



SAFETY PRECAUTIONS AVOID INJURY

Safeguards are designed into this application equipment to protect operators and maintenance personnel from most hazards during equipment operation. However, certain safety precautions must be taken by the operator and repair personnel to avoid personal injury, as well as damage to the equipment. For best results, application equipment must be operated in a dry, dust-free environment. Do not operate equipment in a gaseous or hazardous environment.

Carefully observe the following safety precautions before and during operation of the equipment:

- ALWAYS wear appropriate ear protection.
- ALWAYS wear approved eye protection when operating powered equipment.
- ALWAYS keep guard(s) in place during normal operation.
- ALWAYS disconnect the tool from its power source when performing maintenance on the equipment.
- NEVER wear loose clothing or jewelry that may catch in moving parts of the application equipment.
- NEVER insert hands into installed application equipment.
- NEVER alter, modify, or misuse the application equipment.

TOOLING ASSISTANCE CENTER

CALL TOLL FREE 1-800-722-1111 (CONTINENTAL UNITED STATES AND PUERTO RICO ONLY)

The **Tooling Assistance Center** offers a means of providing technical assistance when required.

In addition, Field Service Specialists are available to provide assistance in the adjustment or repair of the application equipment when problems arise which your maintenance personnel are unable to correct.

INFORMATION REQUIRED WHEN CONTACTING THE TOOLING ASSISTANCE CENTER

When calling the Tooling Assistance Center regarding service to equipment, it is suggested that a person familiar with the device be present with a copy of the manual (and drawings) to receive instructions. Many difficulties can be avoided in this manner.

When calling the Tooling Assistance Center, be ready with the following information:

1. Customer name
2. Customer address
3. Person to contact (name, title, telephone number, and extension)
4. Person calling
5. Equipment number (and serial number if applicable)
6. Product part number (and serial number if applicable)
7. Urgency of request
8. Nature of problem
9. Description of inoperative component(s)
10. Additional information/comments that may be helpful

Read this manual thoroughly before operating any of the pneumatic tools. The performance of these tools will depend largely upon the intelligent use of information contained in this manual and pay particular attention to **DANGER**, **CAUTION**, **NOTE**, and **SAFETY** statements.

DANGER

Denotes an imminent hazard which may result in moderate or severe injury.

**CAUTION**

Denotes a condition which may result in product or equipment damage.

**NOTE**

Highlights special or important information.



Read and understand the entire manual before using the tool.



Always wear appropriate eye protection when using the tool.



Always disconnect the air and lockout the tool when not in use, when performing maintenance on the tool, or when clearing a jammed tool.



Pinch point warning: Keep hands clear of moving parts during operation.

NOTE

Measurements are in metric units [followed by U.S. customary units in brackets]. Illustrations are for identification only and are not drawn to scale.

**DANGER**

This unit should only be operated by trained personnel.

**DANGER**

If not using quick-disconnect fittings to connect the tool to the air supply, provide operators other means to easily disconnect the tool from the air supply.

**DANGER**

This tool is not insulated for coming into contact with electric power sources.



DANGER

Do not use this tool in explosive atmospheres.

**DANGER**

Stored gas or fluid energy may cause a hazard.

