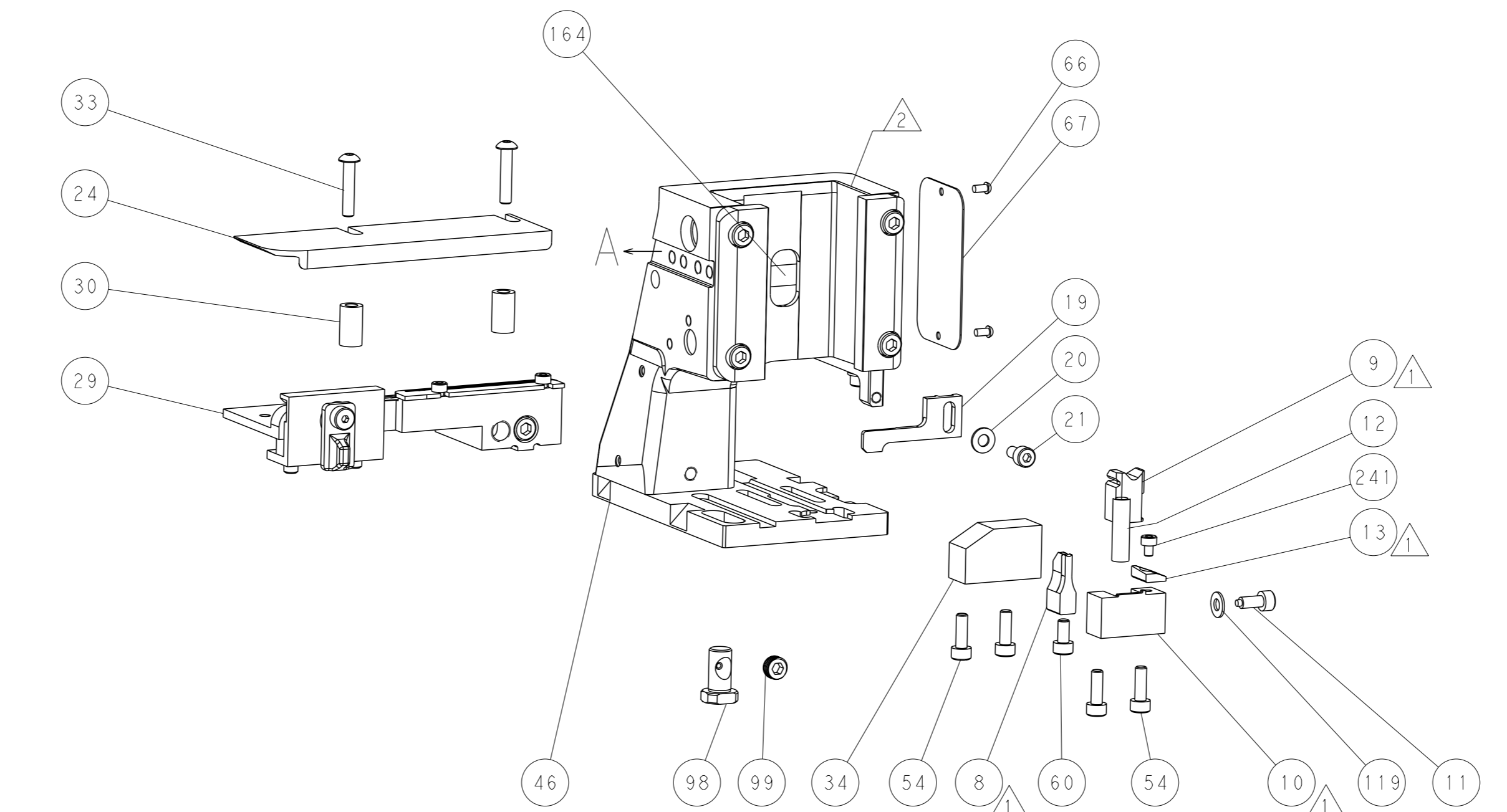
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

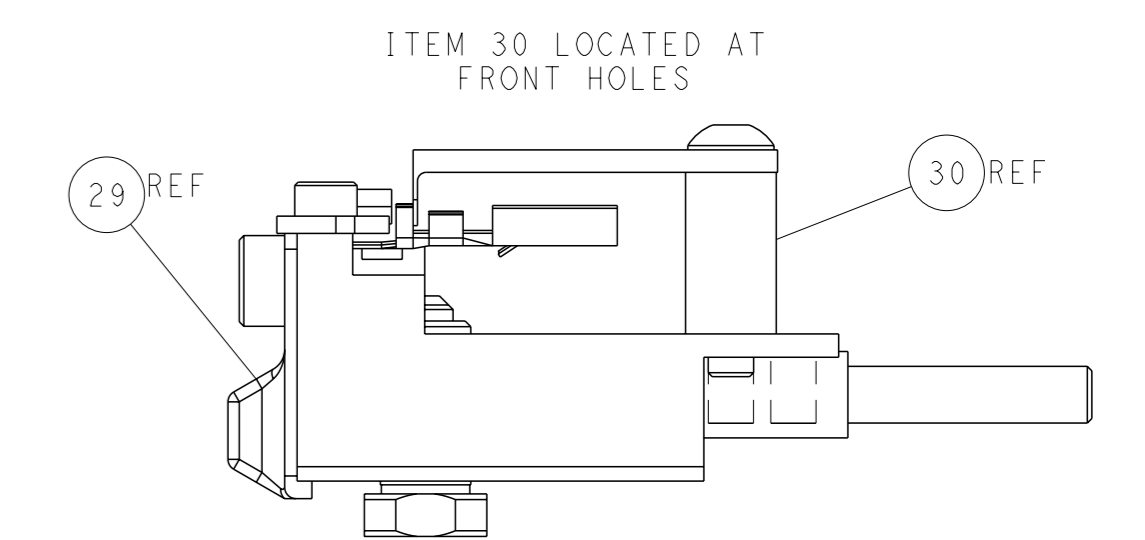
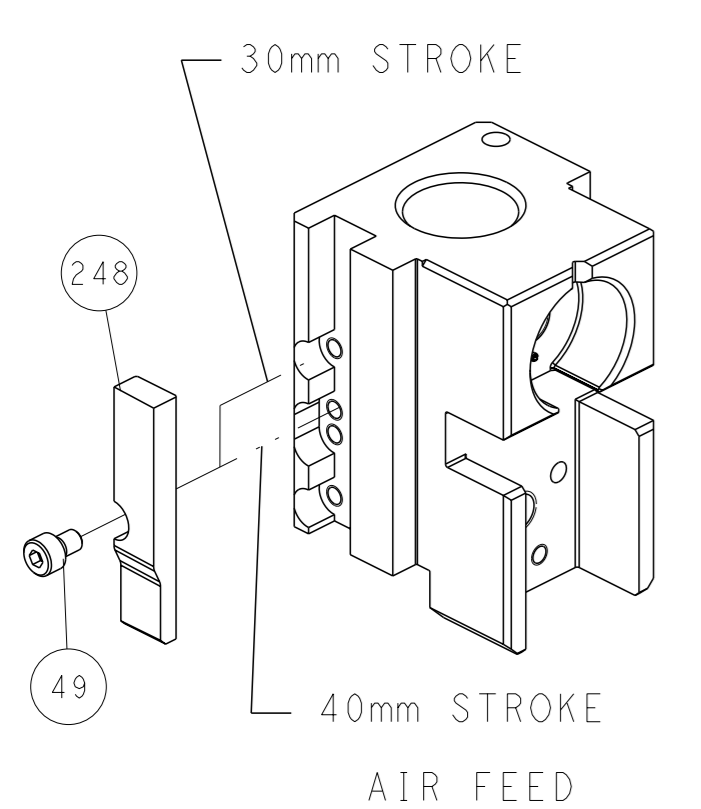


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITION



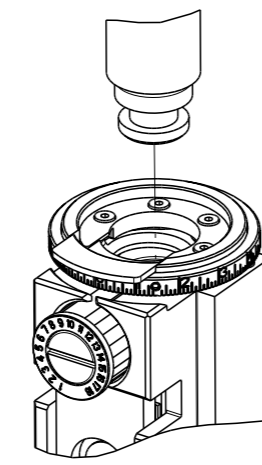
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

| | | | | | | | | | |
|-----------------------|--|--|--|--|--|--|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | | DWG Y.YIN 18OCT2011 CHK G.BAILEY 18OCT2011 APVD S.XI 18OCT2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2151133 SCALE 1:2 SHEET 2 of 4 REV F | | RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608 | |
