PANDUIT

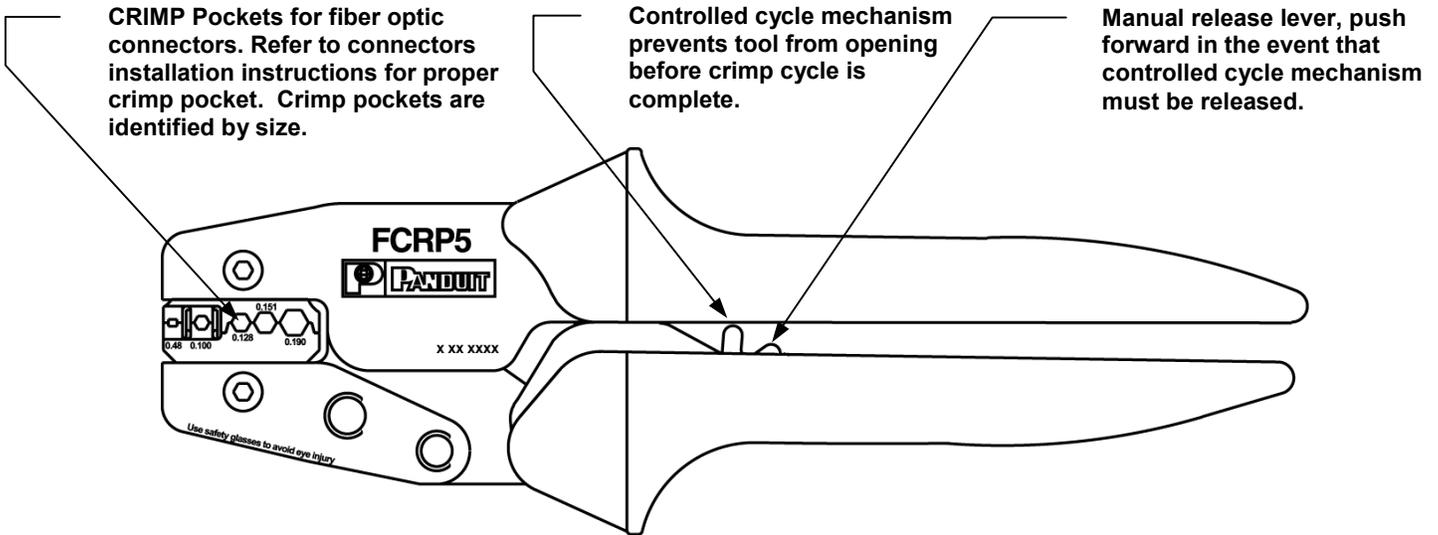# CONTOUR CRIMP ™

FCRP5 CONTROLLED CYCLE CRIMPING TOOL
OPERATION / INSPECTION / MAINTENANCE / TROUBLESHOOTING INSTRUCTIONS

CRIMP Pockets for fiber optic connectors. Refer to connectors installation instructions for proper crimp pocket. Crimp pockets are identified by size.

Controlled cycle mechanism prevents tool from opening before crimp cycle is complete.

Manual release lever, push forward in the event that controlled cycle mechanism must be released.

OPERATION

The Ferrule Assembly Retainer Clip is used to retain the ferrule assembly in position when crimping connectors in the .100" crimp pocket. Pull the Ferrule Assembly Retainer Clip away from the tool by grasping **both ends** and rotating it into the position shown for the specific connector type.	**For FJ Connector**	**For SC Connector**	**For ST Connector**

