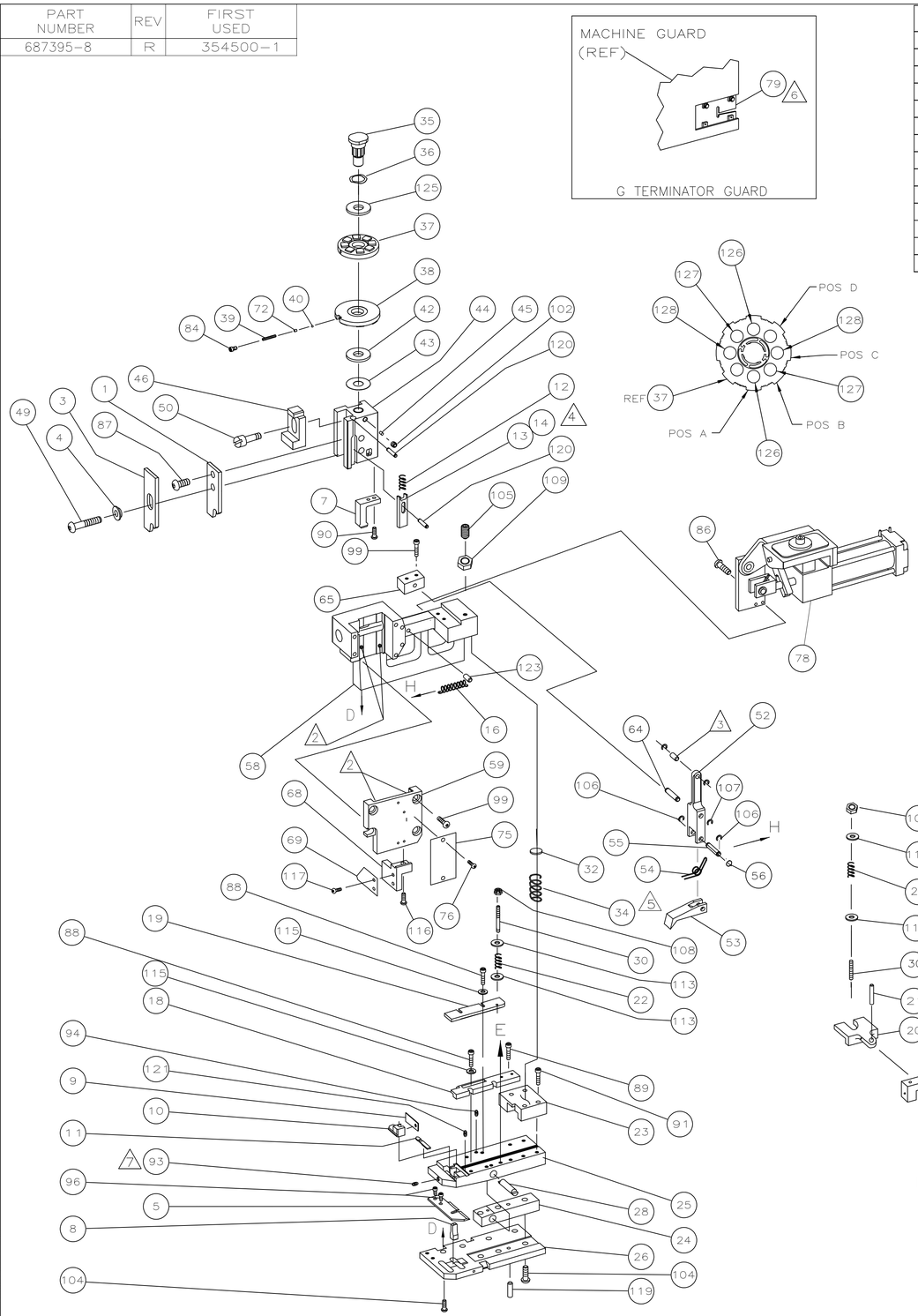
PART NUMBER	REV	FIRST USED
687395-8	R	354500-1



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

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT		WIRE SIZE
A	.070 ±.002		12
B	.060 ±.002		14
C	.052 ±.002		16
D	.048 ±.002		18
CRIMP	SIZE	TYPE	RANGE
WIRE	.160	TAB LOCK	18-12
INSUL	.180	0	.110-.210
FEED	APPL INST	SET UP GAGE	LAYOUT
.767	AI - 8037	-	-
WIRE STRIP LENGTH		.205-.235	