|-----------------------|--|--|--|--|--|--|--|---|--|

| 8 | 7 | 6 | 5 | 4 | 3 | 2 | 1 |
|--|----------|--------------------------|-----------|----|---|---|---|
| THIS DRAWING IS UNPUBLISHED. | | RELEASED FOR PUBLICATION | | 20 | | | |
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | | | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | | | | |
| 2-2151133-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | | | | |
| 7-2151133-7 | A | CRIMP TOOLING KIT | - | | | | |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 2.79 mm [.110] | OV |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|--|--------------|---|--------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: STANDARD TIMER CONTACT | | | |
| WIRE STRIP LENGTH 3.90-4.50 mm [.154-.177 IN] | | INSULATION DIAMETER RANGE Ø1.40-2.30 mm [.055-.091 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-18079 | - | - |
| | (B)114-18080 | - | - |
| TERMINALS APPLIED 5 | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 927845-1 | (B) 927847-1 | (B) 928753-3 | (B) 964201-2 |
| (A) 927845-2 | (B) 927847-2 | (B) 928820-1 | (B) 964201-3 |
| (A) 927845-3 | (B) 927847-3 | (B) 928820-2 | (B) 964201-4 |
| (A) 927845-4 | (B) 928753-1 | (B) 928820-3 | |
| (A) 927845-5 | (B) 928753-2 | (B) 964201-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.00mm2 | 1.36+/-0.05 [.054+/-0.002] | 8.2 |
| 0.85mm2 | 1.31+/-0.05 [.052+/-0.002] | 8.7 |
| 18 AWG | 1.29+/-0.05 [.051+/-0.002] | 9.0 |
| 0.75mm2 | 1.27+/-0.05 [.050+/-0.002] | 9.2 |
| 0.70mm2 | 1.25+/-0.05 [.049+/-0.002] | 9.3 |
| 20 AWG | 1.19+/-0.05 [.047+/-0.002] | 10.4 |
| 0.50mm2 | 1.18+/-0.05 [.046+/-0.002] | 10.4 |



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

| REV | DATE | DESCRIPTION | ITEM NO | |
|-----|-------|-------------|-------------------------------------|---------|
| - | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | 1 | 2844940-2 | AIR FEED MODULE | 238 |
| - | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 2119641-2 | FEED CAM, AIR FEED | 151 |
| - | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 144 |
| - | 4 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 143 |
| - | 1 | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1803516-1 | RAM ASSEMBLY, SF PACIFIC | 140 |
| - | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1803382-6 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1752356-6 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1-1333204-0 | ANVIL, COMBINATION | 8 |
| - | 1 | 3-240641-7 | SPACER | 7 |
| - | - | - | - | 6 |
| - | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1-238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1-2119785-0 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| - | 1 | 1-456405-5 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77-22 | PART NO | DESCRIPTION | ITEM NO |

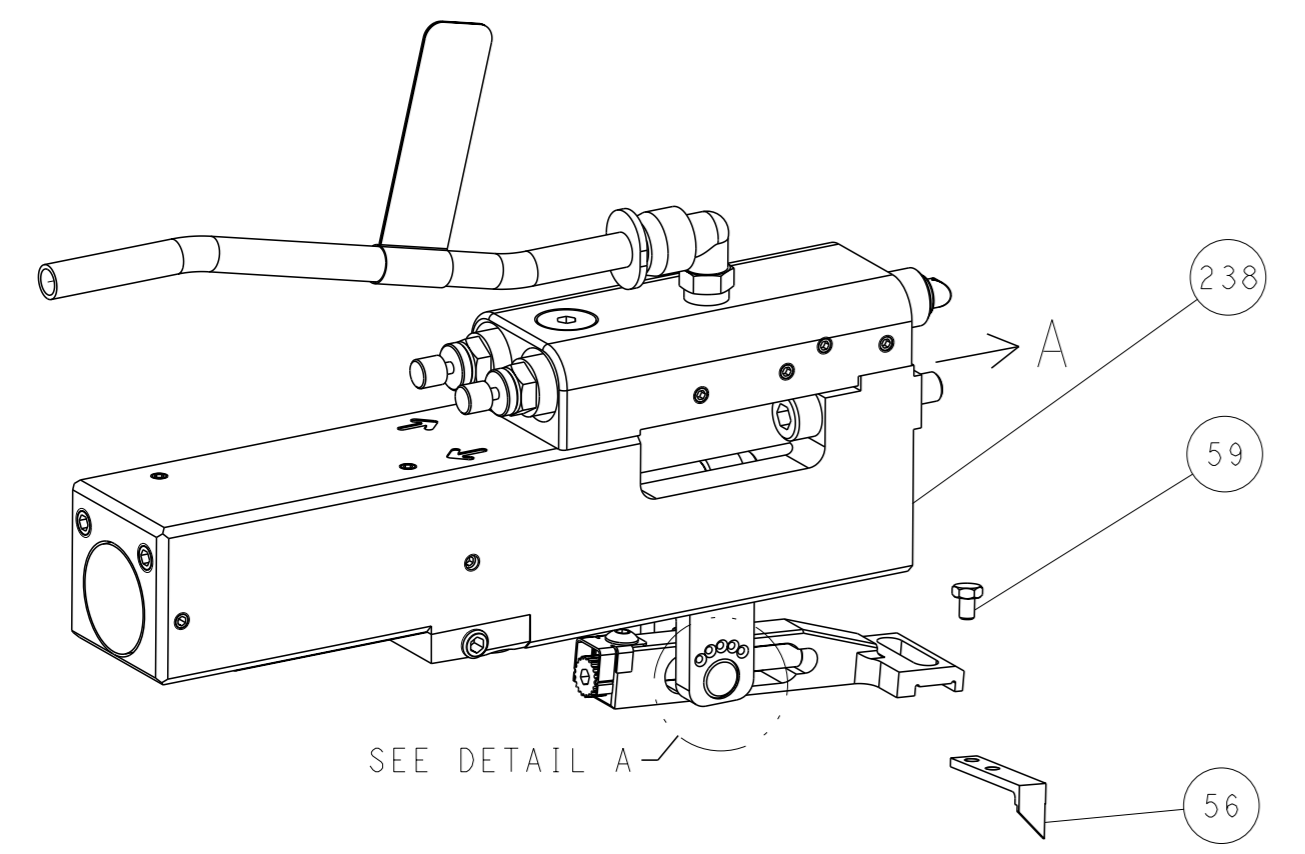
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

| | | | | | | | |
|--|---|--|---|----------------------|-------------------------|----------------------|----------------------------|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN Y. YIN 18OCT2011 | CHK G. BAILEY 18OCT2011 | APVD S. YI 18OCT2011 | NAME |
| 0 PLC | ± | 1 PLC | ± | PRODUCT SPEC | | | STE TE Connectivity |
| 2 PLC | ± | 3 PLC | ± | APPLICATION SPEC | | | Harrisburg, PA 17105-3608 |
| 4 PLC | ± | ANGLES | ± | WEIGHT | | | Ocean Side Feed Applicator |
| MATERIAL | | | | SCALE | | | RESTRICTED TO |
| Customer Accessible Production Drawing | | | | 00779 | ©=2151133 | 3 | REV F |

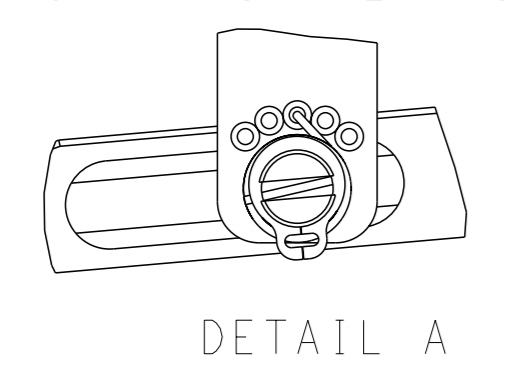
| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|-------------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| | | - | SEE SHEET 1 | - | - |

