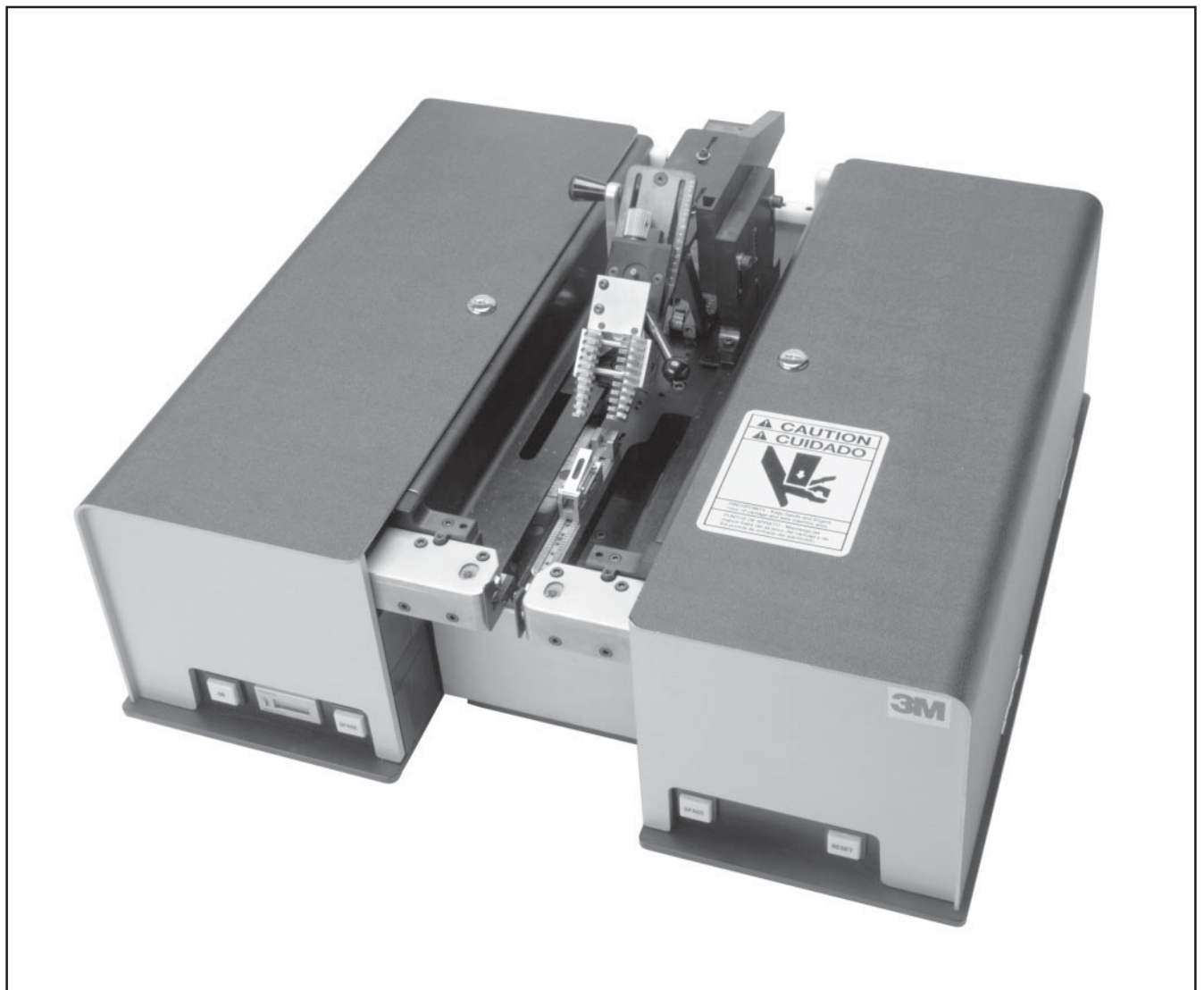


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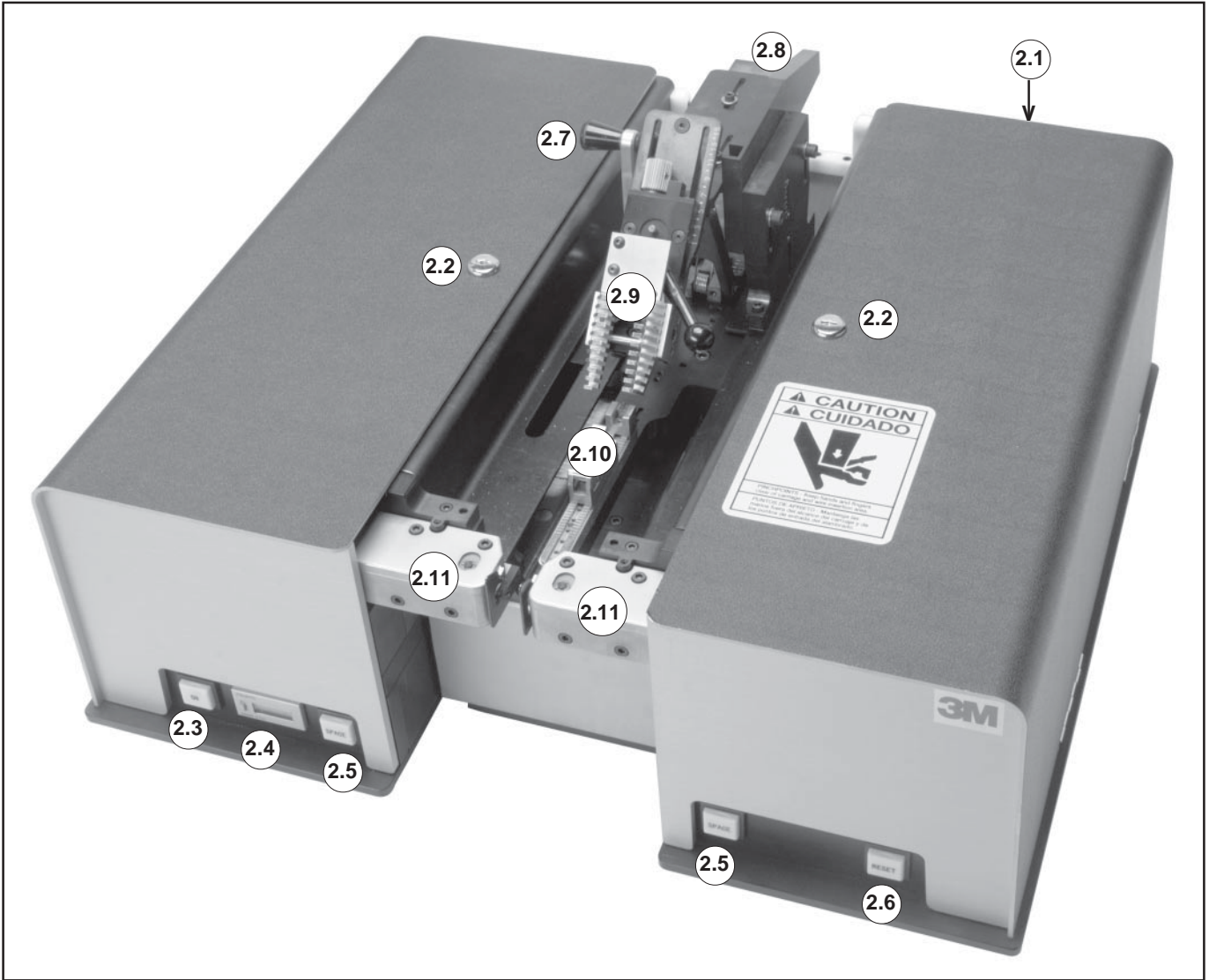
Model 1100A CHG Terminator

Operating Instructions



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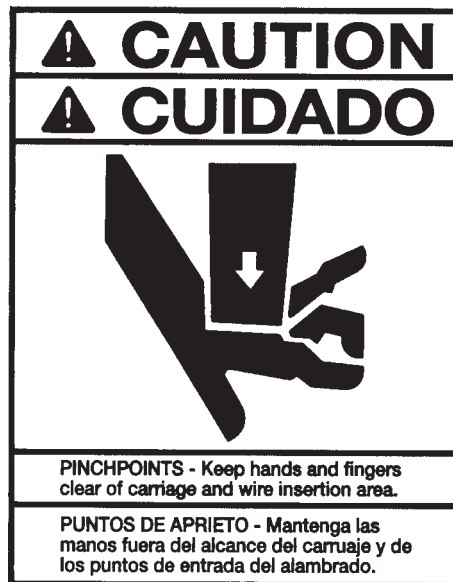
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1.0 Safety Information

