

AUTOMATIC WIRE STRIPPING AND FERRULE CRIMPING PRESS OPERATION MANUAL

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Original Instructions



**TO REDUCE THE RISK OF INJURY, USER
MUST READ INSTRUCTION MANUAL**



NOTE: In the interest of higher quality and value, Panduit products are continually being improved and updated. Consequently, pictures may vary from the enclosed product.

For the most current version of this instruction manual, go to www.panduit.com.

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The information contained in this manual is based on our experience to date and is believed to be reliable. It is intended as a guide for use by persons having technical skill at their own discretion and risk. We do not guarantee favorable results or assume any liability in connection with its use. Dimensions contained herein are for reference purposes only. For specific dimensional requirements consult the factory. This publication is not to be taken as a license to operate under, or a recommendation to infringe any existing patents.

1. Basic information

For greater clarity, only the order designation of CP-991 is used throughout this document. For safe handling and trouble-free operation of the CP-991, you must be familiar with and observe the safety notes.

1.1 Intended use



WARNING: The CP-991 is intended solely for stripping and crimping.

In doing so, the conductor and ferrules with cross section or sleeve length according to "Suitable ferrules and retrofit kits" on Page 12 are to be used. Only the PVC-insulated conductors may be inserted into the insertion funnel on the CP-991 for processing. Under no circumstances should solid metal parts or other similar objects be inserted. This damages the stripping blade. Unauthorized conversions that exceed the scope of modification, and changes to the CP-991 are not permitted for safety reasons.



NOTE: Correct usage includes observing all notes and complying with the predefined operating conditions.



WARNING: The CP-991 may only be used:

- as intended; and
- when in safe and fault-free condition



WARNING: All persons responsible for commissioning, operating and maintenance of the CP-991 must:

- be appropriately qualified; and
- adhere strictly to this user manual

With the CP-991, you can either:

- Strip conductors automatically; or
- Strip conductors automatically and crimp with ferrules

Flexible conductors of class 2, 5, and 6 standard according to DIN VDE 0295, ferrules as loose products according to UL 486F/CSA -C22.2 No. 291-14; and DIN 46228-4 are processed.



NOTE: Use only ferrules and spare parts from Panduit.

1.2 Permitted operators

Only authorized and instructed operators may work with the CP-991.

The operator is responsible for all other persons within the workspace.

The owner must:

- make the user manual available to the operator; and
- ensure that the operator has read and understood the manual

2. Technical Data

Main connection	100 – 240 VAC 50/60 Hz
Power consumption	50 VA
Compressed air connection CP-991	At least 4.5 bar, maximum 6 bar 1/4" plug-in nipple inner thread (Euro
standard) CP-992	At least 5 bar, maximum 6 bar
Compressed air consumption	1.2 liter / cycle
Cycle time	
CP-991	1.3s
CP-992	1.5s
Working Range	
CP-991	#24 – #12 AWG (0,25 mm ² – 4,0 mm ²)
CP-992	#12 – #8 AWG (4,0 mm ² – 10,0 mm ²)
Ferrules	Loose according to UL 486F/CSA -C22.2 No. 291-14 and DIN 46228-4
Crimping	Trapezoidal
Conductor	Class 2, 5, and 6 according to DIN VDE 0295
Control	Electrical/pneumatic
Counter	5-digit, can be reset
Dimensions (W x H x D)	9.45 x 15.4 x 19.3 in. 240 x 390 x 490 (mm)
Weight	Approx. 62 lb. (28 kg)

Name Plate




<p>Panduit Corp. 18900 Panduit Drive Tinley Park, IL 60487 USA</p> <p><u>CP-991 or CP-992</u> Serial Number</p> <p>Manufactured: MM-YY</p> <p>Conformances</p> <p>Main Connection / Input Current</p> <p>Fuse Detail</p> <p>Compliance</p> <p>Country of Origin</p>	<p>PANDUIT S/N: XXXXXX Tinley Park, IL U.S.A. Mfg: MM-YY</p> <p>CP-991 UK CA CE Stationary Tool</p> <p>Conforms to: ANSI/UL 987 - 2013 Cert. to: CSA C22.2 No. 73, R2013 100-240 VAC / 50/60 Hz 50 VA</p> <p>Intertek 4008921 2x - T2AL 250 VAC</p> <p>• Read instructions before using Lisez les instructions avant l'utilisation • Before opening - disconnect main power Avant d'ouvrir, l'appareil couper l'alimentation principale</p> <p>This device complies with part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.</p> <p><i>This Class B digital apparatus complies with Canadian ICES-001. Cet appareil numérique de la classe B est conforme à la norme NMB-001 du Canada.</i></p> <p>Made in Germany Fabriqu� en Allemagne</p>
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3. PRECAUTIONS AND GENERAL GUIDELINES



The basic condition for safe use and proper operation of the CP-991 is the knowledge and attention to the safety information provided in this manual.


The following safety information must be observed by **all** persons who will work with the CP-991 Crimping Press.



All rules and instructions for the work place must be observed, especially those for prevention of accidents.



	This symbol is used to call your attention to hazards or unsafe practices which could result in an injury or property damage. The signal word, defined below, indicates the severity of the hazard. The message after the signal word provides information for preventing or avoiding the hazard.	
	WARNING	Hazards which, if not avoided, COULD result in severe injury or death.
	CAUTION	Hazards or unsafe practices which, if not avoided, MAY result in injury or property damage.

3.1 Safety Warnings


	 WARNING
	<ul style="list-style-type: none"> • Read all safety warning and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury. • Save all warnings and instructions for future reference. • The term “power tool” in the warnings refers to your main-operated (corded) power tool.


	Panduit Corp. recommends the tool be used with all installed safety features. Customer assumes all liability for injury that could result from improper use of this tool and responsibility for all necessary training to ensure safe operation of this tool.
	<ul style="list-style-type: none"> • <i>FOR INSTALLATION AND USE BY TRAINED PERSONNEL ONLY.</i>
	<ul style="list-style-type: none"> • <i>IF ANY DAMAGE TO THE PRODUCT IS APPARENT OR SUSPECTED, DO NOT USE THE PRODUCT. REFER PRODUCT TO QUALIFIED SERVICE PERSONNEL.</i>
	<ul style="list-style-type: none"> • <i>FCC WARNING: CHANGES OR MODIFICATIONS TO THE PRODUCT COULD VOID THE USER’S AUTHORITY TO OPERATE THE PRODUCT.</i>
	<ul style="list-style-type: none"> • <i>USE RECOMMENDED ACCESSORIES. CONSULT THE OWNER’S MANUAL FOR RECOMMENDED ACCESSORIES. THE USE OF IMPROPER ACCESSORIES MAY CAUSE RISK OF INJURY TO PERSONS.</i>

	 WARNING
	<p>DO NOT OPERATE POWER TOOLS IN EXPLOSIVE ATMOSPHERES, SUCH AS IN THE PRESENCE OF FLAMMABLE LIQUIDS, GASES OR DUST.</p> <p><i>Power tools create sparks which may ignite the dust or fumes.</i></p> <p><i>Provide adequate ventilation around the product.</i></p>





		<p>⚠ WARNING</p> <p>KEEP WORK AREA CLEAN AND WELL LIT. <i>Cluttered or dark areas invite accidents.</i></p> <p>KEEP CHILDREN AND BYSTANDERS AWAY. <i>All visitors should be kept a safe distance from work area.</i></p> <p>MAKE WORKSHOP KID PROOF with padlocks, master switches, or by removing starter keys.</p>
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3.2 Electrical Safety Practices





