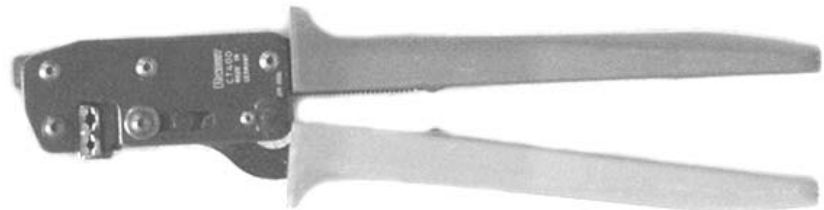


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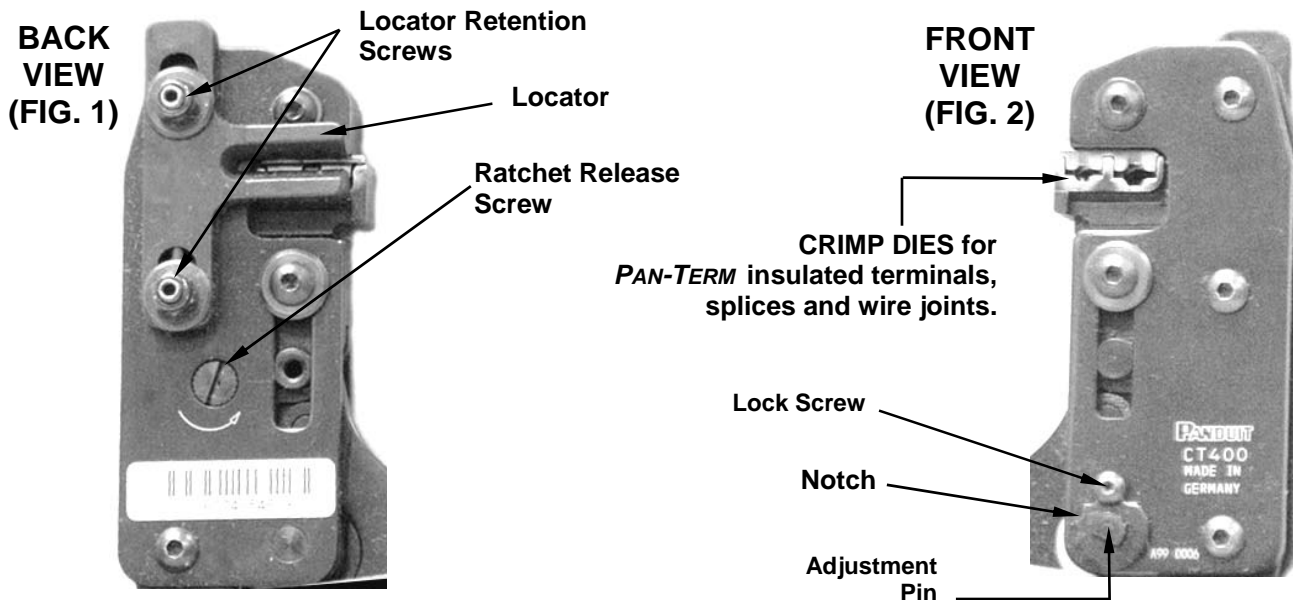
NEW TOOLS – BEFORE PLACING INTO SERVICE

- | | |
|--|---|
| 1. VISUALLY INSPECT TOOL FOR DAMAGE. | All <i>PANDUIT</i> crimping tools are calibrated and inspected before they are shipped from the factory. There is, however, a possibility of damage in shipment. All new tools should therefore be inspected before being used. |
| 2. CHECK DIE CLOSURE | |
| 3. CLEAN EXCESS OIL FROM CRIMP DIES AND USE. | New tools are shipped factory lubricated. They do not require extensive cleaning. After inspection, simply clean any excess oil from the crimping dies and place into service. |

CAUTION: Verify power is “OFF” before working on wiring with this tool. The plastic grips are for the user’s comfort—and are not intended to insulate against shock while working on live electrical circuits.



