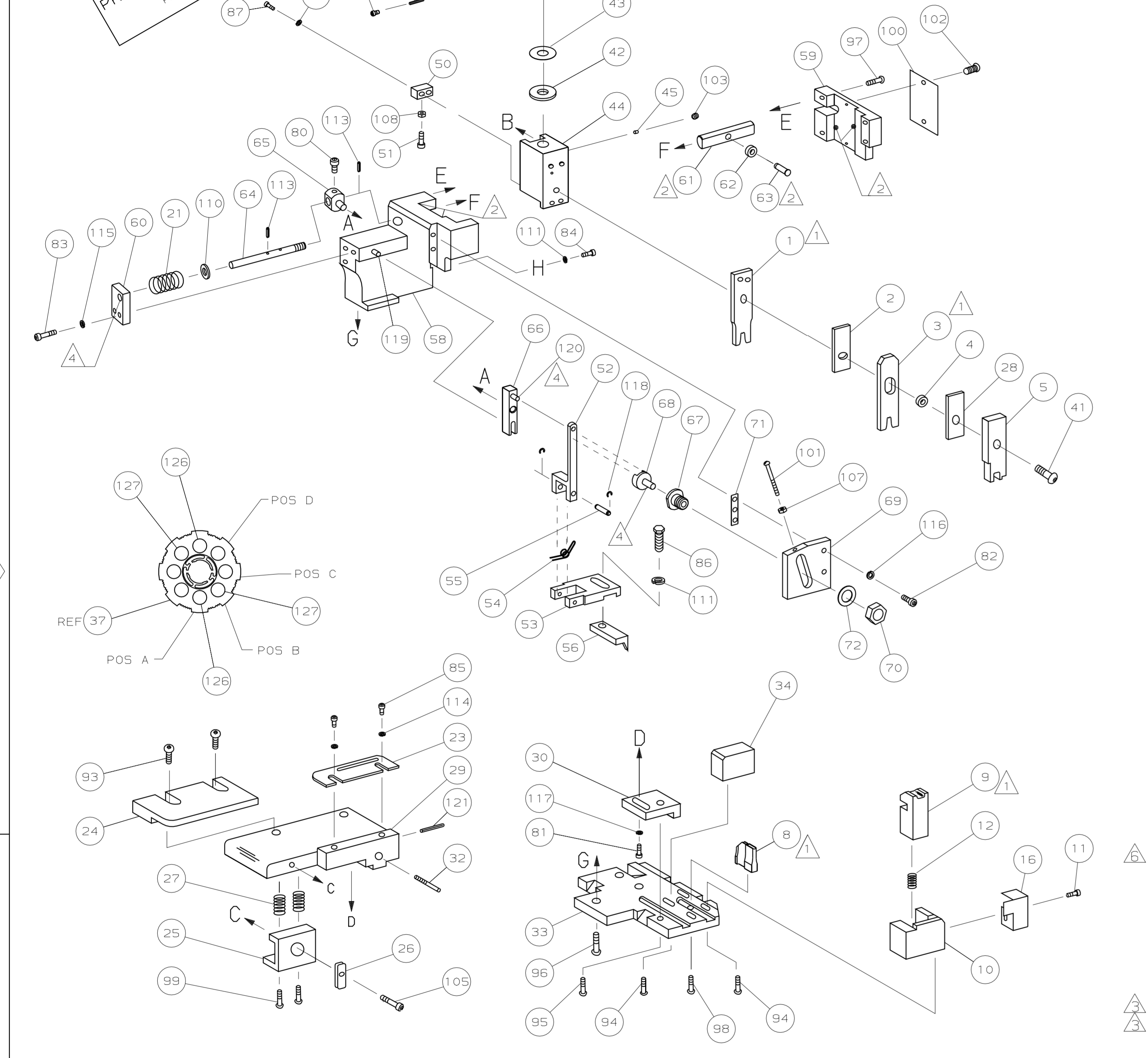
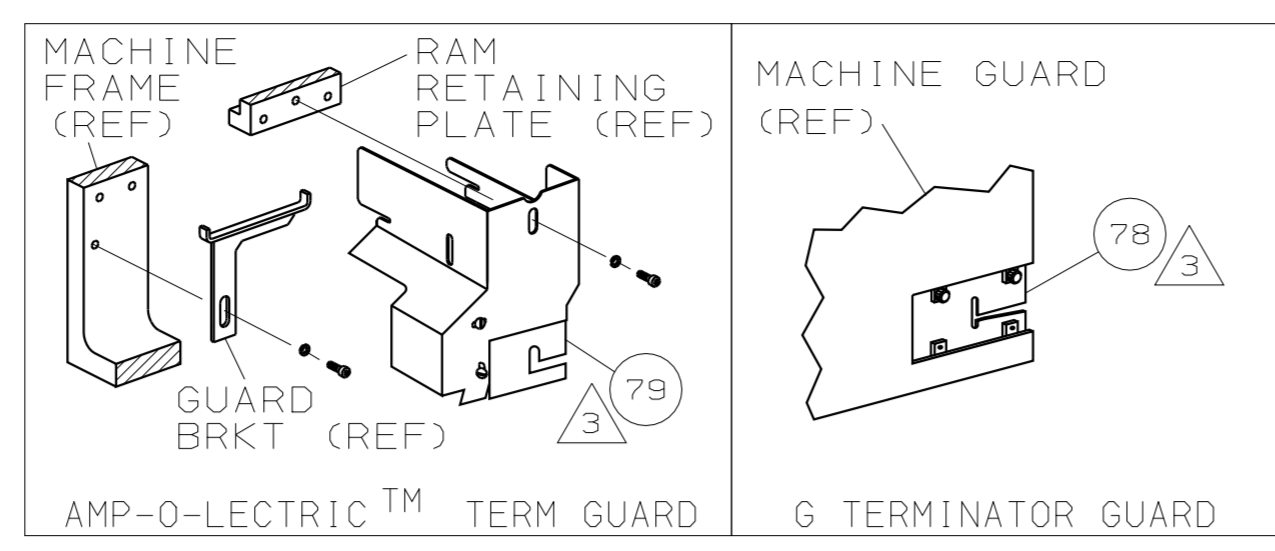


