
OPERATION MANUAL



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A. SAFETY REGULATIONS ENGLISH

A1. Symbols




Please follow exactly the work and processes marked with this pictogram. Failure to do so may result in death or severe injury.



Please follow exactly the work and processes marked with this pictogram. Failure to do so may lead to minor injuries and to damage to the machine.

A5. Danger areas




- The whole area of the processing space underneath the Plexiglas cover
 - Danger due to the Crimp process of the applicator
 - Danger from Crimp stroke
- The entire interior area of the machine and the metal casing:
 - Danger from electrical current
 - Danger from mechanical moving parts

A2. Product description

The *PANDUIT* CP-871 is a crimping machine for the processing of all terminal, disconnect and butt splice crimping contacts up to a cross section of 6mm² (AWG10). The CA-800EZ and CA9 applicators can be fit in. The operator interface consists of membrane keypad and a display. Functions such as speed control, split cycle, pneumatic valve control, and various counter functions are selectable over the interface.

The CP-871 may only be used as described in the enclosed operating manual. Any deviation of the operation mode, additions and extensions must first be discussed with Panduit.

A6. Safety requirements



- This machine has been designed in accordance with the European Standard EN294.
- The machine must only be operated in rooms that are dry and free from dust.
- Never operate the machine without its protective covers.
- Never work on the machine without wearing eye protection.
- Disconnect the machine from the electrical and/or compressed air supply before carrying out any maintenance work.
- Never operate the machine with the mains earth disconnected.
- Do not make any modifications to the machine and only utilise it for its intended purpose according to Paragraph A2 Product description. Other applications are only permitted with the written approval of the manufacturer. The manufacturer will accept no liability for damage resulting from the disregard of this regulation.
- Never operate the machine without first having read through and understood all instructions.
- Repair work may only be carried out by authorised persons who have been specially trained for this work.
- Ensure if you work on the machine that long hair is not worn loose, and do not wear loose clothing or ornaments that could become caught in the moving parts of the machine.
- Only use the lubricant that was delivered with this machine according to these operating instructions.

A3. Responsibilities

The machine operator is responsible for ensuring that every employee who uses the *PANDUIT* CP-871 has received training in accordance with these operating instructions (initial operation, operation, maintenance). The training of the operating personnel must include the following:

- Purpose of the machine (see section A2 Product description).
- Danger areas (see section A4 Personal qualifications).
- Safety instructions (see Default A6 Safety requirements).
- Operating the machine in accordance with these operating instructions.

A4. Personal qualifications

To ensure that all instructions are understood, training must take place in the language of the operating personnel. This means that the following personnel qualifications are required:

Assembly, initial operation, instruction	Technical specialist staff who have a good command of English and/or German as well as of the language of the operating personnel.
Operation	Trained staff in accordance with A3 Responsibilities.
Maintenance, service	Technical specialist staff who have a good command of English or German.

1. ABOUT THIS OPERATOR MANUAL

Thank you for trusting the *PANDUIT* Technology.

With the *PANDUIT* CP-871, you have acquired a semi-automatic crimping machine for the processing of all terminal, disconnect and butt splice crimping contacts up to a diameter of 6mm² (AWG 10).

1.1. Important Information

1.1.1. Manufacturer and Contact Address

See Cover Page

1.1.2. Target Market

Technical Specialists (Team Leader, fitter)

See Chapter A4 Personal qualifications on Page 4

1.1.3. Obligation to Read

As operator and user one is obliged to read and understand this Reference Manual before the initial operation, especially the chapter on safety regulations. Your safety is at stake! Should there be any questions or lack of clarity, please contact your local Panduit representative.

1.1.4. Validity

This User Manual is valid for the *PANDUIT* CP-871 only.

1.1.5. Contents and Purpose

This Reference Manual contains all relevant information regarding the assembly, function, commissioning and operation of the CP-871.

This Reference Manual is part of the client documentation and void without the Operating Manual and the Maintenance Manual.

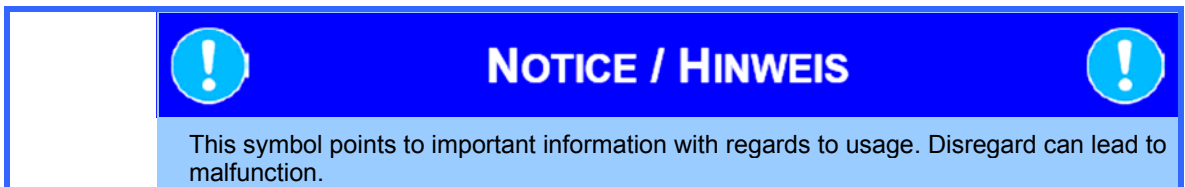
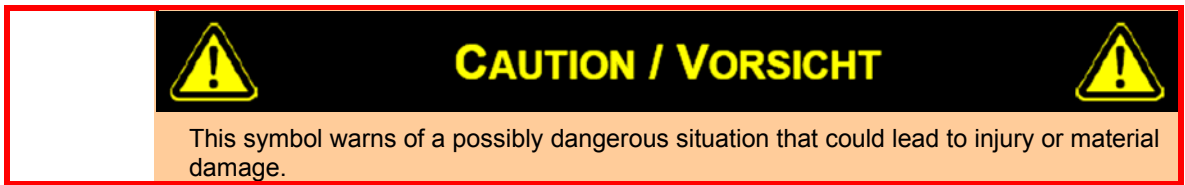
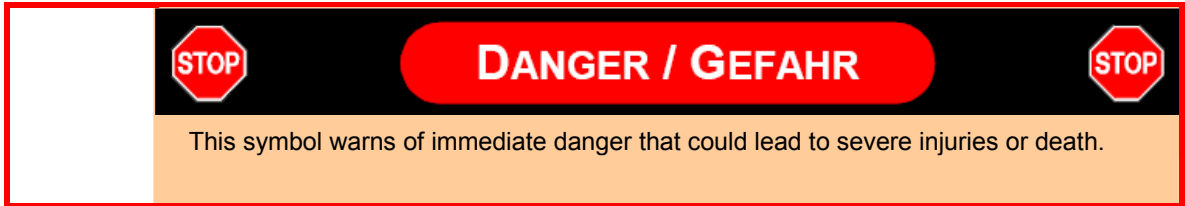
1.1.6. Location

This Reference Manual must be available to the team leader / fitter at the working place.

1.1.7. Symbols

1.1.7.1. Security Tags

Please read the following security advice with the tagged warnings thoroughly to avoid possible injuries or material damage.



1.1.7.2. Security Tag



- Danger moving parts



- Attention danger through electric power



- Attention, warning of dangerous area



- Qualified Personnel Only

1.2. Product Description

1.2.1. Tag

The nameplate is situated on the left side of press and contains the following information:

Model: CP-871



Voltage information:

110 VAC bis
230 VAC
50/60 Hz

T10A
T 6A
255 VA

1.2.2. Application

The *PANDUIT* CP-871 may only be used for processing crimping contacts and cables, i.e. to activate the applicators.

1.2.3. Application Limits

Environmental Temperature:

+5°C to +40°C

Storage and Transport Temperature:

-25°C to +55°C

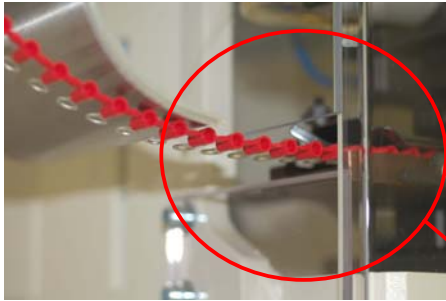
Relative humidity:

90% on 20°C
50% on 40°C

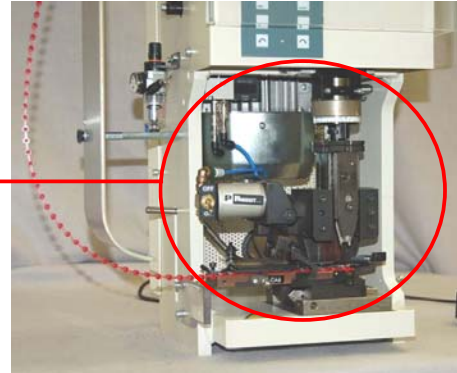
1.2.4. Conformance

The CP-871 conforms entirely with the CE and EMV guidelines (mechanic and electric security, electromagnetic tolerance.)

1.2.5. Danger Areas



Danger through moving parts in the working area



1.2.6. Technical Data

Force	3.7 Tons / (33 kN)
Power	(0.75 KW)
Cross Section Range	Up to approx. AWG 10 / (6mm ²). Material thickness up to .039 in. / (1mm) length of the crimping zone, up to .315 in. / (8mm)
Stroke	1.57 in. / (40 mm); Optional 1.18 in. / (30 mm)
Shut Height	5.345 in. / (135.788 mm)
Height Adjustment Range	± .0098 in. / (0.25 mm), in increments
Cycle Time	Adjustable from 350ms to 1 s
Press Activation	Foot Pedal
Noise Level	< 70 dB (A)
Power Connector	115 VAC bis 230 VAC
Net Frequency	50/60 Hz
Capacity	255 VA
Dimensions [mm] (W x H x D)	13" x 30" x 16" / (320 x 750 x 400 mm)
Weight	176 lbs. / (80 kg)
<i>Dimensions in () are metric</i>	

2. OPERATING ELEMENTS

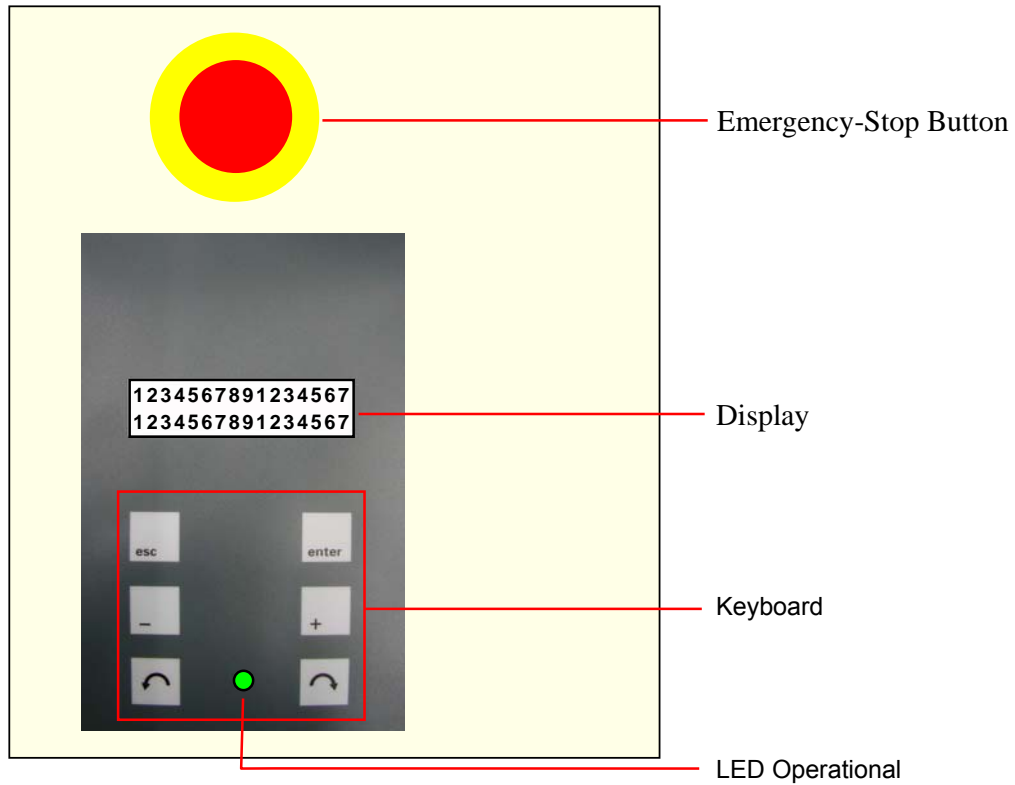
2.1. Main Switch

The CP-871 has no main switch. The power supply is cut off by removing the power cord from the machine or by using the emergency stop button.



