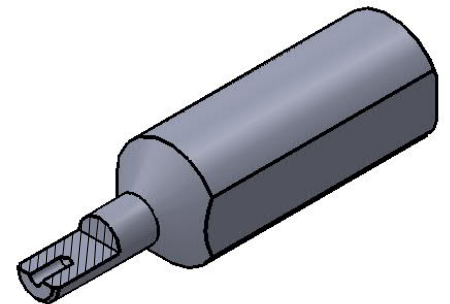
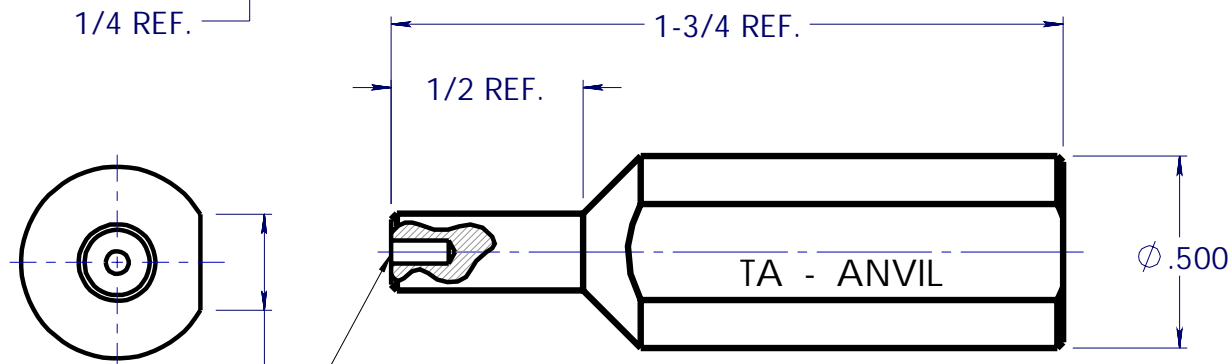
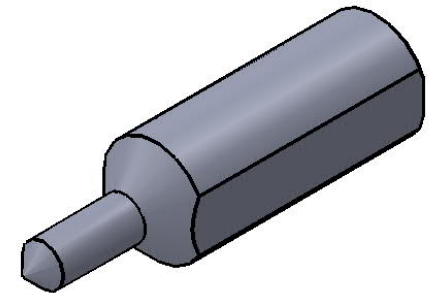
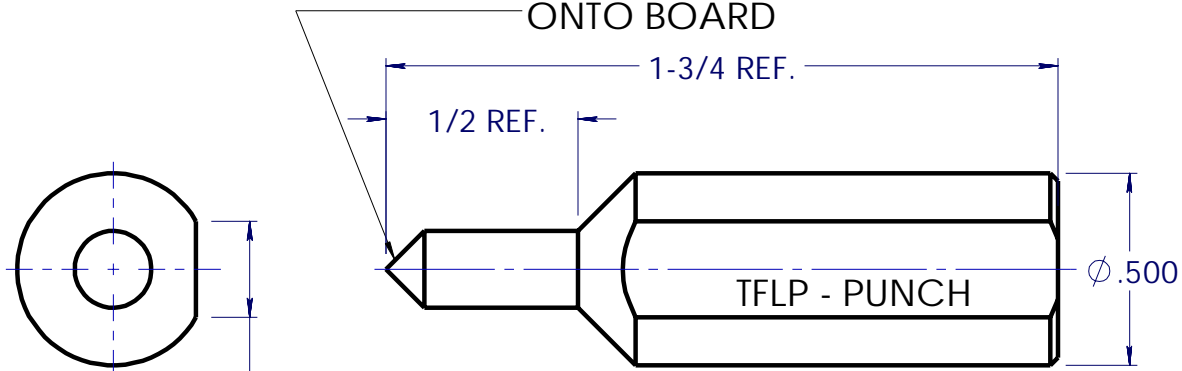


