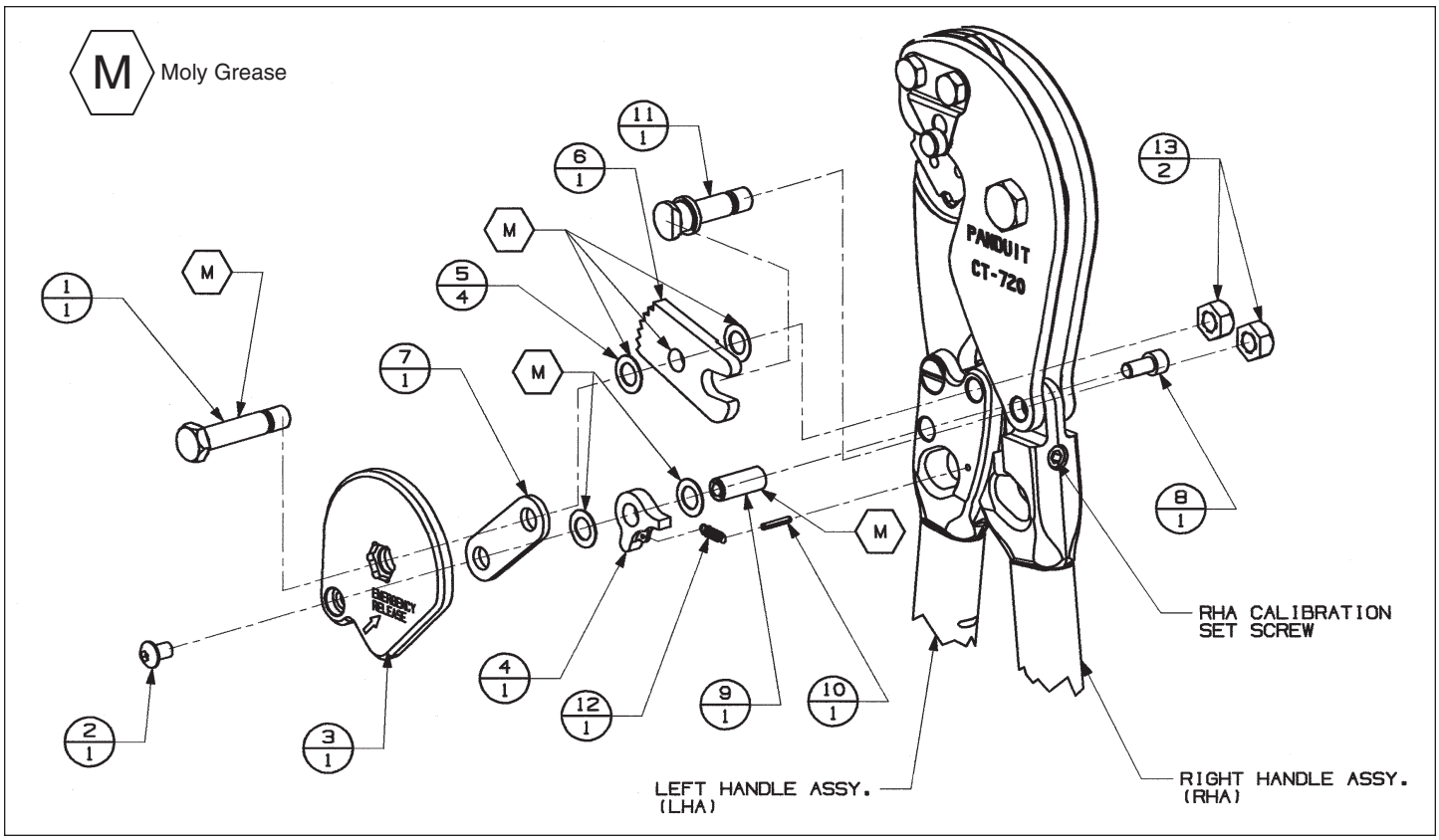
# CC-720

## CONTROLLED CYCLE MECHANISM
## INSTALLATION INSTRUCTIONS



### TOOLS REQUIRED

| | |
|---|---|
| 5/32" Hex Wrench | 9/16" and 1/2" Box or Open End Wrench |
| 3/16" Hex Wrench | Hammer |




