

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2266058-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266058-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266058-4	-	-	-
	2266058-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266058-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266058-4	-	-	-
	2266058-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2266058-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE ¹²	-	-	-	-	-	-	
2266058-7	B	FINE CRIMP HEIGHT ADJUST	NONE	NONE	-	-	-	-	-	-	
7-2266058-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL **TE CRIMP SPECIFICATION**

TERMINAL NAME: MQS SOCKET CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.35-3.65 mm [.132-.144 IN]	∅2.40-2.60 mm [.094-.102 IN] ¹³

TERMINAL APPLICATION SPECIFICATION 114-18025

TERMINALS APPLIED ³

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
965906-1	6-965906-5	967067-1	
965906-5	7-965906-5		
965906-6	965908-1		
1-965906-5	965908-2		
2-965906-5	2-965908-2		
5-965906-1	5-965908-1		
5-965906-5	5-965908-2		
5-965906-6	7-965908-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.07 +/- 0.03 [.042 +/- .001]	6.3
0.50mm2	0.93 +/- 0.03 [.037 +/- .001]	7.7

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266058-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266058-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266058-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266058-6
- 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 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.73. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS ∅1.4 - 1.9 (.055 - .075 IN.)
- 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.
- THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

***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.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	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	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-77	-7	-6	-5	-2	-1	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)

LOC	DIST	REV	DATE	BY	APPROVED
A	66	1	25SEP2013	KH	UG
A			23OCT2013	BH	GB
A1			26JUN2015	JH	TE
B			24OCT2016	KH	TE

P	L	M	R	S	T	DESCRIPTION	DATE	BY	APPROVED
-	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198	
-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182	
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
-	1	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176	
-	1	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	-	-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	-	-	-	-	1	3-23627-7	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	
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	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 POINT, M3 X 4.0	62	
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60	
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57	
-	-	-	-	-	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54	
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1	2-2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	-	-	-	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44	
-	1	1	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	1	1	2119644-1	RAM WASHER, PRECISION	38	
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	1	-	-	-	1	2119092-1	BOLT, ADJUSTMENT	35	
-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
-	1	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30	
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	28	
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	1	1-1333201-0	ANVIL, COMBINATION	8	
-	1	1	1	1	1	5-240641-4	SPACER	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	1	1-2119784-5	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1	
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