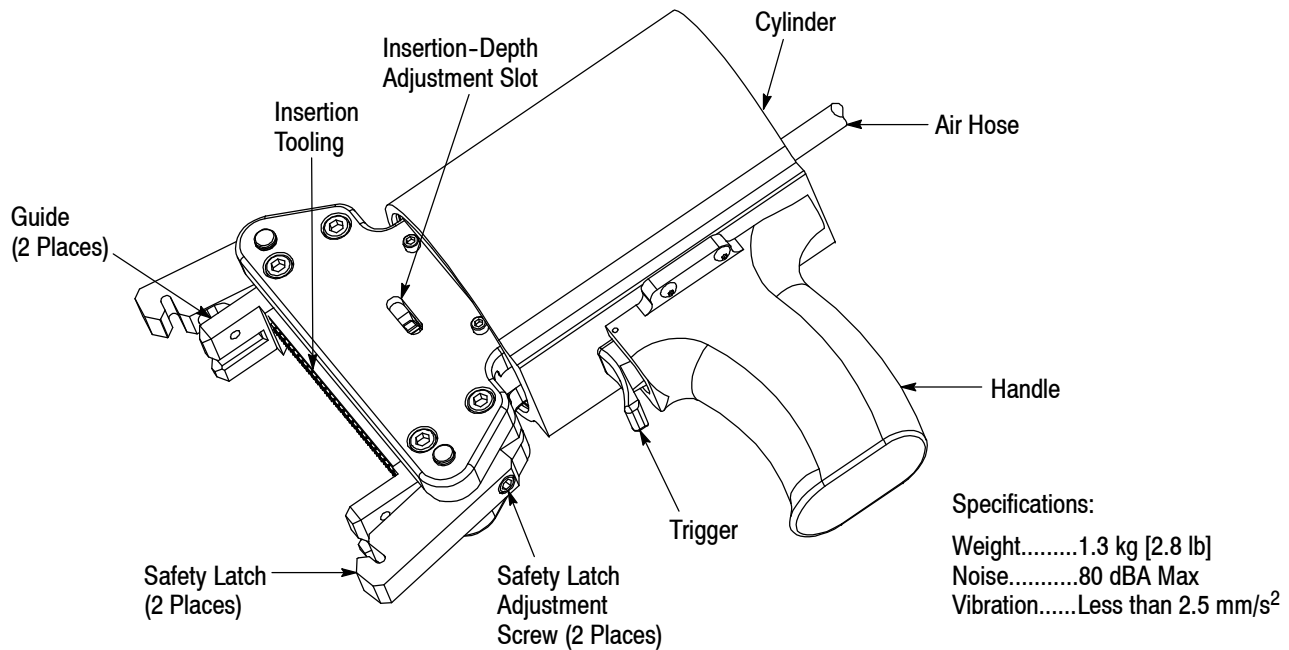
**DANGER**

There is a risk of whipping if a hose is not properly installed or becomes detached.



PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.



MTA APPLICATOR ASSEMBLY	CONNECTOR-HOLDING FIXTURE	MTA CONNECTOR
58575-1	58242-3	.100 Closed End Receptacle With or Without Polarization Tabs
	58243-3	.100 Feed-Through Receptacle With or Without Polarization Tabs
	59845-3	.100 Feed-Through Receptacle Without Polarization Tabs
58576-1	58009-2	.156 Closed End Posted Receptacle
	58010-2	.156 Feed-Through Posted Receptacle
	58244-3	.156 Closed End Test Receptacle With or Without Polarization Tabs
	58245-3	.156 Feed-Through Test Receptacle With or Without Polarization Tabs
	59847-3	.156 Feed-Through Receptacle
	59848-3	.156 Closed End Card Edge Receptacle
	59849-3	.156 Feed-Through Card Edge Receptacle

Figure 1

1. INTRODUCTION

Mass Termination Assembly (MTA) Applicator Assemblies 58575-1 and 58576-1 are used with connector-holding fixtures listed in Figure 1 to insert wires into MTA .100 and .156 closed end and feed-through connectors.

For information regarding connector-holding fixtures, refer to Instruction Sheet 408-7994 (MTA .100) and 408-7995 (MTA .156). Read these instructions and referenced material thoroughly before using the applicator assembly.

NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are for reference only and are not drawn to scale.

The date code is marked on the body of the tool. The date code is in the format YYWW, where YY represents the year of manufacture and WW represents the week of manufacture. For example, if the date code marked on a tool is 0533, the tool was made in the 33rd week of 2005.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

2. DESCRIPTION (Figure 1)

The applicator assembly is a pneumatically operated hand-held unit designed to operate with 517 to 655 kPa [75 tp 95 psi] air pressure. The applicator assembly features a cylinder with a handle capable of pivoting 360°, two safety latches, insertion tooling, an insertion-depth adjustment, and two guidelines which automatically engage the applicator assembly to the connector-holding fixture.