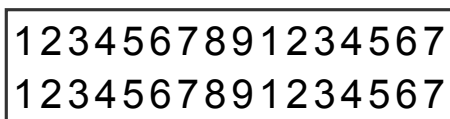
Picture 2.1: Main Switch

2.2. Control Panel





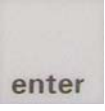


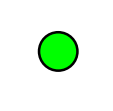

Picture 2.2: Control Panel with Keyboard

2.2.1. Display

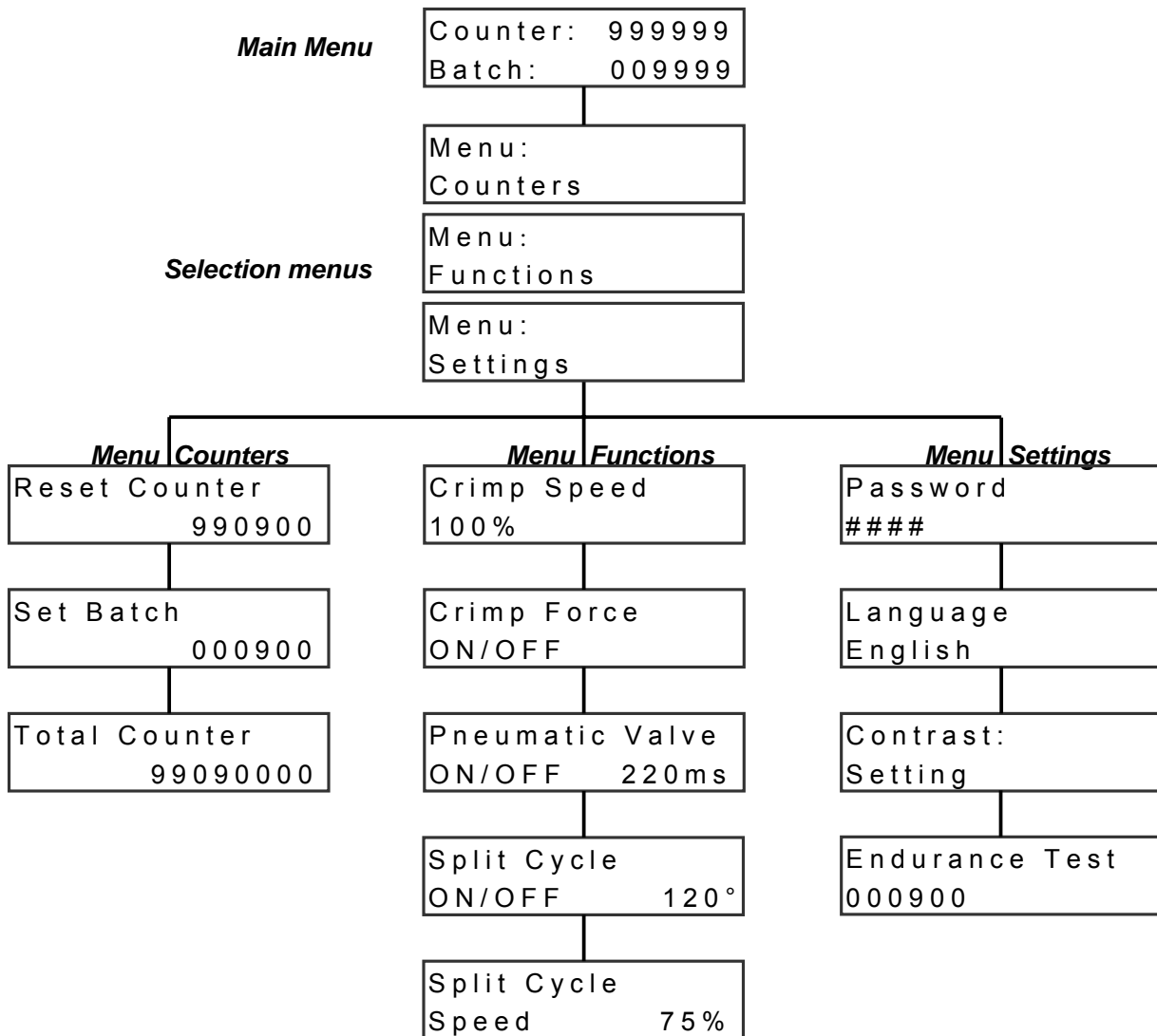


Picture 2.3: Display

2.2.2. Keyboard

	<p>Escape Key: Leave the entry mask or the menus</p>		<p>Creeping Speed Key –Left: Moves the machine with reduced speed against the machining direction</p>
	<p>Enter Key: Activate the entry mask or confirm the entry</p>		<p>Creeping Speed Key – Right: Moves the machine with reduced speed in the machining direction</p>
	<p>Minus Key: Minimize the value in a input field or scroll in the selection menu or in the sub-menus.</p>		<p>Operational LED: The LED indicates that the machine is in the upper dead center and ready for use.</p>
	<p>Plus Key: Increase value in the input field or scroll in the selection menu or in the sub-menus.</p>		




2.3. Monitors, Menus



3. OPERATION

The user's task is as follows:

- Installing the tools
- Installing and setting the contact roller/retooling the contact guide plate
- Programming the counter functions and settings
- Producing cable

	 CAUTION / VORSICHT  <p>The CP-871 may only be operated by trained personnel (PANDUIT personnel or trained personnel at the user)</p>
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3.1. Production

Start the CP-871 by plugging the power cable and/or unlocking the emergency-stop button.

3.1.1. Display

Entries may always be made once the prompt in the display flashes.

3.1.2. Activate Cycle



- The machine gets started with the foot pedal


3.1.3. Settings

Set the menu language


Counter: 999999
Batch: 009999

- Main Menu



Menu: Counters

- , Selection menu „Counters“




Menu: Settings

- With 2 x  change to „Settings“ in the menu






Password ####

- With  log into the sub-menu password
- , Password entry is activated (the first figure flashes) **Password 0200.**

Password 0###

- Change the numerical value  or . Once the wanted value is reached, confirm . (the second figure flashes).
- Repeat the procedure until all four figures have been entered

Language English

- , Sub-Menu language setting (if the password was incorrectly entered the sub-menu cannot be accessed).
- , Function Language setting gets activated.
With  or  choose the language (German, English, French, Italian, Spanish)
- , Confirm language.

Counter: 999999
Batch: 009999


- 2 x , back to main menu.

3.1.4. Menu Counters

Counter: 999999
Batch: 009999

- Main menu





Menu: Counters

- , Selection menu „Counters“









Reset Counter 990900

- With  change to menu „Counters“.





3.1.4.1. Reset Counter

Reset Counter 990900	<ul style="list-style-type: none"> • , Activate „Reset Counter” (figures flash).
Reset Counter 000000	<ul style="list-style-type: none"> • , Reset Counter
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to the main menu or directly to the submenu „Set Batch” with .




3.1.4.2. Programming Batch

Set Batch 000900	<ul style="list-style-type: none"> • , Submenu „Set Batch”. • , Activate function „Set Batch”.
Set Batch 002500	<ul style="list-style-type: none"> • With  or  Enter Batch. • , Confirm entry.
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to main menu or directly to sub-menu „Total Counter” with .
Counter: 999999 Batch Processed	<ul style="list-style-type: none"> • Once the Batch is reached „Batch Processed” will appear. By pressing  the new Batch is activated. To deactivate the Batch function, programm a Batch value of „000000”.







3.1.4.3. Total Counter

Total Counter 99090000	<ul style="list-style-type: none"> • 2 x , sub-menu „Total Counter” (Information)
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to main menu. With  into sub-menu „Det Batch” or with 2x  into sub-menu „Reset Counter”.

3.1.5. Functions

Counter: 999999 Batch: 009999	<ul style="list-style-type: none">• Main Menu
Menu: Counters	<ul style="list-style-type: none">• , Selection menu „Counters“
Menu: Functions	<ul style="list-style-type: none">• With  go to menu „Functions“
Crimp Speed 100%	<ul style="list-style-type: none">• With  go to sub-menu „Functions“.


3.1.5.1. Crimp Speed


Crimp Speed 100%	<ul style="list-style-type: none">• , „Crimp Speed“ function is activated (figures are flashing).
Crimp Speed 080%	<ul style="list-style-type: none">• With  and  one can adjust the pressing speed in percentage.• 100% ⇒ max. speed ⇒ ca. 350ms• 5% ⇒ min. speed ⇒ ca. 1s• , accept entry.
Counter: 999999 Batch: 009999	<ul style="list-style-type: none">• 2 x , back to main menu or with  direct into the sub-menu „Crimp Force“ (Crimp Force monitoring).

3.1.5.2. Crimp Force


This feature does not function with *PANDUIT* product and is not supported by *PANDUIT*.

3.1.5.3. Pneumatic Valve (Option)






CAUTION / VORSICHT




A badly set feeder timing may damage the machine. Always install pneumatic tools without contact material, until the feeder timing is properly set.

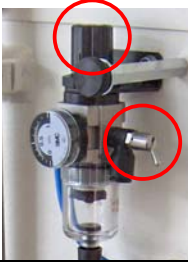
Pneumatic Valve OFF	<ul style="list-style-type: none"> • 2 x , sub-menu „Pneumatic Valve“. • With , „Pneumatic Valve“ function is activated (figures are flashing).
Pneumatic Valve ON 220 ms	<ul style="list-style-type: none"> • With and activation of the „Pneumatic Valve“ function and by pressing the key timing of the valve can be programmed. • , accept entry. • The length of time the valve is engaged is permanently programmed and can not be changed..
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to the main menu or with go directly into the sub-menu „Split Cycle“.