WARNING: Controlled cycle device prevents tool from opening before cycle is completed. Keep hands and other objects clear of pinch areas before closing.



ATTENTION: TO DISENGAGE CONTROLLED CYCLE DEVICE:
Turn the ratchet release screw counterclockwise and open handles.
The controlled cycle device will automatically reset after screw is released.

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INSULATED TERMINAL INSTRUCTIONS

1. With handles in open position, insert terminal in proper size die so that tongue slides into locator slot. See product packaging for proper crimping pockets.
2. Position terminal against locator and close handles until barrel is held snugly in place -- do not deform barrel.
3. Insert stripped wire into terminal until conductor extends beyond barrel. See product packaging for wire strip length.
4. Crimp by closing handles until controlled cycle device releases. Handles will open automatically and crimped terminal may be removed.

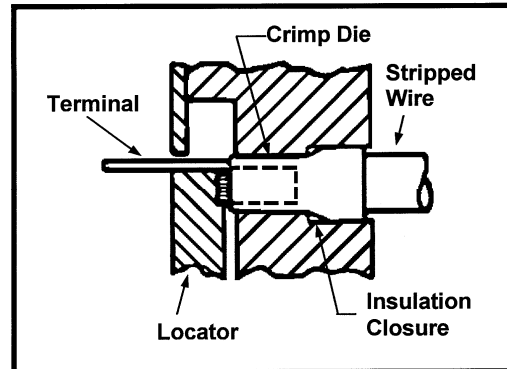


FIG. 3

INSULATED SPLICE INSTRUCTIONS

1. Remove locator using a 2mm Allen wrench on the locator retention screws [see Fig. 1]. *(The 2.5mm wrench may be used simultaneously to secure screws on opposite side.)*
2. With locator removed and handles opened, insert splice in proper size die so that barrel extends 1/16" beyond insulation closures.
3. Close handles until barrel is held snugly in position - do not deform barrel.
4. Insert stripped wire into splice and crimp by closing handles until controlled cycle device releases.
5. Remove splice and repeat operation for crimping other half of barrel.

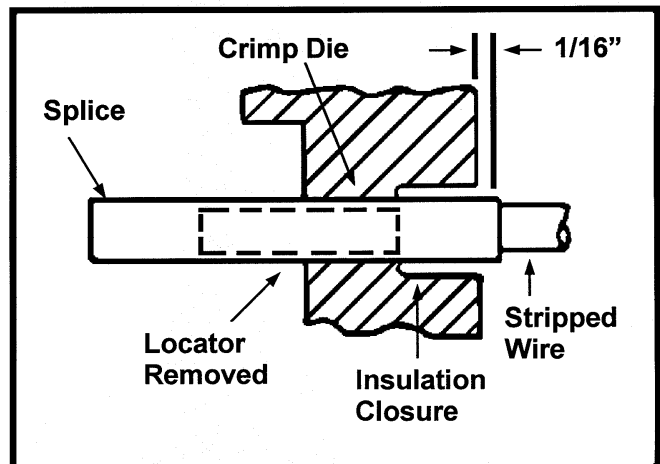


FIG. 4

INSULATED WIRE JOINT INSTRUCTIONS

1. Remove locator using a 2mm Allen wrench on the locator retention screws [see Fig. 1]. *(The 2.5mm wrench may be used simultaneously to secure screws on opposite side.)*
2. With terminal locator removed, insert wire joint in proper size die so that ribs of molded insulator are positioned against face of tool.
3. Twist ends of stripped wire together, trim and insert into wire joint.
4. Crimp by closing handles until controlled cycle device releases. Handles will open automatically and crimped joint may be removed.

