

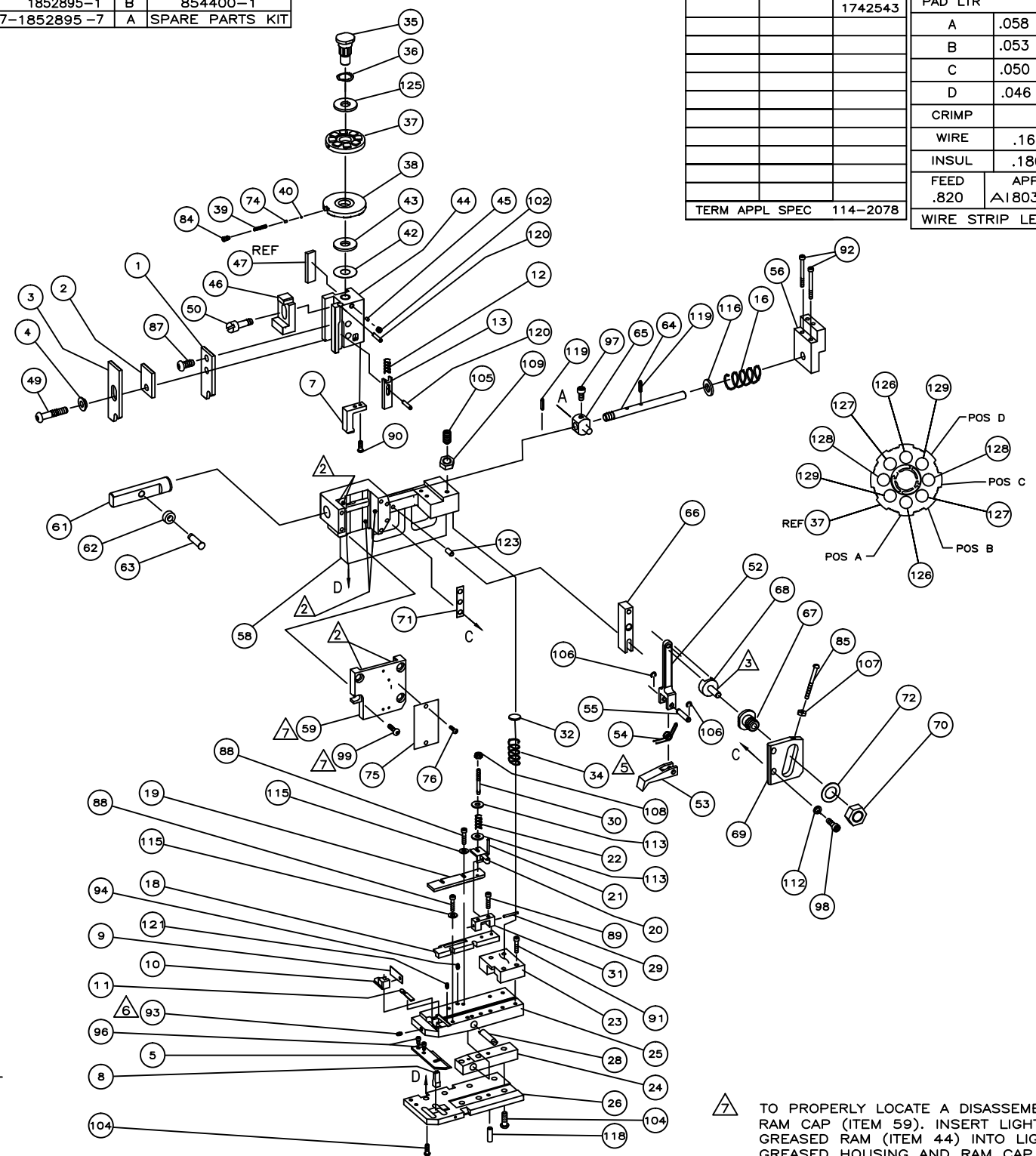
DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS).
 THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED
1852895-1	B	854400-1
7-1852895-7	A	SPARE PARTS KIT

TERMINAL NAME:	
.250 FLAG	FASTON™
	1742543
TERM APPL SPEC 114-2078	

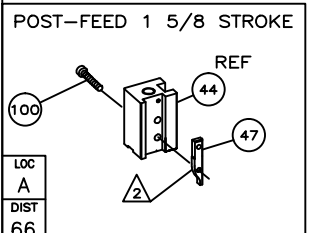
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.058 ±.002 [1.47mm±0.05mm]	(1)14or(1)16+(1)18	
B	.053 ±.002 [1.35mm±0.05mm]	(2)18	
C	.050 ±.002 [1.27mm±0.05mm]	16	
D	.046 ±.002 [1.17mm±0.05mm]	18	
CRIMP	SIZE	TYPE	RANGE
WIRE	.160 [4.06mm]	TAB LOCK	18-12
INSUL	.180 [4.57mm]	0	.110-.210
FEED	APPL INST	SET UP GAGE	LAYOUT
.820	A18031	-	-
WIRE STRIP LENGTH .205-.235			

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



⚠ TO PROPERLY LOCATE A DISASSEMBLED RAM CAP (ITEM 59). INSERT LIGHTLY GREASED RAM (ITEM 44) INTO LIGHTLY GREASED HOUSING AND RAM CAP UNTIL TOOLING RESTS AGAINST HINGE BAR (ITEM 25). TIGHTEN SCREWS (ITEM 99).

