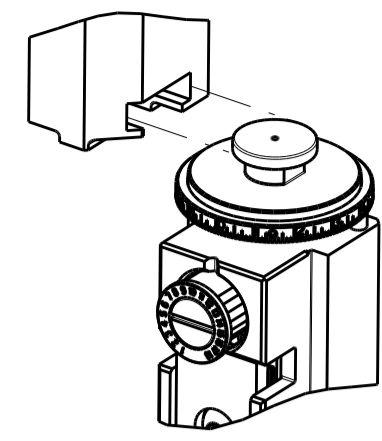


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266215-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266215-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266215-1 | C | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266215-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266215-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.17 mm [.046] | F |
| INSUL | 1.78 mm [.070] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: JST TERMINAL | | JST CRIMP SPECIFICATION | |
|------------------------------------|-------------------------|-----------------------------|----------------|
| TERMINAL NAME: SOCKET CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 1.70-1.72 mm [.067-.068 IN] | | 1.20-1.90 mm [.047-.075 IN] | |
| TERMINAL APPLICATION SPECIFICATION | JST HM-0041 (CHM-1-089) | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | JST TERMINAL | TE TERMINAL | JST TERMINAL |
| 1642501-1 | SXA-001T-P0.6 | 2113431-1 | SXAM-001T-P0.6 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 22 AWG | 0.75 +/- 0.05 [.030 +/- .002] | 9.5 |
| 24 AWG | 0.70 +/- 0.05 [.028 +/- .002] | 10 |
| 26 AWG | 0.65 +/- 0.05 [.026 +/- .002] | 10.5 |
| 28 AWG | 0.60 +/- 0.05 [.024 +/- .002] | 11 |

- 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)

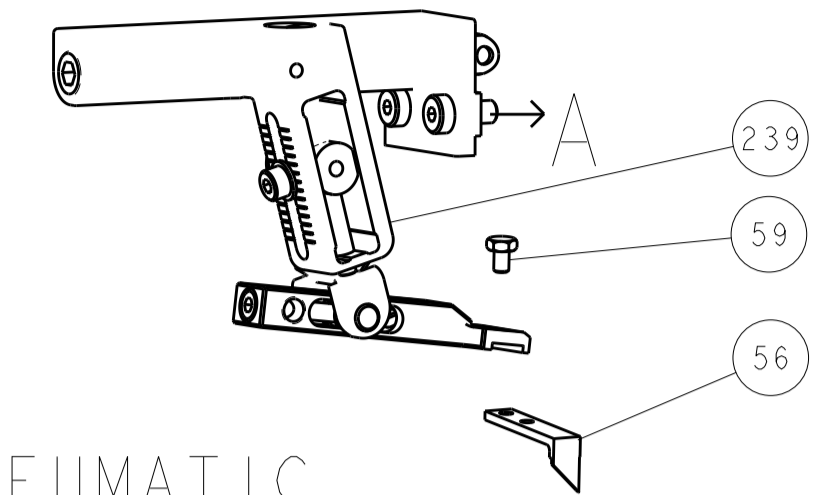
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| | | A1 | | ECR-15-001661 | 02FEB2015 | YY | TE |
| | | B | | ECR-20-005768 | 21APR2020 | FZ | TE |
| | | C | | ECR-20-006582 | 07MAY2020 | JWC | GB |
| | | C1 | | ECR-20-007309 | 21MAY2020 | FZ | RK |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | 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 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 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 | 1-455888-2 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1962431-2 | SPRING, COMPRESSION | 77 | |
| - | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 | |
| - | 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 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 | |
| - | 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 | 1-2168083-4 | SCR, SKT HD CAP, RoHS, M4 X 5 | 53 | |
| - | 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 | 1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 455888-3 | 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 | |
| - | 3 | 3 | 3 | 3 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 1 | 1 | 1 | 2-690518-9 | HOLD DOWN, TERMINAL | 18 | |
| - | 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 | 1633861-4 | SHEAR, FLOATING | 9 | |
| - | 1 | 2 | 2 | 1 | 1333228-8 | ANVIL | 8 | |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119780-4 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 5-238011-3 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 5-1633962-1 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 3-1633730-7 | CRIMPER, WIRE | 1 | |
| - | 77 | 72 | 71 | 2 | -1 | PART NO | DESCRIPTION | ITEM NO |