- Connect the compressed air on the pressure gauge.
- Assemble the tool according to Chapter 4.3 Applicator Assembly on page 19.



- Connect both pneumatic attachments at the valve



- Switch on the air pressure unit using the main switch at the pressure gauge.
- Set gage at 6 bar processing pressure

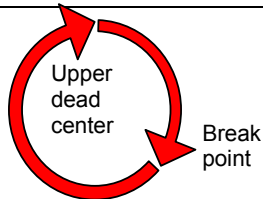
3.1.5.4. Split Cycle

Split Cycle OFF

- 3 x **+**, sub-menu „Split Cycle“.
- **enter**, „Split Cycle“ function is activated (figures are flashing).

Split Cycle ON	120°
-------------------	------

- With **+** and **-** the „Split Cycle“ function can be activated and by press the **enter** key, the breakpoint can be programmed.



- The „Split Cycle“ is used mainly for end sleeve contacts, to centre the contact in the crimping stamp and to ensure easier handling for the operator.

Split Cycle Speed	75%
----------------------	-----

- Change to the sub-menu „Split Cycle Speed“ with **+**.
- **enter**, „Split Cycle Speed“ function is activated (figures are flashing).

Split Cycle Speed	45%
----------------------	-----

- With **+** and **-** the pressing speed can be adjusted in percent. The speed is programmed from the upper dead center to the breakpoint.
- 100% ⇒ max. Speed.
- 5% ⇒ min. Speed.
- **enter**, accept entry.

Counter:	999999
Batch:	009999

- 2 x **esc**, back to the main menu or with **-** back into the previous menu.
- Press the **esc** key to initialise the machine (min. 3s)

4. TOOL REPLACEMENT

4.1. Roller Carrier

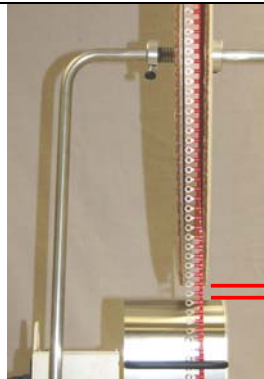


- Loosen both inner hexagon bolts of the pipe clamp on the left side of the machine.

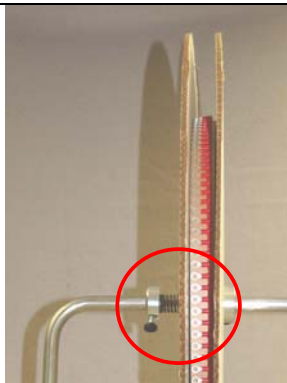


**side
banded**

- Turn the roller carrier 90° to the right for side banded contacts.

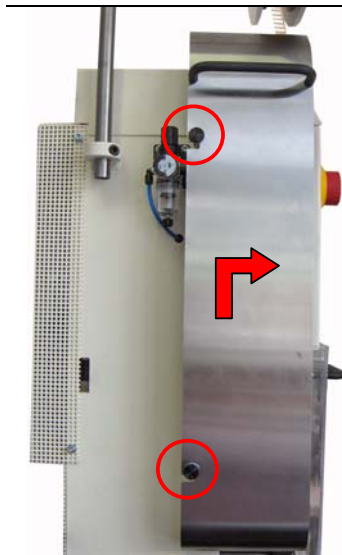


- Set the height according to the contact roll.
- Tighten both hexagon bolts on the pipe clamp.



- Attach the rear dead stop.
- Assemble the contact roll.
- Set the braking power for the contact roll using the forward dead stop and the spring.

4.2. Contact guide plate

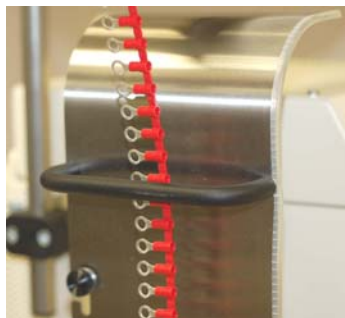


- Loosen both of the knurled screws and lift the sheet plate.
 - Pull the sheet plate to the right and then remove it.
-

Side banded

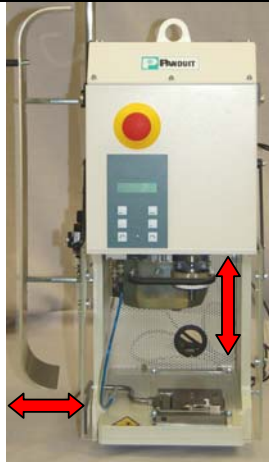


- Assemble the sheet plate onto the distance bolt at the left for side feed applicators.
 - Attach the sheet plate using the knurled screws.
-

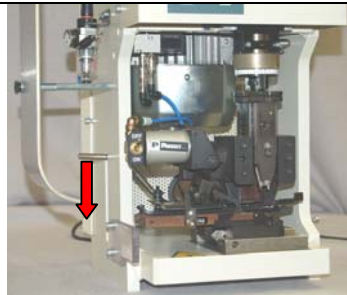


- The contact material must be fed through the black leading bracket
 - Feed material into the applicator.
-

4.3. Applicator Assembly



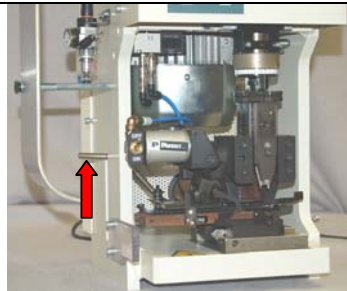
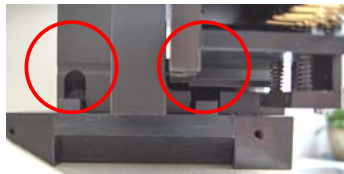
- Open the front guard and remove the contact material.



- Move the clamping lever on the left downwards until the clamps are open.




- Assemble / disassemble the tool in the nut and after remove at the bottom from the retaining clamps of the applicator ground plate.





- Move the clamping lever upwards until the clamping fingers clamp the tool in their respective grooves.
- Check that the tool is properly fastened and close the protective cover.
- Set the tool according to the operating guidelines set out by the manufacturer.

4.4. Setting the Crimp Height

The crimping height of the CA-800EZ and CA9 applicators can be adjusted within the applicator. Further crimp height adjustments can be made to the press itself.



**CAUTION / VORSICHT**

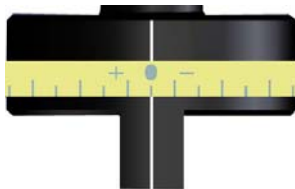
After each tool change, (before the first crimp), set the height of the machine to 0
Not doing so may damage the tool.
Only qualified personnel may carry out this setting.



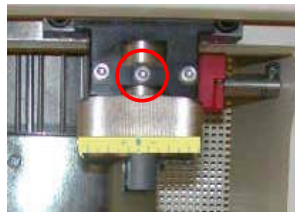
- Micro adjustment of the crimp height.



- Turn the flange toothed surface.
- Minus direction, towards the left, increases the crimping height. (e.g. 1.27 => 1.30).
- Plus direction, towards the right, decreases the crimping height (e.g. 1.27 => 1.24).



- The setting is limited to ± 0.25 mm.
- The graduation is 0.025 mm per line.
- The reference point (135.788 mm) is marked with the figure 0.






- Should the height setting not be used, this function can be blocked by tightening the inner hexagonal screw.

5. CRIMP FORCE MONITORING ACO05

This feature does not function with *PANDUIT* product and is not supported by *PANDUIT*.

6. ERROR MESSAGES

Fault	Action
<i>Open Protection Cover</i>	<ul style="list-style-type: none"> Connect protection cover to CP-871.
<i>Machine not in Home Position</i>	<ul style="list-style-type: none"> With the help of  or  return to Home Position. The green LED glows By activating the  key in the main menu (minimum 3x), the machine returns to the home position. The machine changes the turning direction automatically as soon as it is in contact with a resistor.
<i>CFM not ready</i>	<ul style="list-style-type: none"> Turn on CFM and check the connection of the cable. Set the CFM to the production menu.
<i>No display on the monitor</i>	<ul style="list-style-type: none"> Disengage the emergency-off button or plug into power. Check the fuse

7. MAINTENANCE



CAUTION / VORSICHT



Activate the Emergency-Off button and separate the CP-871 from the power.

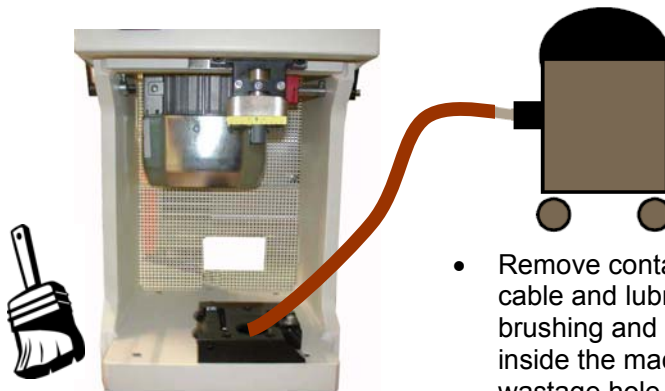
7.1. Daily Maintenance

- Clean the machine and the operating unit with a brush or a clean cloth

7.1.1. Cleaning Processing Room



- Open protection cover and disassemble tool.






- Remove contact band residue, cable and lubricating residue by brushing and vacuum cleaning inside the machine below the wastage hole.

7.2. Lubrication

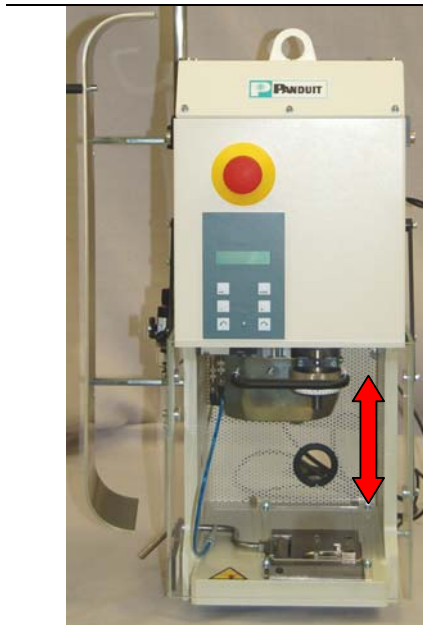
Lubricate the guide and all movable parts on the tool faceplate.



