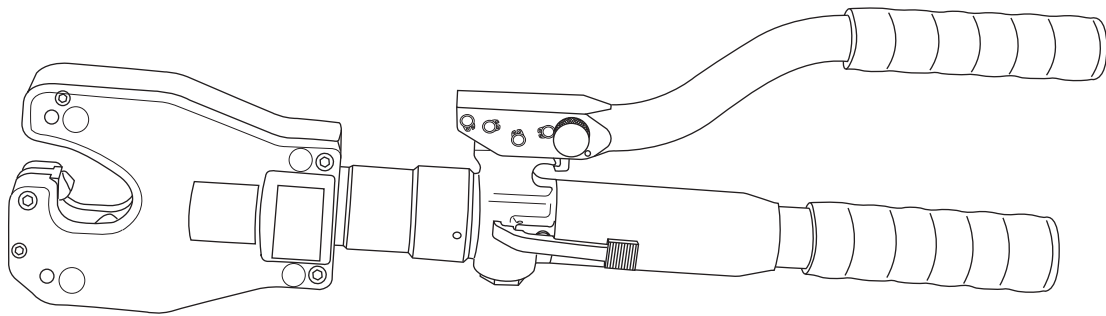


# INSTRUCTION MANUAL



## **HK06AT Hydraulic Crimping Tool**



**Read and understand** all of the instructions and safety information in this manual before operating or servicing this tool.

Register this product at [www.greenlee.com](http://www.greenlee.com)

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## Description

The HK06AT Hydraulic Crimping Tool is a hand-held, self-contained, dieless crimping tool intended to crimp aluminum and copper connectors onto electrical cable.

## Safety

Safety is essential in the use and maintenance of Greenlee tools and equipment. This instruction manual and any markings on the tool provide information for avoiding hazards and unsafe practices related to the use of this tool. Observe all of the safety information provided.

## Purpose of this Manual

This manual is intended to familiarize all personnel with the safe operation and maintenance procedures for the following Greenlee tool:

HK06AT Hydraulic Crimping Tool

Keep this manual available to all personnel.

Replacement manuals are available upon request at no charge at [www.greenlee.com](http://www.greenlee.com).

All specifications are nominal and may change as design improvements occur. Greenlee Textron Inc. shall not be liable for damages resulting from misapplication or misuse of its products.

Blackburn is a registered trademark of Thomas & Betts.

Tellus is a registered trademark of Shell Oil Company.

# ***KEEP THIS MANUAL***

## IMPORTANT SAFETY INFORMATION



### SAFETY ALERT SYMBOL

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.

#### ⚠️ DANGER

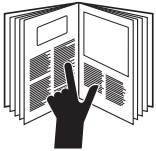
Immediate hazards which, if not avoided, **WILL** result in severe injury or death.

#### ⚠️ 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.



#### ⚠️ WARNING

Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.

Failure to observe this warning could result in severe injury or death.

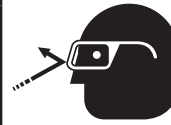


#### ⚠️ WARNING

Electric shock hazard:

This tool is not insulated. When using this unit on or near energized electrical lines, use proper personal protective equipment.

Failure to observe this warning could result in severe injury or death.



#### ⚠️ WARNING

Wear eye protection when operating this tool.

Failure to wear eye protection could result in serious eye injury from flying debris or hydraulic oil.



#### ⚠️ WARNING

Skin injection hazard:

- Do not use hands to check for leaks.
- Depressurize the hydraulic system before servicing.

Oil under pressure easily punctures skin causing serious injury, gangrene, or death. If you are injured by escaping oil, seek medical attention immediately.

**IMPORTANT SAFETY INFORMATION****⚠ WARNING**

An incomplete crimp can cause a fire.

- Use proper connector and cable combinations. Improper combinations can result in an incomplete crimp.
- The handle load will drop suddenly to indicate a completed crimp. If the handle load does not drop suddenly, the crimp is not complete.

Failure to observe these warnings could result in severe injury or death.

