

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151500-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151500-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151500-1	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151500-2	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151500-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151500-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151500-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL	SOCKET 0.5-2.0 mm2	WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.157-.187 IN [3.99-4.75 mm]			Ø.060-.130 IN [1.52-3.30 mm]
TERMINAL APPLICATION SPECIFICATION	(A)114-1010 (C)114-1012		
	(B)114-1011 (D)114-5214		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL	SOCKET 0.5-2.0 mm2	WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.157-.187 IN [3.99-4.75 mm]			Ø.079-.130 IN [2.01-3.30 mm]
TERMINAL APPLICATION SPECIFICATION	(D)114-18011		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 350536-1	(A) 350536-2	(A) 350536-3	(A) 350536-6
(A) 350536-7	(A) 350654-1	(A) 350654-2	(A) 350654-7
(A) 350687-1	(A) 350687-2	(A) 350687-4	(A) 350687-7
(A) 350687-8	(B) 350217-1	(B) 350218-1	(B) 350218-2
(B) 350218-3	(B) 350218-6	(B) 350218-7	(C) 61117-1
(C) 61117-2	(C) 61117-4	(C) 61117-5	(C) 61117-6
(C) 61117-7	(C) 61118-1	(C) 61118-2	(C) 61118-4
(C) 61118-5	(C) 61118-6	(C) 61118-7	(D) 170120-1
(D) 170120-4	(D) 917636-1		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(D) 926882-1	(D) 926882-3	(D) 926883-1	(D) 926883-3
(D) 926887-1	(D) 926887-3	(D) 926887-7	(D) 927965-1
(D) 927965-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/-0.002]	4.6
2.00mm2	1.70+/-0.05 [.067+/-0.002]	5.0
1.50mm2	1.57+/-0.05 [.062+/-0.002]	6.5
16 AWG	1.50+/-0.05 [.059+/-0.002]	7.2
1.25mm2	1.45+/-0.05 [.057+/-0.002]	7.7
1.00mm2	1.40+/-0.05 [.055+/-0.002]	8.2
18 AWG	1.32+/-0.05 [.052+/-0.002]	9.2
0.75mm2	1.30+/-0.05 [.051+/-0.002]	9.4
0.50mm2	1.22+/-0.05 [.048+/-0.002]	10.2
20 AWG	1.19+/-0.05 [.047+/-0.002]	10.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.73+/-0.05 [.068+/-0.002]	4.6
2.00mm2	1.70+/-0.05 [.067+/-0.002]	5.0
1.50mm2	1.53+/-0.05 [.060+/-0.002]	6.5
16 AWG	1.47+/-0.05 [.058+/-0.002]	7.2
1.25mm2	1.45+/-0.05 [.057+/-0.002]	7.7
1.00mm2	1.37+/-0.05 [.054+/-0.002]	8.2
18 AWG	1.30+/-0.05 [.051+/-0.002]	9.2
0.75mm2	1.30+/-0.05 [.051+/-0.002]	9.4
0.50mm2	1.21+/-0.05 [.048+/-0.002]	10.2
20 AWG	1.21+/-0.05 [.048+/-0.002]	10.6

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

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

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		H		ECR-18-016872	30OCT2018	YY	CT
		J		ECR-19-000938	18JAN2019	JAH	CT
		K		ECR-19-005769	10APR2019	FJ	TE
		L		ECR-20-001923	11FEB2020	FZ	GB

-	-	-	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	2119082-4	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
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1	1	1	1	690438-1	FRONT STRIP GUIDE	95
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	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	3-1752356-4	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	-	-	1	1	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	8-1333205-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-7	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	-	2
1	2	2	1	1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM	1

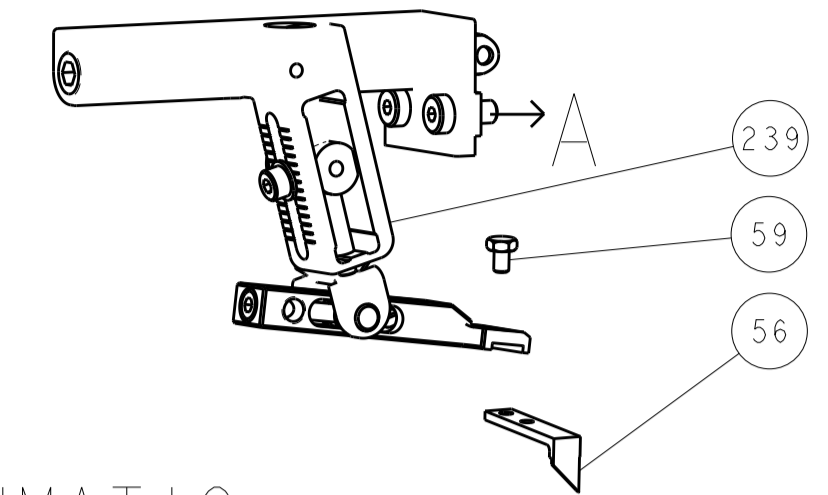
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DATE: 31OCT2011	CHK: T.ELBIN	APVD: T.ELBIN	NAME: Ocean Side Feed Applicator
DATE: 31OCT2011	CHK: T.ELBIN	APVD: T.ELBIN	NAME: Ocean Side Feed Applicator

