

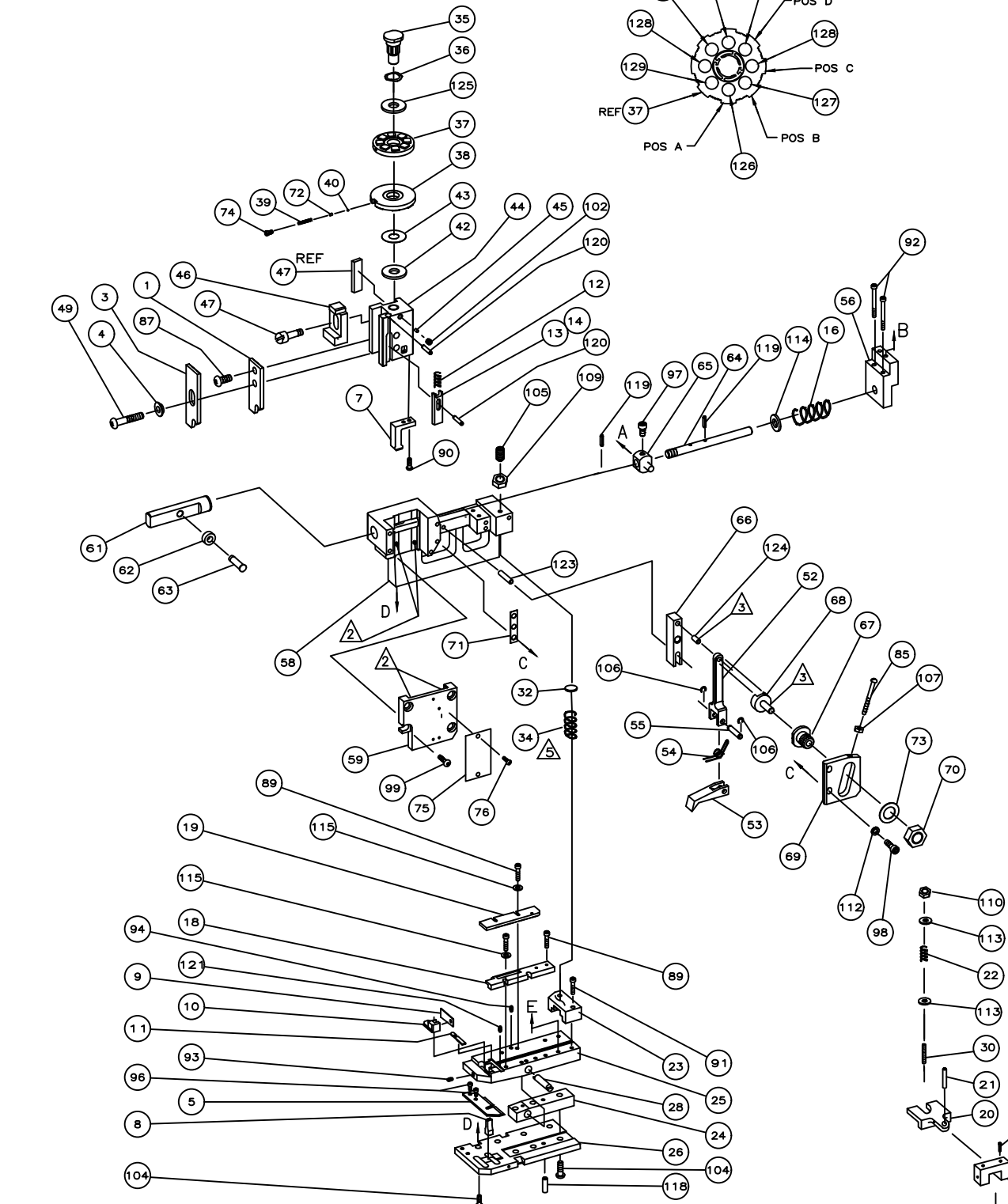
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PART NUMBER	REV	FIRST USED
687391-1	AA	354500-1

TERMINAL NAME: .205 FLAG FASTON™ TERMINAL			
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
42234			
42459			
60195			
60643	A	.065 ±.002 [1.65 ±0.05mm]	14
62354	B	.061 ±.002 [1.55 ±0.05mm]	16
63635	C	.058 ±.002 [1.47 ±0.05mm]	18
1742595-1	D	.056 ±.002 [1.42 ±0.05mm]	20
CRIMP	SIZE	TYPE	RANGE
WIRE	.140 [3.56mm]	TAB LOC	20-14
INSUL	.140 [3.56mm]	0	.110-.170
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.205-.235	114-2078	.650	408-8031
SET UP GAGE	LAYOUT		