MATERIAL
OIL DRILL ROD

REV.	DESCRIPTION	DATE	DR.	APVD.
A	ISSUED	04/23/2019	YS	DS

UPPER TOOL (FLARE PUNCH) IS
DESIGNED TO PROPERLY
INSTALL TERMINAL
ONTO BOARD



LOWER TOOL (ANVIL) IS
DESIGNED TO HOLD
TERMINAL IN PROPER
POSITION DURING
INSTALLATION OPERATION

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

THREE PLACE DECIMAL ±0.010
FRACTIONAL ±1/64

PROPRIETARY AND CONFIDENTIAL

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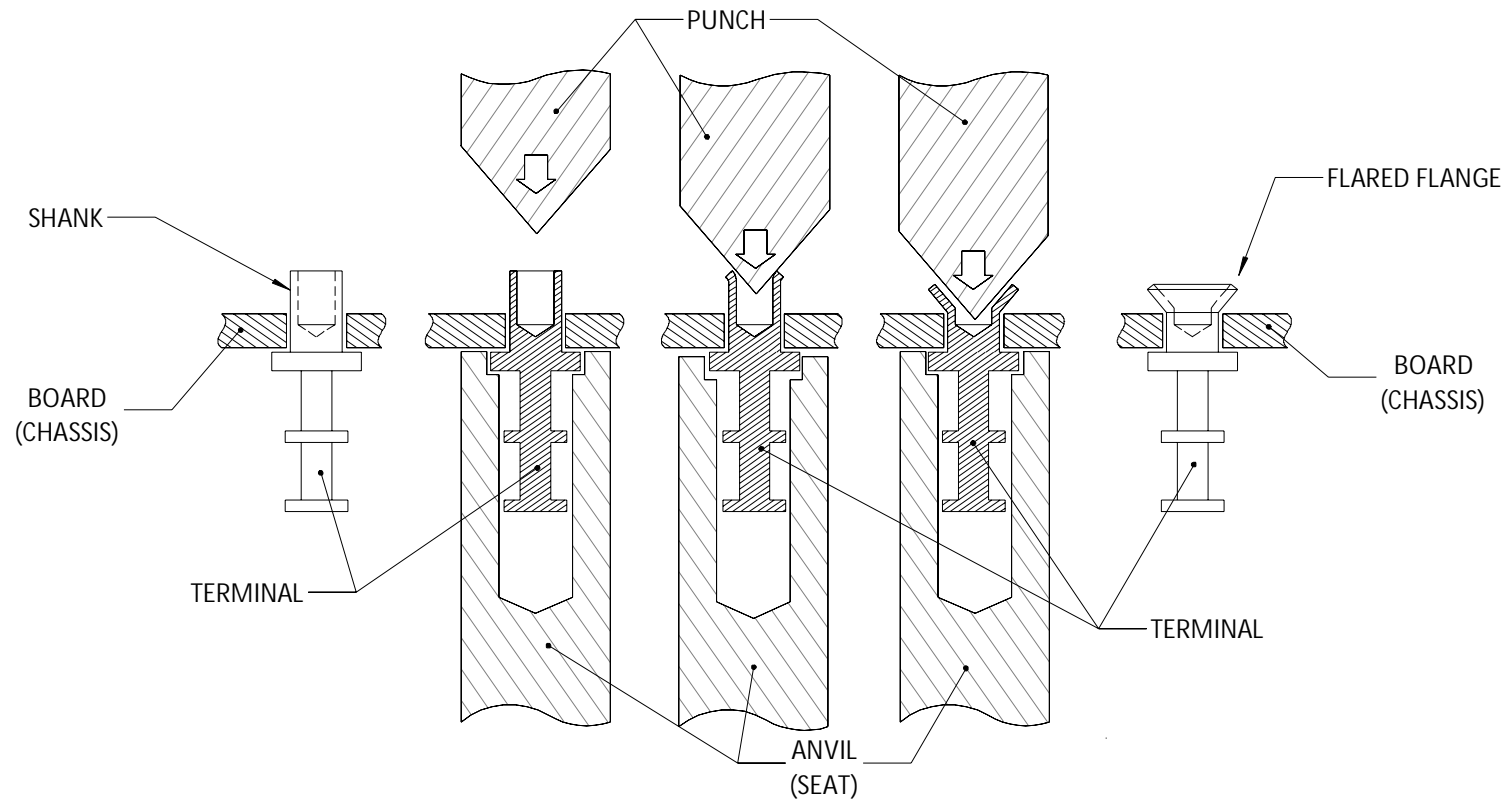


TITLE:
GENERIC DRAWING OF INSTALLATION
TOOLS FOR FLARE SWAGING (TA & TFLP
TYPES), ARBOR PRESS OPERATED

DWG. NO.	REV
TA & TFLP	A

REV.	DESCRIPTION	DATE	DR.	APVD.
A	ISSUED	04/23/2019	YS	DS

FLARE (V-FUNNEL) SWAGE INSTALLATION PROCEDURE FOR TERMINALS



1. THE "FLARE" SWAGE IS ALSO KNOWN AS THE "V-FUNNEL" SWAGE. THE FLARE SWAGING OPERATION FORMS THE LIPS OF THE SHANK INTO A FUNNEL SHAPE. THE TOOL THAT DOES THE ACTUAL FORMING IS CALLED THE "FLARE PUNCH". THE TOOL THAT SUPPORTS THE TERMINAL WHILE SWAGING IS BEING DONE IS CALLED THE "ANVIL" (ALSO SOMETIMES CALLED THE "SEAT").
2. PLACE PROPER CONCORD'S ANVIL AND PUNCH INTO ARBOR PRESS AND ALIGN TOOLS PRIOR SWAGE FORCE.
3. FIRST DRILL A HOLE IN THE BOARD THAT IS JUST LARGE ENOUGH FOR THE SHANK OF THE TERMINAL TO PASS THROUGH, BUT NOT LARGE ENOUGH FOR THE SHOULDER TO PASS THROUGH (SEE INDIVIDUAL PART SPECIFICATIONS FOR RECOMMENDED HOLE SIZE).
4. PLACE A TERMINAL INTO THE ANVIL AND BOARD AS SHOWN.
5. PRESS TERMINAL USING PUNCH TOOL UNTIL LIP OF SHANK, WHICH EXTENDS PASSED THE FACE OF THE BOARD IS FORMED TO FUNNEL SHAPE.
6. RAISE THE PUNCH TOOL. TERMINAL IS NOW PERMANENTLY IN PLACE.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

THREE PLACE DECIMAL ± 0.010
FRACTIONAL $\pm 1/64$

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TITLE:

GENERIC DRAWING OF INSTALLATION TOOLS FOR FLARE SWAGING (TA & TFLP TYPES), ARBOR PRESS OPERATED

DWG. NO.

TA & TFLP

REV

A



PAGE: 2 OF 2

SCALE: NTS