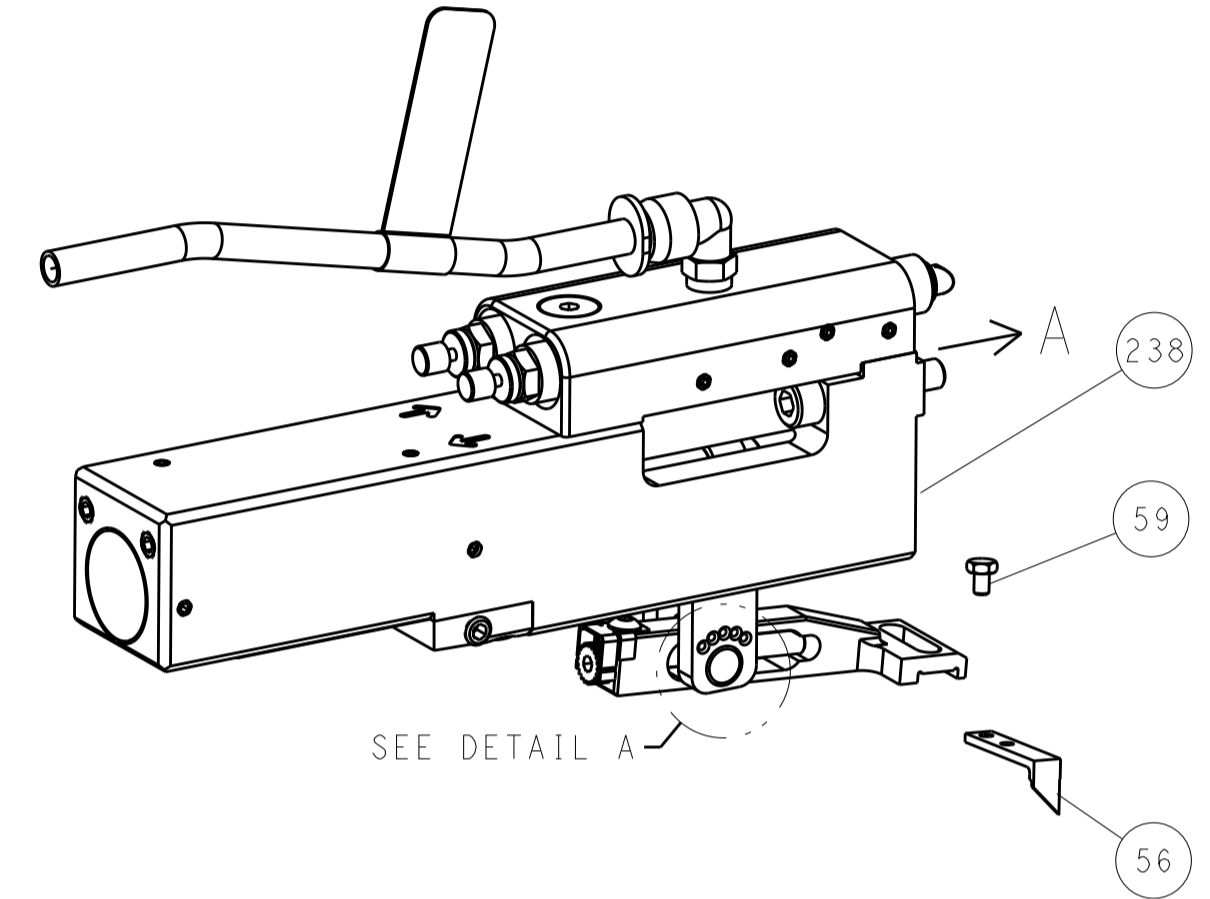
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|--|--|---|--|---|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | | DWN: STAKEM 03FEB2014 CHK: G. BAILEY 03FEB2014 APVD: T. ERLIN 03FEB2014 | | TE Connectivity Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | WEIGHT: | | NAME: Ocean Side Feed Applicator | |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SCALE: 1:2 | | SHEET 1 OF 4 | | REV: C1 | |