- 1.1 **Intended Use:** The 3M™ 1100A CHG Terminator is a semi-automatic machine designed and tested for terminating round jacketed cable onto CHG connectors. The 1100A terminates a pair of discrete wires per cycle and assembles to all three CHG connector body styles: MIL/DIN, one row stackable without tabs, and two row stackable without tabs.

Caution: *During a termination cycle, the carriage will be positioned for the next termination. Also, when the last termination is completed, the carriage will be returned to the home position. Both of these operations are driven by powerful electric motors. Keep hands (both operator's and nearby personnel) away from these moving parts to avoid injury.*

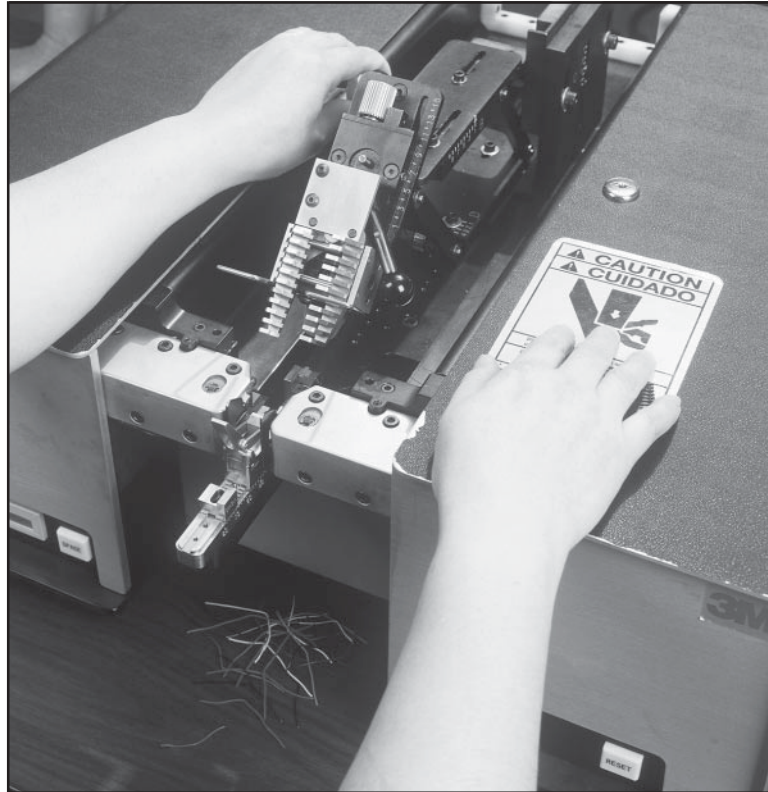


2.0 General Introduction

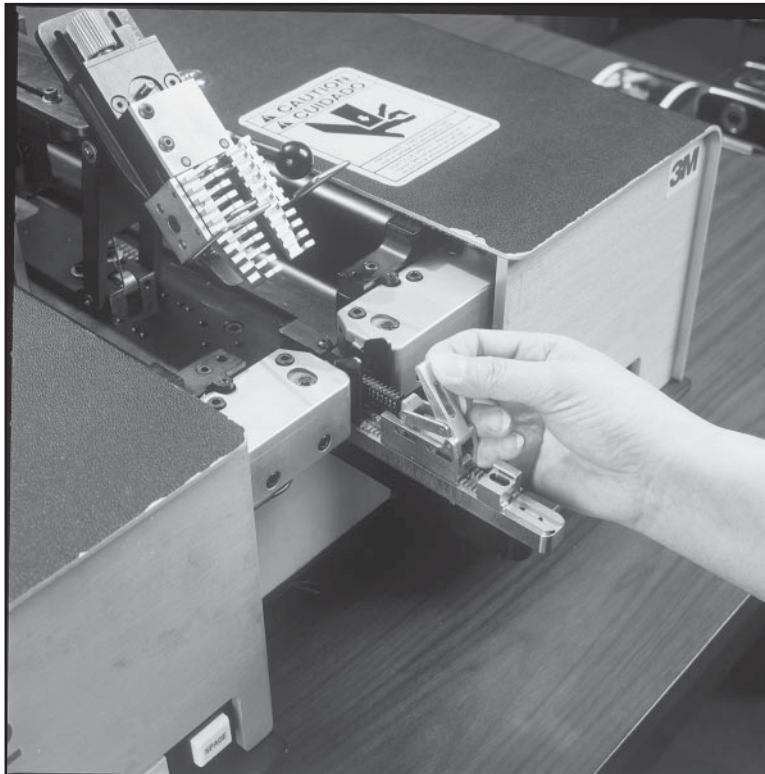
- 2.1 **FUSE and POWER CORD CONNECTION** are on the backside of the machine.
- 2.2 **KEY LOCKS** secure the two machine covers.
- 2.3 The **ON BUTTON** is located on the left front of the machine.
- 2.4 The **ASSEMBLY COUNTER** (center left front of the machine) can be reset.
- 2.5 Two **SPACE BUTTONS** (left front and right front) allow discrete wire location.
