

OPERATION INSTRUCTIONS

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Contour Crimp CONTROLLED CYCLE CRIMPING TOOL

Crimps Panduit #26-#22 AWG insulated terminals/splices, #22-#10 AWG fully insulated disconnects/insulated parallel splices; and specific #22-14 AWG barrel insulated disconnects.

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

Part No. CT-1525 OPERATION MANUAL

INSULATED TERMINAL CRIMPING INSTRUCTIONS

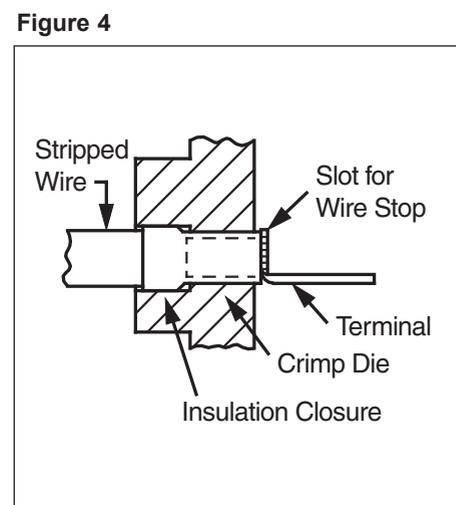
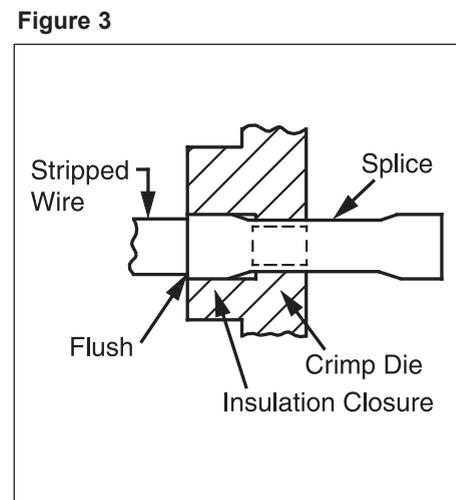
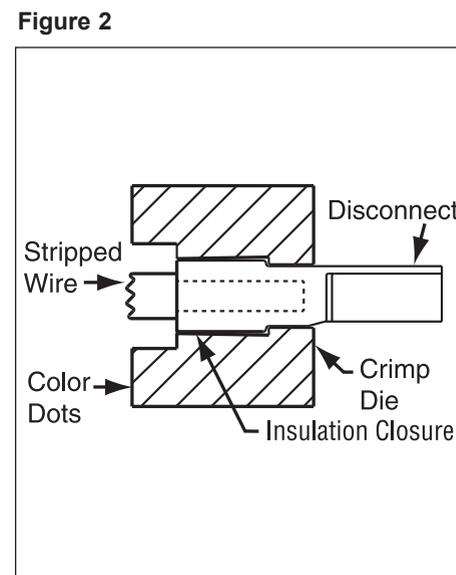
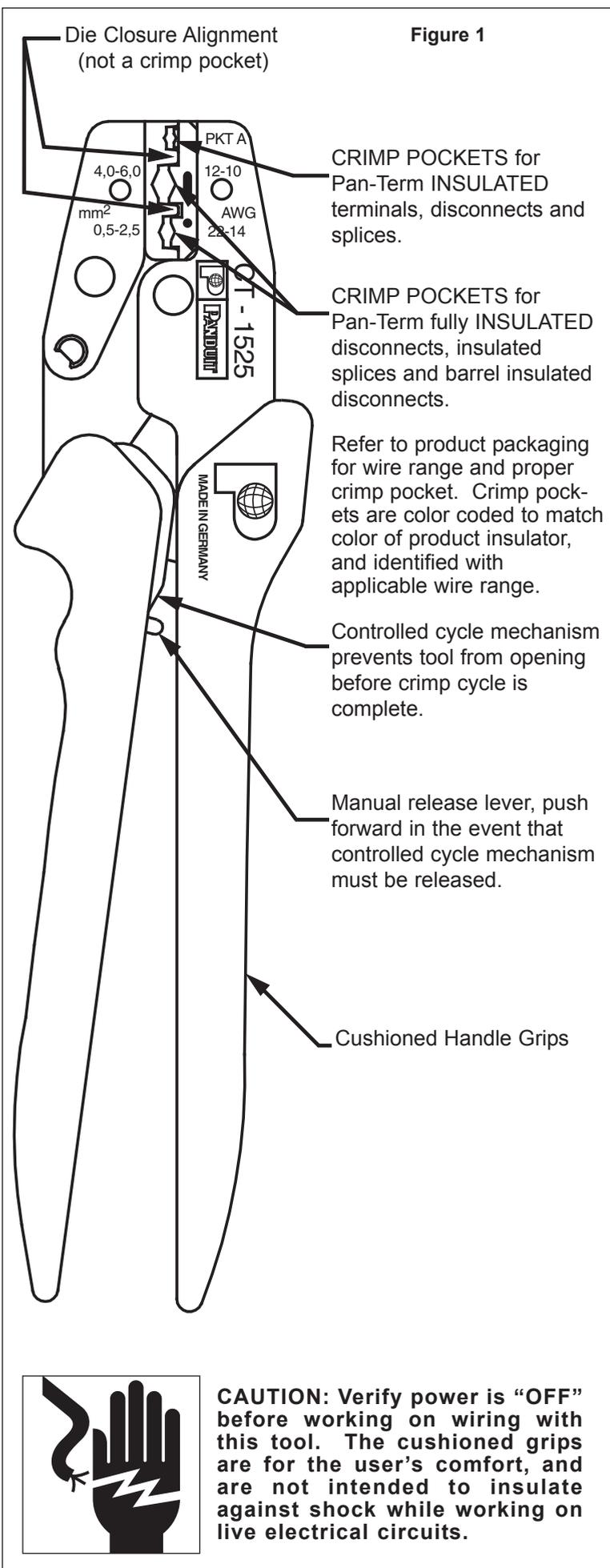
1. With the handles in the **open** position, and the back of the terminal tongue turned toward the color dots, insert the terminal into the proper crimp pocket (See Figure 1). Refer to product packaging for selection of proper crimp pocket.
2. Close handles until the barrel is held snugly in position — do not deform the barrel.
3. Insert the stripped wire into the terminal until the wire stops. Refer to product packaging for wire strip length.
4. Crimp the terminal by closing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped terminal can be removed.