	<p><u>GROUNDING:</u> In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current which reduces the risk of electrical shock. This tool is equipped with an electric cord that includes an equipment-grounding conductor and a grounding plug. The plug must be inserted into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.</p> <p>Improper connection of the equipment grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.</p> <p>Check with a qualified electrician, or service personnel if the grounding instructions are not completely understood; or if in doubt as to whether the tool is properly grounded.</p> <p>DO NOT modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.</p> <p>Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug. Replace a damaged or worn cord immediately.</p> <p>Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators. <i>There is an increased risk of electric shock if your body is earthed or grounded.</i></p> <p>DO NOT abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.</p>
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	<p>⚠ WARNING</p> <p>Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. <i>Unmodified plugs and matching outlets will reduce risk of electric shock.</i></p> <p>USE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Size the cord according to table below. If in doubt, use a heavier gauge.</p>
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Ampere Rating		Volts	Total length of cord in feet (m)			
		100 V	25' (7 m)	50' (15 m)	100' (30 m)	150' (46 m)
240 V	50' (15 m)	100' (30 m)	200' (61 m)	300' (92 m)		
More Than	Not More Than	AWG				
0	6	Minimum Wire Gauge of Cord	18	16	16	14

	 WARNING
	<p>ONLY OPERATE THE CP-991 IN A CLEAN, DRY, INDOOR ENVIRONMENT.</p> <p>DO NOT EXPOSE POWER TOOLS TO RAIN OR WET CONDITIONS.</p> <p><i>Water entering a power tool will increase the risk of electric shock.</i></p>
	 KEEP AWAY FROM LIVE CIRCUITS:
	<ul style="list-style-type: none"> • Operating personnel must not remove covers. • Replacement of components and internal adjustments must be made by qualified maintenance personnel. • Disconnect power cable when replacing components. • Dangerous voltages may exist even with the power cable removed. • To avoid injuries, always disconnect power and discharge circuits by grounding before touching circuitry. • Input connection to the product must remain accessible as a disconnect device. • DO NOT work on the product; connect or disconnect cables during periods of lightning. • Provide wiring per national and local electrical codes.

3.3 Personal Safety

	 WARNING
	<p>Use personal protective equipment. Safety glasses must be worn at all times by all persons operating the CP-991.</p>
	 WARNING
	<p>Hearing protection is recommended to be worn during operation of tool.</p>

1. **STAY ALERT**, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.
A moment of inattention while operating power tools may result in serious personal injury.
2. **KEEP GUARDS IN PLACE** and in working order.
These safety guards should be removed only by specialized and authorized technical persons who take care to adopt all security measures to avoid any risk of danger and injury.
3. **PREVENT UNINTENTIONAL STARTING.** Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.
Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.

4. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
5. **Remove any adjusting key or wrench before turning the power tool on.**
A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
6. **Do not overreach. Keep proper footing and balance at all times.**
This enables better control of the power tool in unexpected situations.
7. **NEVER STAND ON TOOL.**
Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
8. **Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.**
9. **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.**
Use of dust collection can reduce dust-related hazards.

3.4 Power Tool Use And Care

1. **Do not force the power tool. Use the correct power tool for your application.**
The correct power tool will do the job better and safer at the rate for which it was designed.
2. **Do not use the power tool if the switch does not turn it ON and OFF.**
Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
3. **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.**
Such preventive safety measures reduce the risk of starting the power tool accidentally.
4. **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.**
Power tools are dangerous in the hands of untrained users.
5. **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.**
Many accidents are caused by poorly maintained power tools.
6. **Keep cutting tools sharp and clean.**
Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
7. **Use the power tool, accessories and tool bits, etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.**
Use of the power tool for operations different from those intended could result in a hazardous situation.

3.5 Service

- **Have your power tool serviced by a qualified repair person using only identical replacement parts. Contact Panduit Tool Service at the following locations:**

<p>Panduit Electrical Products Division (USA) 16530 W. 163rd Street Lockport, IL 60441 USA</p> <p>Tel.: 1-800-777-3300</p>	<p>Panduit EMEA Service Center (EUR) EMEA Tool Service Center Bedrijvenpark Twente 360 7602 KL Almelo tel + 31 546 580 451</p>
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3.6 Dedicated Usage

- Use the CP-991 only for automatic wire stripping and ferrule crimping.
- Continuously molded ferrules with cross-sections ranging from #20 – #14 AWG (0,5 – 2,5mm²) and a strip length of 5/16" (8 mm) must be used.
- Only the intended PVC insulated cables may be inserted into the funnel guide of the CP-991. Never insert solid metal parts or items, the stripping knives would be damaged.
- Third party reconstruction and changes of the CP-991 beyond retooling are not allowed because of safety!

3.7 Dangers

- Use the CP-991 only when the cover is closed.
- Before carrying out any work with the cover open (e.g. retooling, maintenance work), disconnect the CP-991 from the main power supply
- Make sure that no strange objects are inside the case.

3.8 Places for Use

Avoid operation in the following areas:

- Damp or dusty places
- Places exposed to high or low temperatures, or direct sunlight
- Operating temperature range: 59°F to 95°F (15°C to 35°C)
- Condensation can form when moving from a cold to a warm place
- Open cover to evaporate any condensation before using the CP-991
- Do not spill any liquids over the CP-991
- Protect the CP-991 from heavy vibrations and jolts

3.9 Safety Devices

- The CP-991 can be switched OFF through:
 - The main switch (O OFF)
 - Pulling out the main plug
 - Sliding back the cover (by two micro switches)
 - The cover is built in for safety. It may not be changed, removed or by-passed by reconstructions. A label points to existing dangers.



Before opening disconnect main power.

3.10 Authorized user

- Only authorized and instructed users are allowed to work with the CP-991
- The user has a responsibility to other persons inside the CP-991 work place

The customer must:

- Make the operation manual accessible to the user; and assure that the user has read and understood the manual.

3.11 Work sites



NOTE: For operation and storage, avoid the following:

- humid or dusty places; and
- locations exposed to high levels of heat, direct sunlight or low temperatures [operating range: 59°F to 95°F (15°C to 35°C)]



NOTE:

If the machine is moved from a cold location to a warm location, condensation can form.

Before using the CP-991, open the front door and allow condensation to evaporate.



NOTE:

- Do not spill liquids on the CP-991
- Do not expose the CP-991 to strong vibrations or shocks



NOTE:

- Protect the compressed air hoses from heat, oil and sharp edges

3.12 For your safety



WARNING: The front door is installed for the safety of the operator. Under no circumstances must it be modified, removed or bypassed using attachments.



WARNING:

- Only use filtered compressed air with a maximum pressure of 6 bar.



• **WARNING:**

- Only operate the CP-991 when the front door is closed
- Disconnect the main plug and the compressed air plug prior to all work that requires opening the front door (e.g., retrofitting, remedial action)
- Switch off the CP-991 and disconnect the device from the compressed air during a break or when the device is not in use
- Do **not** pull on the compressed air hose to disconnect the compressed air
- Make sure that there are no foreign objects inside the housing

For safety reasons, the CP-991 automatically switches itself off if the compressed air is disconnected.