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

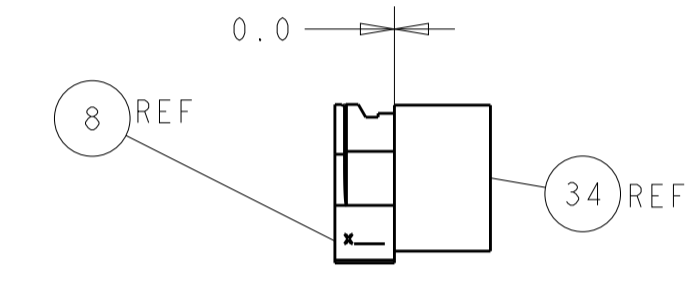
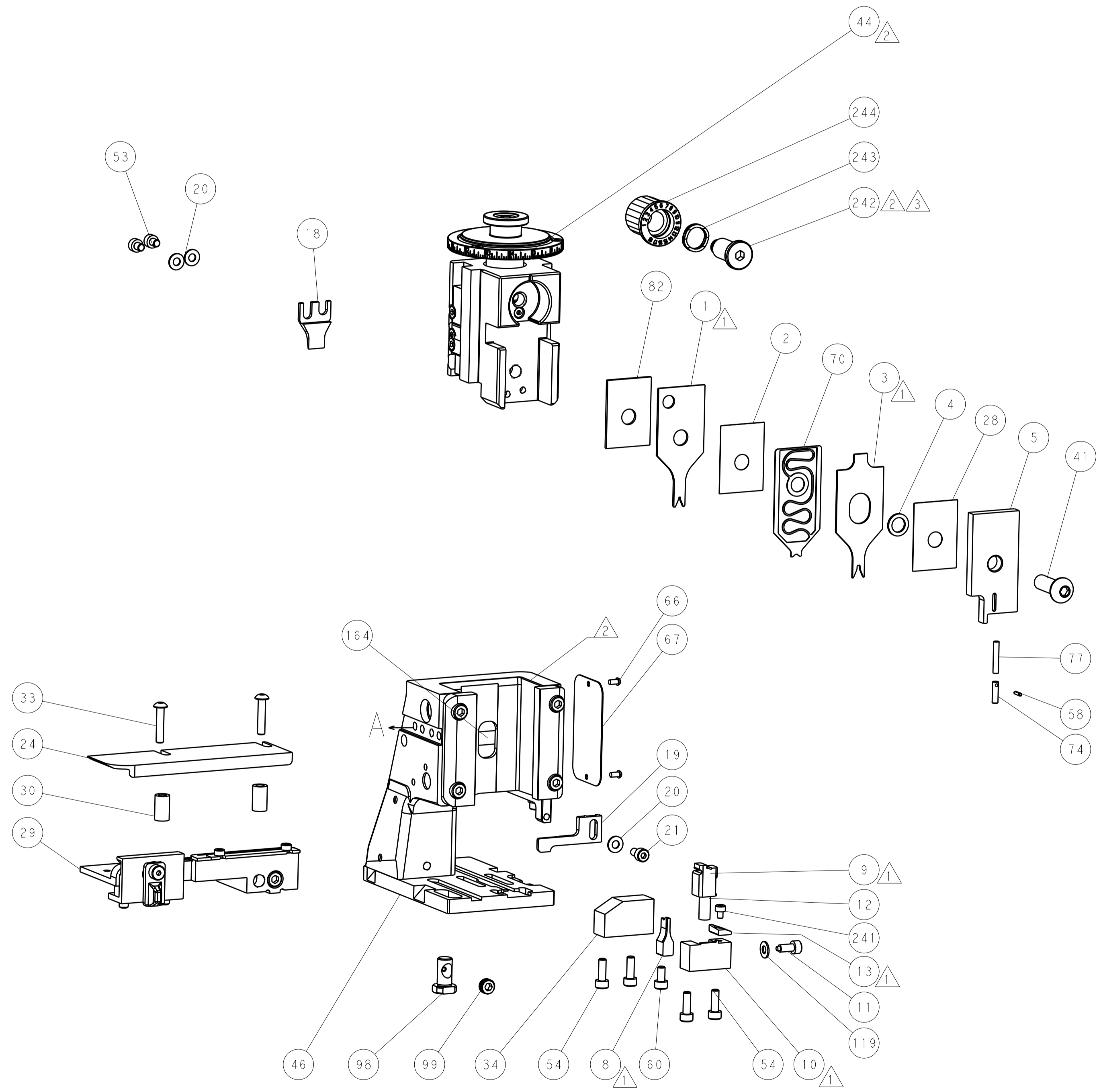
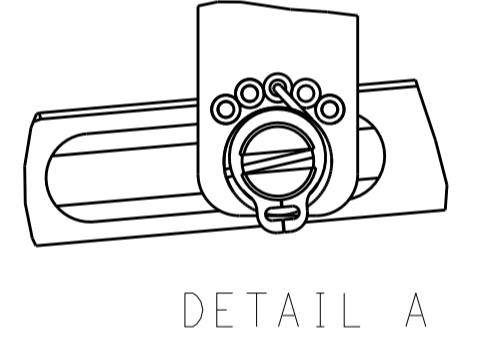
FEED TYPE MECHANICAL