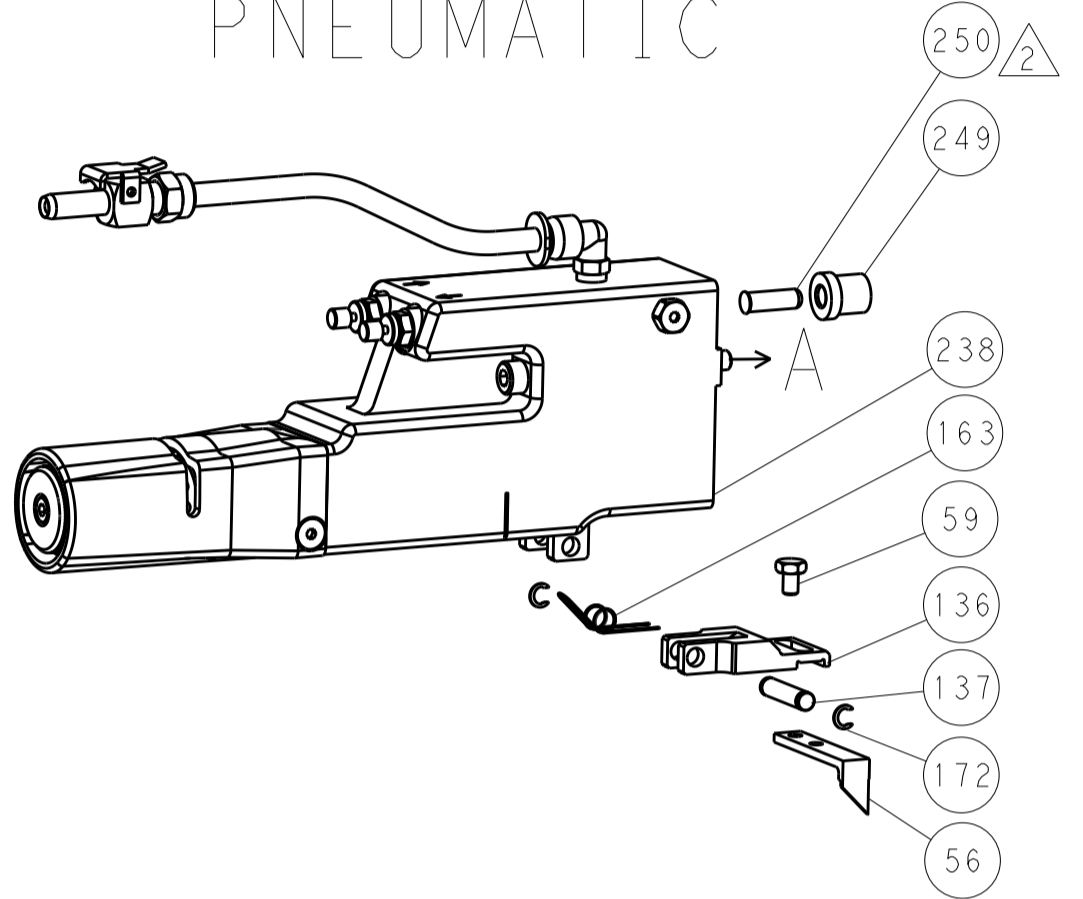
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	DATE
0 PLC	±	1 PLC	±0.5	25SEP2013	25SEP2013
1 PLC	±0.13	2 PLC	±0.13	APPROVED: L. ZHANG	CHECKED: H. HUANG
3 PLC	±0.013	4 PLC	±0.013		
5 PLC	±0.0013	ANGLES	±0.0001		
MATERIAL:	FINISH:			SCALE	SHEET
				1:2	1 OF 4
Customer Accessible Production Drawing				REV	B

