



Operation Manual for the
TD-200 Soldering Iron and MT-200 MiniTweez®
Handpieces

For use with
PACE AccuDrive® Systems and Tip-Heater Cartridges

P/N 5050-0598 Rev. A



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Safety Guidelines

The following are safety precautions that personnel must understand and follow when using or servicing this product.

1. **POTENTIAL SHOCK HAZARD** - Repair procedures on PACE products should be performed by Qualified Service Personnel only. Line voltage parts may be exposed when the equipment is disassembled. Service personnel must avoid contact with these parts when troubleshooting the product.
2. To prevent personnel injury, adhere to safety guidelines in accordance with OSHA and other applicable safety standards.
3. Heater Cartridge Tips are hot when the handpiece is powered on and will remain so for a period after power off. **DO NOT** touch the cartridge. Severe burns may result.
4. PACE Tip & Tool Stands and handpiece cubbies are designed specifically for use with the associated handpiece and houses it in a manner that protects the user from accidental burns. Always store the handpiece in its holder. Be sure to place the handpiece in its holder after use and allow for cooling before storing.
5. Always use PACE systems in well ventilated area. A fume extraction system such as those available from PACE are highly recommended to help protect personnel from solder flux fumes.
6. Exercise proper precautions when using chemicals (e.g., solder paste). Refer to the Material Safety Data Sheet (MSDS) supplied with each chemical and adhere to all safety precautions recommended by the manufacturer.

Handpiece Connection

The TD-200 Soldering Iron and MT-200 MiniTweez® Handpiece are designed to work with AccuDrive® stations (such as the ADS200) and AccuDrive® specific Blue Series Tip-Heater Cartridges, which have a blue end-cap. In addition, TD-200 AccuDrive Tip-heater Cartridges and MT-200 AccuDrive Tip-Heater Cartridge must only be used for their intended handpiece. They are NOT interchangeable! **Caution:** Using other handpieces or Tip-Heater Cartridges may result in damage to your ADS200 system or the attached handpieces and accessories.

Connect the handpiece connector to the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



Tip-Heater Cartridge Installation

All TD-200 and MT-200 Tip-Heater Cartridges have a key lock for orientation of the tip. This ensures the tip cartridges are held firmly in position and in the correct orientation. MT-200 and TD-200 Tip-Heater Cartridges are NOT interchangeable! To install a cartridge, please follow the procedure below.

1. Using the **tip tool (shown) or hot grip removal pad (not shown)**, line up the key lock feature on the tip cartridge with the notch on the front of the handpiece.
2. Push the tip cartridge all the way into the handpiece.



To remove a tip cartridge, to grasp the tip cartridge and pull the tip cartridge out of the handpiece. Be careful when completing this procedure as the tip cartridge may be hot and direct contact with skin can cause injury.



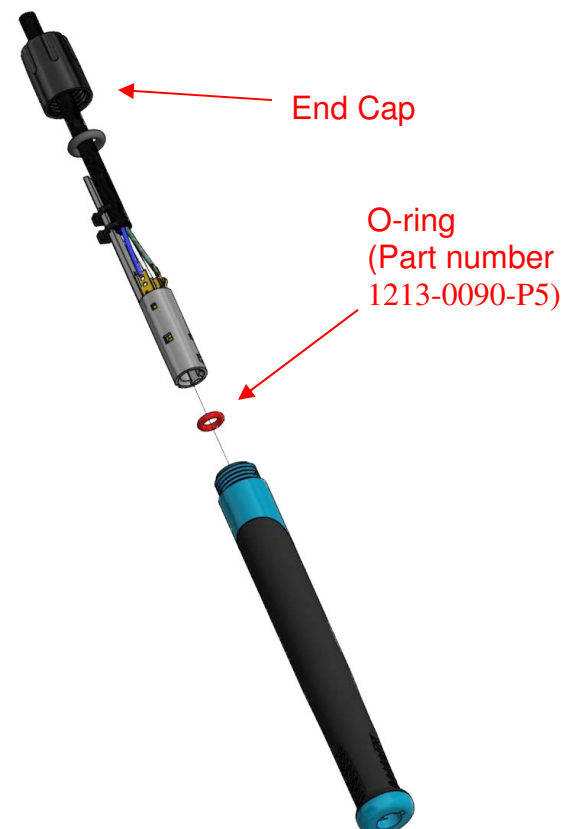
Tip cartridges can be changed at any time and without turning off the power to the unit.

