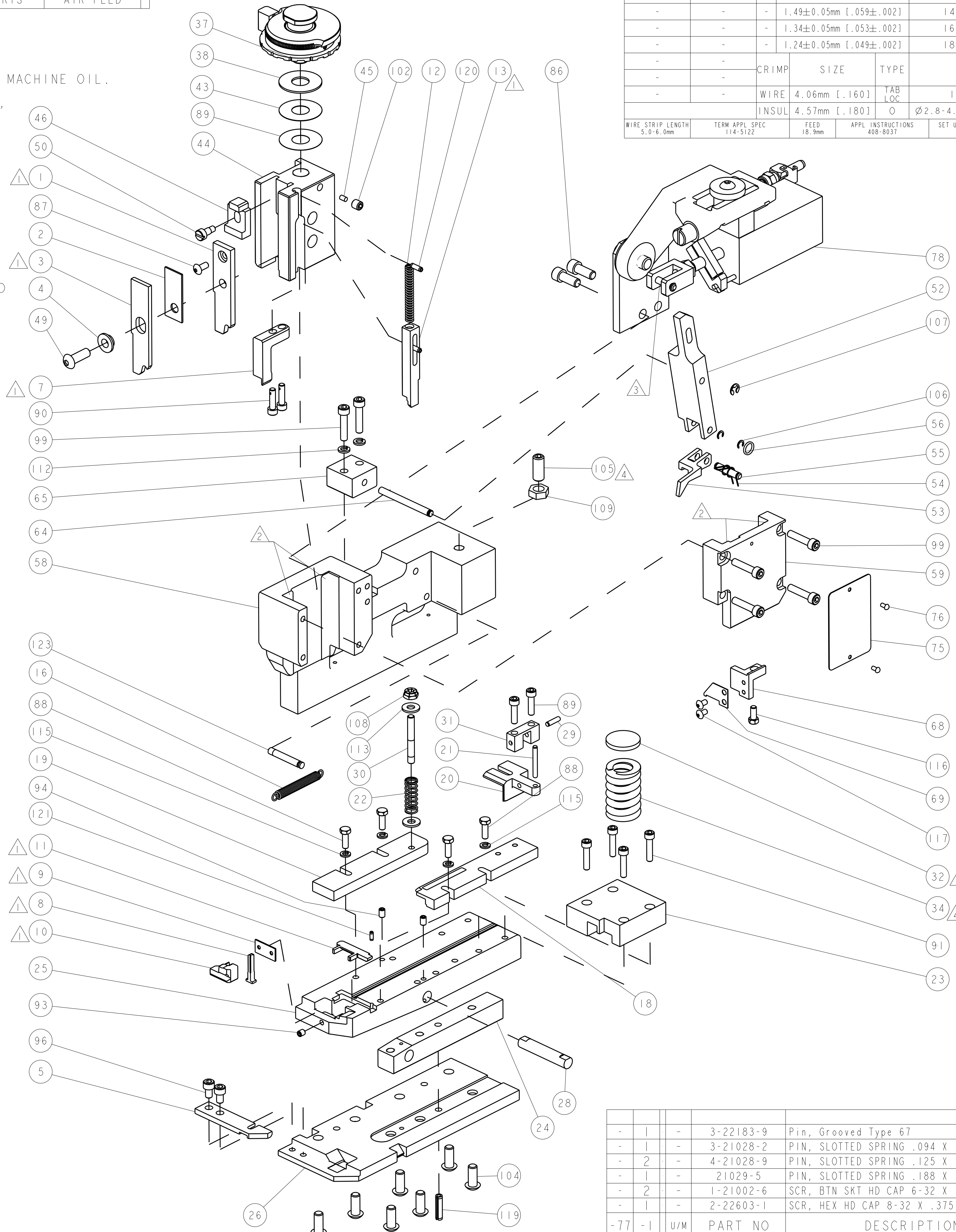
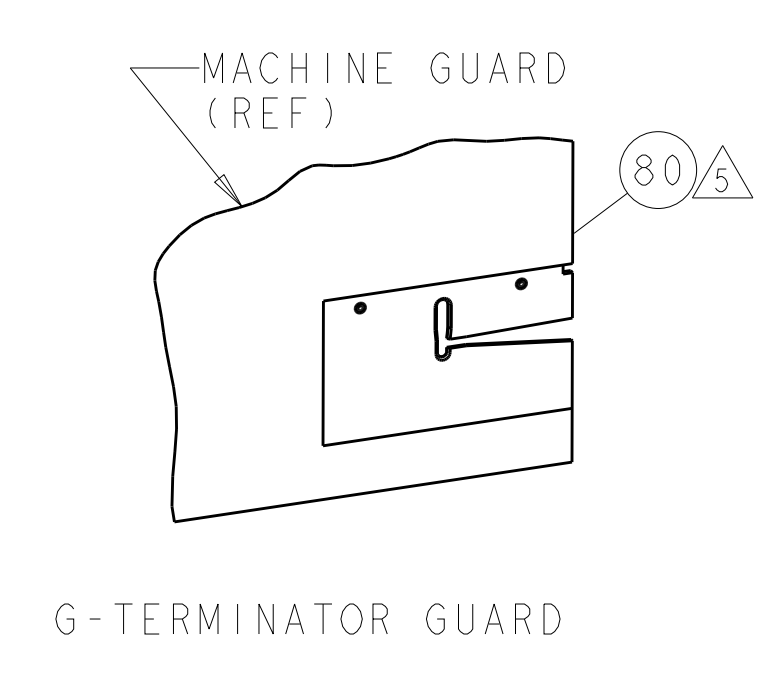


