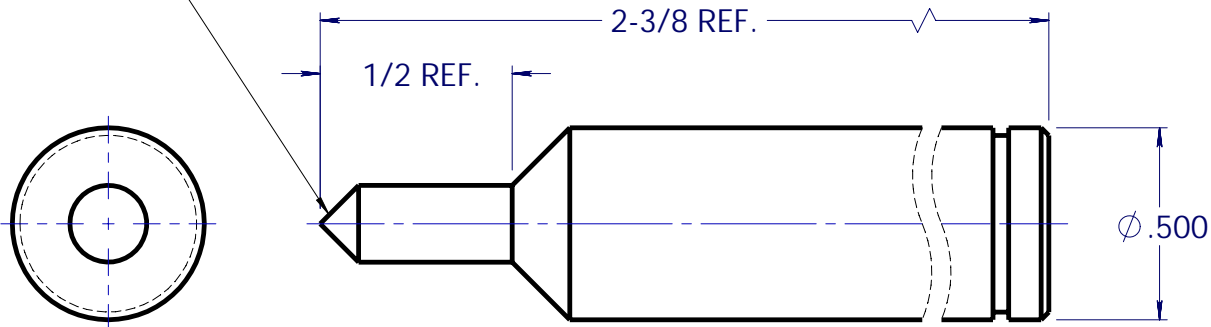
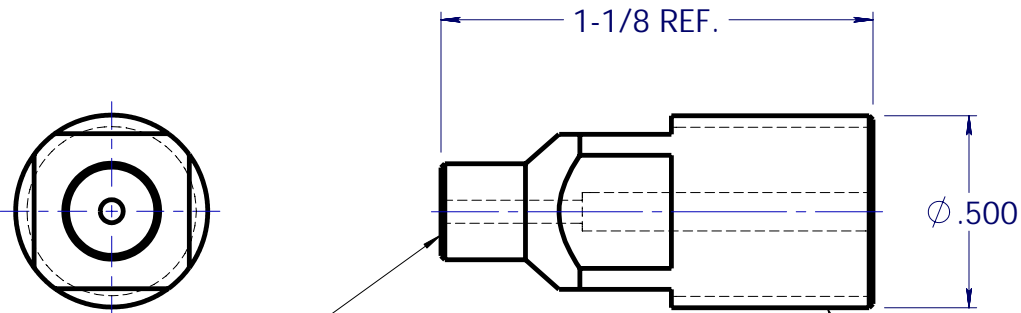
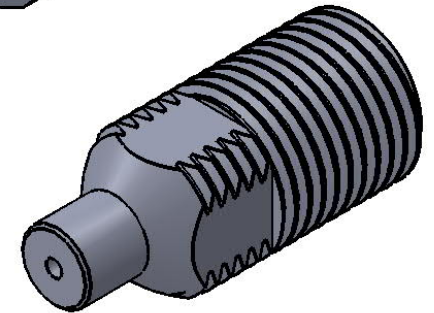
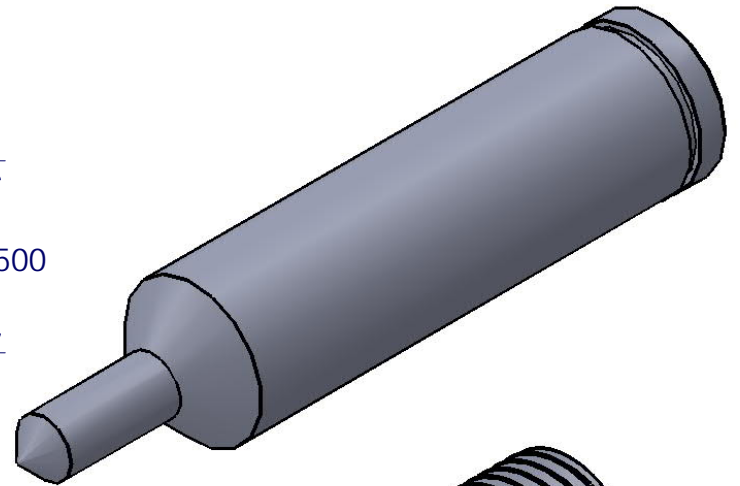


MATERIAL	REV.	DESCRIPTION	DATE	DR.	APVD.
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UPPER TOOL (SNAP-IN FLARE PUNCH)
IS DESIGNED TO PROPERLY
INSTALL TERMINAL
ONTO BOARD



THFLP - PUNCH



THA - ANVIL

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 FLARE SWAGING (THA &
THFLP TYPES), ARBOR PRESS OPERATED

DWG. NO.