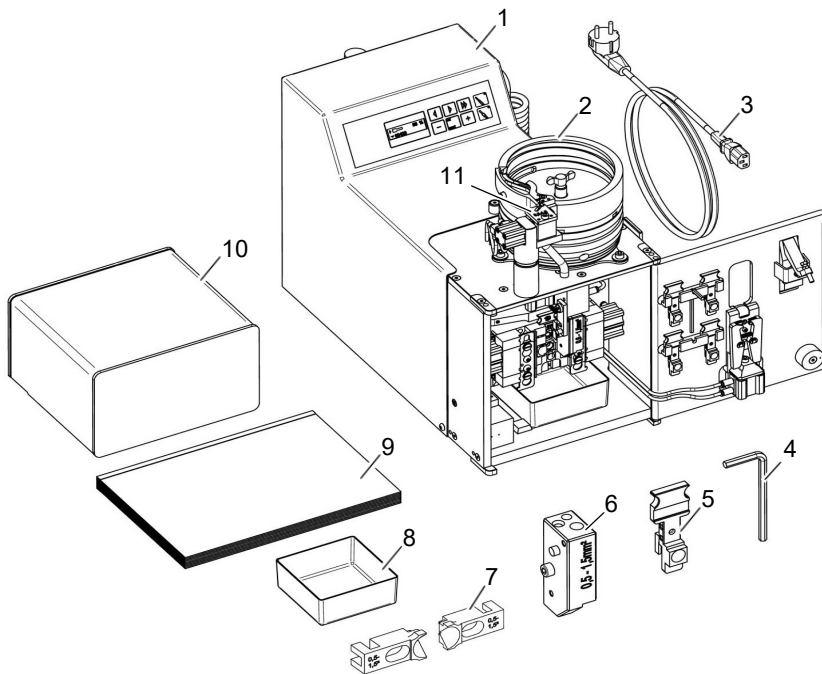


WARNING:

- Before opening the housing, disconnect the main plug and disconnect the device from the compressed air

4 Description of the CP-991 / CP-992

4.1 Scope of supply



1. Basic device
2. Feeder bowl
3. Main cable
4. Hexagonal wrench
5. Sleeve receiver
6. Reversing base sleeve
7. Cord-centering funnel
8. Waste box
9. User manual
10. Covering hood
11. Separation plate

The components have the same color-code as the ferrules (according to DIN color range)

Table 4-1 Scope of supply

Device	Scope of supply	
CP-991 and CP-992	Basic device	
	Main cable	
	Waste box	
	Covering hood	
	Hexagonal wrench	4 5/32"
Only CP-991	Feeder bowl	0.5 ... 1.5 mm ²
	Separation plate	0.5 ... 1.5 mm ²
	Cord-centering funnel	0.5 ... 1.5 mm ²
	Reversing base sleeve	0.5 ... 1.5 mm ²
	Sleeve receiver	0.5 / 0.75 / 1.0 / 1.5 mm ² , 4 items
	Crimping jaws	0.5 ... 2.5 mm ² (≥ 12 mm crimping jaws)
	Stripping blade with blade holder	

4.2 Suitable ferrules and retrofit kits

With the CP-991, you can either:

- strip conductors automatically; or
- strip conductors automatically and crimp with ferrules

Flexible conductors of class 2, 5, and 6 standard according to DIN VDE 0295, ferrules as loose products according to UL 486F/CSA -C22.2 No. 291-14; and DIN 46228-4 are processed.

The following loose ferrules can be processed with the CP-991:

Table 4-2 Suitable ferrules

Basic device	Cross-section AWG (mm ²)	Sleeve length (mm)	DIN color range	Comment	Order No.
CP-991	24/22 (0.25 / 0.34) 0.25/0.34	6 8	yellow/ turquoise	CP-991-KIT025	010799
	20 (0.5)	6 8 10 12	white		included in CP-991
	18 (0.75)	6 8 10 12	gray		
	18 (1.0)	6 8 10 12	red		
	16 (1.5)	6 8 10 12	black		
	14 (2.5)	8 10 12	blue	CP-991-KIT25	010798
	12 (4.0)	10	gray	CP-991-KIT4	010801
CP-992	12 (4.0)	10 12	gray	CP-992-KIT4	010797
	10 (6.0)	12	yellow	CP-992-KIT6	010802
	8 (10.0)	12	red	CP-992-KIT10	010803

The CP-991 retrofit kit...-KIT.... is a case that contains:

- Feeder bowl
- Reversing base sleeve
- Cord-centering funnel
- Sleeve receiver
- Separation plate
- Stripping blade (not required CP-991-KIT25)
- Crimping jaws (not required CP-991 KIT25)

4.3 Overview of the operating components

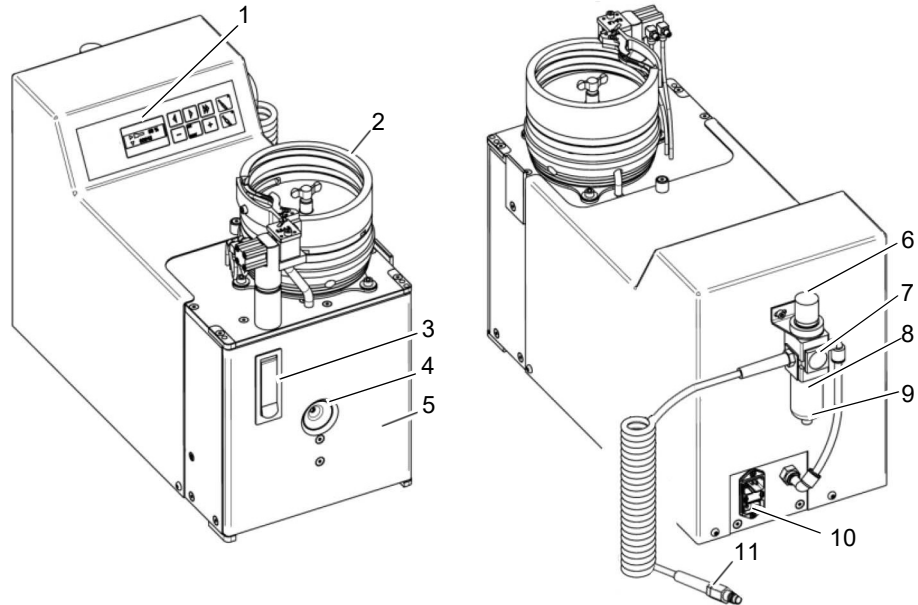







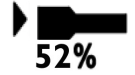








Table 4-3 Operating components

1	Control Panel	See Page 14 or description	7	Manometer	Display of the air pressure set using the air pressure regulator
2	Feeder Bowl	Storage holder for ferrules	8	Water Separator	Container for condensation
3	Door Lock	Locks the front door. The front door is opened by pressing the lower segment and is closed by pressing on the upper segment.	9	Drain Valve.	For draining the water separator
4	Insertion Funnel	The conductor is inserted through the insertion funnel in the CP-991.	10	Main Connection	Device connection for the power cable with integrated micro-fuse and switch, wide range power supply unit 100 – 240V
5	Front Door	Protects the operator from moving parts in the CP-991. The CP-991 only works when the front door is closed.	11	Compressed Air Connection	Device connection to the compressed air supply
6	Air Pressure Regulator	Setting the air pressure: Set the air pressure by pulling the regulator upwards and turning to the right (+) or left (-).			

