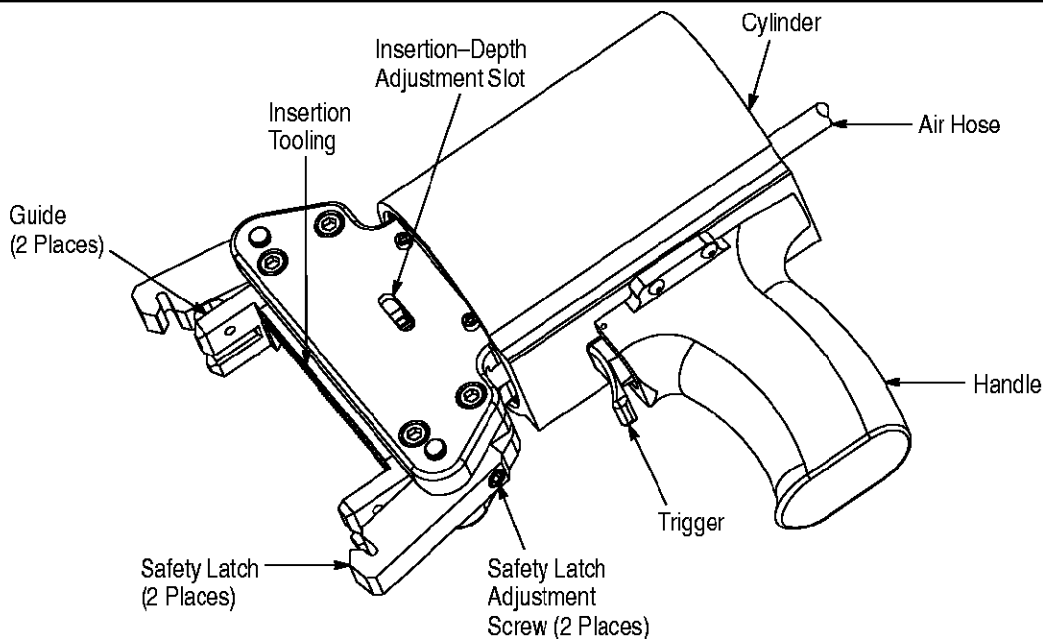


PROPER USE GUIDELINES

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

AMP* 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 not drawn to scale.

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 to 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 guides which automatically engage the applicator assembly to the connector-holding fixture.

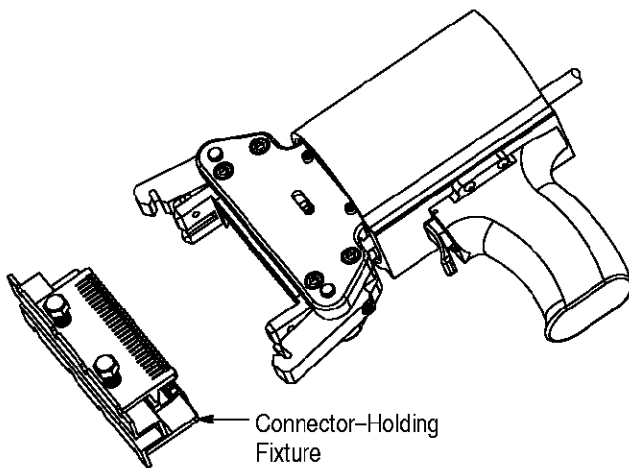
After the connector-holding fixture is mounted to the harness board, the applicator assembly is placed onto the fixture, then actuated to complete the termination.

NOTE *The applicator assembly emits 80 dB(A) maximum noise measured at normal operator position.*

3. OPERATING PROCEDURE

Mount the connector-holding fixture, and install connector and lace wires in the fixture according to the instructions in 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]).
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 2.



Note: For clarity, harness board is not shown.

Figure 2

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).

4. 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.

5. 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.

5.1. 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.

5.2. 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.

6. REPLACEMENT AND REPAIR

Order replacements through your 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.

7. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0266-00 include:

- Changed title of document
- Added connector-holding fixtures to Figure 1