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PART NUMBER	REV	FIRST USED
680563-1	H	854400-1

TERMINAL NAME: .187 FLAG FASTON™ TERMINAL

CRIMPING DATA

TERM	PAD LTR	CRIMP HEIGHT	WIRE SIZE
1217027	A	.051±.002[1.29±0.05mm]	14
1742422	B	.046±.002[1.17±0.05mm]	16
	C	.043±.002[1.09±0.05mm]	18
	D	NOT	USED

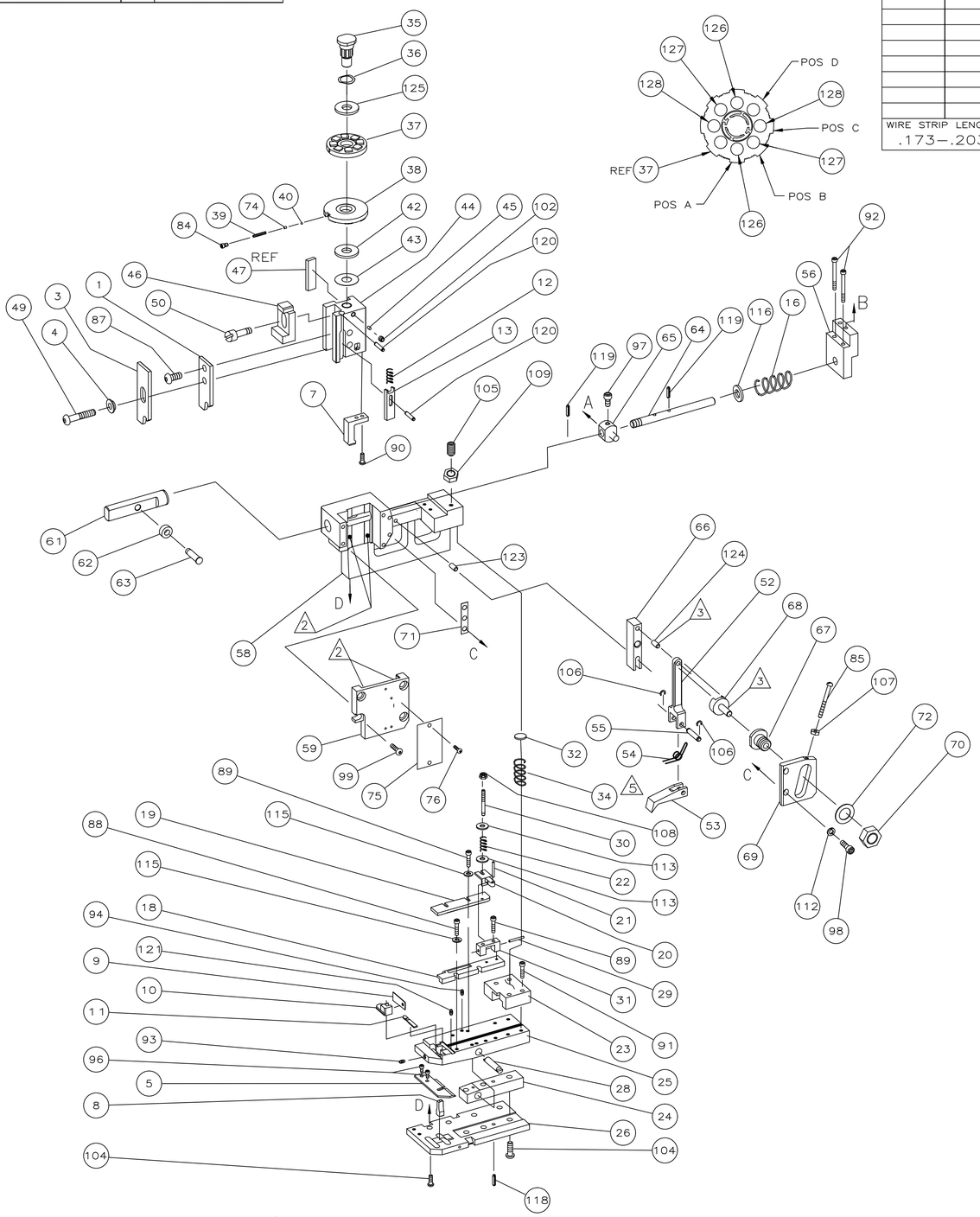
CRIMP	SIZE	TYPE	RANGE
WIRE	.140 [3.56mm]	TAB LOCK	18-14
INSUL	.170 [3.56mm]	0	.110-.190

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.173-.203	114-2078	.650	408-8037	-	-

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	H	ECR-17-013473	09-2017	RS	LZ

-1	LEADMAKER	MECH POST FEED	



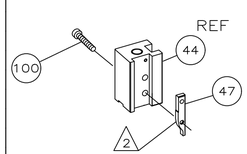
QTY	U/M	PART NO	DESCRIPTION	ITEM NO
				129
2	-	3-354779-5	PIN, WIRE DISC (.3165)C	128
2	-	3-354779-0	PIN, WIRE DISC (.3140)B	127
2	-	2-354779-2	PIN, WIRE DISC (.3100)A	126
1	-	986950-1	WASHER, FLAT PRECISION	125
1	-	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
1	-	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
1	-	217238-1	GENERAL INST PACKAGE	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.187X.75)	118
1	-	4088037	TAB-LOC™ INST 408-8037	117
1	-	21899-4	WASHER, FLAT (5/16)	116
4	-	21024-4	WASHER, LOCK (#8)	115
2	-	21055-6	WASHER, FLAT (#8)	114
2	-	1-21899-3	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
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 (8-32X0.88)	92
4	-	2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)	90
4	-	2-21000-8	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
1	-	23030-1	SCREW, SHC(NYLOK)(6-32X.25)	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

PARTS LIST

QTY	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	-	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
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	44
1	-	690125-1	WASHER, LAMINATED	43
1	-	1-690124-1	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	-	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	-	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	-	454571-2	GUIDE, STRIP (FRONT)	18
				17
1	-	4-22284-6	SPRING, FEED RETURN	16
				15
				14
1	-	692134-7	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

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.

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 12-26-97
CHK C.ERISMAN 12-26-97
APVD T.ELBIN 12-26-97
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT 0

TE Connectivity

NAME END FEED HINGE BAR APPLICATOR - -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-680563-1	-

CUSTOMER DRAWING SCALE NTS SHEET 1 OF 1 REV H