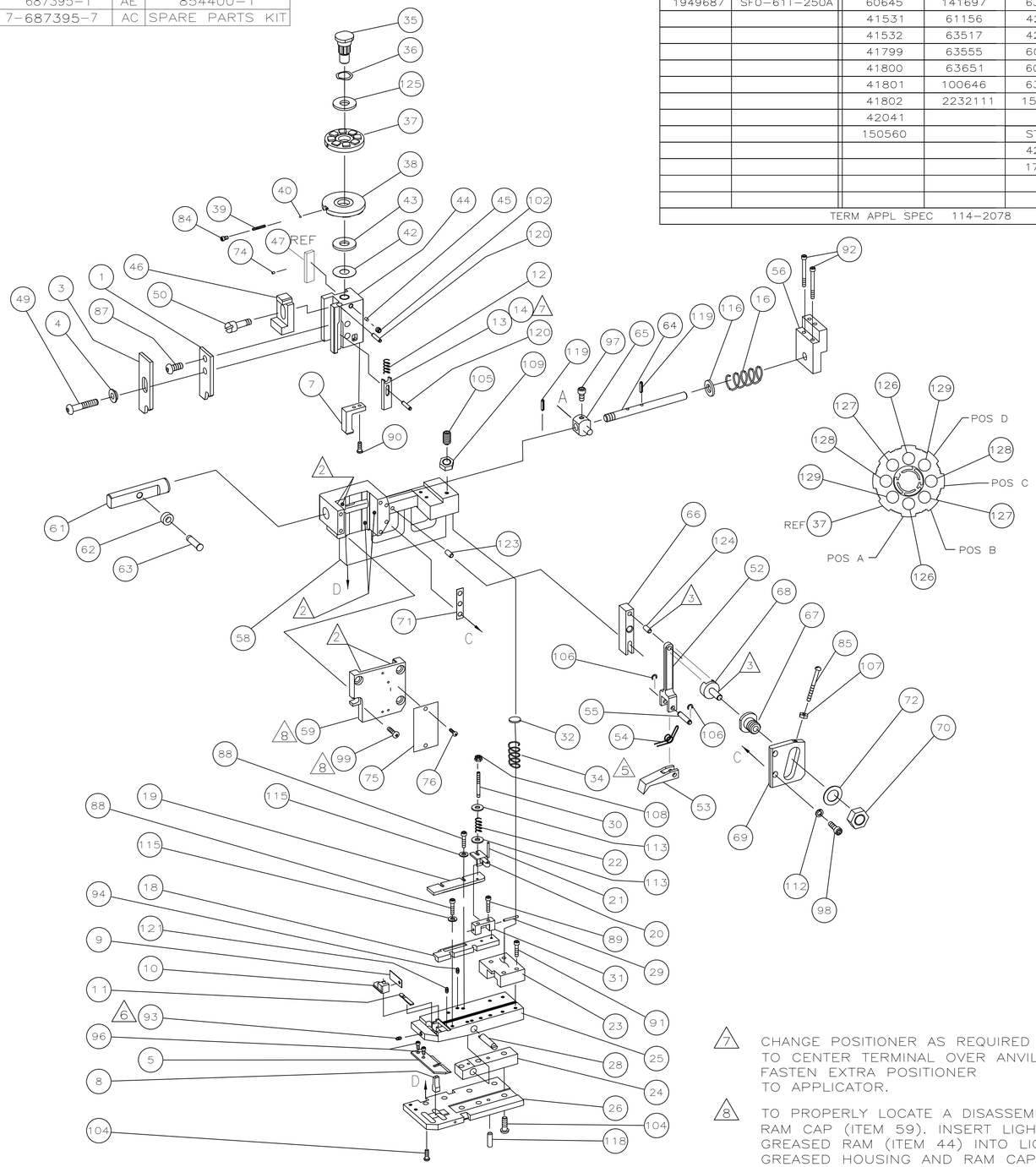
PART NUMBER	REV	FIRST USED
687395-1	AE	854400-1
7-687395-7	AC	SPARE PARTS KIT

TERMINAL NAME:		.250 FLAG FASTON™		
TE P/N	MFG P/N	.018 THK	.018 THK	.016 THK
1949687	SF0-61T-250A	60645	141697	63604
		41531	61156	42511
		41532	63517	42742
		41799	63555	60641
		41800	63651	60712
		41801	100646	63445
		41802	2232111	150561
		42041		
		150560		STEEL
				42404
				1742460
TERM APPL SPEC 114-2078				

