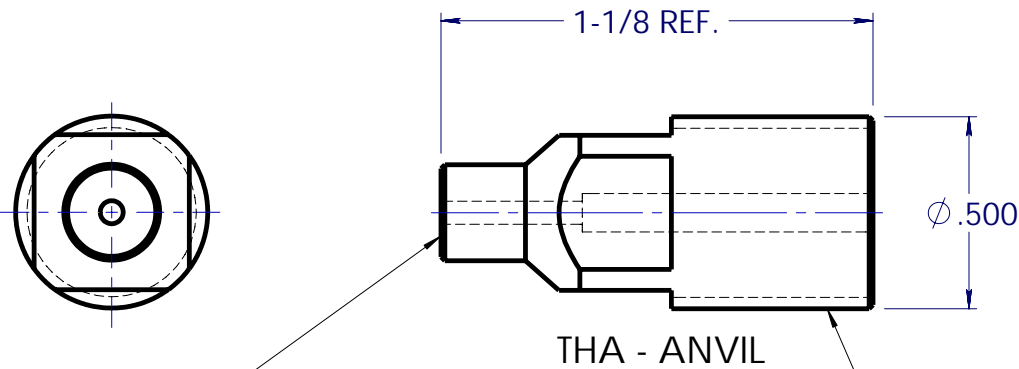
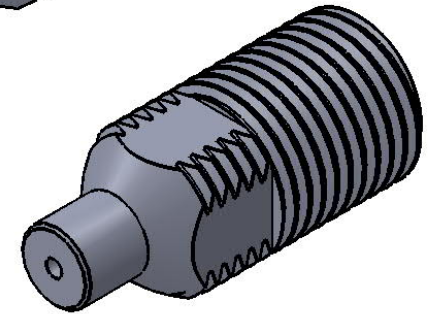
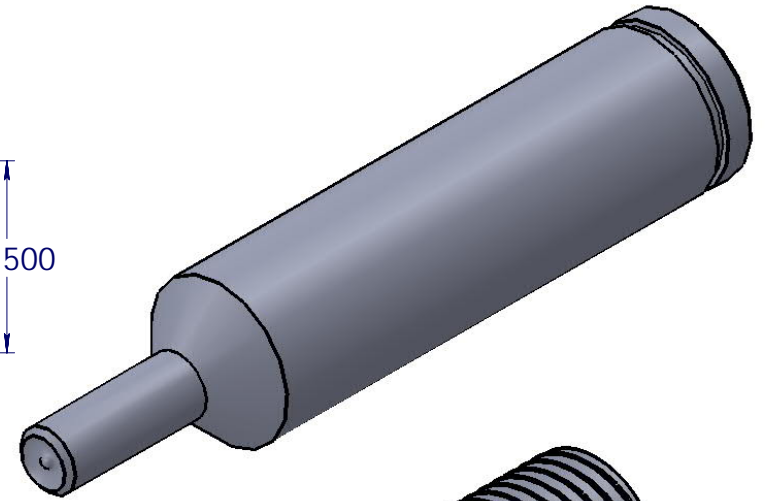
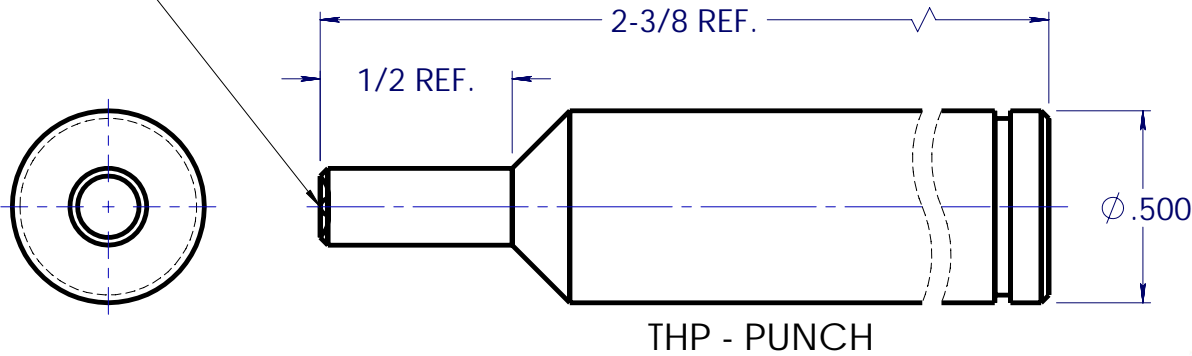


