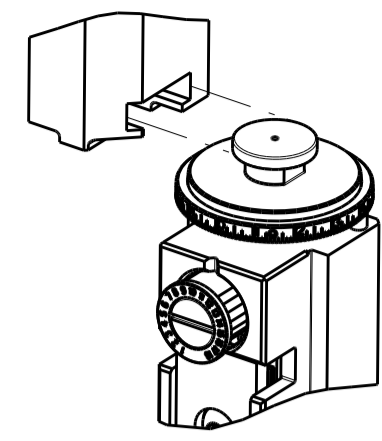


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151122-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151122-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151122-1 | D | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151122-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151122-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.79 mm [.110] | F |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|---------------|------------------------------|---------------|
| TERMINAL NAME: DUAC SOCKET CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.40-3.20 mm [.094-.126 IN] | | Ø1.50-2.40 mm [.059-.094 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)1114-19048 | | |
| | (B)114-6067 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 794576-1 | (A) 794576-3 | (A) 794576-4 | (A) 794138-3 |
| (A) 1-794138-3 | (A) 106529-2 | (A) 1-106529-2 | (B) 1586405-3 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 18 AWG | 1.07 +/- 0.05 [.042 +/- .002] | 5.8 |
| 20 AWG | 0.91 +/- 0.05 [.036 +/- .002] | 7.6 |
| 22 AWG | 0.81 +/- 0.05 [.032 +/- .002] | 8.6 |

- 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. 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)

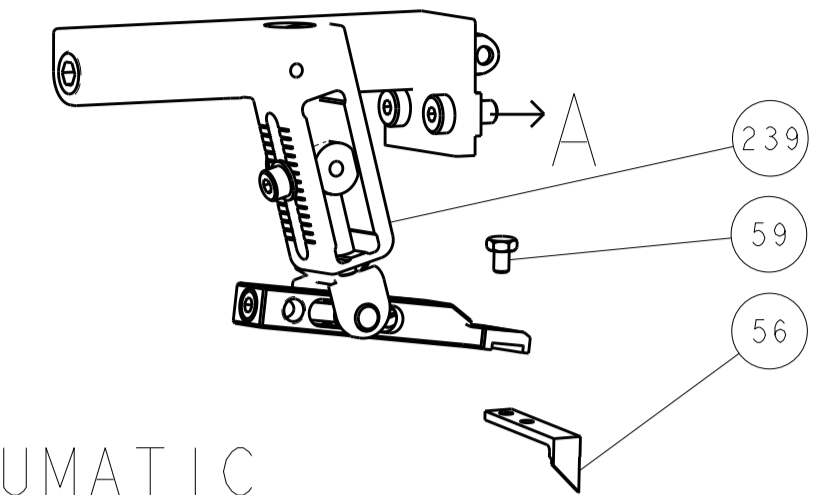
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|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | A | | RELEASED | 02FEB2012 | KH | SX |
| | | B | | ECR-13-017650 | 12NOV2013 | KH | TE |
| | | C | | ECR-14-012413 | 18AUG2014 | BH | GB |
| | | D | | ECR-20-010180 | 17JUL2020 | FZ | TE |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 1 | 1 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 241 |
| - | - | 1 | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 1 | - | 2844940-1 | AIR FEED MODULE | 238 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 |
| - | 1 | 1 | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | 1 | 2 | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | 1 | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | 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 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1 | 1 | 1752356-1 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2 | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 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 |
| - | 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 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| 1 | 2 | 2 | 1 | 1 | 1-1333202-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 2-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 2 | 2 | 1 | 1 | 2-2119582-5 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| 1 | 2 | 2 | 1 | 1 | 2-1633730-4 | CRIMPER, WIRE | 1 |
| - | 77 | -72 | -71 | -2 | -1 | PART NO | ITEM NO |