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

FEED TYPE MECHANICAL



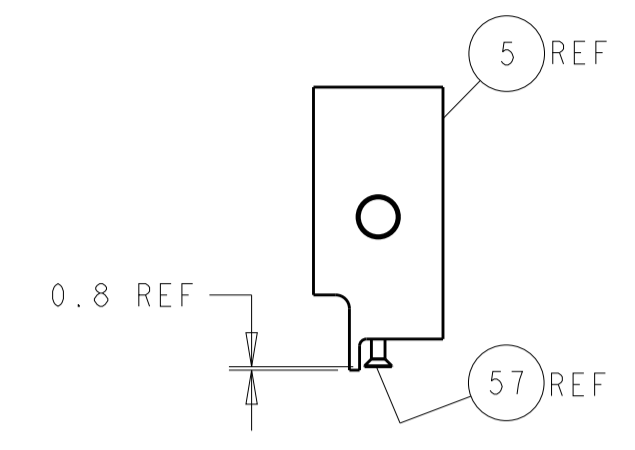
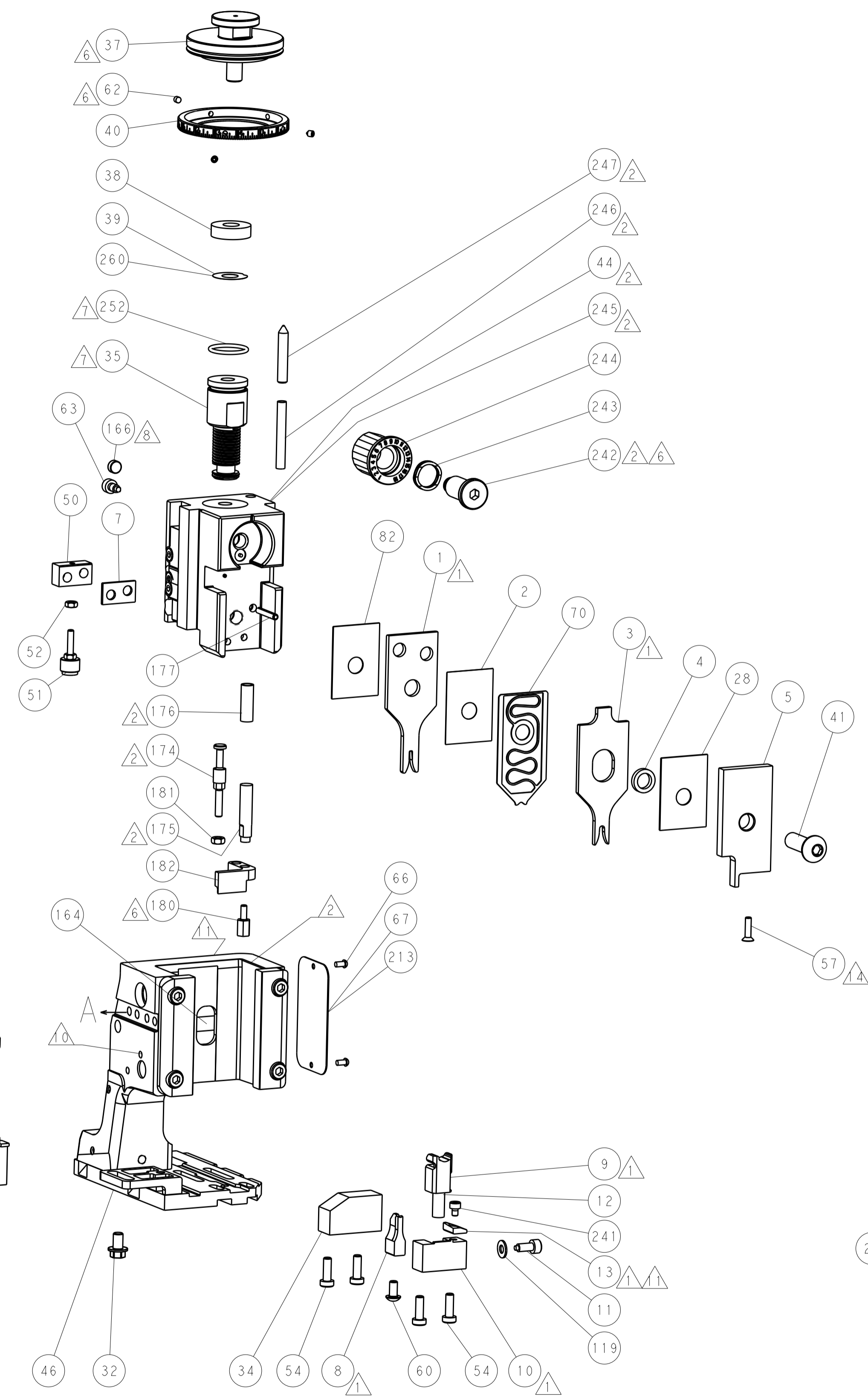
PNEUMATIC



