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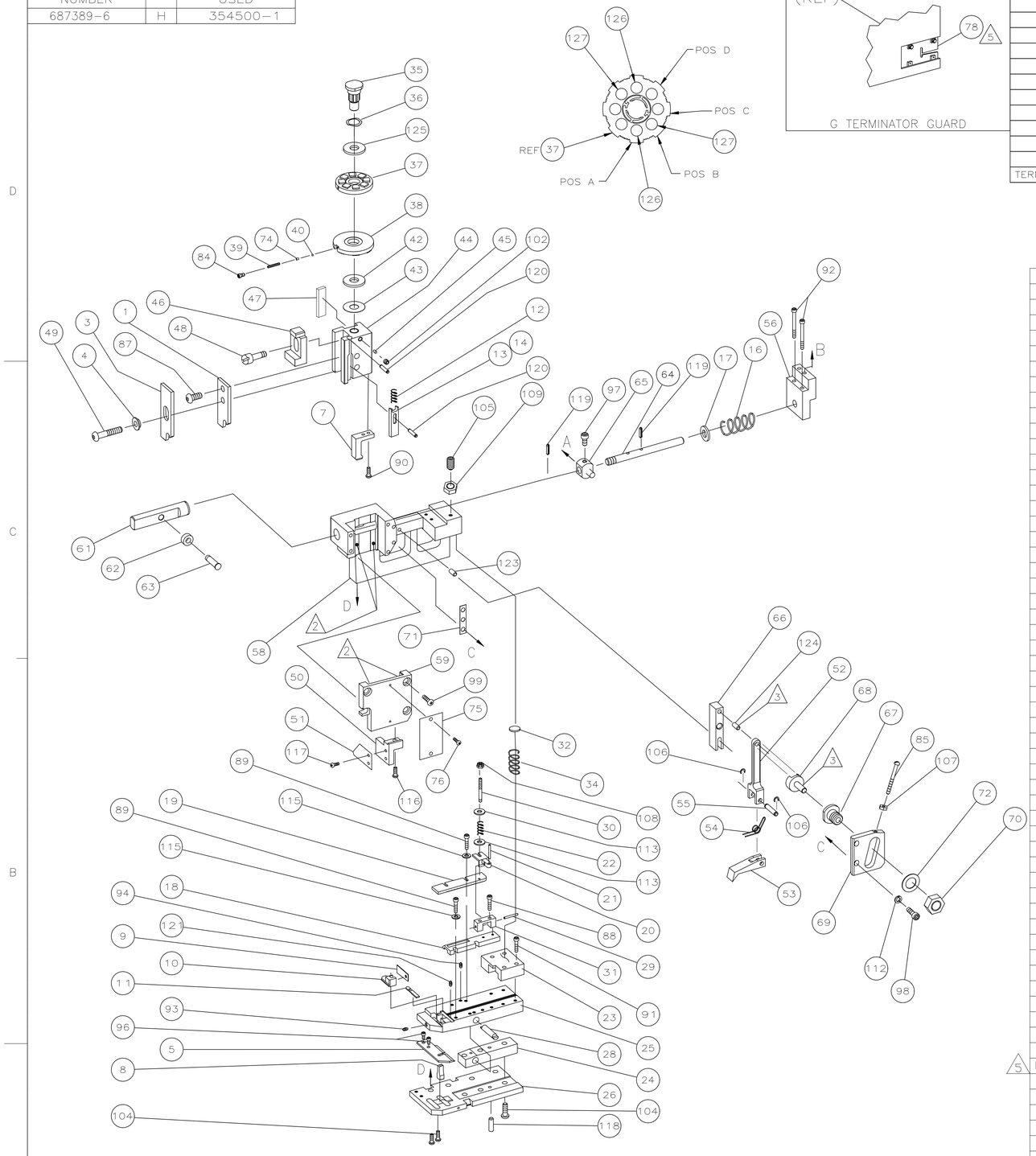
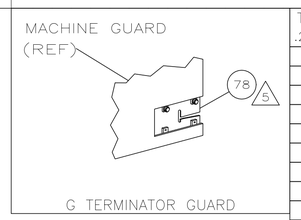
PART NUMBER	REV	FIRST USED
687389-6	H	354500-1