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT		WIRE SIZE
A	.070 ±.002 [1.78mm±0.05mm]		12
B	.060 ±.002 [1.52mm±0.05mm]		14
C	.052 ±.002 [1.32mm±0.05mm]		16
D	.048 ±.002 [1.22mm±0.05mm]		18
CRIMP	SIZE	TYPE	RANGE
WIRE	.160 [4.06mm]	TAB LOCK	18-12
INSUL	.180 [4.57mm]	0	.110-.210
FEED .767	APPL INST △18031	SET UP GAGE –	LAYOUT –
WIRE STRIP LENGTH .205-.235			

USED ON –

-1	LEADMAKER G	MECH POST FEED
-77	–	SPARE PARTS KIT



△7 CHANGE POSITIONER AS REQUIRED TO CENTER TERMINAL OVER ANVIL. FASTEN EXTRA POSITIONER TO APPLICATOR.

△8 TO PROPERLY LOCATE A DISASSEMBLED RAM CAP (ITEM 59). INSERT LIGHTLY GREASED RAM (ITEM 44) INTO LIGHTLY GREASED HOUSING AND RAM CAP UNTIL TOOLING RESTS AGAINST HINGE BAR (ITEM 25). TIGHTEN SCREWS (ITEM 99).

△1 RECOMMENDED SPARE PARTS.

△2 LIGHTLY GREASE INDICATED CONTACT SURFACES WITH 984999-1 (CHEVRON ULTRA-DUTY EP NGLI 2).

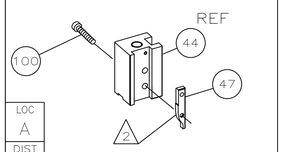
△3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.

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 ADITIONAL 5 1/2 – 6 REVOLUTIONS.

△6 APPLY LOCTITE TO ITEM 93.

POST-FEED 1 5/8 STROKE



LOC A
DIST 66

-77	-1	U/M	PART NO	DESCRIPTION	ITEM NO
–	2	–	5-354779-3	PIN, WIRE DISC (.3255)D	129
–	2	–	4-354779-7	PIN, WIRE DISC (.3225)C	128
–	2	–	3-354779-0	PIN, WIRE DISC (.3140)B	127
–	2	–	1-354779-3	PIN, WIRE DISC (.3055)A	126
–	1	–	986950-1	WASHER, FLAT PRECISION	125
–	1	–	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
–	1	–	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
					122
–	1	–	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
–	1	–	21899-4	WASHER, FLAT (5/16)	116
–	4	–	21024-4	WASHER, LOCK (#8)	115
					114
–	2	–	21899-2	WASHER, FLAT (#10)	113
–	2	–	21024-5	WASHER, LOCK (#10)	112
					111
					110
–	1	–	1-22202-7	NUT, HEX (5/16-24)	109
–	1	–	21022-3	NUT,HEX (LOCKING)(10-32)	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
–	1	–	3-21000-9	SCREW, SHC (10-32X1.00)	100
–	4	–	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
–	1	–	4-21006-5	SCREW, SKT SET (8-32X.62)	94
△6 –	1	–	21061-9	SCREW, SKT SET (8-32X.25)	93
–	2	–	9-21000-3	SCREW, SHC (8-32X2.00)	92
–	4	–	2-21000-9	SCREW, SHC (8-32X.75)	91
–	2	–	1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)	90
–	2	–	2-21000-8	SCREW, SHC (8-32X.62)	89
–	4	–	2-22603-3	SCREW, HEX (8-32X.62)	88
–	1	–	2-21002-1	SCREW, BHC (8-32X.38)	87
					86
–	1	–	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	85
–	1	–	23030-1	SCREW, SHC(NYLOK)(6-32X.38)	84
					83
					82
					81
					80
					79
					78
					77
–	2	–	21017-2	SCR,DRIVE(#2X.19)ID	76
–	1	–	461264-1	PLATE, IDENTIFICATION	75
–	1	–	690603-1	SPRING, ASSIST	74
					73
–	1	–	458109-1	WASHER, SPECIAL	72
–	1	–	690517-1	SPACER	71

