

INSTRUCTION MANUAL

Battery-operated Hydraulic Crimping Tool

InLiner® C6

**MASTER
BAS**Fits all OEM
batteries

Original instruction manual
Ident-No.: 76000300-BA
Stand: 06/2024 / Revision: 05/2026

- ☐ InLiner® C6 Ma (suitable for Makita batteries LXT)
- ☐ InLiner® C6 Bo (suitable for Bosch batteries PRO)
- ☐ InLiner® C6 Hi (suitable for Hilti batteries CPC)
- ☐ InLiner® C6 HiN (suitable for Hilti batteries Nuron)
- ☐ InLiner® C6 Mi (suitable for Milwaukee batteries M18)

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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



InLiner® C6 Ma Force 60 kN Range Cu/Al DIN 10 - 240 mm ² Input 18 V DC / 450 W Built 2025 holger-clasen.de	InLiner® C6 Bo Force 60 kN Range Cu/Al DIN 10 - 240 mm ² Input 18 V DC / 450 W Built 2025 holger-clasen.de	InLiner® C6 Hi Force 60 kN Range Cu/Al DIN 10 - 240 mm ² Input 22 V DC / 540 W Built 2025 holger-clasen.de	InLiner® C6 Mi Force 60 kN Range Cu/Al DIN 10 - 240 mm ² Input 18 V DC / 450 W Built 2025 holger-clasen.de	InLiner® C6 HiN Force 60 kN Range Cu/Al DIN 10 - 240 mm ² Input 22 V DC / 540 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 crimping area.

Danger of crushing the hand.

- ▶ 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.

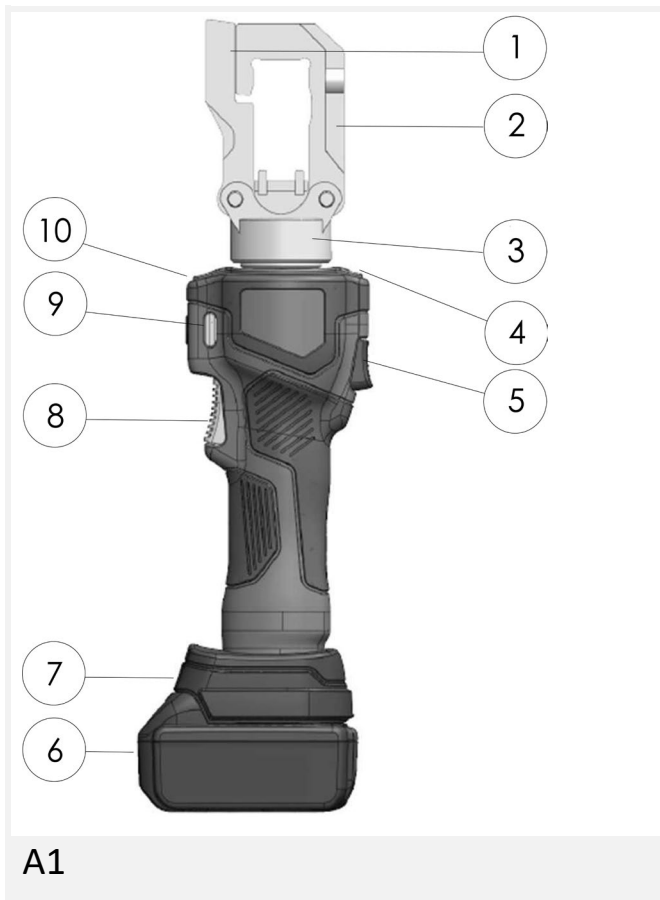
Do not operate the tool if you are in poor physical condition.

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: Descripton

- 1 Clamp
- 2 Hanger
- 3 Crimping Head,
can be rotated through 180°
- 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

**Crimping dies are not included
in scope of delivery.**

3.1 Intended Use

This battery-operated hydraulic tool has been designed for crimping connectors and cable lugs with spring or pin crimping dies (form: F, Z) according to the crimping die table (chapter 4.1). For other applications, please contact HOLGER CLASEN. 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 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.