- 2.6 The **RESET BUTTON** (right front of the machine) returns the carriage to the "home" position.
- 2.7 The **CARRIAGE HANDLE** is pulled forward to set the assembly function in place.
- 2.8 The **CENTER ADAPTER** holds and positions the cable for center entry application.
- 2.9 The **CABLE CLAMP** holds the cable in place during assembly.
- 2.10 The **CONNECTOR NEST** positions the connector for assembly.
- 2.11 The **RAM ASSEMBLY** (left and right) performs the wire insertion and wire cut off function.
- 2.12 The **MAINTENANCE COUNTER**, not shown, is inside the left cover at the front of the machine.

3.0 General Assembly Operation

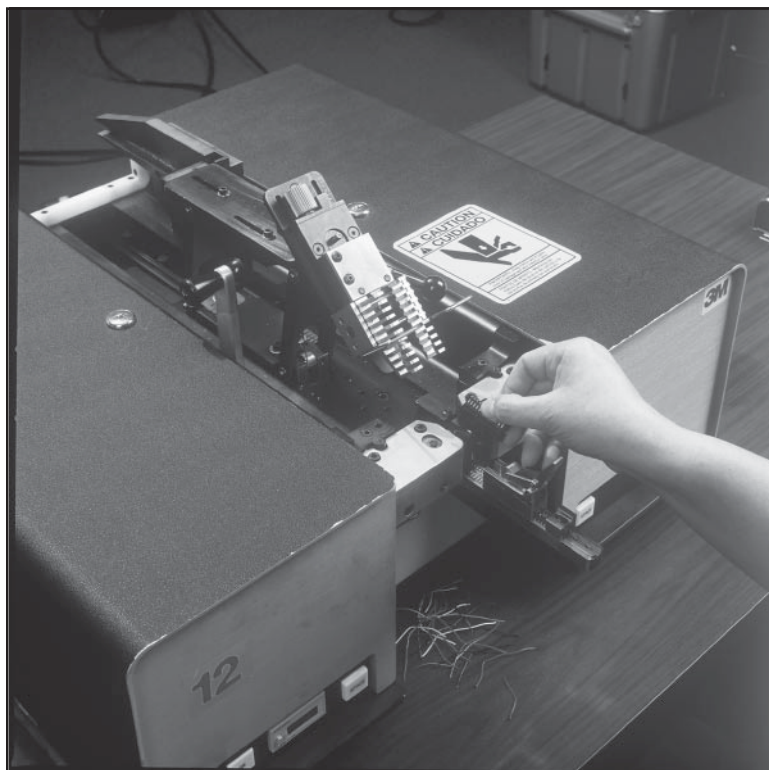
- 3.1 This machine assembles several similar connectors onto round jacketed cable. The MIL/DIN connector and the 1 and 2 row stackable connectors have similarities, so the following instructions will apply to all.
- 3.2 To prepare cable, remove approximately 6" of jacket, metal braiding paper, or aluminum foil wrapped around the twisted pair connector.
- 3.3 Turn the machine on by pushing the ON button.
- 3.4 Use your left hand to pull the carriage handle and bring the carriage forward to the locked position



