

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151443-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151443-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151443-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151443-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
	2151443-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151443-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151443-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
2151443-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-		
2151443-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151443-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.85 mm [.033]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25 WIRE TO BOARD CONN, CRIMP RECEPT.			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.40-1.90 mm [.055-.075 IN]	Ø0.51-0.99 mm [.020-.039 IN]		
TERMINAL APPLICATION SPECIFICATION	63900-3700 Rev D		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
993820-1	50079-8000		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
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TERMINAL APPLICATION SPECIFICATION	63900-3700 Rev D		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
993820-2	50058-8000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.12mm2	0.625+/-0.025 [.024+/- .001]	5.8
28 AWG OR 0.08mm2	0.585+/-0.025 [.023+/- .001]	6.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG OR 0.08mm2	0.535+/-0.025 [.021+/- .001]	6.7
30 AWG OR 0.05mm2	0.505+/-0.025 [.020+/- .001]	7.0
32 AWG OR 0.03mm2	0.485+/-0.025 [.019+/- .001]	7.3

- 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: 8-2151443-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151443-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151443-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151443-6
- 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, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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. 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.
- 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. ADJUSTMENTS MAY BE REQUIRED WHEN CHANGING TERMINALS.

***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.

- 2 2 2 2 2	22281-8	SPRING, COMPRESSION	279
- 2 2 2 2 2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	278
- 1 1 1 1 1	1-22281-8	SPRING, COMPRESSION	277
- 1 1 1 1 1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	276
- 1 1 1 1 1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	275
- 1 1 1 1 1	356835-1	LEVER, DRAG RELEASE	274
- 1 1 1 1 1	240792-1	DRAG, TERMINAL	273
- 2 2 2 2 2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	271
- 1 1 1 1 1	1-690438-0	FRONT STRIP GUIDE	270
- - 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
- 1 1 1 1 1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-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)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			A		RELEASED	25FEB2013	LG	TE
			B		ECR-14-004979	04APR2014	KH	UG

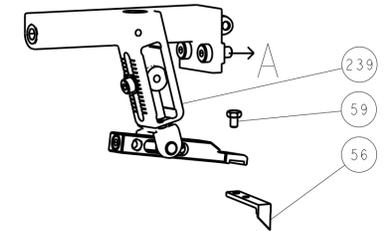
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- 1 1 1 1 1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
- - 2 2 - -	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
- - - - 1 -	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - - 1 -	2063440-1	AIR FEED MODULE	238
- 2 2 2 2 2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	235
- - 1 1 - -	2119740-2	TAG, IDENTIFICATION	213
- - 1 1 - -	1901094-3	SPACER, FEEDER	198
- 1 1 1 1 1	1-1752354-3	STANDOFF, HOLD-DOWN	180
- 1 1 1 1 1	2-1976053-9	LOCATER BLOCK, TERMINAL	179
- 1 1 1 1 1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
- 1 1 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2	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	1-455888-8	SPACER, CRIMPER	82
- 1 1 1 1 1	1962431-2	SPRING, COMPRESSION	77
- 1 1 1 1 1	854769-4	HOLDER, INS	74
- 1 1 1 1 1	2119956-1	DOCUMENTATION PACKAGE	71
- 1 - - 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 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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
- - - - 1 -	1338685-1	PAWL, FEED	56
- 4 4 4 4 4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- 1 1 1 1 1	1901681-4	HOLDDOWN, TERMINAL	51
- - - - 1 2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
- - - - - 1	2119652-1	FEED CAM, PRE FEED	48
- - - - - 1	2119653-1	FEED CAM, POST FEED	47
- 1 1 1 1 1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
- 1 - - 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 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 - - 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 1	2119092-1	BOLT, ADJUSTMENT	35
- 1 1 1 1 1	2-1752356-6	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	1320908-2	SPACER, STRIP GUIDE	30
- 1 1 1 1 1	2-1901086-0	PLATE, STRIP GUIDE	29
- 1 1 1 1 1	455888-4	SPACER, CRIMPER	28
- 1 1 1 1 1	1320928-2	STRIP GUIDE	24
- 1 1 1 1 1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
- 1 1 1 1 1	1-18028-2	WASHER, FLAT, REG M4	20
- 1 1 1 1 1	2119533-3	STRIPPER, SIDE FEED	19
- 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	1633861-1	SHEAR, FLOATING	9
1 1 1 1 1	1-1633621-2	ANVIL, COMBINATION	8
- - - - - -	-	-	7
- - - - - -	-	-	6
- 1 1 1 1 1	2119780-4	DEPRESSOR, SHEAR	5
- 1 1 1 1 1	2-238011-5	BLOCK, CRIMPER SPACER	4
1 1 1 1 1	1-1803017-2	CRIMPER, INSULATION F	3
- 1 1 1 1 1	455888-2	SPACER, CRIMPER	2
1 1 1 1 1	1633713-8	CRIMPER, WIRE PREMIUM	1
-77 -7 -6 -5 -2 -1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.05	1 PLC ±.03	2 PLC ±.02	3 PLC ±.01	4 PLC ±.005
	ANGLES ±.0001				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:2	1 OF 4	B