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 persons 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	InLiner® C6
Crimping Force	60 kN
Stroke	15 mm
Battery Voltage	18 V / Hilti (Hi, HiN): 22 V
Weight*	2.5 kg
Dimensions* L x W x H	375 x 75 x 95 mm
Head	Closed, 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
InLiner® C6 Ma	76000300	Makita 18 V Li-Ionen LXT
InLiner® C6-Set Ma **	76000400	Makita 18 V Li-Ionen LXT
InLiner® C6 Bo	76002300	Bosch 18 V Li-Ionen PRO
InLiner® C6-Set Bo ***	76005500	Bosch 18 V Li-Ionen PRO
InLiner® C6 Hi	76001900	Hilti 22 V Li-Ionen CPC
InLiner® C6 HiN	76005200	Hilti 22 V Li-Ionen Nuron
InLiner® C6 Mi	76004900	Milwaukee 18 V Li-Ionen M18

**Scope of Delivery Set:

InLiner® C6 Ma (Item No. 76000300),
 Li-Ion Battery Makita BL1850B, 18 V / 5 Ah (Item No. 79300115),
 Battery Charger DC18RC (Item No. 79300120)
 Transportation Case KOFF-Km IL C6 (Item No. 79500134)

***Scope of Delivery Set:

InLiner® C6 Bo (Art.-Nr. 76002300),
 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 C6 (Item No. 79500134)

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 Crimping Die Table

NOTICE

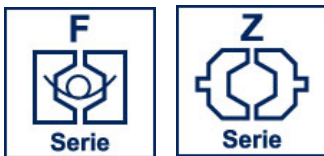
Our crimping dies are manufactured in accordance with the DIN 48083 standard. The assignment to the crimping areas is for guidance only.

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 spring crimping dies (F) or pin crimping dies (Z)

Nomenclature:

Example: K8 / 5 – F
K8 – Index according to DIN 48083 (**60 kN**)
5 – 5 mm Crimping width
F – Spring crimping dies
Z – Pin crimping dies

DIN-Crimping Dies for InLiner® C6:

Pressbereich Crimping Range DIN 48083	Cu nach DIN / acc. to DIN		Al nach DIN* / acc. to DIN	
	Zugentlastet Non Tension	Zugfest Full Tension	Zugentlastet Non Tension	Zugfest Full Tension
10 mm²	K6 / 5 - F # 769 00 111	K8 / 5 - F # 769 00 112	K10 / 7 - F # 769 00 122	
16 mm²	K8 / 5 - F # 769 00 112	K8 / 5 - F # 769 00 112	K12 / 7 - F # 769 00 123	K12 / 7 - F # 769 00 123
25 mm²	K10 / 5 - F # 769 00 113	K10 / 5 - F # 769 00 113	K12 / 7 - F # 769 00 123	K12 / 7 - F # 769 00 123
35 mm²	K12 / 5 - F # 769 00 114	K12 / 5 - F # 769 00 114	K14 / 7 - F # 769 00 124 K14 / 14 - F # 769 00 313	K14 / 7 - F # 769 00 124 K14 / 14 - F # 769 00 313
50 mm²	K14 / 5 - F # 769 00 115 K14 / 14 - F # 769 00 313	K14 / 5 - F # 769 00 115 K14 / 14 - F # 769 00 313	K16 / 7 - F # 769 00 125 K16 / 14 - F # 769 00 284	K16 / 7 - F # 769 00 125 K16 / 14 - F # 769 00 284
70 mm²	K16 / 5 - F # 769 00 116 K16 / 14 - F # 769 00 284	K16 / 5 - F # 769 00 116 K16 / 14 - F # 769 00 284	K18 / 7 - F # 769 00 126 K18 / 14 - F # 769 00 314	K18 / 7 - F # 769 00 126 K18 / 14 - F # 769 00 314
95 mm²	K18 / 5 - F # 769 00 117 K18 / 14 - F # 769 00 314	K20 / 5 - F # 769 00 118 K20 / 14 - F # 769 00 395	K22 / 7 - F # 769 00 127 K22 / 14 - F # 769 00 145	K22 / 7 - F # 769 00 127 K22 / 14 - F # 769 00 145
120 mm²	K20 / 5 - F # 769 00 118 K20 / 14 - F # 769 00 395	K22 / 5 - F # 769 00 119	K22 / 7 - F # 769 00 127 K22 / 14 - F # 769 00 145	K25 / 7 - F # 769 00 128 K25 / 14 - F # 769 00 144
150 mm²	K22 / 5 - F # 769 00 119	K25 / 5 - F # 769 00 120	K25 / 7 - F # 769 00 128 K25 / 14 - F # 769 00 144	
185 mm²	K25 / 5 - F # 769 00 120		K28 / 7 - F # 769 00 129	
240 mm²	K28 / 5 - F # 769 00 121		K32 / 5 - F # 769 00 130	

