

INSTRUCTION MANUAL

Battery-operated Hydraulic Crimping and Cutting Tool DuoLiner® C



Original instruction manual
Ident-No.: 78001100-BA
Stand: 06/2024 / Revision: 05/2026

- ☐ DuoLiner® C Ma (suitable for Makita batteries LXT)
- ☐ DuoLiner® C Bo (suitable for Bosch batteries PRO)
- ☐ DuoLiner® C Hi (suitable for Hilti batteries CPC)
- ☐ DuoLiner® C HiN (suitable for Hilti batteries Nuron)
- ☐ DuoLiner® C Mi (suitable for Milwaukee batteries M18)

Holger Clasen GmbH & Co. KG
Alsterdorfer Straße 228
22297 Hamburg, Germany
Tel. +49 40 511 28-0
info@holger-clasen.de
www.holger-clasen.de

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Thank you for placing your trust in us by purchasing this tool.

1 General Information

We hereby confirm that the tool described in this instruction manual complies with the basic safety and health requirements pursuant to the EC Machinery Directive 2006/42/EC, the EMC Directive 2014/30/EU and the RoHS Directive 2011/65/EU relating to electromagnetic compatibility.

Keep this instruction manual in a place that all users of the tool are familiar with and can access easily. Read this manual carefully before using, maintaining, repairing or disposing of the tool. Make sure that you clearly understand the instructions and symbols explained in this manual or attached to any tools.

You can prevent accidents by adhering to the following basic safety advice pursuant to the EC Machinery Directive 2006/42/EC and the regulations for hand-operated tools. In any case inform yourself about and comply with the accident prevention regulations applicable in your country.

Do not remove existing labels and stickers, especially those containing legally required information.

Upon receiving the tool, make sure that the packaging is intact and the tool did not suffer any transportation damage. In case of damage, please contact Holger Clasen GmbH & Co. KG's customer service at +49 40 511 28-0. Keep the packaging.

1.1 Manufacturer's Warranty

If operated correctly and if the required service intervals are adhered to, we grant a warranty of 24 months beginning as of the day of delivery unless legal regulations require other warranties.

1.2 Disclaimer of Warranty

The product is designed exclusively for the intended use described in this documentation. Provided that the technical specifications are complied with and the prescribed maintenance and servicing measures are carried out, the product is intended for reliable continuous operation.

Safe operation requires compliance with all safety, operating, and maintenance instructions as well as with all applicable statutory regulations.

Any use other than the intended use, overloading, improper handling, failure to perform required maintenance, or unauthorized modifications may, to the extent permitted by law, result in the exclusion of liability and warranty claims.

The product is subject to natural wear and tear. Wear parts are therefore excluded from warranty and guarantee coverage unless a verifiable material or manufacturing defect can be demonstrated.

1.3 Symbols



WARNING!



Danger of hand injuries



Please read the instruction manual



Please wear safety goggles



Please wear safety shoes



Please wear protective clothes



Don't dispose of in residual waste



DuoLiner® C Ma Force 58 kN Width 30 mm Range 6 - 185 mm² Input 18 V DC / 450 W Built 2025 holger-clasen.de	DuoLiner® C Bo Force 58 kN Width 30 mm Range 6 - 185 mm² Input 18 V DC / 450 W Built 2025 holger-clasen.de	DuoLiner® C Hi Force 58 kN Width 30 mm Range 6 - 185 mm² Input 22 V DC / 540 W Built 2025 holger-clasen.de	DuoLiner® C HiN Force 58 kN Width 30 mm Range 6 - 185 mm² Input 22 V DC / 540 W Built 2026 holger-clasen.de	DuoLiner® C Mi Force 58 kN Width 30 mm Range 6 - 185 mm² Input 18 V DC / 450 W Built 2025 holger-clasen.de
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Serial No./Built: In the battery shaft/at the head

2 General Safety Information

WARNING

Danger due to overheating, breakage or electric shock of the battery.

The tool, the battery and the charger are matched components.

- ▶ This tool may only be operated with a suitable rechargeable battery.
- ▶ Charge the battery with the appropriate charger.
- ▶ Only use the original battery and charger.

Charge the battery in accordance with the instructions.

- ▶ Connect the charger to a power source with suitable power specifications.
- ▶ Do not use a DC or motor-driven generator.
- ▶ Unplug the charger after charging is complete.
- ▶ Do not use the charger in the rain.

Pay attention to the temperature of the battery, the charger and the environment.

- ▶ Do not charge the battery at temperatures below 0° or above +40° C.

Ensure sufficient ventilation of the battery during the charging process.

- ▶ Do not cover the battery and charger during charging.

Do not short-circuit the contact surfaces of the battery.

Failure to do so may result in bursting of the battery and leakage of hazardous materials.

- ▶ Secure the contact surfaces of the battery with the cover provided for this purpose.
- ▶ Do not store the battery without the cover together with metal parts such as nails, screws, etc.

Do not place the battery in a fire.

Failure to do so may result in bursting of the battery and leakage of hazardous materials.

Hydraulic fluid under pressure.

Escaping fluid under pressure can cause severe injury or death.

- ▶ If injure, seek medical attention immediately.

Danger due to electric shock.

The tool is not insulated in contact with electrically charged parts.

- ▶ Never work live strands / cables!
- ▶ When using the device on or near live wires, wear suitable personal protective equipment
- ▶ Do not touch the power plug or the battery with wet hands.

Exposed working area.

Danger of hand injury.

- ▶ Never reach into the running tool.

Influence by electromagnetic waves

The functionality of pacemakers can be influenced by electromagnetic waves emitted.

- ▶ Keep the tool at least 15 cm or more away from the pacemaker.

Risk of injury to the hand

Prevent the tool from starting up unintentionally

- ▶ Always move the piston to the starting position after use or before changing parts and remove the battery.
- ▶ Keep your fingers away from the trigger when transporting the tool.
- ▶ Secure the trigger.

Danger due to inhalation of dust

Depending on work environment dust hazardous to health may be generated during machining.

- ▶ Wear a protective mask during dusty operation.