FEED TYPE

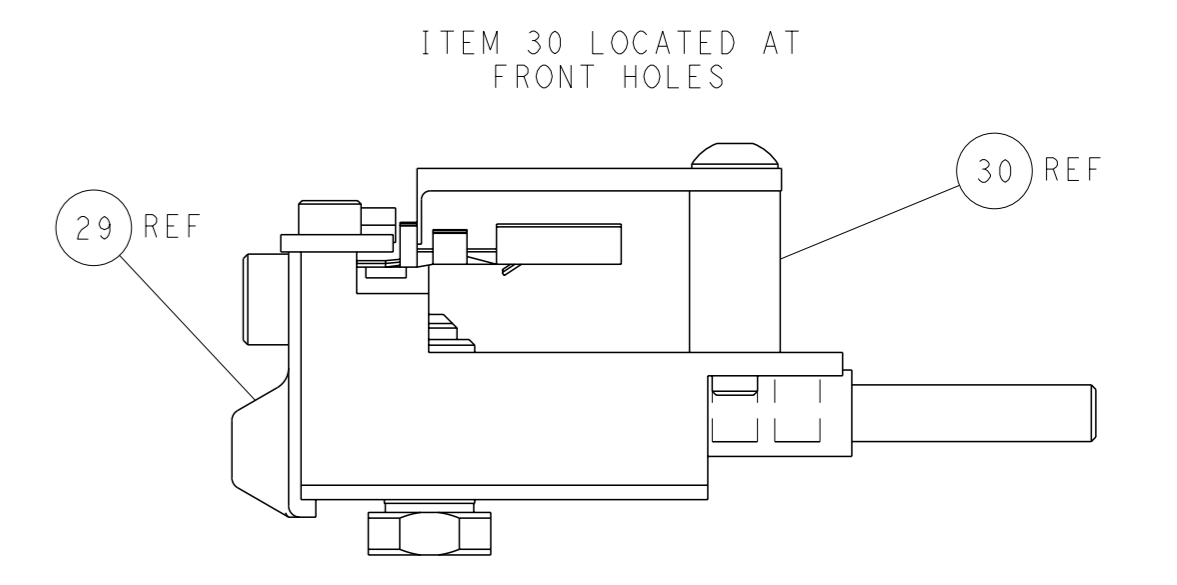
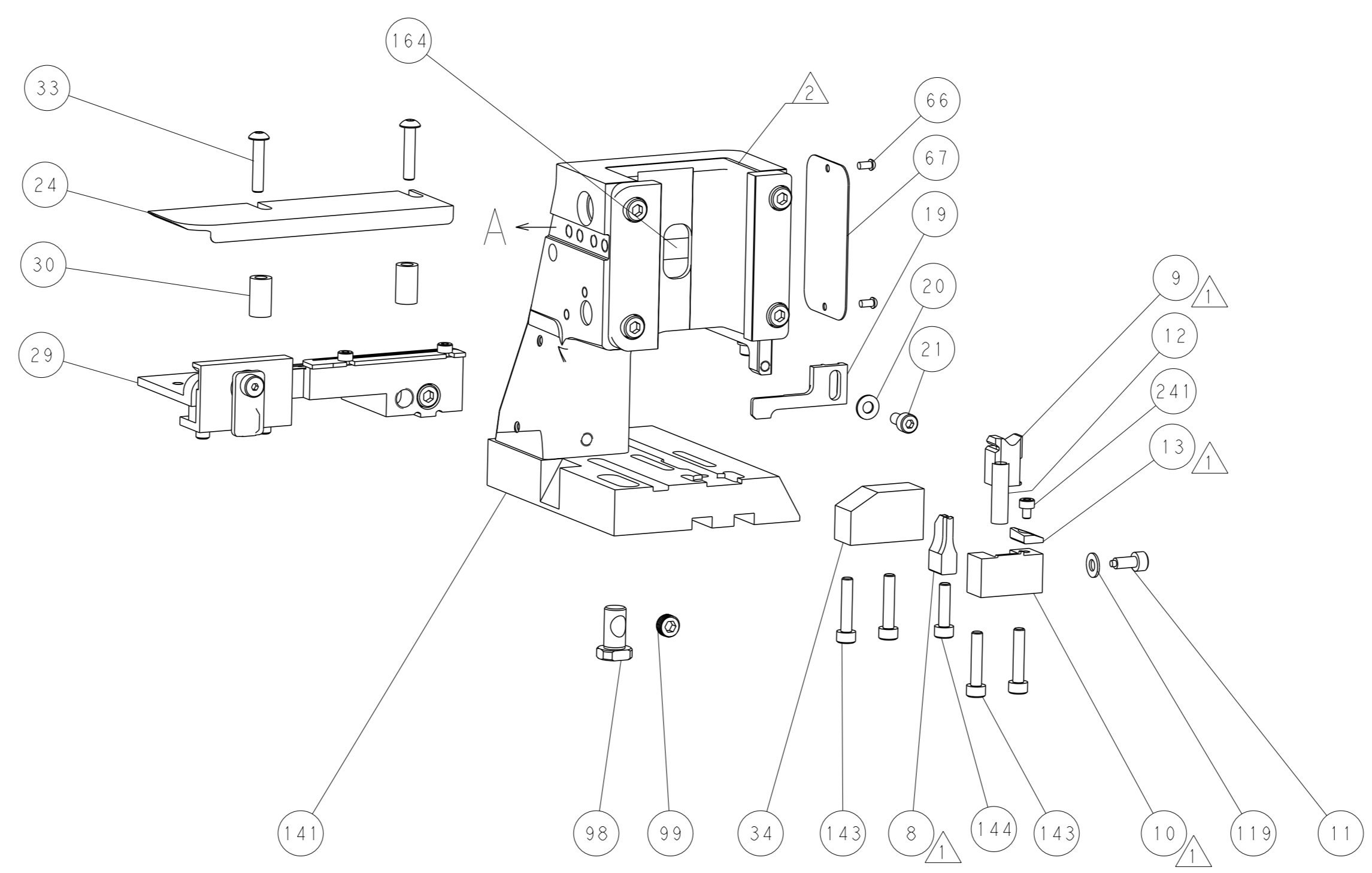
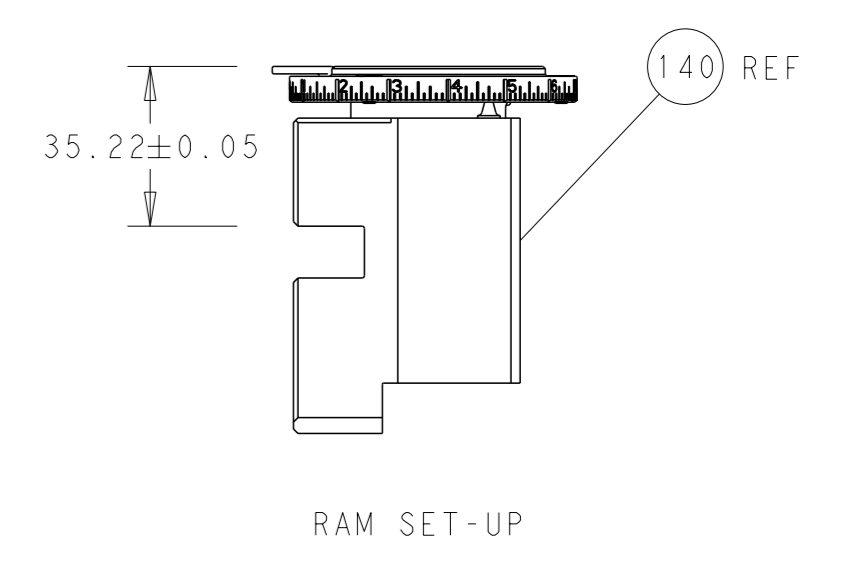
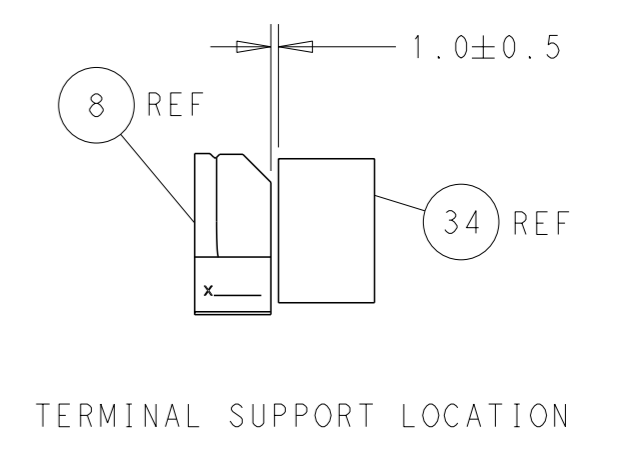
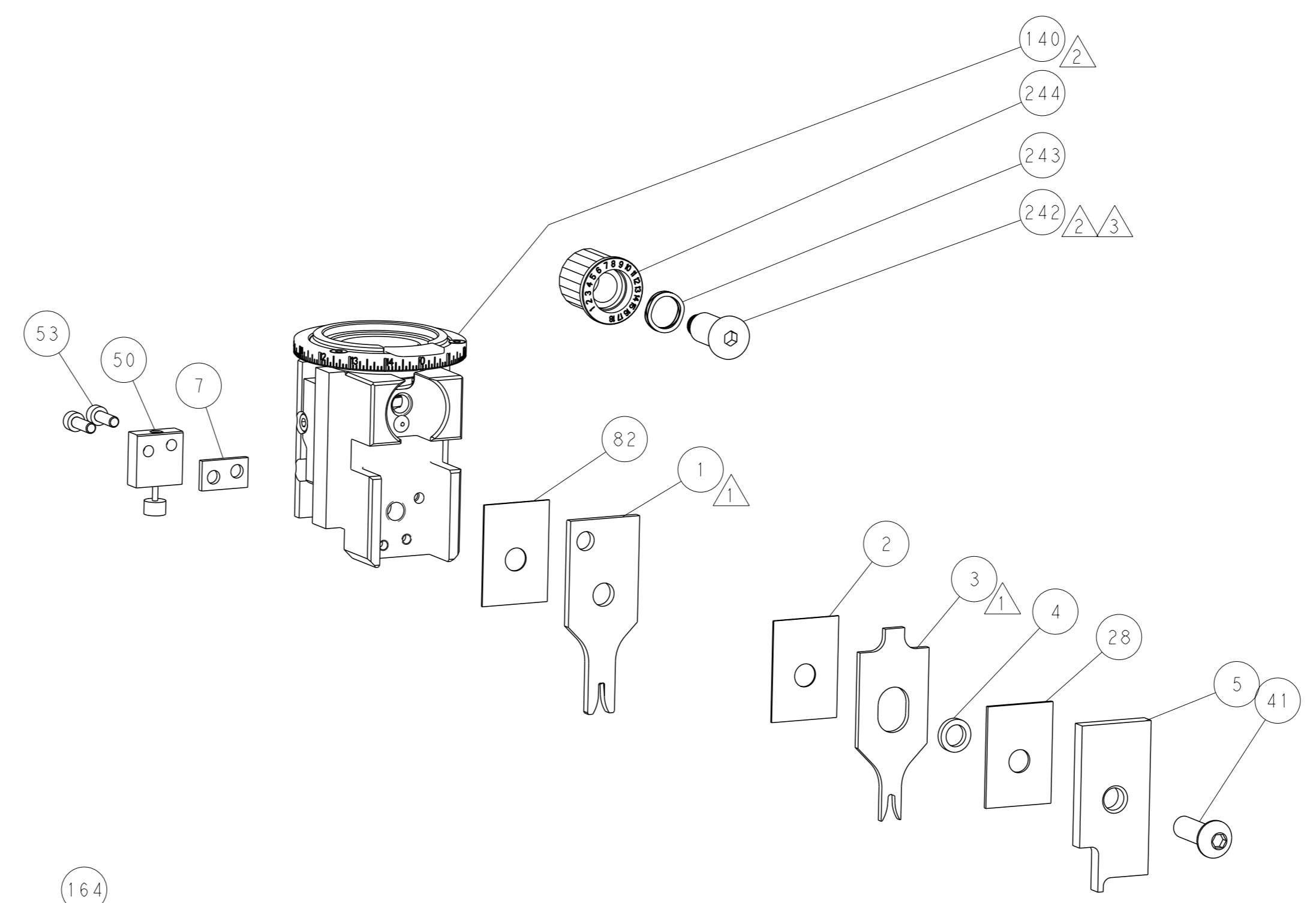
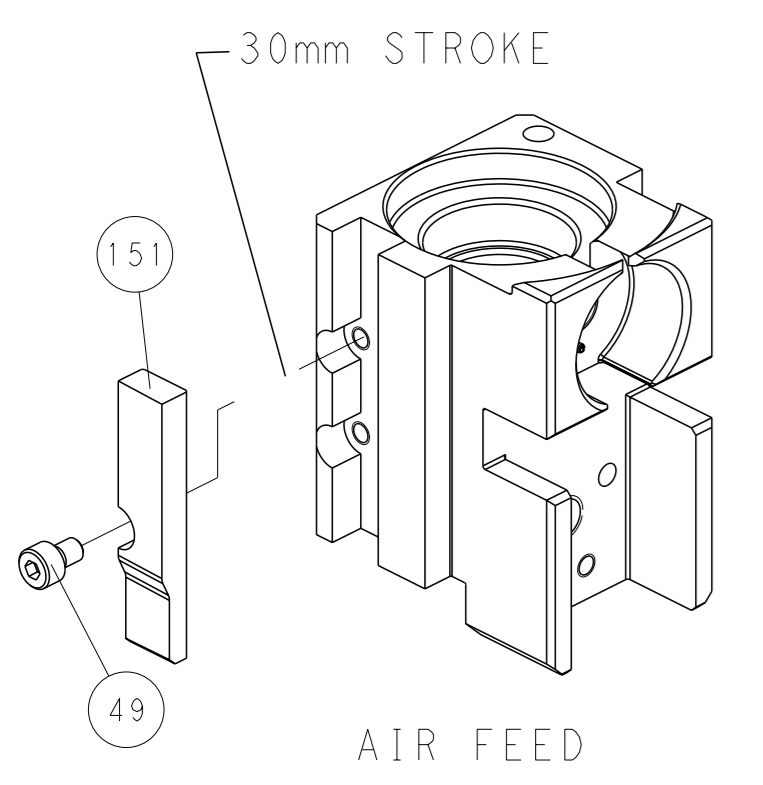
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN Y.YIN 18OCT2011 CHK G.BAILEY 18OCT2011 APVD S.XI 18OCT2011 | STE TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH * | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151133 WEIGHT - Customer Accessible Production Drawing | RESTRICTED TO - SCALE 1:2 SHEET 4 OF 4 REV F |