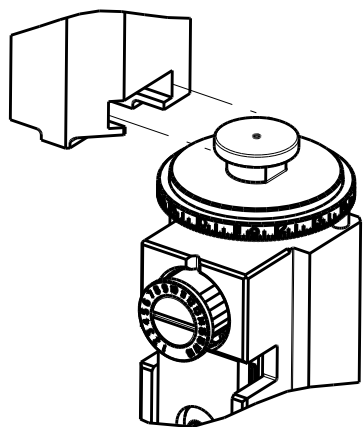


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150461-1	A	FINE CRIMP HEIGHT ADJUST
	2150461-2	A	FINE CRIMP HEIGHT ADJUST
	2150461-5	A	FINE CRIMP HEIGHT ADJUST
	2150461-6	A	NON-CRIMP HEIGHT ADJUST
	2150461-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150461-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.94 mm [.155]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,RING			
WIRE STRIP LENGTH 3.20-4.00 mm [.126-.157 IN]		INSULATION DIAMETER RANGE Ø2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED ¹³	-	-	-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160252-1	160189-2	160237-1	160210-1
160252-2	160189-3	160434-1	
160189-1	160189-4	160434-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2	1.65+/-0.05 [1.065+/- .002]	6.5
0.75mm2	1.58+/-0.05 [1.062+/- .002]	7.3
0.50mm2	1.50+/-0.05 [1.059+/- .002]	8.1



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150461-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150461-6
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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 12 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
- 13 TERMINAL LUBRICANT IS RECOMMENDED.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,RING			
WIRE STRIP LENGTH 3.20-4.00 mm [.126-.157 IN]		INSULATION DIAMETER RANGE Ø2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED ¹³	-	-	-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41472	41471		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG	1.52+/-0.05 [1.060+/- .002]	7.9
20 AWG	1.45+/-0.05 [1.057+/- .002]	8.7

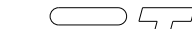
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

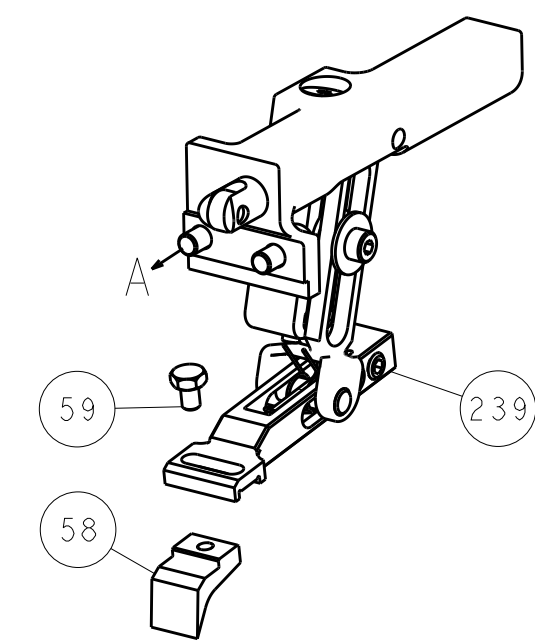
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

