CRIMPING HEAD and CRIMP DIE INSERT INSTALLATION INSTRUCTIONS

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**CT-2500CH
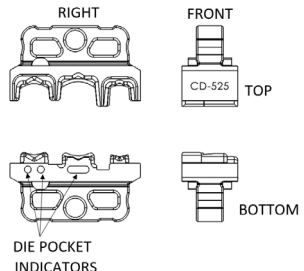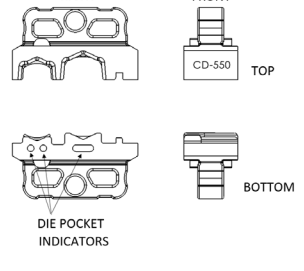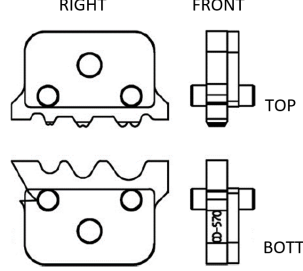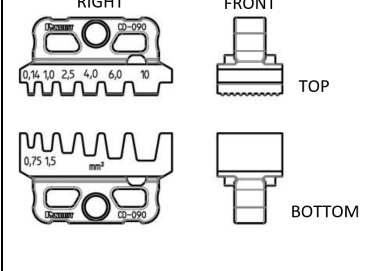(shown without
Crimp Die Inserts)**

CRIMPING HEAD REMOVAL / INSTALLATION

- Pull out the pins and remove crimp head for mounting different crimping die inserts into the crimp head. Once die inserts have been installed, reinsert the crimp head and lock the head with the locating pins (see Step 1) paying attention that the pins are locked securely before starting.
- The crimping cycle is terminated when the dies are completely closed and the maximum crimping force is reached, which is indicated by the auto retraction of the piston.
- Follow the instructions for installing crimp die inserts below. The directional callouts indicate die position for correct die orientation.

Refer to CT-2500, CT-2500/E (PA25346A01); CT-2500/L or CT-2500/LE (PA28113A01) Operation Manual for complete tool and crimping head instructions.

STEP 1

NOTE: DIE MOUNTING ORIENTATION IS SAME FOR CT-2500CH, CT-2300 and UP14ZLW TOOLS.

CD-525	CD-550	CD-570	CD-090
Crimping Die for installing the following Panduit products: #26 – #22 AWG insulated terminals and splices, #22 – #10 AWG fully insulated disconnects, insulated parallel splices; and specific #22 – #14 AWG barrel insulated disconnects.	**Crimping Die for installing the following Panduit products:** #22 – #10 AWG insulated terminals and splices; and specific insulated disconnects.	**Crimping Die for installing most of the following Panduit products:** #22 – #10 AWG and 0,5 – 6,0 mm^2 non-insulated terminals, disconnects; and specific non-insulated splices. Orient part seam on bottom half of die opposite of indentor.	**Crimping Die with square profile for installing the following Panduit products:** #26 – #10 AWG insulated and non-insulated single wire ferrules; and #22 - #12 AWG insulated twin ferrules.

CRIMPING DIE INSERT INSTALLATION

Step 1: Align Crimp Die halves as shown.

- Crimp tabs should be centered on crimp pockets
- Color dot die halves should nest together when properly aligned. Crimp die part numbers should be on top and in front (as shown above).

NOTE: CD-570 crimp die part number should be on bottom and in front (as shown in view to the right). [*Continued on Page 2*]
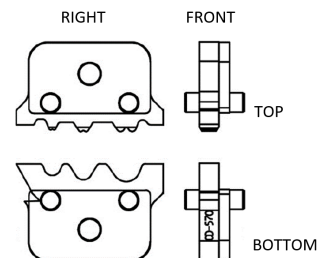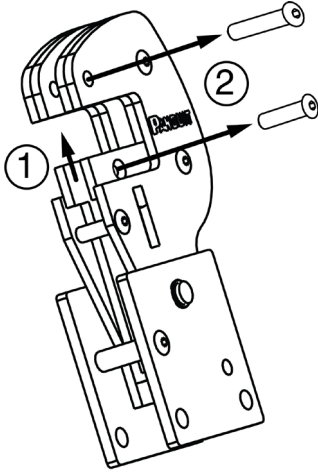

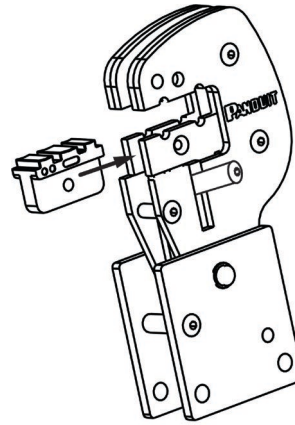**Step 2: Slide Lower Jaw upward. Remove two (2) screws as shown.**

STEP 2

Step 3: Insert lower half of Crimp Die Insert into tool.