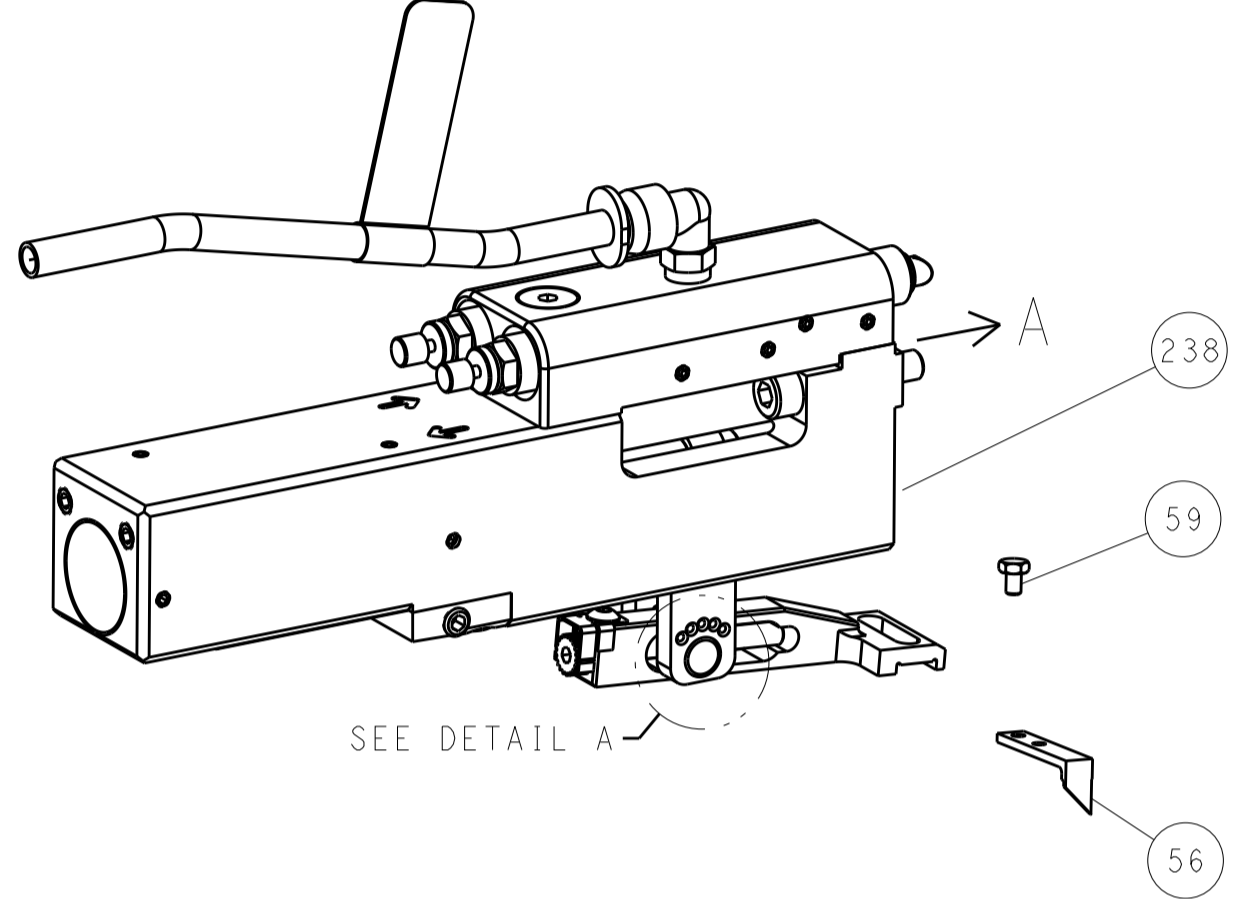
| | | | |
|--|--|---|---|
| <small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF STC CONNECTIVITY CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO COPY OR REPRODUCE THIS DRAWING IN ANY MANNER MUST BE OBTAINED FROM STC CONNECTIVITY CORPORATION. CONTACT: 171105-3608</small> | | DWN H. HUANG 30SEP2011 S. XI 30SEP2011 I. CRUZ 30SEP2011 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | NAME Ocean Side Feed Applicator |
| MATERIAL: | | WEIGHT: | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151122 RESTRICTED TO: |
| Customer Accessible Production Drawing | | SCALE: 1:2 | SHEET 1 OF 4 REV D |

