



- 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 ADDITIONAL 5 1/2 - 6 REVOLUTIONS.

6 AFTER QUALIFICATIONS, DRILL & PIN ITEM 26 TO ITEM 58 USING ITEM 118, 2 PLACES, (-4 ONLY).

TERMINAL NAME: .250 LEFT-HAND FASTON™ FLAG RECEPTACLE

60274			CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
A	.072 ±.002 [1.83 ±0.05mm]	12			
B	.062 ±.002 [1.57 ±0.05mm]	14			
C	.056 ±.002 [1.42 ±0.05mm]	16			
D	.052 ±.002 [1.32 ±0.05mm]	18			
CRIMP WIRE	SIZE	TYPE	RANGE		
	.160 [4.06mm]	TAB-LOCK	18-12		
INSUL	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	
	.180 [4.57mm]	0		.110-.210	
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2078	.770	408-8037	-	L667

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO
2	2	-	C	3-354779-1	PIN, WIRE DISC (.3145)D	129
2	2	-	C	2-354779-1	PIN, WIRE DISC (.3095)C	128
2	2	-	C	1-354779-0	PIN, WIRE DISC (.3040)B	127
2	2	-	C	8-354778-7	PIN, WIRE DISC (.2930)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	-	A	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
3	3	-	A	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
						122
2	2	-	A	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
2	2	-	A	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	2	-	A	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
3	1	-	A	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)	118
1	1	-	A	21029-3	PIN, SLOTTED SPRING (Ø.188X.62)	117
1	1	-	A	21899-4	WASHER, 5\16 FLAT	116
4	4	-	A	21024-4	WASHER, LOCK (#8)	115
4	4	-	A	21055-6	WASHER, FLAT (#8)	114
1	1	-	A	21899-1	WASHER, FLAT (#6)	113
2	2	-	A	21024-5	WASHER, LOCK (#10)	112
						111
						110
1	1	-	A	1-22202-7	NUT, HEX (5/16-24)	109
1	1	-	A	21018-7	NUT, HEX (10-32)	108
1	1	-	A	21018-5	NUT, HEX (6-32)	107
2	2	-	A	21045-3	RING, RET"C"(Ø.187)FD PIN	106
1	1	-	A	8-21007-5	SCREW, SKT SET(5/16-24x.75)	105
7	7	-	A	2-22733-8	SCREW, BHC (1/4-20X.63)	104
						103
1	1	-	A	21009-2	SCREW, SKT SET(1/4-20x.25)	102
						101
						100
2	2	-	A	3-21000-9	SCREW, SHC (10-32X1.00)	99
4	4	-	A	3-21000-8	SCREW, SHC (10-32X.88)	98
2	2	-	A	3-21000-6	SCREW, SHC (10-32X.62)	97
1	1	-	A	3-21000-4	SCREW, SHC (10-32X.38)	96
2	2	-	A	7-21000-6	SCREW, SHC (10-32X.31)	95
						94
2	2	-	A	4-21006-0	SCREW, SKT SET (8-32X.25)	93
1	1	-	A	21061-9	SCREW, SKT SET (8-32X.25)	92
2	2	-	A	9-21000-3	SCREW, SHC (8-32X2.00)	91
4	4	-	A	2-21000-9	SCREW, SHC (8-32X.75)	90
2	2	-	A	1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)	89
2	2	-	A	2-21000-8	SCREW, SHC (8-32X.62)	88
2	2	-	A	2-21000-7	SCREW, SHC (8-32X.50)	87
1	1	-	A	2-21002-1	SCREW, SBHC (8-32X.38)	86
						85
1	1	-	A	6-23715-5	SCR, PAN HD(6-32x1.50)FEED ADJ	84
1	1	-	A	23030-1	SCREW, SHC(NYLOK)(6-32X.25)	83
						82
						81
1	1	-	A	1-22353-9	SCREW, SHLDR (Ø.250 x .250 LG)	80
						79
						78
						77
2	2	-	A	21017-2	SCR, DRIVE(#2X.19)ID	76
1	1	-	B	461264-1	PLATE, IDENTIFICATION	75
1	1	-	A	690603-1	SPRING, ASSIST	74
						73
1	1	-	A	458109-1	WASHER, SPECIAL	72
1	1	-	A	690517-1	SPACER	71
-4	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
QTY	REQD	PER	ASSY	PARTS LIST		

