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PART NUMBER	REV	FIRST USED
1385580-1	C	854400-1

TERMINAL NAME: .187 FLAG FASTON™		
	TERMINAL	1217876
TERM APPL SPEC 114-2078		

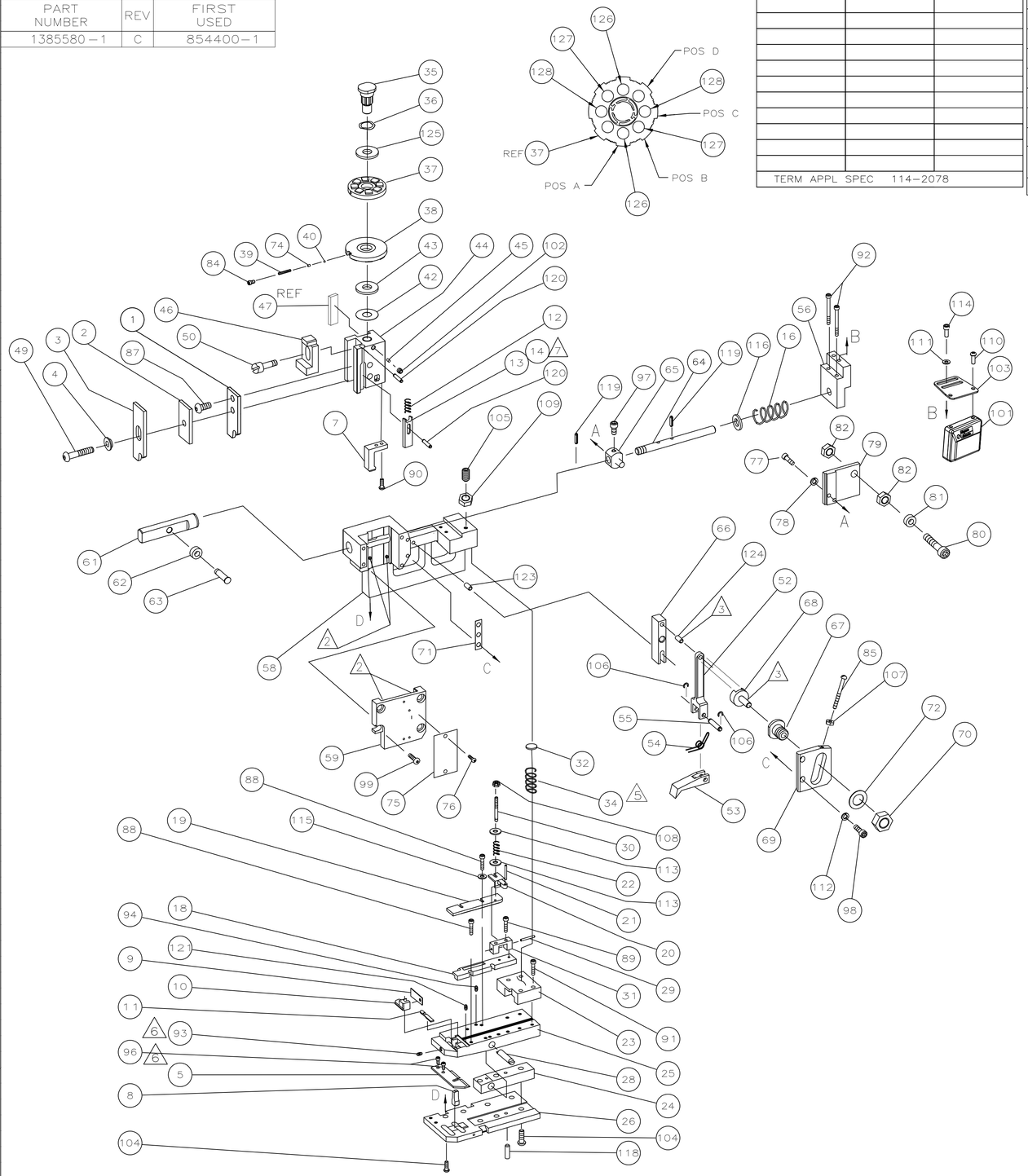
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT		WIRE SIZE
A	.079 ±.002 [2.0mm±0.05mm]		(2)14
B	NOT		USED
C	NOT		USED
D	NOT		USED
CRIMP	SIZE	TYPE	RANGE
WIRE	.200 [5.08mm]	TAB LOCK	(2)14
INSUL	.210 [5.33mm]	0	.110-200
FEED .770	APPL INST △18031	SET UP GAGE –	LAYOUT –
WIRE STRIP LENGTH .250-.280			