Corrective Maintenance

The robust design of both the TD-200 and MT-200 allow for trouble free operation with only very minimal maintenance. The TD-200 handpiece contains a replaceable O-ring which protects the inner contact area from flux fumes or other contamination and helps secure the tip cartridge from coming out unexpectedly. The O-ring may need to be replaced over time due to age and wear. To replace the O-ring follow the procedure below:

1. Disconnect the TD-200 from the power source.
2. Remove the tip cartridge.
3. Unscrew the splined end cap from the back of the TD-200
4. Slide the connector assembly out of the handle.
5. Remove and replace the old O-ring from the connector assembly (Old "O-ring" may remain in handle.)
6. Reinstall the connector assembly. Be sure to line up the keyways on the handle and connector assembly. Do not force the connector assembly into the handle.
7. Reinstall the cap and make sure it is fully seated against the handle.
8. Install a tip cartridge.

The O-rings on the MT-200 do not need to be replaced.



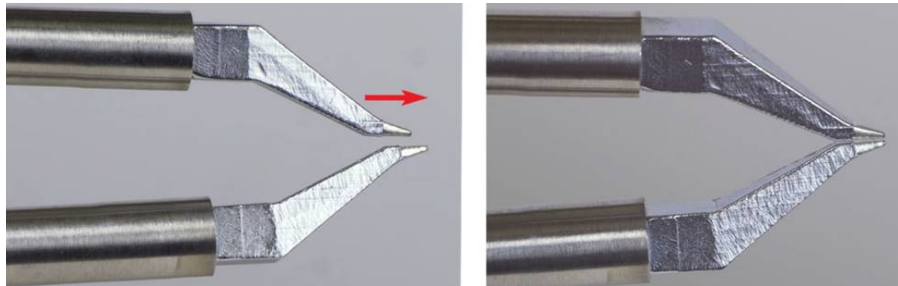
MT-200 Features

Tip-Gap Adjustment Wheel – Continuously adjustable tweezer tip spacing adjustment.

Tip Rotational (Theta) adjustment – For fine tuning the alignment of tips in the x, y and theta axis, for each side of the tweezer tool.

Tip Rotation Locking Screws – These #4-40 setscrews can be gently tightened using a 0.050" SAE hex key to prevent any theta rotation of the tips, but **use of these locking screws should NOT be necessary during normal operation**. If you must tighten these screws, be sure to loosen them after completing the job to prevent any damage which may occur if another operator attempts to adjust theta rotation while the screws are in the locked position.

Cool Touch™ Design – Aluminum construction helps dissipate heat for comfort during extended use.



Height (“z-axis”) spacing – Once the tip heater cartridges are fully seated into the MT-200 and aligned in x, y and theta, one cartridge can be slightly pulled out if necessary, to correct any remaining z-axis misalignment (1 mm max.)



Tips and Accessories

Tips and other accessories for the TD-200 and MT-200 are available directly from PACE via our website, or from any our Authorized PACE distributors.

TD-200 AccuDrive Tips: <https://paceworldwide.com/product-catalog/734>

MT-200 AccuDrive MiniTweez Tips: <https://paceworldwide.com/product-catalog/824>

Service

Please contact PACE or your local Authorized PACE Distributor for service and repair.

PACE WORLDWIDE LIMITED WARRANTY STATEMENT

Limited Warranty

Seller warrants to the first user that products manufactured by it and supplied hereunder are free of defects in materials and workmanship for a period of one (1) year from the date of receipt by such user. This Warranty as applied to blowers, motor pumps, x-ray tubes, lenses, optical/lighting probes and cameras is limited to a period of six (6) months. Monitors, computers and other brand equipment supplied but not manufactured by PACE are covered under their respective manufacturer's warranty in lieu of this Warranty.

This warranty does not cover wear and tear under normal use, repair or replacement required as a result of misuse, improper application, mishandling or improper storage. Consumable items such as tips, heaters, filters, etc. which wear out under normal use are excluded. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with Seller's directions, or removal or alteration of identification markings in any way will void this warranty. This warranty is available only to the first user, but the exclusions and limitations herein apply to all persons and entities.

SELLER MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

Seller will, at its option, repair or replace any defective products at its facility or other locations approved by it at no charge to user or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to Seller or other location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, SELLER WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE PRODUCTS, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE PRODUCTS.

Warranty service may be obtained by contacting PACE Worldwide or your local Authorized PACE Distributor to determine if return of any item is required, or if repairs can be made by the user in the field. Any warranty or other claim with respect to the products must be made with enough evidence of purchase and date of receipt, otherwise user's rights under this warranty shall be deemed waived.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.



www.paceworldwide.com

PACE Incorporated
346 Grant Road
Vass, NC 28394

Tel: (877) 882-PACE
Tel: (910) 695-7223
Fax: (910) 695-1594