REVISIONS						
P	LR	DESCRIPTION	DATE	DRN	APRD	
D		ECR-17-010110	7-2017	RS	LZ	

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO
1	1	-	A	22594-8	NUT, HEX	70
1	1	-	B	240628-1	PLATE, ADJ	69
1	1	-	B	240626-1	SHAFT, PIVOT	68
1	1	-	B	240633-1	BUSHING	67
1	1	-	A	240630-1	LEVER, INTERMEDIATE	66
1	1	-	B	1804317-1	BLOCK, PIVOT	65
1	1	-	A	1633286-1	SCR, ADJ	64
1	1	-	B	240659-3	PIN, CAM ROLLER	63
1	1	-	B	240658-1	ROLER, CAM	62
1	1	-	B	240631-1	ROD, FEED	61
						60
1	1	-	C	455164-1	CAP ASSEMBLY	59
1	1	-	B	356418-1	HOUSING	58
						57
1	1	-	B	1804319-1	GUIDE, FEED ROD	56
1	1	-	B	240624-1	PIN, FEED FINGER	55
1	1	-	B	691499-1	SPRING, FEED FINGER	54
1	1	-	B	690584-5	FINGER, FEED	53
1	1	-	B	240634-1	LEVER, TERMINAL	52
						51
1	1	-	A	22353-8	SCREW, SHOULDER	50
1	1	-	A	3-21002-5	BOLT, CRIMPER	49
						48
1	1	-	B	238015-1	CAM, POST-FEED 1 5/8 ST	47
1	1	-	A	690578-2	BLOCK, INSULATION ADJUST	46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	459732-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	1-690124-1	WASHER, RAM	42
						41
1	1	-	A	23241-6	BALL, STEEL	40
1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	-	C	690142-1	DISC, INSULATION	38
1	1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	1	-	B	22480-5	WASHER, SPRING	36
1	1	-	B	690212-1	POST, RAM	35
1	1	-	A	3-23846-5	SPRING, HINGE BAR	34
						33
1	1	-	A	690573-1	SPACER, SPRING	32
1	1	-	B	356419-1	RETAINER, DRAG SPRING	31
						30
						29
1	1	-	B	690582-1	PIN, HINGE	28
						27
1	1	-	C	463873-1	PLATE, BASE	26
1	1	-	B	691535-2	HINGE BAR	25
1	1	-	B	690571-1	BLOCK, STABILIZER	24
1	1	-	C	814222-1	BLOCK, PRESSURE	23
1	1	-	A	7-22282-5	SPRING, DRAG	22
1	1	-	A	458968-1	LEVER, DRAG	21
1	1	-	A	458960-1	DRAG, STOCK	20
1	1	-	C	691530-4	GUIDE, STRIP (REAR)	19
1	1	-	C	691529-2	GUIDE, STRIP (FRONT)	18
						17
1	1	-	A	4-22284-6	SPRING, FEED RETURN	16
						15
						14
1	1	-	C	692134-5	POSITIONER, TERMINAL	13
1	1	-	A	5-22280-5	SPRING, TERM. POSITIONER	12
1	1	-	B	691525-5	PLATE, REAR SHEAR	11
1	1	-	C	459730-1	ANVIL INSERT	10
1	1	-	B	690569-9	PLATE, FRONT SHEAR	9
1	1	-	D	691523-3	ANVIL	8
1	1	-	B	691532-5	BLADE, SLUG	7
						6
1	1	-	B	463874-1	PLATE, ANVIL RETAINING	5
1	1	-	B	690574-1	SPACER, TUBULAR INSUL CRIMPER	4
1	1	-	C	459728-1	CRIMPER, INSULATION	3
						2
1	1	-	C	459731-1	CRIMPER, WIRE	1
-4	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
QTY	REQD	PER	ASSY	PARTS LIST		

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DWG NO	5-9-96
0 PLC ± .005	1 PLC ± .002	DR	R O WILSON
2 PLC ± .001	3 PLC ± .0005	CHK	C ERISMAN
4 PLC ± .0002	ANGLES ± .0001	APRD	T ELBIN
MATERIAL: -	FINISH: -	NAME	TE Connectivity
		PRODUCT SPEC	END FEED HINGE BAR APPLICATOR
		APPLICATION SPEC	-
		WEIGHT	0
		SIZE	A1
		SCALE	1 OF 1
		CAGE CODE	00779
		DRAWING NO	680313
		RESTRICTED TO	-
		CUSTOMER DRAWING	REV D

CUSTOMER AND ASSEMBLY DRAWING