**⚠ CAUTION**

- This tool is intended for two-handed operation. Maintain a firm grip on both handles during operation. Using this tool in any other manner can result in injury or property damage.
- Do not operate the tool without a connector in place. Damage to the ram or crimping tool head can result.

Failure to observe these precautions may result in injury and property damage.

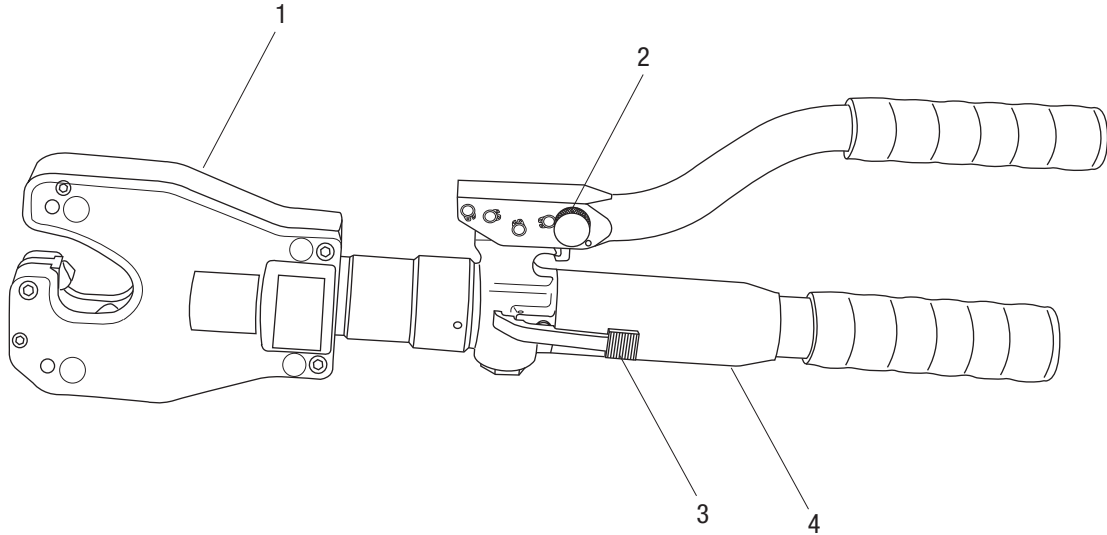
**⚠ WARNING**

Inspect tool before use. Replace any worn or damaged parts. A damaged or improperly assembled tool can break and strike nearby personnel.

Failure to observe this warning could result in severe injury or death.

*Note: Keep all decals clean and legible, and replace when necessary.*

**Identification**



**HK06AT**

- 1. Crimping Head
- 2. Handle Lock
- 3. Release Lever
- 4. Pump Body

**Specifications**


**Crimping Tool**


Length .....	552 mm (21.75")
Width .....	191 mm (7.5")
Height .....	63.5 mm (2.5")
Mass/Weight .....	4.5 kg (9 lb)
Hydraulic Oil .....	150 ml (0.3 pints) of Shell Tellus® T15


**Crimping Capacities**

Crimping Range .....	#4 AWG to 500 kcmil
Crimping Force .....	55 kN (6.2 tons)

## Operation

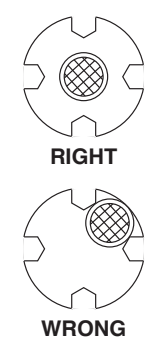
	<b>⚠ WARNING</b>
	<p>Electric shock hazard:</p> <p>This tool is not insulated. When using this unit on or near energized electrical lines, use proper personal protective equipment.</p> <p>Failure to observe this warning could result in severe injury or death.</p>