- 1 RECOMMENDED SPARE PARTS.
- 2 LIGHTLY GREASE INDICATED CONTACT SURFACES WITH 984999-1 (CHEVRON ULTRA-DUTY EP NGLI 2).
- 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 APPLY LOCTITE TO ITEM 93.



QTY	PART NO	DESCRIPTION	ITEM NO
- 2	5-354779-8	PIN, WIRE DISC (.3280)D	129
- 2	5-354779-2	PIN, WIRE DISC (.3250)C	128
- 2	4-354779-6	PIN, WIRE DISC (.3220)B	127
- 2	3-354779-6	PIN, WIRE DISC (.3170)A	126
- 1	986950-1	WASHER, FLAT PRECISION	125
- 1	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
- 1	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
- 1	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
- 2	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
- 2	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
- 1	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)	118
- 1	21899-4	WASHER, FLAT (5/16)	116
- 4	21024-4	WASHER, LOCK (#8)	115
- 2	21899-2	WASHER, FLAT (#10)	113
- 2	21024-5	WASHER, LOCK (#10)	112
- 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" (Ø.187)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
- 1	21009-2	SCREW, SKT SET(1/4-20X.25)	102
- 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
- 1	4-21006-5	SCREW, SKT SET (8-32X.62)	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
- 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
- 1	6-23715-5	SCR, PAN HD(6-32x1.50)FEED ADJ	85
- 1	23030-1	SCREW, SHC(NYLOK)(6-32X.38)	84
- 2	21017-2	SCR, DRIVE(#2X.19)ID	76
- 1	461264-1	PLATE, IDENTIFICATION	75
- 1	690603-1	SPRING, ASSIST	74
- 1	458109-1	WASHER, SPECIAL	72
- 1	690517-1	SPACER	71
-77	-1	U/M	

QTY	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	
- 1	2217626-1	CAP ASSEMBLY	59	
- 1	2217625-1	HOUSING	58	
- 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	2256119-1	SCREW, SHOULDER	50	
- 1	3-21002-5	BOLT, CRIMPER	49	
- 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	
- 1	690125-1	WASHER, LAMINATED	43	
- 1	690124-4	WASHER, RAM	42	
- 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	
- 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	1633530-1	PIN, HINGE	28	
- 1	684905-1	PLATE, BASE	26	
- 1	454579-4	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	454570-2	DRAG, STOCK	20	
- 1	454573-2	GUIDE, STRIP (REAR)	19	
- 1	454571-6	GUIDE, STRIP (FRONT)	18	
- 1	4-22284-9	SPRING, FEED RETURN	16	
- 1	692134-1	POSITIONER, TERMINAL	13	
- 1	5-22280-5	SPRING, TERM. POSITIONER	12	
- 1	454711-5	PLATE, REAR SHEAR	11	
- 1	1633080-2	ANVIL INSERT	10	
- 1	690569-1	PLATE, FRONT SHEAR	9	
1	1	690575-1	ANVIL	8
- 1	854422-3	BLADE, SLUG	7	
- 1	684906-1	PLATE, ANVIL RETAINING	5	
- 1	690574-1	SPACER, TUBULAR INSUL CRIMPER	4	
1	1	690588-1	CRIMPER, INSULATION	3
1	1	681153-1	SPACER, CRIMPER	2
1	1	690587-1	CRIMPER, WIRE	1
-77	-1	U/M		

REV	DATE	BY	APPD	REASON
B	26FEB2014	JH	TE	ECR-14-028115
A				RELEASED

DIMENSIONS: INCHES
 TOLERANCES UNLESS OTHERWISE SPECIFIED:
 0 PLG ±.001
 1 PLG ±.002
 2 PLG ±.003
 3 PLG ±.004
 4 PLG ±.005

M. YOUNGER
 G. BAILEY
 G. BAILEY
 END FEED HINGE BAR APPLICATOR

SCALE: NTS A1
 SIZE: A1
 DRAWING NO: 1852895
 SHEET 1 OF 1
 REV B

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TE CONNECTIVITY. IT IS TO BE KEPT SECRET AND NOT DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION OF TE CONNECTIVITY.