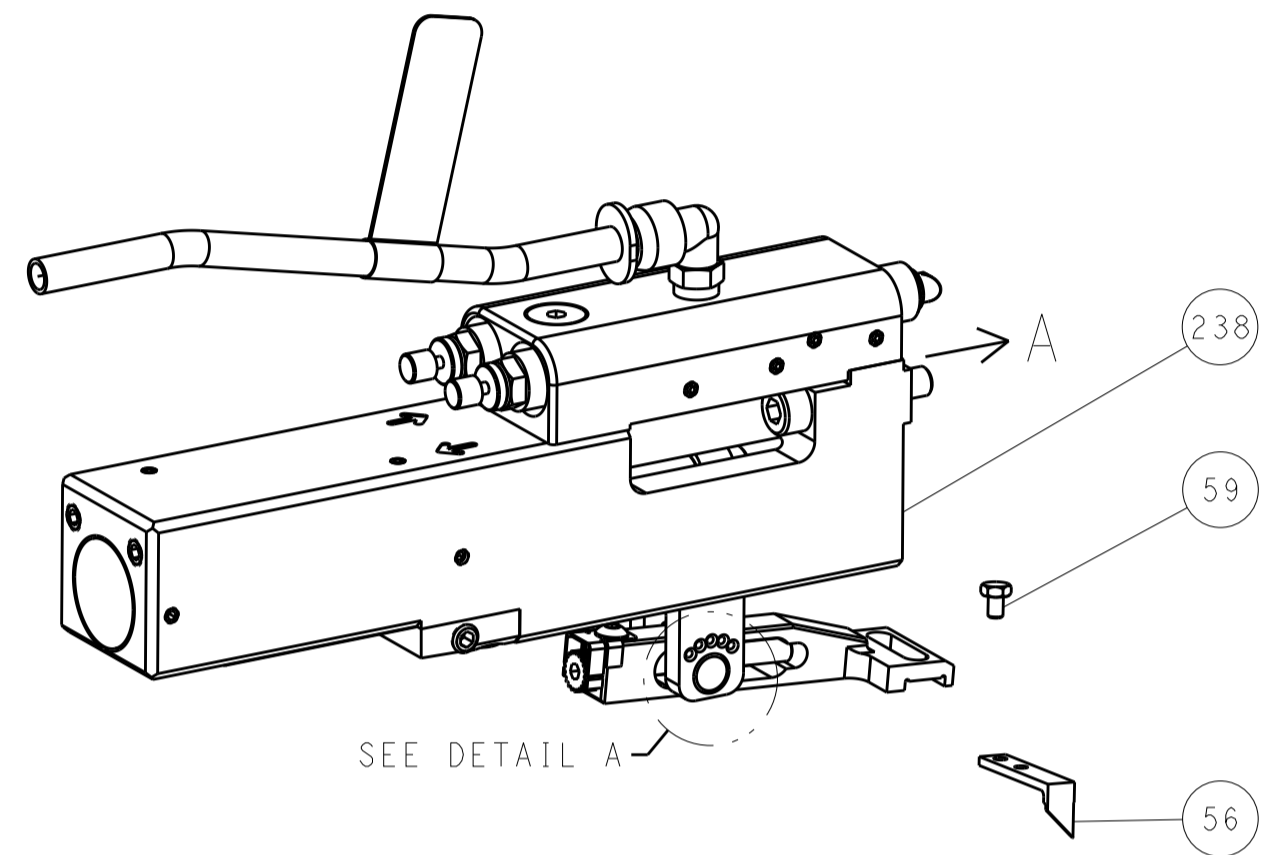
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Customer Accessible Production Drawing			SCALE: 1:2 SHEET 1 OF 4 REV L

