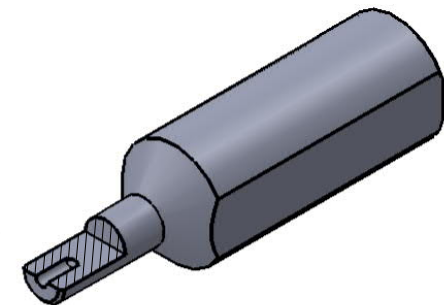
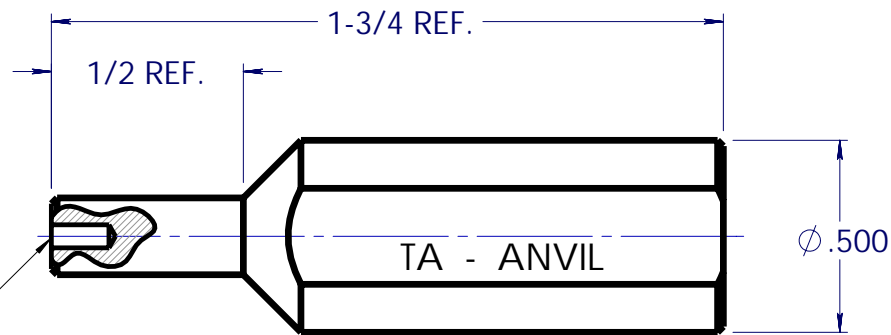
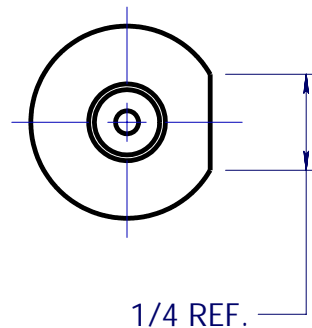
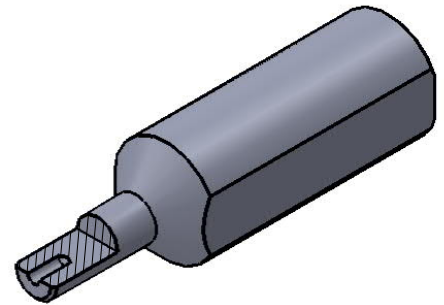
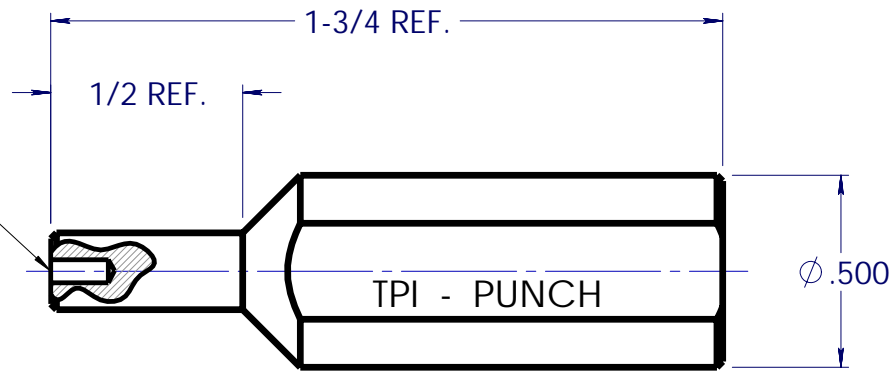
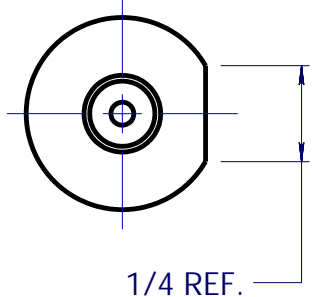


MATERIAL
OIL DRILL ROD

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

UPPER TOOL (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**

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF CONCORD ELECTRONICS INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF CONCORD ELECTRONIC INC. IS PROHIBITED.