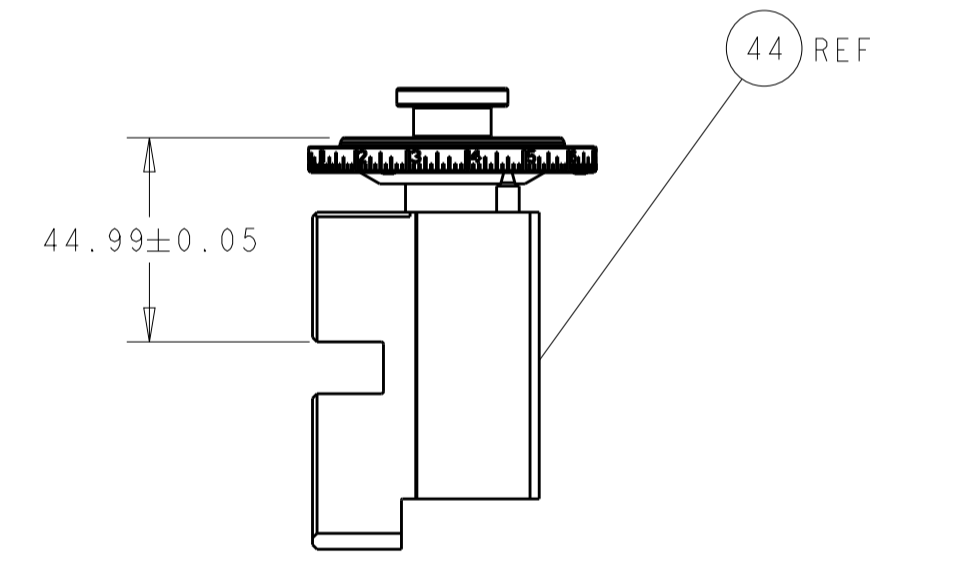
PNEUMATIC



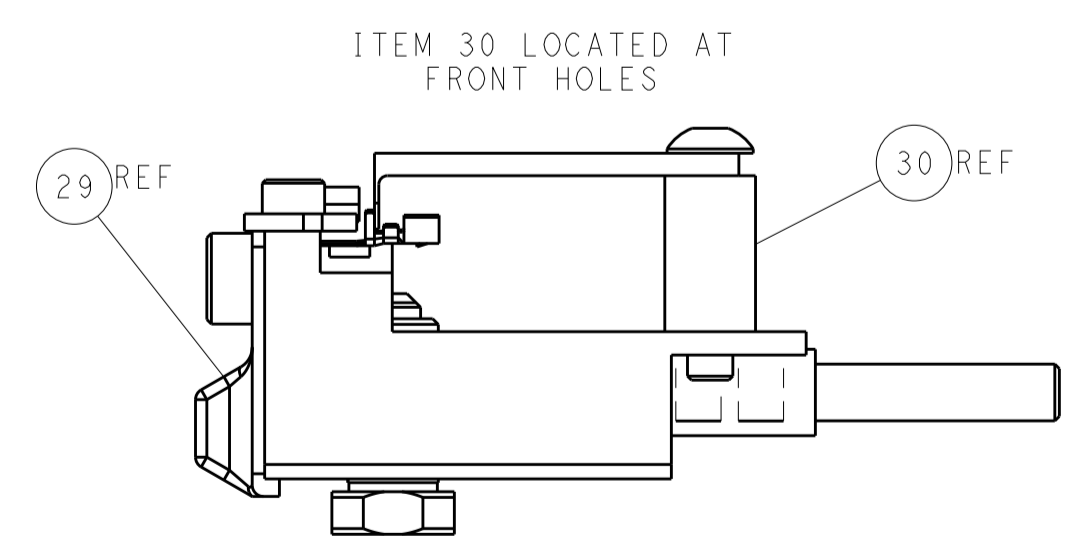
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

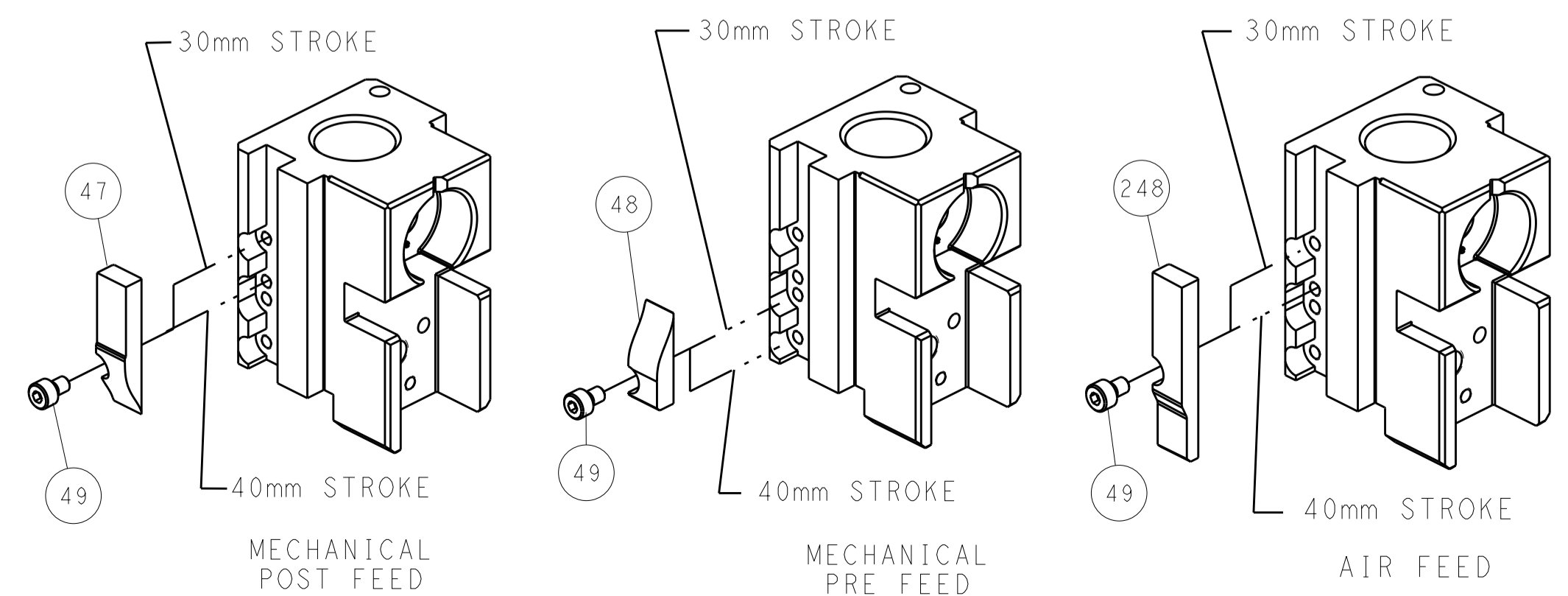


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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: STAKEM 03FEB2014 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | APVD: G. BAILEY 03FEB2014 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME: Ocean Side Feed Applicator | | RESTRICTED TO: | |
| | | | | SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2266215 | | SCALE: 1:2 SHEET 2 OF 4 REV C1 | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266215-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266215-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266215-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.17 mm [.046] | F |
| INSUL | 1.78 mm [.070] | F |