4.4 Control panel

Table 4-4 Button functions

Button	Display	Button function
 	 	<p>Select operating mode</p> <p>Strip only For testing the incision depth of the blade. The LED on the button lights up.</p> <p>Strip and crimp The LED on the button lights up.</p>
 	 	<p>Changing the speed of the feeder bowl Increases the speed of filling the feeder bowl if new ferrules have been filled. Display shows 100%.</p> <p>The speed of the feeder bowl can be changed using the arrow buttons. The speed is shown in percent in the display.</p>
2 s	▲ 00000	<p>Setting the counter to zero Pressing the set/reset button for two seconds resets the counter to zero.</p>
5 s	  	<p>Changing the counting direction Pressing the set/reset button for five seconds changes the counting direction. The counting direction is shown in the display.</p> <p>▲ Forwards (1, 2, 3, ...) ▼ Backwards (... , 3, 2, 1)</p> <p>When counting backwards, a checkered flag appears at 0 items. The device can no longer be started. Turn the CP-991 off and on again. The CP-991 changes to forwards mode.</p>
  	▼ 00647	<p>Changing the counter reading with backwards counting Press the set/reset button briefly to change the counter reading. The selected number flashes.</p> <p>The selected number can be changed using the plus or minus button.</p> <p>Another position within the five-digit number can be selected using the arrow buttons.</p> <p>To save, press the set/reset button again.</p>

5. Starting up and operating

5.1 Selecting the installation site

!	NOTE: The device must be set up on a level and horizontal surface.
!	NOTE: For operation and storage, avoid the following: – humid or dusty places; and – locations exposed to high levels of heat, direct sunlight or low temperatures [operating range: 59°F to 95°F (15°C to 35°C)]
!	NOTE: If the machine is moved from a cold location to a warm location, condensation can form. • Before using the CP-991, open the front door and allow condensation to evaporate
!	NOTE: – Do not spill liquids on the CP-991 – Do not expose the CP-991 to strong vibrations or shocks
!	NOTE: • Protect the compressed air hoses from heat, oil and sharp edges

5.2 Determine the cross section

Check that the CP-991 is equipped for the desired cross section. If necessary, upgrade the CP-991 (see "Retrofitting" on Page 20).

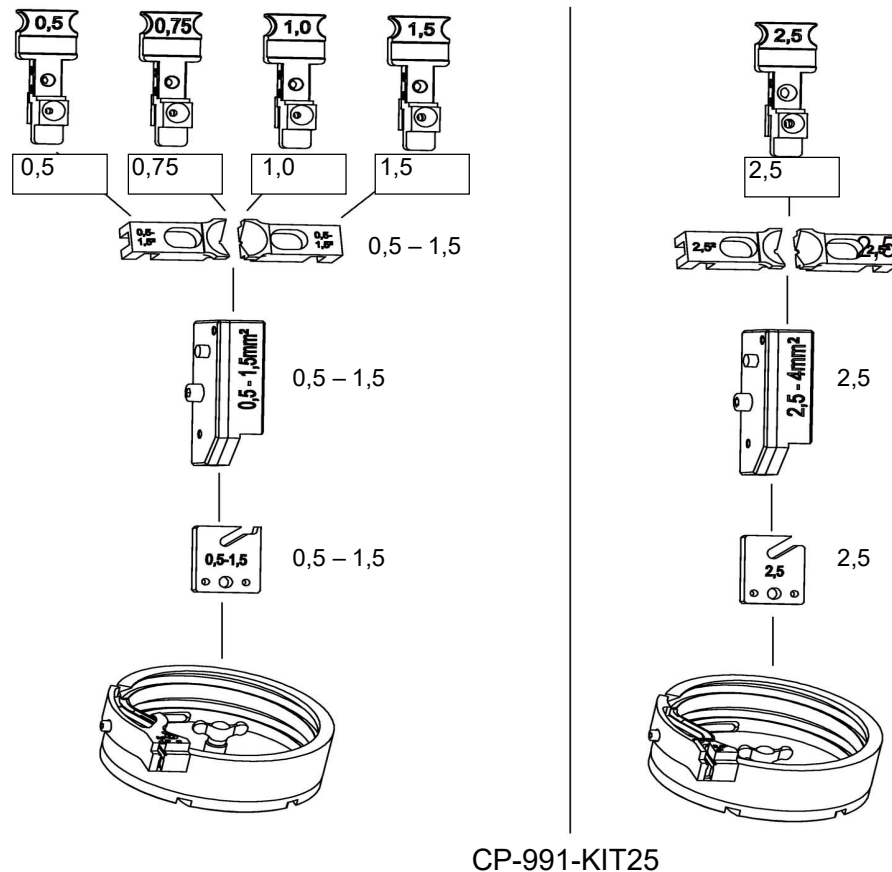
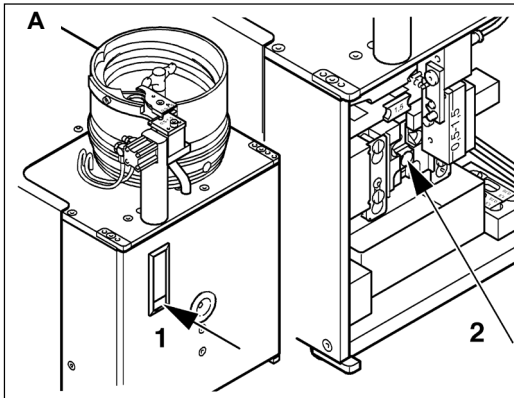


Figure 5-1 Example of CP-991 (value in mm²)

5.3 Stripping and crimping

With the CP-991, you can either:

- Strip conductors automatically; or
- Strip conductors automatically and crimp with ferrules



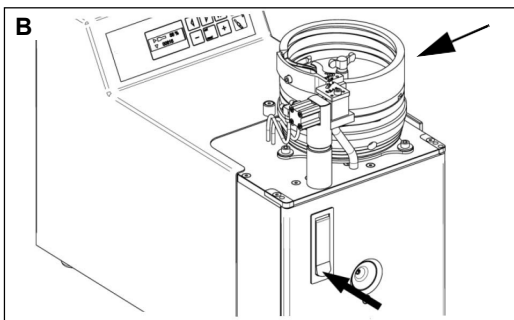
Checking the sleeve receiver



WARNING: Risk of injury!

Disconnect the main plug and the compressed air before you open the front door.

- Switch off the CP-991 with the main switch
- Disconnect the main plug
- Disconnect the compressed air connection
- Open the front door (1)

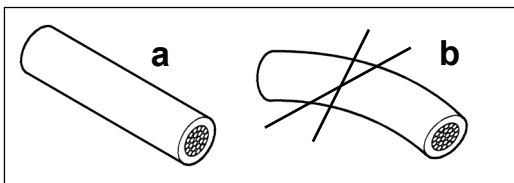


A. Stripping

- Check that the sleeve receiver and fine stranded wire centering funnel are adjusted for the conductor cross section. Modify if necessary (see Page 20).
- Check whether sleeve receiver (2) is free from ferrules

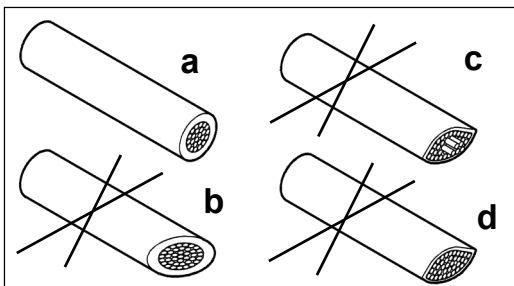
B. Stripping and crimping

- Check for the correct cross section setting. Modify if necessary (see Page 20)
- Fill ferrules into the feeder bowl [max. 500 pieces (CP-991)/ max. 200 pieces (CP-992)]
- Close front door



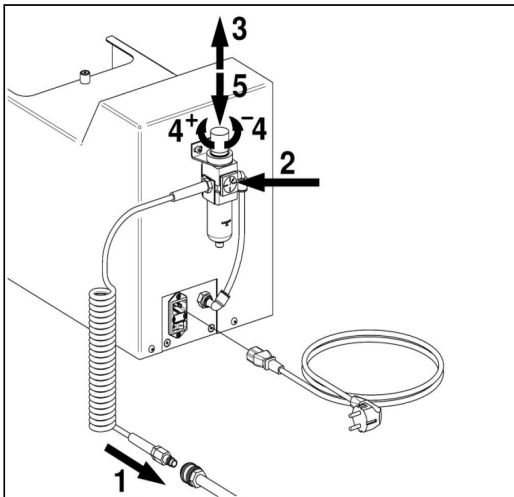
Aligning the conductor

- The conductor has to be aligned as straight as possible before processing
 - a. Bend is OK, maximum 2 – 3 mm at 6 mm length
 - b. Bend too large