- * Für die DIN-Verpressungen können auch Zapfenpresseinsätze verwendet werden
- * For crimps according to DIN also pin crimping dies useable

DIN Al/St-Seile** / ACSR-Ropes			
Werkzeug- Kennzahl Index DIN 48083	Al-Hülse Al-Sleeve	St-Hülse St-Sleeve	Presseinsatz Crimping Die
6		16/2,5 25/4 35/6	K6 / 5 - F # 769 00 111
7		50/8	K7 / 5 - F # 769 00 105
9		70/12 95/15	K9 / 5 - F # 769 00 106
12	16/2,5 25/4		K12 / 7 - F # 769 00 123
13		120/20 150/25	K13 / 5 - F # 769 00 107
14	35/6		K14 / 7 - F # 769 00 124 K14 / 14 - F # 769 00 313
16	50/8		K16 / 7 - F # 769 00 125 K16 / 14 - F # 769 00 284
18	70/12		K18 / 7 - F # 769 00 126 K18 / 14 - F # 769 00 314
22	95/15		K22 / 7 - F # 769 00 127 K22 / 14 - F # 769 00 145
25	44/32 50/30 120/20		K25 / 7 - F # 769 00 128 K25 / 14 - F # 769 00 144

* Querschnitt Al/St /
Cross section ACSR

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

Further Spring Crimping Dies for InLiner® C6:

Pressbereich Crimping Range	Al / Cu-Sektorleiter / Sector-shaped conductor - Vorrunden / Prerounding	Nicht DIN Sechskant / Non DIN Hexagonal		Dorn Arbor
	Eindrähtig Single Stranded	Mehrdrähtig Multi-Stranded		
10 mm²		R10 / 20 - F # 769 00 152	ND10 / 5 - F # 769 00 133	D10 / 9 - F # 769 00 513
16 mm²		R12 / 20 - F # 769 00 153	ND16 / 5 - F # 769 00 134	D16 / 9 - F # 769 00 514
25 mm²		R12+ / 20 - F # 769 00 154	ND25 / 5 - F # 769 00 135	D25 / 9 - F # 769 00 164
35 mm²	R12+ / 20 - F # 769 00 154	R14 / 20 - F # 769 00 155	ND35 / 5 - F # 769 00 136	D35 / 9 - F # 769 00 165
50 mm²	R14 / 20 - F # 769 00 155	R16 / 20 - F # 769 00 156	ND50 / 5 - F # 769 00 137	D50 / 9 - F # 769 00 166
70 mm²	R16 / 20 - F # 769 00 156	R18 / 20 - F # 769 00 157	ND70 / 5 - F # 769 00 138	D70 / 10 - F # 769 00 167
95 mm²	R18 / 20 - F # 769 00 157	R22 / 20 - F # 769 00 158	ND95 / 5 - F # 769 00 139	D95 / 12 - F # 769 00 168
120 mm²	R22 / 20 - F # 769 00 158	R22+ / 20 - F # 769 00 159	ND120 / 5 - F # 769 00 140	
150 mm²	R22+ / 20 - F # 769 00 159	R25 / 20 - F # 769 00 160	ND150 / 5 - F # 769 00 141	
185 mm²	R25 / 20 - F # 769 00 160	R28 / 20 - F # 769 00 161	ND185 / 5 - F # 769 00 142	
240 mm²	R28 / 20 - F # 769 00 161	R32 / 20 - F # 769 00 162	ND240 / 5 - F # 769 00 143	
300 mm²	R32 / 20 - F # 769 00 162		ND300 / 5 - F # 769 00 285	