REVISIONS			
REV	DATE	BY	APPD
AA	11-2017	RS	LZ

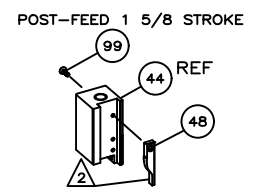
1 LEADMAKER MECH POST FEED



QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
2	3-354779-8	PIN, WIRE DISC (.3180)D	129
2	3-354779-7	PIN, WIRE DISC (.3175)C	128
2	3-354779-2	PIN, WIRE DISC (.3150)B	127
2	2-354779-9	PIN, WIRE DISC (.3135)A	126
1	986950-1	WASHER, FLAT PRECISION	125
1	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
3	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
			122
2	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
2	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
1	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)	118
			117
			116
4	21024-4	WASHER, LOCK (#8)	115
			114
2	21899-2	WASHER, FLAT (#10)	113
2	21024-5	WASHER, LOCK (#10)	112
2	994991-5	SCR, OVAL HD(M4X12)COUNTER	111
1	21022-3	NUT, HEX (10-32)	110
1	1-22202-7	NUT, HEX (5/16-24)	109
			108
1	21018-5	NUT, HEX (6-32)	107
2	21045-3	RING, RET "C" (Ø.187)FD PIN	106
1	8-21007-5	SCREW, SKT SET(5/16-24x.75)	105
7	2-22733-8	SCREW, BHC (1/4-20X.63)	104
			103
1	21009-2	SCREW, SKT SET(1/4-20x.25)	102
			101
			100
5	3-21000-8	SCREW, SHC (10-32X.88)	99
2	3-21000-6	SCREW, SHC (10-32X.62)	98
1	3-21000-4	SCREW, SHC (10-32X.38)	97
2	7-21000-6	SCREW, SHC (10-32X.38)	96
			95
2	4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	21061-9	SCREW, SKT SET (8-32X.25)	93
2	3-21000-0	SCREW, SHC (8-32X.88)	92
2	2-21000-9	SCREW, SHC (8-32X.75)	91
2	1-23030-1	SCREW, MACH (NYLOK)(8-32X.62)	90
4	2-22603-3	SCREW, SHC (8-32X.62)	89
2	2-21000-8	SCREW, SHC (8-32X.62)	88
1	2-21002-1	SCREW, SBHC (8-32X.38)	87
			86
1	6-23715-5	SCR, PAN HD(6-32x1.50)FEED ADJ	85
			84
			83
			82
			81
			80
			79
			78
			77
2	21017-2	SCR, DRIVE(#2X.19)ID	76
1	461264-1	PLATE, IDENTIFICATION	75
1	23030-1	SCR, SHC(NYLOK)(6-32X.25)	74
1	458109-1	WASHER, SPECIAL	73
1	690603-1	SPRING, ASSIST	72
1	690517-1	SPACER	71
-1	U/M	PART NO	DESCRIPTION
			ITEM NO

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
1	22594-8	NUT, HEX	70
1	240628-1	PLATE, ADJ	69
1	240626-1	SHAFT, PIVOT	68
1	240633-1	BUSHING	67
1	240630-1	LEVER, INTERMEDIATE	66
1	1804317-1	BLOCK, PIVOT	65
1	1633286-1	SCR, ADJ	64
1	240659-3	PIN, CAM ROLLER	63
1	240658-1	ROLER, CAM	62
1	240631-1	ROD, FEED	61
			60
1	2217626-1	CAP ASSEMBLY	59
1	2217625-1	HOUSING	58
			57
1	458361-1	GUIDE, FEED ROD	56
1	240624-1	PIN, FEED FINGER	55
1	691499-1	SPRING, FEED FINGER	54
1	454568-2	FINGER, FEED	53
1	240634-1	LEVER, TERMINAL	52
			51
			50
1	3-21002-5	BOLT, CRIMPER	49
1	238015-1	CAM, POST FEED 1 5/8 ST	48
1	2256119-1	SCREW, SHOULDER	47
1	690578-3	BLOCK, INSUL ADJUSTMENT	46
1	690191-1	PLUG, NYLON	45
1	2217624-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-4	WASHER, RAM	42
			41
1	23241-6	BALL, STEEL	40
1	690170-1	SPRING, COMPRESSION	39
1	690142-1	DISC, INSULATION	38
1	354777-1	WIRE DISC, PLASTIC	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
1	3-23846-5	SPRING, HINGE BAR	34
			33
1	690573-1	SPACER, SPRING	32
1	454569-1	MOUNT, DRAG	31
1	1-22354-8	STUD, DRAG	30
1	21030-2	MOUNT, SPRING DRAG	29
1	690582-1	PIN, HINGE	28
			27
1	684905-1	PLATE, BASE	26
1	454579-2	HINGE BAR	25
1	690571-1	BLOCK, STABILIZER	24
1	690585-1	BLOCK, PRESSURE	23
1	8-22282-6	SPRING, DRAG	22
1	21030-6	LEVER, DRAG	21
1	454570-1	DRAG, STOCK	20
1	454573-1	GUIDE, STRIP (REAR)	19
1	454571-2	GUIDE, STRIP (FRONT)	18
			17
1	4-22284-9	SPRING, FEED RETURN	16
			15
1	692134-7	POSITIONER, TERMINAL	14
1	692134-2	POSITIONER, TERMINAL	13
1	5-22280-5	SPRING, TERM. POSITIONER	12
1	454712-4	PLATE, REAR SHEAR	11
1	454578-1	ANVIL INSERT	10
1	690569-3	PLATE, FRONT SHEAR	9
1	690718-1	ANVIL	8
1	454575-3	BLADE, SLUG	7
			6
1	684906-1	PLATE, ANVIL RETAINING	5
1	690574-1	SPACER, TUBULAR, INSUL CRIMPER	4
1	690588-1	CRIMPER, INSULATION	3
			2
1	690716-3	CRIMPER, WIRE	1
-1	U/M	PART NO	DESCRIPTION
			ITEM NO

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- 5 AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.
- 6 SELECT TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL. FASTEN EXTRA TERMINAL POSITIONER TO APPLICATOR. (REFER TO AMP FORM 6140-4)
- 7 APPLY LOCKTITE TO SET SCREWS AT ASSY.



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END FEED HINGE BAR APPLICATOR

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687391-1

SCALE - SHEET 1 OF 1