



CT-1550

OPERATION INSTRUCTIONS

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Contour Crimp CONTROLLED CYCLE CRIMPING TOOL

Crimps most Panduit #22-#10 AWG insulated terminals & splices; and specific insulated disconnects. Reduced crimp effort advantage for #22-#14 AWG terminations.

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

Part No. CT-1550

OPERATION INSTRUCTIONS

INSULATED TERMINAL CRIMPING INSTRUCTIONS

1. With the handles in the **closed** position, (See Figure 1), rotate the locator until the narrow slot is centered between the crimp pockets (See Figure 2). The locator will detent and “lock” in this position. Squeeze the handles to open the tool. With the back of the terminal tongue turned toward the color dots, insert the terminal in the proper crimp pocket (See Figure 1) so that the tongue slides into the locator slot (See Figure 3). Refer to product packaging for selection of proper crimp pocket.
2. Hold the terminal against the locator and close the handles until the barrel is held snugly in place—do not deform the barrel.
3. Insert the stripped wire into the terminal until the wire stops in the recessed slot in the locator. 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.

- Two (2) dots for red and blue crimp pocket
- Three (3) dots for yellow crimp pocket.

INSULATED SPLICE AND FULLY INSULATED DISCONNECT CRIMPING INSTRUCTIONS

1. With the handles in the **open** position, swing the locator out of the way (See Figure 4). The locator will detent and “lock” in this position. For splices, insert the splice in the proper crimp pocket (See Figure 1) so that the crimp is located on the barrel of the splice (See Figure 5). For fully insulated disconnects, insert the disconnect in the proper crimp pocket (See Figure 1) so that the crimp is located on the barrel of the disconnect (See Figure 6). 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 barrel until the wire stops. Refer to product packaging for wire strip length. Crimp by closing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped splice or disconnect can be removed. **After crimping, inspect that the crimp is centered on the disconnect barrel in order to achieve optimal pullout performance.**
4. For splices, remove the splice and repeat operation for crimping the other end of the splice.