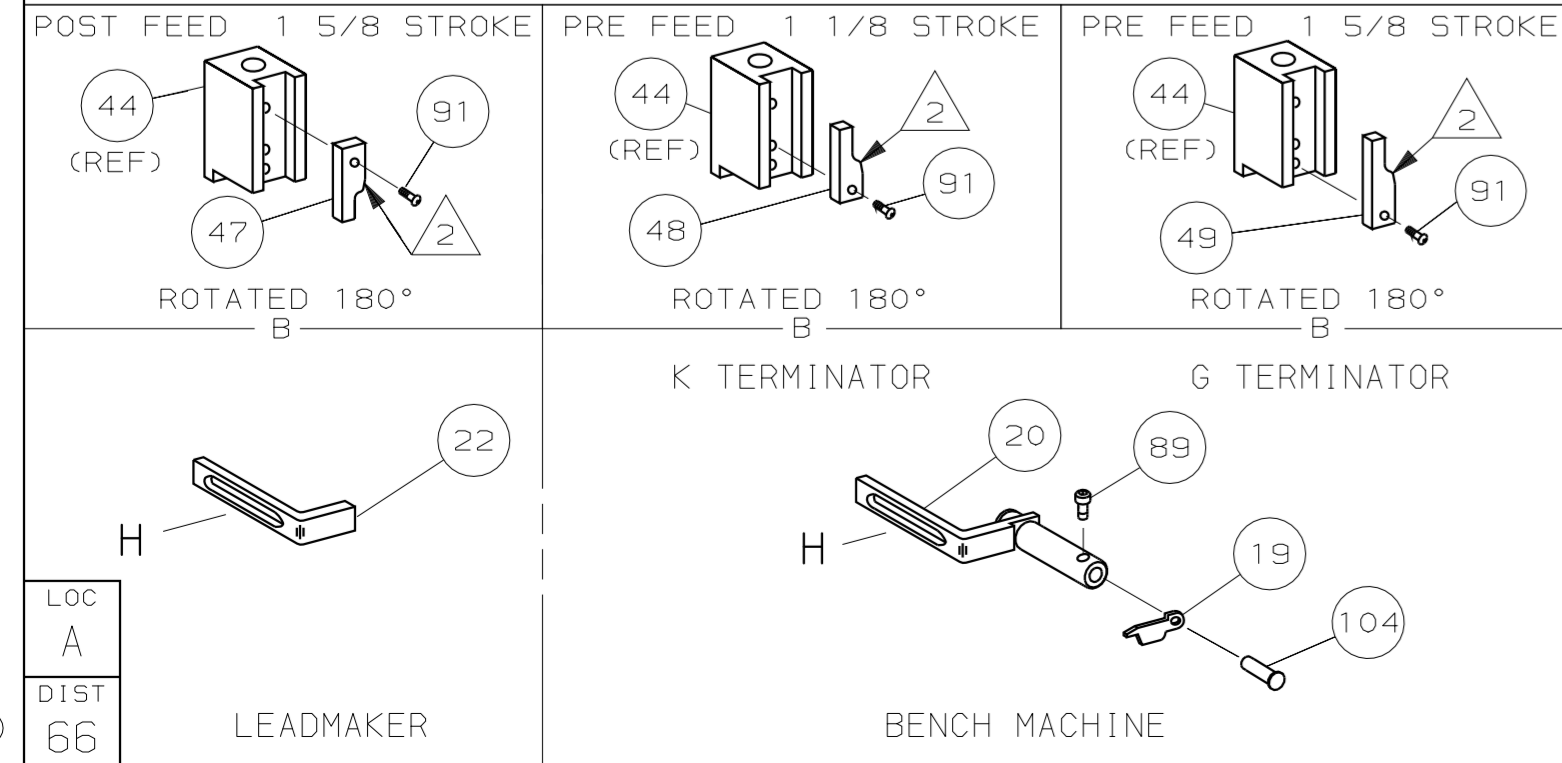
PART NUMBER	REV	FIRST USED
1852043-1	0	122500-1
1852043-2	0	565435-5
1852043-3	0	354500-1