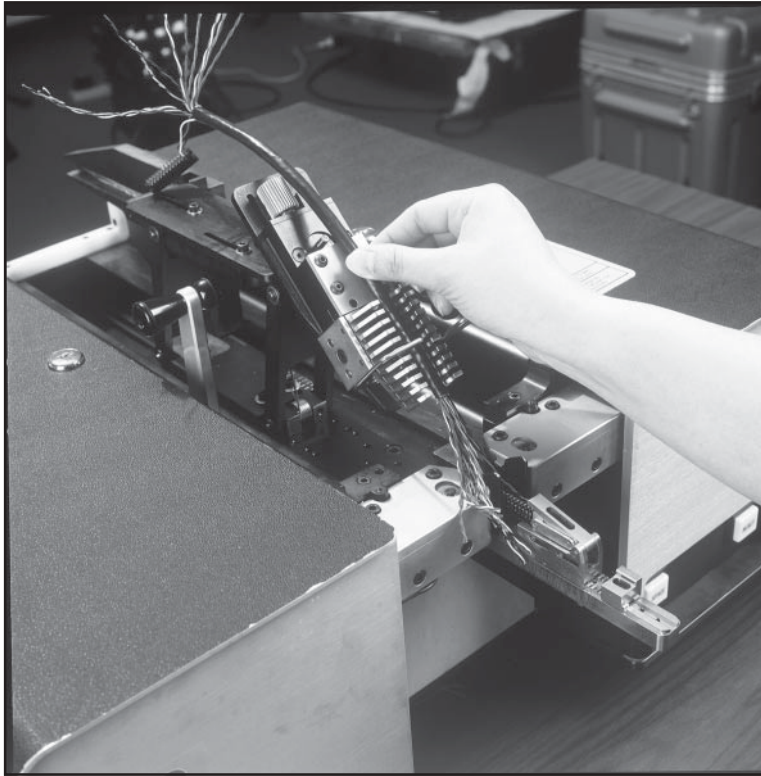
3.5 Open the clamp handle in the assembly nest.



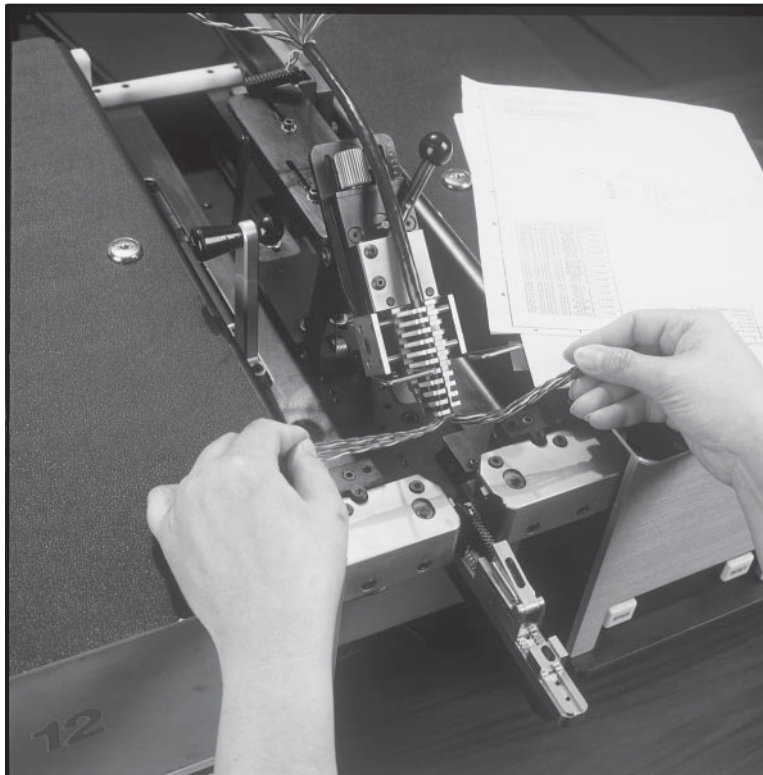
3.6 Place a connector in the assembly nest.