Lubricating interval: at least every 3 months
Lubricating Grease: Microlub GBU Y 131 (Will be delivered with the unit)




CAUTION / VORSICHT

Use the lubricating grease delivered with the unit only according to the the available instructions. Please note that the information relating to the lubricating grease is given in the attachment to chapter 10 Appendix on page 27.

7.3. Machine Preparation

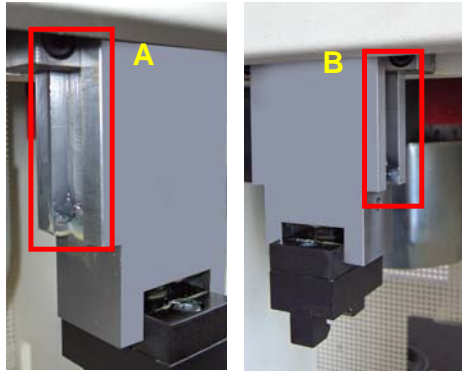


- Open protection cover. Disassemble applicator.
- Take machine down to the bottom death centre with  or  keys
- Open safety cover.
- Activate Emergency-Off button and separate the machine from the power supply system.

CAUTION / VORSICHT

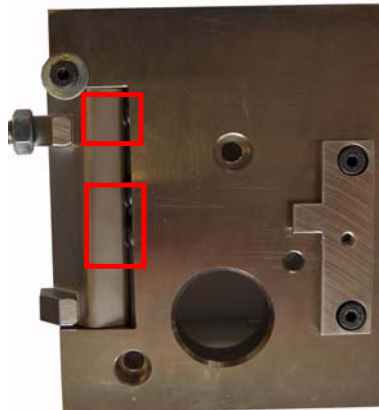
Press the Emergency-Off button and unplug the power supply. Lubricating work may only be carried out by trained personnel (*PANDUIT* personnel or trained personnel at the user)

7.4. Slide




- Open safety cover
- Clean the slide's guides (A / B) with a lint free cloth.
- Lubricate the left guide (A) and the right guide (B) on all three faces.

7.5. Tool Base Plate




- Clean the clamping claws of the tool base plate with lint free cloth and the delivered brush.
- Lightly lubricate the clamping claws of the three bolts.
- Open and close the clamping claws a few times


- Close safety cover
- Deactivate Emergency-Off button and connect the machine to the power supply system.
- Bring the machine through operate  key (min. 1x) in the main menu automatically into the upper dead center.

8. SETTINGS

8.1. Setting Crimping Height at 135.788mm



CAUTION / VORSICHT



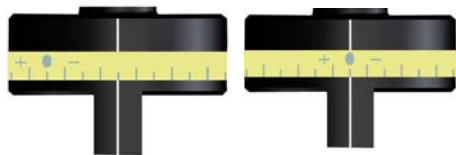
The crimping height may only be set by trained personnel (*PANDUIT* personnel or trained personnel at the User) who have a SLM crimping height gage or a similar device at their disposal.



- Set the height with help of the fine adjustment on the crimping machine until the display in the window lies within the range of $\pm 005\mu$



- Turn the ring at the edged surface.
- Plus direction to the right, crimping height increases (e.g. 1.27 => 1.30)
- Minus direction to the left, crimping height decreases (e.g. 1.27 => 1.24)



- Now loosen the adhesives with the scale and assemble them in such a way that the reference „0“ corresponds again with the white line.



- Remove the limitation pin and assemble into the hole above the reference position. This will make sure that the limitations are again symmetrical.

- Remove the SLE CM gage. The machine is now set onto a crimp height of 135.788.

9. REPAIRS



**DANGER / GEFAHR**

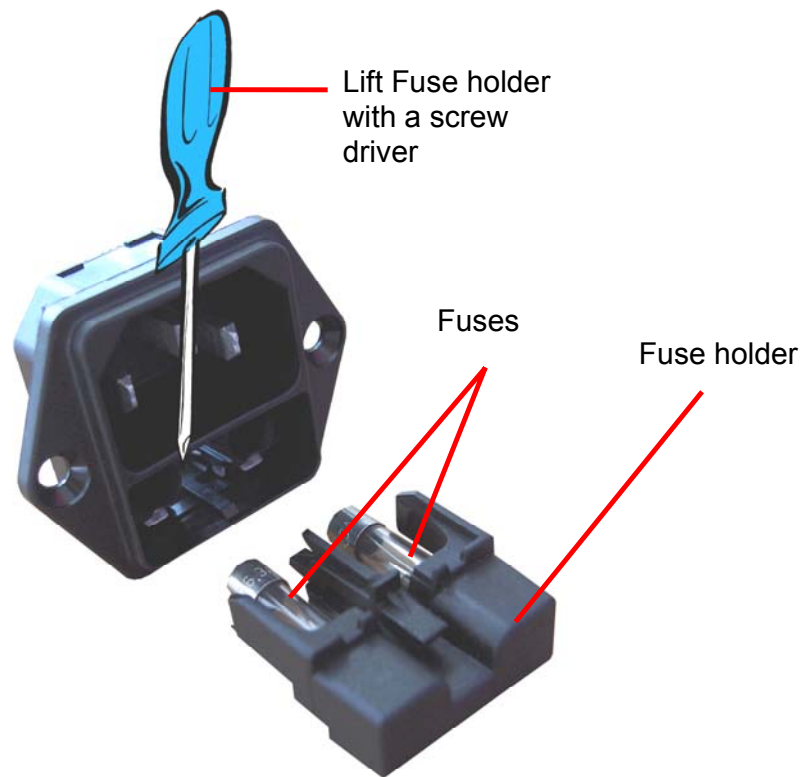


Press the Emergency-Off button and unplug the CP-871's power supply. Fuses may only be replaced by trained personnel (*PANDUIT* personnel or trained personnel at the user).

9.1. Replace Main Fuse

- Lift out the fuse holder with a screwdriver. Always replace both main fuses.

100/115 VAC = 2 x 10 A/T
230/240 VAC = 2 x 6 A/T



Picture 5.1: Replace main fuse

- Place the fuse holder back into the CP-871 and plug the line cord.

10. APPENDIX

10.1. EU-Safety Data Sheet KLÜBER

MICROLUBE GBU-Y 131

Safety Data Sheet

<p>1.1 Product name: MICROLUBE GBU-Y 131 Code-No.: 017 117 15.11.2001</p>	<p>9. Physical and chemical properties Form: paste Colour: beige Odour: characteristic Drop point: > 250 °C, DIN ISO 2176 Flash point: > 200 °C (base oil) Ignition temperature: not applicable Lower explosion limit: not applicable Upper explosion limit: not applicable Vapour pressure-first: not applicable Density: approx. 0.95 g/cm³, 20 °C Water solubility: insoluble pH value: not applicable Kinematic viscosity: not applicable Further information: none</p>
<p>1.2 Klüber Lubrication München KG Geisenhausenstraße 7 81379 München, Germany ☎ +49 89 7876-0 telephone exchange Telefax +49 89 7876-333 Emergency telephone no.: +49 89 7876-0</p>	<p>10. Stability and reactivity Conditions to avoid: None Materials to avoid: Strong oxidising agents Hazardous decomposition products: None under normal use Additional information: None</p>
<p>2. Composition / information on ingredients Chemical characterization (preparation): Mineral oil, synthetic hydrocarbon oil, barium complex soap Hazardous ingredients CAS-No. Components Value Symbols R-phrases Barium soap < 25% 5253</p>	<p>11. Toxicological information Prolonged skin contact may cause skin irritation and/or dermatitis</p>
<p>3. Hazards identification Prolonged skin contact may cause skin irritation and/or dermatitis</p>	<p>12. Ecological information Information on elimination (persistence and degradability): Product is insoluble in water. May be separated out mechanically in purification plants Behaviour in environmental compartments: Ecological injuries are not known or expected under normal use Ecotoxic effects: Barium complex soap: Toxic to aquatic organisms, may cause long-term adverse effects in the aquatic environment Additional information: Should not be released into the environment</p>
<p>4. First aid measures After inhalation: Not applicable After contact with skin: Wash off with mild cleansers and plenty of water. If symptoms persist, call a physician After contact with eyes: Rinse with plenty of water. If symptoms persist, call a physician After ingestion: Do not induce vomiting. Obtain medical attention Advice to doctor: Treat symptomatically</p>	<p>13. Advice on Disposal Code of waste: 120 112. Wastes from shaping and surface treatment of metals and plastics; wastes from shaping (including forging, welding, pressing, drawing, turning, cutting and filing); spent waxes and fats Disposal: The code of waste has to correspond to the Council Directive 75/442/EEC and be specific as far as the related sector and process are concerned. Can be incinerated when in compliance with local, state and federal regulations Dispose of contaminated packaging and recommended cleaning: Offer rinsed packaging material to local recycling facilities</p>
<p>5. Fire-fighting measures Suitable extinguishing media: Water spray, foam, dry powder, carbon dioxide (CO₂) Unsuitable extinguishing media: High volume water jet Special Hazards: In case of fire the following can be released: Carbon monoxide, hydrocarbons Special protective equipment for firefighters: Standard procedure for chemical fires Additional information: Water mist may be used to cool closed containers. In the event of fire and/or explosion do not breathe fumes</p>	<p>14. Transport information GGVS / GGVE: not applicable ADN / ADN: not applicable IMDG-Code: not applicable ICAO / IATA-DGR: not applicable Further information: Not classified as dangerous in the meaning of transport regulations</p>
<p>6. Accidental release measures Personal precautions: Not required Environmental precautions: Do not flush into surface water or sanitary sewer system Methods for cleaning up / taking up: Use mechanical handling equipment. Dispose of absorbed material in accordance with the regulations Additional information: None</p>	<p>15. Regulatory information Labeling according to EU-guidelines: The product does not require a hazard warning label in accordance with EC-directives/German regulations on dangerous substances National regulations: Labeling according to the Swiss regulations: No toxicological class, BAGT-no. 88650</p>
<p>7. Handling and storage Advice on safe handling: No special handling advice required Advice on protection against fire and explosion: No special precautions required Requirements on storage rooms and vessels: Store at room temperature in the original container Incompatible materials: Incompatible with oxidising agents. Do not store together with food Further information on storage conditions: None</p>	<p>16. Other information Issue-department of Safety Data Sheet: Chemical Documentation, ☎ +49 89 7876-564</p>
<p>8. Exposure controls / personal protection Additional advice on system design: Not applicable Ingredients and specific control parameters: None Respiratory protection: No special protective equipment required Hand protection: No special protective equipment required Eye protection: No special protective equipment required Body protection: No special protective equipment required Other protection measures: No special protective equipment required General protection and hygiene measures: Avoid prolonged and/or repeated contact with skin. Remove soiled or soaked clothing immediately. Clean skin thoroughly after work; apply skin cream</p>	

The data in this product information is based on our general experience and knowledge at the time of printing and is intended to give information of possible applications to a reader with technical experience. It constitutes neither an assurance of product properties nor does it release the user from the obligation of performing preliminary tests with the selected product. We recommend contacting our Technical Consulting Staff to discuss your specific application. If required and possible we will be pleased to provide a sample for testing. Klüber products are continually improved. Therefore, Klüber Lubrication reserves the right to change all the technical data in this product information at any time without notice.