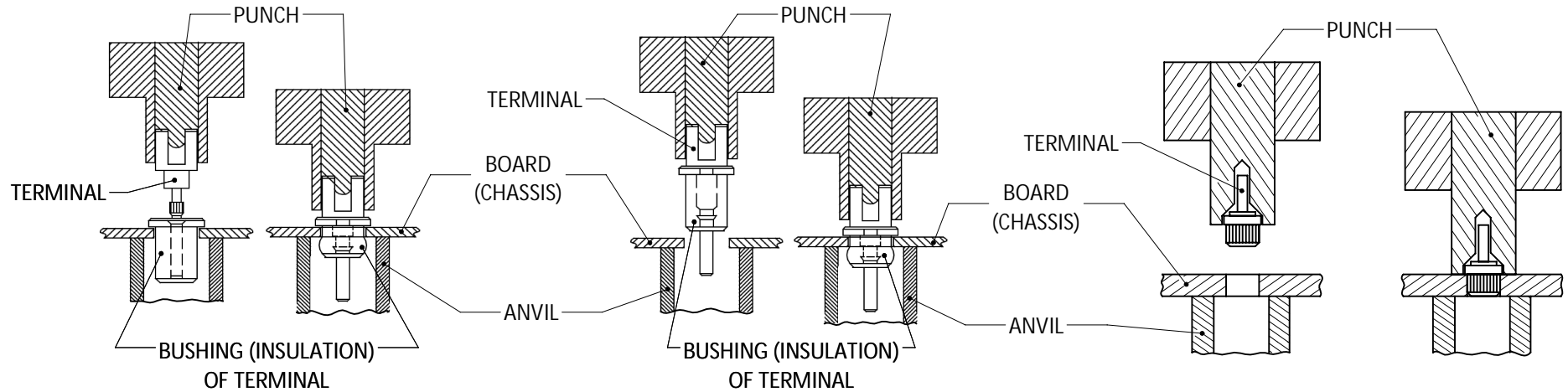


TITLE:  
GENERIC DRAWING OF INSTALLATION TOOLS FOR PRESS LOCK AND PRESS FIT (TA & TPI TYPES), ARBOR PRESS OPERATED

DWG. NO. TA & TPI REV A

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

## PRESS LOCK AND PRESS FIT INSTALLATION PROCEDURES FOR TERMINALS



### PRESS LOCK FOR INSULATED TERMINALS (UNASSEMBLED AND PARTIALLY ASSEMBLED):

1. DRILL THROUGH-HOLE AND COUNTERSINK BOARD ACCORDING TO BOARD THICKNESS AND TERMINAL SPEC SHEET RECOMMENDATIONS.
2. PLACE PROPER CONCORD'S ANVIL AND PUNCH INTO ARBOR PRESS AND ALIGN TOOLS PRIOR INSERTION FORCE.
3. SLIP BUSHING THROUGH CHASSIS HOLE UNTIL SHOULDER OF BUSHING IS PROPERLY SEATED ON BOARD SURFACE.
4. PRESS METAL TERMINAL USING PUNCH TOOL INTO CENTER OF BUSHING HOLE UNTIL TERMINAL IS FULLY LOCKED WITH A BOARD. PRESSURE BY INSERTION TOOL ON ASSEMBLED TERMINAL WILL LOCKS INSULATION BY EXPANDING OUTSIDE DIAMETER OF BUSHING AND REDUCING DIAMETER OF BUSHING HOLE.
5. RAISE THE PUNCH TOOL FROM INSTALLED TERMINAL WHICH IS NOW PERMANENTLY IN PLACE.

### PRESS FIT FOR INSULATED TERMINALS (ASSEMBLED):

1. DRILL THROUGH-HOLE AND COUNTERSINK BOARD ACCORDING TO BOARD THICKNESS AND TERMINAL SPEC SHEET RECOMMENDATIONS.
2. PLACE PROPER CONCORD'S ANVIL AND PUNCH INTO ARBOR PRESS AND ALIGN TOOLS PRIOR INSERTION FORCE.
3. CENTER CHASSIS HOLE AND PUNCH WITH A TERMINAL.
4. PRESS TERMINAL INTO BOARD HOLE UNTIL SHOULDER OF BUSHING IS FULLY SEATED AGAINST BOARD. PRESSURE BY INSERTION TOOL ON ASSEMBLED TERMINAL WILL LOCKS INSULATION BY EXPANDING OUTSIDE DIAMETER OF BUSHING AND REDUCING DIAMETER OF BUSHING HOLE.
5. RAISE THE PUNCH TOOL FROM INSTALLED TERMINAL WHICH IS NOW PERMANENTLY IN PLACE.

### PRESS FIT FOR NON-INSULATED TERMINALS:

1. DRILL THROUGH-HOLE AND COUNTERSINK BOARD ACCORDING TO BOARD THICKNESS AND TERMINAL SPEC SHEET RECOMMENDATIONS.
2. PLACE PROPER CONCORD'S ANVIL AND PUNCH INTO ARBOR PRESS AND ALIGN IT PRIOR INSERTION FORCE.
3. CENTER PUNCH WITH A PART AND A CHASSIS HOLE.
4. PRESS PART INTO CHASSIS HOLE.
5. RAISE THE PUNCH TOOL FROM INSTALLED TERMINAL.
6. SOLDERING CAN BE PROCEED UPON REQUEST

#### UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

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

#### PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF CONCORD ELECTRONICS INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF CONCORD ELECTRONIC INC. IS PROHIBITED.



TITLE:  
GENERIC DRAWING OF INSTALLATION  
TOOLS FOR PRESS LOCK AND PRESS FIT  
(TA & TPI TYPES), ARBOR PRESS  
OPERATED

DWG. NO.

TA & TPI

REV

A



PAGE: 2 OF 2

SCALE: NTS