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

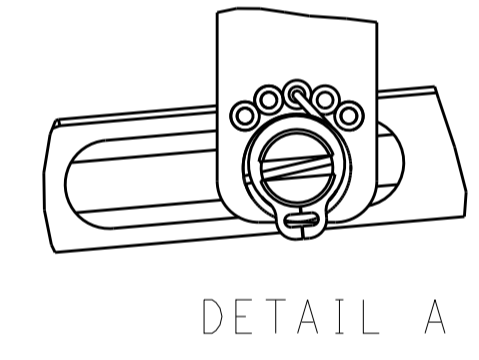
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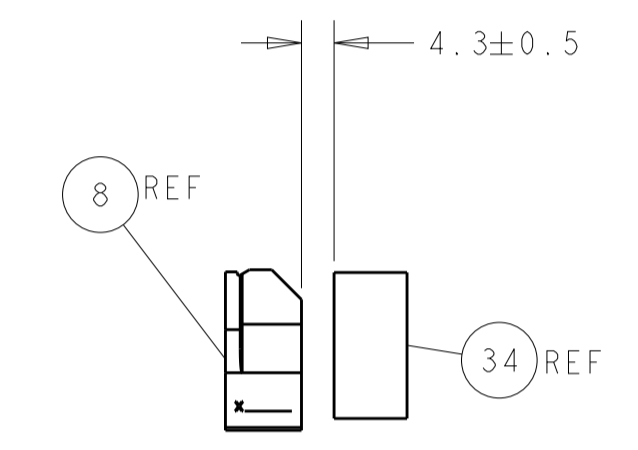
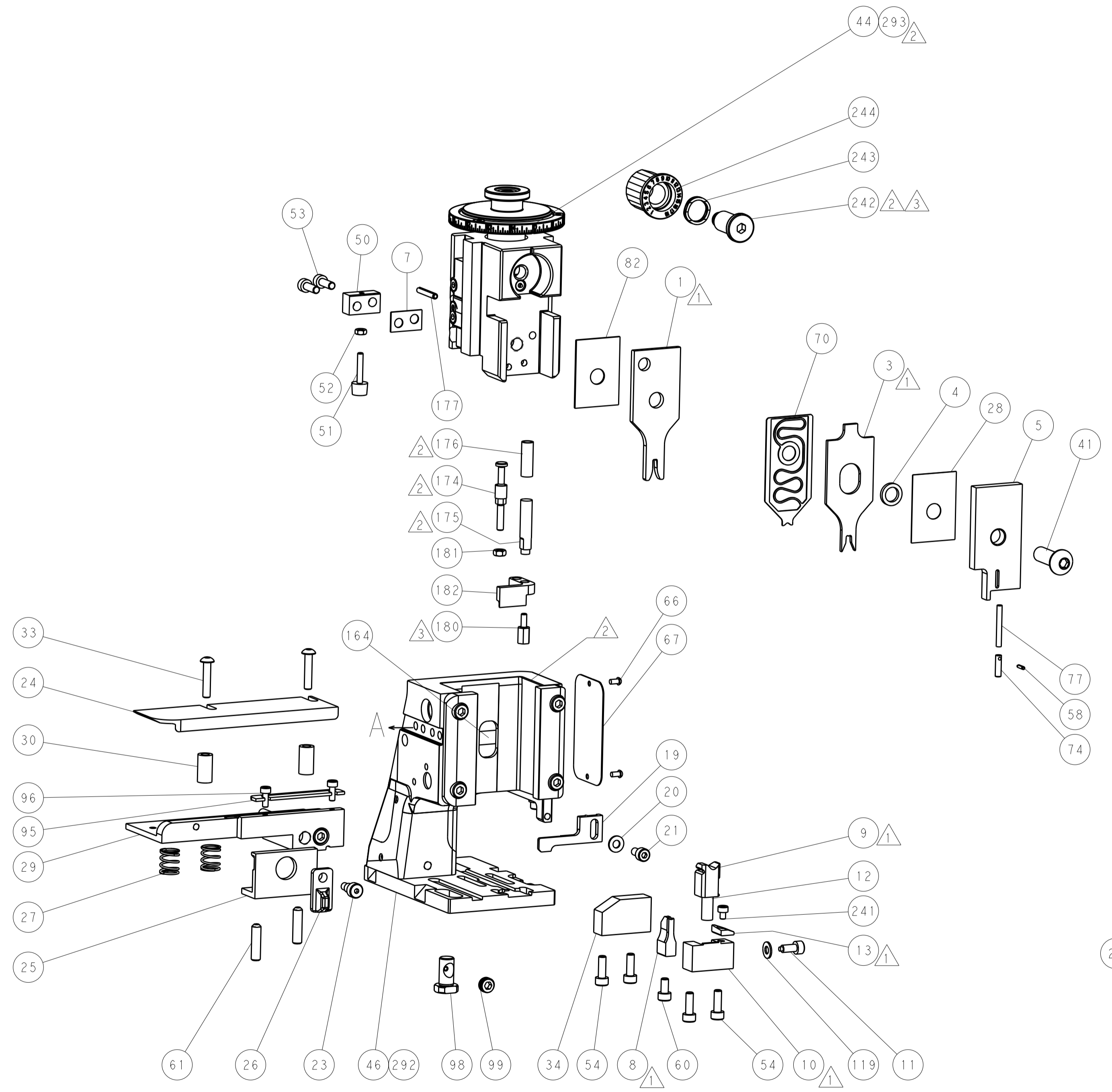
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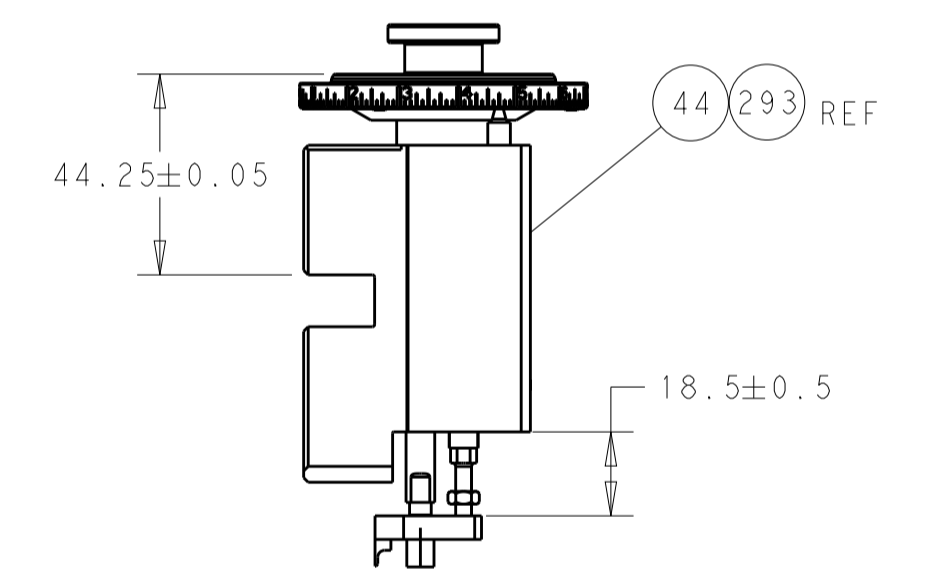
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