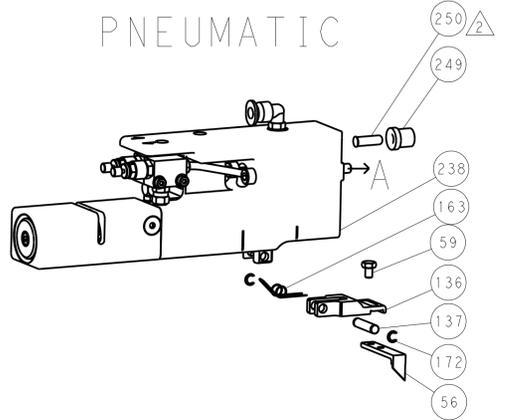
Customer Accessible Production Drawing

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

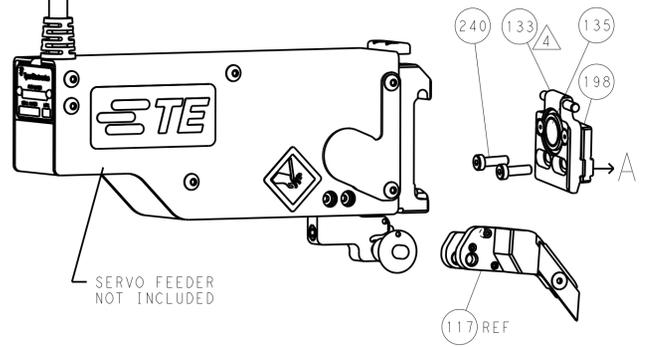
FEED TYPE MECHANICAL



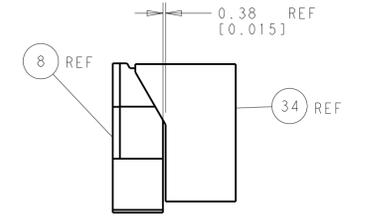
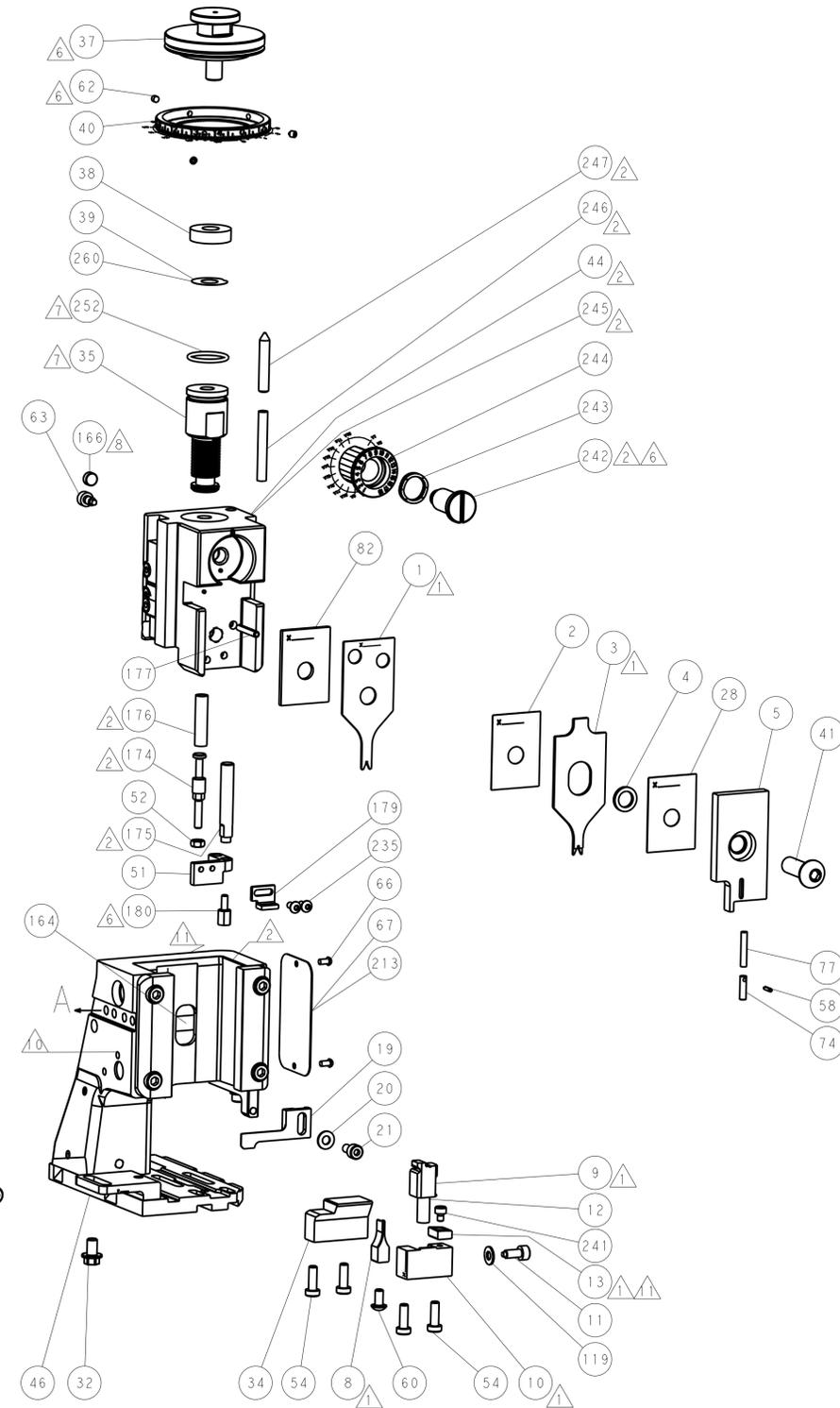
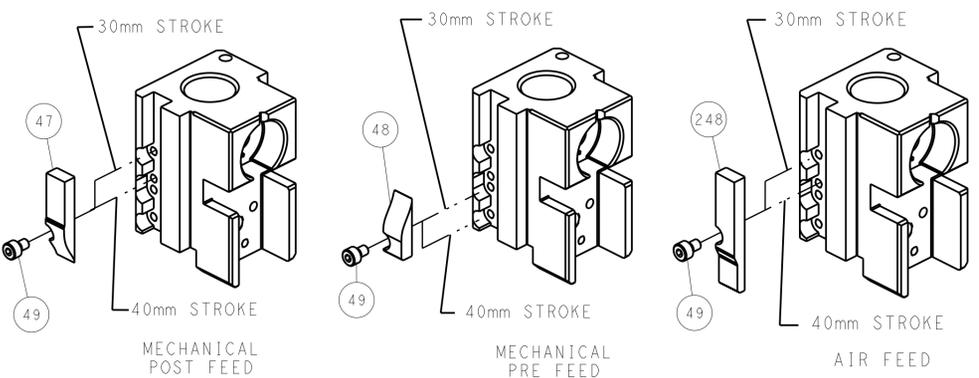
PNEUMATIC



