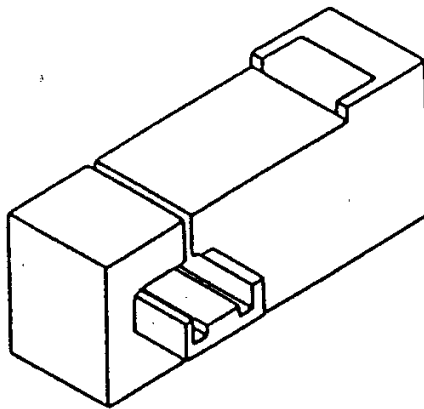




## **CHANGEHEAD PART No. 69008-0225**



### **DESCRIPTION**

Changehead for terminating Molex products Eng Nos. 7720; 7720S; 7795 & 40555 onto pre cut discrete wire.

### **FEATURES**

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

### **SPECIFICATION**

SIZE: 80mm x 37mm x 33mm

WEIGHT: 0.1Kg

MATL: Plastic Construction

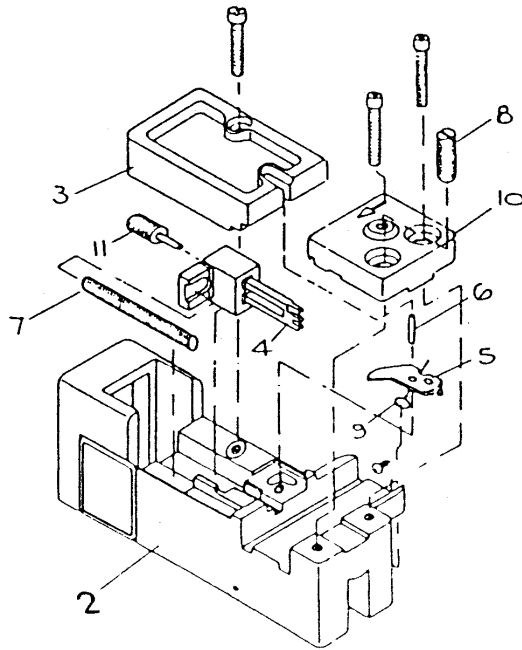
## OPERATION PROCEDURE

1. Slide changehead onto pistol (69008-0949).
2. Place connector on protruding track, compress pistol handle and slide connector into changehead until it stops, release handle.
3. Operate pistol to 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 terminated.
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 positions, if dirty or contains any plastic particles, then clean using a brush or similar.

## EXPLODED VIEW



## PARTS LIST FOR CHANGEHEAD

<u>Item</u>	<u>Part No.</u>	<u>Description</u>
1	69008-0225	Changehead (Full Assembly)
2	69008-0226	Body Moulding
3	69008-0227	Cover Plate
4	69008-0228	Insertor Block
5	69008-0229	Feed Lever
6	69008-0230	Pivot Pin
7	69008-0231	Spring Feed
8	69008-0232	Spring - Ball Screw
9	69008-0233	Spring
10	69008-0234	Guide Plate
11	69008-0235	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

### GUIDE PLATE (ITEM 10)

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

### CONNECTOR LOCATOR

The small slotted screw (item 8) in the guide plate 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: PSX-7720-WT.

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.