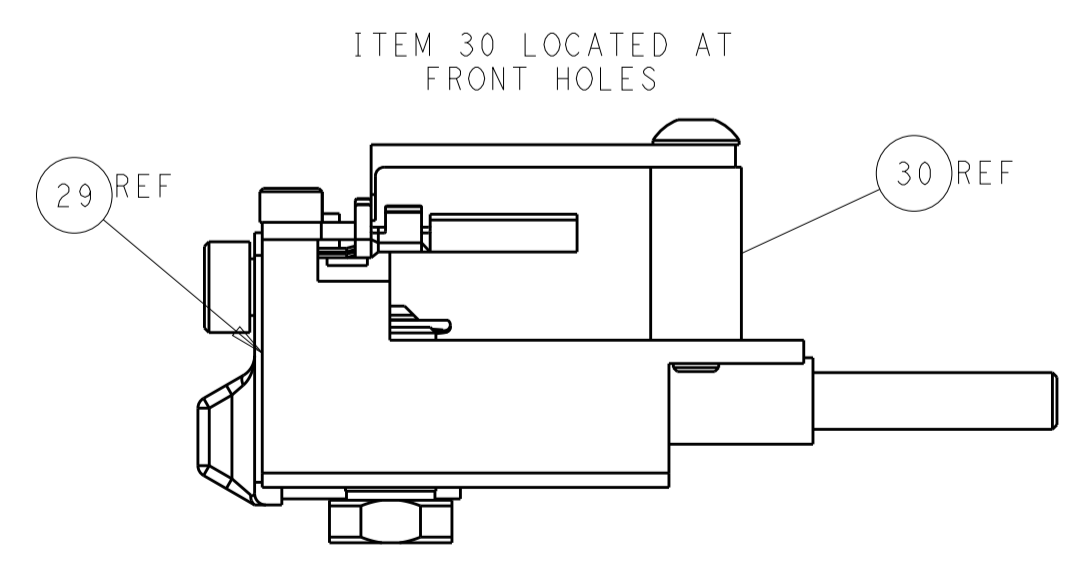
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND 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:		DWG: HOFFNER 28OCT2011		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 31OCT2011	Harrisburg, PA 17105-3608		
	1 PLC	±		APPV: T. ELBIN 31OCT2011	NAME: Ocean Side Feed Applicator		
	2 PLC	±		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO		
	3 PLC	±		APPLICATION SPEC	A1 00779 ©=2151500		
	4 PLC	±		WEIGHT	Customer Accessible Production Drawing		
MATERIAL:	FINISH:			SCALE: 1:2	SHEET: 2 OF 4	REV: L	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151500-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151500-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151500-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL SOCKET 0.5-2.0 mm2			
WIRE STRIP LENGTH .157-.187 IN [3.99-4.75 mm]		INSULATION DIAMETER RANGE Ø.060-.130 IN [1.52-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	(A)114-1010 (B)114-1011	(C)114-1012 (D)114-5214	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 350536-1	(A) 350536-2	(A) 350536-3	(A) 350536-6
(A) 350536-7	(A) 350654-1	(A) 350654-2	(A) 350654-7
(A) 350687-1	(A) 350687-2	(A) 350687-4	(A) 350687-7
(A) 350687-8	(B) 350217-1	(B) 350218-1	(B) 350218-2
(B) 350218-3	(B) 350218-6	(B) 350218-7	(C) 61117-1
(C) 61117-2	(C) 61117-4	(C) 61117-5	(C) 61117-6
(C) 61117-7	(C) 61118-1	(C) 61118-2	(C) 61118-4
(C) 61118-5	(C) 61118-6	(C) 61118-7	(D) 170120-1
(D) 170120-4	(D) 917636-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/- .002]	4.6
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TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL SOCKET 0.5-2.0 mm2			
WIRE STRIP LENGTH .157-.187 IN [3.99-4.75 mm]		INSULATION DIAMETER RANGE Ø.079-.130 IN [2.01-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	(D)114-18011	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(D) 926882-1	(D) 926882-3	(D) 926883-1	(D) 926883-3
(D) 926887-1	(D) 926887-3	(D) 926887-7	(D) 927965-1
(D) 927965-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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. 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.