**INSTALLATION** (Refer to the figure above for parts included in the kit.)

1. With Panduit Logo side of tool down, remove and discard the left two nuts securing the handle to the head assembly.

2. Drive out the L.H. bolt, and replace (from logo side) with the L.H. Stub Bolt (Item #11). Put on a 3/8" Nut (Item #13) and tighten by hand.

3. With Panduit logo side up, attach the Pawl Stud (Item #9). Insert Roll Pin (Item #10) on the tool and tap pin in with hammer until it stops. From the other side, screw the ¼¼¼1/4-20 Cap Screw (Item #8) into the pawl stud.

4. Insert a Spacer (Item #5) over Pawl Stud. Apply small amount of grease to top side.

5. Attach hook end of Spring (Item #12) to Pawl (Item #4), insert pawl over pawl stud, then attach other end of spring over Roll Pin (Item #10). **Note:** Refer to drawing for proper orientation of pawl.

6. Apply small amount of grease to topside of pawl and pawl stud. Place another Spacer (Item #5) over pawl stud, on top of pawl.

7. Drive out the center bolt and reinsert bolt in from opposite side to maintain bolt hole alignment.
   ***Caution:*** Moving the tool at this time will disrupt the alignment of the parts around the center bolt.

8. Apply small amount of grease to bottom side of Spacer (Item #5) and place over the center bolt hole.

9. Apply grease to center pivot hole of the Ratchet Plate (Item #6). Assemble the slot end of ratchet plate onto the L.H. stub bolt.
   **Note:** Refer to drawing for proper orientation of ratchet plate, centering the ratchet plate hole over the spacer and the center bolt hole of the tool
   ***Caution:*** Moving the tool at this time will disrupt the alignment of the parts around the center bolt.

10. Apply a small amount of grease on the bottom of Spacer (Item # 5) and place it over the ratchet plate hole, centering it over the bolt.

11. Place the hole of one end of the Strap (Item #7) on the pawl stud, and center the other hole over the spacers, ratchet plate hole, and center bolt hole.

12. Carefully place Guard (Item #3) over the mechanism, centering the large hole over the center bolt, and the small hole over the pawl stud hole. Insert the 1/4-20 button head Cap Screw (Item #2) through the guard and thread it into the pawl stud until tight. **Note:** Be sure to keep large hole aligned with ratchet plate hole while tightening.

13. Apply a small amount of grease to the diameter of the center Bolt (Item #1) and insert through the center bolt hole of the guard, strap, ratchet plate, spacers, and tool handles, while pushing out existing center bolt. Orient the head of the bolt to fit into the anti-rotation hex pocket in the guard.

14. Put a nut on the center bolt and tighten by hand.

15. Using the 9/16" wrench, tighten the two nuts, adjusting them to allow free movements of the tool handles.

## CALIBRATION

1. Insert any CD-720 die into the tool and secure.

2. **Important: Gage block or die must be installed in tool during calibration.**

3. Cycle tool (3) complete times.

4. Close handles until jaw plate comes into contact with die block and small amount of back pressure is felt.

5. Measure distance between inside of handles. If less than 10 in., turn calibration set screw in RHA clockwise to tighten (see drawing). If greater than 13 in., turn set screw in RHA counterclockwise to loosen. Cycle tool between adjustments.

6. Repeat Steps 3 to 5 until dimension from inside of handle to inside of handle measures 11.5 in., +/- 1.5 in.

7. **Important: Remove Calibration Die!**

8. Wipe external surfaces of tool and handles with rust inhibiting oil to remove all excess grease and handprints.