Cutting the conductor

- Cut the conductor off in a clean and straight motion, for example:
 - a. Proper cut
 - b. Cut surface angled
 - c. Cut surface squeezed, single conductors pulled out
 - d. Cut surface squeezed

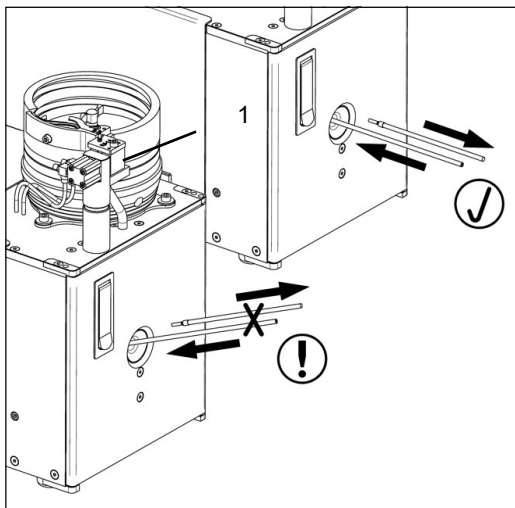


Connecting CP-991



CP-991: 4.5 bar ... 6 bar of filtered air
CP-992: 5 bar ... 6 bar of filtered air

- Connect compressed air connection (1) to the compressed air supply
- Check air pressure at manometer (2):
Operating pressure 5 bar, at least 4.5 bar (CP-991)
Operating pressure 5.5 bar, at least 5 bar (CP-992)
- Set air pressure, if necessary. Pull the air pressure regulator (3) upwards, set the air pressure by turning (4) to the right (+) or left (-) and then press the regulator (5) downwards
- Connect the main plug to the CP-991 main connection and the shock-proof plug to the main socket



Stripping conductors

A Stripping



Press the "Strip" button.

B Stripping and crimping



Press the "Strip and crimp" button. Set the speed of the feeder bowl. Wait until the ferrule is visible at the separation plate (1).

A and B

- Insert the conductor straight into the insertion funnel until it stops. As soon as the CP-991 starts, hold the conductor with slight tension
- The conductor is automatically stripped
- When the CP-991 has stopped, pull the conductor out



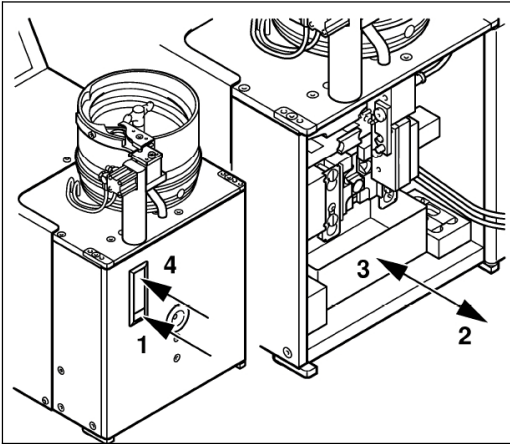
In the event of a malfunction or improper stripping, see Page 23.

Shutting down

- If necessary, read the counter and reset to zero
- Switch off the CP-991 with the main switch

6. Starting up and operating

6.1 Daily care



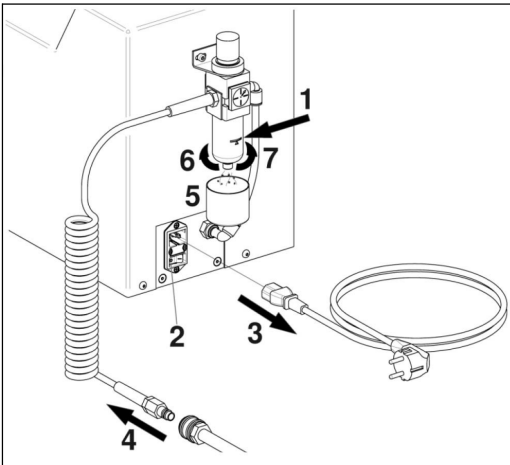
Cleaning CP-991



WARNING: Risk of injury!

Disconnect the main plug and the compressed air before you open the front door.

- Switch off the CP-991 with the main switch
- Disconnect the main plug
- Disconnect the compressed air connection
- Open the front door (1)
- Empty the drawer (2)
- Clean the inside
- Replace the drawer (3)
- Close the front door (4)



Checking the level of condensation



WARNING: Risk of injury!

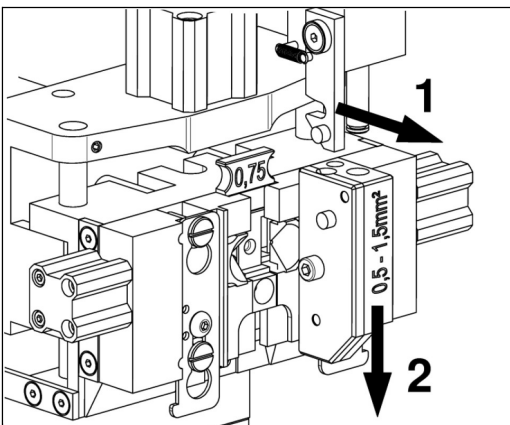
Disconnect the main plug and the compressed air before opening the drain valve.

- Check the water level in the water separator (1)

If water is in the water separator:

- Switch off the CP-991 at the main switch (2)
- Disconnect the main plug (3)
- Disconnect the compressed air connection (4)
- Store the container (5)
- Open the drain valve (6)
- Drain the water
- Close the drain valve (7)
- Plug in the main plug
- Connect the compressed air connection

6.2 Adjusting and changing the stripping blade



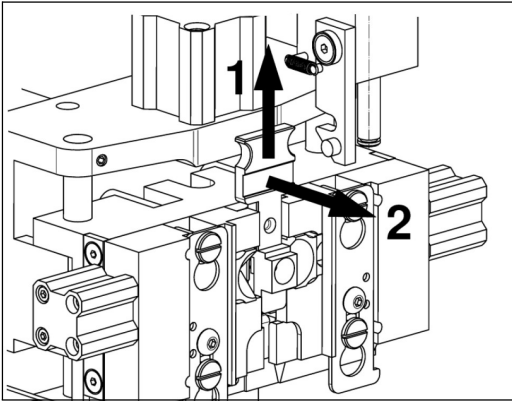
Removing the stripping blade



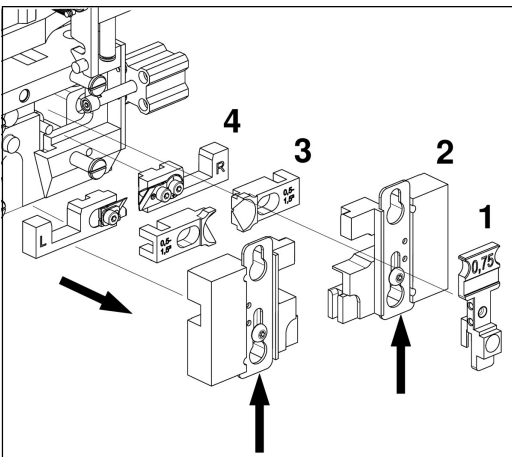
WARNING: Risk of injury!

Disconnect the main plug and the compressed air before you open the front door.