REPLACEMENT KIT FOR FERRULE ASSEMBLY RETAINER – PART NUMBER: TD24269A01 – INCLUDES: 1 Clip, 1 Screw, 1 Spring

INSPECTION / MAINTENANCE
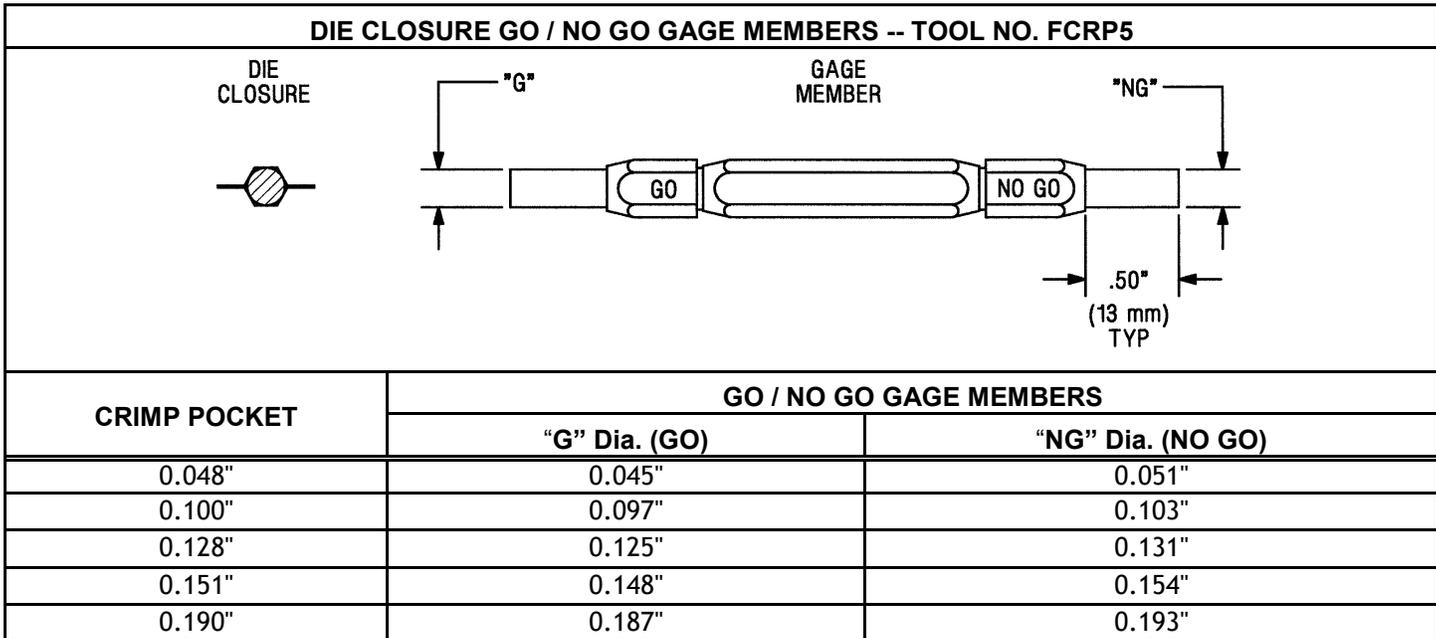
NEW TOOLS - BEFORE PLACING INTO SERVICE:

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. 2. LUBRICATE THE TOOL ONCE A WEEK. 3. CLEAN EXCESS OIL FROM THE CRIMP DIES AND USE.	In-service tools should be cleaned and inspected at least ONCE A MONTH. To clean -- wipe with a clean cloth. In-service tool should be lubricated ONCE A WEEK, and after every cleaning. Lubricate all pins, pivots and bearing surfaces with a light multi-purpose grease. Be sure to clean any excess oil from the crimping dies before using.

TROUBLESHOOTING
DIE CLOSURE INSPECTION
Die closure is measured by using the GO/NO GO gage members (dimensions listed in table below).

DIE CLOSURE GO / NO GO GAGE MEMBERS -- TOOL NO. FCRP5

CRIMP POCKET	GO / NO GO GAGE MEMBERS	
	"G" Dia. (GO)	"NG" Dia. (NO GO)
0.048"	0.045"	0.051"
0.100"	0.097"	0.103"
0.128"	0.125"	0.131"
0.151"	0.148"	0.154"
0.190"	0.187"	0.193"

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. Perform this test for all four crimp pockets.
4. Repeat Step 3 with the appropriate GO gage for all four 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" (32 mm) 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 Field Service.