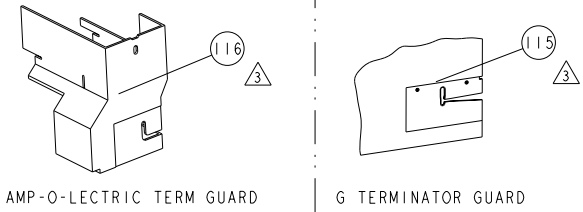
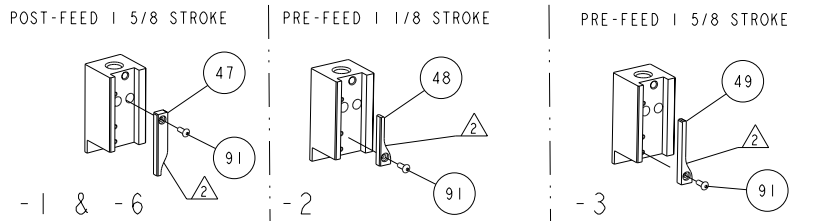
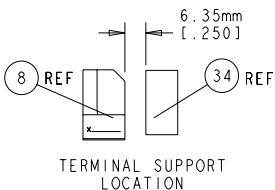
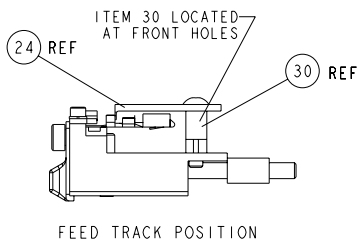
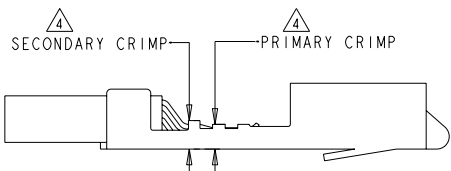


| 8                            |     | 7                                                     |               | 6         |                    | 5 |  | 4 |  | 3 |  | 2 |  | 1 |  |
|------------------------------|-----|-------------------------------------------------------|---------------|-----------|--------------------|---|--|---|--|---|--|---|--|---|--|
| THIS DRAWING IS UNPUBLISHED. |     | RELEASED FOR PUBLICATION                              |               | 20        |                    |   |  |   |  |   |  |   |  |   |  |
| COPYRIGHT 20                 |     | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |               |           |                    |   |  |   |  |   |  |   |  |   |  |
| PART NUMBER                  | REV | FIRST USED                                            | POWER UNIT    | FEED TYPE | DESCRIPTION        |   |  |   |  |   |  |   |  |   |  |
| 1855205-1                    | B   | 122500-1                                              | LEADMAKER     | POST FEED | CUTS CARRIER       |   |  |   |  |   |  |   |  |   |  |
| 1855205-2                    | B   | 565435-5                                              | BENCH MODEL K | PRE FEED  | CUTS CARRIER       |   |  |   |  |   |  |   |  |   |  |
| 1855205-3                    | B   | 354500-1                                              | BENCH MODEL G | PRE FEED  | CUTS CARRIER       |   |  |   |  |   |  |   |  |   |  |
| 1855205-6                    | B   | 122500-1                                              | LEADMAKER     | POST FEED | CONTINUOUS CARRIER |   |  |   |  |   |  |   |  |   |  |
| 7-1855205-7                  | A   | -                                                     | -             | -         | SPARE PARTS        |   |  |   |  |   |  |   |  |   |  |

- △ RECOMMENDED SPARE PARTS  
△ GREASE LIGHTLY  
△ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE  
△ PRIMARY CRIMP IS LISTED. SECONDARY CRIMP HEIGHT IS .009±.003 HIGHER THAN PRIMARY CRIMP HEIGHT.

• WARNING  
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



| TERMINAL NAME: METRI-PACK 280 |            |                                        |                             |                                  |             |
|-------------------------------|------------|----------------------------------------|-----------------------------|----------------------------------|-------------|
| TE PN                         | PACKARD PN | PACKARD TERMINAL - PACKARD CRIMP SPECS |                             |                                  |             |
| 283558-1                      | 12034046   |                                        |                             |                                  |             |
| 286558-2                      | 12015823   |                                        |                             |                                  |             |
| -                             | -          | △ CRIMP HEIGHT                         | WIRE SIZE                   | REF SETTING                      |             |
| -                             | -          | 1.55±0.05mm[.061±.002]                 | 1mm <sup>2</sup>            | A9                               |             |
| -                             | -          | 1.35±0.05mm[.053±.002]                 | 0.8mm <sup>2</sup> or 18AWG | D1                               |             |
| -                             | -          | 1.25±0.05mm[.049±.002]                 | 0.5mm <sup>2</sup> or 20AWG | D7                               |             |
| -                             | -          | -                                      | -                           | -                                |             |
| -                             | -          | CRIMP                                  | SIZE                        | TYPE                             | RANGE       |
| -                             | -          | WIRE                                   | 2.39mm [ .094 ]             | F                                | 0.5-1mm     |
| -                             | -          | INSUL                                  | 3.43mm [ .135 ]             | F                                | Ø 2.03-3.12 |
| -                             | -          | FEED                                   | 15.3mm                      | APPLICATOR INSTRUCTIONS 408-8040 |             |
| -                             | -          | WIRE STRIP LENGTH 5.2 -6mm             | TERM APPL SPEC NONE         | SET UP GAGE 458637-1             |             |