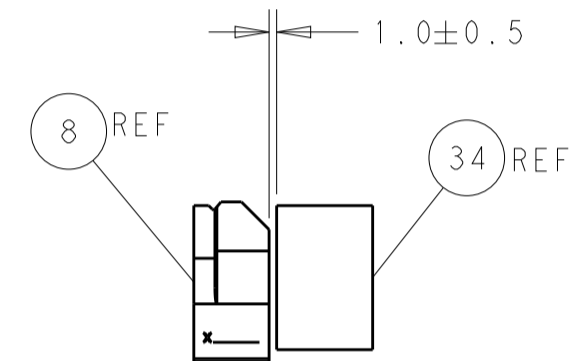
SERVO LATCH PLATE



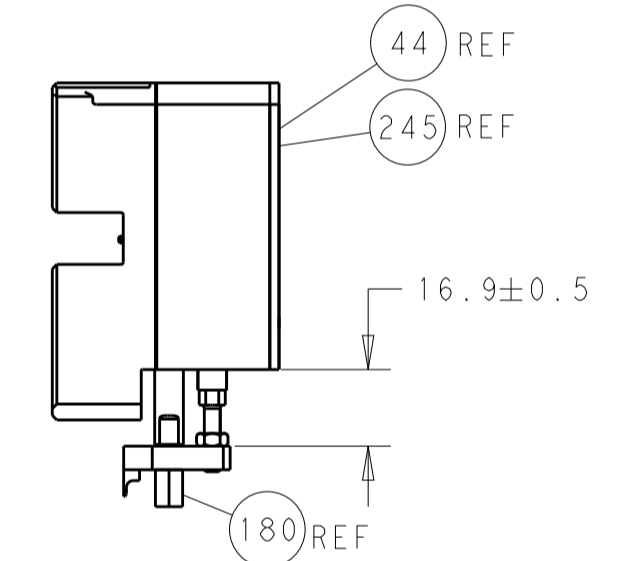
CAM POSITIONS



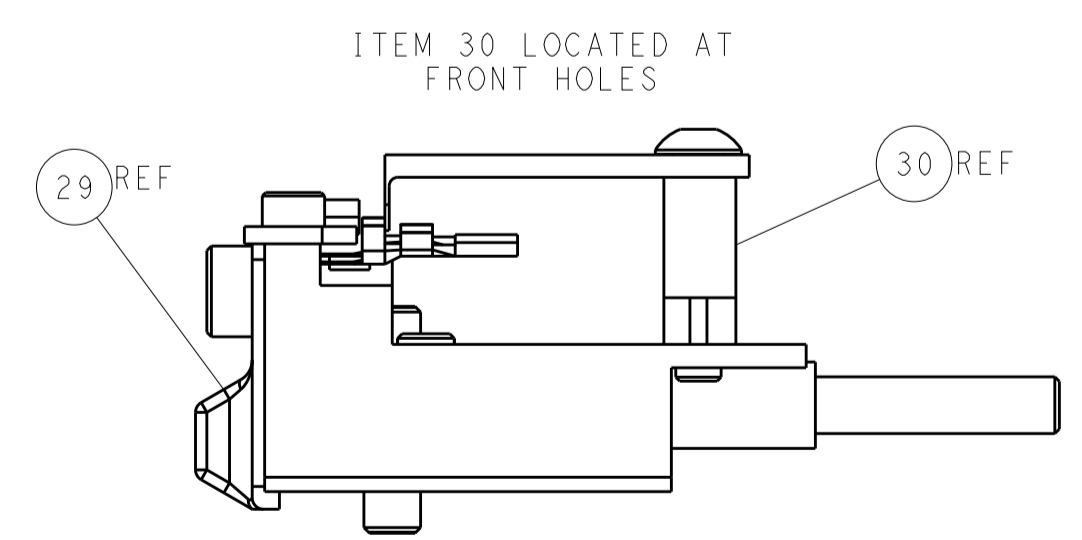
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN 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:		DWN: H. HUANG 25SEP2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK: L. ZHANG 25SEP2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: H. GUO 25SEP2013		NAME: Ocean Side Feed Applicator	
				WEIGHT:		SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2266058	
				Customer Accessible Production Drawing		RESTRICTED TO: SCALE: 1:2 SHEET 2 OF 4 REV B	

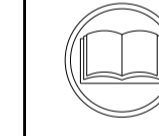
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Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE, WIRE, INSUL, APPLICATOR INSTRUCTIONS.

Terminal data and specifications including: TERMINAL DATA: TE TERMINAL, TE CRIMP SPECIFICATION, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINALS APPLIED.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY.
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 62 & 180.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
MAGNET 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.
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING.
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various components like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, CAM, WASHER.