- Pull the release lever (1) forwards
- Remove the reversing base sleeve (2) downwards



- Pull the sleeve receiver (1) upwards, remove from the holder (2)



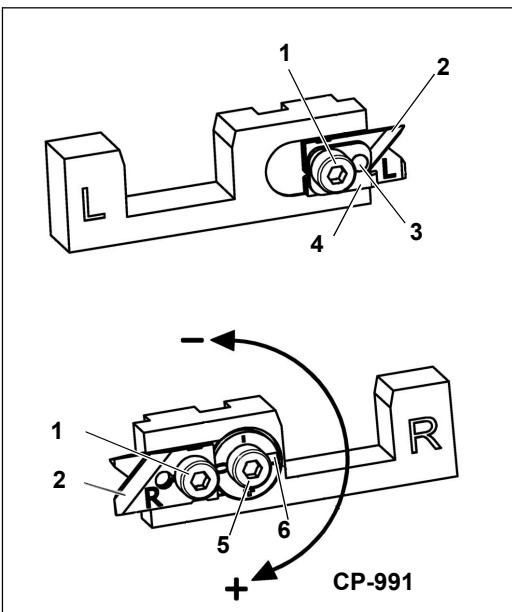
- Slide the slide upwards and pull the holder (2) forwards
- Remove the second holder in the same way
- Remove the cord-centering funnels (3) to the left and right



WARNING: Risk of injury!

The stripping blades are sharp. Be careful not to injure yourself.

- Take out both the left and right stripping blades (4)
- Worn-out or damaged blades must be replaced
- If the blades are still in working order, the malfunction can be rectified by correcting the incision depth on the right-side blade



CP-991: Changing the stripping blade



WARNING: Risk of injury!

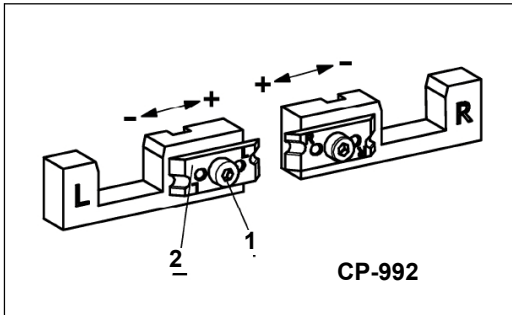
The stripping blades are sharp. Be careful not to injure yourself.

Left blade

- Unscrew the Allen screw (1) and take out the old blade (2)
- Put new blade on the pin (3)
- Fix the limit plate (4)
- Tighten the Allen screw (1)

Right blade

- Unscrew the Allen screw (1) and take out the old blade (2)
- Fix new blade
- Loosen the Allen screw (5)
- Attach tappet over the groove (6) at the correct incision depth (0 = initial position)
- Press the blade against the tappet and tighten both Allen screws (1) and (5)



CP-992: Changing the stripping blade



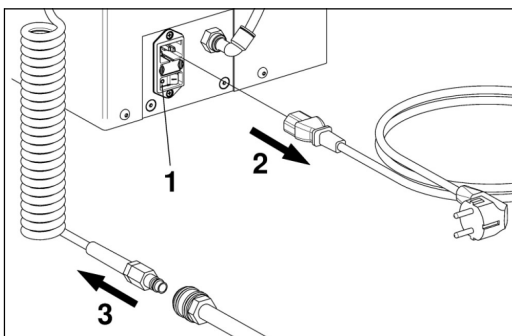
WARNING: Risk of injury!

The stripping blades are sharp. Be careful not to injure yourself.

- Unscrew the Allen screw (1) and take out the old blade (2)
- Attach the new blade to the guiding pin (3)
- Adjust the incision depth of the stripping blade to the conductor to be processed
- Adjusting the blade changes the incision depth by ± 0.25 mm
- Tighten Allen screw (1)
- Check incision depth by stripping a conductor. The copper strands must not be cut by the stripping blade.

7. Retrofitting

7.1 Changing the cross section



Preparing the modification

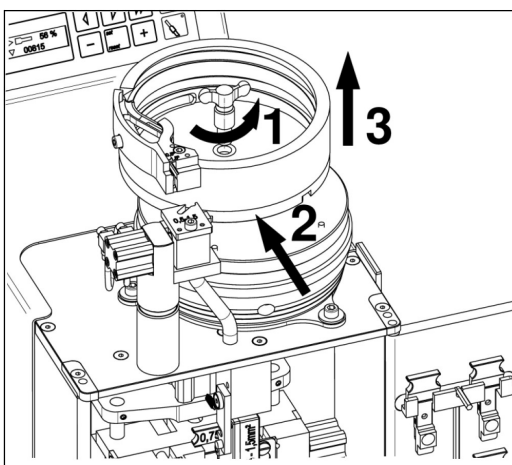


WARNING: Risk of injury!

Disconnect the main plug and the compressed air before you open the front door

- Switch off the CP-991 with the main switch (1)
- Disconnect the main plug (2)
- Disconnect the compressed air connection (3)
- Open the front door

Retrofit kits, see Page 12.



Changing the feeder bowl



CP-991: Change the feeder bowl during a cross section change from 0.5/0.75/1.0/1.5 ↔ 2.5

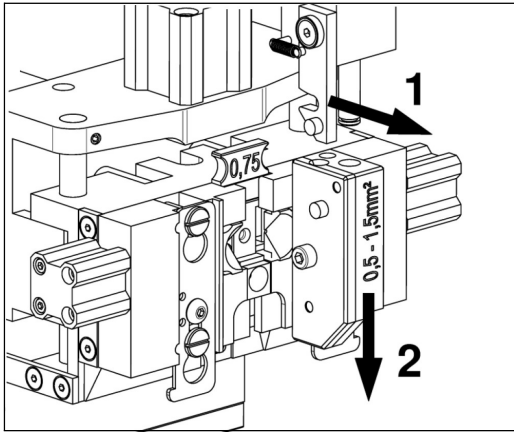
CP-992: Change the feeder bowl every time the cross section is changed.

- Unscrew the winged screw (1)
- Move the feeder bowl to the side (2), pull upwards (3) and empty



NOTE: Ensure that all ferrules are removed, especially from the slot under the baffle.

- Attach the feeder bowl in such a way that it slides into the centering pins and tighten the winged screw



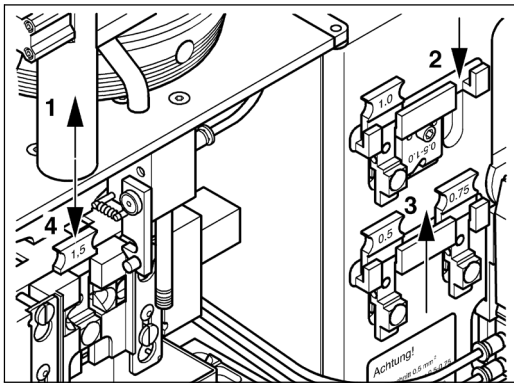
Changing the reversing base sleeve



CP-991: Change the reversing base sleeve during a cross section change from 0.5/0.75/1.0/1.5 ↔ 2.5.

CP-992: Change the reversing base sleeve every time the cross section is changed.

- Pull the release lever (1) forwards
- Remove the reversing base sleeve (2) downwards
- Hold the release lever in the forward position and attach the reversing base sleeve with the desired cross section
- Lock the release lever into place



Changing the sleeve receiver



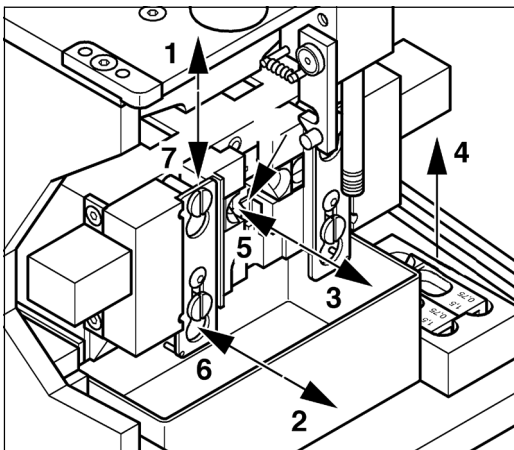
The sleeve receiver must be changed every time the cross section is changed.