**PROTOTYPE DESIGN**  
NOT RELEASED FOR PRODUCTION



TERMINAL NAME: METRI-PACK, 280 SERIES					
286516		CRIMPING DATA			
AMP	MFG	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
		A	1.19 ±0.05 [.047 ±.002IN]	0.5mm <sup>2</sup>	
		B	1.09 ±0.05 [.043 ±.002IN]	0.35mm <sup>2</sup>	
		C	NOT	USED	
D	NOT	USED			
		CRIMP	SIZE	TYPE	RANGE
WIRE	1.91 [.075 IN]	F	0.35-0.5mm <sup>2</sup>		
INSUL	2.44 [.096 IN]	F	1.47-2.19		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
5.21-5.97	NONE	16.26	408-8040	458637-1	L1819

PARTS LIST									
QTY	REF	REF	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
129									
2	2	2	-	C		3-354779-6	PIN, WIRE DISC (.3170)B	127	
2	2	2	-	C		2-354779-8	PIN, WIRE DISC (.3130)A	126	
1	1	1	-	A		986950-1	WASHER, FLAT PRECISION	125	
1	1	1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124	
1	1	1	-	-		4088040	SF APPL INST 408-8040	123	
								122	
1	1	1	-	A		4-21028-0	PIN,SLT SPR(φ.093x.75)ST GDE PL	121	
REF	REF	REF	-	A		1-21030-1	PIN,DOWEL (φ.187x.50)LEVER	120	
REF	REF	REF	-	A		1-21030-6	PIN,DOWEL (φ.187x1.25)HOUSING	119	
REF	REF	REF	-	A		21045-3	RING,RET "C"(φ.187)FD FING PIN	118	
1	1	1	-	A		21024-5	WASHER, LOCK (#10)ADJ BLOCK	117	
REF	REF	REF	-	A		21024-5	WASHER,LOCK (#10)ADJ PLATE	116	
REF	REF	REF	-	A		21024-5	WASHER,LOCK (#10)FEED GDE ROD	115	
2	2	2	-	A		21024-2	WASHER,LOCK (#4)FRONT STP GUIDE	114	
REF	REF	REF	-	A		5-21028-1	PIN,SLT SPR(φ.125x.50)ADJ ROD	113	
								112	
4	4	4	-	A		21024-4	WASHER,LOCK (#8)STRIPPER	111	
REF	REF	REF	-	A		21899-4	WASHER,FLAT (φ5/16)SCREW ADJ	110	
								109	
1	1	1	-	A		21018-5	NUT, HEX (NO. 6)HOLDDOWN	108	
REF	REF	REF	-	A		21018-5	NUT, HEX (6-32)FEED ADJ	107	
								106	
1	1	1	-	A		22353-8	SCR,SHLD (φ.187x.25)DRAG LEVER	105	
1	1	-	-	A		992031-1	PIN, CLEVIS	104	
1	1	1	-	A		21009-2	SCR,SKT SET (1/4-20x.25 LW)RAM	103	
2	2	2	-	A		21017-2	SCR,DRIVE (#2x.19)ID PLATE	102	
REF	REF	REF	-	A		6-23715-5	SCR,PAN HD (6-32x1.50)FEED ADJ	101	
1	1	1	-	B		461264-1	PLATE, IDENTIFICATION	100	
2	2	2	-	A		3-21002-0	SCR,BHC (10-32x.88)DRAG	99	
1	1	1	-	A		22733-8	SCR,BHC (8-32x.38 LW)ANVIL	98	
REF	REF	REF	-	A		2-21002-9	SCR,BHC (10-32x.75)CAP	97	
REF	REF	REF	-	A		2-22733-8	SCR,BHC (1/4-20x.62)HOUSING	96	
REF	REF	REF	-	A		2-21002-7	SCR,BHC (10-32x.50)SG ADJ BLOCK	95	
4	4	4	-	A		2-21002-2	SCR,BHC (8-32x.50)TERM H DWN	94	
2	2	2	-	A		2-21002-3	SCR,BHC (8-32x.62)R STP GDE	93	
								92	
1	1	1	-	A		1-21002-7	SCR,BHC (6-32x.38)CAM	91	
								90	
1	1	-	-	A		7-21000-9	SCR,SHC (4-40x.19)STRIPPER	89	
								88	
2	2	2	-	A		2-21000-7	SCR,SHC (8-32x.48)DEP-HOLD	87	
1	1	1	-	A		2-22603-0	SCR,HEX HD (8-32x.31)FEED FINGER	86	
2	2	2	-	A		1-21000-3	SCR,SHC (4-40x.25)F ST GUIDE	85	
1	1	1	-	A		2-21000-7	SCR,SHC (8-32x.50)STRIPPER	84	
REF	REF	REF	-	A		3-21000-7	SCR,SHC (10-32x.75)FEED ROD GD	83	
REF	REF	REF	-	A		3-21000-6	SCR,SHC (10-32x.62)FD ADJ BLK	82	
1	1	1	-	A		3-21000-4	SCR,SHC (10-32x.38)SG ADJ BL	81	
REF	REF	REF	-	A		3-21000-4	SCR,SHC (10-32x.38)PIVOT BLK	80	
-	REF	-	-	B		455749-1	GUARD, WINDOW	79	
REF	-	-	-	B		679532-1	INSERT, GUARD	78	
								77	
								76	
								75	
1	1	1	-	A		690603-1	SPRING, ASSIST	74	
1	1	1	-	A		23030-1	SCR,SHC (6-32x.25 SL)INS DISC	73	
REF	REF	REF	-	A		458109-1	WASHER, SPECIAL	72	
REF	REF	REF	-	A		690517-1	SPACER	71	



- ① RECOMMENDED SPARE PARTS.
- ② GREASE LIGHTLY.
- ③ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- ④ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ⑤ ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- ⑥ CUT TO LENGTH AT ASSY