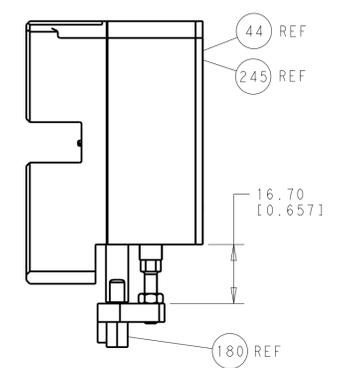
SERVO LATCH PLATE



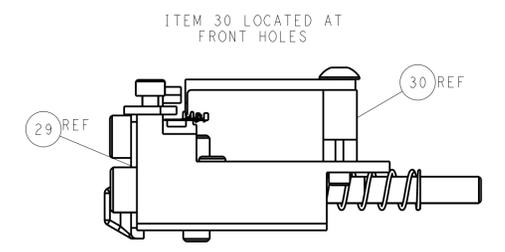
CAM POSITIONS



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 X ZHAO 25MAY2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD S. XI 25MAY2012	NAME	Customer Accessible Production Drawing	RESTRICTED TO
			1:2		Ocean Side Feed Applicator		
					SIZE CAGE CODE DRAWING NO		
					A1 00779 ©=2151443		
					SHEET 2 OF 4		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151443-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151443-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151443-4	-	-	-
	2-2151443-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151443-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151443-4	-	-	-
	2-2151443-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151443-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151443-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.85 mm [.033]	F
APPLICATOR INSTRUCTIONS 408-10389		

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TERMINAL APPLICATION SPECIFICATION	63900-3700 Rev D	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
993820-1	50079-8000		

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TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
993820-2	50058-8000		

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28 AWG OR 0.08mm2	0.535+/-0.025 [.021+/- .001]	6.7
30 AWG OR 0.05mm2	0.505+/-0.025 [.020+/- .001]	7.0
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- 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: 8-2151443-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151443-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151443-5
- 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, 180 & 242.
- 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
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-	2	2	2	2	22281-8	SPRING, COMPRESSION	279
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	278
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	277
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	276
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	275
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	274
-	1	1	1	1	240792-1	DRAG, TERMINAL	273
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	271
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	270
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-1	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
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	-	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
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	235
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1-1752354-3	STANDOFF, HOLD-DOWN	180
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	NAME
mm	0 PLC ±.05	1 PLC ±.05	2 PLC ±.05	3 PLC ±.05	4 PLC ±.05	ANGLES ±.0001	FINISH
MATERIAL		FINISH		WTG	SCALE	SHEET	REV
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