DIN Pin Crimping Dies for InLiner® C6:

Cu nach DIN / acc. to DIN		
Pressbereich Crimping Range DIN 48083	Zugentlastet Non Tension	Zugfest Full Tension
10 mm²	K6 / 5 - ZA # 769 00 315	K8 / 5 - ZA # 769 00 316
16 mm²	K8 / 5 - ZA # 769 00 316	K8 / 5 - ZA # 769 00 316
25 mm²	K10 / 5 - ZA # 769 00 317	K10 / 5 - ZA # 769 00 317
35 mm²	K12 / 5 - ZA # 769 00 318	K12 / 5 - ZA # 769 00 318
50 mm²	K14 / 5 - ZA # 769 00 319	K14 / 5 - ZA # 769 00 319
70 mm²	K16 / 5 - ZA # 769 00 320	K16 / 5 - ZA # 769 00 320
95 mm²	K18 / 5 - ZA # 769 00 321	K20 / 5 - ZA # 769 00 322
120 mm²	K20 / 5 - ZA # 769 00 322	K22 / 5 - ZA # 769 00 323
150 mm²	K22 / 5 - ZA # 769 00 323	K25 / 5 - ZA # 769 00 324
185 mm²	K25 / 5 - ZA # 769 00 324	

Al nach DIN / acc. to DIN	
Zugentlastet Non Tension	Zugfest Full Tension
K10 / 5 - ZA # 769 00 317	
K12 / 7 - ZA # 769 00 335	K12 / 7 - ZA # 769 00 335
K12 / 7 - ZA # 769 00 335	K12 / 7 - ZA # 769 00 335
K14 / 7 - ZA # 769 00 336	K14 / 7 - ZA # 769 00 336
K16 / 7 - ZA # 769 00 337	K16 / 7 - ZA # 769 00 337
K18 / 7 - ZA # 769 00 338	K18 / 7 - ZA # 769 00 338
K22 / 7 - ZA # 769 00 339	K22 / 7 - ZA # 769 00 339
K22 / 7 - ZA # 769 00 339	K25 / 7 - ZA # 769 00 340
K25 / 7 - ZA # 769 00 340	

DIN Al/St-Seile **/ACSR-Ropes			
Werkzeug- Kennzahl Index DIN 48083	Al-Hülse Al-Sleeve	St-Hülse St-Sleeve	Presseinsatz Crimping Die
6		16/2,5 25/4 35/6	K6 / 5 - ZA # 769 00 315
7		50/8	K7 / 5 - ZA # 769 00 405
9		70/12 95/15	K9 / 5 - ZA # 769 00 406
12	16/2,5 25/4		K12 / 7 - ZA # 769 00 335
13		120/20 150/25	K13 / 5 - ZA # 769 00 407
14	35/6		K14 / 7 - ZA # 769 00 336
16	50/8		K16 / 7 - ZA # 769 00 337
18	70/12		K18 / 7 - ZA # 769 00 338
22	95/15		K22 / 7 - ZA # 769 00 339
25	44/32, 50/30 120/20		K25 / 7 - ZA # 769 00 340

* Querschnitt Al/St / Cross section ACSR

** Pressbreiten/Crimping Width:

K6/K13 = 5mm;