Danger of eye injuries

Material can fly around.

- ▶ Wear protective goggles. Normal goggles do not provide sufficient protection.

Danger to persons in the vicinity due to breakage

During operation, overload/material fatigue can cause damage to the head. Parts flying around can cause injuries.

- ▶ Do not point the head of the tool at persons in your environment during operation.

Failure to observe the following instructions may result in property damage or accidents:

Use the tool within the scope of its intended use.

Do not overload the tool. Overloading can lead to blocking, excessive heat generation and ignition.

Keep handles and contact surfaces dry, clean and oil-free. Slippery surfaces reduce tool control and can lead to accidents in unexpected situations.

Refrain from any working method that could endanger safety.

Only use attachments and accessories for the work intended for them.

Do not make any modifications to the tool. Ensure a fatigue-free working position.

Remain attentive when working with high concentration.

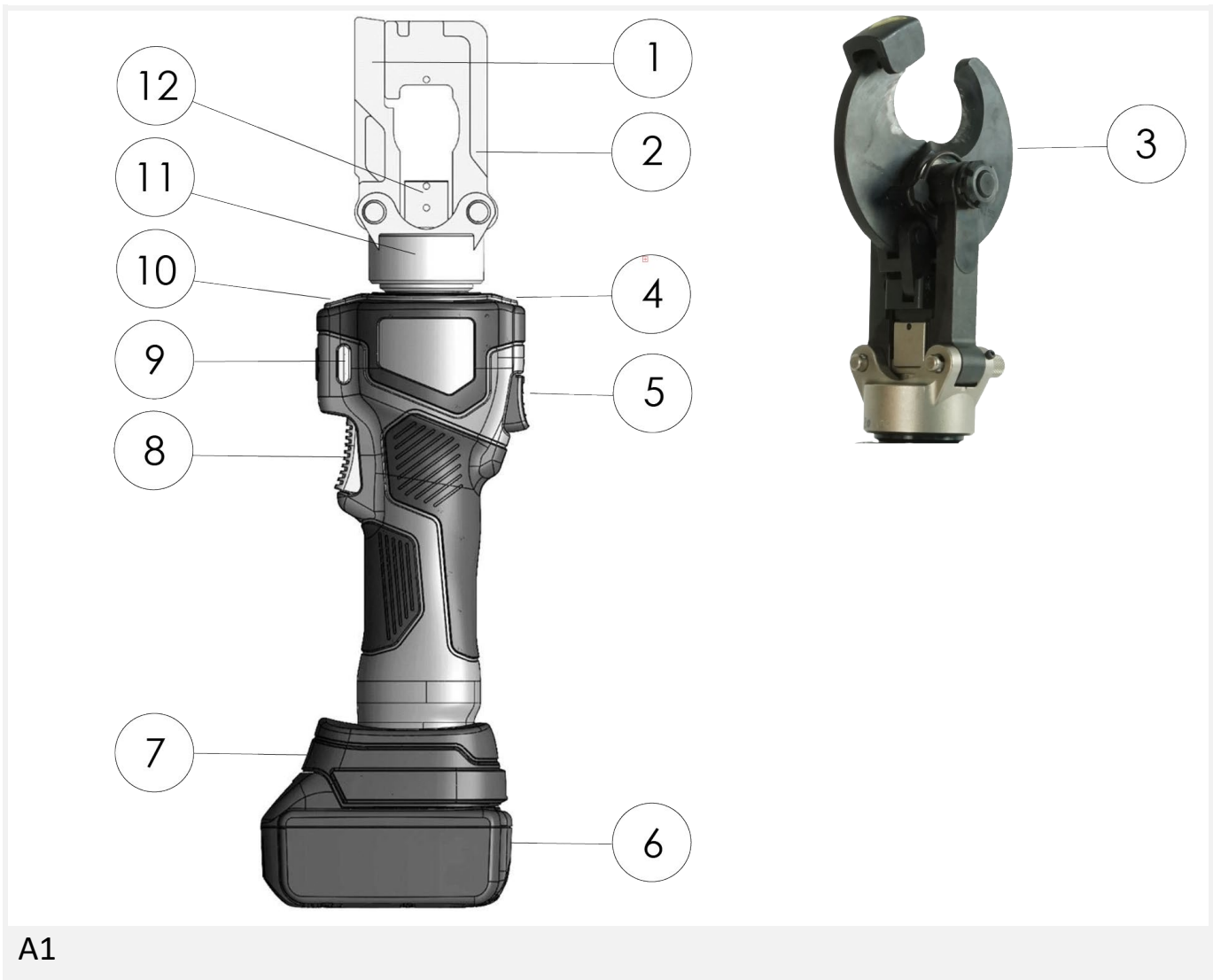
Do not operate the tool if you are in poor physical condition.

Do not operate the tool under the influence of alcohol.

When using the device on or near live wires, wear suitable personal protective equipment.

Do not touch the power plug or the battery with wet hands.

3 Product Description



A1

A1: Description

- 1 Clamp
- 2 Latch
- 3 Cutting Head
- 4 LED Work Field Illumination
- 5 Return Button
- 6 Battery (only included in Set)
- 7 Battery Holder
- 8 Release Button
- 9 Changeover Automatic Return
- 10 LED Work Field Illumination
- 11 Crimping head, 180° rotatable
- 12 Holder for Crimping Dies (Crimping dies are not included)

3.1 Intended Use

This battery-operated hydraulic tool has been designed for crimping connectors and cable lugs with block crimping dies (form: B) according to the crimping die table (chapter 4.2). Equipped with the cutting head as interchangeable equipment, the tool is suitable for cutting Cu and Al wires/cables up to Ø 30 mm according to the cutting range table (chapter 4.1). For other applications, please contact Holger Clasen GmbH & Co. KG. The tool has been designed to be connected to an accumulator according to technical data.

Although this tool has been designed according to the state-of-the-art and recognized safety requirements, its use may constitute a potential threat to the life and limbs of its user or third parties or damage the tool or other material assets. Use or application for purposes other than those intended by the manufacturer will be considered improper. Holger Clasen GmbH & Co. KG will not be liable for damage resulting from improper use. The operator works at his own risk.

