

**Product:**  
Ultra-Fast Fully Insulated FASTON\* Terminals  
Ultra-Fast Plus Fully Insulated FASTON Terminals  
**Wire Size:** 26-14 AWG  
**Product Catalog:** 82042  
**Tooling Catalog:** 124208

Figure 1

**1. INTRODUCTION**

Pneumatic Platform Adapters 679992-1 (shown in Figure 1) and 679992-2 are used with 626 Pneumatic Tooling Assemblies 189721-1, 189722-1, 189723-1, or 189724-1 when fitted with Tool Holder Assembly 189767-1. The platform adapter accepts the crimping die assemblies listed in Figure 2 and will crimp Ultra-Fast FASTON terminals onto wire sizes 26 through 14 AWG.

This instruction sheet provides recommended procedures for insulation crimp adjustments, wire preparation, crimp head installation, crimping, and

maintenance and inspection. For information concerning the setup and operation of the pneumatic tools, see Customer Manual 409-5862.

Read these instructions thoroughly before proceeding.

**NOTE** *Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.*

Reasons for reissue are provided in Section 7, REVISION SUMMARY.

CRIMPING DIE ASSEMBLY			TERMINAL		WIRE SIZE (AWG)
PART NUMBER	INSTRUCTION SHEET	COLOR DOT CODE	TYPE	CRIMP DOT CODE	
58052-3	408-9277	Violet	Ultra-Fast Fully Insulated FASTON Terminal	3	26-22
58079-3	408-9278	Red	Ultra-Fast Plus Fully Insulated FASTON Terminal	NA	22-18
58080-3		Blue		NA	16-14
90390-3	408-9279	Red	Ultra-Fast Fully Insulated FASTON Terminal	1	22-18
90391-3		Blue		2	16-14

Figure 2

**2. DESCRIPTION** (Figure 1)

The platform adapter features a top jaw with a platform, a bottom jaw, and an adjustable stop. The top jaw has a mounting hole and the bottom jaw has a socket head setscrew for securing the crimping die assembly. The stop adjusts for various terminal series size. In addition, Adapter -1 has a spring-loaded locator assembly which aids in positioning the terminal between the jaws.

The die assembly consists of a lower die and an upper die, each marked with a color dot code that must match the color of the terminal insulation. When closed, the die assembly forms two crimping chambers, each marked with the wire size range.

After the operator locates the terminal and inserts the stripped wire, the tool is activated to complete the crimp. The crimped terminal will display a crimp dot code which indicates that the correct crimping die assembly was used.

**3. SETUP PROCEDURES**

**3.1. Die Assembly Installation** (Figure 3)

**NOTE** *The platform adapter must be removed from the tool holder to install the die assembly. Refer to Paragraph 3.2, Platform Adapter Installation and Removal.*

**A. Upper Die**

1. Slide upper die onto the top jaw of the adapter. Make sure that the hole on the side of the upper die aligns with the socket head setscrew in the jaw.

**NOTE** *If upper die will not position properly, use hex wrench (provided with die assembly) to turn socket head setscrew either in or out until upper die is positioned properly.*