- Remove the reversing base sleeve (see Page 21).
- Pull the sleeve receiver (1) upwards, remove from the holder and insert into the transport holder (2).
- Insert the sleeve receiver into the holder using the desired cross section (3) and push downwards (4).



NOTE: Check for correct lock-in position.

- Install reversing base sleeve.



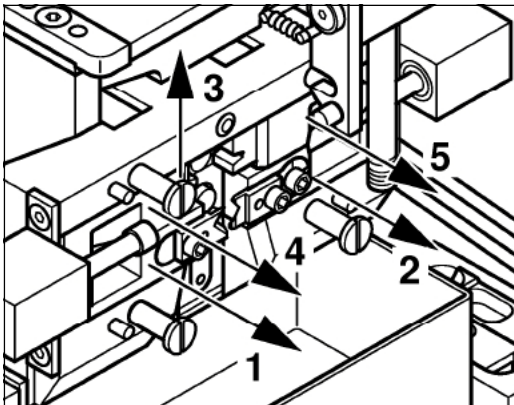
Changing the cord-centering funnel



CP-991: The cord-centering funnels must be changed during a 0.5...1.5 ↔ 2.5 cross section change.

CP-992: The cord-centering funnels must be changed every time the cross section is changed.

- Remove the reversing base sleeve and sleeve receiver (see above)
- Slide the slide (1) upwards and pull the holder (2) forwards
- Remove the second holder in the same way
- Remove both cord-centering funnels (3)
- Attach the cord-centering funnels onto the driving pins (5) with the desired cross section (4)
- Attach the holders (6) and press the slide (7) downwards
- Install the sleeve receiver and reversing base sleeve



Changing the stripping blade and crimping jaws



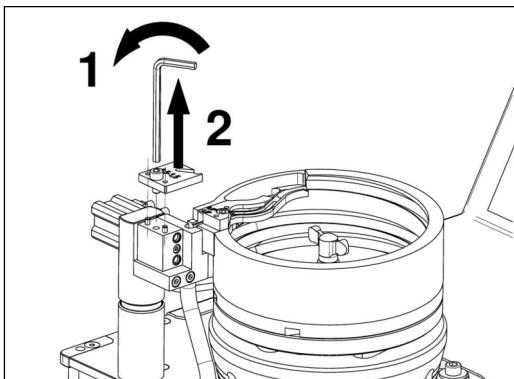
CP-991: No change.

CP-992: The crimping jaws and stripping blade must be altered during a cross section change.

- The steps for removing the cord-centering funnels are mentioned above
- Take out both of the stripping blades (1 + 2)
- Slide the cassette (3) upwards
- Take out both of the crimping jaws (4 + 5)
- Attach in the reverse order



NOTE: Check for correct lock-in position.



Changing the separation plates



CP-991: The separation plates must be changed during a 0.5...1.5 ↔ 2.5 cross section change.

CP-992: The separation plate must be changed during a 4 ↔ 6 ↔ 10 cross section change.

- Unscrew the separation plate (1) using the hexagonal wrench and remove (2)
- Remove the separation plate from the retrofit kit with the desired cross section and attach in place of the previous separation plate

7.2 Changing the crimping length

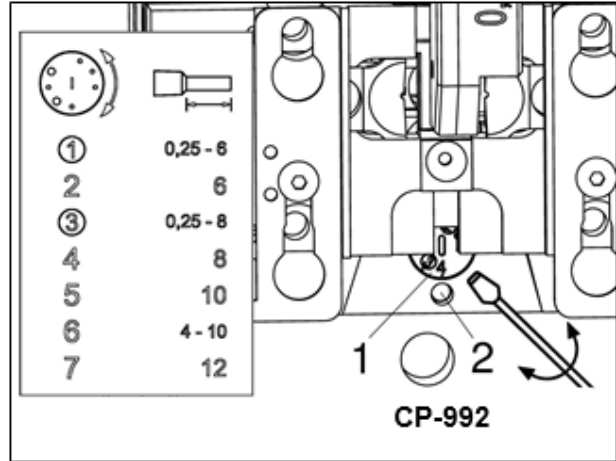
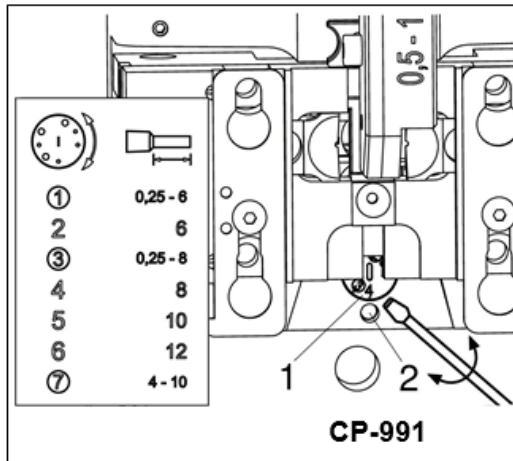
Changing the crimping length



The crimping length is changed using a rotary dial.

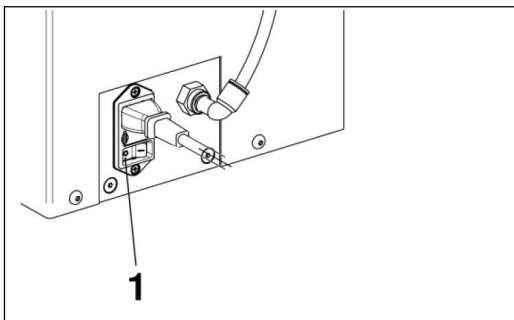
Changing the rotary dial

- Follow the steps mentioned above to remove the stripping blade and crimping jaws (see Page 22)
- Insert the rotary dial (1) at the desired crimping length using a screwdriver. The selected value is shown via the red marker (2).
- Re-attach individual parts



8. Troubleshooting

8.1 CP-991 does not run after being switched on



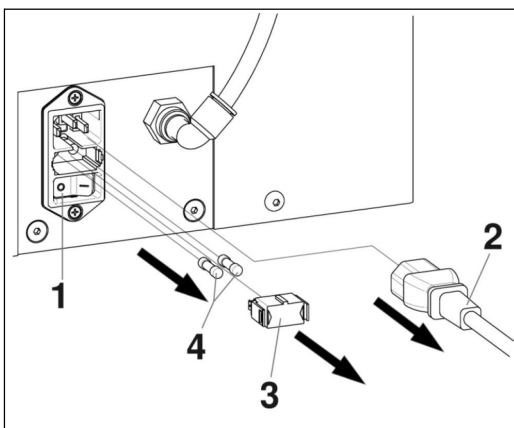
Check the main indicator

Main indicator (1) is not lit:

- Check air pressure

Main indicator (1) is not lit:

- Check whether the main plug is connected to the CP-991 main connection and the shock-proof plug is connected to the main socket
- Check whether the power supply at the main socket is O.K.
- If O.K., check the main fuse



Check the main fuse



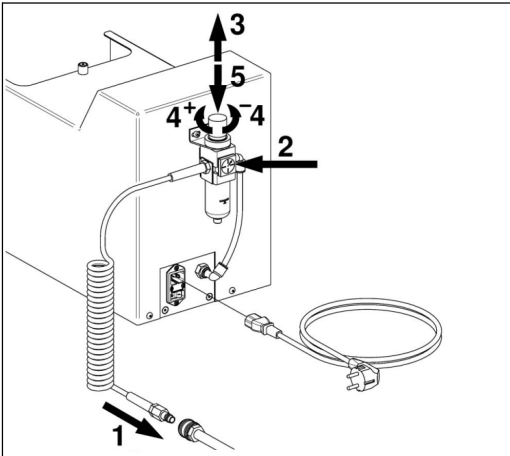
WARNING: Risk of injury!