3.2 Expected misuse

Do not retract the tool without inserted crimping dies.

This will cause damage and possibly break the head.

This tool is not suitable for cutting high-tensile or hardened steel, which will damage and possibly break the knife. This tool is not suitable for cutting fine/very fine stranded conductors, this will cause the blades to jam.

3.3 Qualification

This tool may only be used by qualified personnel who have read this safety advice and instruction manual.

3.4 Operator Protection



Danger due to chips flying around.

Wear protective goggles.

Standard glasses do not provide sufficient protection and are no proper substitution for safety eyewear.



Danger of drawing in of clothes and hair.

Wear protective clothes.

Loose or baggy clothes increase the risk of catching or winding on moving parts.

- Wear tight-fitting work clothing.

- Do not wear long hair open. Wear it well covered.
- Do not wear rings, chains or other jewellery.



Risk of crushing/sliding.

Wear protective shoes.
Make sure to stand firmly.

3.5 Workplace

Do not use the tool in environments where there is a risk of fire or explosion.
Keep your workplace clean.

Keep children and unauthorized person away from your work environment.
Ensure that there is sufficient lighting at the workplace.

Before switching on the tool, make sure that no one is endangered
by the starting tool.

Protect the tool from moisture, water, extreme heat / cold, chemical solutions
and gases.

Do not use the tool, the battery and the charger in the rain or in a wet environment
or a wet environment. Do not charge the battery there either.

Protect the battery tool from falls or impacts.

3.6 Temperature Range

The possible working range of the tool is in the temperature range from
-20° C to +40° C.

The recommended working range is in the temperature range from -5° C to +40° C.
Temperatures between -20° C and -5° C leads to changes in the flow properties of
the hydraulic oil.

To ensure unrestricted use, we recommend storing the tool for one hour in a room
with a temperature of +10 to +25°C.

3.7 Transport and Storage

Ensure dry storage to protect the tool from rust.

Clean the tool before / after use and before storage.

Secure the contact surfaces of the battery with the cover provided.

If the tool is transported to another factory department or location, make sure that the tool and/or accessories are not damaged. Pack the tool accordingly.

Store the tool properly when not in use.

Store the tool in a place inaccessible to unauthorized persons.

Do not store the tool and battery in a place where the temperature may rise to +40°C or more (in a metal box, in a car in summer, etc.). Overheating may cause damage, smoke generation or ignition.

⚠ Due to the high energy density of rechargeable batteries, there is a higher risk potential, especially when shipping used rechargeable batteries.

One of the greatest risk factors when transporting rechargeable batteries or battery-powered devices is the danger of short circuits if the battery terminals meet other rechargeable batteries, metal objects or other conductive material.

If the battery is inserted in the tool, the battery terminals are secured.

If they are stored separately or shipped individually, secure storage must be ensured. A possible short circuit and damage to the connection terminals must be prevented. For this purpose, the battery terminals must be secured with a non-conductive material (e.g. adhesive tape) or the contact protection cap. Batteries must be adequately protected against movement.

Special protective measures must be taken when shipping in airplanes or batteries over 100 Wh.

Notice IATA Packing instruction 965 Part 2 for lithium-ion-batteries. If package/battery is damaged, batteries must be quarantined, inspected and repacked.

Attention: Following the IATA Packing instructions batteries are delivered on 30 % charge level. Please completely charge the battery before usage with the recommended battery charger.

Observe the manufacturer delivery information (download):

Makita:

<https://www.holger-clasen.de/bl1850b-makita-akku-lithium-ionen-18-v/79300115>

Bosch:

<https://www.holger-clasen.de/en/bosch-battery-lithium-ion-18-v/79300122>

4 Technical Data

Item	DuoLiner® C
Opening Width	30 mm
Crimping/Cutting Force	58 kN
Stroke	15 mm
Battery Voltage	18 V / Hilti (Hi, HiN): 22 V
Weight*	Crimping: 2.3 kg Cutting: 3.0 kg
Dimensions* L x W x H	Crimping: 365 x 75 x 95 mm Cutting: 430 x 75 x 110 mm
Head	Crimping: Closed Cutting: Open Head 180° rotatable
Sound Pressure Level L_{pa}	77.3 dB(A)
Sound Power Level L_{WA}	88.3 dB(A)
Vibration a_h	0.433 m/s ²
Uncertainty K	0.047 m/s ²

* without battery

MasterBase technology offers the following battery options:

Item	Item No.	Suitable for batteries
DuoLiner® C Ma	78001100	Makita 18 V Li-Ionen LXT
DuoLiner® C-Set Ma **	78101100	Makita 18 V Li-Ionen LXT
DuoLiner® C Bo	78002700	Bosch 18 V Li-Ionen PRO
DuoLiner® C-Set Bo ***	78003400	Bosch 18 V Li-Ionen PRO
DuoLiner® C Hi	78002800	Hilti 22 V Li-Ionen CPC
DuoLiner® C HiN	78003200	Hilti 22 V Li-Ionen Nuron
DuoLiner® C Mi	78002500	Milwaukee 18 V Li-Ionen M18

**Scope of Delivery Set:

DuoLiner® C Ma (Item No. 78001100),
 Li-Ion Battery Makita BL1850B, 18 V / 5 Ah (Item No. 79300115),
 Battery Charger DC18RC (Item No. 79300120)
 Transportation Case KOFF-Km IL C div (Item No. 79500135)

***Scope of Delivery Set:

DuoLiner® C Bo (Art.-Nr. 78002700),
 Bosch Li-Ion Battery PRO GBA 18V 5.0 Ah (Item No. 79300122),
 Bosch Battery Charger PRO GAL 1880CV (Item No. 79300123),
 Transportation Case KOFF-Km IL C div (Item No. 79500135)

Noise information and vibration values in accordance with EN 62841-1

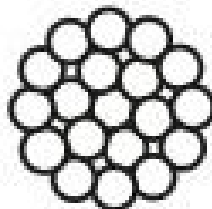
The sound pressure and vibration values given in these instructions were measured in accordance with a standardized test and can be used to compare one power tool with another. They can also be used for a preliminary assessment of exposure.