2. Using hex wrench, turn socket head setscrew clockwise until secure. Do NOT overtighten.

**B. Lower Die**

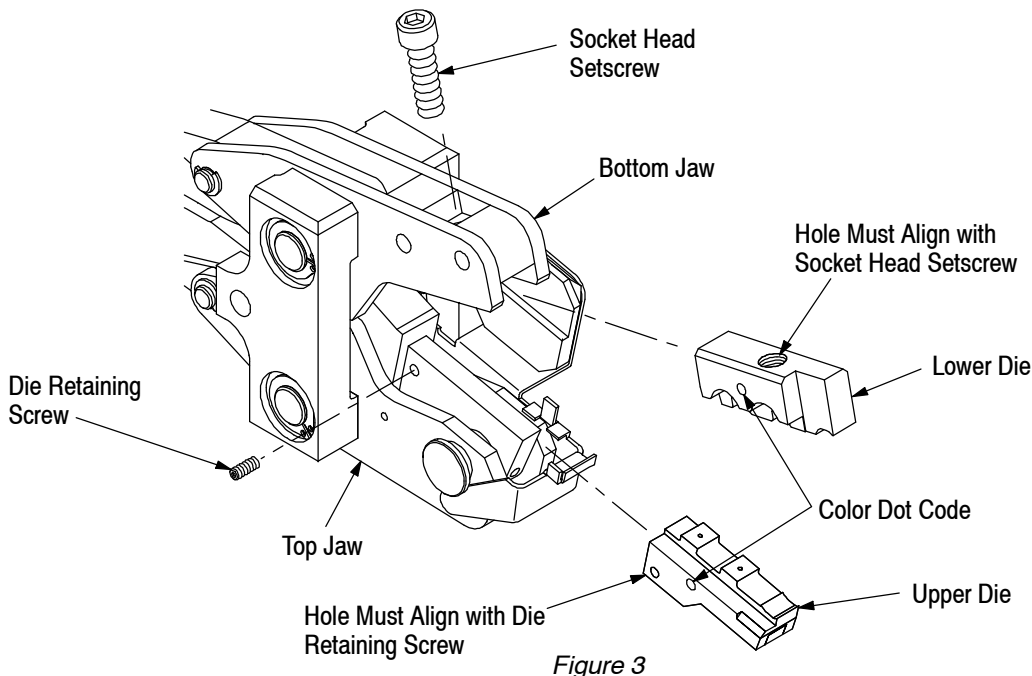
1. Remove die retaining screw from lower die.
2. Squeeze the adapter rollers together to open jaws. Slide lower die onto bottom jaw of adapter. Make sure the color dot code on lower die is on the same side as the color dot code on upper die.
3. Carefully release the rollers to allow the adapter jaws to close. Make sure that the dies are properly aligned.
4. Insert die retaining screw through the mounting hole in the platform of the bottom jaw and into the hole in the lower die.
5. Tighten the die retaining screw until secure.

**3.2. Platform Adapter Installation and Removal**

**A. Installation**


**NOTE** *Before installing or removing the adapter, DISCONNECT THE TOOL FROM THE AIR SUPPLY. After installation, ALWAYS ensure that the tool holder quick pins are fully tightened to avoid personal injury or damage to the tool.*

1. Remove quick pins from the tool holder (refer to Figure 1).




2. Insert platform adapter into tool holder as shown in Figure 1.

3. After platform adapter is properly aligned, insert and tighten quick pins provided with the tool holder assembly (refer to Figure 1).

**NOTE**  
 We recommend using LOCTITE† 242 removable threadlock, or equivalent, to prevent the quick pins from loosening..

4. Connect pneumatic tool to an adequate air supply between 620 and 690 kPa [90 and 100 psi]. For specific information on air line requirements and air hose installation, refer to the instructions packaged with the pneumatic tooling assembly.


**B. Removal**


**DANGER**  
 To avoid personal injury, ALWAYS disconnect tool from air supply before removing platform adapter.

Remove quick pins from platform adapter; then remove platform adapter from tool holder.


**4. CRIMPING PROCEDURE** (Figure 4)

Strip the wire to the appropriate length according to Application Specification 114-2123. Proceed as follows:

**CAUTION**  
 Do NOT operate the tool without the platform adapter or die assembly properly installed.

**DANGER**  
 To avoid personal injury or damage to the tool, always keep fingers clear of jaws, and frequently check the quick pins to ensure that they are secure.

1. The locator stop must be adjusted to accommodate the terminal series size, which is marked on the terminal insulation (.110, .187, or .250). Rotate the blue plastic locator stop until the series size matches the terminal series size.

**NOTE**  
 If crimping a flag terminal, the locator stop does NOT need to be adjusted.

2. Open the dies by squeezing the adapter rollers together.

3. Center the terminal wire barrel in the appropriate crimping chamber on the lower die.

a. For straight terminals, insert mating end into crimping chamber with the flat side facing the locator assembly (for Adapter -1) as shown in Figure 4, or the upper die (for Adapter -2). Allow terminal to butt against the locator stop.

b. For flag terminals, orient the terminal as shown in Figure 4. The mating end must be seated on the locator assembly (for Adapter -1), or the upper die (for Adapter -2).

4. After terminal is properly positioned, release the adapter rollers to allow the dies to spring shut, holding the terminal in place.