In order to check the main fuse, the main connection has to be open. Disconnect the main plug first!

- Switch off the CP-991 with the main switch (1)
- Disconnect the main plug (2)
- Pull out the fuse holder (3)
- Checking the main fuse (4)
- Replace the defect main fuse with the backup fuse. Retrofit the backup fuse.
- Insert the fuse holder



NOTE: The fuse holder should snap into place.

**Check the air pressure**

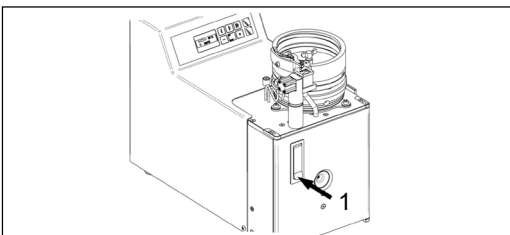
- Disconnect the compressed air connection (1)
- Check the air pressure at the manometer (2):
CP-991: 5 bar
CP-992: 5.5 bar

No pressure present:

- Check whether the compressed air connection is connected to the compressed air supply
- Check whether the compressed air supply is O.K.

Pressure is not 5 bar/5.5 bar:

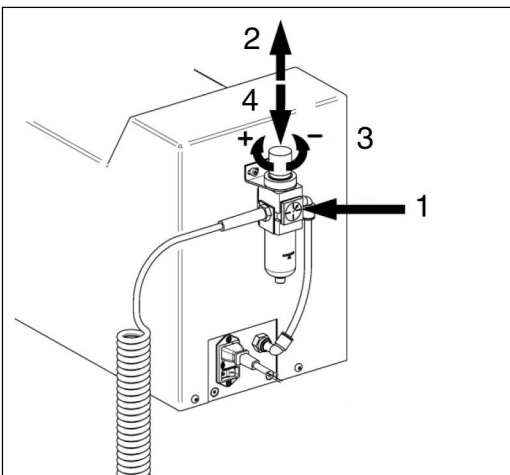
- Pull the air pressure regulator (3) upwards
- Set the air pressure by turning (4) to the right (+) or left (-)
- Then press the regulator (5) downwards

8.2 Start process is not being initiated

If the conductor is inserted, the CP-991 will not start.

Check the front door

- Check that the front door (1) is completely closed and locked

**Check the air pressure**

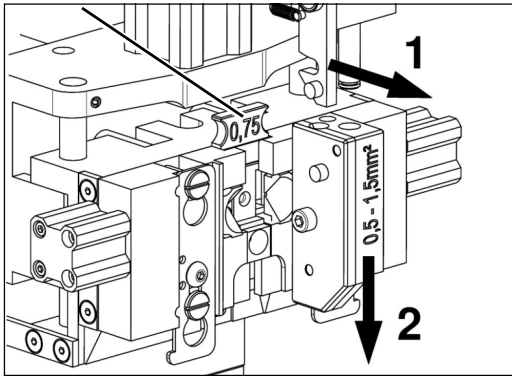
- Check air pressure at the manometer (1):
CP-991: 5 bar
CP-992: 5.5 bar

No pressure present:

- Check whether the compressed air connection is connected to the compressed air supply
- Check whether the compressed air supply is O.K.

Pressure is not 5 bar/5.5 bar:

- Disconnect the compressed air connection
- Pull the air pressure regulator (2) upwards
- Set the air pressure by turning (3) to the right (+) or left (-)
- Then press the regulator (4) downwards

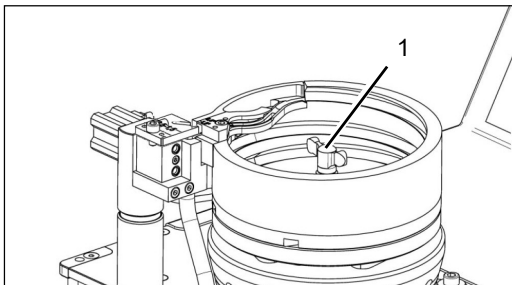
**Check sleeve receiver****WARNING: Risk of injury!**

Disconnect the main plug and the compressed air before you open the front door.

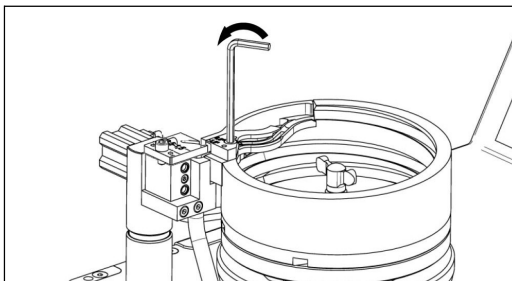
- Pull the release lever (1) forwards
- Remove the reversing base sleeve (2) downwards
- Check that the sleeve receiver (3) is positioned correctly and is snapped into place in the ball latch
- Install sleeve receiver
- Close front door

8.3 Conductor insulation is not removed completely**Check cross section**

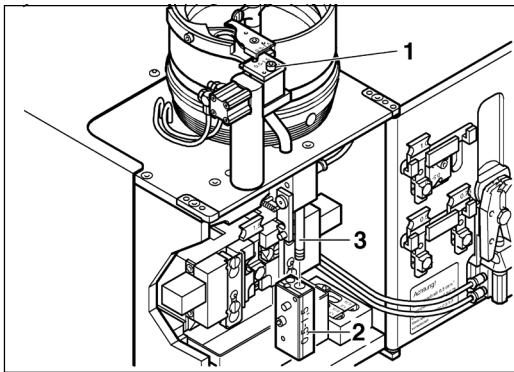
- If the conductor isn't properly stripped, first check that the CP-991 is fitted with the correct retrofit kit
- Adjust the retrofit kit to suit the selected conductor cross section (see Page 20)
- Also check the conductor cross section
- If the malfunction continues despite having the correct retrofit kit, check the stripping blade (see Page 22)

8.4 Ferrule in-feed is disrupted**Check the feeder bowl**

- Check if the winged screw (1) is loose, if necessary, re-tighten
- Tuck the ferrules into the transport grooves
- Change the speed of the feeder bowl

**Check the baffles**

- Switch off the CP-991 at the main switch
- Unscrew the baffle covering with the hexagonal wrench
- Remove the defective ferrules



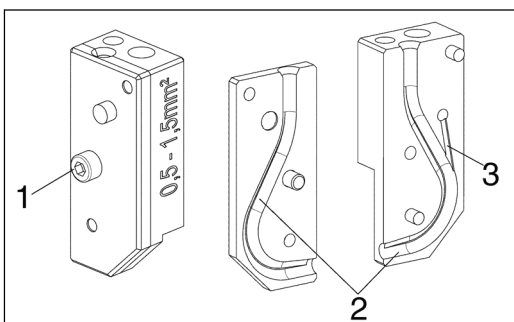
Check the sleeve feeding



WARNING: Risk of injury!

Disconnect the main plug and the compressed air before you open the front door.

- Unscrew the separation plate (1) using the hexagonal wrench
- Remove the reversing base sleeve (2)
- Push the cable through the feeder (3) and, if necessary, remove the crimped ferrules



Check the reversing base sleeve

- Unscrew Allen screw (1) on the reversing base sleeve using a hexagonal wrench and open the reversing base sleeve
- Remove the crimped ferrules
- Clean the feeder channel (2) and air pressure channel (3)