|   |   |   |     |     |   |    |            |                                       |     |
|---|---|---|-----|-----|---|----|------------|---------------------------------------|-----|
| △ | - | - | -   | REF | - | .. | 455749-1   | GUARD WINDOW                          | 116 |
| △ | - | - | REF | -   | - | .. | 679532-1   | INSERT, GUARD                         | 115 |
| - | 1 | 1 | 1   | 1   | - | -  | 1-21002-7  | SCR, BTN SKT HD CAP 6-32 X .375       | 91  |
| - | 1 | 1 | 1   | 1   | - | -  | 318563-1   | GUARD, FRONT CHIP                     | 89  |
| - | 1 | 1 | 1   | 1   | - | -  | 4088040    | SF APPL INST 408-8040                 | 72  |
| - | 1 | 1 | 1   | 1   | - | -  | 217238-1   | GENERAL INSTRUCTION PKG               | 71  |
| - | 1 | 1 | 1   | 1   | - | -  | 461264-5   | PLATE, IDENTIFICATION                 | 67  |
| - | 2 | 2 | 2   | 2   | - | -  | 21017-2    | SCREW, DRIVE                          | 66  |
| - | 1 | 1 | 1   | 1   | - | -  | 21009-2    | SCR, SET, SELF LOCKING 1/4-20 X .250  | 63  |
| - | 1 | 1 | 1   | 1   | - | -  | 22733-8    | SCR, BHSC, SELF-LOCKING, 8-32 X .375  | 60  |
| - | 1 | 1 | 1   | 1   | - | -  | 2-22603-0  | SCR, HEX HD CAP 8-32 X .312           | 59  |
| - | 1 | 1 | 1   | 1   | - | -  | 458537-2   | PAWL, FEED                            | 56  |
| - | 4 | 4 | 4   | 4   | - | -  | 2-21002-2  | SCR, BTN SKT HD CAP 8-32 X .500       | 54  |
| - | 2 | 2 | 2   | 2   | - | -  | 2-21000-7  | SCR, SKT HD CAP 8-32 X .500           | 53  |
| - | 1 | 1 | 1   | 1   | - | -  | 21018-5    | NUT, HEX, REG 6-32                    | 52  |
| - | 1 | 1 | 1   | 1   | - | -  | 811242-2   | BUMPER, HOLD DOWN                     | 51  |
| - | 1 | 1 | 1   | 1   | - | -  | 690753-1   | SPACER, TONKER                        | 50  |
| - | - | - | -   | -   | - | .. | 690602-6   | CAM, PRE FEED, 1 5/8                  | 49  |
| - | - | - | -   | -   | - | .. | 690602-5   | CAM, PRE FEED, 1 1/8                  | 48  |
| - | 1 | - | -   | -   | - | -  | 690501-4   | CAM, POST-FEED 1 5/8                  | 47  |
| - | 1 | 1 | 1   | 1   | - | -  | 459456-1   | APPL, BASIC SUB ASSY (SIDE WISE MOCA) | 46  |
| - | 1 | 1 | 1   | 1   | - | -  | 690191-1   | PLUG, NYLON                           | 45  |
| - | 1 | 1 | 1   | 1   | - | -  | 819307-7   | RAM, SIDE FEED                        | 44  |
| - | 1 | 1 | 1   | 1   | - | -  | 7-21002-9  | SCR, BTN SKT HD CAP 5/16-24 X 1.00    | 41  |
| - | 1 | 1 | 1   | 1   | - | -  | 690125-1   | SHIM SUB-ASSY                         | 39  |
| - | 1 | 1 | 1   | 1   | - | -  | 469367-9   | SHIM                                  | 38  |
| - | 1 | 1 | 1   | 1   | - | -  | 879103-2   | FINE ADJUST HEAD ASSEMBLY             | 37  |
| - | 1 | 1 | 1   | 1   | - | -  | 690786-1   | TERMINAL SUPPORT                      | 34  |
| - | 2 | 2 | 2   | 2   | - | -  | 2-21002-4  | SCR, BTN SKT HD CAP 8-32 X .750       | 33  |
| - | 1 | 1 | 1   | 1   | - | -  | 21024-5    | WASHER, SPRG LOCK, REG NO 10          | 32  |
| - | 1 | 1 | 1   | 1   | - | -  | 3-21000-4  | SCR, SKT HD CAP 10-32 X .375          | 31  |
| - | 1 | 1 | 1   | 1   | - | -  | 1320908-1  | SPACER, STRIP GUIDE                   | 30  |
| - | 1 | 1 | 1   | 1   | - | -  | 1633091-1  | ASSEMBLY, STRIP GUIDE                 | 29  |
| - | 1 | 1 | 1   | 1   | - | -  | 1-455888-0 | SPACER, CRIMPER                       | 28  |
| - | 1 | 1 | 1   | 1   | - | -  | 1320928-1  | PLATE, STRIP GUIDE                    | 24  |
| - | 1 | - | -   | -   | - | -  | 690472-2   | STRIPPER                              | 22  |
| - | 1 | 1 | 1   | 1   | - | -  | 2-21000-7  | SCR, SKT HD CAP 8-32 X .500           | 21  |
| - | 4 | 4 | 4   | 4   | - | -  | 21024-4    | WASHER, SPRG LOCK, REG NO 8           | 20  |
| - | - | - | -   | -   | - | -  | 691353-1   | STRIPPER                              | 19  |
| △ | - | 1 | -   | -   | - | -  | 679625-1   | SHEAR HOLDER, FRONT (NO CUT)          | 17  |
| △ | - | 1 | 1   | 1   | - | -  | 3-568176-2 | CRIMPER, WIRE                         | 15  |
| △ | - | 1 | 1   | 1   | - | -  | 3-22280-3  | SPRING, COMPRESSION                   | 12  |
| △ | - | 1 | 1   | 1   | - | -  | 690461-1   | STOP, SHEAR                           | 11  |
| △ | - | 1 | 1   | 1   | - | -  | 690459-1   | SHEAR HOLDER, FRONT                   | 10  |
| △ | - | 1 | 1   | 1   | - | -  | 454276-1   | FLOATING SHEAR, FRONT                 | 9   |
| △ | 1 | 1 | 1   | 1   | - | -  | 904132-4   | ANVIL, COMBINATION                    | 8   |
| △ | - | 1 | 1   | 1   | - | -  | 1-455889-4 | DEPRESSOR, SHEAR                      | 5   |
| △ | - | 1 | 1   | 1   | - | -  | 3-238011-1 | BLOCK, CRIMPER SPACER                 | 4   |
| △ | 1 | 1 | 1   | 1   | - | -  | 7-683453-6 | CRIMPER, INSULATION PREMIUM           | 3   |
| △ | - | 1 | 1   | 1   | - | -  | 1-455888-1 | SPACER, CRIMPER                       | 2   |
| △ | 1 | 1 | 1   | 1   | - | -  | 3-568176-1 | CRIMPER, WIRE                         | 1   |