USED ON —

-8	BENCH MODEL G	AIR FEED

	-8	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
					124
	1	-	3-22183-9	PIN, GROOVED (Ø.187X.62)	123
					122
	1	-	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
	2	-	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
	1	-	21029-5	PIN,SLOTTED SPRING (Ø.188X.75)	119
					118
	2	-	1-21002-6	SCREW, SBHC (6-32 x .25) STOP	117
	1	-	2-22603-1	SCR,HEX HD(8-32X.38)MTG	116
	4	-	21024-4	WASHER, LOCK (#8)	115
					114
	2	-	21899-2	WASHER,FLAT (#10)	113
					112
					111
					110
	1	-	1-22202-7	NUT, HEX (5/16-24)	109
	1	-	21022-3	NUT,HEX (LOCKING) (10-32)	108
	1	-	1-21986-2	RING,RET "E" Ø3/16	107
	2	-	21045-3	RING,RET "C" Ø3/16	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
	6	-	3-21000-8	SCREW, SHC (10-32X.88)	99
					98
					97
	2	-	7-21000-6	SCREW, SHC (10-32X.38)	96
					95
7	1	-	4-21006-5	SCREW, SKT SET (8-32X.62)	94
7	1	-	21061-9	SCREW, SKT SET (8-32X.25)	93
					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.50)	88
	1	-	2-21002-1	SCREW, BHC (8-32X.38)	87
	2	-	21001-3	SCREW,SHC (1/4-20X.62)	86
					85
	1	-	23030-1	SCREW, SHC(NYLOK)(6-32X.25)	84
					83
					82
					81
					80
6	REF	-	679532-1	INSERT, GUARD	79
	1	-	462622-2	AIR FEED ASSEMBLY	78
					77
	2	-	21017-2	SCR,DRIVE(#2X.19)ID	76
	1	-	461264-1	PLATE, IDENTIFICATION	75
					74
					73
	1	-	690603-1	SPRING, ASSIST	72
					71

PARTS LIST — QTY

	-8	U/M	PART NO	DESCRIPTION	ITEM NO
					70
	1	-	318530-3	STOP, WIRE	69
	1	-	318529-1	BLOCK, MOUNTING	68
					67
					66
	1	-	456987-1	BLOCK, PIVOT	65
	1	-	457058-1	PIN, PIVOT	64
					63
					62
					61
					60
	1	-	318528-1	END CAP	59
	1	-	457079-1	HOUSING	58
					57
	1	-	25745-1	RING, SPLIT	56
	1	-	240624-1	PIN, FEED FINGER	55
	1	-	691499-1	SPRING, FEED FINGER	54
	1	-	454568-1	FINGER, FEED	53
	1	-	457057-1	ARM, PIVOT	52
					51
	1	-	22353-8	SCREW, SHOULDER	50
	1	-	3-21002-5	BOLT, CRIMPER	49
					48
					47
	1	-	690578-1	BLOCK, INSULATION ADJUST	46
	1	-	690191-1	PLUG, NYLON	45
	1	-	454574-1	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	-	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	-	318739-6	GUIDE, STRIP (FRONT)	18
					17
	1	-	2-22287-6	SPRING, FEED RETURN	16
					15
4 1	1	-	1-692134-3	POSITIONER,TERMINAL	14
4 1	1	-	692134-1	POSITIONER,TERMINAL	13
	1	-	5-22280-5	SPRING,TERM. POSITIONER	12
	1	-	454711-1	PLATE, REAR SHEAR	11
1	1	-	454709-1	ANVIL INSERT	10
	1	-	690569-1	PLATE, FRONT SHEAR	9
8 1	1	-	690575-1	ANVIL	8
1	1	-	454575-4	BLADE, SLUG	7
	-	-	-	-	6
	1	-	684906-1	PLATE,ANVIL RETAINING	5
	1	-	690574-1	SPACER,TUBULAR INSUL CRIMPER	4
8 1	1	-	690588-2	CRIMPER, INSULATION	3
	-	-	-	-	2
8 1	1	-	690587-1	CRIMPER, WIRE	1

PARTS LIST — QTY

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
4. CHANGE TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL.FASTEN EXTRA TERMINAL POSITIONER TO 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. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
7. APPLY LOCTITE TO ITEM 93 & 94 AT ASSEMBLY.
8. SPARE TOOLING KIT 7-687395-7.

P	LTR	REVISION RECORD	DATE	DWN	APVD
R		ECR-14-004490	3-2014	JH	UG
P		ECR-14-002720	2-2014	JH	UG
N		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 P.MATHIAS	1-4-95	MATERIAL — —
CHK C.ERISMAN	1-6-95	HEAT TREAT — —
APVD T.BEDDICK	1-6-95	TE Connectivity Harrisburg, PA 17105-3608

NAME: END FEED HINGE BAR APPLICATOR

SCALE	SIZE	DRAWING NO	SHEET	REV
NTS	A1	687395-8	1 OF 1	R

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

LOC A
DIST 66

3308-8 (1/08)

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