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

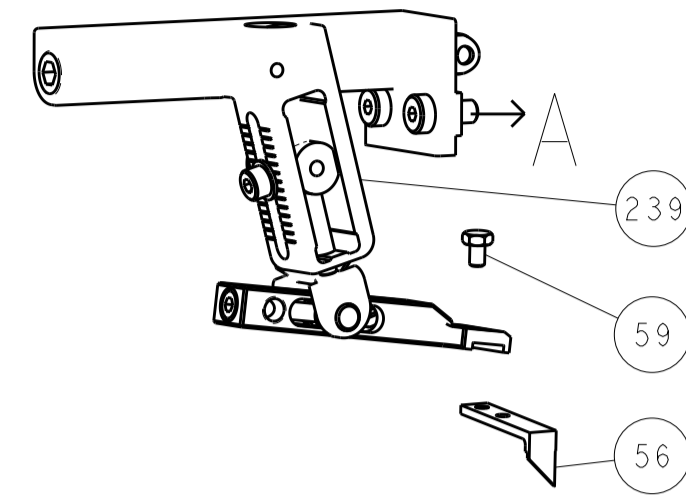
Table with columns: SET UP GAUGE, DIST, REVISIONS. Includes fields for P, LTM, DESCRIPTION, DATE, DWN, APVD.

Main assembly drawing table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists numerous parts such as RETAINER, INSULATION DIAL, SCR, SKT HD CAP, SHCS, LOW HEAD, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, STRIPPER, SIDE FEED, NUT, HEX, REG, RoHS, M3.5, STANDOFF, HOLD-DOWN, PIN, SLOTTED SPRING, SPRING, COMPRESSION, GUIDE PIN, HOLDDOWN, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, O-RING, .801 ID, .070 DIA. MAT., FEED CAM, AIR FEED, DETENT PIN, SCR, BHSC, RoHS (M4 X 16), SHCS, LOW HEAD, RoHS, M4 X 20, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, ASIAN STYLE, SIDE FEED, BOLT, ADJUSTMENT, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, WASHER, FLAT, REG M4, FEED FINGER ASSEMBLY, SF, SPACER, CRIMPER, DOCUMENTATION PACKAGE, DEPRESSOR, WIRE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 X .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 X 4.0, SCR, HEX HD CAP, M4 X 6.0, SCR, FLT SKT HD CAP M3 X 12.0, PAWL, FEED, SCR, SKT HD CAP, RoHS, M4 X 12.0, NUT, HEX, REG, RoHS, M3, BUMPER, HOLD DOWN, SPACER, TONKER, SCR, SKT HD CAP M4 X 6.0, FEED CAM, PRE FEED, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, SUPPORT, TERMINAL, SCR, BHSC, RoHS (M4 X 20), HEX HEAD, FLANGED, M5 X 8mm LONG, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION, SPACER, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION O PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM.