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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	
1855465-1	C	-	BENCH MODEL G	AIR FEED	
7-1855465-7	A	-	SPARE PARTS	AIR FEED	

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4 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.
- 5 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 6 ITEM 89 NEEDS TO BE INSTALLED TO ACHIEVE CRIMP HEIGHTS FOR WIRE SIZES 16 & 18 AWG.

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



TERMINAL NAME: .250 SERIES FLAG POS LOCK-EX RECEPTACLE

-	175057	TE TERMINAL - TE CRIMP SPECS			
-	1743221				
-	-	CRIMP HEIGHT	WIRE SIZE	REF SETTING	
-	-	1.75±0.05mm [.069±.002]	12	A5	
-	-	1.49±0.05mm [.059±.002]	14	C9	
-	-	1.34±0.05mm [.053±.002]	16	D5	
-	-	1.24±0.05mm [.049±.002]	18	E4	
-	-	CRIMP SIZE	TYPE	RANGE	
-	-	WIRE 4.06mm [.160]	TAB LOC	18-12 AWG	
-	-	INSUL 4.57mm [.180]	O	∅2.8-4.1mm [.110-.161]	
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTIONS	SET UP GAGE	LAYOUT
5.0-6.0mm	114-5122	18.9mm	408-8037	-	L1815

REVISIONS					
P	LTN	DESCRIPTION	DATE	OWN	APVD
A		RELEASED	26FEB2009	LG	GB
B		ECR-18-019872	19DEC2018	TB	GB
B1		ECR-19-000894	18JAN2019	GK	GB
C		-1 REVISED, ECR-19-004398	20MAR2019	GK	GB