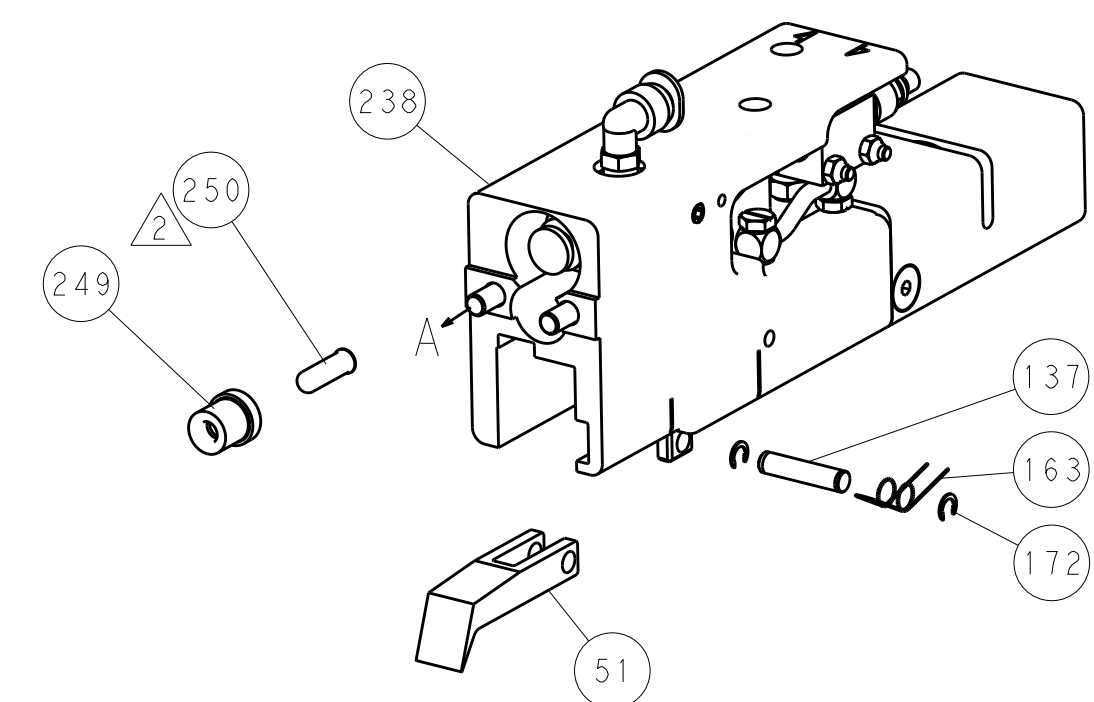
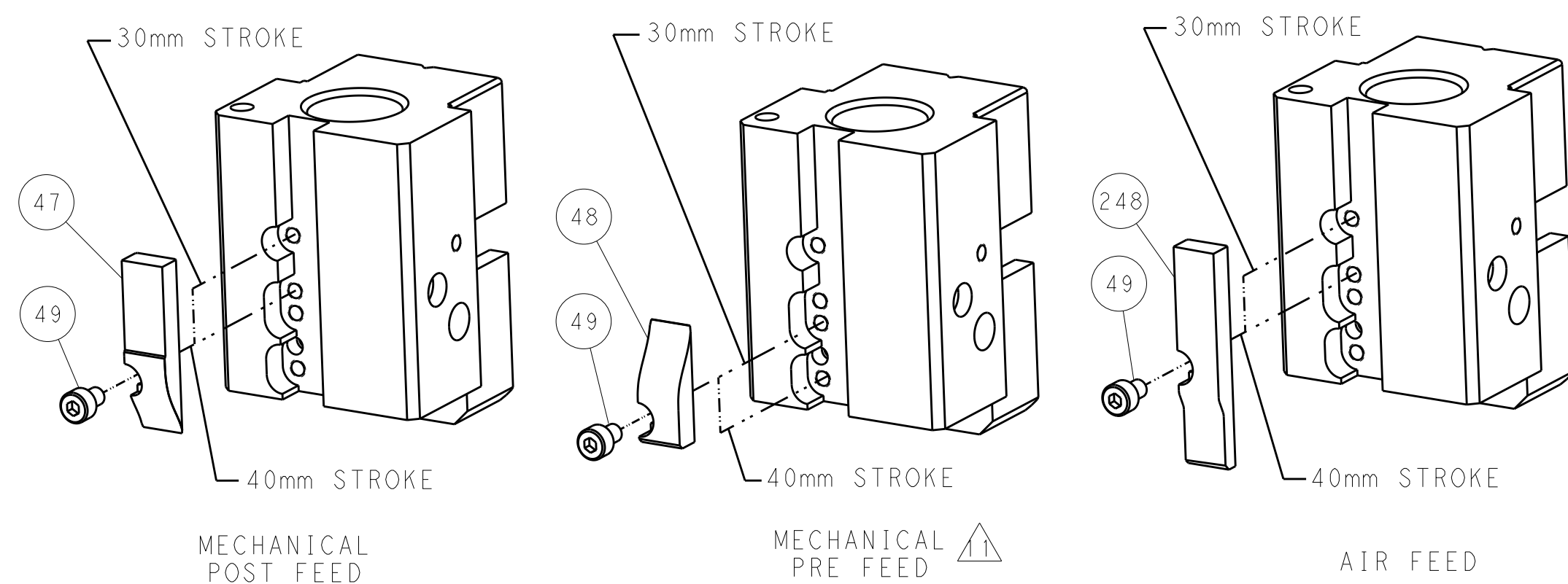
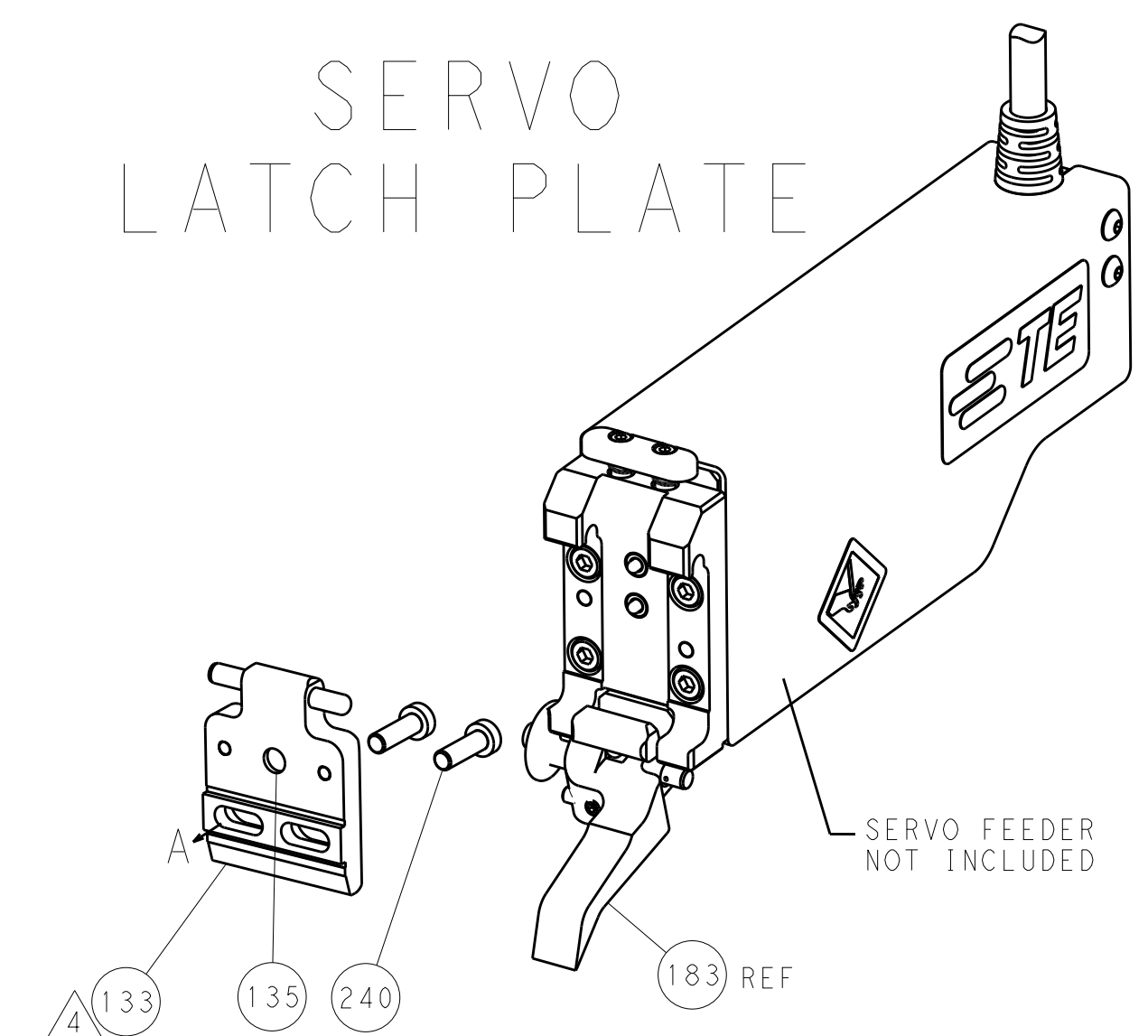
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SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS			
		P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	24SEP2014	KH	UG