The data given represent the main applications of the power tool. However, if the power tool is used for different applications, with different accessory tools, or is poorly maintained, the data can vary. This can significantly increase exposure over the total working period.

An accurate estimation of exposure should also take into account the times when the tool is switched off, or when it is running but not actually being used for a job. This can significantly reduce exposure over the total working period.

Identify additional safety measures to protect the operator from the effects of noise and/or vibration, for example: maintaining the power tool and accessory tools, keeping the hands warm, organization of work patterns.

4.1 Cutting Ranges

Anwendung <i>Application</i>	Max. Schneiddurchmesser <i>Max. Cutting Diameter</i>	
Cu Seil <i>Cu Strand</i>	Ø 30 mm	
Al Seil <i>Al Strand</i>	Ø 30 mm	
Cu Energiekabel <i>Cu Energy Cable</i>	Ø 30 mm	
Al Energiekabel <i>Al Energy Cable</i>	Ø 30 mm	

4.2 Crimping Die Table

NOTICE

Our crimping dies are manufactured in accordance with the DIN 48083 standard. The assignment to the crimping areas is for guidance only.

Please observe the connector manufacturer's specifications regarding the required force and index number.

Due to the large number of possible connectors/materials, we always recommend carrying out test crimping.

Tensile tests, conductivity tests or cross-section checks may also be useful in individual cases.

Please contact us, we can arrange a test for you.



The tool is designed to accommodate block crimping dies (B)

Nomenclature:

Example: K8 / 5 – B
K8 – Index according to DIN 48083 (**60 kN**)
5 – 5 mm Crimping width
B – Block crimping dies

DIN-Crimping Dies for DuoLiner® C:

Cu nach DIN / acc. to DIN		
Pressbereich Crimping Range DIN 48083	Zugentlastet Non Tension	Zugfest Full Tension
6 mm ²	K5 / 5 - B # 769 00 518	
10 mm ²	K6(16) / 5 - B # 769 00 298	K8(12) / 5 - B # 769 00 017
	K6 / 7 - B # 769 00 292	K8(12) / 7 - B # 769 00 010
	K6(16) / 7 - B # 769 00 016	K8 / 7 - B # 769 00 293
16 mm ²	K8(12) / 5 - B # 769 00 017	K8(12) / 5 - B # 769 00 017
	K8 / 7 - B # 769 00 293	K8 / 7 - B # 769 00 293
	K8(12) / 7 - B # 769 00 010	K8(12) / 7 - B # 769 00 010
25 mm ²	K10(14) / 5 - B # 769 00 018	K10(14) / 5 - B # 769 00 018
35 mm ²	K8(12) / 5 - B # 769 00 017	K8 (12) / 5 - B # 769 00 017
	K8(12) / 7 - B # 769 00 010	K8(12) / 7 - B # 769 00 010
50 mm ²	K10(14) / 5 - B # 769 00 018	K10(14) / 5 - B # 769 00 018
70 mm ²	K6(16) / 5 - B # 769 00 298	K6(16) / 5 - B # 769 00 298
95 mm ²	K18 / 5 - B # 769 00 011	K20 / 5 - B # 769 00 013
		K20 / 7 - B # 769 00 014
120 mm ²	K20 / 5 - B # 769 00 013	K22 / 5 - B # 769 00 015
	K20 / 7 - B # 769 00 014	
150 mm ²	K22 / 5 - B # 769 00 015	K25 / 5 - B # 769 00 009
185 mm ²	K25 / 5 - B # 769 00 009	

Al nach DIN / acc. to DIN	
Zugentlastet Non Tension	Zugfest Full Tension
K10(14) / 7 - B # 769 00 020	
K10 / 7 - B # 769 00 294	
K12 / 7 - B # 769 00 297	K12 / 7 - B # 769 00 297
K8(12) / 7 - B # 769 00 010	K8(12) / 7 - B # 769 00 010
K12 / 7 - B # 769 00 297	K12 / 7 - B # 769 00 297
K8(12) / 7 - B # 769 00 010	K8(12) / 7 - B # 769 00 010
K10(14) / 7 - B # 769 00 020	K14 / 7 - B # 769 00 295
K16 / 7 - B # 769 00 296	K16 / 7 - B # 769 00 296
K6(16) / 7 - B # 769 00 016	K6(16) / 7 - B # 769 00 016
K18 / 7 - B # 769 00 012	K18 / 7 - B # 769 00 012
K22 / 7 - B # 769 00 021	K22 / 7 - B # 769 00 021
K22 / 7 - B # 769 00 021	K25 / 7 - B # 769 00 008
K25 / 7 - B # 769 00 008	

DIN-Crimping Dies for DuoLiner® C:

DIN Al/St-Seile*/ACSR-Ropes			
Werkzeug-Kennzahl DIN 48083	Al-Hülse Al-Sleeve	St-Hülse St-Sleeve	Presseinsatz Crimping Die
6		16/2,5 25/4 35/6	Multi-B** # 76900006
			K6(16)/5-B # 76900298
7		50/8	K16(7)/7(5)-B # 76900003
9		70/12 95/15	K18(9)/7(5)-B # 76900004
			K22(9)/7(5)-B # 76900005
			K9/5-B # 76900028
12	16/2,5 25/4		Multi-B** # 76900006
			K8(12)/7-B # 76900010
			K12/7-B # 76900297
13		120/20 150/25	Multi-B** # 76900006
			K13/5-B # 76900027
14	35/6		Multi-B** # 76900006
			K10(14)/7-B # 76900020
			K14/7-B # 76900295
16	50/8		K16(7)/7(5)-B # 76900003
			K6(16)/7-B # 76900016
			K16/7-B # 76900296
18	70/12		K18(9)/7(5)-B # 76900004
			K18/7-B # 76900012
22	95/15		K22(9)/7(5)-B # 76900005
			K22/7-B # 76900021