-	4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	115
-	2	-	21899-2	WASHER, FLAT	113
-	2	-	21024-5	WASHER, SPRG LOCK, REG NO 10	112
-	1	-	1-22202-7	NUT, HEX, JAM 5/16-24/UNF	109
-	1	-	21022-3	NUT, HEX, SELF-LOCKING, THIN, 10-32	108
-	1	-	1-21986-2	RING, RETAIN, EXTERN, 3/16 E-RING	107
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	106
-	1	-	8-21007-5	SCR, SET, CUP POINT 5/16-24 X .750	105
-	7	-	2-22733-8	SCR, BHSC, SELF-LOCKING, 1/4-20 X .625	104
-	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	102
-	6	-	3-21000-8	SCR, SKT HD CAP 10-32 X .875	99
-	2	-	7-21000-6	SCR, SKT HD CAP 10-32 X .312	96
-	2	-	4-21006-0	SCR, SET, CUP POINT 8-32 X .250	94
-	1	-	21061-9	SCR, SET, CONE POINT 8-32 X .250	93
-	4	-	2-21000-9	SCR, SKT HD CAP 8-32 X .750	91
-	2	-	1-23030-1	SCR, SKT HD CAP, S-LOCK, 8-32 X .625	90
-	1	-	469367-2	SHIM	89
-	2	-	2-21000-8	SCR, SKT HD CAP 8-32 X .625	89
-	4	-	2-22603-3	SCR, HEX HD CAP, 1N	88
-	1	-	2-21002-1	SCR, BTN SKT HD CAP 8-32 X .375	87
-	2	-	21001-3	SCR, SKT HD CAP 1/4-20 X .625	86
-	REF	-	679532-1	INSERT, GUARD	80
-	1	-	462622-2	AIR FEED ASSEMBLY	78
-	2	-	21017-2	SCREW, DRIVE	76
-	1	-	461264-5	PLATE, IDENTIFICATION	75
-	1	-	318530-3	STOP, WIRE	69
-	1	-	318529-1	BLOCK, MOUNTING	68
-	1	-	456987-1	BLOCK, PIVOT	65
-	1	-	457058-1	PIN, PIVOT	64
-	1	-	318528-2	CAP, RAM	59
-	1	-	457079-1	HOUSING, MACHINING	58
-	1	-	25745-1	RING, SPLIT	56
-	1	-	240624-1	PIN, FEED FINGER	55
-	1	-	691499-1	SPRING-FEED FINGER	54
-	1	-	454568-3	FINGER, FEED	53
-	1	-	457057-1	PIVOT ARM	52
-	1	-	22353-8	SCR, SHLD, SLOT HD, 3/16 DIA	50
-	1	-	3-21002-5	SCR, BTN SKT HD CAP 1/4-20 X .750	49
-	1	-	690578-1	INSULATION ADJUST BLOCK	46
-	1	-	690191-1	PLUG, NYLON	45
-	1	-	454574-1	RAM, SPECIAL	44
-	1	-	690125-1	SHIM SUB-ASSY	43
-	1	-	1-469367-1	SHIM	38
-	1	-	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	1	-	3-23846-5	SPRING, DIE	34
-	1	-	690573-1	SPACER, SPRING	32
-	1	-	454569-2	MOUNT, DRAG	31
-	1	-	1-22354-8	STUD, THREADED	30
-	1	-	21030-2	PIN, DOWEL .1250 X .500	29
-	1	-	690582-1	PIN, HINGE	28
-	1	-	684905-1	PLATE, BASE	26
-	1	-	454579-5	BAR, HINGE	25
-	1	-	690571-1	STABILIZER	24
-	1	-	690585-2	BLOCK, SPRING PRESSURE	23
-	1	-	8-22282-6	SPRING, COMPRESSION	22
-	1	-	21030-6	PIN, DOWEL .1250 X 1.000	21
-	1	-	454570-1	DRAG, STOCK	20
-	1	-	454573-1	GUIDE, STRIP, REAR	19
-	1	-	318739-7	GUIDE, FRONT STRIP	18
-	1	-	2-22287-6	SPRING, EXTENSION	16
-	1	-	1-692134-8	TERMINAL POSITIONER	13
-	1	-	5-22280-5	SPRING, COMPRESSION	12
-	1	-	454712-7	PLATE, REAR SHEAR	11
-	1	-	454709-1	ANVIL, INSERT	10
-	1	-	690569-1	PLATE, SHEAR, FRONT	9
-	1	-	691523-3	ANVIL	8
-	1	-	454575-9	BLADE, SHEAR	7
-	1	-	684906-1	ANVIL RETAINING	5
-	1	-	690574-1	SPACER, TUBULAR	4
-	1	-	690588-1	CRIMPER, INSULATION PREMIUM	3
-	1	-	681153-1	SPACER, CRIMPER	2
-	1	-	690587-1	CRIMPER, WIRE	1

-	1	-	3-22183-9	Pin, Grooved Type 67	123
-	1	-	3-21028-2	PIN, SLOTTED SPRING .094 X .250	121
-	2	-	4-21028-9	PIN, SLOTTED SPRING .125 X .375	120
-	1	-	21029-5	PIN, SLOTTED SPRING .188 X .750	119
-	2	-	1-21002-6	SCR, BTN SKT HD CAP 6-32 X .250	117
-	1	-	2-22603-1	SCR, HEX HD CAP 8-32 X .375	116
-77	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

APPROVED: G. BAILLEY 19JAN2009

DATE: 19JAN2009

NAME: APPLICATOR, FINE ADJUST HINGE BAR, .250 FLAG POS LOCK-EX RECEPTACLE

SIZE: 3.5

SCALE: 3:5

SHEET: 1 OF 1

REV: C

CUSTOMER DRAWING

RESTRICTED TO

100779C=1855465

CUSTOMER VIEWABLE ASSEMBLY