|                                        |  |                                               |             |         |
|----------------------------------------|--|-----------------------------------------------|-------------|---------|
| -77 -6 -3 -2 -1 U/M                    |  | PART NO                                       | DESCRIPTION | ITEM NO |
| D. KNEPPER 30MAR2007                   |  | 30MAR2007                                     |             |         |
| G. BAILEY 18APR2007                    |  | 18APR2007                                     |             |         |
| T. BENCHOFF 30MAR2007                  |  | 30MAR2007                                     |             |         |
| NAME                                   |  | Tyco Electronics<br>Harrisburg, PA 17105-3608 |             |         |
| DIMENSIONS:<br>INCHES                  |  | FINE ADJUST SIDE FEED<br>HDM APPLICATOR       |             |         |
| TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | SIZE CASE CODE DRAWING NO RESTRICTED TO       |             |         |
| 0 PLC .#1                              |  | A 00779 C-1855205                             |             |         |
| 1 PLC .#0.01                           |  | SCALE 3:5 SHEET 1 OF 1 REV B                  |             |         |
| 2 PLC .#0.001                          |  |                                               |             |         |
| 3 PLC .#0.0001                         |  |                                               |             |         |
| 4 PLC .#0.0001                         |  |                                               |             |         |
| ANGLES                                 |  |                                               |             |         |
| FINISH                                 |  |                                               |             |         |
| MATERIAL                               |  |                                               |             |         |
| WEIGHT                                 |  |                                               |             |         |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING |  |                                               |             |         |

# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1855205-6](#)