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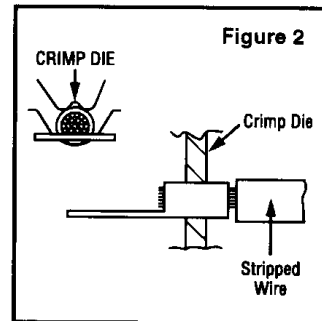
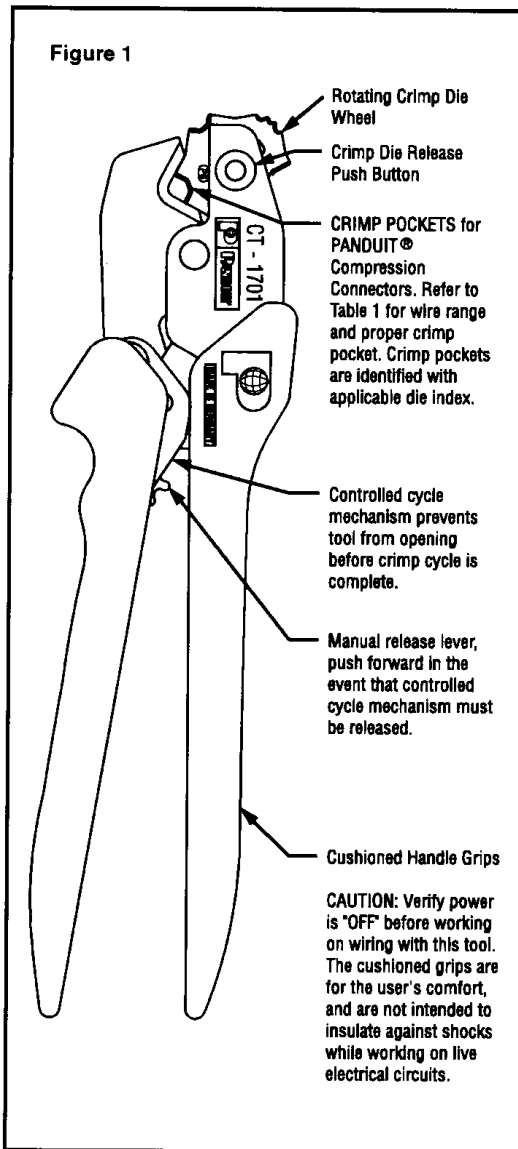
## **CONTOUR CRIMP™ CONTROLLED CYCLE CRIMPING TOOL**

**Crimps PANDUIT #10-#2 AWG  
non-insulated P series terminals,  
and #12-#4 non-insulated P  
series heavy duty ring terminals.**

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

**Part No. CT-1701  
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 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 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.

Table 1

PRODUCT INFORMATION TABLE - TOOL NO. CT-1701					
Die 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.	
P10	Terminals	P10-R, F, FF, LF, SLF*, P55, RHT6 P12-HDR	12-10	9/32	1
	Disconnects	D10-250, 250M, DR10-250			
	Splices	BS10			
P8	Ring Terminals	P8-R, HDR	8	3/8	2
P6	Ring Terminals	P6-R, HDR	6	7/16	2
P4	Ring Terminals	P4-R, HDR	4	1/2	2
P2	Ring Terminals	P2-R	2	7/16	2

\*Butted Seam

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.	All Panduit crimping tools are calibrated and inspected before they are shipped from the factory. All new tools should be inspected before being used.
2. CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.	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.	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.
2. LUBRICATE THE TOOL ONCE A WEEK.	
3. CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.	

® 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

### DIE CLOSURE INSPECTION

Die closure is measured by using the GO/NO GO gage members (dimensions listed in Table 2).

Table 2

DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1701		
DIE INDEX NUMBER	GO / NO GO GAGE MEMBERS	
	"G" Dia. (GO)	"NG" Dia. (NO GO)
P10	0.099"	0.109"
P8	0.179"	0.201"
P6	0.217"	0.238"
P4	0.273"	0.295"
P2	0.351"	0.374"

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.

### 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" (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.