PART NUMBER	REV	FIRST USED
1855041-1	F	854400-1
7-1855041-7	F	SPARE PARTS KIT

TERMINAL NAME:		.250 FLAG FASTON™		
TE P/N	MFG P/N	.018 THK	.018 THK	.016 THK
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
		2232111		42404
				1742460
		TERM APPL SPEC 114-2078		

REF SETTING	CRIMPING DATA: CRIMP HEIGHT *	WIRE SIZE
B1	.070 ±.002 [1.78mm±0.05mm]	12
C6	.060 ±.002 [1.52mm±0.05mm]	14
D3	.055 ±.002 [1.4mm±0.05mm]	(2)18
D9	.052 ±.002 [1.32mm±0.05mm]	16
E5	.048 ±.002 [1.22mm±0.05mm]	18

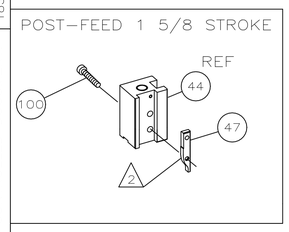
CRIMP	SIZE	TYPE	RANGE
WIRE	.160 [4.06mm]	TAB LOCK	18-12
INSUL	.180 [4.57mm]	0	.110-.210 (8)

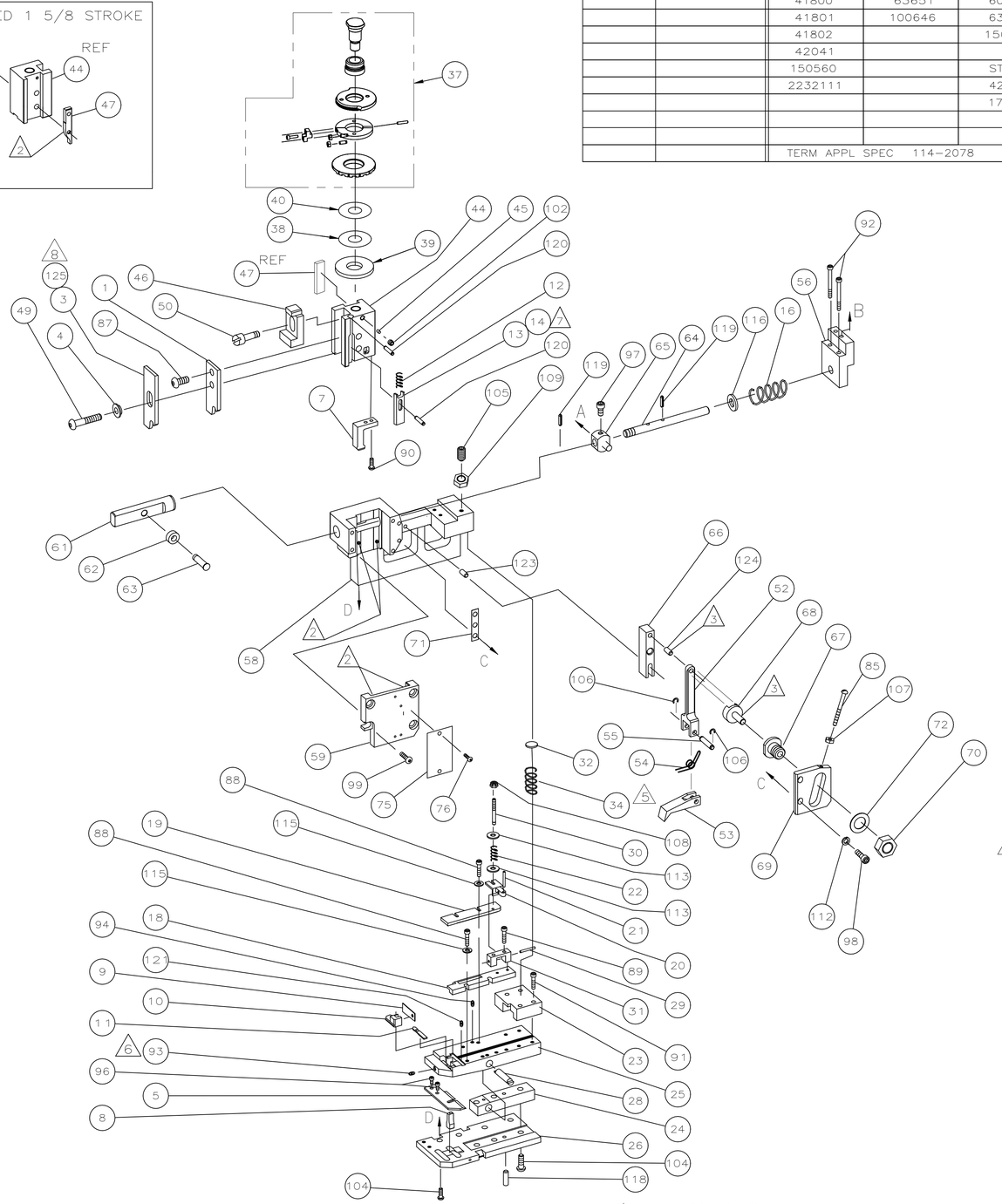
FEED	APPL INST	SET UP GAGE	LAYOUT
.770	A18031	–	–

WIRE STRIP LENGTH .205-.235

USED ON –

-1	LEADMAKER G	MECH POST FEED
-77	–	SPARE PARTS KIT





					129
					128
					127
					126
1	1	–	690764-1	CRIMPER, INSULATION	125
–	1	–	1-21030-2	PIN, DOWEL (Ø187X.62)	124
–	1	–	1-21030-6	PIN, DOWEL (Ø187X1.25)	123
					122
–	1	–	3-21028-2	PIN, SLOTTED SPRING (Ø094X.25)	121
–	2	–	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
					117
–	1	–	21899-4	WASHER, FLAT (5/16)	116
–	4	–	21024-4	WASHER, LOCK (#8)	115
					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	–	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
(6) –	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
–	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
					84
					83
					82
					81
					80
					79
					78
					77
–	2	–	21017-2	SCR,DRIVE(#2X.19)ID	76
–	1	–	461264-5	PLATE, IDENTIFICATION	75
					74
					73
–	1	–	458109-1	WASHER, SPECIAL	72
–	1	–	690517-1	SPACER	71
-77	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY			PARTS LIST		

–	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	–	454568-1	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
					43
					42