-	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	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-2	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
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	1	2063440-1	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	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREFREF	-	-	-	-	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	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	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	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
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	-	2063961-1	FEED FINGER	58
-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	-	-	-	2119792-2	PAWL, EF, AIR	51
-	-	-	-	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	-	1	1	2119369-1	RAM,AMP STYLE, END FEED	44
-	1	1	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	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1	1-1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1	1-1901695-2	STRIP GUIDE, FRONT	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	691901-2	REAR SHEAR PLATE, REVERSIBLE	11
-	2	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1803060-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2-691157-6	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	5-240641-8	SPACER	5
-	1	1	1	1	1	238009-8	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	2-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	456409-2	CRIMPER, WIRE .120 "F" PREMIUM	1

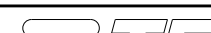
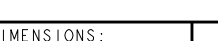
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				CHK L. ZHANG 22JUL2014					APVD U. GUO 22JUL2014				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator -							
		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC									
MATERIAL		FINISH		APPLICATION SPEC		SIZE		CASE CODE		DRAWING NO		RESTRICTED TO	
				WEIGHT		A		00779		C-2150461		-	
Customer Accessible Production Drawing						SCALE		1:1		SHEET		1 OF 4	
												REV A	



PNEUMATIC

SERVO
LATCH PLATE

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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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
		WEIGHT -		DRAWING NO C-2150461	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

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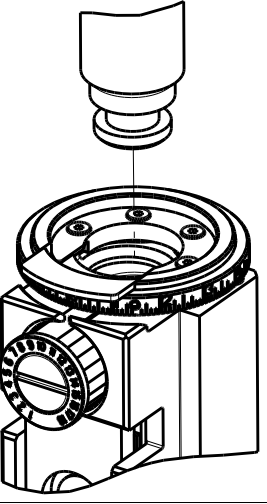
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150461-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150461-5

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150461-4

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150461-5

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150461-4

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

-

-

-

-

-

-

-

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-

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-

-

2-2150461-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150461-5

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150461-4

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

-

-

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-

-

-

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-

-

-

-

2-2150461-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

2-2150461-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150461-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.05 mm [.120]

F

INSUL

3.94 mm [.155]

F

APPLICATOR INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,RING							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.20-4.00 mm [.126-.157 IN]				Ø2.54-3.43 mm [.100-.135 IN]			
TERMINAL APPLICATION SPECIFICATION		114-2084		-		-	
TERMINALS APPLIED		△		-		-	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160252-1	160189-2	160237-1	160210-1	160252-2	160189-3	160434-1	160189-1
160252-2	160189-3	160434-1	160189-1	160189-1	160189-4	160434-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.65+/-0.05 [.065+/- .002]		6.5
0.75mm2		1.58+/-0.05 [.062+/- .002]		7.3
0.50mm2		1.50+/-0.05 [.059+/- .002]		8.1

△

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150461-5

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

△

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

△

THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

△

TERMINAL LUBRICANT IS RECOMMENDED.

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,RING							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.20-4.00 mm [.126-.157 IN]				Ø2.54-3.43 mm [.100-.135 IN]			
TERMINAL APPLICATION SPECIFICATION		114-2084		-		-	
TERMINALS APPLIED		△		-		-	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41472	41471						

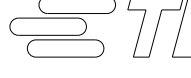
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.52+/-0.05 [.060+/- .002]		7.9
20 AWG		1.45+/-0.05 [.057+/- .002]		8.7

*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)