PARTS LIST									
QTY	REF	REF	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
-1	LEADMAKER	MECH	POST FEED						
-2	BENCH MODEL K	MECH	PRE FEED						
-3	BENCH MODEL G	MECH	PRE FEED						
REF	REF	REF	-	B		22594-8	NUT, HEX (1/2-20)	70	
REF	REF	REF	-	B		240628-1	PLATE, ADJUSTMENT	69	
REF	REF	REF	-	B		240626-1	SHAFT, PIVOT	68	
REF	REF	REF	-	B		240633-1	BUSHING	67	
REF	REF	REF	-	A		455680-1	LEVER, INTERMEDIATE	66	
REF	REF	REF	-	B		240629-1	BLOCK, PIVOT	65	
REF	REF	REF	-	A		240632-2	SCREW, ADJ FEED ROD	64	
REF	REF	REF	-	B		240659-3	PIN, CAM ROLLER	63	
REF	REF	REF	-	B		240658-1	ROLLER, CAM	62	
REF	REF	REF	-	B		454398-2	ROD, FEED	61	
REF	REF	REF	-	A		454178-1	GUIDE, FEED ROD	60	
REF	REF	REF	-	C		454220-1	CAP, RAM	59	
REF	REF	REF	-	D		454485-1	HOUSING	58	
								57	
1	1	1	-	B		1-694433-6	PAWL, FEED	56	
REF	REF	REF	-	B		240624-1	PIN, FEED FINGER	55	
REF	REF	REF	-	B		691499-1	SPRING, FEED FINGER	54	
REF	REF	REF	-	B		690541-1	HOLDER, FEED FINGER	53	
REF	REF	REF	-	A		455679-2	LEVER, TERMINAL FEED ARM	52	
1	1	1	-	A		811242-2	BUMPER, HOLDDOWN	51	
1	1	1	-	A		690753-1	SPACER, TONKER	50	
1	-	-	-	B		690602-6	CAM, PRE-FEED 1 5/8 ST	49	
-	1	-	-	B		690602-5	CAM, PRE-FEED 1 1/8 ST	48	
-	-	1	-	B		690501-4	CAM, POST-FEED 1 5/8 ST	47	
1	1	1	-	B		459456-2	APPLICATOR, BASIC (SUBASSY)	46	
1	1	1	-	A		690191-1	PLUG, NYLON	45	
1	1	1	-	C		455673-1	RAM	44	
1	1	1	-	A		690125-1	WASHER, LAMINATED	43	
1	1	1	-	A		690124-1	WASHER, RAM	42	
1	1	1	-	A		690686-1	BOLT, CRIMPER (5/16x1.00)	41	
1	1	1	-	A		23241-6	BALL, STEEL	40	
1	1	1	-	A		690170-1	SPRING, COMPRESSION	39	
1	1	1	-	C		690142-1	DISC, INSULATION	38	
1	1	1	-	D		354777-1	WIRE DISC, PLASTIC	37	
1	1	1	-	A		22480-5	WASHER, SPRING	36	
1	1	1	-	B		690212-1	POST, RAM	35	
1	1	1	-	B		690786-1	SUPPORT, TERMINAL	34	
REF	REF	REF	-	D		455675-1	PLATE, BASE	33	