THA & THFLP

REV

A

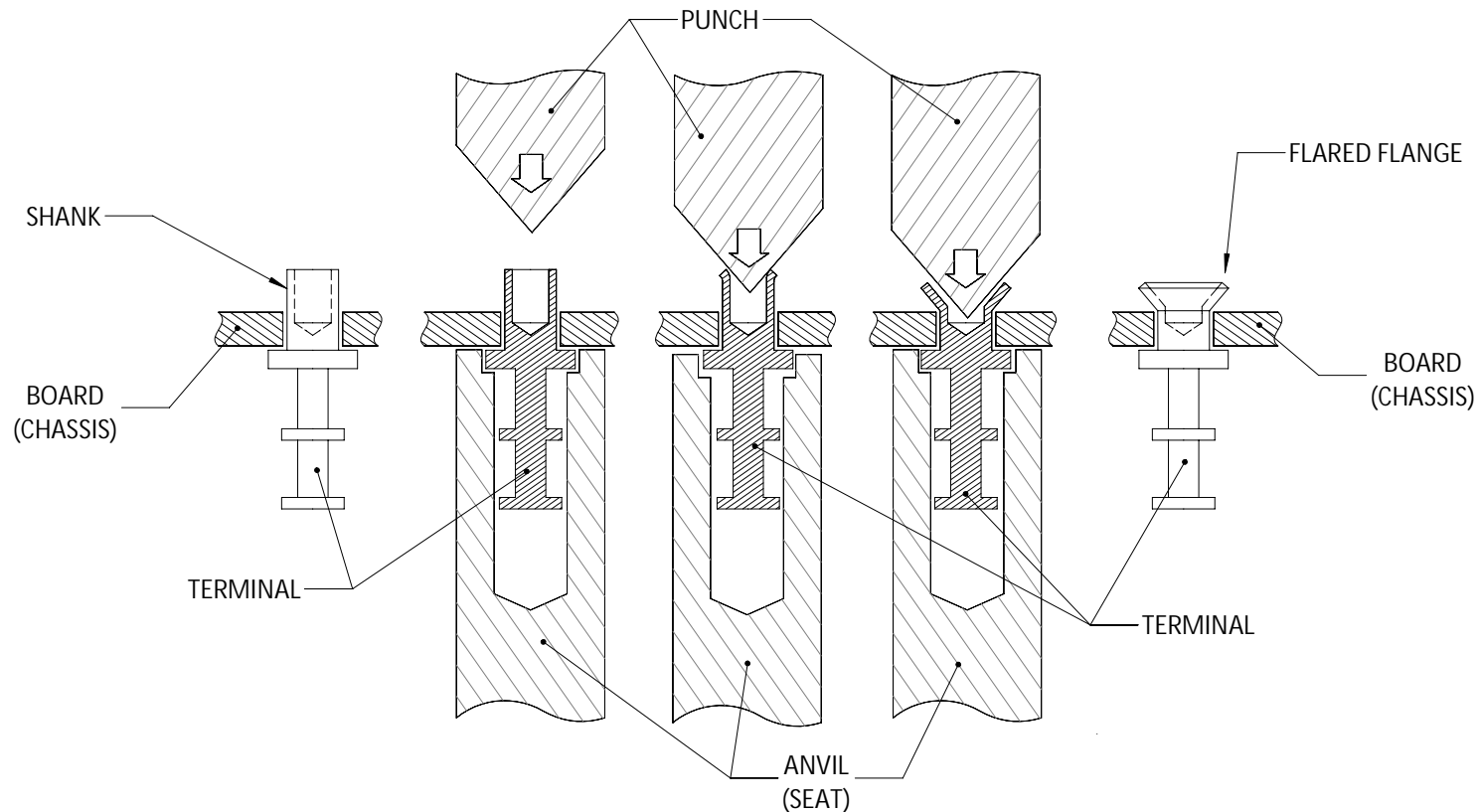


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SCALE: NTS

REV.	DESCRIPTION	DATE	DR.	APVD.
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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 (THA & THFLP TYPES), ARBOR PRESS OPERATED

DWG. NO.

THA & THFLP

REV

A



PAGE: 2 OF 2

SCALE: NTS