APPLICATOR INSTRUCTIONS
 408-35042

| | | | |
|--|---------------|---|----------------|
| TERMINAL DATA: JST TERMINAL | | JST CRIMP SPECIFICATION | |
| TERMINAL NAME: SOCKET CONTACT | | | |
| WIRE STRIP LENGTH 1.70-1.72 mm [.067-.068 IN] | | INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN] | |
| TERMINAL APPLICATION SPECIFICATION JST HM-0041(CHM-1-089) | | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | JST TERMINAL | TE TERMINAL | JST TERMINAL |
| 1642501-1 | SXA-001T-P0.6 | 2113431-1 | SXAM-001T-P0.6 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 22 AWG | 0.75+/-0.05 [.030+/-0.002] | 9.5 |
| 24 AWG | 0.70+/-0.05 [.028+/-0.002] | 10 |
| 26 AWG | 0.65+/-0.05 [.026+/-0.002] | 10.5 |
| 28 AWG | 0.60+/-0.05 [.024+/-0.002] | 11 |



- 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)

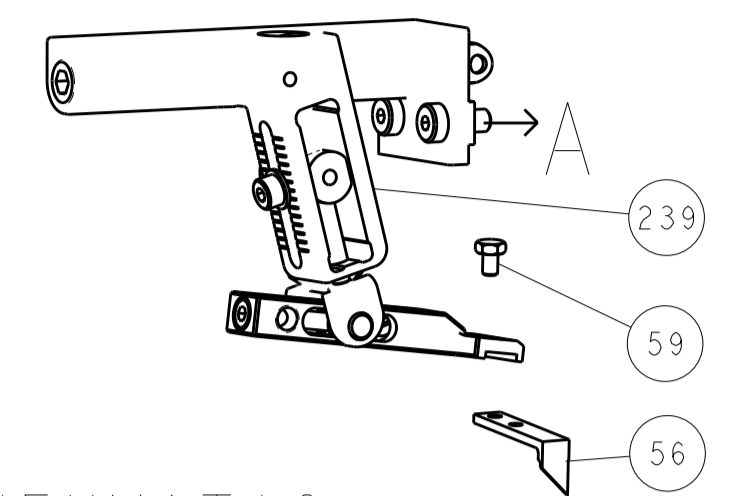
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|-----|------|-----|------|----|------|
| A | 66 | | | | |

| REVISIONS | | | | | |
|-----------|------|-----|-------------|-------------------------------------|---------|
| REV | DATE | BY | DESCRIPTION | DATE | APPV |
| - | - | - | 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 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 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 | 1-455888-2 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1962431-2 | SPRING, COMPRESSION | 77 |
| - | 1 | 1 | 854769-4 | HOLDER, INS | 74 |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| - | 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 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 1-2168083-4 | SCR, SKT HD CAP, RoHS, M4 X 5 | 53 |
| - | 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 | 1752356-3 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 3 | 3 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 2-690518-9 | HOLD DOWN, TERMINAL | 18 |
| - | 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 | 1633861-4 | SHEAR, FLOATING | 9 |
| - | 1 | 1 | 1333228-8 | ANVIL | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119780-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 5-238011-3 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 5-1633962-1 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 3-1633730-7 | CRIMPER, WIRE | 1 |
| -77 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