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

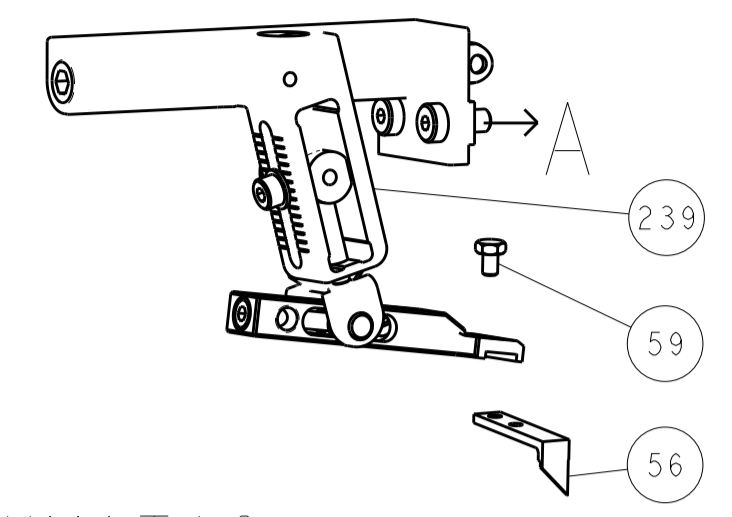
LOC	DIST	REV	DATE	BY	APP'D
A	66				

REV	DATE	DESCRIPTION	ITEM NO
-	-	SEE SHEET 1	-
-	1	2119082-4	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
-	-	2119580-1	MECHANICAL FEED ASSEMBLY 239
-	1	2844940-1	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
-	-	2119653-2	FEED CAM, POST FEED 142
-	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
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0 96
-	1	690438-1	FRONT STRIP GUIDE 95
-	1	455888-7	SPACER, CRIMPER 82
-	1	5-547505-2	SPRING, COMPRESSION 77
-	1	854769-4	HOLDER, INS 74
-	1	1803607-3	DOCUMENTATION PACKAGE 71
-	1	2119791-5	DEPRESSOR, WIRE 70
-	1	2119740-1	TAG, IDENTIFICATION 67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188 66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0 61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0 59
-	1	21028-2	PIN, SLOTTED SPRING .062 X .250 58
-	1	1338685-1	PAWL, FEED 56
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0 53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3 52
-	1	811242-5	BUMPER, HOLD DOWN 51
-	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
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25) 41
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-	1	238011-7	BLOCK, CRIMPER SPACER 4
-	1	1633962-3	CRIMPER, INSULATION F PREMIUM 3
-	-	-	2
-	1	3-456406-3	CRIMPER, WIRE PREMIUM 1

