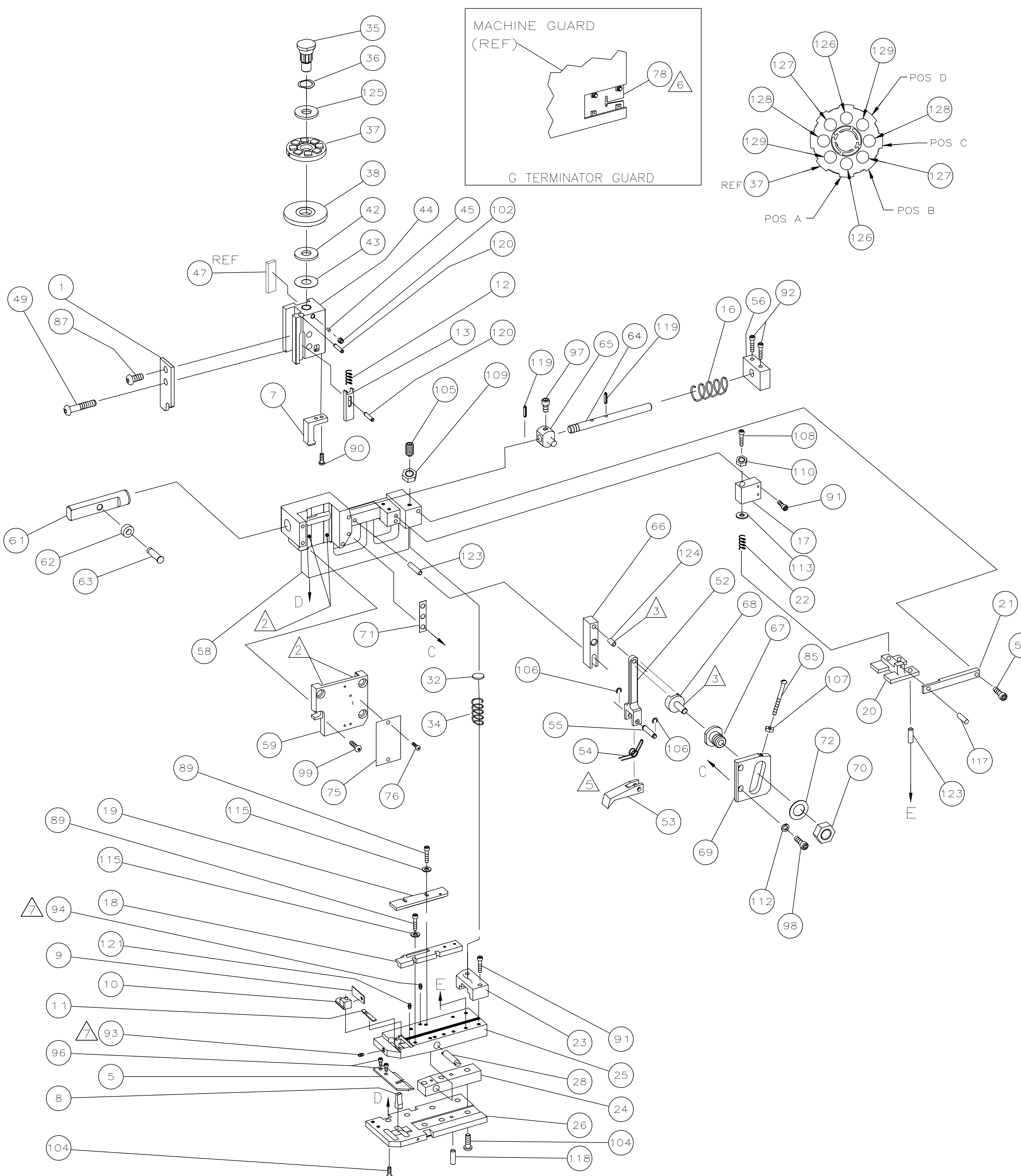


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PART NUMBER	REV	FIRST USED
1-686961-2	D	354500-1

