CT-1701

OPERATION INSTRUCTIONS

Contour Crimp CONTROLLED CYCLE CRIMPING TOOL

Crimps Panduit #10 - #2 AWG non-insulated P series terminals and #14 - 10 AWG copper code conductor lugs. Includes 5-position, rotating die.

Provides UL Listed and CSA Certified terminations with applicable Panduit terminals.

Part No. CT-1701

OPERATION INSTRUCTIONS

Figure 2

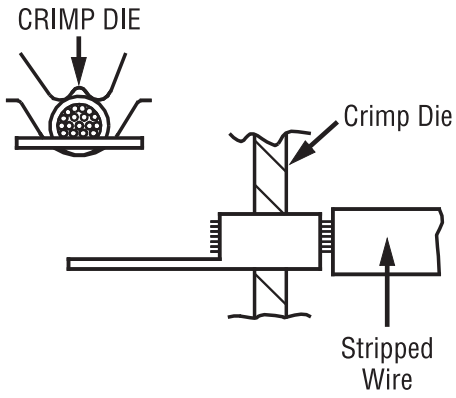
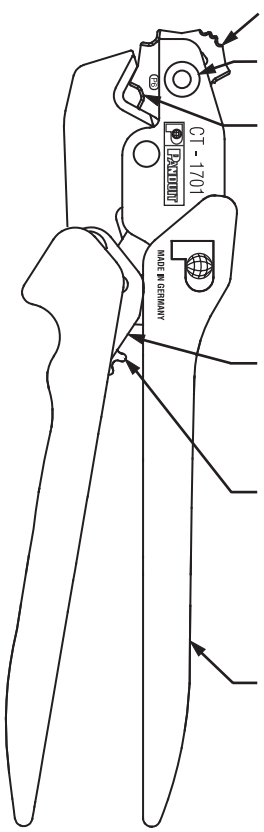


Figure 1



CAUTION: Verify power is "OFF" before working on wiring with this tool. The cushioned grips are for the user's comfort, and are not intended to insulate against shock while working on live electrical circuits.

COPPER COMPRESSION CONNECTOR CRIMPING INSTRUCTIONS

1. With the handles in the ***open*** position, depress die release and rotate die to desired pocket. The pocket will lock in place when an audible "click" is heard (Die index number appears to the left of corresponding pocket).

   CAUTION: Do not cycle tool unless the die release button has seated and the die has locked in place.

   Refer to product packaging for selection of the proper crimp pocket. Place the desired compression connector in the crimp pocket (See Fig. 2).

2. Close handles until the connector is held snugly in position—do not deform the barrel.
3. Insert the stripped wire into the connector until the wire stops. Refer to product packaging for wire strip length.
4. Crimp the connector by closing the handles until the controlled cycle mechanism releases. Repeat this operation for the compression connectors that require more than one compression. Upon release, the handles will open automatically and the crimped connector can be removed.

   After crimping, inspect that the crimp is centered on the barrel in order to achieve optimal pullout performance.

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INSPECTION / MAINTENANCE

NEW TOOLS -
BEFORE PLACING INTO SERVICE:

All Panduit crimping tools are calibrated and inspected before they are shipped from the factory. All new tools should be inspected before being used.

New tools are shipped, factory lubricated, in protective packaging. After inspection, simply clean any excess oil from the crimping dies and place into service.

When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping area. Store the tool in a clean, dry area.

IN-SERVICE TOOLS -
AFTER TOOLS HAVE BEEN IN SERVICE:

It is recommended that each operator of the tool be made aware of-and responsible for following these maintenance steps.:

In-service tools should be cleaned and inspected at least ONCE A MONTH. To clean-wipe with a clean cloth.

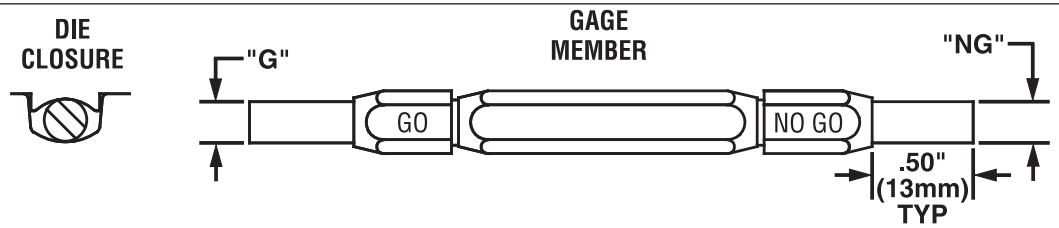
In-service tools should be lubricated ONCE A WEEK, and after every cleaning. Lubricate all pins, pivots and bearing surfaces with DOW CORNING® Molykote BR2 Plus. Do not use oil excessively.

Be sure to clean any excess oil from the crimping dies before using.

® Molykote BR2 Plus is the Registered Trademark of DOW CORNING

Table 1

DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1701



DIE INDEX NUMBER	ENGLISH GO / NO GO GAGE MEMBERS		METRIC GO / NO GO GAGE MEMBERS	
	"G" Dia. (GO)	"NG" Dia. (NO GO)	"G" Dia. (GO)	"NG" Dia. (NO GO)
P10	0.099"	0.109"	2,51 mm	2,76 mm
P8	0.179"	0.201"	4,54 mm	5,10 mm
P6	0.217"	0.238"	5,51 mm	6,04 mm
P4	0.273"	0.295"	6,93 mm	7,49 mm
P2	0.351"	0.374"	8,91 mm	9,49 mm

1. Clean the crimping dies and gage member surfaces.
2. Close the tool handles until the crimping dies are bottomed and the controlled cycle mechanism releases. Keep the handles closed together.
3. Using the appropriate gage member, attempt to insert the NO GO gage into the die opening. The NO GO side may partially enter the die closure but must NOT pass completely through. Perform this test for all three crimp pockets.
4. Repeat Step 3 with the appropriate GO gage for all three crimp pockets. The GO side must enter and pass completely through the die closures.
5. If both gage conditions are met, the tool is dimensionally correct. If either condition fails, contact Panduit Tool Division Tool Service, or Panduit EMEA Service Center for technical assistance.

DIE CLOSURE INSPECTION

Die closure is measured by using GO/NO GO gage members (dimensions listed in Table 1).

VISUAL INSPECTION

1. Visually inspect the tool for missing or loose pins, then close the tool and note the return action of the handles.
2. Inspect the crimping dies for worn, chipped or broken edges.
3. If parts are missing, defective or damaged, contact your local Panduit Sales Office for information on repair or replacement of tools.

TROUBLESHOOTING

PRELOAD FORCE INSPECTION

1. Close the handles until the controlled cycle mechanism is engaged, but before the mechanism releases.
2. Apply a force to the handles 1-1/4" (32 mm) from the end of the handles, until the controlled cycle release mechanism releases. Record the reading using a force gauge.
3. The force required to release the controlled cycle release mechanism should be a ***minimum*** of 15 pounds-force (67 N). If the force required is less than 15 pounds-force (67 N), contact Panduit Tool Division Tool Service, or Panduit EMEA Service Center for technical assistance.