- 3.7 Lay the cable in the cable clamp and close the cable clamp. The cable can be adjusted in the clamp at any time. The position of the cable in the cable clamp will determine the distance of the end jacket to the connector body on the cable.

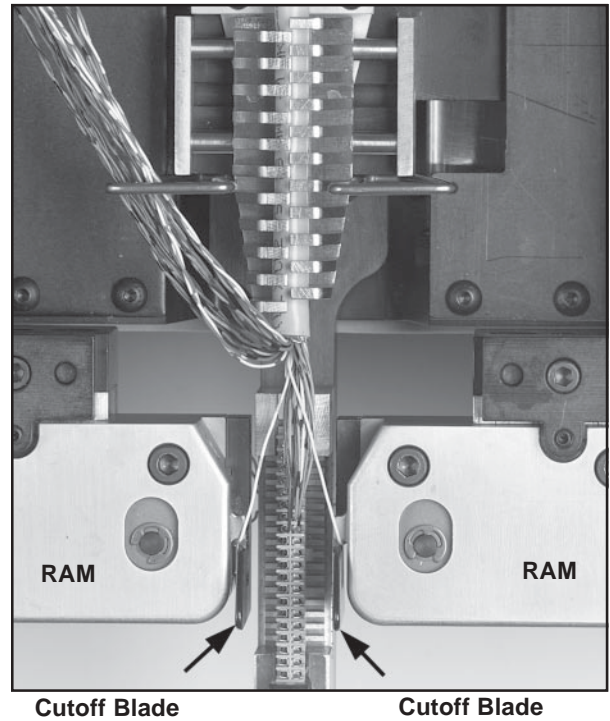
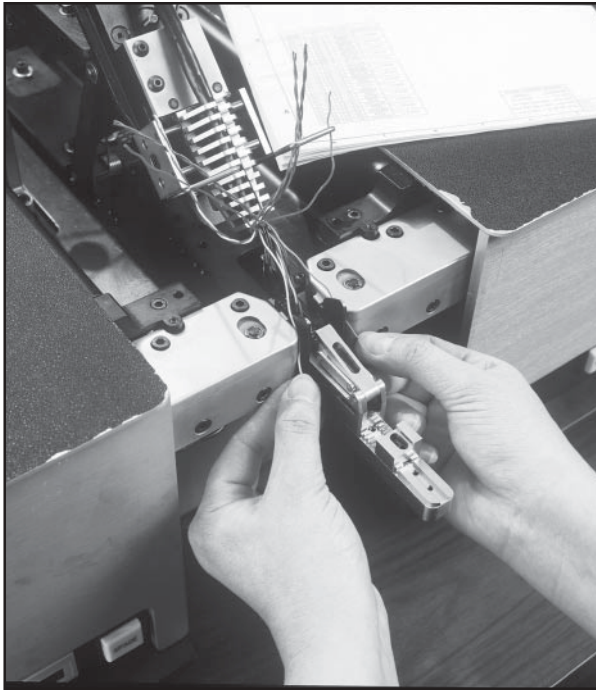


- 3.8 Divide the wires into two groups and place them in the wire holders. Check that no wires are kinked or twisted.