 Klüber Lubrication München KG, a member of the Freudenberg group

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CP-871

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REFERENCE MANUAL



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E-mail: cs@panduit.com



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888-506-5400, ext. 3255
Fax: (630) 759-7532

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A. SAFETY REGULATIONS ENGLISH

A1. Symbols



Please follow exactly the work and processes marked with this pictogram. Failure to do so may result in death or severe injury.



Please follow exactly the work and processes marked with this pictogram. Failure to do so may lead to minor injuries and to damage to the machine.

A2. Product description

The *PANDUIT* CP-871 is a crimping machine for the processing of all terminal, disconnect and butt splice crimping contacts up to a cross section of 6mm² (AWG10). The CA-800EZ and CA9 applicators can be fit in. The operator interface consists of membrane keypad and a display. Functions such as speed control, split cycle, pneumatic valve control, and various counter functions are selectable over the interface.

The CP-871 may only be used as described in the enclosed operating manual. Any deviation of the operation mode, additions and extensions must first be discussed with Panduit.

A3. Responsibilities

The machine operator is responsible for ensuring that every employee who uses the *PANDUIT* CP-871 has received training in accordance with these operating instructions (initial operation, operation, maintenance). The training of the operating personnel must include the following:


- Purpose of the machine (see section A2 Product description).
- Danger areas (see section A4 Personal qualifications).
- Safety instructions (see Default A6 Safety requirements).
- Operating the machine in accordance with these operating instructions.

A4. Personal qualifications

To ensure that all instructions are understood, training must take place in the language of the operating personnel. This means that the following personnel qualifications are required:


Assembly, initial operation, instruction	Technical specialist staff who have a good command of English and/or German as well as of the language of the operating personnel.
Operation	Trained staff in accordance with A3 Responsibilities.
Maintenance, service	Technical specialist staff who have a good command of English or German.

A5. Danger areas



- The whole area of the processing space underneath the Plexiglas cover
 - Danger due to the crimp process of the applicator
 - Danger from crimp stroke
- The entire interior area of the machine and the metal casing:
 - Danger from electrical current
 - Danger from mechanical moving parts

A6. Safety requirements



- This machine has been designed in accordance with the European Standard EN294.
- The machine must only be operated in rooms that are dry and free from dust.
- Never operate the machine without its protective covers.
- Never work on the machine without wearing eye protection.
- Disconnect the machine from the electrical and/or compressed air supply before carrying out any maintenance work.
- Never operate the machine with the mains earth disconnected.
- Do not make any modifications to the machine and only utilise it for its intended purpose according to Paragraph A2 Product description. Other applications are only permitted with the written approval of the manufacturer. The manufacturer will accept no liability for damage resulting from the disregard of this regulation.
- Never operate the machine without first having read through and understood all instructions.
- Repair work may only be carried out by authorised persons who have been specially trained for this work.
- Ensure if you work on the machine that long hair is not worn loose, and do not wear loose clothing or ornaments that could become caught in the moving parts of the machine.
- Only use the lubricant that was delivered with this machine according to these operating instructions.

1. ABOUT THIS OPERATOR MANUAL

Thank you for trusting the *PANDUIT* Technology.

With the *PANDUIT* CP-871, you have acquired a semi-automatic crimping machine for the processing of all terminal, disconnect and butt splice crimping contacts up to a diameter of 6mm² (AWG 10).

1.1. Important Information

1.1.1. Manufacturer and Contact Address

See Cover Page

1.1.2. Target Market

Technical Specialists (Team Leader, fitter)
See Chapter A4 Personal qualifications on Page 4

1.1.3. Obligation to Read

As operator and user one is obliged to read and understand this Reference Manual before the initial operation, especially the chapter on safety regulations. Your safety is at stake! Should there be any questions or lack of clarity, please contact your local Panduit representative.

1.1.4. Validity

This User Manual is valid for the *PANDUIT* CP-871 only.

1.1.5. Contents and Purpose

This Reference Manual contains all relevant information regarding the assembly, function, commissioning and operation of the CP-871.
This Reference Manual is part of the client documentation and void without the Operating Manual and the Maintenance Manual.



1.1.6. Location



This Reference Manual must be available to the team leader / fitter at the working place.



1.1.7. Symbols



1.1.7.1. Security Tags

Please read the following security advice with the tagged warnings thoroughly to avoid possible injuries or material damage.

	DANGER / GEFAHR	
This symbol warns of immediate danger that could lead to severe injuries or death.		

	WARNING / WARNUNG	
This symbol warns of a possibly dangerous situation that could lead to serious injury or death.		

	CAUTION / VORSICHT	
This symbol warns of a possibly dangerous situation that could lead to injury or material damage.		

	NOTICE / HINWEIS	
This symbol points to important information with regards to usage. Disregard can lead to malfunction.		

1.1.7.2. Security Tag



- Danger moving parts



- Attention danger through electric power



- Attention, warning of dangerous area




- Qualified Personnel Only

1.2. Product Description

1.2.1. Tag

The nameplate is situated on the left side of press and contains the following information:

Model:	CP-871	
Voltage information:	110 VAC bis 230 VAC 50/60 Hz	T10A T 6A 255 VA

1.2.2. Application

The *PANDUIT* CP-871 may only be used for processing crimping contacts and cables, i.e. to activate the applicators.

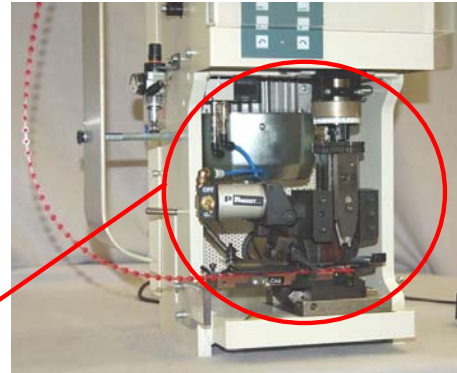
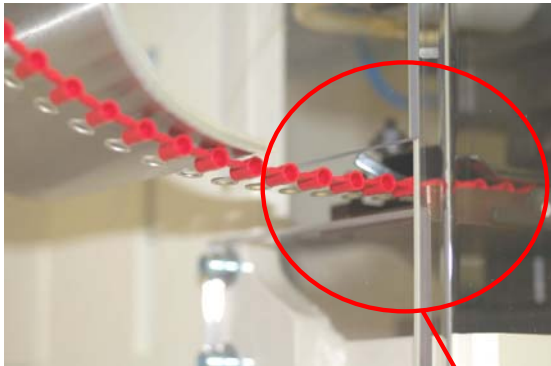
1.2.3. Application Limits

Enviromental Temperature:	+5°C to +40°C
Storage and Transport Temperature:	-25°C to +55°C
Relative humidity:	90% on 20°C 50% on 40°C

1.2.4. Conformance

The CP-871 conforms entirely with the CE and EMV guidelines (mechanic and electric security, electromagnetic tolerance.)

1.2.5. Danger Areas



Picture 1.2.5: Danger Areas



Danger through moving parts in the working area

1.2.6. Technical Data

Force	3.7 Tons / (33 kN)
Power	(0.75 KW)
Cross Section Range	Up to approx. AWG 10 / (6mm ²). Material thickness up to .039 in. / (1mm) length of the crimping zone, up to .315 in. / (8mm)
Stroke	1.57 in. / (40 mm); Optional 1.18 in. / (30 mm)
Shut Height	5.345 in. / (135.788 mm)
Height Adjustment Range	± .0098 in. / (0.25 mm), in increments
Cycle Time	Adjustable from 350ms to 1 s
Press Activation	Foot Pedal
Noise Level	< 70 dB (A)
Power Connector	115 VAC bis 230 VAC
Net Frequency	50/60 Hz
Capacity	255 VA
Dimensions [in] (W x H x D)	13" x 30" x 16" / (320 x 750 x 400 mm)
Weight	176 lbs. / (80 kg)

Dimensions in () are metric

2. FUNCTIONS

2.1. Processing

The stripped conductor is held in the connector.

Processing is activated with the foot pedal. The crimping press moves the tool down to the lower dead center and thereafter to the upper dead center.

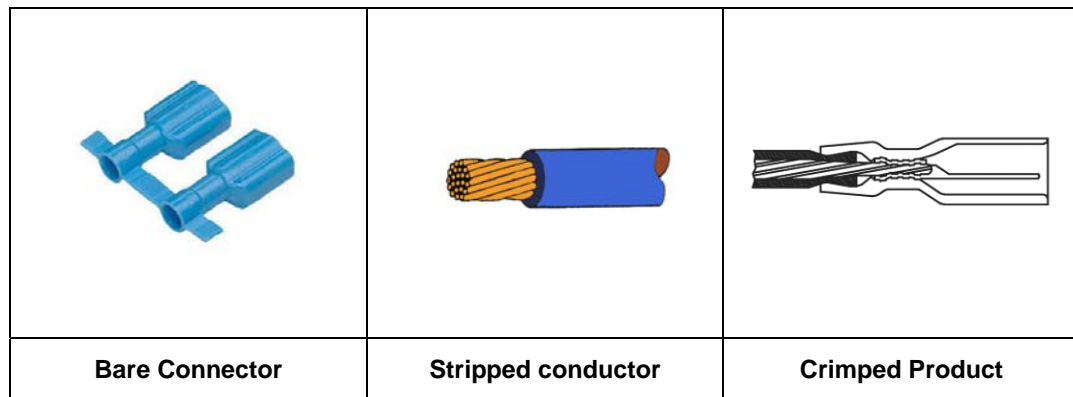
The tool separates the connector from the carrier strip, crimps the connector with the conductor and feeds a new connector into position.

The carrier strip is cut by the applicator die.

2.2. Crimping Connections

The term crimping comes from the English word “to crimp” which means press, impress, fold or fold deform.

In the electrical installation language, crimping means to mechanically fold or press the connector onto the conductor.



3. CIRCUIT POINTS

3.1. Overview



- | | | | |
|---|------------------|---|--------------|
| 1 | Crimp Monitoring | 4 | Power Supply |
| 2 | Pneumatic Valve | 5 | Fuse Holder |
| 3 | Foot Pedal | | |

Picture 3.1 Connections

3.1.1. Crimp Force Monitoring (Optional)

The crimp force monitor option does not work with *PANDUIT* product and is not supported by *PANDUIT*.