TERMINAL NAME: .250 FLAG FASTON™ RECEPTACLE	
	60851
	42563-6
	42563-8
	42563-9
TERM APPL SPEC	114-02078

CRIMPING DATA

PAD LTR	CRIMP HEIGHT		WIRE SIZE
A	.089±.002[2.26±0.05mm]		10
B	.075±.002[1.91±0.05mm]		12
C	NOT		USED
D	NOT		USED
CRIMP	SIZE	TYPE	RANGE
WIRE	.200[5.08mm]	TAB LOCK	12-10
INSUL	.200[5.08mm]	0	.110-.210
FEED .770	APPL INST △1 8031	SET UP GAGE –	LAYOUT –
WIRE STRIP LENGTH .234-.266			

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	H	REVISED PER ECR-20-015067	29OCT2020	GK	GB

-6	BENCH MODEL G	MECH PRE FEED	

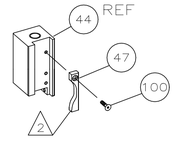
QTY REQD PER ASSY -1		U/M	PART NO	DESCRIPTION	ITEM NO
					129
					128
2	–		9-354778-1	PIN, WIRE DISC (.2950)B	127
2	–		6-354778-5	PIN, WIRE DISC (.2820)A	126
1	–		986950-1	WASHER, FLAT PRECISION	125
1	–		1-21030-2	PIN, DOWEL (Ø187X.62)	124
1	–		1-21030-6	PIN, DOWEL (Ø187X1.25)	123
					122
2	–		3-21028-2	PIN, SLOTTED SPRING (Ø094X.25)	121
3	–		4-21028-9	PIN, SLOTTED SPRING (Ø125X.38)	120
2	–		5-21028-1	PIN, SLOTTED SPRING (Ø125X.50)	119
1	–		21029-5	PIN, SLOTTED SPRING (Ø188X.75)	118
2	–		1-21002-6	SCREW, BHC (6-32 x .25) STOP	117
1	–		2-22603-1	SCREW, HEX (8-32 x .38) MTG	116
4	–		21024-4	WASHER, LOCK (#8)	115
2	–		21055-6	WASHER, FLAT (#8)	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"(Ø187)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	–		1-21002-7	SCREW, BHC (6-32X.38)CAM	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.31)	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
4	–		2-22603-3	SCREW, HEX (8-32X.62)	89
2	–		2-21000-8	SCREW, SHC (8-32 X .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.25)	84
					83
					82
					81
					80
					79
△5	REF	–	679532-1	INSERT, GUARD	78
					77
1	–		21017-2	SCR, DRIVE (2X .19)	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 REQD PER ASSY -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	–		318528-1	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
1	–		318530-3	STOP, WIRE	51
1	–		318529-1	BLOCK, MOUNTING	50
1	–		3-21002-5	BOLT, CRIMPER	49
1	–		22353-8	SCREW,SHOULDER	48
1	–		453991-1	CAM, PRE-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	–		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	–		318739-6	GUIDE, STRIP (FRONT)	18
1	–		21899-4	WASHER, FLAT (5/16)	17
1	–		4-22284-9	SPRING, FEED RETURN	16
					15
△6 △1 1	–		1-692134-6	POSITIONER,TERMINAL	14
1	–		692134-6	POSITIONER,TERMINAL	13
1	–		5-22280-5	SPRING,TERM. POSITIONER	12
1	–		454711-1	PLATE, REAR SHEAR	11
1	–		454710-1	ANVIL INSERT	10
△1 1	–		1-690569-1	PLATE, FRONT SHEAR	9
1	–		690761-1	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	–		690764-4	CRIMPER, INSULATION	3
					2
△1 1	–		690763-2	CRIMPER, WIRE	1

PARTS LIST

PRE-FEED 1 5/8 STROKE



G TERMINATING UNIT
BENCH MACHINE

△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 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

△6 ITEMS 13 & 14 CAN BE CHANGED TO CENTER TAB IN SLOT WHILE CRIMPING.

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 R O WILSON	4-25-97	TE Connectivity
CHK C.ERISMAN	4-28-97	
APVD J DODDS	4-29-97	NAME END FEED HINGE BAR APPLICATOR
PRODUCT SPEC –		–
APPLICATION SPEC –		–
WEIGHT –		SIZE A1 · CAGE CODE 00779 · DRAWING NO C-687389-6 · RESTRICTED TO –
CUSTOMER DRAWING		SCALE – · SHEET 1 OF 1 · REV H