TERMINAL NAME: TAB LOK (RIGHT HAND)		CRIMPING DATA	
	61177	PAD LTR	CRIMP HEIGHT
		A	.072±.002
		B	.062±.002
		C	.056±.002
		D	.052±.002
		CRIMP	SIZE
		WIRE	.160
		INSUL	-
		FEED	APPL INST
			△18031
		SET UP GAGE	-
		LAYOUT	-
TERM APPL SPEC	114-2078	WIRE STRIP LENGTH	.363-.393

REVISIONS				
P	LTR	DESCRIPTION	DATE	APPD
D		REVISED PER ECR-20-016299	19NOV2020	GK LG

-12 BENCH MODEL G MECH PRE FEED

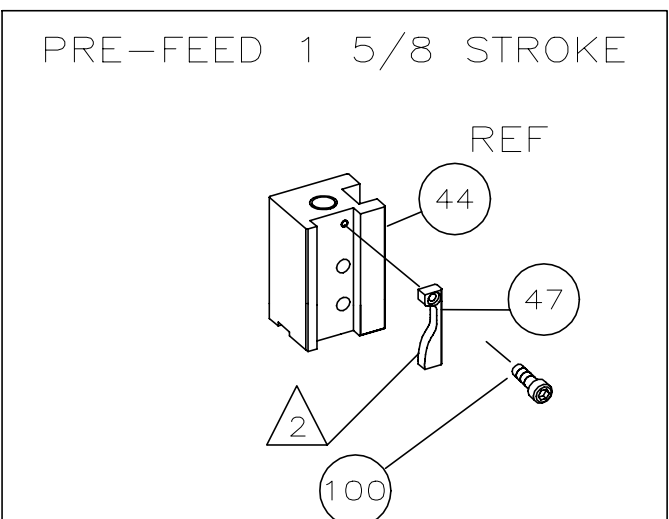


2	-	C	2-354779-8	PIN, WIRE DISC (.3130)D	129
2	-	C	2-354779-2	PIN, WIRE DISC (.3100)C	128
2	-	C	1-354779-5	PIN, WIRE DISC (.3065)B	127
2	-	C	9-354778-6	PIN, WIRE DISC (.2975)A	126
1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	-	A	1-21030-2	PIN, DOWEL (Ø187X.62)	124
3	-	A	1-21030-6	PIN, DOWEL (Ø187X1.25)	123
2	-	A	3-21028-2	PIN, SLOTTED SPRING (Ø094X.25)	122
2	-	A	4-21028-9	PIN, SLOTTED SPRING (Ø125X.38)	120
2	-	A	5-21028-1	PIN, SLOTTED SPRING (Ø125X.50)	119
1	-	A	21029-5	PIN, SLOTTED SPRING (Ø188X.75)	118
1	-	A	21029-3	PIN, SLOTTED SPRING (Ø188X.62)	117
4	-	A	21024-4	WASHER, LOCK (#8)	115
2	-	A	21055-6	WASHER, FLAT (#8)	114
1	-	A	21899-1	WASHER, FLAT (#6)	113
2	-	A	21024-5	WASHER, LOCK (#10)	112
1	-	A	21018-7	NUT, HEX (10-32)	110
1	-	A	1-22202-7	NUT, HEX (5/16-24)	109
1	-	A	3-21000-9	SCREW,SHC (10-32 X 1.00)DRAG	108
1	-	A	21018-5	NUT, HEX (6-32)	107
2	-	A	21045-3	RING,RET" C"(Ø187)FD PIN	106
1	-	A	8-21007-5	SCREW,SKT SET(5/16-24x.75)	105
7	-	A	2-22733-8	SCREW, BHC (1/4-20X.63)	104
1	-	A	21009-2	SCREW,SKT SET(1/4-20x.25)	102
2	-	A	1-21003-9	SCREW, FL (6-32X.38)	100
4	-	A	3-21000-8	SCREW, SHC (10-32X.88)	99
2	-	A	3-21000-6	SCREW, SHC (10-32X.62)	98
1	-	A	3-21000-4	SCREW, SHC (10-32X.38)	97
2	-	A	7-21000-6	SCREW, SHC (10-32X.38)	96
2	-	A	4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	-	A	21061-9	SCREW, SKT SET (8-32X.25)	93
2	-	A	3-21000-0	SCREW, SHC (8-32X.88)	92
2	-	A	2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	A	23030-4	SCREW, SHC (NYLOK)(6-32X.62)	90
4	-	A	2-22603-3	SCREW, HEX (8-32X.62)	89
1	-	A	2-21002-2	SCREW, BHC (8-32X.50)	87
1	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	85
1	-	A	23030-1	SCREW, SHC(NYLK)(6-32X.25)	84
REF	-	B	679532-1	INSERT, GUARD	78
2	-	A	21017-2	SCR,DRIVE(#2X.19)ID	76
1	-	B	461264-1	PLATE, IDENTIFICATION	75
1	-	A	690603-1	SPRING, ASSIST	74
1	-	A	458109-1	WASHER, SPECIAL	72
1	-	A	690517-1	SPACER	71