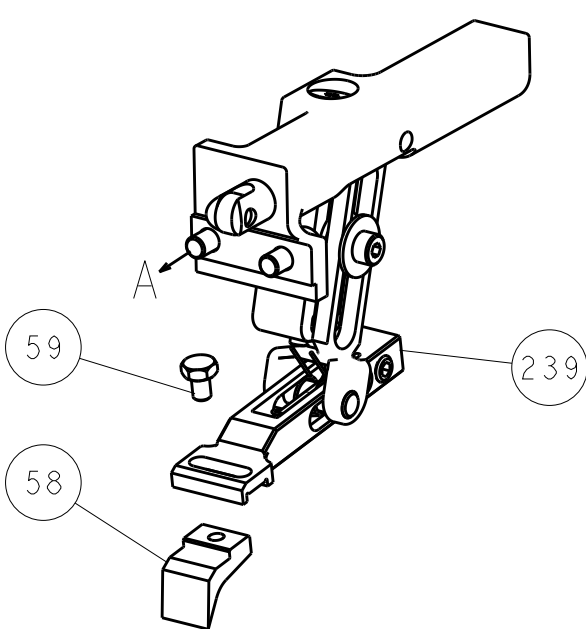
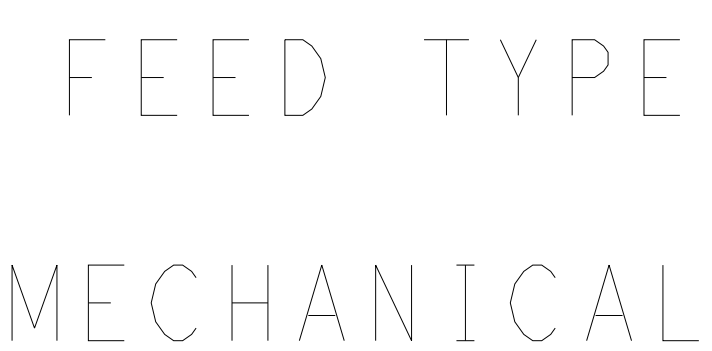
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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-	77-27-25-22-21	PART NO	DESCRIPTION				ITEM NO