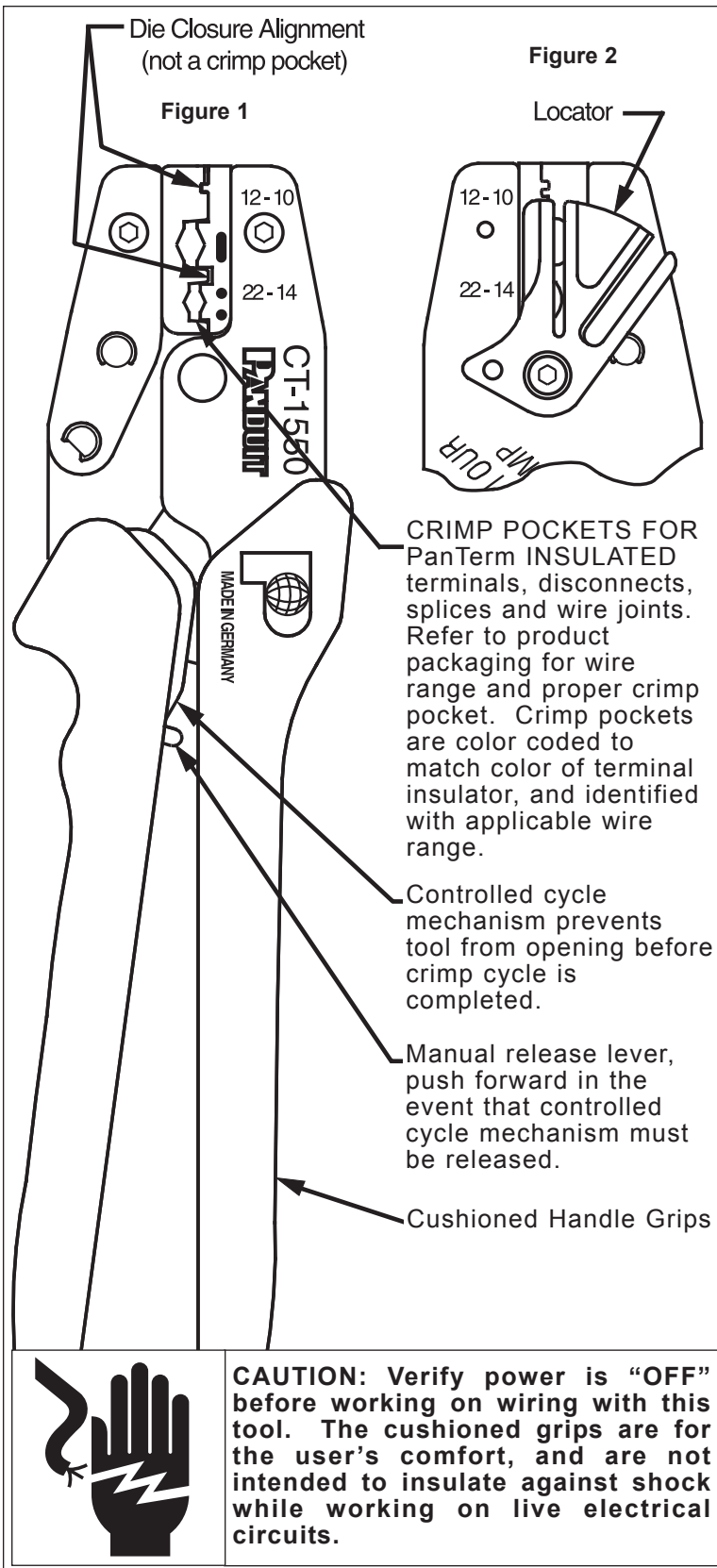


Figure 3

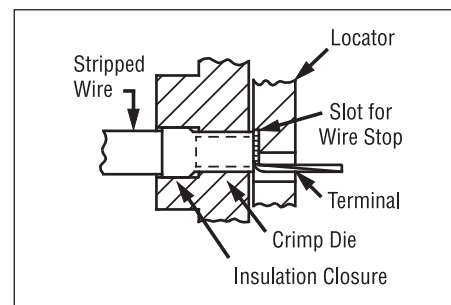


Figure 4

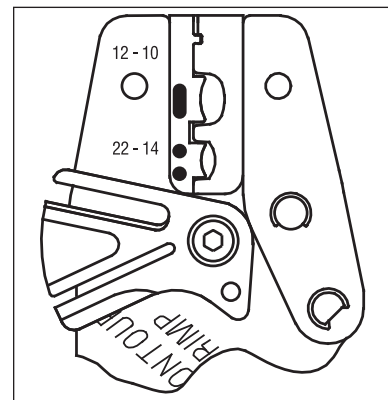


Figure 5

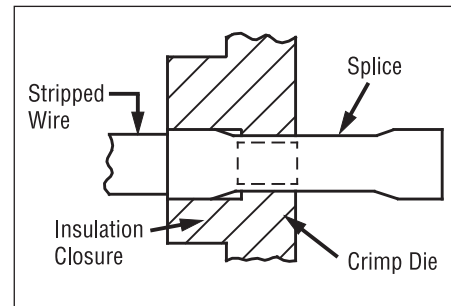


Figure 6

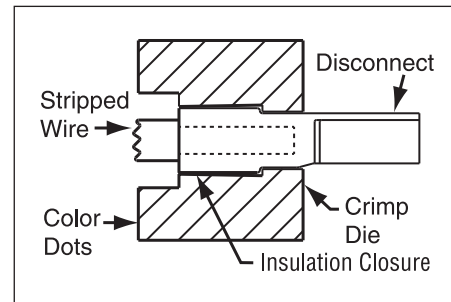
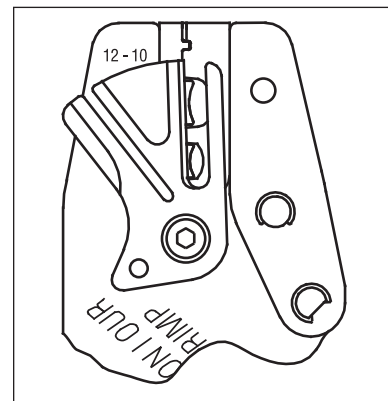


Figure 7



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INSULATED WIRE JOINT CRIMPING INSTRUCTIONS

1. Twist the ends of the stripped wire together, trim and set aside. Refer to product packaging for wire strip length.
2. With the handles in the **open** position, swing the locator out of the way (See Figure 4). The locator will detent and “lock” in this position. Insert the wire joint from the back (locator) side of the crimp tool in the proper crimp pocket (See Figure 1) so that the ribs of the molded insulator (where applicable) are positioned against the crimp die (See Figure 9). Refer to product packaging for selection of proper crimp pocket.
3. Close the handles until the barrel is held snugly in position—do not deform the barrel.
4. Insert the prepared wires into the wire joint. Crimp the wire joint by closing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped joint can be removed.

INSULATED DISCONNECT CRIMPING INSTRUCTIONS

1. With the handles in the **closed** position, (See Figure 1), rotate the locator until the wide slot is centered between the crimp pockets (See Figure 7). The locator will detent and “lock” in this position. Squeeze the handles to open the tool. With the back of the disconnect tongue turned toward the color dots, insert the disconnect in the proper crimp pocket (See Figure 1) so that the tongue slides into the locator slot (See Figure 8). Refer to product packaging for selection of proper crimp pocket.
2. Hold the disconnect against the locator and close the 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.

Figure 8

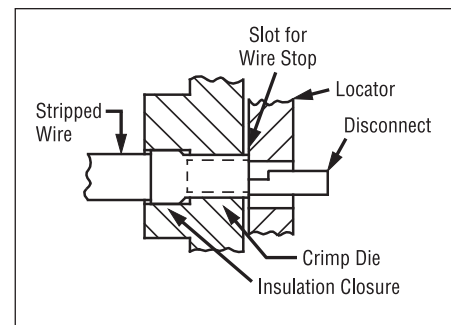
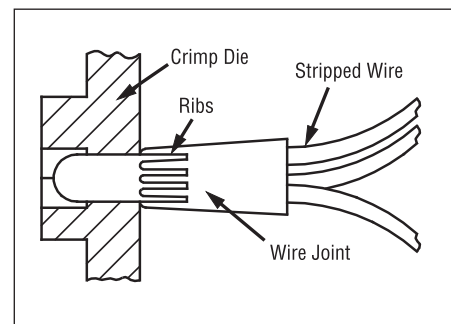


Figure 9



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.

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TROUBLESHOOTING

DIE CLOSURE INSPECTION

Die closure is measured by using pin gages (dimensions listed in Table 1).

Table 1

DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1550		
CRIMP POCKET	“G” Dia. (GO)	“NG” Dia. (NO GO)
22 - 14	0.101	0.109
12 - 10	0.147	0.155

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 both crimp pockets.
4. Repeat Step 3 with the appropriate GO gage for both 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 Service, or Panduit EMEA Service Center for technical assistance.

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. Swing the locator out of the way (See Figure 4), and 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. 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 Service, or Panduit EMEA Service Center for technical assistance.