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

FEED TYPE MECHANICAL



PNEUMATIC

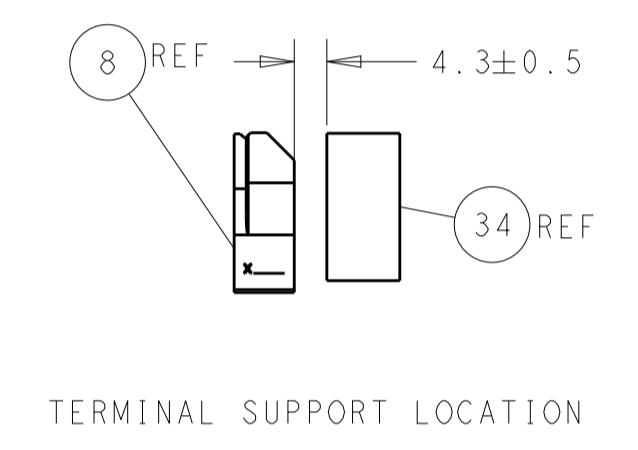
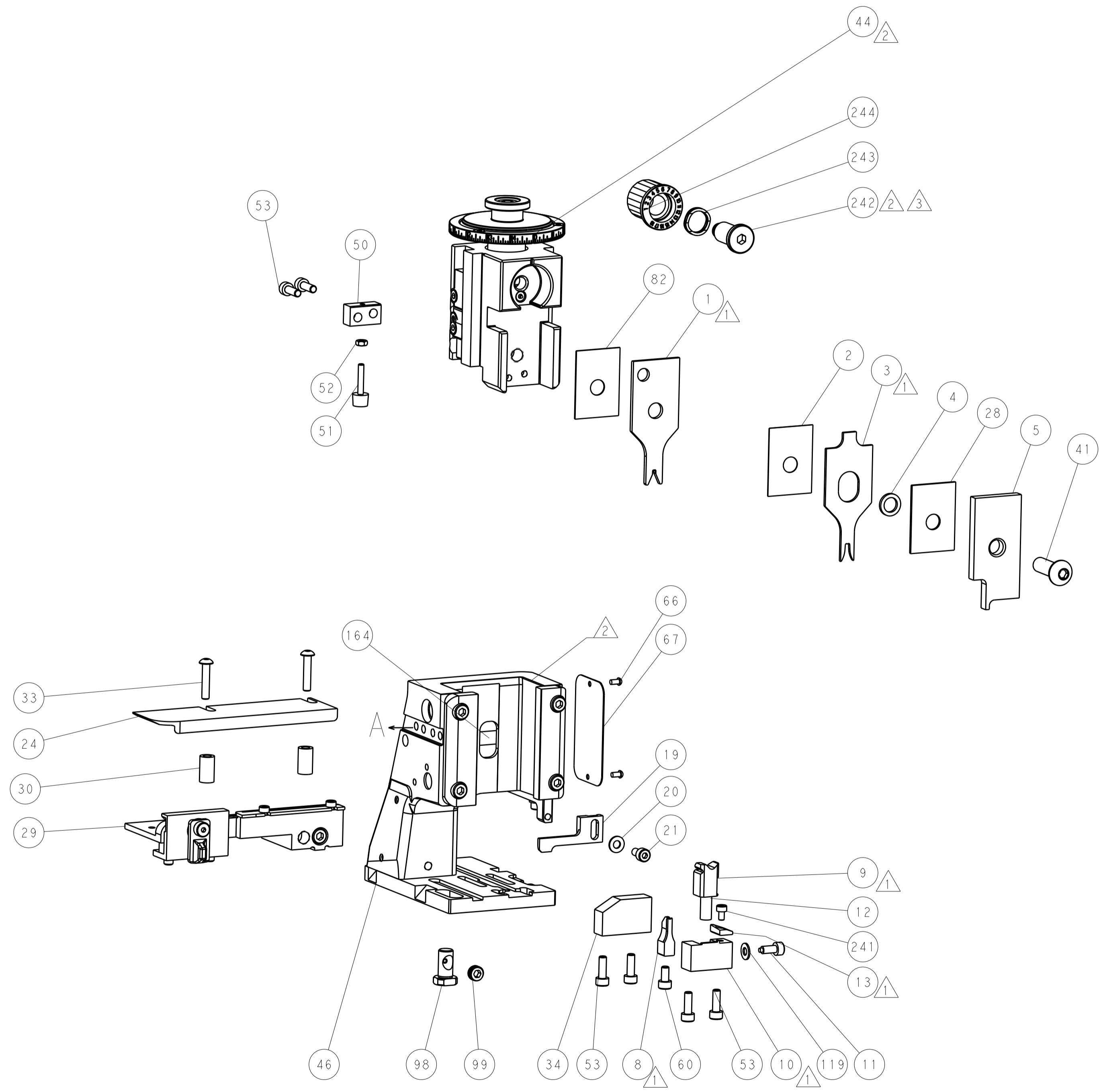