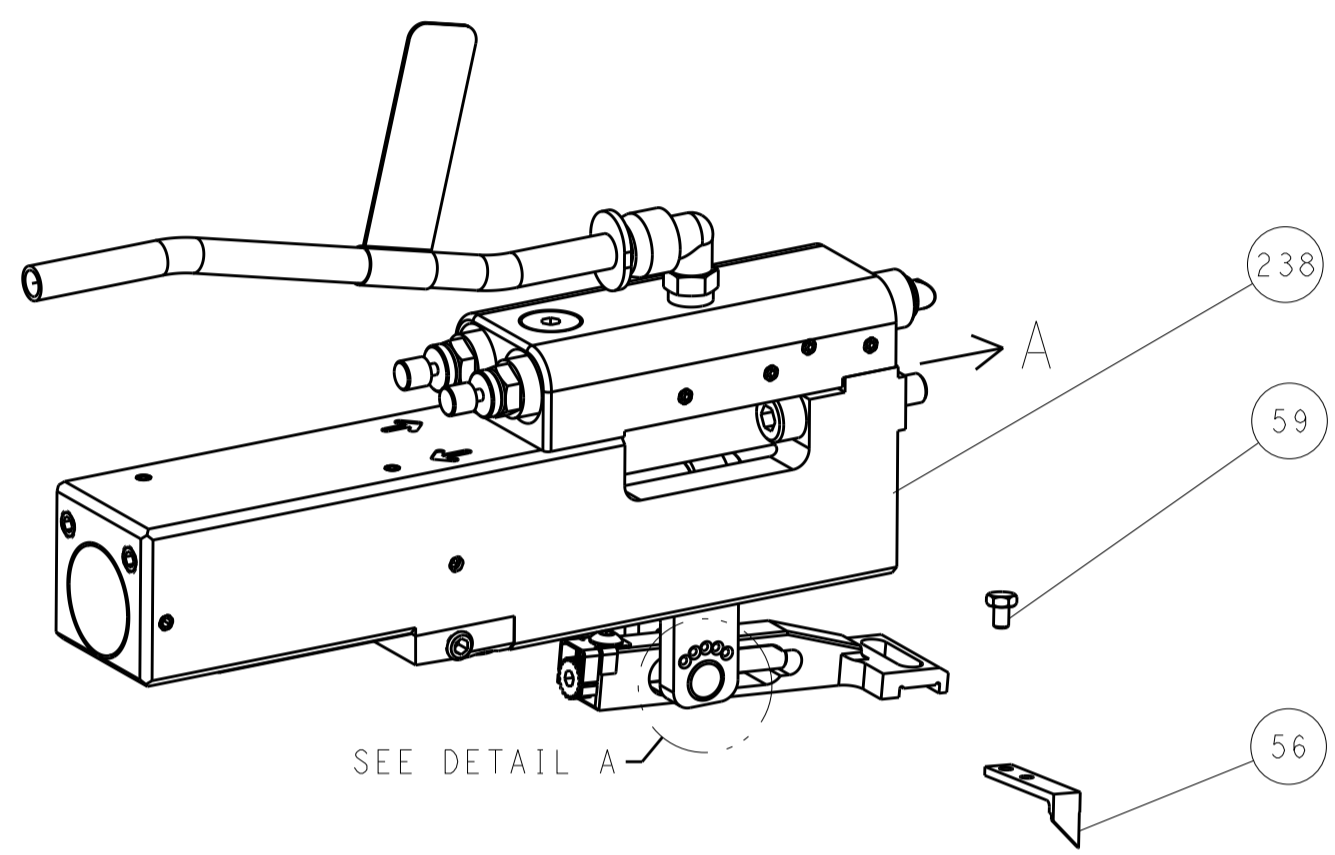
REV	DATE	DESCRIPTION	ITEM NO
-77	-22	-21	PART NO
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	ANGLES ±
MATERIAL	FINISH	WEIGHT	SCALE