K12/K14 = 7mm

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

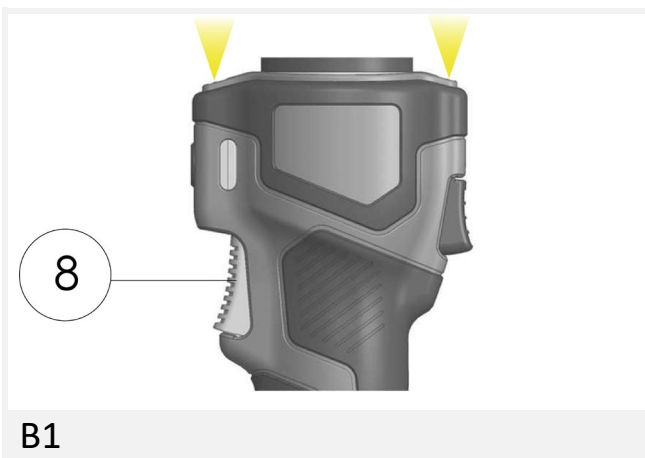
The LED for working field illumination switches on after the forward or reverse switch is actuated and remains lit until 10 seconds after the switch is released.

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

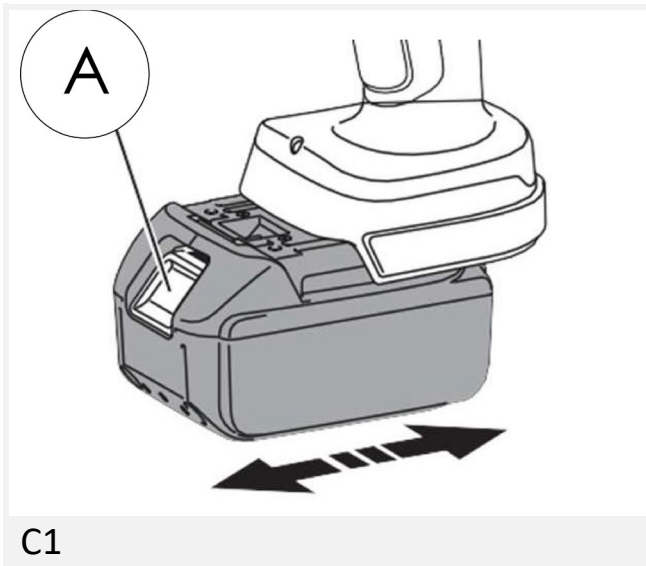
To protect the battery against deep discharge and to increase the service life, the tool motor switches off before the critical range and the motor stops; this is not a malfunction.

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.

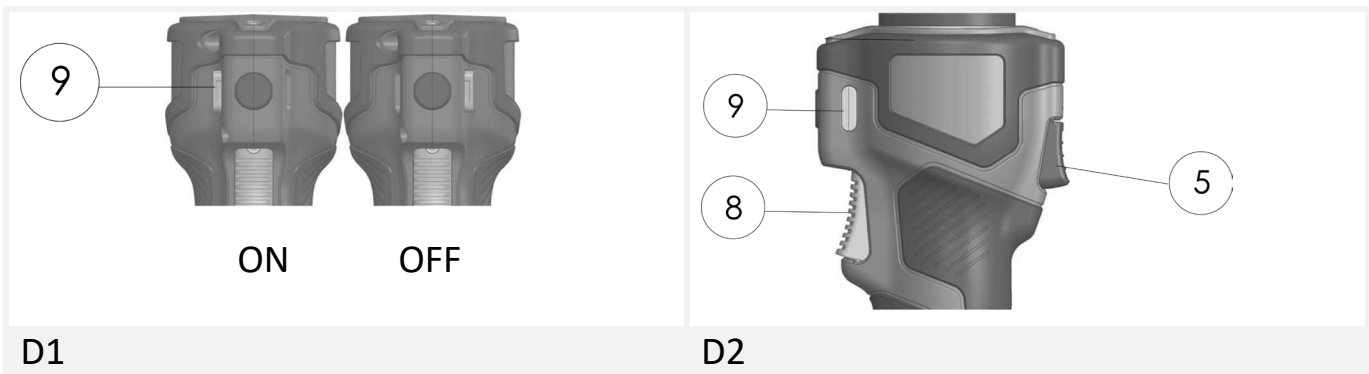
Check that the battery is firmly engaged

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 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 Spring Crimping Dies:

Slide the crimping dies into the guides of the clamp and the hanger.
Pay attention to the correct position of the spring clip (red lines).