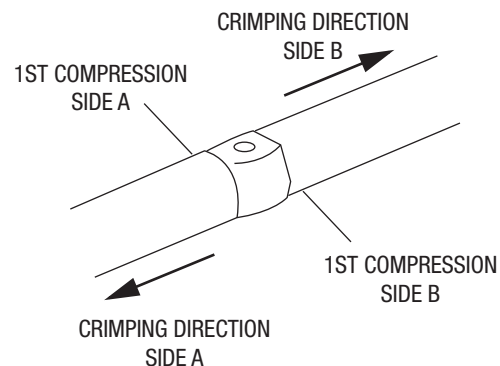
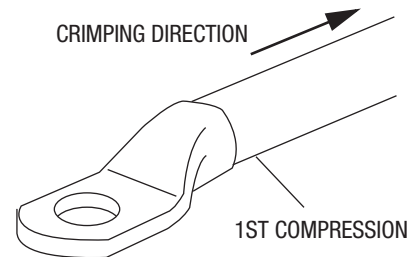
	<b>⚠ WARNING</b>
	<p>Wear eye protection when operating this tool.</p> <p>Failure to wear eye protection could result in serious eye injury from flying debris or hydraulic oil.</p>

	<b>⚠ WARNING</b>
	<p>Skin injection hazard:</p> <ul style="list-style-type: none"> <li>Do not use hands to check for leaks.</li> <li>Depressurize the hydraulic system before servicing.</li> </ul> <p>Oil under pressure easily punctures skin causing serious injury, gangrene, or death. If you are injured by escaping oil, seek medical attention immediately.</p>

<b>⚠ WARNING</b>
<p>An incomplete crimp can cause a fire.</p> <ul style="list-style-type: none"> <li>Use proper connector and cable combinations. Improper combinations can result in an incomplete crimp.</li> <li>The handle load will drop suddenly to indicate a completed crimp. If the handle load does not drop suddenly, the crimp is not complete.</li> </ul> <p>Failure to observe these warnings could result in severe injury or death.</p>

- Follow the lug manufacturer's instructions for appropriate cable strip length and surface preparation.
- Insert cable fully into connector. Center the connector between the nibs.

 <p><b>RIGHT</b></p> <p><b>WRONG</b></p>	<b>⚠ CAUTION</b>
	<p>Small connectors may become wedged between the nibs of the tool. Center the connector between the four nibs before crimping.</p> <p>Failure to observe this precaution may cause property damage.</p>



- Using the sequence illustrated here, pump the handles to advance the nibs. Continue to pump until the pressure relief valve activates.
 

*Note: Pressure relief occurs at approximately 55 kN (6.2 tons) and is indicated by an audible "pop".*
- After achieving pressure relief, the ram automatically returns to the start position and the nibs retract.
- Complete the number of crimps specified by the connector manufacturer.

## Connector Selection

**Tool Range:** Copper — 4 AWG to 500 kcmil (except as noted Δ)

**This tool is cUL and UL classified for use with the following connector brands:**

CONNECTOR TYPE	BARREL TYPE	ANDERSON	BLACKBURN®	BURNDY	ILSCO	PANDUIT	T&B	PENN-UNION	NO. OF CRIMPS*
Copper Splices	Short	VHSS	CSP	YS-L	CT	SCSS/SCS	54506–54518	BCU	4 to 4/0 AWG: 1 crimp 250 to 500 kcmil: 2 crimps
	Long	VHS	CU	YS	CTL	SCL/SCH	54806–54818	BBCU	
Copper Lugs	Short	VHCS	CTL-2/CTL	YA-2LN/YA-L/YA-2L YA/YA-L-TC/YA-L-2TC	CSW <sup>Δ</sup> CRA/CRB	LCAS/LCA LCD	54106–54118 54206–54286	BLU	
	Long	VHCL	CTL-L/LCN	YA-2N	CLN, CLW <sup>Δ</sup> CRA-L/CRB-L CRA-2L/CRB-2L	LCB/LCC	54906BE–54919BE 54854BE–54876BE	BBLU	



\*Use the number of crimps listed in the last column instead of the number provided with the connector.

