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ELECTRICAL GROUP

17301 Ridgeland Ave., Tinley Park, IL 60477-3091

Phone (708)532-1800 • Fax (708)532-1811

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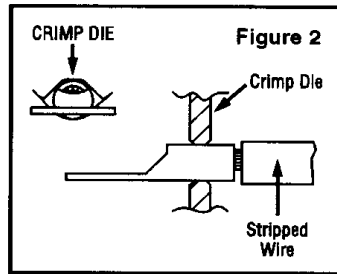
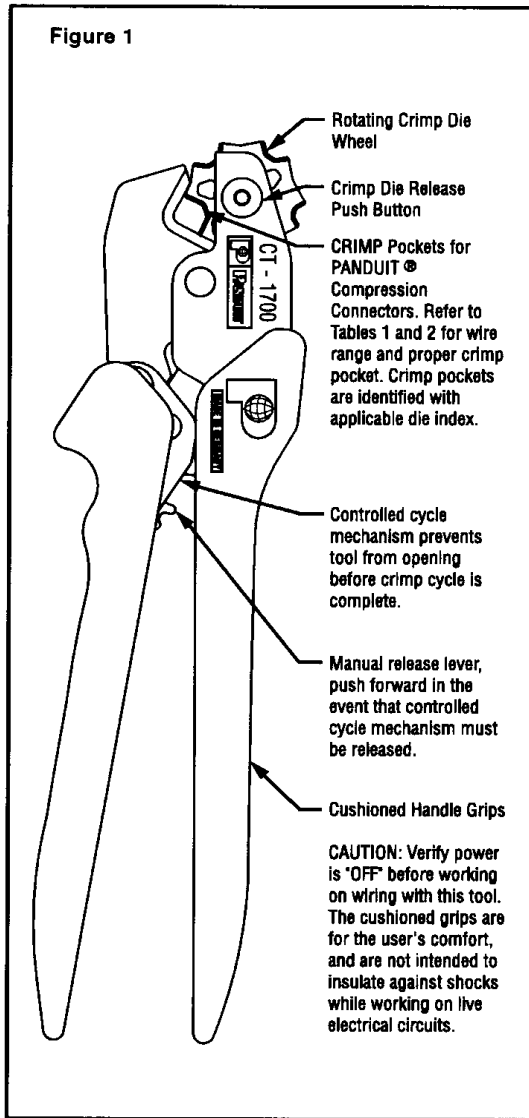
## ***CONTOUR CRIMP***™ **CONTROLLED CYCLE CRIMPING TOOL**

**Crimps PANDUIT #8-#1 AWG  
copper lugs and splices, #6-#4  
AWG aluminum lugs and splices,  
and #8-#2 AWG non-insulated  
S series tubular terminals.**

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

**Part No. CT-1700  
OPERATION MANUAL**

# 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 and color appear 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 Table 1 for selection of the proper crimp pocket. Place the desired compression connector in the crimp pocket (See Figure 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 Table 1 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. Refer to Table 1 for number of crimps. Upon release, the handles will open automatically and the crimped connector can be removed.

# COPPER COMPRESSION CONNECTOR CRIMPING INSTRUCTIONS CONT'D

Table 1

PRODUCT INFORMATION TABLE - TOOL NO. CT-1700						
Die Color/ Index Number	Type	COPPER PAN-TERM® Terminal or Power Connector Part Number Series	AWG Wire		Number of Crimps	
			Size	Strip Length +1/32; -0 (in.)		
Red P21	Ring Terminals	S8-R	8	7/16	2	
	Lugs & Splices	LCAS8, SCSS8		7/16	2	
		LCA8, LCD8, LCA8		9/16	2	
		SCS8		11/16	2	
		LCB8, LCC8		11/16	3	
SCL8	1-1/16	3				
Blue P24	Ring Terminals	S6-R	6	1/2	2	
	Lugs & Splices	LCAS6		1/2	2	
		LCA6, LCD6, SCS6		13/16	2	
		SCSS6		7/16	2	
		LCB6, LCC6, LCBH6		1-1/16	3	
SCL6, SCH6	1-1/8	3				
Grey P29	Ring Terminals	S4-R	4	1/2	2	
	Lugs & Splices	LCAS4		9/16	2	
		LCA4, LCD4, SCS4, LCA4		13/16	2	
		SCSS4		7/16	2	
		LCB4, LCC4, LCBH4		1-1/16	3	
SCL4, SCH4	1-1/8	3				
Brown P33	Lugs & Splices	LCAS2, SCSS2	2	9/16	2	
		LCA2, LCD2, SCS2, LCA2		7/8	2	
		LCB2, LCC2, LCBH2		1-3/16	3	
SCL2, SCH2	1-1/4	3				
Green P37	Ring Terminals	S2-R	1	2&1	5/8	2
	Lugs & Splices	LCAS1		5/8	3	
		LCA1, LCD1, SCS1, LCA1		7/8	3	
		SCSS1		11/16	3	
LCB1, LCC1, SCL1, LCBH1, SCH1	1-3/8	4				

Provides U.L. Listed and C.S.A. Certified terminations where applicable. Chart provided for reference only. Consult product packaging or contact factory to confirm UL/CSA approved product/tooling/wire combinations.

## ALUMINUM 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 and color appear 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 Table 2 for selection of the proper crimp pocket. Place the desired compression connector in the crimp pocket (See Figure 2).

2. Close handles until the connector is held snugly in position—do not deform the barrel.
3. Remove end plug(s). Insert the stripped wire into the connector until the wire stops. Refer to Table 2 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. Refer to Table 2 for number of crimps. Upon release, the handles will open automatically and the crimped connector can be removed.

**Table 2**

PRODUCT INFORMATION TABLE - TOOL NO. CT-1700					
Die Color/ Index Number	Type	ALUMINUM Power Connector Part Number Series	AWG Wire		Number of Crimps
			Size	Strip Length +1/32; -0 (in.)	
Grey P29	Lugs & Splices	LAA6	6	1	5
		SA6		3/4	5
Green P37	Lugs & Splices	LAA4	4	1-1/16	5
		SA4		7/8	5

Provides U.L. Listed and C.S.A. Certified terminations where applicable. Chart provided for reference only. Consult product packaging or contact factory to confirm UL/CSA approved product/tooling/wire combinations.

## INSPECTION / MAINTENANCE

### NEW TOOLS - BEFORE PLACING INTO SERVICE:

1. CLEAN AND INSPECT THE TOOL FOR DAMAGE.
2. CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.

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.

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

1. CLEAN AND VISUALLY INSPECT FOR DAMAGE ONCE A MONTH.
2. LUBRICATE THE TOOL ONCE A WEEK.
3. CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.

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

® Molykote BR2 Plus is the Registered Trademark of DOW CORNING

### 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.

## DIE CLOSURE INSPECTION

Die closure is measured by using the GO/NO GO gage members (dimensions listed in Table 3).

**Table 3**

DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1700		
DIE COLOR/ INDEX NUMBER	GO / NO GO GAGE MEMBERS	
	"G" Dia. (GO)	"NG" Dia. (NO GO)
Red P21	0.177"	0.201"
Blue P24	0.219"	0.239"
Grey P29	0.255"	0.276"
Brown P33	0.324"	0.348"
Green P37	0.347"	0.368"

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 must NOT pass through the die closure. Perform this test for all five crimp pockets.
4. Repeat Step 3 with the appropriate GO gage for all five 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.