

### Contour Crimp CONTROLLED CYCLE CRIMPING TOOL

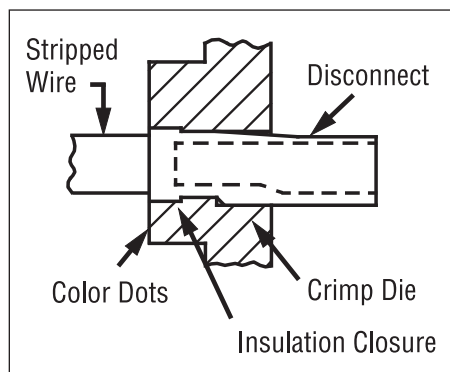
**Crimps Panduit #20-#14 AWG  
Disco-Lok Locking  
Female Disconnects.**

Provides UL Listed and CSA Certified terminations where applicable.

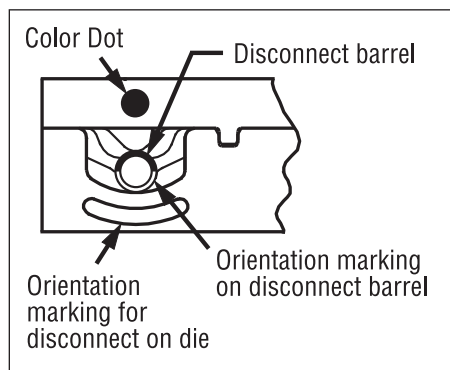
### Part No. CT-1014 OPERATION INSTRUCTIONS

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). Rotate the disconnect until the marking on the barrel is in line with the white arch marking on the crimp die (See Figure 3). Refer to Table 1 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 disconnect. Refer to Table 1 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.