QTY — PARTS LIST

-77	-1	U/M	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	ROLLER, CAM	62
–	1	–	240631-1	ROD, FEED	61
					60
–	1	–	2217626-1	END CAP	59
–	1	–	2217625-1	HOUSING	58
					57
–	1	–	1804319-1	GUIDE,FEED ROD	56
–	1	–	240624-1	PIN, FEED FINGER	55
–	1	–	691499-1	SPRING, FEED FINGER	54
–	1	–	454568-1	FINGER, FEED	53
–	1	–	240634-1	LEVER, TERMINAL	52
					51
–	1	–	2256119-1	SCREW, SHOULDER	50
–	1	–	3-21002-5	BOLT, CRIMPER	49
					48
–	1	–	238015-1	CAM, POST-FEED 1 5/8 ST	47
–	1	–	690578-3	BLOCK, INSULATION ADJUST	46
–	1	–	690191-1	PLUG, NYLON	45
–	1	–	2217624-1	RAM, LONG	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	PIN, MOUNT, DRAG	29
–	1	–	1633530-1	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	–	22282-5	SPRING, DRAG	22
–	1	–	21030-6	LEVER, DRAG	21
–	1	–	454570-1	DRAG, STOCK	20
–	1	–	454573-1	GUIDE, STRIP (REAR)	19
–	1	–	454571-1	GUIDE, STRIP (FRONT)	18
					17
–	1	–	4-22284-9	SPRING, FEED RETURN	16
					15
△7 △1 –	1	–	1-692134-3	POSITIONER,TERMINAL	14
–	1	–	692134-1	POSITIONER,TERMINAL	13
–	1	–	5-22280-5	SPRING,TERM. POSITIONER	12
–	1	–	454711-1	PLATE, REAR SHEAR	11
–	1	–	454709-1	ANVIL INSERT	10
△1 –	1	–	690569-1	PLATE, FRONT SHEAR	9
1	1	–	690575-1	ANVIL	8
–	1	–	454575-4	BLADE, SLUG	7
–	–	–	–	–	6
–	1	–	684906-1	PLATE,ANVIL RETAINING	5
–	1	–	690574-1	SPACER,TUBULAR INSUL CRIMPER	4
△1 1	1	–	690588-2	CRIMPER, INSULATION	3
–	–	–	–	–	2
△1 1	1	–	690587-1	CRIMPER, WIRE	1

QTY — PARTS LIST

P	LTR	REVISION RECORD	DATE	DWN	APVD
	AE	ECR-13-018324	11-2013	XZ	GB

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± –
1 PLC ± –
2 PLC ± –
3 PLC ± –
4 PLC ± –
ANGLES ± –
SURFACE TEXTURE –

DWN B.HIGMAN	09-14-99	MATERIAL – –	HEAT TREAT – –
CHK C.ERISMAN	09-14-99	TE Connectivity	
APVD T.ELBIN	09-14-99		
NAME END FEED HINGE BAR APPLICATOR			
SCALE NTS	SIZE A1	DRAWING NO 687395-1	SHEET 1 OF 1 REV AE

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS)
THIS DRAWING IS A CONTROLLED DOCUMENT.
DWG NO 687395-1

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3308-8 (3/11)