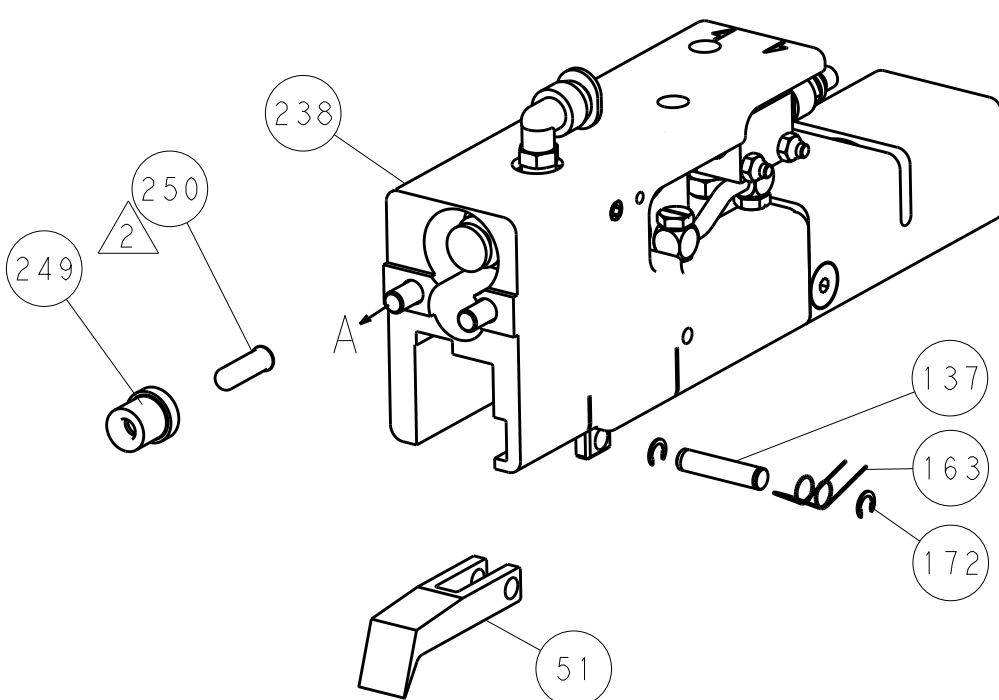
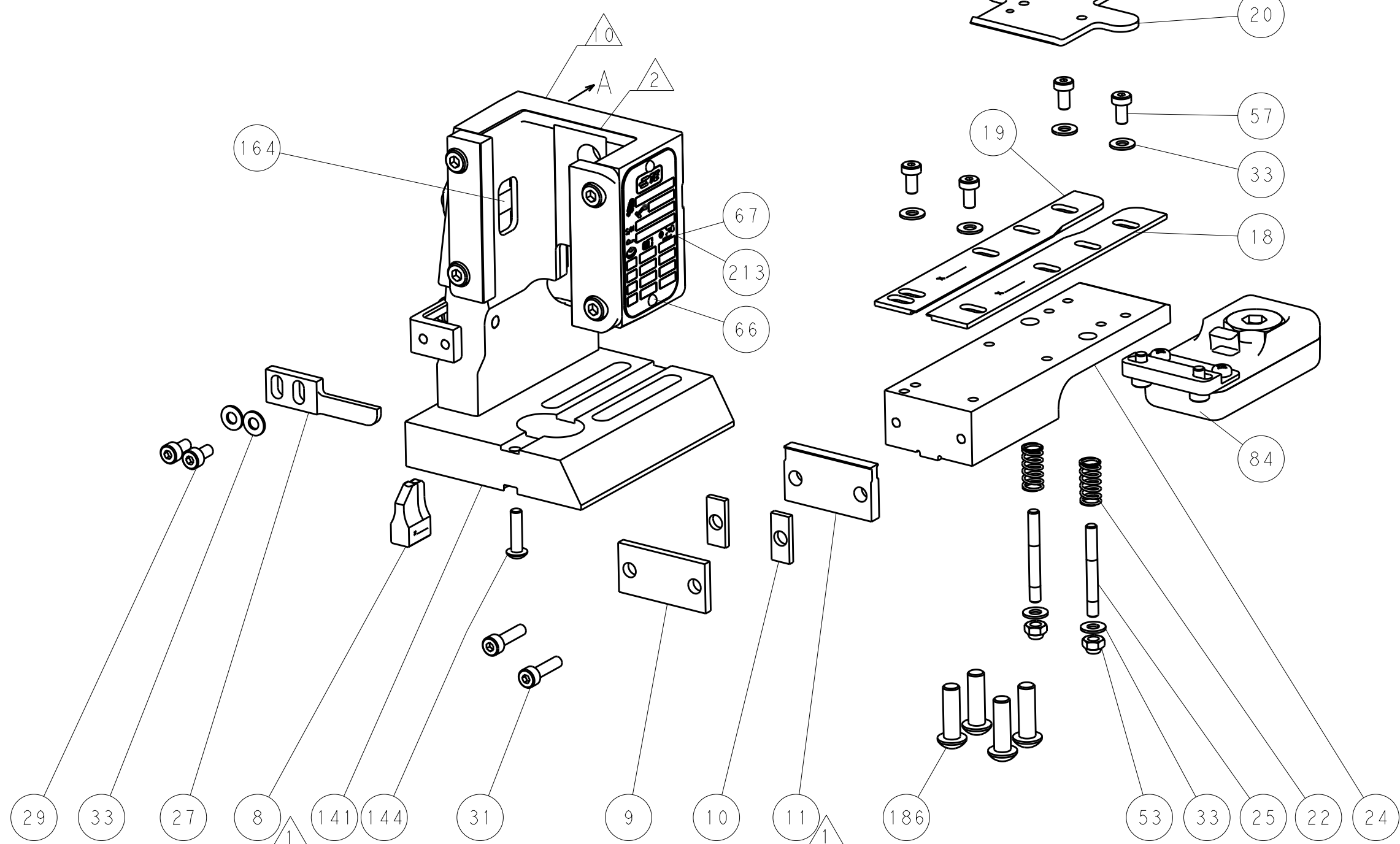
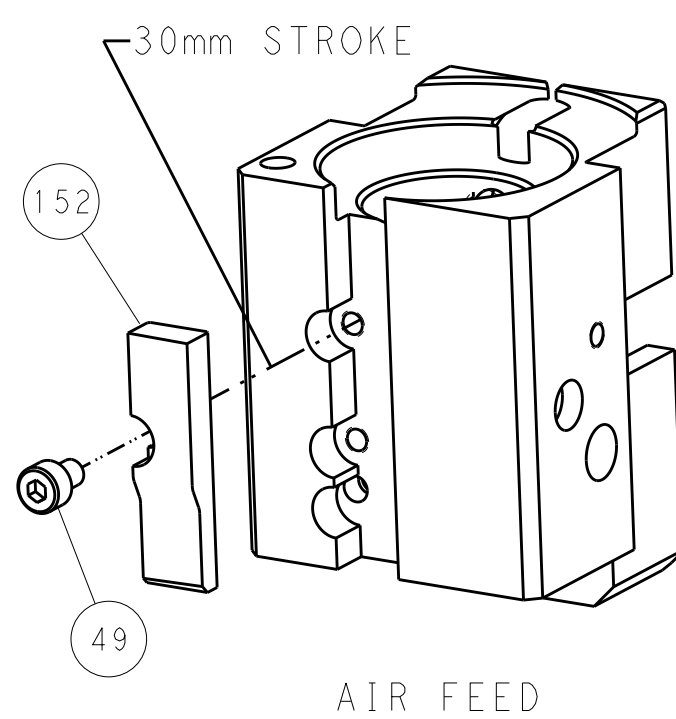
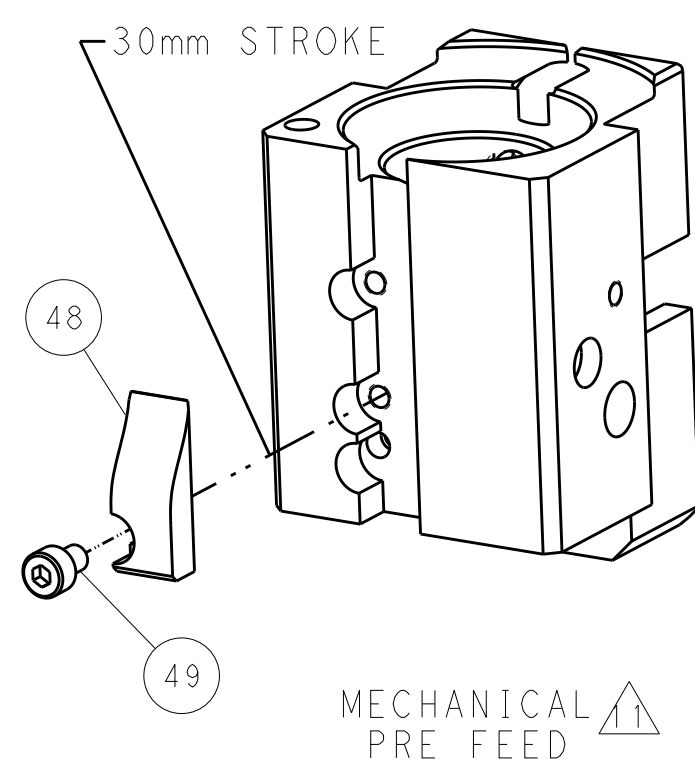
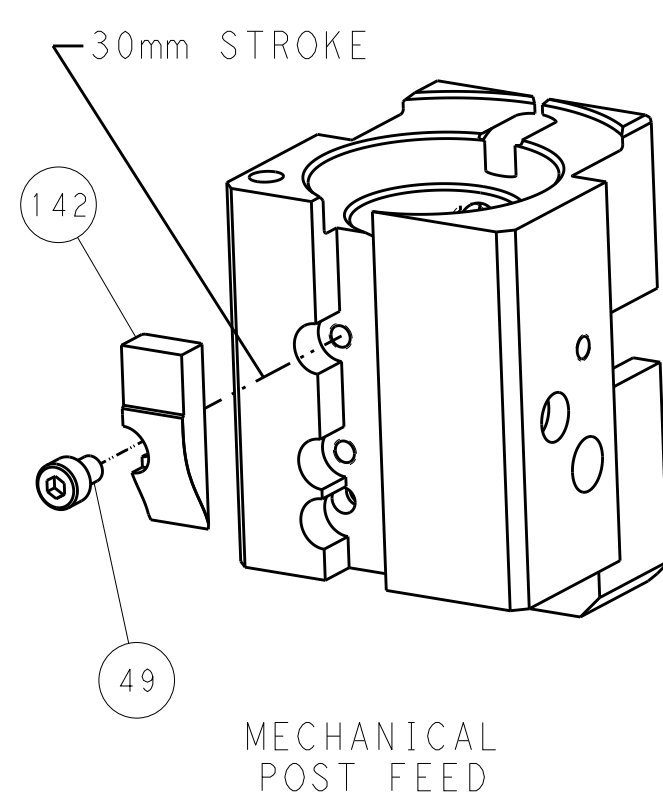
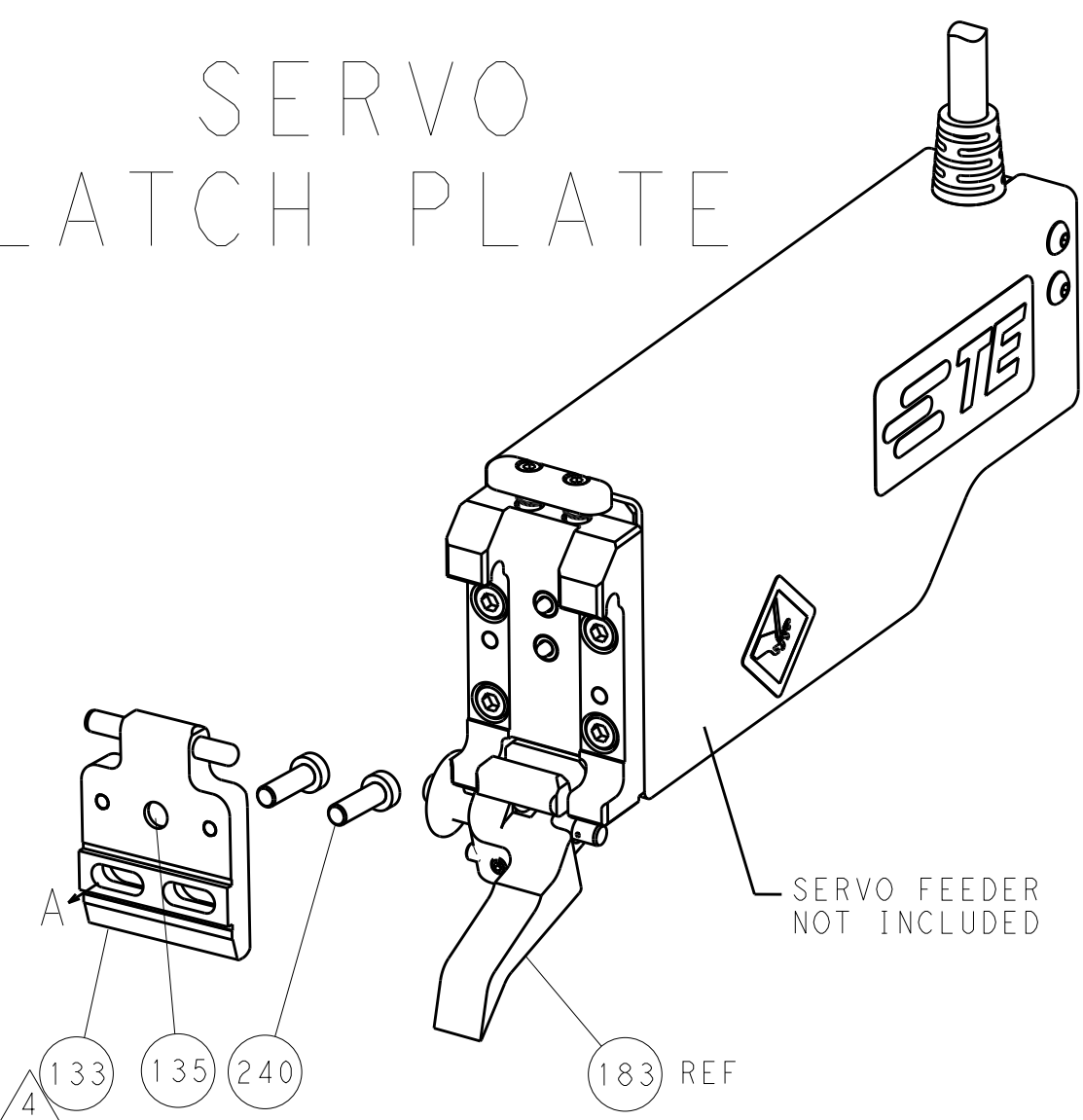
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				CHK L. ZHANG	22JUL2014				
				APVD J. GUO	22JUL2014				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean End Feed Applicator			
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		APPLICATION SPEC					
MATERIAL		FINISH		WEIGHT		SIZE A1			
-		-		-		CASE CODE 00779			
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4			
						REV A			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

AMP 4805 REV 31MAR2000



PNEUMATIC

SERVO
LATCH PLATE

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 ±.05 1 PLC ±.05 2 PLC ±.013 3 PLC ±.0013 4 PLC ±.0001 ANGLES ±.		NAME PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL FINISH		WEIGHT -		SIZE A 00779	
				DRAWING NO C=2150461	
		Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1 SHEET 4 OF 4 REV A	