1	-	A	22594-8	NUT, HEX	70
1	-	B	240628-1	PLATE, ADJ	69
1	-	B	240626-1	SHAFT, PIVOT	68
1	-	B	240633-1	BUSHING	67
1	-	A	240630-1	LEVER, INTERMEDIATE	66
1	-	B	240629-1	BLOCK, PIVOT	65
1	-	A	1633286-1	SCR, ADJ	64
1	-	B	240659-3	PIN, CAM ROLLER	63
1	-	B	240658-1	ROLER, CAM	62
1	-	B	240631-1	ROD, FEED	61
1	-	C	455164-1	CAP ASSEMBLY	59
1	-	D	458984-1	HOUSING	58
1	-	B	458361-1	GUIDE,FEED ROD	56
1	-	B	240624-1	PIN, FEED FINGER	55
1	-	B	691499-1	SPRING, FEED FINGER	54
1	-	B	690584-5	FINGER, FEED	53
1	-	B	240634-1	LEVER, TERMINAL	52
1	-	A	1-22353-9	SCREW, SHOULDER	50
1	-	A	3-21002-5	BOLT, CRIMPER	49
1	-	B	453991-1	CAM, PRE-FEED 1 5/8 ST	47
1	-	A	690191-1	PLUG, NYLON	45
1	-	C	691533-1	RAM	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	1-690124-1	WASHER, RAM	42
1	-	A	690223-1	DISC, SPACER	38
1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	-	B	22480-5	WASHER, SPRING	36
1	-	B	690212-1	POST, RAM	35
1	-	A	3-23846-5	SPRING, HINGE BAR	34
1	-	A	690573-1	SPACER, SPRING	32
1	-	B	691535-2	HINGE BAR	25
1	-	B	690571-1	BLOCK, STABILIZER	24
1	-	C	814222-2	BLOCK, PRESSURE	23
1	-	A	7-22282-5	SPRING, DRAG	22
1	-	A	458968-1	LEVER, DRAG	21
1	-	A	458960-2	DRAG, STOCK	20
1	-	C	691530-1	GUIDE, STRIP (REAR)	19
1	-	C	691529-1	GUIDE, STRIP (FRONT)	18
1	-	B	458978-1	BLOCK, SPRING	17
1	-	A	4-22284-9	SPRING, FEED RETURN	16
1	-	C	692134-5	POSITIONER,TERMINAL	13
1	-	A	5-22280-5	SPRING,TERM. POSITIONER	12
1	-	B	691525-1	PLATE, REAR SHEAR	11
1	-	C	691524-1	ANVIL INSERT	10
1	-	B	690569-4	PLATE, FRONT SHEAR	9
1	-	D	691523-1	ANVIL	8
1	-	B	691532-1	BLADE, SLUG	7
1	-	B	463874-1	PLATE,ANVIL RETAINING	5
1	-	C	691531-1	CRIMPER, WIRE	1

- 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 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.  
7 APPLY SEALANT PN 1-23419-5.



THIS DRAWING IS A CONTROLLED DOCUMENT.

APPROVED: M. O'BRIEN, 10-10-94  
 DWG: C. CRISMAN, 10-10-94  
 NAME: J. SLUSSER, 10-10-94

TE Connectivity  
 END FEED HINGE BAR APPLICATOR

SCALE: 1 OF 1 REV: D