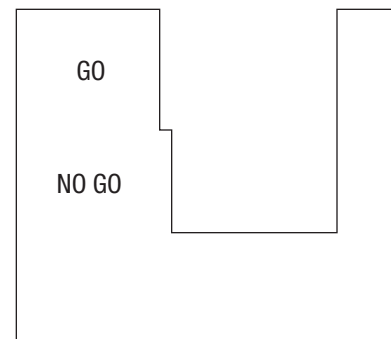
Δ ILSCO Capacity: 4 AWG to 250 kcmil

## Periodic Pressure Relief Valve Check

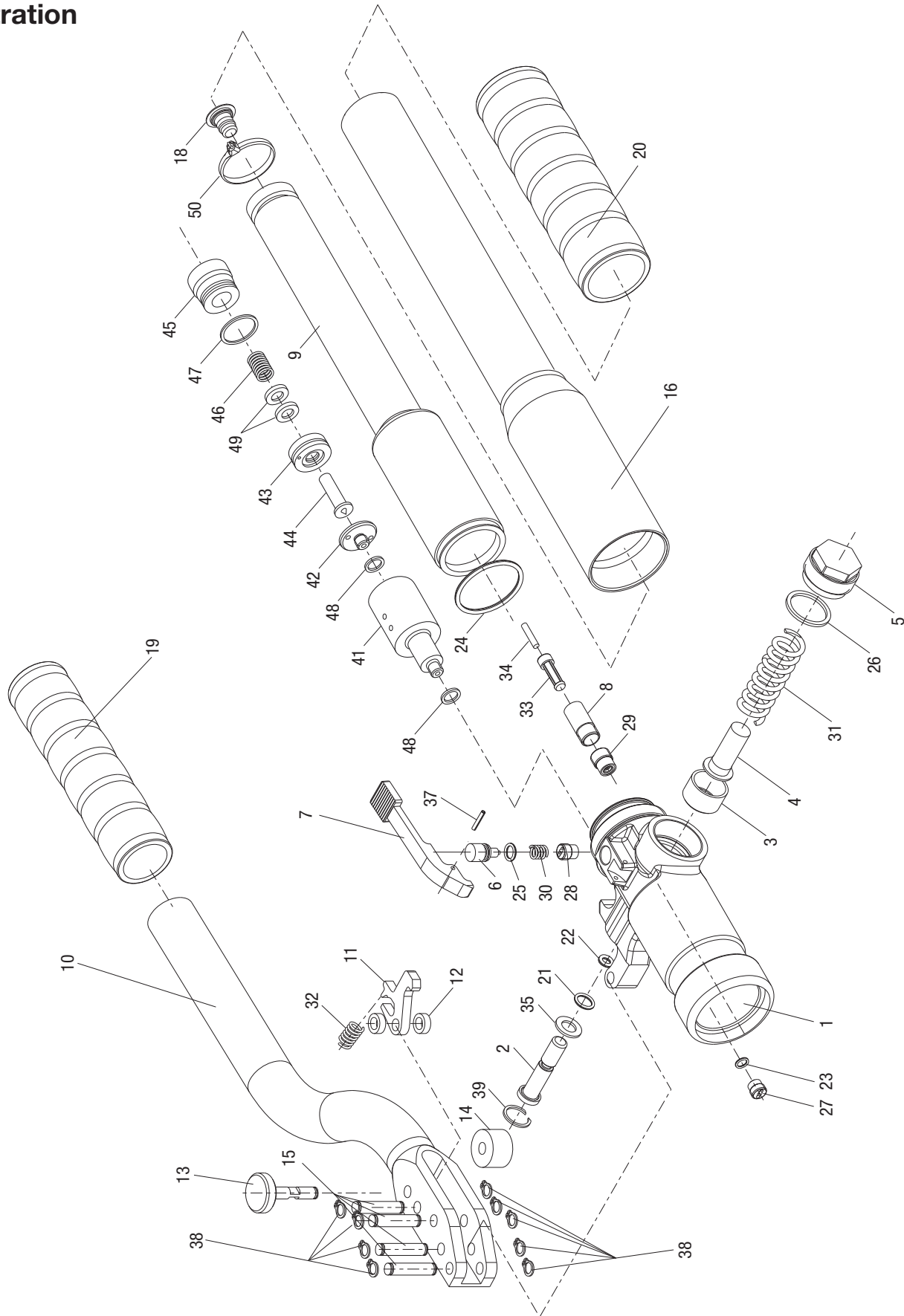
Test the crimping tool periodically to ensure that the pressure relief valve activates at the proper pressure.