					41
–	1	–	469367-4	SPACER, FINE ADJ	40
–	1	–	690125-1	WASHER, LAMINATED	39
–	1	–	469367-7	SPACER, FINE ADJUST	38
–	1	–	879103-2	FINE ADJUST HEAD SUBASSY	37
					36
					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	–	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
(7)(1) –	1	–	1-692134-3	POSITIONER,TERMINAL	14
–	1	–	692134-1	POSITIONER,TERMINAL	13
–	1	–	5-22280-5	SPRING,TERM. POSITIONER	12
–	1	–	454711-1	PLATE, REAR SHEAR	11
–	1	–	454709-1	ANVIL INSERT	10
(1) –	1	–	690569-1	PLATE, FRONT SHEAR	9
1	1	–	690575-1	ANVIL	8
–	1	–	454575-4	BLADE, SLUG	7
–	–	–	–	–	6
–	1	–	684906-1	PLATE,ANVIL RETAINING	5
–	1	–	690574-1	SPACER,TUBULAR INSUL CRIMPER	4
(8)(1) 1	1	–	690588-1	CRIMPER, INSULATION	3
–	–	–	–	–	2
(1) 1	1	–	690587-3	CRIMPER, WIRE	1
-77	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY			PARTS LIST		

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.
8. INSULATION CRIMPER PN 690764-1 MAY BE USED FOR LARGER INSULATION DIAMETERS.

* WARNING:
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

P	LTR	REVISION RECORD	DATE	DWN	APVD
	F	REVISED PER ECR-24-205342	10APR2024	GV	GB
	E	REVISED PER ECR-23-170330	25MAR2023	GK	GB
	D2	ECR-18-019891	20DEC2018	GK	GB

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± – ; 3 PLC ± – ; 4 PLC ± –
ANGLES ± –
SURFACE TEXTURE √

DWN C.ERISMAN	31MAR2006	MATERIAL – –
CHK C.ERISMAN	31MAR2006	HEAT TREAT – –
APVD T.ELBIN	31MAR2006	TE Connectivity

NAME: END FEED HINGE BAR APPLICATOR

SCALE	SIZE	DRAWING NO	SHEET	REV
NTS	A1	1855041	1 OF 1	F

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1855041

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TE CONNECTIVITY AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES (THE "TE GROUP") AND MAY BE DISCLOSED ONLY TO TE GROUP PERSONNEL, WITHOUT AUTHORIZATION FROM TE (www.TE.com).

3308-8 (1/15)