5. Insert stripped wire into wire barrel until the wire bottoms.

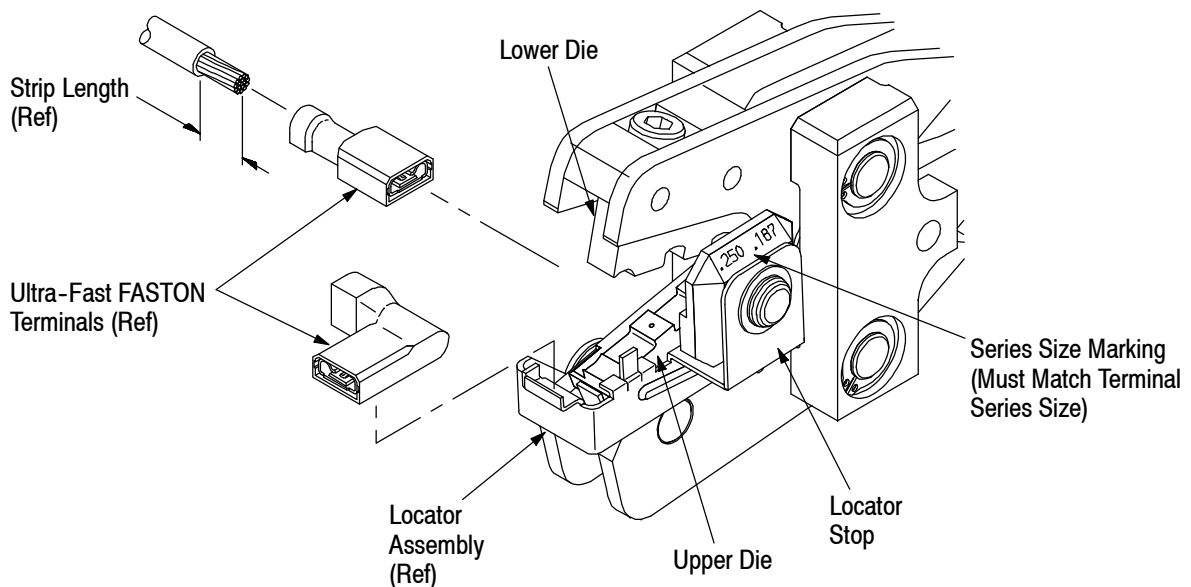


Figure 4

† Trademark of Loctite Corporation

6. Activate tool to complete the crimp. Open the jaws by squeezing the adapter rollers together; then remove the crimped terminal.
7. Inspect terminal in accordance with 114-2123 to ensure a proper crimp.

**NOTE**

*A properly crimped terminal will display a crimp dot code on the flat side of the terminal insulation. For applicable crimp dot codes, refer to Figure 2. Flag terminals will not have a crimp dot code.*

**NOTE****5. MAINTENANCE AND INSPECTION****DANGER**

*To avoid injury, DISCONNECT TOOL FROM AIR SUPPLY before performing any maintenance or inspection procedures.*

It is recommended that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations. The platform adapter should be inspected once a month. Frequency of inspection should be adjusted to suit your requirements, and depends on:

1. The care, amount of use, and handling of the adapter.
2. The type and size of the products crimped.
3. The degree of operator skill.
4. The presence of abnormal amounts of dust and dirt.
5. Your own established standards.

The platform adapter is thoroughly inspected before packaging. Since there is the possibility of damage during shipment, the adapter should be inspected immediately upon arrival at your facility.

**5.1. Maintenance****A. Cleaning**

Remove dust, moisture, and other contaminants with a clean, soft brush, or a soft, lint-free cloth. Do NOT use objects that could damage the adapter. Re-lubricate adapter, as instructed in Paragraph 5.1.B. Lubrication, before placing it back into service.

**B. Lubrication**

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. The use of Molykote<sup>■</sup> grease, which is a commercially available lubricant, is recommended. Lubricate according to the following schedule:

- Adapter used in daily production—lubricate daily
- Adapter used daily (occasional)—lubricate weekly
- Adapter used weekly—lubricate monthly

Wipe excess grease from adapter, particularly from die closure areas. Grease transferred from the die closure area onto certain terminations may affect the electrical characteristics of an application.