### Testing the Crimping Tool

1. Center a test slug between the nibs.
  2. Pump the handle to advance the nibs. Continue pumping until the pressure relief valve activates.
  3. After achieving pressure relief, the ram automatically returns to the start position and the nibs retract.
4. Evaluate the test slug as follows:
    - If the test slug does not fit into GO slot, the pressure relief valve is set too high. Send the crimping tool to an authorized Greenlee service center.
    - If the test slug fits into the GO slot, the pressure relief valve is set correctly.
    - If the test slug fits into the NO GO slot, the pressure relief valve is set too low. Send the crimping tool to an authorized Greenlee service center.

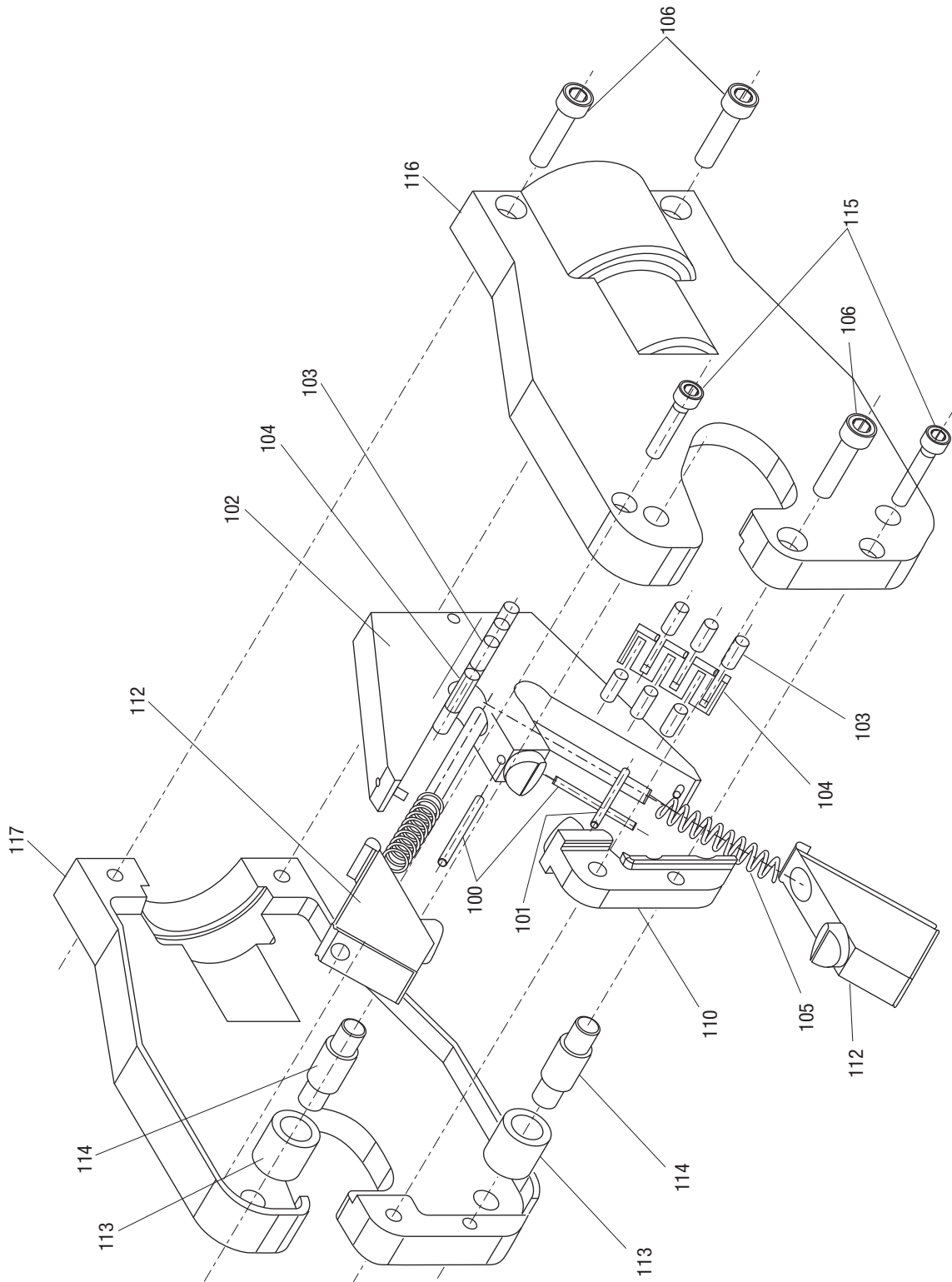


**Illustration**

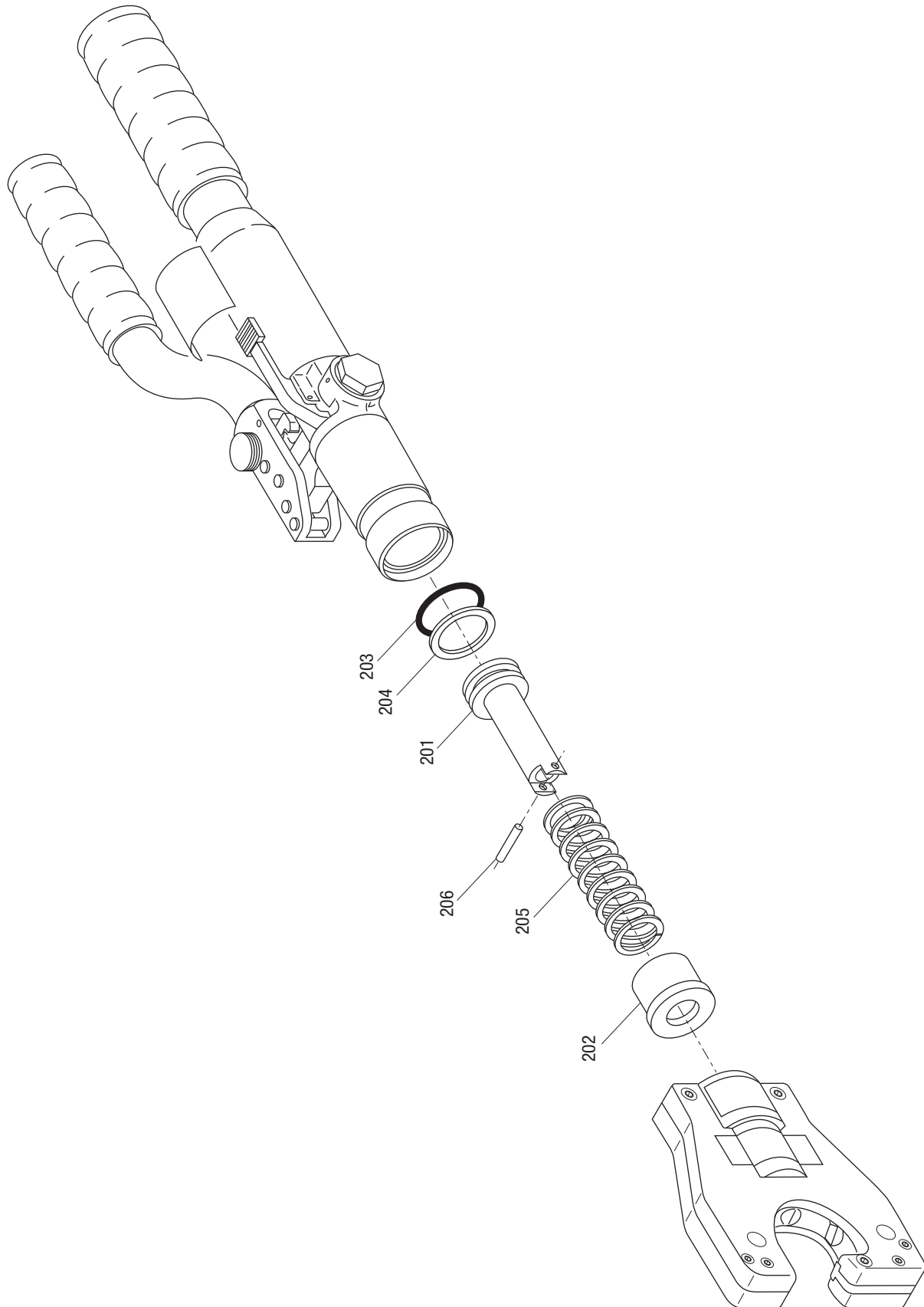




**Illustration**



**Illustration**



## Parts List

Key	Part No.	Description	Qty
1	50063847	Pump body.....	1
2	50063456	Pump piston.....	1
3	50063464	Sleeve .....	1
4	50063480	Ram.....	1
5	50063499	Screw plug .....	1
6	52046669	Release pin .....	1
7	50063553	Release lever.....	1
8	50058827	Filter adapter.....	1
9	50063448	Reservoir.....	1