NOTE: Visual inspection dots (formed by the crimp dies) on the insulation sleeve verify proper crimp cycle.

- One (1) dot for PKT A crimp pocket
- Two (2) dots for red and blue crimp pocket
- Three (3) dots for yellow crimp pocket

INSULATED DISCONNECT CRIMPING INSTRUCTIONS

1. With the handles in the **open** position, insert the disconnect in the proper crimp pocket (See Figure 1), so that the barrel is flush with the crimp die (See Figure 2). Refer to product packaging for selection of proper crimp pocket.
2. Close the tool handles until the barrel is held snugly in place—do not deform the barrel.
3. Insert the stripped wire into the disconnect. Refer to product packaging for wire strip length. Crimp the disconnect by closing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped disconnect can be removed. *After crimping, inspect that the crimp is centered on the disconnect barrel in order to achieve optimal pullout performance.*



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INSULATED SPLICE CRIMPING INSTRUCTIONS

1. With the handles in the *open* position, insert the splice into the proper crimp pocket (See Figure 1) so that the crimp is located on the barrel of the splice (See Figure 3). Refer to product packaging for selection of proper crimp pocket.
2. Close the handles until the barrel is held snugly in position — do not deform the barrel.
3. Insert the stripped wire into the splice until the wire stops. Refer to product packaging for wire strip length. Crimp the splice by closing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped splice can be removed.
4. Remove the splice and repeat operation for crimping the other end of the splice.

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

TROUBLESHOOTING

DIE CLOSURE INSPECTION

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

Table 1

| DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1525 | | | | |
|---|---------------------------------|-------------------|--------------------------------|-------------------|
| | 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) |
| Pocket "A" | .065" | .073" | 1,65 mm | 1,85 mm |
| 22-14 / 0,5-2,5 | .076" | .084" | 1,93 mm | 2,13 mm |
| 12-10 / 4,0-6,0 | .100" | .108" | 2,54 mm | 2,74 mm |

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.

PRELOAD FORCE INSPECTION

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.
1. Close the handles until the controlled cycle mechanism is engaged, but before the mechanism releases.
 2. Apply force to the handles 1-1/4" (32mm) 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 Department, or Panduit EMEA Service Center for technical assistance.