**5.2. Periodic Inspection**

1. Inspect the adapter for missing pins and retaining rings. If parts are missing or defective, replace them by referring to Section 6.
2. Check all bearing surfaces for wear. Make sure the rollers turn freely with minimal resistance. Replace any worn parts.
3. Inspect the crimping area for flattened, chipped, or broken areas. Worn or damaged surfaces are objectionable and will affect the quality of the crimp.

**6. REPLACEMENT AND REPAIR**

The parts listed in Figure 5 are customer-replaceable. A complete inventory can be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

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

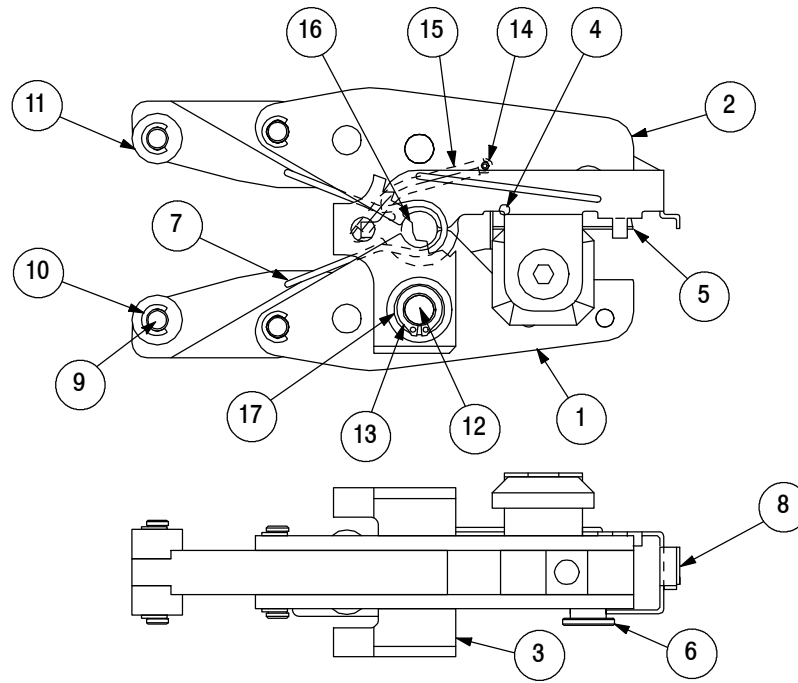
Tools may also be returned for evaluation and repair. For tool repair service, contact a representative at 1-800-526-5136.

**7. REVISION SUMMARY**

Revisions to this instruction sheet include:

- Added "Original Instructions"

<sup>■</sup>Trademark of Dow Corning Corporation



**REPLACEMENT PARTS**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY PER ADAPTER
1	217450-1	Jaw, Assembly, Bottom	1
2	217451-1	Jaw, Assembly, Top	1
3	679261-1	Link	2
4	21061-1	Setscrew, Socket Head	2
5	310952-2	Jaw, Platform	1
6	122637-1	Pin, Toggle Link	1
7	122701-1	Spring ‡	1
8	312388-1	Locator Assembly ■■	1
9	3-23620-3	Pin, Straight Groove ‡	2
10	21045-6	Ring, Retaining ‡	4
11	314479-2	Roller ‡	4
12	6-23629-1	Pin, Straight Groove	2
13	1-21048-0	Ring, Retaining	4
14	21028-8	Pin, Slotted Spring	1
15	310690-1	Spring, Extension	1
16	679495-2	Pin	1
17	301185-6	Shim, 0.20 mm [.008 in.] ●	<i>At Request</i>
	301185-7	Shim, 0.25 mm [.010 in.] ●	<i>At Request</i>
	301185-8	Shim, 0.30 mm [.012 in.] ●	<i>At Request</i>
	301185-9	Shim, 0.38 mm [.015 in.] ●	<i>At Request</i>

● Add Shim to reduce gap by 0.18 mm [.007 in.] (max.) between Link (Item 3) and Retaining Ring (Item 10).

‡ Recommended Spare Parts

■■ Locator Assembly (Item 8) is not a component of Adapter 67992-2.

Figure 5