10	50063561	Pump handle.....	1
11	50103768	Handle lock .....	1
12	50063588	Spacer.....	2
13	50063600	Release knob .....	1
14	50063618	Roller.....	1
15	50063642	Handle pin.....	4
16	50067826	Handle tube.....	1
18	50058789	Reservoir plug .....	1
19	50063421	Grip, 25 mm .....	1
20	50063430	Grip, 32 mm .....	1
21*		O-ring.....	1
22*		O-ring.....	1
23*		O-ring.....	1
24*		O-ring.....	1
25*		O-ring.....	1
26*		Copper washer.....	1
27	50041444	Threaded bushing .....	1
28	50041452	Threaded bushing .....	1
29	50058851	Threaded bushing .....	1
30	50063723	Spring, compression.....	1
31	50063731	Spring, compression.....	1
32	50103776	Spring, compression.....	1
33*		Filter .....	1
34	50058983	Magnet.....	1
35	50063758	Washer .....	1
37*		Roll pin .....	1
38*		Retaining ring .....	9
39*		Retaining ring .....	1
	50063316	Pressure adjustment cartridge (includes items 41–49).....	1
41	50063782	Cartridge body .....	1
42	50058630	Valve seat .....	1
43	50058649	Plunger.....	1
44	50063790	Needle valve.....	1
45	50063804	Pressure adjustment screw.....	1
46	50058940	Spring.....	1
47	50058690	O-ring.....	1
48	50058622	Seal .....	2
49	50058606	Washer .....	2
50	50071777	Ring tie.....	1