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

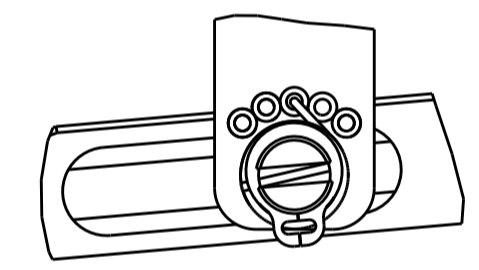
# FEED TYPE MECHANICAL



## PNEUMATIC

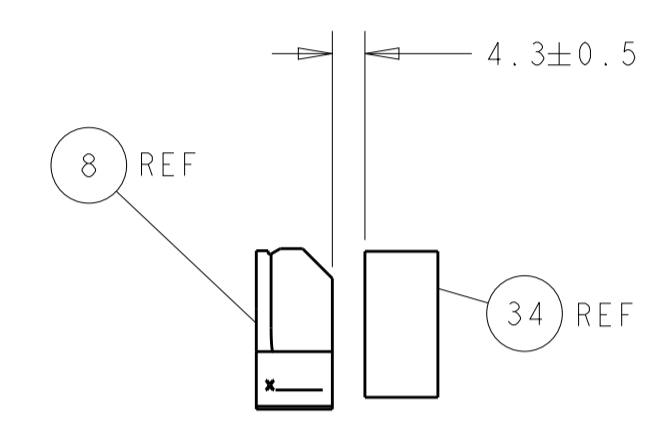
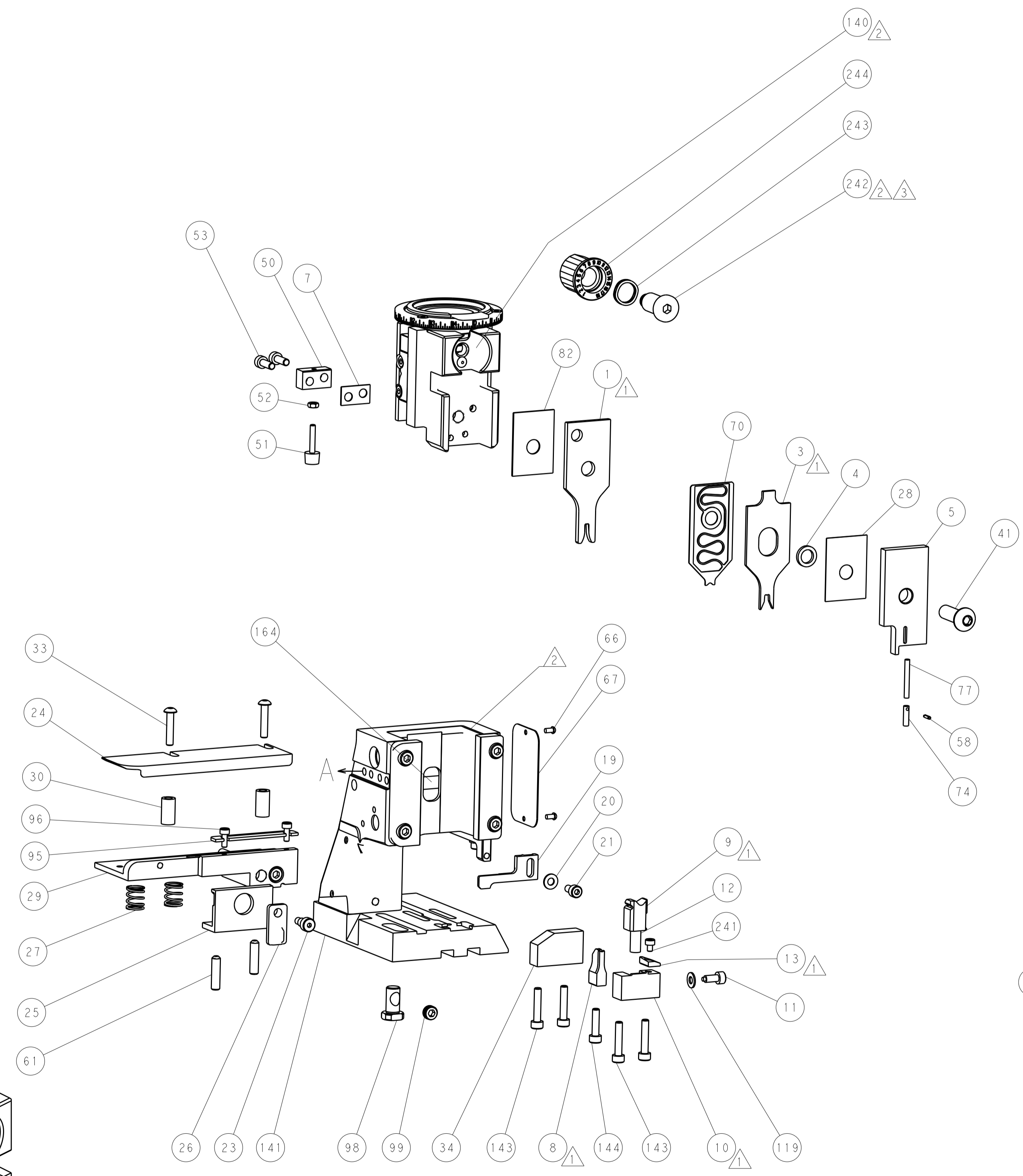
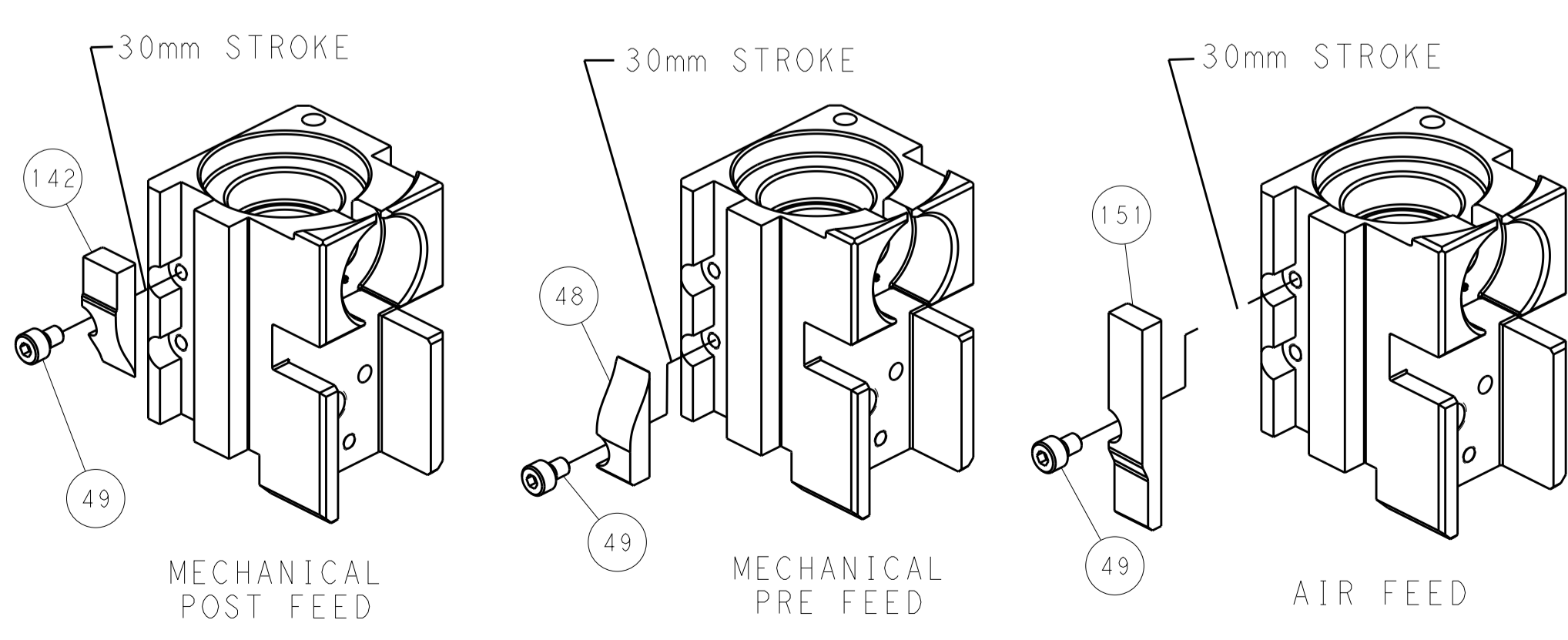