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

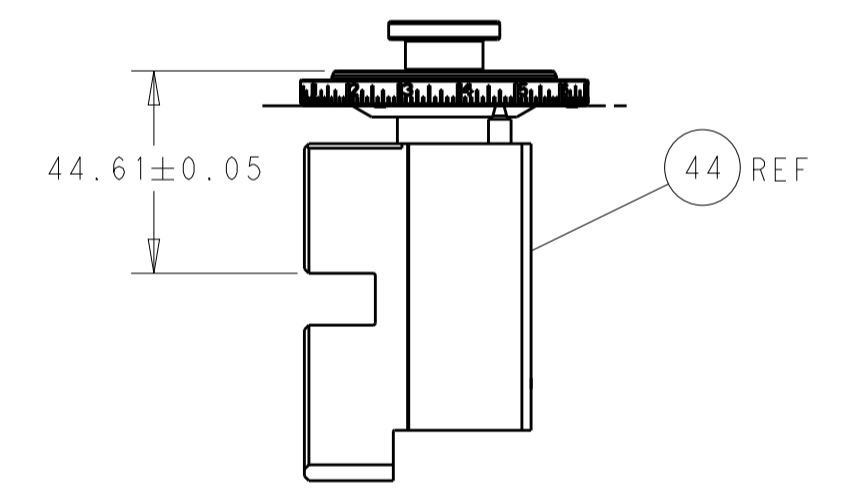


DETAIL A

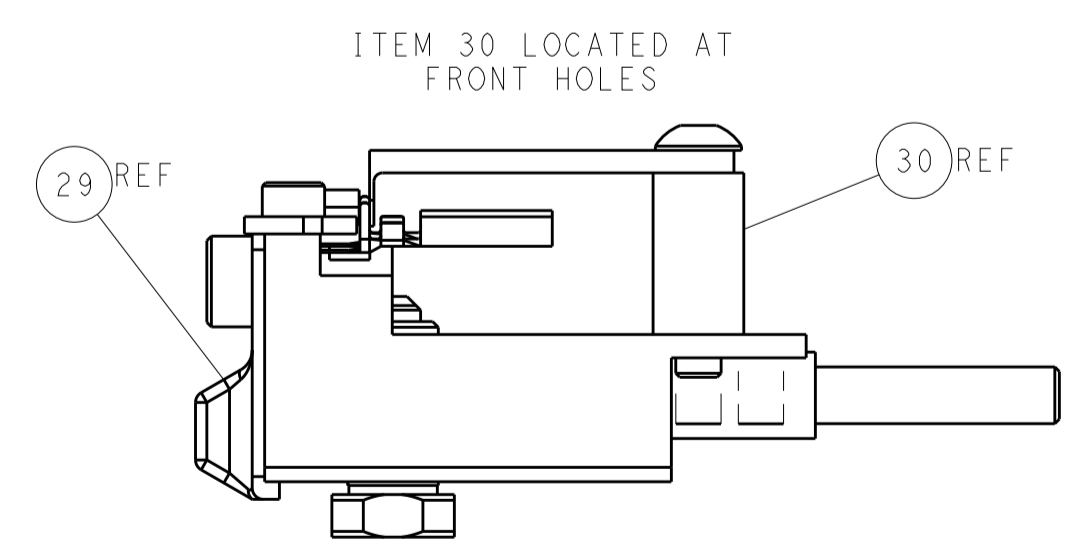
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 R. HUANG 30SEP2011 | | TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC | ± | | CHK S. XI | 30SEP2011 | NAME Ocean Side Feed Applicator | |
| | 1 PLC | ± | | APVD J. CRUZ | 30SEP2011 | SIZE A1 00779 ©=2151122 | |
| | 2 PLC | ± | | PRODUCT SPEC | | RESTRICTED TO | |
| | 3 PLC | ± | | APPLICATION SPEC | | Customer Accessible Production Drawing | |
| | 4 PLC | ± | | WEIGHT | | SCALE 1:2 SHEET 2 OF 4 REV D | |
| | ANGLES | ± | | MATERIAL | | Customer Accessible Production Drawing | |

| THIS DRAWING IS UNPUBLISHED. | RELEASED FOR PUBLICATION | | |
|--|--------------------------|--------------------------|------------|
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2151122-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151122-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151122-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.79 mm [.110] | F |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|--|--------------|---|---------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: DUAC SOCKET CONTACT | | | |
| WIRE STRIP LENGTH 2.40-3.20 mm [.094-.126 IN] | | INSULATION DIAMETER RANGE Ø1.50-2.40 mm [.059-.094 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-19048 | - | - |
| | (B)114-6067 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 794576-1 | (A) 794576-3 | (A) 794576-4 | (A) 794138-3 |
| (A) 1-794138-3 | (A) 106529-2 | (A) 1-106529-2 | (B) 1586405-3 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 18 AWG | 1.07+/-0.05 [.042+/-0.002] | 5.8 |
| 20 AWG | 0.91+/-0.05 [.036+/-0.002] | 7.6 |
| 22 AWG | 0.81+/-0.05 [.032+/-0.002] | 8.6 |



- 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. 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 | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | | | |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 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 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 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 | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | 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 | 1752356-1 | 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 | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1-1333202-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 2-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 2-2119582-5 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 2-1633730-4 | CRIMPER, WIRE | 1 |

| | | | | | |
|--|---------|--|---------|------------------------------|---------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN H. HUANG 30SEP2011 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| ANGLES | FINISH | | | CHK S. XI 30SEP2011 | |
| MATERIAL | | | | APVD I. CRUZ 30SEP2011 | |
| Customer Accessible Production Drawing | | SCALE 1:2 | | SHEET 3 OF 4 | |