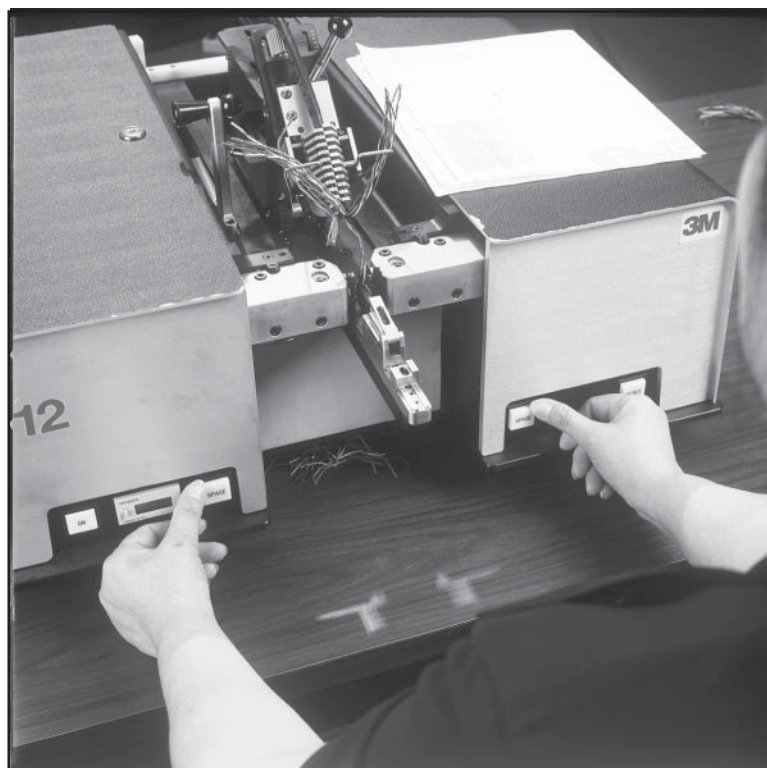
3.9 Choose a specific pair of wires. Grasp the wires in each hand and pull them down between the ram and the cutoff blades. Pull straight down on the wires. This activates the machine to automatically cut the wire to the proper length and put the wires in the connector.

Caution: *Keep hands and fingers clear of carriage and wire insertion area.*



3.10 Repeat wire termination for the other wires. After the last termination, the carriage will return automatically to the home position.

Note: *During assembly, to skip a wire location, press both SPACE buttons instead of terminating two wires.*



3.11 Single Row Stackable Connector:

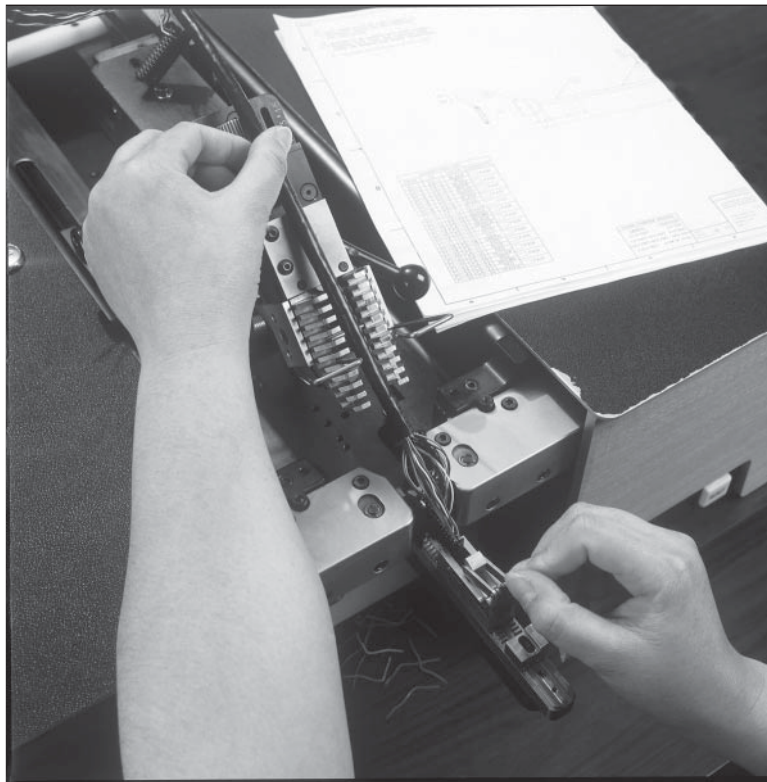
- a) Use the CHGS Connector Nest.
- b) Place two single row connectors back to back.

Note: *One of the two connectors will be used as a backup connector. This connector can be used multiple times.*

- c) Termination of one wire in a single row connector. Place wire in the right hand RAM/CUTOFF blade slot and push the opposite side SPACE button.

Caution: *Keep hands and fingers clear of carriage and wire insertion area.*

- 3.12 When all wires have been inserted into the connector, open the jaws of the cable clamp and the clamp handle in the assembly nest to remove the finished connector .



3.13 At any time during the assembly cycle, pressing the RESET button will return the carriage to the home position.

Caution: *Keep hands and fingers clear of carriage and wire insertion area.*



For technical assistance contact 3M Electronic Product Division at:
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