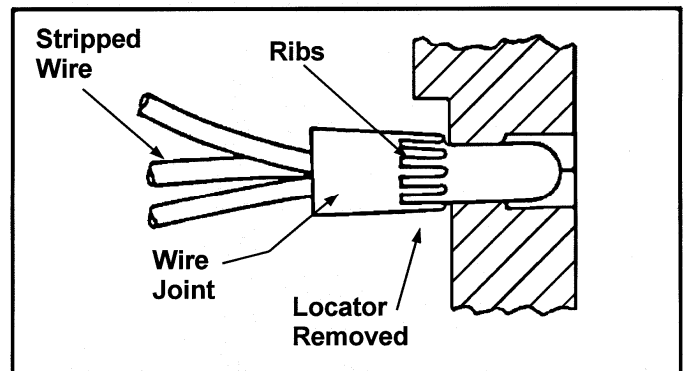


FIG. 5

**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---immerse in a commercial degreasing compound and wipe clean with a lint free cloth. If a degreasing compound is not available, wipe with a clean cloth.
2. CHECK DIE CLOSURE	After cleaning, inspect the crimping dies for proper die closure. See Fig. 6 for plug gaging instructions.
3. LUBRICATE TOOL ONCE A WEEK.	In-service tools should be lubricated ONCE A WEEK, and after every cleaning. Lubricate all pins, pivots and bearing surfaces with a good grade S.A.E. 20 or equivalent motor oil. Be sure to clean any excess oil from crimping dies before using.
4. CLEAN EXCESS OIL FROM CRIMP DIES AND USE.	

VISUAL INSPECTION

1. Visually inspect tool for missing or loose pins; then close the tool and note the return action of the handles.
2. Remove the terminal locator and visually inspect the crimping dies for worn, chipped or broken surfaces. Damaged crimping dies are objectionable and may go undetected when gaging the die closure.
3. If parts are missing, defective or damaged; contact your local *PANDUIT* Sales Office for information on repair or replacement of tools.

DIE CLOSURE INSPECTION: CT-400

Die Closure inspection is made by using the GO/NO-GO gaging dimensions listed in Fig. 6.

TO PERFORM DIE CLOSURE INSPECTION

- A. Clean die and plug gage surfaces.
- B. Close tool handles until crimping jaws are bottomed and handles are fully closed.
- C. Using the proper gage member, insert the GO side into the die – it must pass completely through the closure.
- D. Reverse the gage and try to insert the NO-GO side into the die closure (Do Not use excessive force). The NO-GO side may partially enter the die closure but must not pass completely through.
- E. Perform the above procedure for both the crimp die closure and the insulation die closure, as listed in Fig. 6.



- F. If both the GO and NO-GO conditions are met; the tool is dimensionally correct – if either condition fails, adjust the DIE CLOSURE as follows:
1. Remove lock screw with small wrench [see Fig. 2].
 2. With adjustment wrench provided, turn adjustment pin one notch – each notch produces approximately .002” of adjustment. A clockwise turn increases the die closure and a counter-clockwise turn decreases the die closure.
 3. Close the tool and plug gage the die closure as instructed above. If the GO/NO-GO conditions are not met, repeat Step (2) in one-notch increments until the tool is gages to be dimensionally correct. Replace and tighten both lock screws after final adjustment.
- G. If the above procedure fails to satisfy all GO and NO-GO conditions, contact your local *PANDUIT* Sales Office.

FIG. 6

POCKET SIZE	CRIMP DIE CLOSURE GAGING		GAGE ELEMENT DIAMETERS	
	GO	NO-GO	GO	NO-GO
22-18 RED	0.096	0.106	0.0960 - 0.0963	0.1057 - 0.1060
16-14 BLUE	0.114	0.124	0.1140 - 0.1143	0.1237 - 0.1240

POCKET SIZE	INSULATION DIE CLOSURE GAGING		GAGE ELEMENT DIAMETERS	
	GO	NO-GO	GO	NO-GO
22-18 RED	0.100	0.116	0.1000 - 0.1003	0.1157 - 0.1160
16-14 BLUE	0.142	0.158	0.1420 - 0.1423	0.1577 - 0.1580