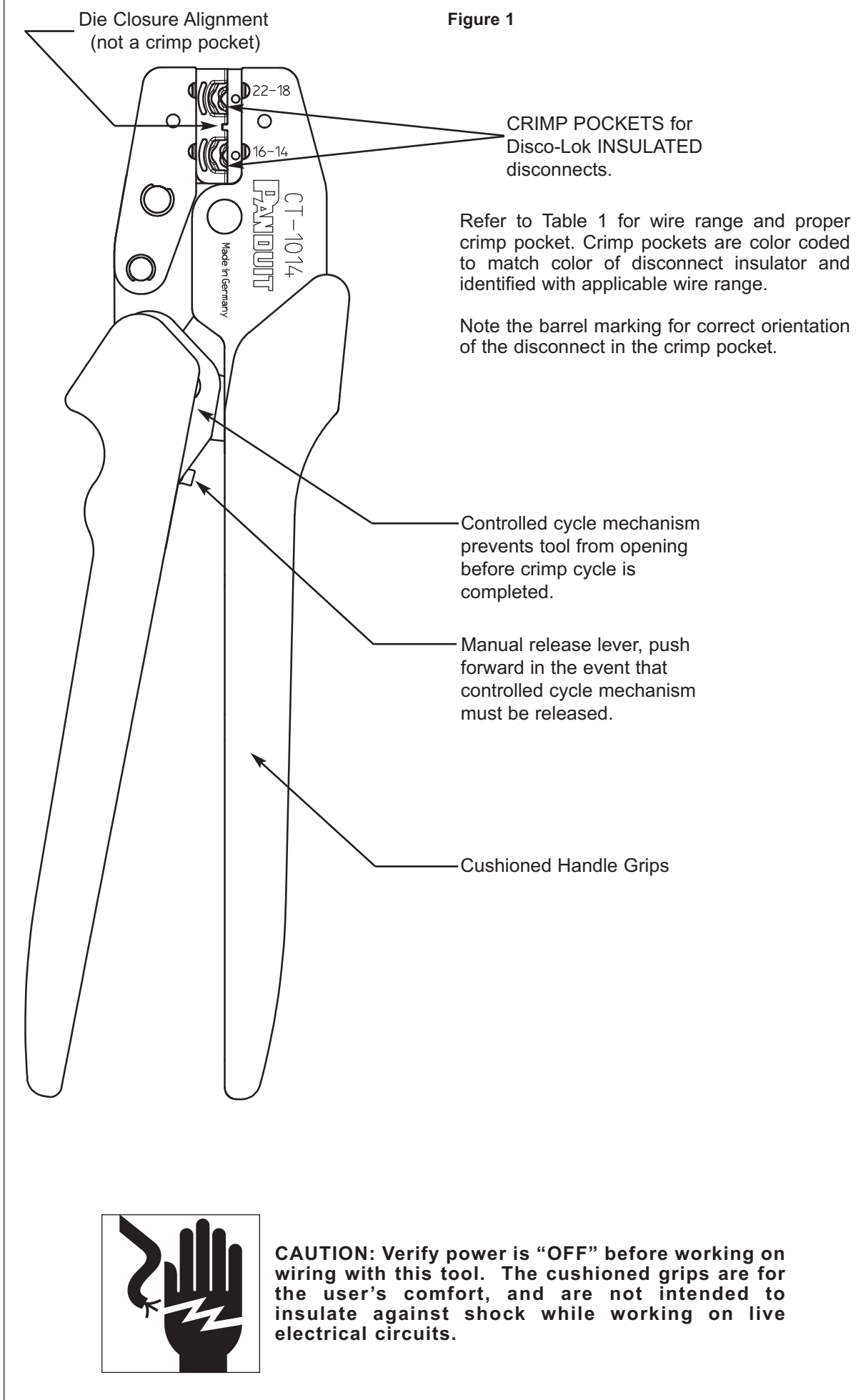
**Figure 2**



**Figure 3**



**Figure 1**



**CAUTION:** Verify power is "OFF" before working on wiring with this tool. The cushioned grips are for the user's comfort, and are not intended to insulate against shock while working on live electrical circuits.

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Table 1

PRODUCT INFORMATION TABLE - TOOL NO. CT-1014				
Crimp Pocket/Color Guide	Type	Disco-Lok Disconnect Part Number Series	AWG Wire Range	Strip Length +1/32; -0 in.
22 - 18 / Red	Disconnects	DNG18-250FL	20 - 18	1/4
16 - 14 / Blue	Disconnects	DNG14-250FL	16 - 14	1/4

Provides UL Listed and CSA 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:

- 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.
- 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.  
  
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:

- CLEAN AND VISUALLY INSPECT THE TOOL FOR DAMAGE ONCE A MONTH.** 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.
  - LUBRICATE THE TOOL ONCE A WEEK.**
  - CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.**
- ® 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 2).

Table 2

DIE CLOSURE GO / NO GO GAGE MEMBERS - TOOL NO. CT-1014				
CRIMP POCKET AWG / mm <sup>2</sup>	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)
22-18 / 0,5-1,0	.077"	.087"	1,96mm	2,21mm
16-14 / 1,5-2,5	.093"	.103"	2,36mm	2,62mm

- Clean the crimping dies and gage member surfaces.
- Close the tool handles until the crimping dies are bottomed and the controlled cycle mechanism releases. Keep the handles closed together.
- 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.
- Repeat Step 3 with the appropriate GO gage for both crimp pockets. The GO side must enter and pass completely through the die closures.
- If both gage conditions are met, the tool is dimensionally correct. If either condition fails, contact Panduit Customer Service, or Panduit EMEA Service Center for technical assistance.

### VISUAL INSPECTION

- Visually inspect the tool for missing or loose pins, then close the tool and note the return action of the handles.
- Inspect the crimping dies for worn, chipped or broken edges..
- If parts are missing, defective or damaged, contact Panduit Customer Service, or Panduit EMEA Service Center for information on repair or replacement of tools.

### PRELOAD FORCE INSPECTION

- Close the handles until the controlled cycle mechanism is engaged but before the mechanism releases.
- 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.
- 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 Customer Service, or Panduit EMEA Service Center for technical assistance.