## Parts List (cont'd)

Key	Part No.	Description	Qty
100	50017276	Spring pin.....	2
101	50017349	Spring pin.....	1
102	50017292	Cam yoke assembly.....	1
103		Roller bearings .....	12
104		Bearing retainers.....	2
105	50060910	Spring, compression.....	2
106	50061003	Socket head cap screw, 1/4-20 x 1 Nylock .....	3
110	50060848	Fixed jaw .....	1
112	50060856	Moving side jaw .....	2
113	50060864	Pivot roller .....	2
114	50060872	Pivot pin .....	2
115		Socket head cap screw, #10-32 x 1 .....	2
116	50017314	Head cover (LH) .....	1
117	50017322	Head cover (RH).....	1
201	50063812	Piston .....	1
202	50063820	Sleeve .....	1
203	50041924	O-ring, piston .....	1
204	50041940	Backup ring, piston.....	1
205	50058398	Spring, compression.....	1
206	50063405	Dowel pin, 4 x 20 mm .....	1
	50062140	Decal, pinch hazard .....	1
	50060791	Decal, ID and warning.....	1
	50018817	Decal, connector compatibility .....	1
	50063910	Steel case .....	1
<b>Kits</b>			
*	50063952	Seal kit (includes items marked with an asterisk)	
	50061291	Bearing/retainer kit (includes items 103 and 104)	
	50017284	Quad point AT head assembly (includes items 100-117)	
	50063081	10 test slugs with gage	