3.1.2. Pneumatic Valve (Optional)

By means of this connection the valve for feeding pneumatic tools gets activated. Pneumatic connections see chapter 7.1 Connect Compressed air on page 27.

3.1.3. FOOT PEDAL

The crimping process can be started with the foot pedal.

3.1.4. Fuse Holder

The fuse holder contains both main fuses.

3.1.5. Power Supply

One-Phase with protective earth (2P+E)	
100/115 VAC, Fuse T10A	50/ 60 Hz, 255 VA
230/240 VAC, Fuse T6A	

4. OPERATING ELEMENTS

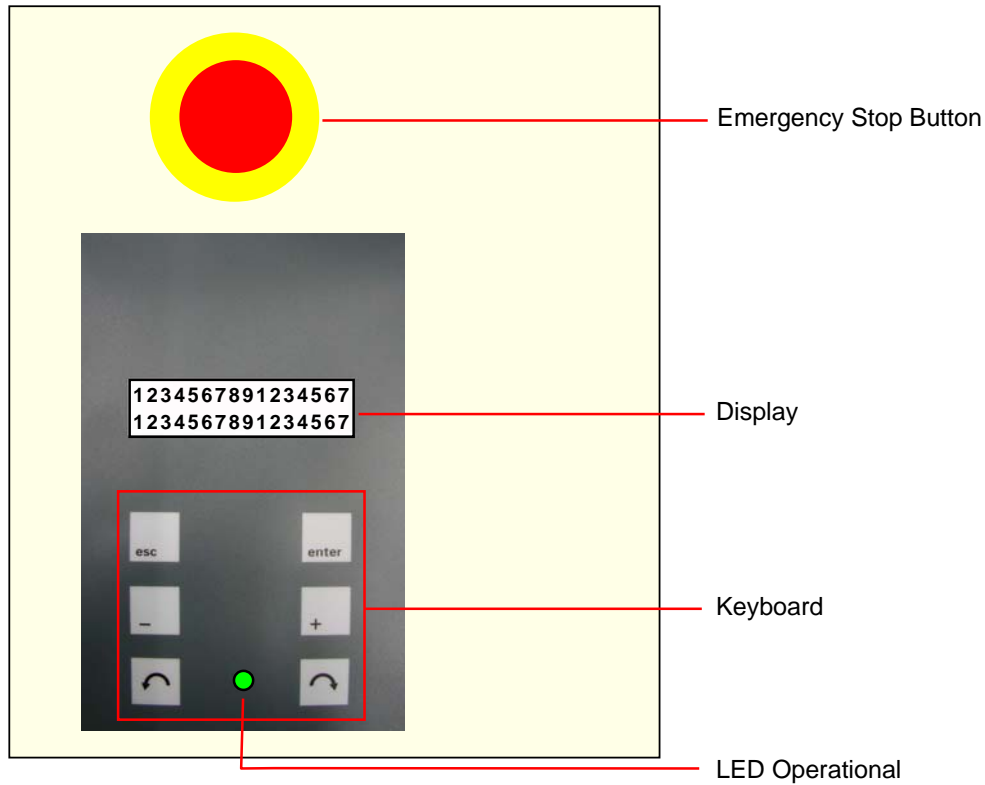
4.1. Main Switch

The CP-871 has no main switch. The power supply is cut off by removing the power cord from the machine or by using the emergency stop button.



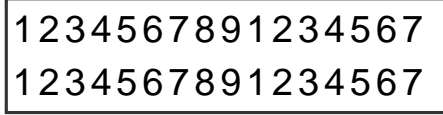
Picture 4.1: Main Switch

4.2. Control Panel








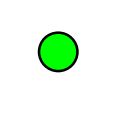

Picture 4.2: Control Panel with Keyboard

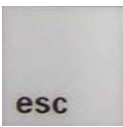
4.2.1. Display



Picture 4.2.1: Display

4.2.2. Keyboard

	<p>Escape Key: Leave the entry mask or the menus</p>		<p>Creeping Speed Key – Left: Moves the machine with reduced speed against the machining direction</p>
	<p>Enter Key: Activate the entry mask or confirm the entry</p>		<p>Creeping Speed Key – Right: Moves the machine with reduced speed in the machining direction</p>
	<p>Minus Key: Minimize the value in a input field or scroll in the selection menu or in the sub-menus.</p>		<p>Operational LED: The LED indicates that the machine is in the upper dead center and ready for use.</p>
	<p>Plus Key: Increase value in the input field or or scroll in the selection menu or in the sub-menus.</p>		



Escape Key in the main menu:
By activating the Escape key in the main menu (minimum 1x), the machine returns to the home position as soon as the machine hits high resistance (e.g. contact material) the rotational direction changes.

5. MONITORS, MENUS

Start menu

Panel V. XX.XX
Drive V. XX.XX

When starting the CP-871, the software version is briefly indicated.

Main Menu

Counter: 999999
Batch: 009999

Selection menus

Menu:
Counters

Menu:
Functions

Menu:
Settings

Menu Counters

Menu Functions

Menu Settings

Reset Counter
990900

Set Batch
000900

Total Counter
99090000

Crimp Speed
100%

Crimp Force
ON/OFF

Pneumatic Valve
ON/OFF 220ms

Split Cycle
ON/OFF 120°

Split Cycle
Speed 75%

Password
###

Language
English

Contrast:
Setting














Endurance Test
000900

5.1. Main Menu














Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • Lot Counter • Piece Counter
SAFETY COVER OPEN	<ul style="list-style-type: none"> • Error Message Display • Safety cover open, crimping error, machine not at home position, activating device not ready.
Counter: 999999 Batch Processed	<ul style="list-style-type: none"> • Information Display • Lot processed

5.2. Settings















5.2.1. Menu language

Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • Main Menu
Menu: Counters	<ul style="list-style-type: none"> •  , Selection menu „Counters“
Menu: Settings	<ul style="list-style-type: none"> • With 2 x  change to „Settings“ in the menu
Password ####	<ul style="list-style-type: none"> • With  log into the sub-menu password •  , Password entry is activated (the first figure flashes) Password 0200.
Password 0###	<ul style="list-style-type: none"> • Change the numerical value  or  . Once the wanted value is reached, confirm  . (the second figure flashes). • Repeat the procedure until all four figures have been entered
Language English	<ul style="list-style-type: none"> •  , Sub-Menu language setting (if the password was incorrectly entered the sub-menu cannot be accessed). •  , Function Language setting gets activated. With  or  choose the language (German, English, French, Italian, Spanish) •  , Confirm language.
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x  , back to main menu.



5.2.2. Contrast Setting

<p>Counter: 999999 Batch: 009999</p>	<ul style="list-style-type: none"> • Main Menu
<p>Menu: Counters</p>	<ul style="list-style-type: none"> • , Selection menu „Counters“
<p>Menu: Settings</p>	<ul style="list-style-type: none"> • With 2 x  change to „Settings“ in the menu
<p>Password ####</p>	<ul style="list-style-type: none"> • With  log into the sub-menu password • , Password entry is activated (the first figure flashes) Password 0200.
<p>Password 0###</p>	<ul style="list-style-type: none"> • Change the numerical value  or . Once the wanted value is reached, confirm . (the second figure flashes). • Repeat the procedure until all four figures have been entered
<p>Contrast Setting</p>	<ul style="list-style-type: none"> • 2 x , Sub-Menu “contrast setting” (if the password was incorrectly entered the sub-menu cannot be accessed). • , Function contrast setting gets activated. • Set with  or  the contrast • , Confirm settings.
<p>Counter: 999999 Batch: 009999</p>	<ul style="list-style-type: none"> • 2 x , back to main menu.





5.2.3. Endurance Test

<p>Counter: 999999 Batch: 009999</p>	<ul style="list-style-type: none"> • Main Menu
<p>Menu: Counters</p>	<ul style="list-style-type: none"> • , Selection menu „Counters“
<p>Menu: Settings</p>	<ul style="list-style-type: none"> • With 2 x  change to „Settings“ in the menu
<p>Password ####</p>	<ul style="list-style-type: none"> • With  log into the sub-menu password • , Password entry is activated (the first figure flashes) Password 0200.
<p>Password 0###</p>	<ul style="list-style-type: none"> • Change the numerical value  or . Once the wanted value is reached, confirm . (the second figure flashes). • Repeat the procedure until all four figures have been entered
<p>Endurance Test 000900</p>	<ul style="list-style-type: none"> • 3 x , sub-menu „Endurance Test“ (if password was entered incorrectly, the menu cannot be selected). • , Function “Endurance Test” is activated. With  or  the number of cycles get chosen. • , Confirm entry. the Endurance Test is activated and the number of cycles chosen are processed. • By pressing . Endurance Test can be discontinued
<p>Counter: 999999 Batch: 009999</p>	<ul style="list-style-type: none"> • 2 x , back to main menu.









5.3. Menu Counters

Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • Main menu
Menu: Counters	<ul style="list-style-type: none"> • , Selection menu „Counters“
Reset Counter 990900	<ul style="list-style-type: none"> • With  change to menu „Counters“.





5.3.1. Reset Counter

Reset Counter 990900	<ul style="list-style-type: none"> • , Activate „Reset Counter“ (figures flash).
Reset Counter 000000	<ul style="list-style-type: none"> • , Reset Counter
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to the main menu or directly to the submenu “Set Batch” with .




5.3.2. Programming Batch

Set Batch 000900	<ul style="list-style-type: none"> • , Submenu „Set Batch“. • , Activate function „Set Batch“.
Set Batch 002500	<ul style="list-style-type: none"> • With  or  Enter Batch. • , Confirm entry.
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to main menu or directly to submenu „Total Counter“ with .
Counter: 999999 Batch Processed	<ul style="list-style-type: none"> • Once the Batch is reached „Batch Processed“ will appear. By pressing  the new Batch is activated. To deactivate the Batch function, programm a Batch value of „000000“.







5.3.2.1. Total Counter

Total Counter 99090000	<ul style="list-style-type: none"> • 2 x , sub-menu „Total Counter“ (Information)
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to main menu. With  into sub-menu „Det Batch“ or with 2x  into sub-menu „Reset Counter“.

5.4. Functions

Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • Main Menu
Menu: Counters	<ul style="list-style-type: none"> • , Selection menu „Counters“
Menu: Functions	<ul style="list-style-type: none"> • With  go to menu „Functions“
Crimp Speed 100%	<ul style="list-style-type: none"> • With  go to sub-menu „Functions“.