* Querschnitt Al/St
Cross section ACSR

** Pressbreiten
Crimping Width:
K6/K13 = 5mm;
K12/K14 = 7mm

Further Crimping Dies for DuoLiner® C:

Pressbereich Crimping Range	Al / Cu-Sektorleiter / Sector-shaped conductor - Vorrunden / Prerounding		WM-Form WM shape	WM-Form WM shape	WM-Form WM shape	Dorn Arbor	Trapez für Aderendhülsen Trapezoid for Wire End Ferrules
	Eindrähtig Single Stranded	Mehrdrähtig Multi-Stranded	Standard-Serie	Euro-Serie	feindrähtig fine-stranded		
6 mm ²				WME6/5-B # 76900652		D6/5-B # 76900351	AE6/19-B # 76900542
10 mm ²			WM10(70)/5-B # 76900090	WME10(70)/5-B # 76900653	WM10(25)F/5-B # 76900536	D10/8-B # 76900352	AE10/19-B # 76900543
16 mm ²			WM16(35)/5-B # 76900091	WME16(35)/5-B # 76900654	WM16(35)F/5-B # 76900537	D16/10-B # 76900353	AE16/19-B # 76900544
25 mm ²		R12+/12-B # 76900097 R12+(16)/12-B # 76900022	WM25(50)/5-B # 76900092	WME25(50)/5-B # 76900655	WM10(25)F/5-B # 76900538	D25/12-B # 76900354	AE25/19-B # 76900545
35 mm ²	R12+/12-B # 76900097 R12+(16)/12-B # 76900022	R14/12-B # 76900098 R14(18)/12-B # 76900023	WM16(35)/5-B # 76900091	WME16(35)/5-B # 76900654	WM16(35)F/5-B # 76900537	D35/12-B # 76900355	AE35/19-B # 76900546
50 mm ²	R14/12-B # 76900098 R14(18)/12-B # 76900023	R16/12-B # 76900099 R12(16)/12-B # 76900022	WM25(50)/5-B # 76900092	WME25(50)/5-B # 76900655	WM50F/5-B # 76900538	D50/12-B # 76900356	AE50/19-B # 76900547
70 mm ²	R16/12-B # 76900099 R12(16)/12-B # 76900022	R18/12-B # 76900100 R14(18)/12-B # 76900023	WM10(70)/5-B # 76900090	WME10(70)/5-B # 76900653	WM70F/5-B # 76900539	D70/12-B # 76900357	AE70/19-B # 76900548
95 mm ²	R18/12-B # 76900100 R14(18)/12-B # 76900023	R22/12-B # 76900024	WM95/5-B # 76900093	WME95/5-B # 76900656	WM95F/5-B # 76900540		
120 mm ²	R22/12-B # 76900024	R22+/12-B # 76900025	WM120/5-B # 76900094	WM120/5-B # 76900094	WM120F/5-B # 76900541		
150 mm ²	R22+/12-B # 76900025	R25/12-B # 76900026	WM150/5-B # 76900095	WM150/5-B # 76900095			
185 mm ²	R25/12-B # 76900026	R28/12-B # 76900007	WM185/5-B # 76900096				
240 mm ²	R28/12-B # 76900007						

5 Commissioning

The tool set includes a tool, a battery and a matching charger.

Charge the battery using only this charger.

Fully charge the battery before using it for the first time.

Make sure that the accumulator is charged before each use.

Reload if necessary.

Observe the manufacturer manual (Download):

Makita:

<https://www.holger-clasen.de/bl1850b-makita-akku-lithium-ionen-18-v/79300115>

<https://www.holger-clasen.de/en/dc18rc-makita-quick-charger/79300120>

Bosch:

<https://www.holger-clasen.de/en/bosch-battery-lithium-ion-18-v/79300122>

<https://www.holger-clasen.de/en/bosch-quick-charger/79300123>

6 Operation

WARNING

Exposed Crimping Area.

Danger of hand injuries.

- Never reach into the running tool.

NOT suitable for continuous use. The motor overheats when used continuously.

Allow the tool to cool down for a few minutes.

6.1 LED-Workplace Illumination

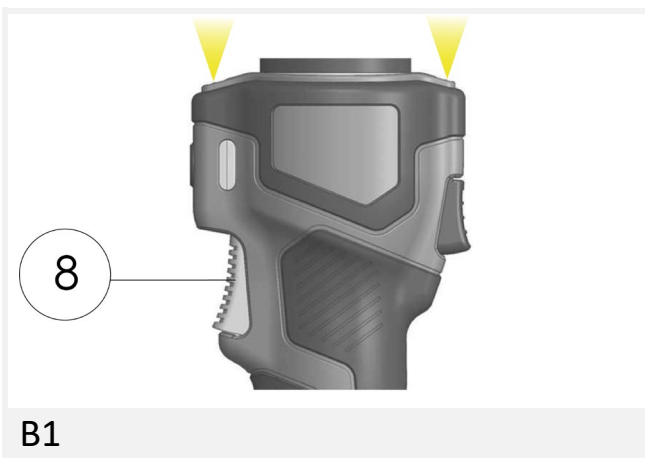
The LED for working field illumination switches on after the forward or reverse switch is actuated and remains lit until 10 seconds after the switch is released.

WARNING

Very bright light source.

Danger due to damage to the eyes during prolonged eye contact.

- Do not look directly into the LED.



B1: Press the forward/return button.

The LED switches on.

The LED shines until 10 seconds after the switch is released.