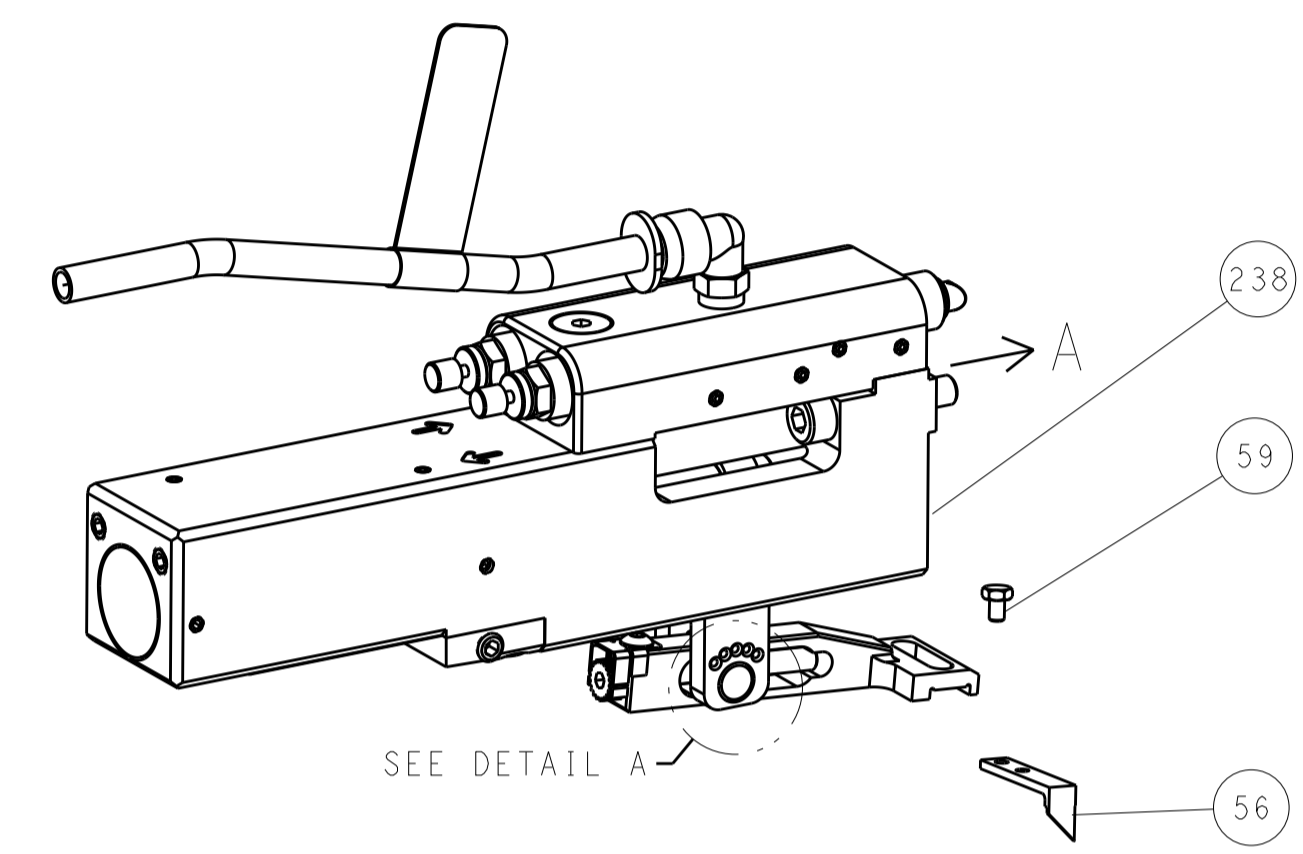
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| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: STAKEM 03FEB2014 | |
| mm | | 0 PLC ± | | CHK: G. BAILEY 03FEB2014 | |
| 1 PLC ± | | 2 PLC ± | | APPV: T. ERLIN 03FEB2014 | |
| 3 PLC ± | | 4 PLC ± | | NAME: Ocean Side Feed Applicator | |
| ANGLES | | FINISH | | SIZE: A1 | |
| MATERIAL | | WEIGHT | | CAGE CODE: 00779 | |
| | | | | DRAWING NO: C=2266215 | |
| | | | | RESTRICTED TO: - | |
| | | | | SCALE: 1:2 | |
| | | | | SHEET: 3 OF 4 | |
| | | | | REV: C1 | |