5.4.1. Crimp Speed

Crimp Speed 100%	<ul style="list-style-type: none"> • , „Crimp Speed“ function is activated (figures are flashing).
Crimp Speed 080%	<ul style="list-style-type: none"> • With  and  one can adjust the pressing speed in percentage. • 100% ⇨ max. speed ⇨ ca. 350ms • 5% ⇨ min. speed ⇨ ca. 1s • , accept entry.
Counter: 999999 Batch: 009999	<ul style="list-style-type: none"> • 2 x , back to main menu or with  direct into the sub-menu „Crimp Force“ (Crimp Force monitoring).

5.4.2. Crimp Force

This feature does not function with *PANDUIT* product and is not supported by *PANDUIT*.

5.4.3. Pneumatic Valve (Option)

CAUTION / VORSICHT

A badly set feeder timing may damage the machine. Always install pneumatic tools without contact material, until the feeder timing is properly set.

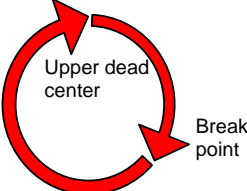
<div style="border: 1px solid black; padding: 2px;"> Pneumatic Valve OFF </div>	<ul style="list-style-type: none"> 2 x , sub-menu „Pneumatic Valve“. With , „Pneumatic Valve“ function is activated (figures are flashing).
<div style="border: 1px solid black; padding: 2px;"> Pneumatic Valve ON 220 ms </div>	<ul style="list-style-type: none"> With and activation of the „Pneumatic Valve“ function and by press the key timing of the valve can be programmed. , accept entry. The length of time the valve is engaged is permanently programmed and can not be changed..
<div style="border: 1px solid black; padding: 2px;"> Counter: 999999 Batch: 009999 </div>	<ul style="list-style-type: none"> 2 x , back to the main menu or with go directly into the sub-menu „Split Cycle“.

- Connect the compressed air on the pressure gauge.
- Assemble the tool according to Chapter 6.3 Applicator Assembly on page 23.

- Connect the applicator to the normally open port of the pneumatic valve.

- Switch on the air pressure unit using the main switch at the pressure gauge.
- Set gage at 6 bar processing pressure

5.4.4. Split Cycle

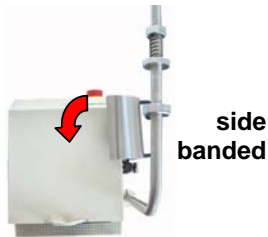
<p>Split Cycle OFF</p>	<ul style="list-style-type: none"> • 3 x +, sub-menu „Split Cycle“. • enter, „Split Cycle“ function is activated (figures are flashing).
<p>Split Cycle ON 120°</p>	<ul style="list-style-type: none"> • With + and - the „Split Cycle“ function can be activated and by press the enter key the breakpoint can be programmed.
	<ul style="list-style-type: none"> • The „Split Cycle“ is used mainly for end sleeve contacts, to centre the contact in the crimping stamp and to ensure easier handling for the operator.
<p>Split Cycle Speed 75%</p>	<ul style="list-style-type: none"> • Change to the sub-menu „Split Cycle Speed“ with +. • enter, „Split Cycle Speed“ function is activated (figures are flashing).
<p>Split Cycle Speed 45%</p>	<ul style="list-style-type: none"> • With + and - the pressing speed can be adjusted in percent. The speed is programmed from the upper dead center to the breakpoint. • 100% ⇒ max. Speed. • 5% ⇒ min. Speed. • enter, accept entry.
<p>Counter: 999999 Batch: 009999</p>	<ul style="list-style-type: none"> • 2 x esc, back to the main menu or with - back into the previous menu. • Press the esc key to initialise the machine (min. 3s)

6. TOOL REPLACEMENT

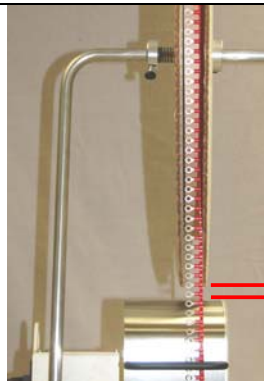
6.1. Roller Carrier



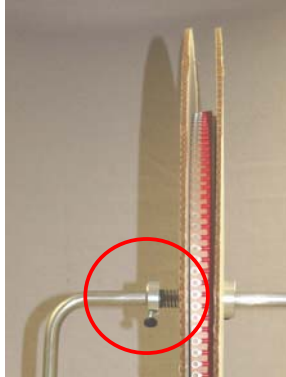
- Loosen both inner hexagon bolts of the pipe clamp on the left side of the machine.



- Turn the roller carrier 90° to the right for side banded contacts.

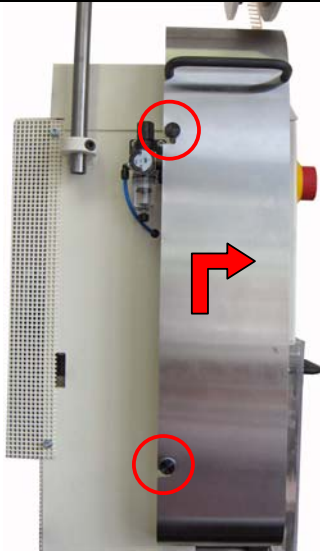


- Set the height according to the contact roll.
- Tighten both hexagon bolts on the pipe clamp.

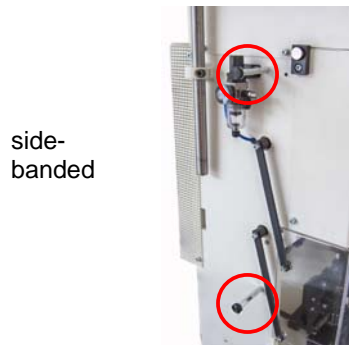


- Attach the rear dead stop.
- Assemble the contact roll.
- Set the braking power for the contact roll using the forward dead stop and the spring.

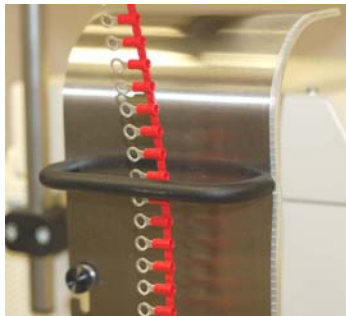
6.2. Contact guide plate



- Loosen both of the knurled screws and lift the sheet plate.
- Pull the sheet plate to the right and then remove it.



- Assemble the sheet plate onto the distance bolt at the left for side feed applicators.
- Attach the sheet plate using the knurled screws.

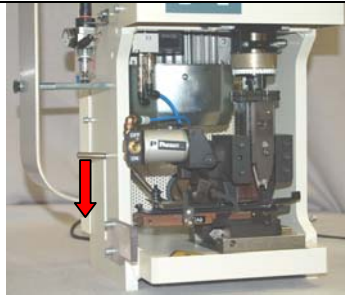


- The contact material must be fed through the black leading bracket
- Feed material into the applicator.

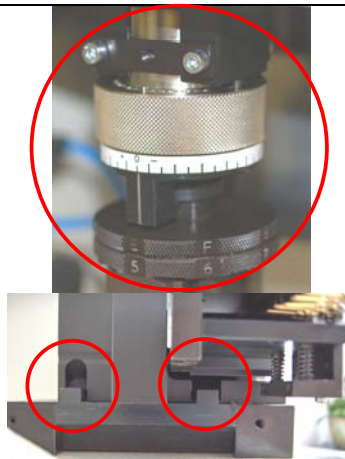
6.3. Applicator Assembly



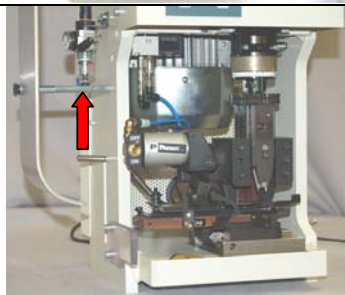
- Open the front guard and remove the contact material.



- Move the clamping lever on the left downwards until the clamps are open.




- Assemble / disassemble the tool in the nut and after remove at the bottom from the retaining clamps of the applicator ground plate.





- Move the clamping lever upwards until the clamping fingers clamp the tool in their respective grooves.
- Check that the tool is properly fastened and close the protective cover.
- Set the tool according to the operating guidelines set out by the manufacturer.

6.4. Remove lateral cover

To use large tools on the machine a part of the lateral safety cover can be removed.

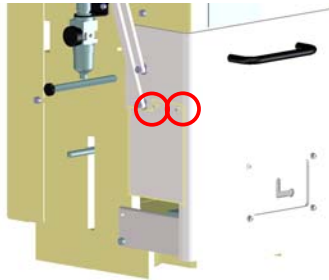


**CAUTION / VORSICHT**

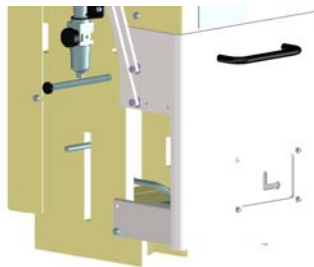
As part of the tools may protrude laterally from the machine's guard, these may come in touch with movable mechanical parts.
If this happens, the machine may no longer conform to the CE standard rules.
Therefore removal of the lateral part of the guard is at ones own risk.




- Open the front guard (safety cover) and remove contact material
- Loosen both knurled screws and lift the sheet plate.
- Pull the sheet plate to the right and remove.





- Loosen both inside hexagonal screws.



- Remove the lateral cover piece.
- Assemble the tool and the contact lead.




**CAUTION / VORSICHT**

To ensure safety, assemble the lateral cover piece removed immediately after use.

6.5. Setting the Crimp Height

The crimping height of the CA-800EZ and CA9 applicators can be adjusted within the applicator. Further crimp height adjustments can be made to the press itself.





CAUTION / VORSICHT



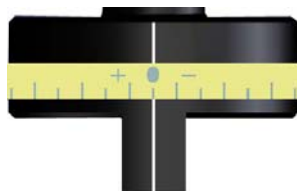
After each tool change, (before the first crimp), set the height of the machine to 0
 Not doing so may damage the tool.
 Only qualified personnel may carry out this setting.



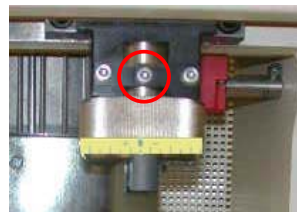
- Micro adjustment of the crimp height.



- Turn the flange toothed surface.
- Minus direction, towards the left, increases the crimping height. (e.g. 1.27 => 1.30).
- Plus direction, towards the right, decreases the crimping height (e.g. 1.27 => 1.24).






- The setting is limited to ± 0.25 mm.
- The graduation is 0.025 mm per line.
- The reference point (135.788 mm) is marked with the figure 0.