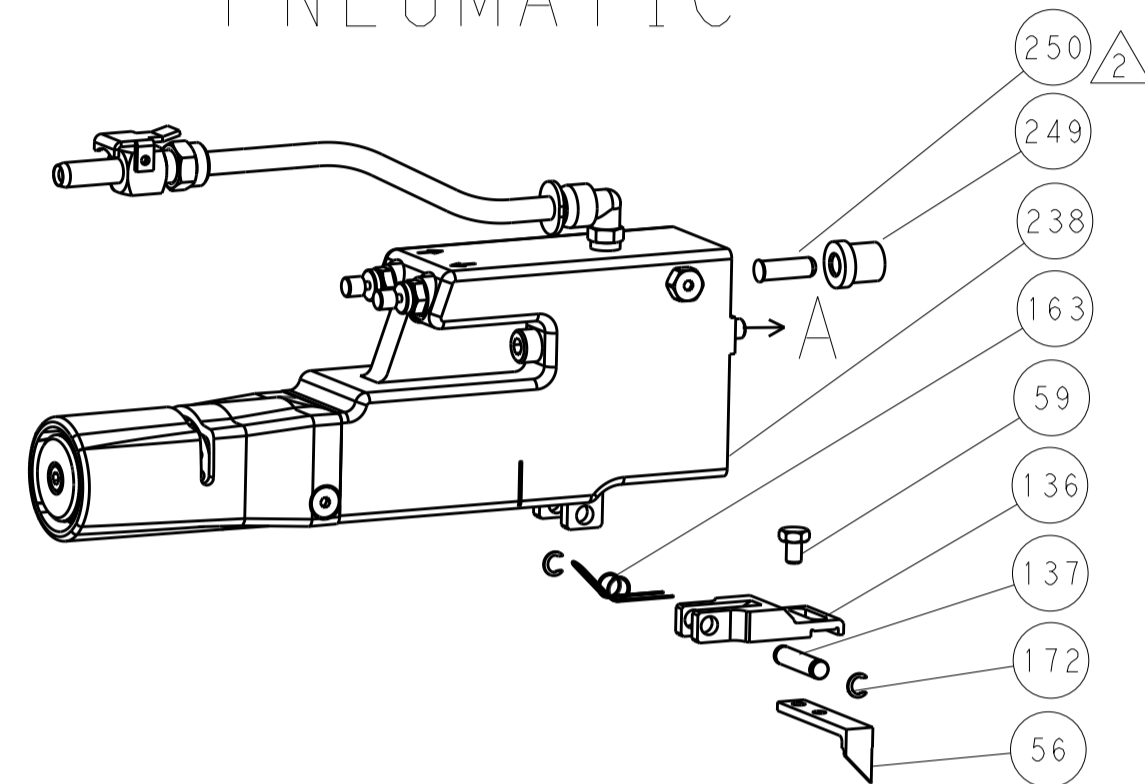
Technical drawing details including: DIMENSIONS (mm), TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE (1:2), SHEET (3 OF 4), REV (B), and customer information: Ocean Side Feed Applicator.