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

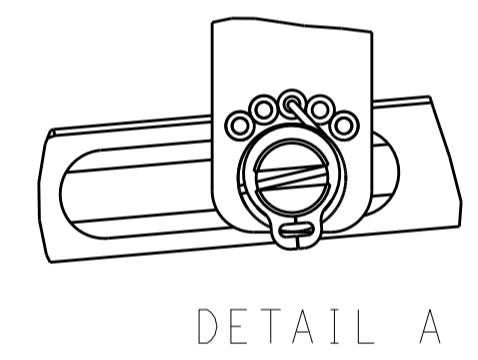
FEED TYPE MECHANICAL



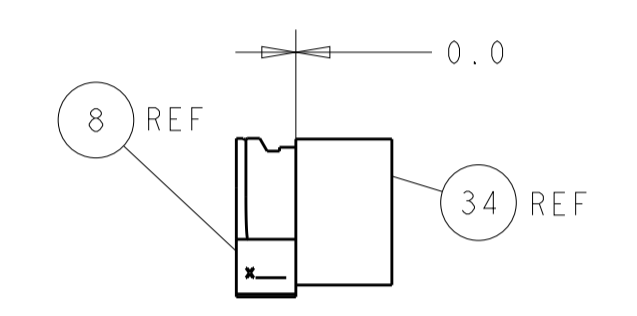
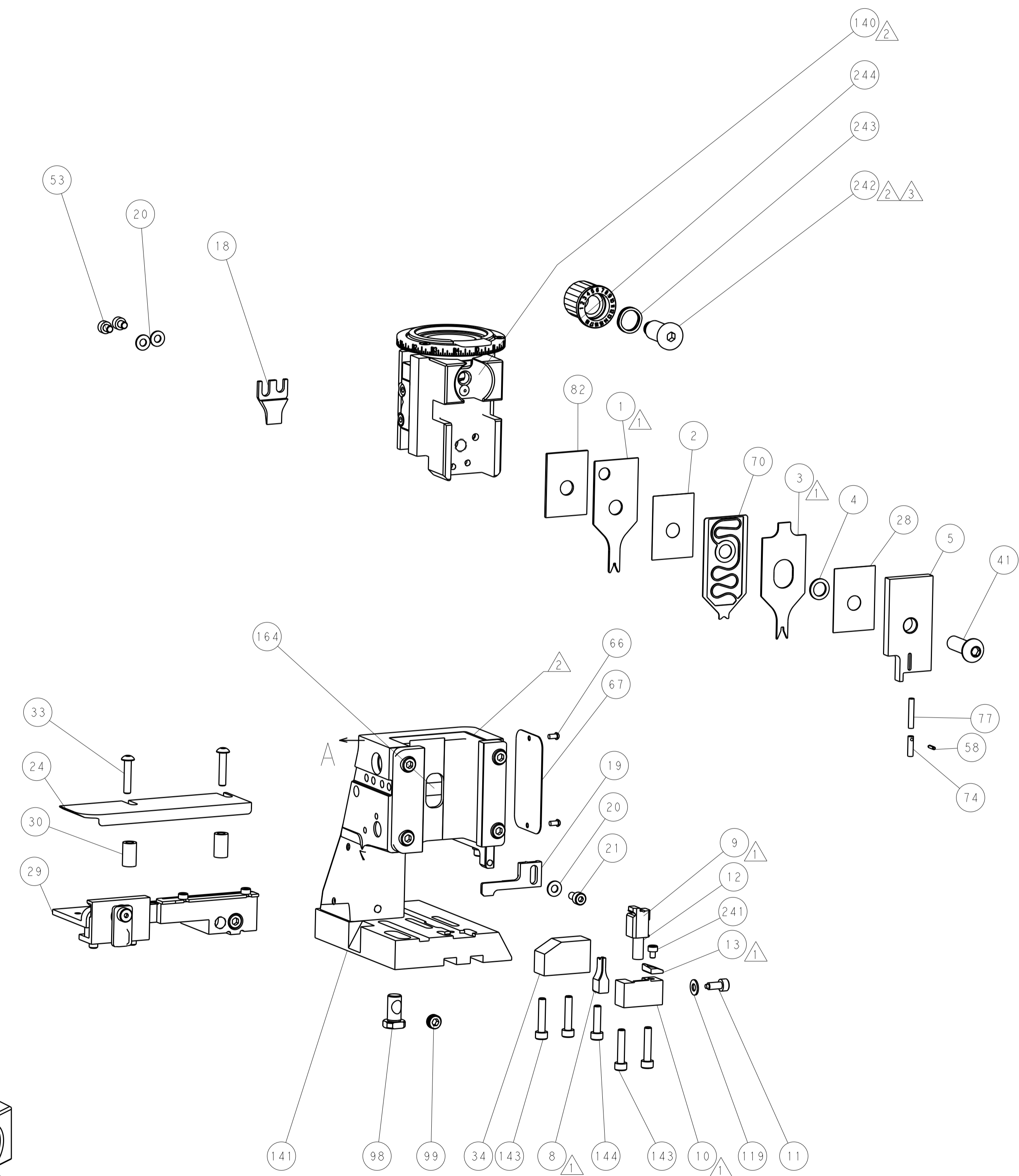
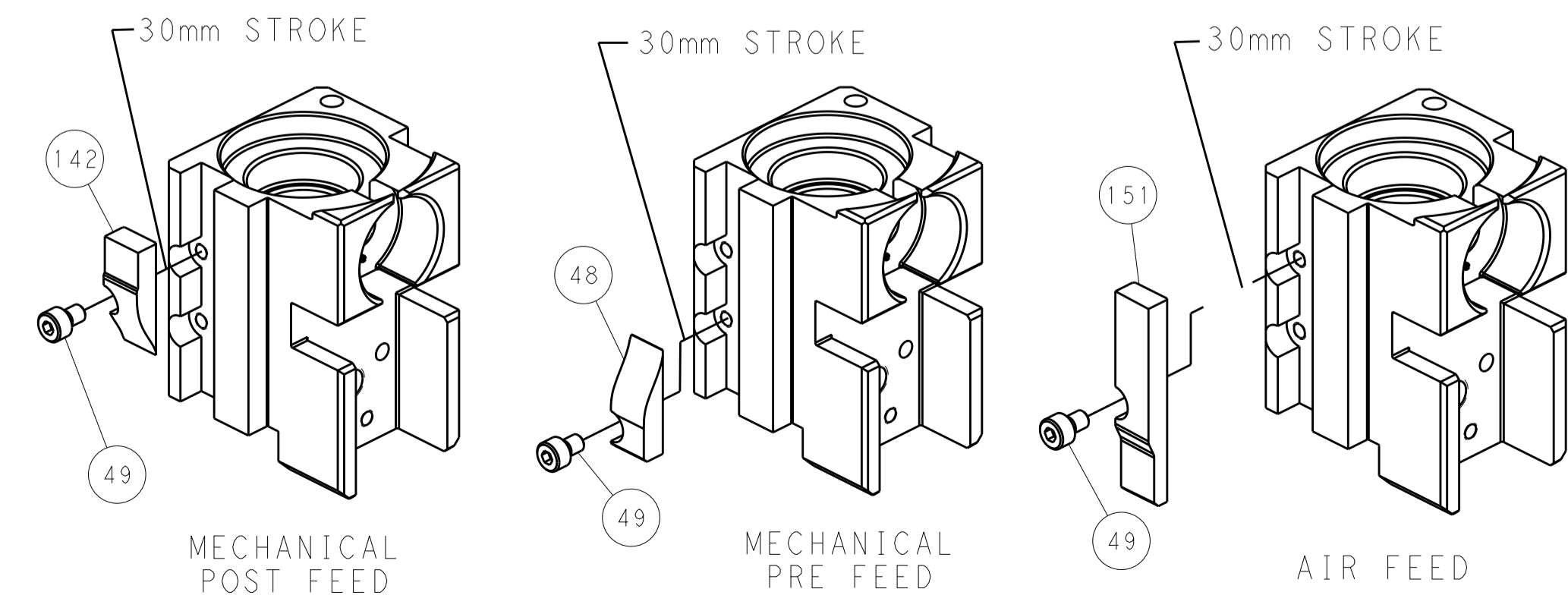
PNEUMATIC