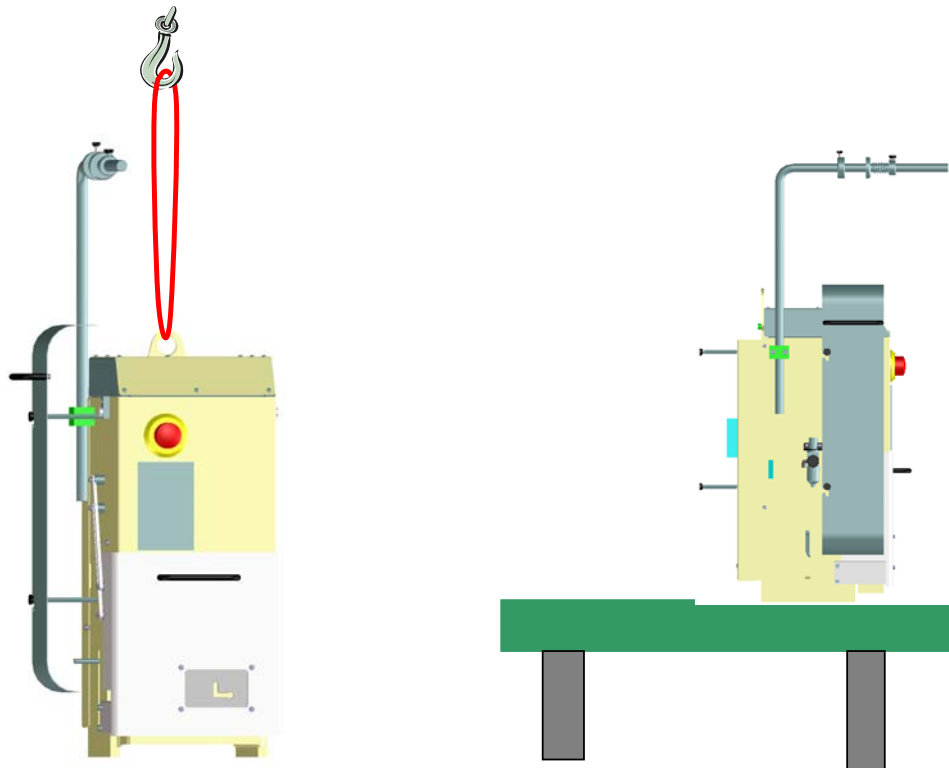


- Should the height setting not be used, this function can be blocked by tightening the inner hexagonal screw.

7. START-UP


		CAUTION / VORSICHT	
The CP-871 may only be started-up by trained personnel (Panduit personnel or trained personnel at the user).			



- After unpacking use the included lifting column and lift the machine with a crane or another auxiliary device onto a leveled working area (table, workbench, etc.)




- Open the safety cover and remove any packaging residuals.
- Connect the foot pedal.
- Plug in the line cord.

7.1. Connect Compressed air

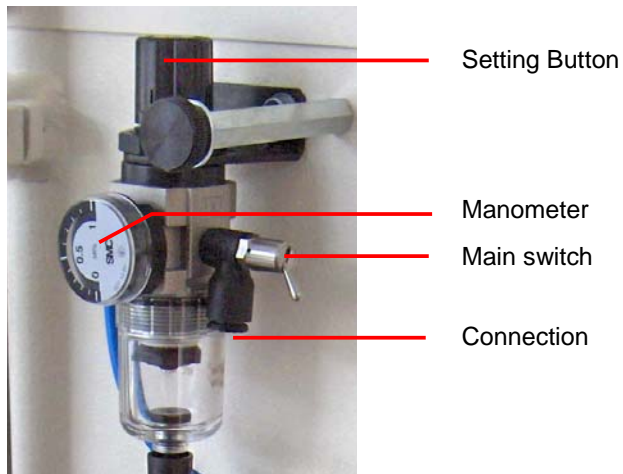


**CAUTION / VORSICHT**



- The air pressure's entry pressure may never exceed 7 bar / 0.7 MPa
- Operating pressure must be set at a minimum of 4-5 bar / 0.4-0.5 MPa
- Use only dry, clean, oil free air pressure.

- Connect the compressed air to the service unit.
- Adjust the operating pressure.
To do so pull the setting button from the interlock and turn clockwise until the manometer shows 4-5 bar (0.4-0.5 MPa). Press the setting button downward until it engages.



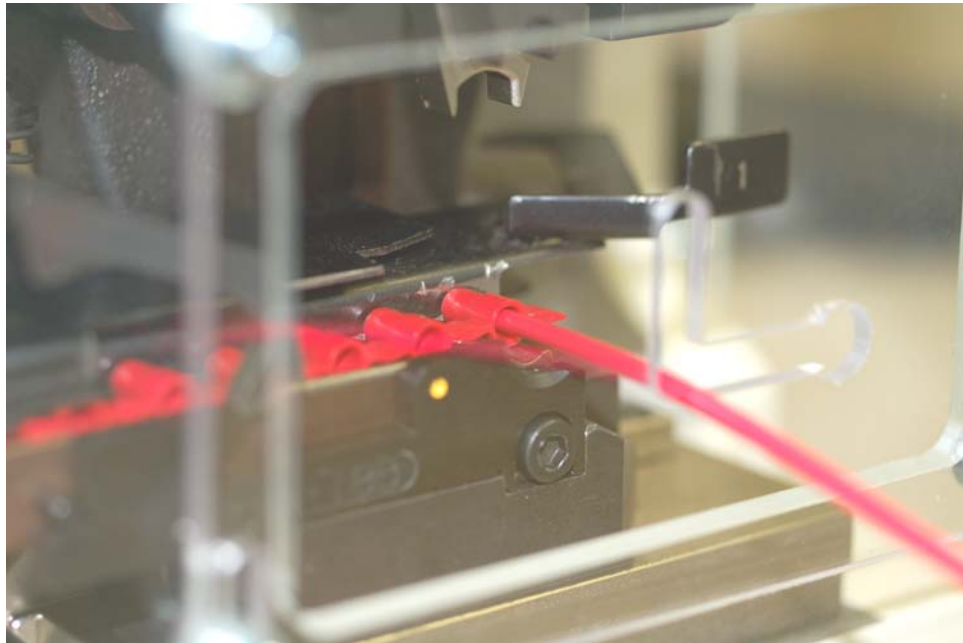
Picture 7.1: Connect Compressed air

8. PRODUCTION

- Engage the CP-871 by plugging the line cord and/or unlocking the Emergency-Off button. The CP-871 activates itself.
- Set the menu language according to the instructions in chapter 5.2.1 Menu language on page 14.
- Assemble the contact material according to the instructions in chapter 6.1 Roller Carrier on page 21 and chapter 6.2 Contact guide plate on page 22.
- Assemble the applicator according to the applicator instructions in chapter 6.3 Applicator Assembly on page 23.

8.1. Production start




- Lead the cable through the opening of the protection cover to the applicator's wire stop or using the plug connection as a reference.



Picture 8.1: Production start

- The cycle will be activated only when the green LED is on.
- Processing is activated with the foot pedal.
- The crimping press moves the tool into the bottom dead center and after that to the upper dead center.
- The tool separates the plug connection from the belting band, crimps the plug connector onto the conductor and feeds a new plug connector into position. The belting band gets cut by the tool.
- Remove the cable with the crimped connector.
- As soon as the LED on the control panel turns green the next cycle can be activated.

9. FAULT MESSAGES

Fault	Diagnosis	Action
Message: <i>Protection Cover open</i>	<ul style="list-style-type: none"> Protection cover open 	<ul style="list-style-type: none"> Connect protection cover to CP-871.
Message: <i>Machine not in home Position</i>	<ul style="list-style-type: none"> Machine is not in the upper dead center or blocked 	<ul style="list-style-type: none"> With the help of  or  return to Home Position. The green LED glows By activating the  key in the main menu (minimum 3x), the machine returns to the home position. The machine changes the turning direction automatically as soon as it is in contact with a resistor.
Message: <i>Crimp Drive not ready</i>	<ul style="list-style-type: none"> 15 V Error Over current fault Over temperature fault Watchdog fault 	<ul style="list-style-type: none"> Check fuse on print machine over-loaded replace drive
Message: <i>CFM not ready</i>	<ul style="list-style-type: none"> Crimp force monitoring without function. 	<ul style="list-style-type: none"> Turn on CFM and check the connection of the cable. Set the CFM to the production menu.
No display on the monitor	<ul style="list-style-type: none"> Power supply not connected Fuse defect Emergency stop activated 	<ul style="list-style-type: none"> Disengage the emergency-off button or plug in power. Check the fuse
Machine does not switch on	<ul style="list-style-type: none"> Power supply not connected Fuse defect Emergency stop activated 	<ul style="list-style-type: none"> Disengage the emergency-off button Plug in power Check fuse on the power supply.
Wrong crimping height	<ul style="list-style-type: none"> Crimp height not adjusted 	<ul style="list-style-type: none"> Adjust the crimp height on the machine adjustment.
Contact material does not feed correctly	<ul style="list-style-type: none"> Roller carrier wrong adjusted Contact break wrong adjusted Contact guide plate wrong mounted 	<ul style="list-style-type: none"> Adjust the position of the roll on the roller carrier. Set the contact break. Mount the contact guide right. The contact material must be fed trough the black leading bracket.

10. DISPOSAL

The equipment must be properly disposed of according to the local and legal regulations.

10.1. Packaging

The packaging consists of environment friendly materials such as wood, nails, cardboard, paper and synthetics and can be disposed of as regular waste.

10.2. Machine

The machine is made up of 90% aluminium and steel, 5% other metals and up to 5% electric materials and synthetics.

The environmentally friendly disposal of the machine must be done according to each country legal regulations.

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CP-871

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SPARE PARTS MANUAL

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Part Number	Name
CA32147A01	Pneumatic feed  A blue and black pneumatic feed assembly consisting of a main cylindrical body and a separate mounting bracket with two screws.
CA32148A01	Lamp 230 VAC  A black lamp assembly with a curved neck and a cylindrical lamp head, connected to a power cord with a standard two-prong plug.
CA32149A01	Lamp 115 VAC  A black lamp assembly with a curved neck and a cylindrical lamp head, connected to a power cord with a standard two-prong plug.
TP25130B01	Finger protection  A rectangular white plastic plate with a central T-shaped cutout and four mounting holes at the corners.
TP25131B01	Hole Cover  A rectangular white plastic cover with a central rectangular hole and two mounting holes at the top edge.
CA32152A01	Power Cord Europe  A power cord with a standard two-prong plug on one end and a circular connector on the other.

Part Number	Name
CA32153A01	Power Cord USA 
CA32154A01	Fuses 6.3 A/T 5x20 (230V) 
CA32155A01	Fuses 10A/T SPT 5x20 (115V) 
CA32156A01	Foot pedal 
CA32157A01	Grease Microlube GBUY 131 
CA32158A01	Hex Key Set 
CA32159A01	Packaging 