STE TE Connectivity
Harrisburg, PA 17105-3608

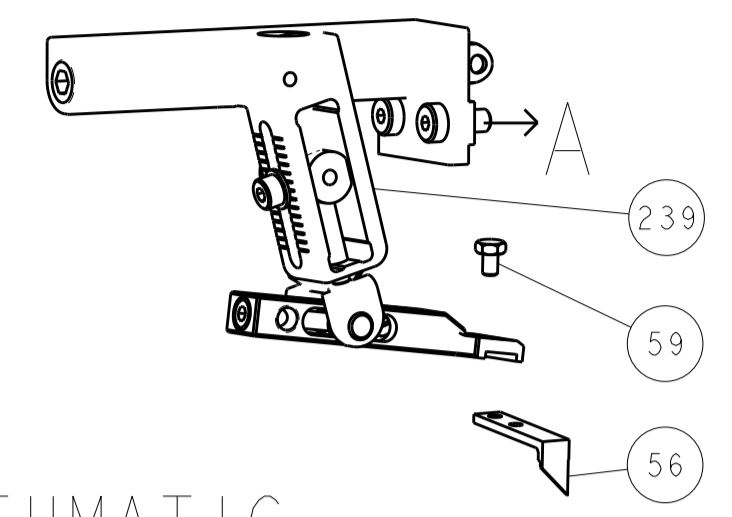
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SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151122

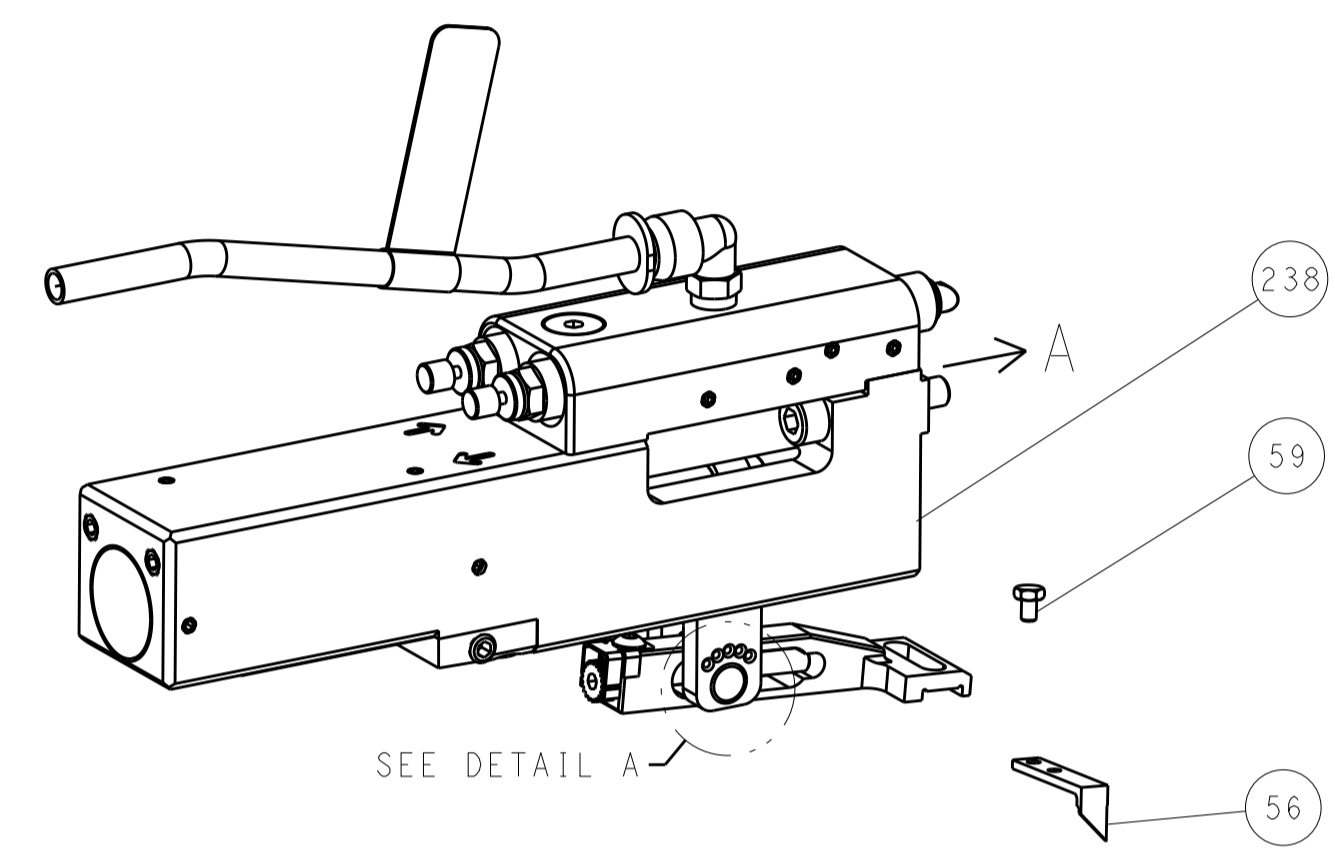
RESTRICTED TO: -

| LOC | | DIST | | REVISONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | | | |

FEED TYPE MECHANICAL



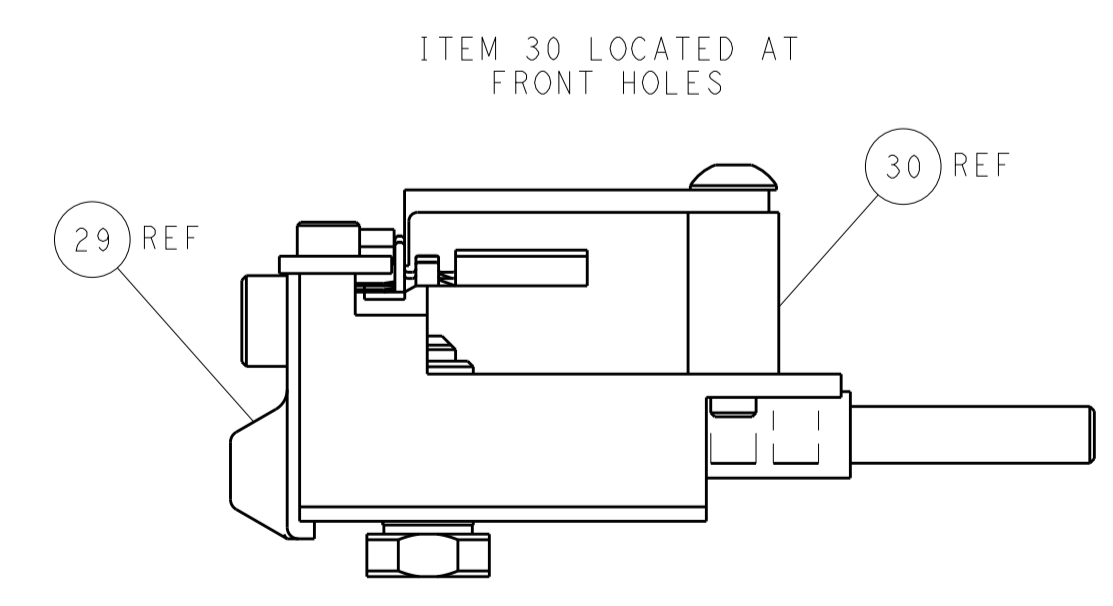
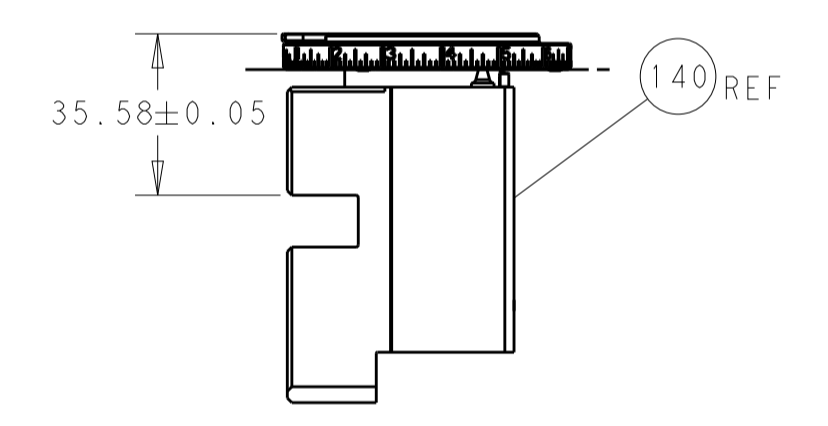
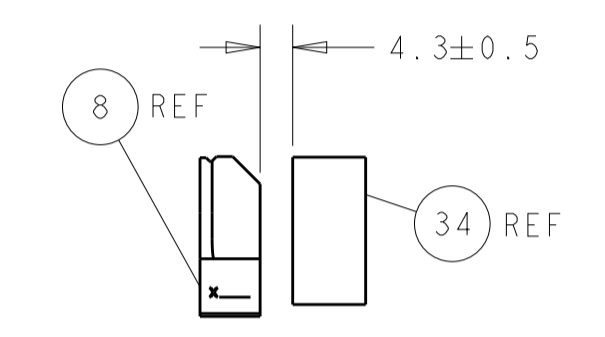
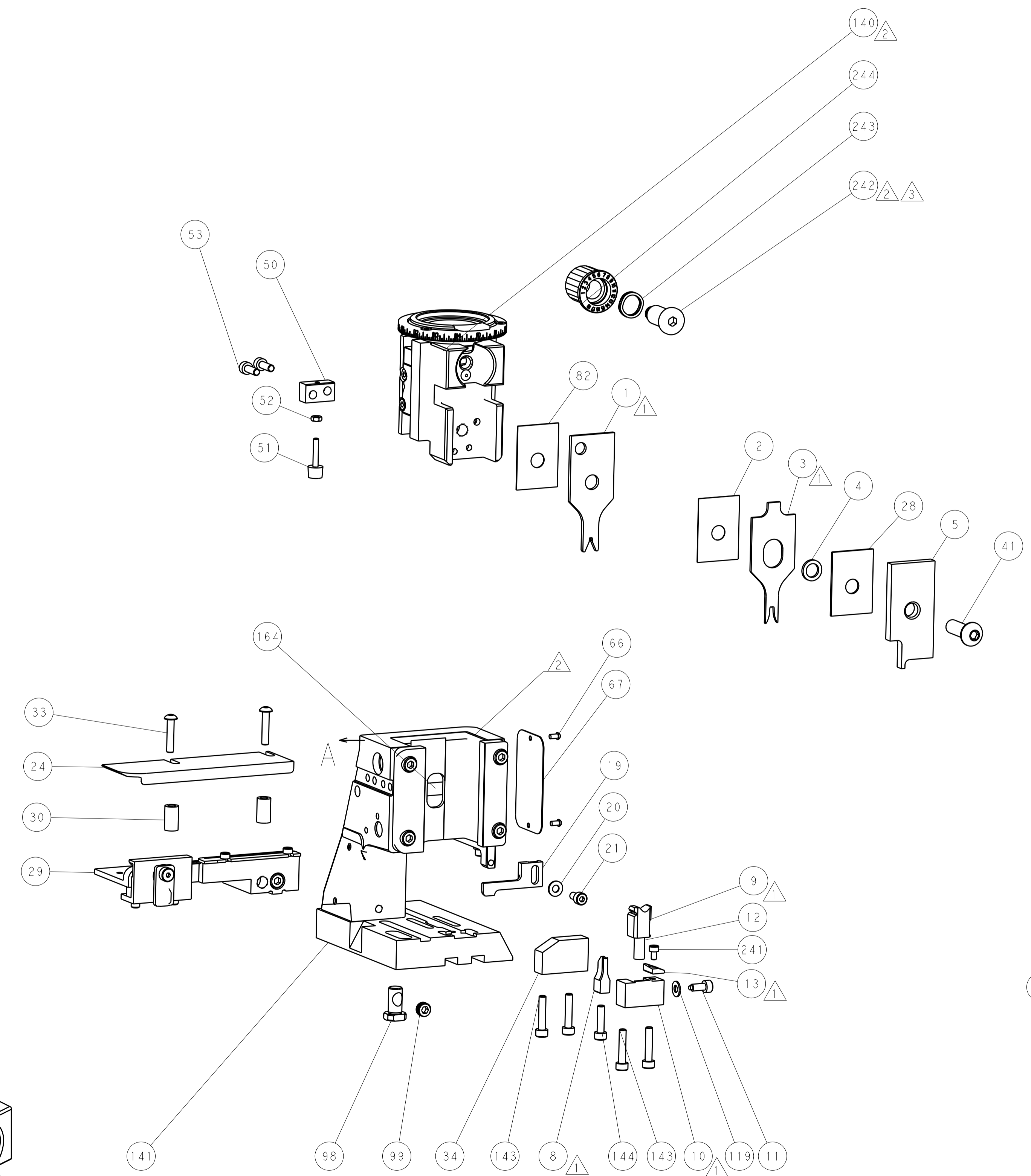
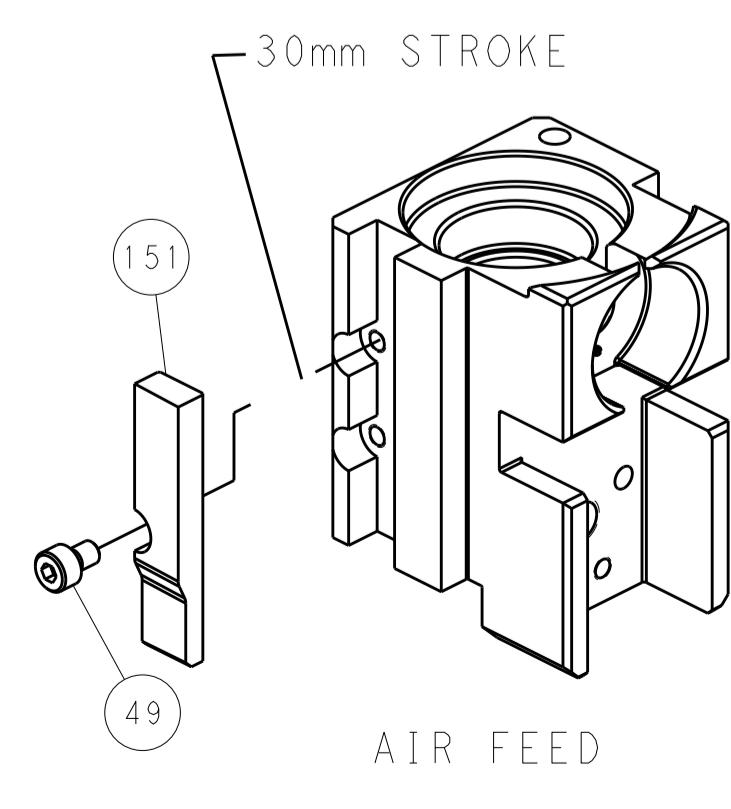
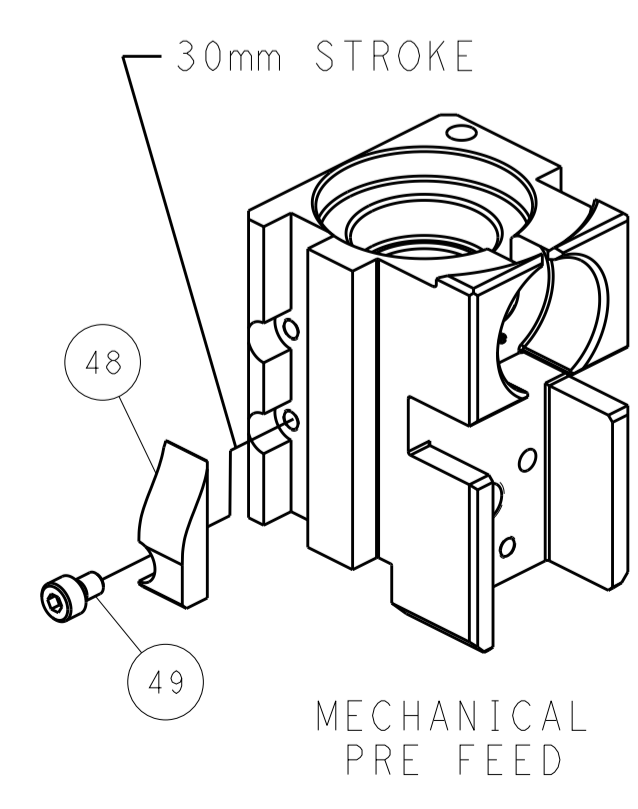