After the connector-fixture holding fixture is mounted to the harness board, the applicator assembly is placed onto the fixture, then actuated to complete the termination.

3. AIR LINE REQUIREMENTS AND SETUP (Figure 2)

A filter and moisture separator, regulator, and lubricator must be used with these tooling assemblies to ensure dependable performance and long life. It is recommended that quick-disconnect fittings are used to connect the tool to the air supply. If not using

quick-disconnect fittings, provide a pneumatic lock-out on the air line that bleeds air after it is turned off. These items are customer supplied.

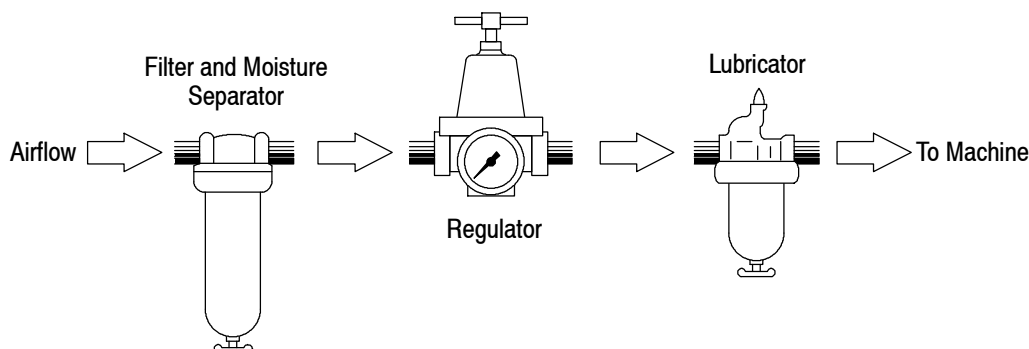
It is strongly recommended that these items be installed *at each tool station* in the order shown in Figure 2. Mount the items as close as possible to the tooling assembly, preferably where the tool hose is connected to the air system. Be sure the items are checked after every 40 hours of use by the tool operator or maintenance personnel.

Figure 2 lists the suggested manufacturers and benefits of using this equipment.

4. OPERATING PROCEDURE

Mount the connector-holding fixture, and install connector and lace wires in the fixture according to Instruction Sheets 408-7994 (MTA .100) or 408-7995 (MTA .156). Then proceed as follows:

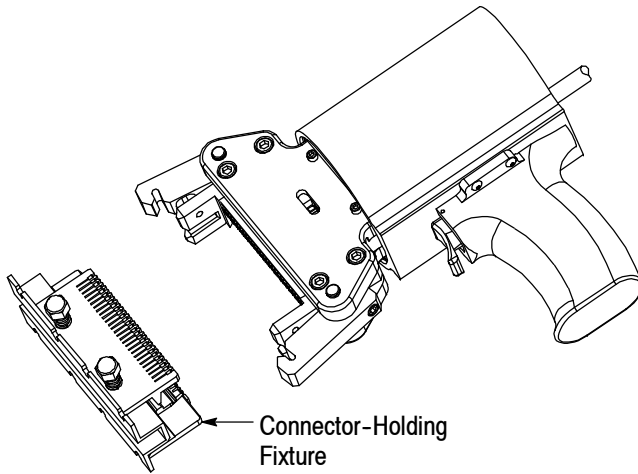
1. Attach air supply to applicator assembly and adjust air pressure (517 to 655 kPa [75 to 95 psi]).