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

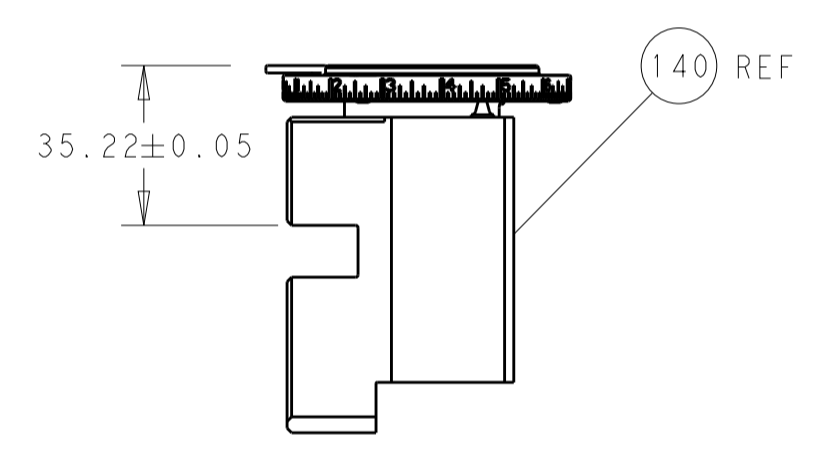


DETAIL A

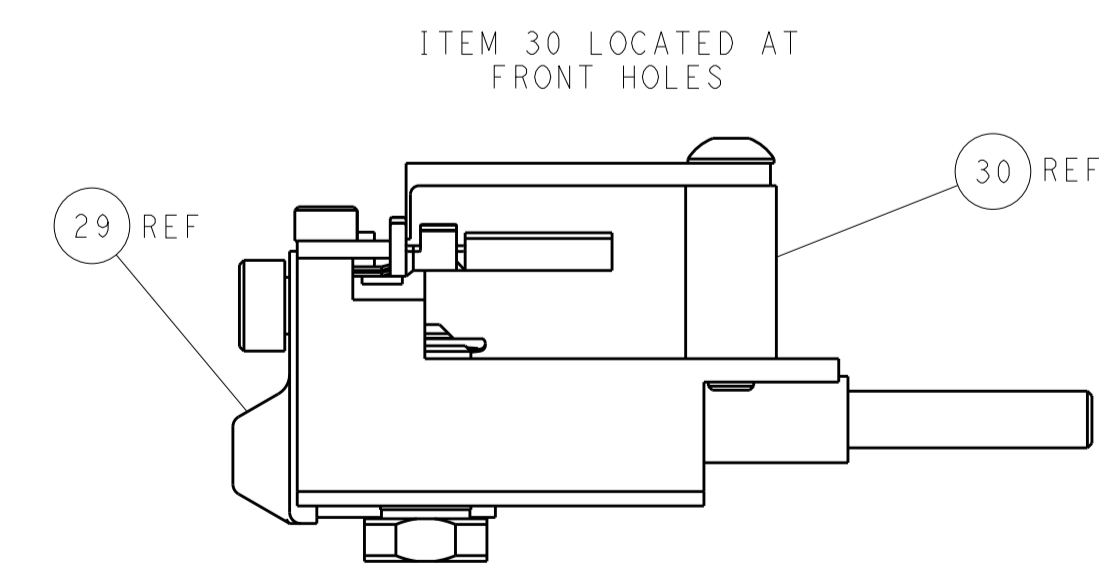
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN HOFFNER 28OCT2011 CHK T. ELBIN 31OCT2011 APVD T. ELBIN 31OCT2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151500 SCALE 1:2 SHEET 4 OF 4 REV L		RESTRICTED TO -	
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