6.2 Integrated Protective Function

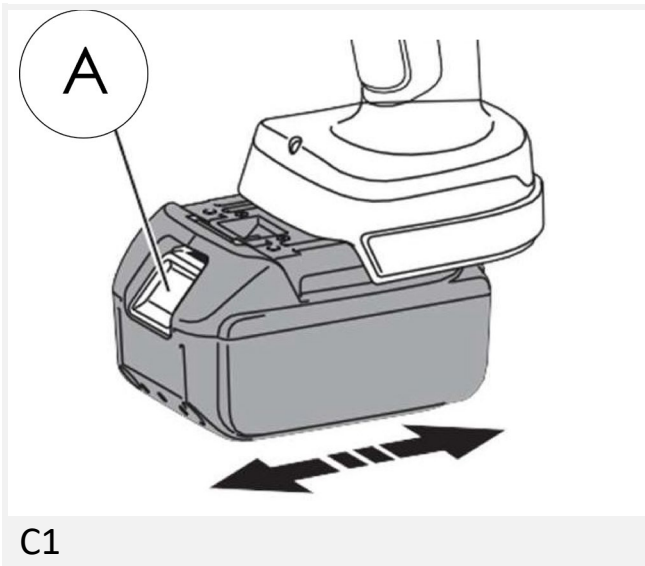
To protect the battery against deep discharge and to increase the service life, the tool motor switches off before the critical range and the motor stops; this is not a malfunction.

As a warning, the LED flashes when the battery level falls below 25 % when the tool is started. In this case, charge the battery immediately.

6.3 Inserting / Removing the Battery

The LEDs indicate the battery capacity.

To do this, press the test button on the battery.



C1:

Inserting:

Push the battery firmly into the battery holder.

The locking button (A) must engage.

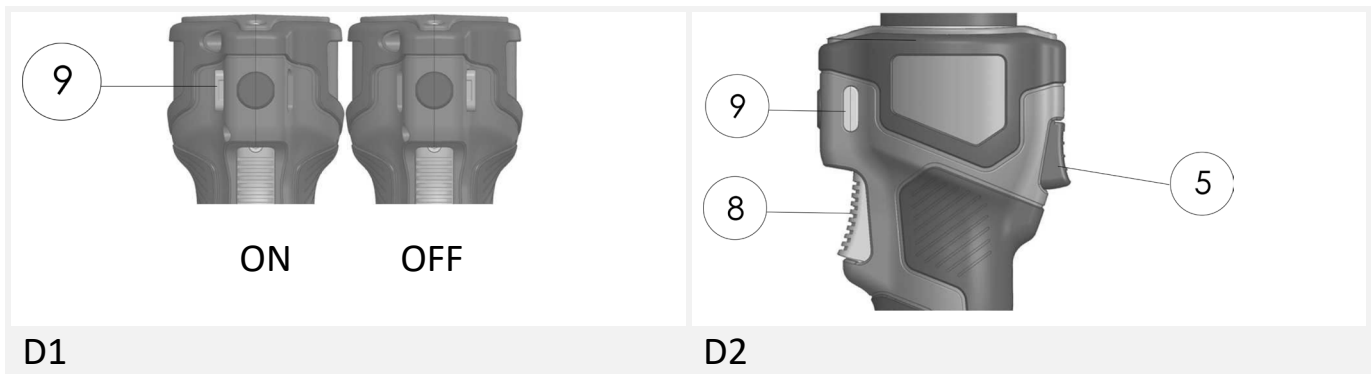
Check that the battery is firmly engaged

Removing:

Press and hold the locking button (A).

Pull the battery off the tool.

6.4 Select Auto Retract / Manual



D1: Changeover Button

The tool can be switched from manual to automatic return.

Press the changeover button (9) to select:

ON: Button left-hand side - **automatic reverse** is activated.

OFF: Button right-hand side - **manual reverse** is set.

D2: Return Setting

Manual Reverse:

Press the forward button (8) to start process.

Press and hold the forward button. The feed can be interrupted by releasing the release button. This is useful for realignment.

The tool stops after reaching the maximum force.

Retract the piston to its initial position/to the desired position by pressing the return button (5).

Automatic Reverse:

Press the forward button (8) to cut the material.

The tool stops after reaching the maximum force and the piston automatically return to the starting position.

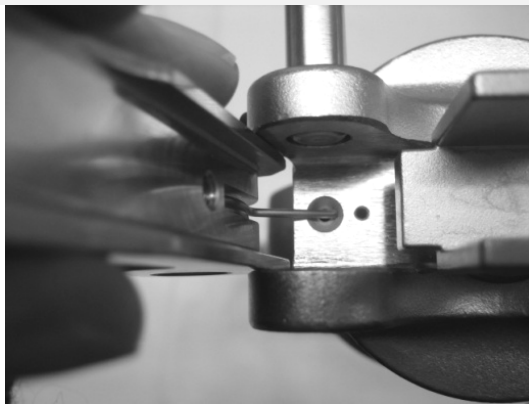
The piston always returns to the starting position automatically after the forward button is released. This is helpful for series processing.

To stop the piston in a desired position, release the button halfway and leave the finger on the button.

6.5 Changing Crimping Head/Cutting Head



E1



E2



E3

E1+E2 Crimping Head:

Disassembly: Pull the safety pins. Remove the clamp and hanger.

Assembly: Note to insert the ends of the springs into the chamfered bores.

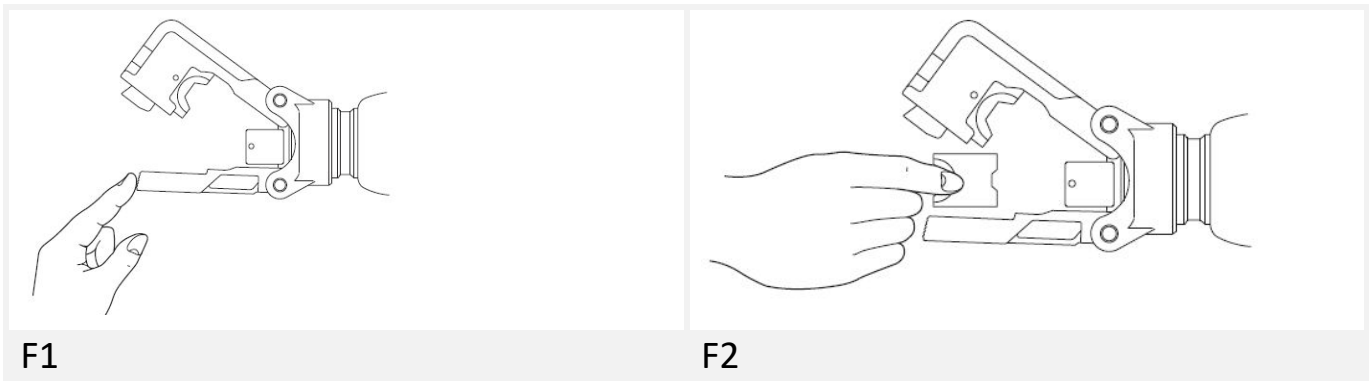
The holes of the tool holder and the clamp / hanger must fit correctly.
Close the safety pins.