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

FEED TYPE MECHANICAL



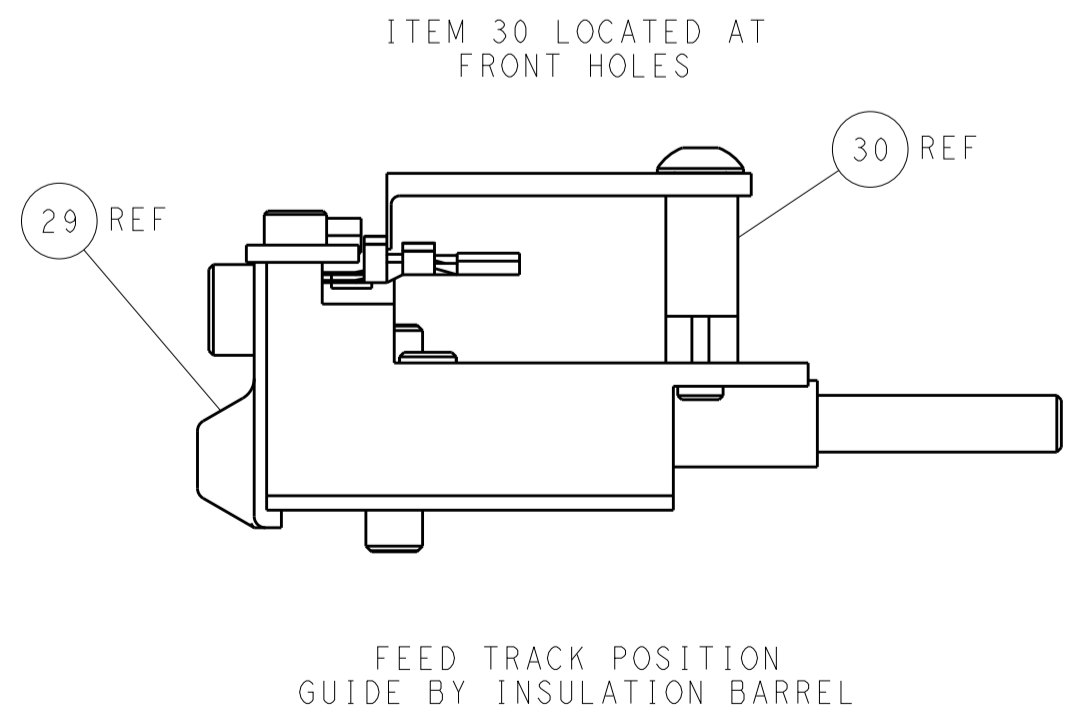
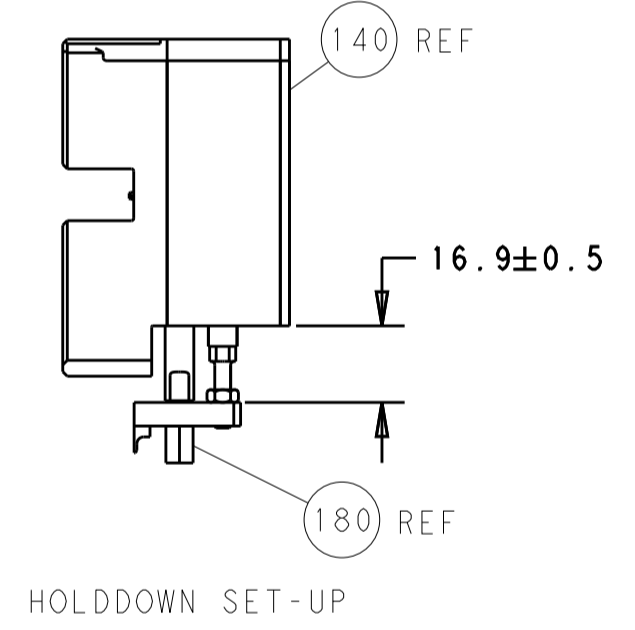
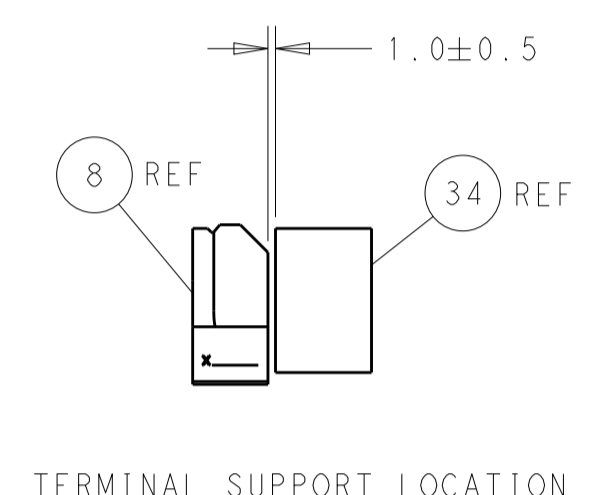
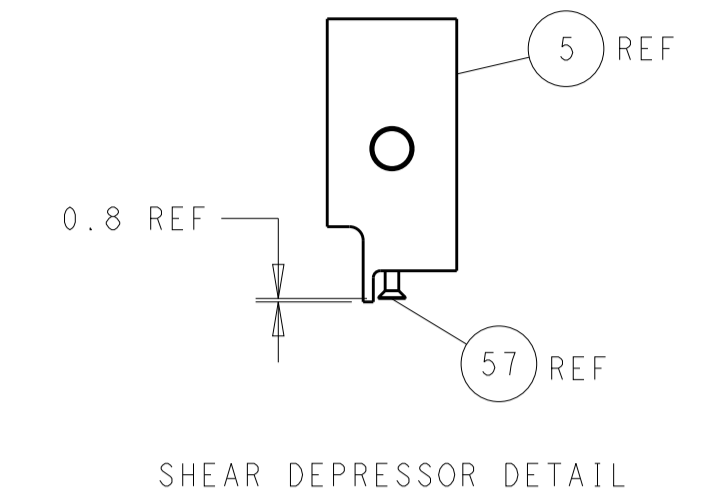
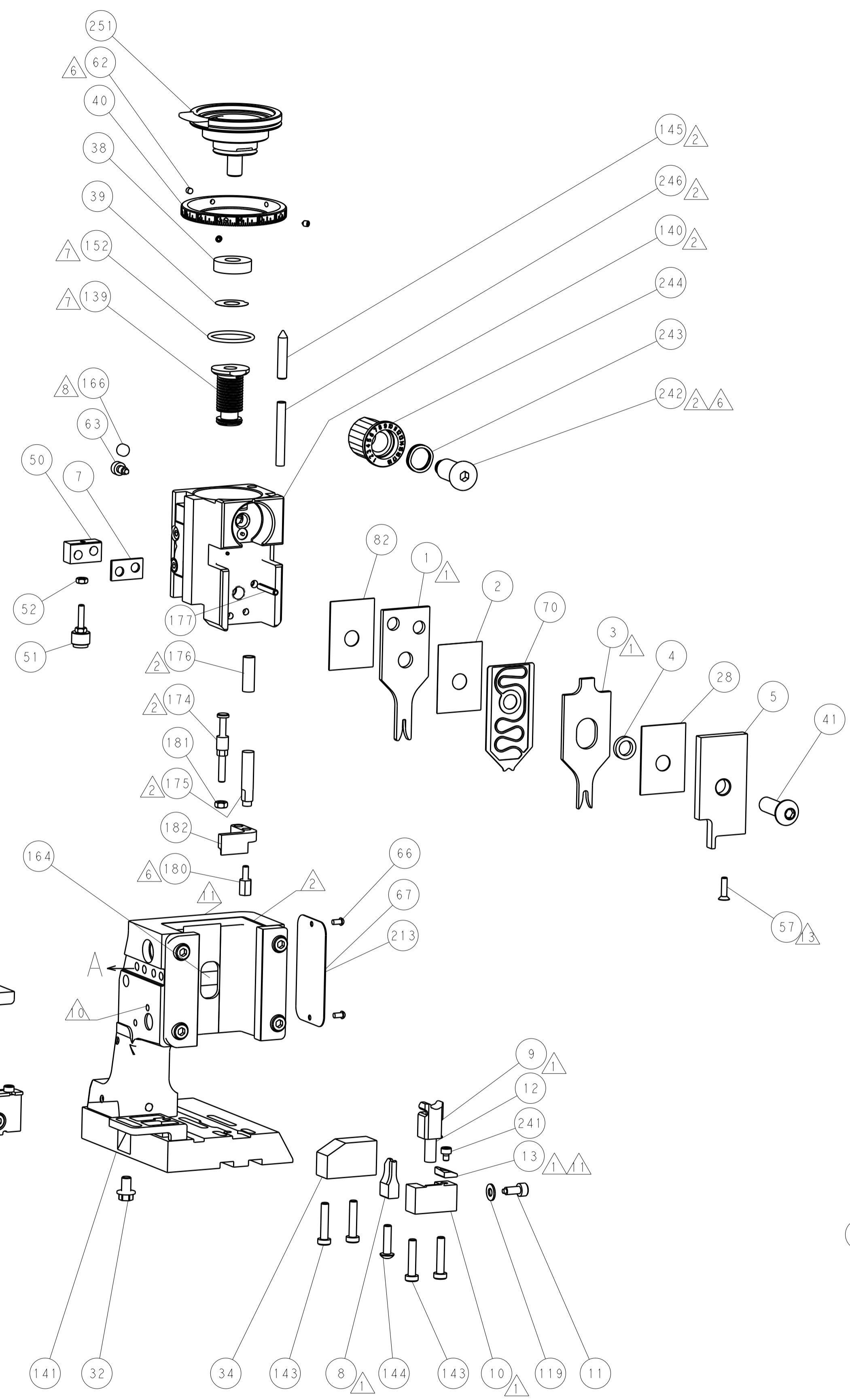
PNEUMATIC



SERVO LATCH PLATE



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 ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE: DRAWING NO: A1 00779 C=2266058
MATERIAL:	FINISH:	Customer Accessible Production Drawing	RESTRICTED TO: B