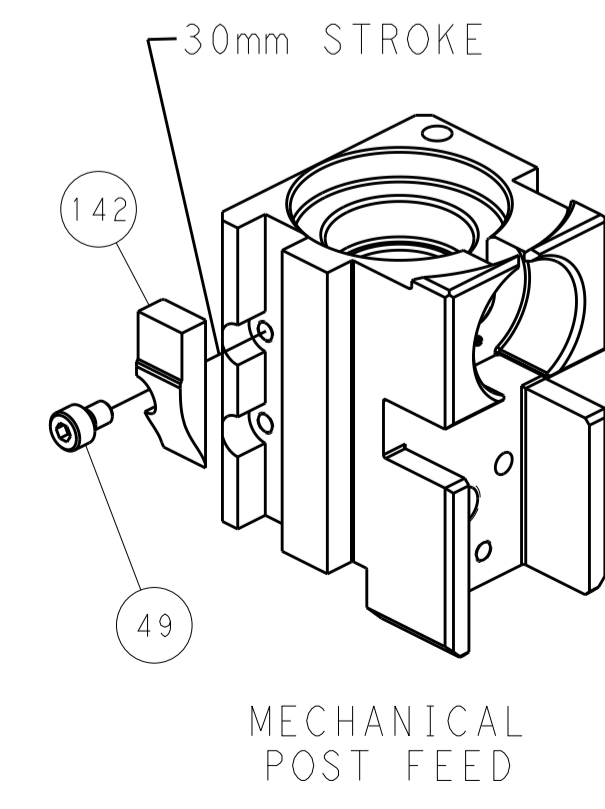
PNEUMATIC



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)

| | | | | | | | |
|-------------|---------|--|---------|-------------------------|------------|-----------------|----------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: R. HUANG 30SEP2011 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | ANGLES ± |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | SIZE: | CAGE CODE: | DRAWING NO: | RESTRICTED TO: |
| | | | 1:2 | A1 | 00779 | ©=2151122 | |

Customer Accessible Production Drawing SHEET 4 OF 4 REV D