Removing:

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

Inserting Pin Crimping Dies:

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.

6.6 Crimping

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

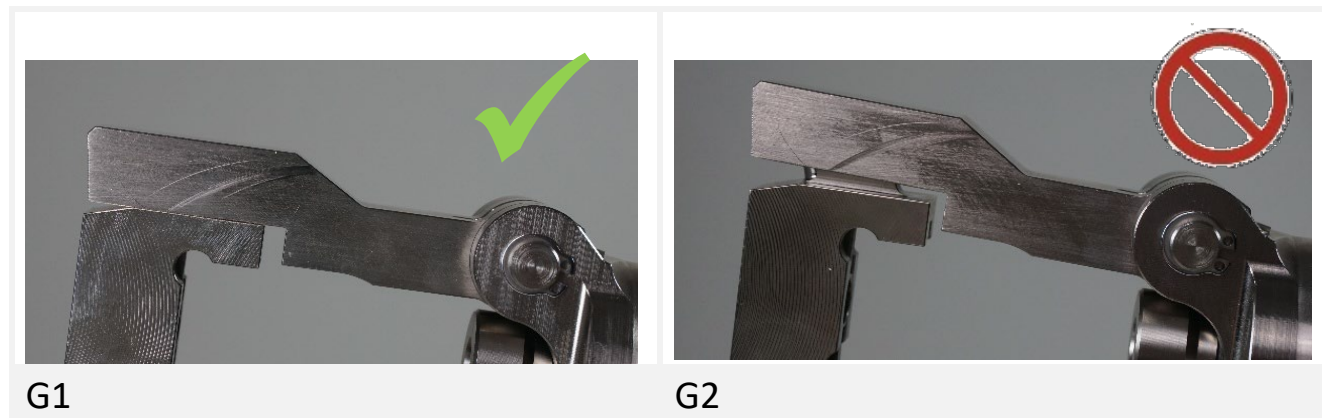
If there is obvious damage, do not put it into operation.

Move the piston 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 advices will lead to damage and even to breakage of the head.



Locking properly (G1+G2):

Make sure that the clamp is closed completely.

Alignment Tool to Material:

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

Press the forward button (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 button (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.

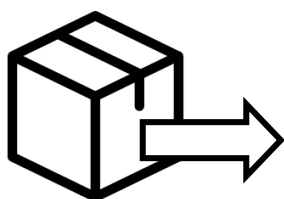
7 Troubleshooting

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 crimping dies do not move to starting position	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.

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 ▪ Head/Dies	Every 12 months (approx. 10.000 work cycles)	Manufacturer



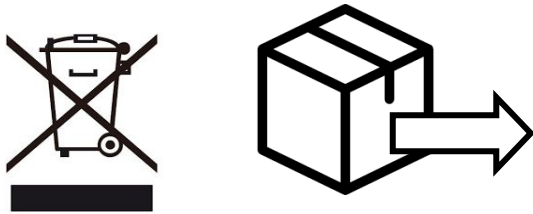
TSC Technik-Service-Center
Alsterdorfer Straße 228
22297 Hamburg, Germany
Tel. +49 40 511 28-200
service@holger-clasen.de
www.holger-clasen.de

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 InLiner® C6 Ma / Bo / Mi	Koff-Km IL C6	Lightweight Plastic case with compartments for tool, two batteries, battery charger, crimping die box	79500134
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 Tool**

Type: **InLiner® C6**

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)