E3: Cutting Head

Disassembly: Pull the safety pins. Remove the cutting head.

Assembly: Insert the power joint of the cutting head into the holder.
The holes of the tool holder and the cutting head must fit correctly.
Close the safety pins.

6.6 Inserting/Removing Crimping Dies



Select the correct crimping dies for the connector (chapter 4.2).
Insert the crimping dies for the tool in pairs.

Inserting:

Open the crimping head by pulling the clamp. Slide the crimping dies into the guides of the clamp and the hanger.

Check that the crimping dies are centered and firmly engaged.

Removing:

Open the crimping head by pulling the clamp. You can remove the crimping dies.

6.7 Crimping

Check the head and the control buttons for function and damage.

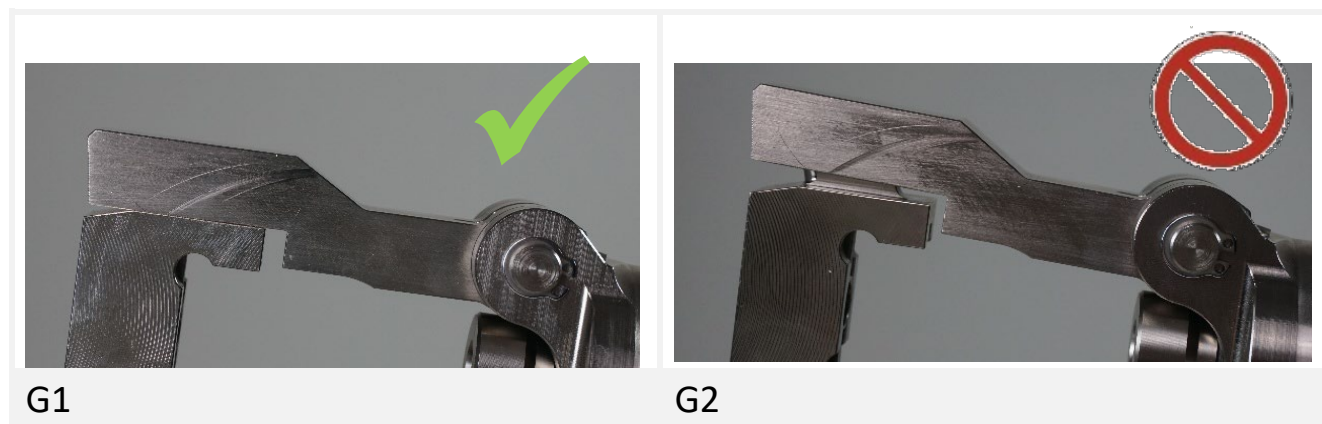
If there is obvious damage, do not put it into operation.

Move the crimping head to its starting position by using the return button (5).

Insert the cable into the connector material. Position the connector material between the crimping dies. Close the clamp.

NOTICE

Non-observance of the following advice will lead to damage and even to breakage of the head.



Locking properly (G1+G2):

Make sure that the clamp is closed completely. Non-observance will lead to deformation and even destruction of the head.

Tool alignment to the material:

Hold the press head at an angle of 90° to the material to be pressed.

Press the release lever (8) to crimp the connector material. Keep the release lever pressed until the maximum pressure is reached. The pressure relief valve stops the pressure build-up when the maximum pressure is reached.

For manual return, move the piston to its starting position by actuating the return switch (5).

With automatic retraction, the retraction takes place after reaching the maximum force or releasing the release lever.

Check that the crimping dies are fully closed.

Only then is the crimping process fully completed.

If possible, use a measuring gauge to check the crimping.

6.8 Cutting

Check the head and the control buttons for function and damage.

If there is obvious damage, do not put it into operation.

Move the cutting blade to its starting position by using the return lever (5).

NOTICE

Non-observance of the following advice will lead to damage and even to breakage of the blades.



Alignment of the tool to cable:

Align the cable on the counter blade near the pivot point (H1).

Position the tool so that it cuts axial to the cable (H2+H3).

Cutting:

Press the release button (8) to cut the cable. Keep the release button pressed until the cable is cut completely.

In the case of **manual return**, move the cutting blade to its starting position by pressing the return switch (5).

In the case of **automatic return**, this is done after reaching the maximum force or loosening the release button.

Remove any chips and metal left on the blades before cutting again.

7 Troubleshooting

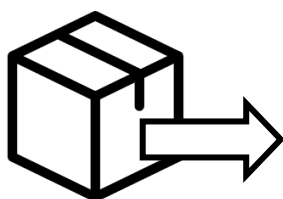
If the tool is colder than -5°C, store it in a room with a temperature of +10 to +25°C for at least one hour to allow the tool to warm up to room temperature again. At temperatures between -20°C and -5°C, the flow properties of the hydraulic oil change.

Error	Cause	Solution
The tool does not work.	The battery is not charged.	Recharge the battery.
	The battery is not inserted correctly.	Insert the battery correctly.
	The contacts between the battery and the tool are dirty.	Clean the contacts.
	Fault in the hydraulic system (e.g. air).	Have the manufacturer inspect the tool.
The piston/cutting blades neither move forwards nor backwards.	The head is dirty.	Remove chips and metal left on the movable parts.
	Wear of the return spring.	Have the manufacturer inspect the tool.
	Defect hydraulic system.	Have the manufacturer inspect the tool.
The piston moves too slowly/not at all together.	Fault in the valves.	Have the manufacturer inspect the tool.
Material is not cut. *	Check the application area / material to be cut.	Incorrect use.
	The material to be cut is excessively cold. *	Warm up the material to be cut

* At temperatures below 10° C, the cutting properties of electrical conductors' change. Cuts may not be possible even if they are within the range of intended use.