MATERIAL	REV.	DESCRIPTION	DATE	DR.	APVD.
OIL DRILL ROD	A	ISSUED	04/23/2019	YS	DS

UPPER TOOL (SNAP-IN ROLL PUNCH)
IS DESIGNED TO PROPERLY
INSTALL TERMINAL
ONTO BOARD



1/2-24 THREAD

LOWER TOOL (THREADED 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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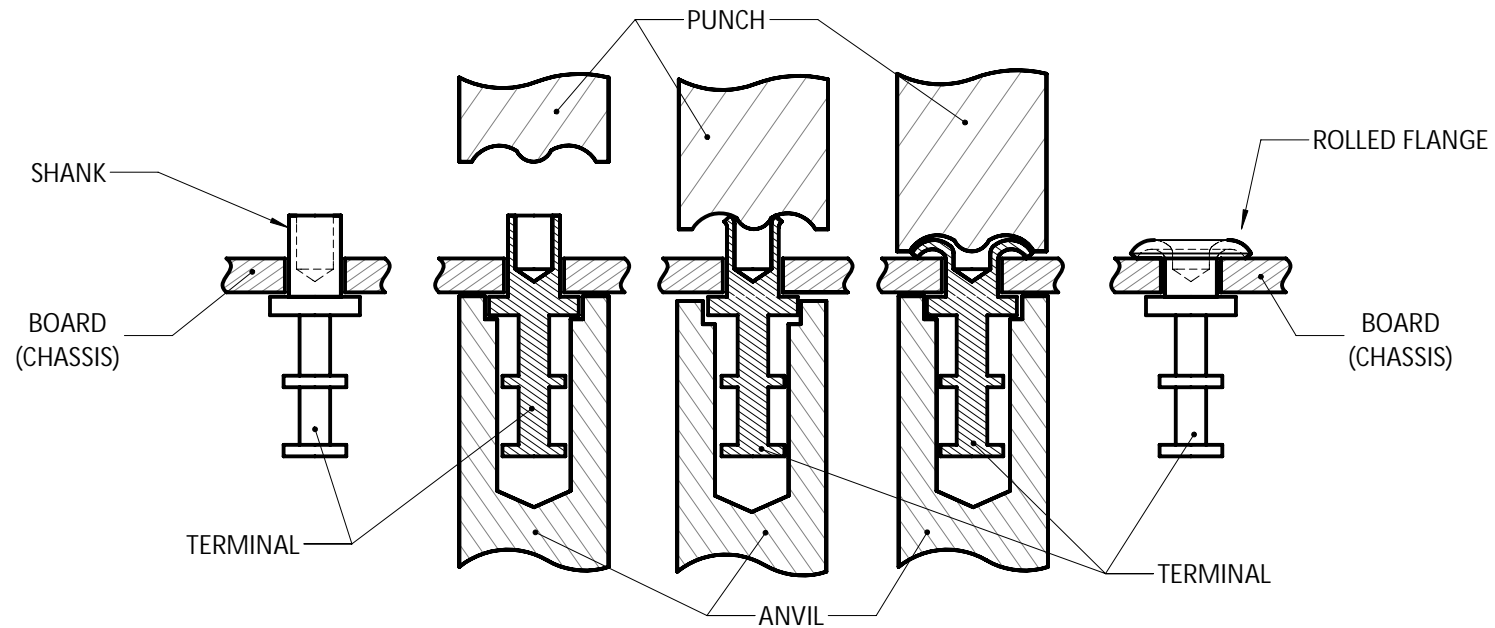


TITLE:
GENERIC DRAWING OF INSTALLATION
TOOLS FOR ROLL SWAGING (THA & THP
TYPES), ARBOR PRESS OPERATED

DWG. NO. **THA & THP** REV **A**

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

ROLL SWAGE INSTALLATION PROCEDURE FOR TERMINALS



1. THE NAME , "ROLL SWAGE" FAIRLY WELL DESCRIBES WHAT IS HAPPENING TO THE PART. THE LIP OF THE SHANK, WHICH EXTENDS PASSED THE FACE OF THE BOARD, IS ROLLED OVER AND BACK DOWN ONTO THE FACE OF THE BOARD AS SHOWN. THE TOOL THAT DOES THE ACTUAL FORMING IS CALLED THE "ROLL 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. 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 ROLL 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 ROLL SWAGING (THA & THP TYPES), ARBOR PRESS OPERATED

DWG. NO.

THA & THP

REV

A



PAGE: 2 OF 2

SCALE: NTS