DRAIN REGULARLY	CHECK AIR PRESSURE REGULARLY (517 kPa [75 psi] Min—655 kPa [95 psi] Max)	CHECK OIL LEVEL REGULARLY (Adjust to Very Fine Mist—Approximately 1 Drop per 15-20 Tool Cycles)
- Minimizes clogging and excessive wear - Minimizes rust and corrosion - Prevents water from washing away lubricants - Prevents water emission from exhaust ports	- Promotes smooth, consistent performance - Protects hoses and components from damage	- Eliminates sluggish or sticking valves and pistons - Provides protective film for highly polished or close tolerance surfaces - Provides seal in close tolerance areas - Extends life of pistons, cylinders, and valves
SUGGESTED MANUFACTURERS		
Filter/Moisture Separator, Regulator, Lubricator		Lubricator Oil (Use Only Good Quality, Non-Synthetic Air Lubricant)
C.A. Norgen Co., Littleton, CO		(C.P. Airoilene SAE 10)
Chicago Pneumatic Tool Co., New York, NY		Chicago Pneumatic Tool Co., New York, NY

Figure 2

2. Grasp the applicator assembly handle and hold the applicator assembly over the connector-holding fixture so that the guides align with the ends of the fixture as shown in Figure 3.



Note: For clarity, harness board is not shown.

Figure 3



CAUTION Do not use this tool as a blunt object, a crushing device, or for any purpose other than crimping the proper specified product. Inappropriate use of the tool could result in personal injury or damage to the tool.

3. Gently push the applicator assembly onto the fixture until the safety latches engage the fixture and the insertion tooling sits flat on the connector.
4. Depress the trigger to actuate the applicator assembly.
5. Remove the terminated connector from the fixture, and inspect the connector according to Application Specification 114-1019 (MTA .100) or 114-1020 (MTA .156).

5. INSERTION-DEPTH ADJUSTMENT



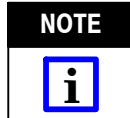
DANGER To avoid personal injury, DISCONNECT applicator assembly from air supply before making any adjustments.

If, after inspection, the wire insertion depth measurement is not in accordance, adjust the applicator assembly according to the following.



CAUTION The applicator assembly insertion depth is factory preset and should not require adjusting; however, number of conductors, air pressure, wire size, and wire insulation diameter can affect insertion depth measurements. Always verify the insertion depth setting using a test sample before making any adjustments.

1. Insert a small-diameter punch into the insertion depth adjustment slot (refer to Figure 1), and rotate the wheel *clockwise* to decrease the insertion depth setting; *counterclockwise* to increase the insertion depth.



NOTE Each click of the wheel adjusts the insertion depth setting by 0.10 mm [.004 in.].

2. When the applicator assembly is actuated, the safety latches should slightly touch the guides. If they do not, turn each safety latch adjustment screw (located on the lower side of the latch) *clockwise* in small increments until latches move properly.

6. MAINTENANCE AND INSPECTION

Each applicator assembly is assembled and inspected before shipment. It is recommended that the applicator assembly be inspected immediately upon arrival in your plant to ensure that it has not been damaged during shipment.

6.1. Daily Maintenance

It is recommended that each operator be made aware of, and responsible for, the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean, soft brush or clean lint-free cloth. Do NOT use objects that could damage the applicator assembly or any of its components.
2. Ensure that the screws are in place and secured.
3. When the applicator assembly is not in use, store it in a clean, dry area.

6.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the applicator assembly or be supplied to personnel responsible for the applicator assembly. The inspection frequency should be based on the amount of use, working conditions, operator training and skill, and established company standards. At a minimum, the tool should be inspected on a weekly basis.

7. REPLACEMENT AND REPAIR

Order replacements through your Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (38-35)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG, PA 17105-3608

The applicator assembly may be returned for evaluation and repair. For repair service, contact a representative at 1-800-526-5136.

8. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements
- Added "ORIGINAL INSTRUCTIONS"
- Added new Safety and Tooling Assistance Information at beginning of document
- Added Safety icons at beginning of document
- Added new information to Figure 1
- Added new text to Section 1, INTRODUCTION
- Deleted NOTE in Section 2, DESCRIPTION
- Added new Section 3 and renumbered
- Added new Figure 2 and renumbered