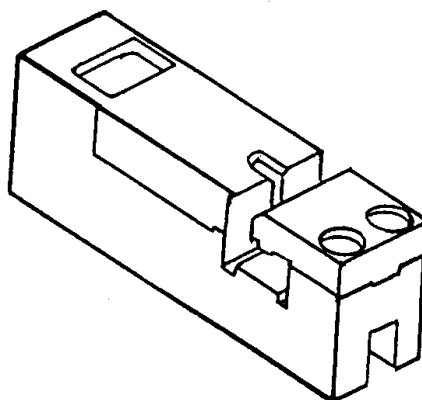




CHANGEHEAD PART No. 69008-0270



DESCRIPTION

Changehead for terminating Molex product Eng No 6952 onto pre cut discrete wire.

FEATURES

1. Fits onto pistol 69008-0949.
2. Internal indexing mechanism.
3. Designed for prototype, small batch and field repair applications only.

SPECIFICATION

SIZE: 80mm x 37mm x 33mm

WEIGHT: 0.1Kg

MATL: Plastic Construction



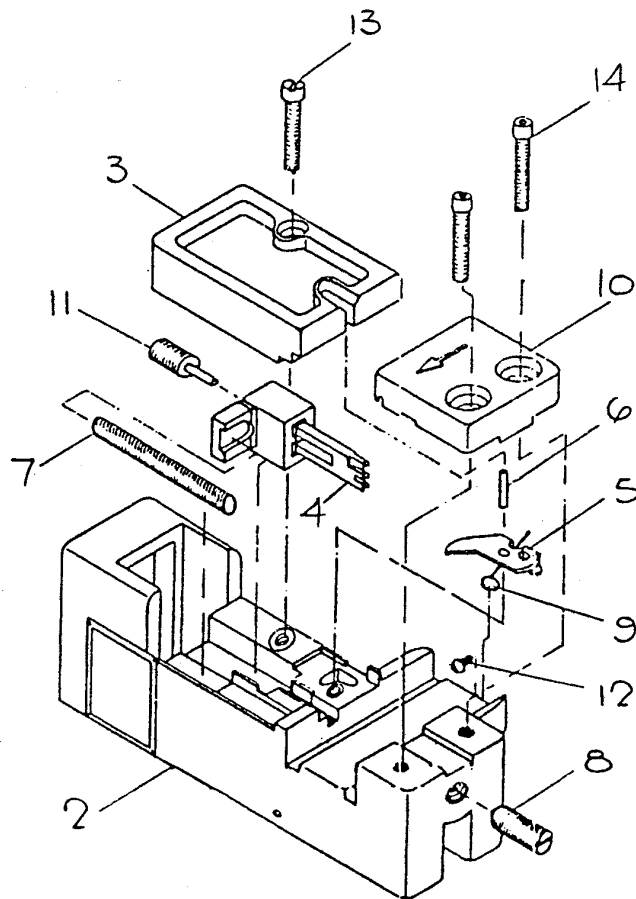
OPERATION PROCEDURE

1. Slide changehead onto pistol (69008-0949).
2. Place connector on protruding track and push into tool.
3. Operate pistol and index connector into changehead.
4. Place wire into slot (above connector) and fully insert.
5. Operate pistol to insert wire.
6. Repeat 4, 5 above until connector is fully loaded.
7. Insert next connector and repeat 3, 4 and 5 above.

MAINTENANCE PROCEDURE

1. Keep changehead clean at all times.
2. Look into track at index and termination punch if dirty or contains any plastic particles, then clean using a brush or similar.

DRAWING SHOWING SPARE PARTS



<u>Item</u>	<u>Part No.</u>	<u>Description</u>
1	69008-0270	Changehead (Full Assembly)
2	69008-0271	Body Moulding
3	69008-0272	Cover Plate
4	69008-0243	Insertor Block
5	69008-0244	Feed Lever
6	69008-0230	Pivot Pin
7	69008-0231	Spring Feed
8	69008-0245	Spring - Ball Screw
9	69008-0233	Spring
10	69008-0246	Guide Plate
11	69008-0247	Adjusting Screw

ADJUSTMENTS

TERMINATION DEPTH

1. To adjust termination depth of wire, remove the changehead from the pistol.
2. Looking into the mounting slot, a set screw can be seen.
3. By rotating this set screw, the termination depth can be changed.
 - Clockwise to increase wire depth
 - Anticlockwise to decrease wire depth

FRONT TRACK

The two fixing screws on the front track offer a small amount of track adjustment. This should be adjusted if the connector does not run smoothly through the track.

CONNECTOR LOCATOR

The small slotted screw in the base track is used to adjust the connector locator.

This is factory set and should not require adjustment.

PISTOL 69008-0949

This tool is factory set to give a stroke of 11.7mm and does not need adjusting.

QUALITY

Check termination quality against the Molex wire termination specification for relevant product being terminated eg: PS-17933 etc.

A quality procedure should be in place to monitor output from this changehead.

SAFETY

This changehead should be used in accordance with the operation procedure. Any misuse may cause injury to operator. Suitable training should be given to indicate good working practice.