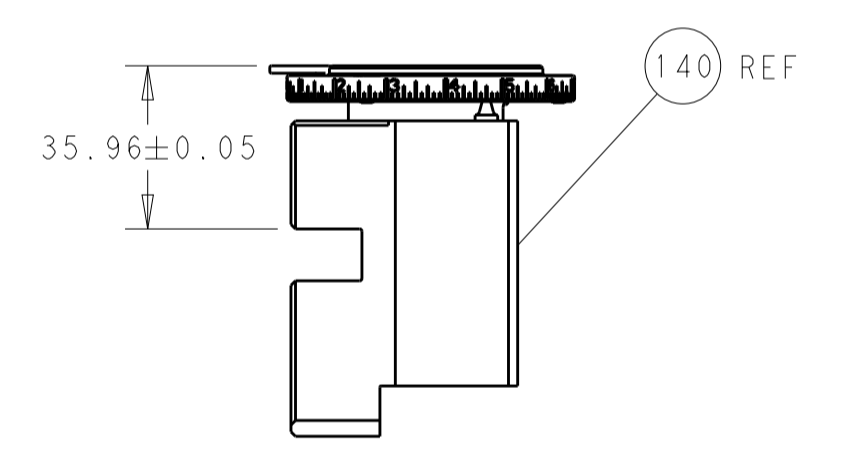
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

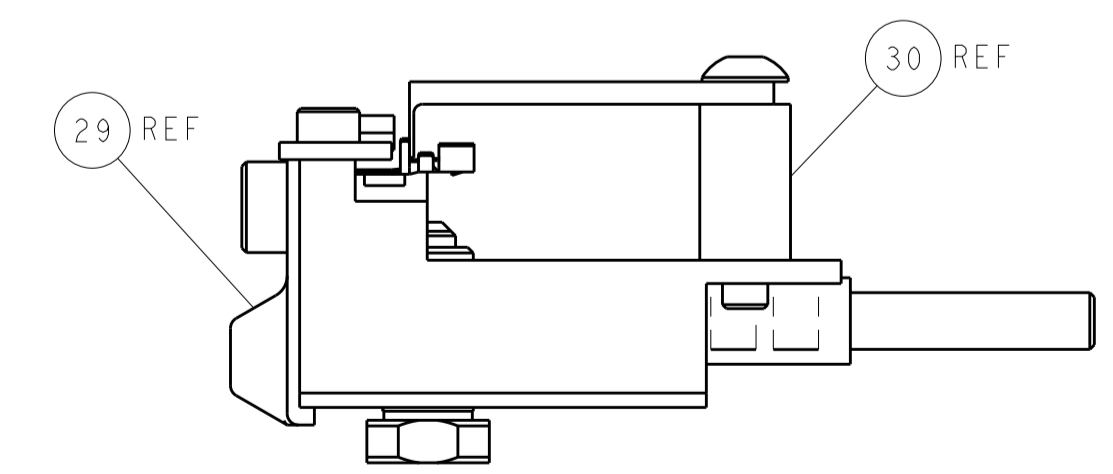


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: R. STAKEM 03FEB2014 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| | ANGLES | FINISH | | CHK: G. BAILEY 03FEB2014 | NAME: T. ELBIN 03FEB2014 | Ocean Side Feed Applicator | |
| MATERIAL: | | | | PRODUCT SPEC: | APPLICATION SPEC: | SIZE: A1 | CAGE CODE: 00779 |
| | | | | WEIGHT: | SCALE: 1:2 | SHEET: 4 | OF 4 |
| Customer Accessible Production Drawing | | | | REV: C1 | | RESTRICTED TO: | |