Insert should be fully seated between plates. If insert has pins, pins should be nested in indent cavities.
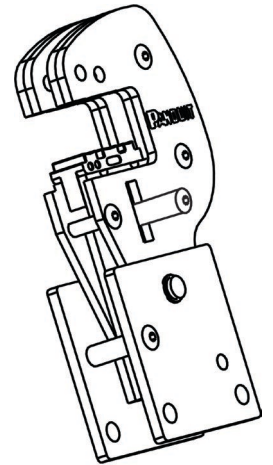
Screw hole in crimp die (insert should align with hole in jaw)

Pull lower jaw back down

STEP 3-A

NOTE: POSITION RED/BLUE POCKET INDICATORS FACING AWAY FROM THE TOOL, AS SHOWN IN THE PHOTO

STEP 3-B

**Step 4: Insert upper half of Crimp Die Insert into tool.**

Part numbers should be facing forward.

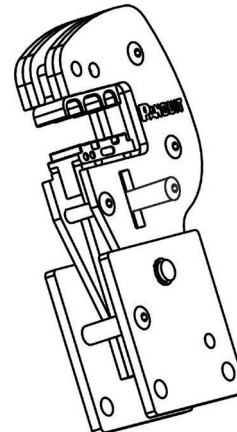Insert should be fully seated between plates. If Insert has pins, pins should be nested in indent cavities.

Screw hole in Die Insert should align with hole in jaw.

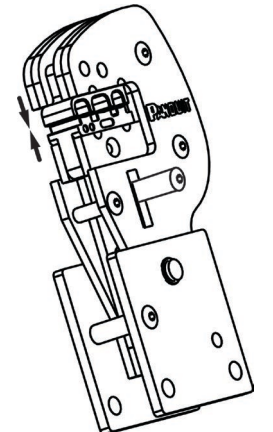**Step 5: Bring lower jaw up to mate with upper jaw.**

The two (2) Crimp Die Insert halves should properly nest as shown on previous page.
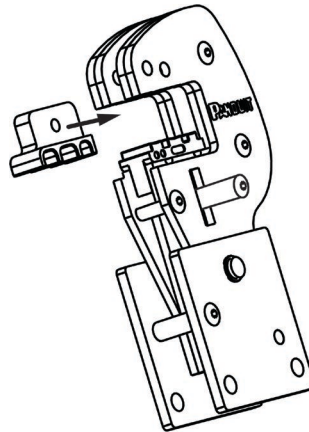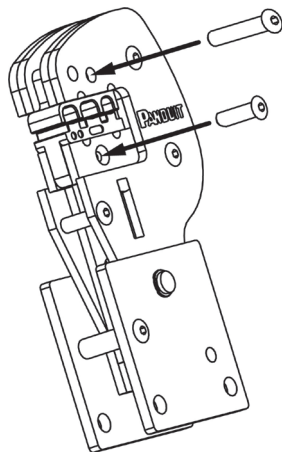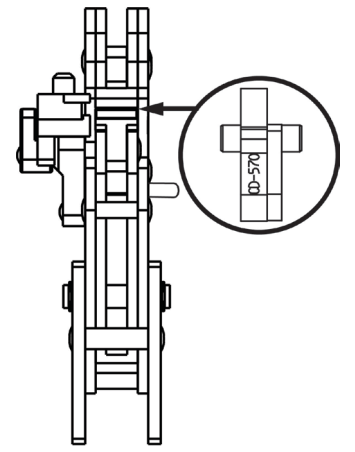

STEP 4-A

STEP 4-B

STEP 5

Step 6: Insert the two (2) screws into the jaws and tighten.

The longer screw is used in the upper jaw.

STEP 6

Step 7: Die halves should align front and back; and side-to-side.

STEP 7

Re-insert Crimp Head with newly installed Crimp Die Inserts into the tool per the instructions on Page 1.

Monthly Maintenance
1. Thoroughly clean all surfaces.
2. Oil the locating pins.