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	C	ECR-08-011943	5-2008	MY	GB

-1	LEADMAKER G	MECH POST FEED

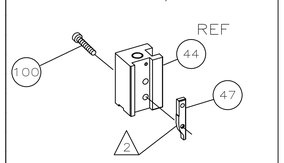


				129
				128
				127
2	–	9-354778-9	PIN, WIRE DISC (.2990)A	126
1	–	986950-1	WASHER, FLAT PRECISION	125
1	–	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
1	–	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
				122
1	–	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
2	–	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	–	5-21028-1	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
2	–	2-21000-6	SCR,SHC(8-32X.38)COUNTER	114
2	–	21899-2	WASHER, FLAT (#10)	113
2	–	21024-5	WASHER, LOCK (#10)	112
2	–	18028-2	WASHER,FLAT(M4)COUNTER	111
2	–	994991-5	SCR,OVAL HD(M4X12)COUNTER	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
1	–	1804303-1	BRACKET, COUNTER MTG	103
1	–	21009-2	SCREW,SKT SET(1/4-20x.25)	102
1	–	1804300-1	APPLICATOR COUNTER ASSY	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
2	–	4-21006-0	SCREW, SKT SET (8-32X.25)	94
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 7
1	–	23030-1	SCREW, SHC(NYLOK)(6-32X.38)	84 7
				83
2	–	22593-1	NUT, HEX JAM(1/4-20)BRACKET	82
1	–	1804310-1	MAGNET, RING	81
1	–	3-21081-2	SCR,SHC(1/4-20X1.00)BRACKET	80
1	–	1804318-1	BRACKET, MAGNET HOLDER	79
2	–	21024-3	WASHER, LOCK (#6) BRACKET	78
2	–	2-21000-0	SCR,SHC (6-32X.50)BRACKET	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

-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY		PARTS LIST		

	-3	-2	-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	ROLER, CAM	62
	1	–			240631-1	ROD, FEED	61
							60
	1	–			455164-1	CAP ASSEMBLY	59
	1	–			455162-1	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	–			22353-8	SCREW, SHOULDER	50
	1	–			3-21002-5	BOLT, CRIMPER	49
							48
	1	–			238015-1	CAM, POST-FEED 1 5/8 ST	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	–			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	–			690582-1	PIN, HINGE	28
	–	–			–	–	27
	1	–			684905-1	PLATE, BASE	26
	1	–			454579-7	HINGE BAR	25
	1	–			690571-1	BLOCK, STABILIZER	24
	1	–			690585-3	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	–			454571-1	GUIDE, STRIP (FRONT)	18
							17
	1	–			4-22284-9	SPRING, FEED RETURN	16
							15
△1	1	–			1-692134-3	POSITIONER,TERMINAL	14
	1	–			692134-1	POSITIONER,TERMINAL	13
	1	–			5-22280-5	SPRING,TERM. POSITIONER	12
	1	–			454711-4	PLATE, REAR SHEAR	11
	1	–			1633080-1	ANVIL INSERT	10
△1	1	–			1-690569-2	PLATE, FRONT SHEAR	9
	1	–			690575-1	ANVIL	8
	1	–			1-454575-1	BLADE, SLUG	7
	–	–			–	–	6
	1	–			684906-1	PLATE,ANVIL RETAINING	5
	1	–			690574-1	SPACER,TUBULAR INSUL CRIMPER	4
△1	1	–			1633086-1	CRIMPER, INSULATION	3
	1	–			681153-1	SPACER, CRIMPER	2
△1	1	–			690763-3	CRIMPER, WIRE	1
	QTY REQD PER ASSY			U/M	PART NO	DESCRIPTION	ITEM NO
	PARTS LIST						

POST-FEED 1 5/8 STROKE



△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 ADITIONAL 5 1/2 - 6 REVOLUTIONS.

△6 APPLY LOCTITE TO ITEM 93.

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

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

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

MATERIAL –
FINISH –

DWN	B.HIGMAN	04-21-03
CHK	B.HIGMAN	04-21-03
APVD	T.ELBIN	04-21-03

PRODUCT SPEC –
APPLICATION SPEC –
WEIGHT –

Tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME END FEED HINGE BAR APPLICATOR – –

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1385580	–

CUSTOMER DRAWING
SCALE NTS SHEET 1 OF 1 REV C