8 Maintenance and Service

Task	Period	Maintenance by
Clean and grease movable parts. ► Use machine care oil Not authorised: chemicals, water or wet clothes	Daily	User
Inspection for damage and defects	Daily	User
Maintenance: ▪ Tool ▪ Operating pressure ▪ Hydraulic oil ▪ Blades/Head/Dies	Every 12 months (approx. 10.000 work cycles)	Manufacturer



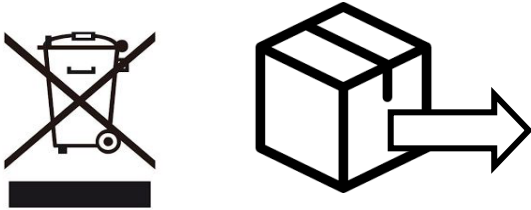
TSC Technik-Service-Center
Alsterdorfer Straße 228
22297 Hamburg, Germany
Tel. +49 40 511 28-200
service@holger-clasen.de
www.holger-clasen.de

Only use the original hydraulic oil used by us.

The use of any other hydraulic oil may damage the tool or affect functionality.

Disassembly or modification of the tool by unqualified persons could cause accidents. Always allow qualified technicians only or the Technik-Service-Center (TSC) by Holger Clasen GmbH & Co. KG to carry out maintenance work. Use original spare parts by HOLGER CLASEN.

9 Disposal



Holger Clasen GmbH & Co. KG
Alsterdorfer Straße 228
22297 Hamburg, Germany
Tel. +49 40 511 28-0
service@holger-clasen.de
www.holger-clasen.de

Do not dispose of the tool as a unit in residual waste.

Tool components can cause environmental damage!

Dispose of the tool in accordance with the scope of the European WEEE (2012/19/EU) and RoHS directives (2011/65/EU).

Rechargeable batteries must be disposed of in accordance with the Battery Directive (2023/1542/EU).

Improper disposal is punishable under the Environmental Liability Act!

In accordance with §19 ElektroG, Holger Clasen GmbH & Co. KG offers the following options for returning old appliances:

1. send in the old appliance with clear notification for disposal to the following drop-off address: **Holger Clasen GmbH & Co. KG, Alsterdorfer Straße 228, 22297 Hamburg, Germany.**
2. personal delivery of the old appliance to the above address.
3. chargeable commissioning of Holger Clasen GmbH & Co. KG to collect the old appliance. The end user is responsible for the proper packaging of the old appliance.

The owner of the waste equipment is responsible for the disposal of personal data in physical or digital form prior to handover.

The owner of the old appliance is responsible for the non-destructive separation or appropriate packaging of old batteries and accumulators in accordance with Section 10 (1) ElektroG, unless they are enclosed by the old appliance.

The battery, the circuit boards and other components must be disposed of separately in accordance with the environmental standards in force in the European Union or in your country. Send the tool to Holger Clasen GmbH & Co. KG for disposal.

Do not dispose of battery pack together with household waste material! In observance of the European Directive 2006/66/EC, on batteries and accumulators and waste batteries and accumulators and the implementation in accordance with national laws, batteries and battery pack(s) that have reached the end of their life must be collected separately and returned to an environmentally compatible recycling facility.

For the disposal of products from other manufacturers, please check their applicable disposal procedures.

For Makita and Bosch products, you will find disposal instructions in the download section of our website under the relevant products.

10 Accessories

Type		Description	Item No.
Case DuoLiner® C Ma / Bo / Mi	Koff-Km IL C div	Lightweight Plastic case with compartments for tool, two batteries, battery charger, crimping die box	79500135
Battery Makita*	BL1850B	Type: Lithium-Ion (90 Wh) Battery Voltage: 18 V Capacity: 5.0 Ah Dimensions: 115 x 75 x 67 mm Weight: 0.64 kg Charging Time: 45 min Charger: DC18RC	79300115
Battery Charger Makita	DC18RC	Input Voltage: 220 – 240 V, 50/60 Hz Weight: 0.90 kg Dimensions: 156 x 190 x 84 mm Charging Time BL1850B (5.0 Ah): 45 min	79300120
Battery Bosch	GBA 18V 5.0Ah	Type: Lithium-Ionen (90 Wh) Battery Voltage: 18 V Capacity: 5.0 Ah Dimensions: 74 x 114 x 56 mm Gewicht: 0.62 kg Charging Time: 80% / 28 min 100% / 45 min Charger: GAL 1880 CV	79300122
Battery Charger Bosch	GAL 1880 CV	Input Voltage: 220 – 240 V, 50/60 Hz Charging Current: 8 A Weight: 0.70 kg Dimensions: 140 x 95 x 250 mm Charging Time GBA 18V 5 Ah: 100% / 45 min	79300123

* Optionally, other 18V Makita batteries can be used:
BL1815N, BL1820B, BL1830B, BL1840B, BL1860B

EC DECLARATION OF CONFORMITY

We: **HOLGER CLASEN GmbH & Co. KG**
Alsterdorfer Straße 228
22297 Hamburg, Germany

in accordance with the following Directive(s)

Im Sinne der EG-Richtlinie(n)

2006/42/EG – The Machinery Directive

2014/30/EU – EMC Directive

2011/65/EU – RoHS Directive

hereby declare that,

Equipment: **Battery-operated Hydraulic Crimping and Cutting Tool**

Type: **DuoLiner® C**

Serial number: _____

is in conformity with the applicable requirements of the following documents:

Machinery Directive: IEC 62841-1:2015

EMC Directive: EMI: EN IEC 61000-6-4: 2019

EMS: EN IEC 61000-6-2:2019; EN 61000-4-2:2009

EN 61000-4-3:2006+A1: 2008+A2:2009

EN 61000-4-8:2010

I hereby confirm that the equipment named above has been designed to comply with the relevant sections of the above referenced specifications. The unit complies with all applicable Essential Requirements of the Directive(s).

Hamburg, 29.05.2024

HOLGER CLASEN GmbH & Co. KG



Lennart Clasen (Managing Director)