1	1	1	-	A		690432-3	SCREW, ADJUSTMENT	32	
								31	
REF	REF	REF	-	B		455689-1	BLOCK, STRIP GUIDE ADJ	30	
1	1	1	-	C		3-458144-4	PLATE, STRIP GUIDE	29	
1	1	1	-	C		1-455888-6	SPACER, FRONT SHEAR DEP	28	
2	2	2	-	A		1-22284-0	SPRING, DRAG	27	
1	1	1	-	B		240793-1	LEVER, DRAG RELEASE	26	
1	1	1	-	B		240792-1	DRAG, TERMINAL	25	
1	1	1	-	D		1-90765-1	GUIDE, STRIP (REAR)	24	
1	1	1	-	A		690438-1	GUIDE, STRIP (FRONT)	23	
-	-	1	-	B		690472-2	STRIPPER	22	
REF	REF	REF	-	A		4-22284-9	SPRING, FEED RETURN	21	
1	1	-	-	A		679218-1	STRIPPER WIRE STOP ASSY	20	
1	1	-	-	B		458949-1	STRIPPER	19	
								18	
								17	
1	1	1	-	B		318563-1	GUARD, CHIP, FRONT	16	
								15	
								14	
								13	
1	1	1	-	A		5-22280-0	SPRING, SHEAR	12	
1	1	1	-	B		690461-1	STOP, SHEAR	11	
1	1	1	-	C		690459-1	HOLDER, SHEAR (FRONT)	10	
1	1	1	-	C		454276-1	SHEAR, FLOAT (FRONT)	9	
1	1	1	-	C		3-1424534-2	ANVIL	8	
								7	
								6	
1	1	1	-	C		1-455889-4	DEPRESSOR, SHEAR (FRONT)	5	
1	1	1	-	B		238011-4	SPACER, BLOCK CRIMPER	4	
1	1	1	-	C		5-1424909-2	CRIMPER, INSULATION	3	
1	1	1	-	C		2-455888-1	SPACER, CRIMPER	2	
1	1	1	-	C		1-1673600-8	CRIMPER, WIRE	1	

**REVISION RECORD**

P/F	LTR	REVISION	RECORD	APP	DATE

**DIMENSIONS IN INCHES. DO NOT SCALE PRINT.**  
TOLERANCES UNLESS OTHERWISE SPECIFIED:  
2 PLC DEC ±  
3 PLC DEC ±  
4 PLC DEC ±  
ANGLES ±  
SURF TEXTURE: ✓  
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL	HT TR	FIN
-	-	-

**AMP** Incorporated  
Harrisburg, PA 17105-3608

DR: C.ERISMAN  
CHK: 26APROS  
APP: T.ELBIN  
REL: -

NAME: **SIDE FEED HDM APPLICATOR**  
SCALE: -  
Dwg NO: **1852043**

MACHINE REF: MINI APPL  
SHEET: 1 OF 1  
REV: 0

CAGE CODE: 00779  
CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNRELEASABLE. RELEASE FOR PUBLICATION BY AMP INCORPORATED. ALL RIGHTS RESERVED.