

INSTRUCTIONS FOR THE MEASUREMENT OF RAISED AND RECESSED STYLE CD-920 STYLE CRIMP DIES

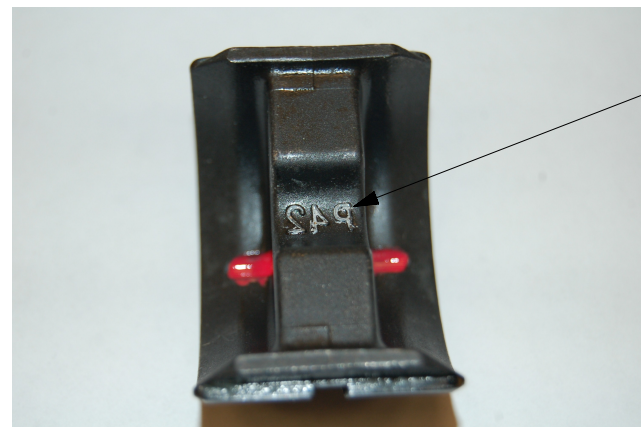
Please follow the steps below for measurement of the CD-920 series crimp dies.

STEP ONE

Please select the correct Crimp Die set for the application that you will be checking. Wipe die set clean.



Your die set outside surfaces should look like this.



Your RAISED LETTER die set inside surfaces should look like this. The raised letters in this picture have been painted to show up more clearly.

NOTES:

- CD-920 CRIMP DIES WITH QC #'S AT OR HIGHER THAN 13287938L, WILL HAVE RAISED DIE INDEX NUMBERS IN DIE POCKET.
- CD-920 CRIMP DIES WITH QC #'S LOWER THAN 13287938L, WILL HAVE ENGRAVED DIE INDEX NUMBERS IN THE DIE POCKET.

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
00	4/18/23	JHNU	JHNU	MRWA	DRAWING RELEASED-REPLACES 10J002BE-JC	130488

TITLE		CD-920 SERIES CRIMP DIE MEASUREMENT INSTRUCTIONS	
CUSTOMER DRAWING			
ITEM REVISION NAME	03249NBF/00	PANDUIT	MATERIAL: NONE
DATASET FILE NAME	03249NBF-DC/00		
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [mm]		DRAWING NUMBER: 03249NBF - DC	
.x ± .1 [2.54]	.xxx ± .005 [.127]	THIRD ANGLE PROJECTION	
.xx ± .01 [.25]	ANGLES ± 1°	DRAWING NUMBER: 03249NBF - DC	
DRAWN BY	DATE	CHK	SCALE
JHNU	4/18/23	MRWA	NONE
SHT 1 OF 4		SIZE B	

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STEP TWO

Ensure crimp die halves are touching and aligned as shown below.



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00	4/18/23	JHNU	JHNU	MRWA	SEE SHEET 1 FOR DRAWING REVISIONS	

TITLE CD-920 SERIES CRIMP DIE MEASUREMENT INSTRUCTIONS CUSTOMER DRAWING			
ITEM REVISION NAME 03249NBF/00		PANDUIT	
DATASET FILE NAME 03249NBF-DC/00			
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [mm]			
.x ± .1 [2.54]	.xxx ± .005 [.127]	MATERIAL: NONE	
.xx ± .01 [.25]	ANGLES ± 1°	DRAWING NUMBER: 03249NBF - DC	
THIRD ANGLE PROJECTION		SHT 2 OF 4	
DRAWN BY JHNU	DATE 4/18/23	CHK MRWA	SCALE NONE
			SIZE B



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STEP THREE

Measure crimp die diameter by placing caliper in ridges as shown below.



Place calipers in ridge for die measurement

See sheet 4 for appropriate die diameter range.

If dies are measured outside of the acceptable range, contact the Panduit sales office.

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THIRD ANGLE PROJECTION			DRAWING NUMBER: 03249NBF - DC		
DRAWN BY JHNU	DATE 4/18/23	CHK MRWA	SCALE NONE	SHT 3 OF 4	
					SIZE B



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CRIMP DIE PART NUMBER	DIE COLOR CODE	DIE INDEX NUMBER	RAISED AND RECESSED LETTER CRIMP DIES DIE DIAMETER RANGE MIN. - MAX.
CD-920-8	RED	P21	1.536" - 1.606"
CD-920-6	BLUE	P24	1.536" - 1.606"
CD-920-4	GREY	P29	1.536" - 1.606"
CD-920-2	BROWN	P33	1.536" - 1.606"
CD-920-1	GREEN	P37	1.536" - 1.606"
CD-920-1/0	PINK	P42	1.536" - 1.606"
CD-920-2/0	BLK/GLD	P45	1.536" - 1.606"
CD-920-3/0	ORN/TAN	P50	1.536" - 1.606"
CD-920-4/0	PUR/OLV	P54	1.536" - 1.606"
CD-920-250	YEL/RBY	P62	1.536" - 1.606"
CD-920-300	WHITE	P66	1.536" - 1.606"
CD-920-350	RED	P71	1.536" - 1.606"
CD-920-400	BLUE	P76	1.536" - 1.606"
CD-920-500	BROWN	P87	1.536" - 1.606"
CD-920-500A	PINK	P99	1.262" - 1.332"
CD-920-600	GREEN	P94	1.536" - 1.606"
CD-920-750	BLACK	P106	1.262" - 1.332"
CD-920H-6	ORANGE	PH6	1.518" - 1.588"
CD-920H-2	BROWN	PH2	1.518" - 1.588"

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DRAWN BY JHNU	DATE 4/18/23
CHK MRWA	SCALE NONE
SHT 4 OF 4	
SIZE B	



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