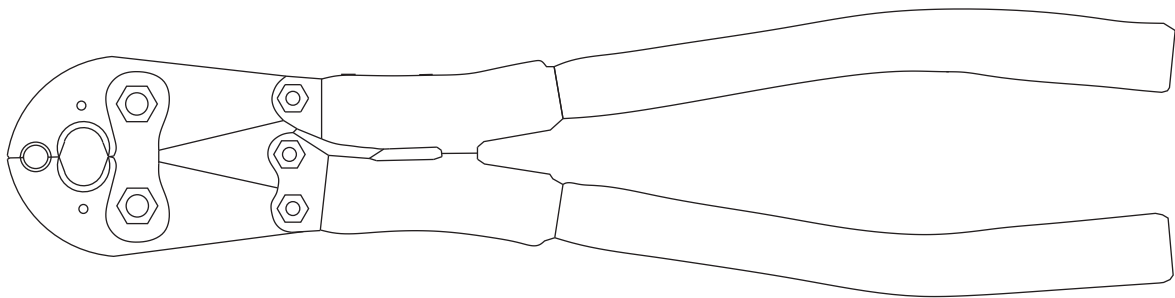


# INSTRUCTION MANUAL



## **K425BG, K425O, K425K58, and K425KO Mechanical Crimping Tools**



**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)



## Description

The **K425BG and K425O** Mechanical Crimping Tools are hand-operated tools that use permanent die grooves and/or insertable W-type dies. These tools have two permanent die grooves, either a “BG” or “O”, and a “D<sub>3</sub>” for distribution tap connectors. The “D<sub>3</sub>” groove also serves as a seat for W-type die inserts to install additional connector types. The die inserts snap into a permanent “D<sub>3</sub>” groove easily with one hand and are secured with the spring-loaded, positive lock, die retaining buttons.

The **K425K58 and K425KO** Mechanical Crimping Tools are hand-operated tools that use permanent die grooves and/or insertable Kearney O-type dies. These tools have two permanent die grooves, either a “5/8” or “O”, and an opening for Kearney O-type dies. When used with the Kearney “D” die, the die groove also serves as a seat for W-type die inserts to install additional connector types. The die inserts snap into the “D” groove easily with one hand and are secured with the spring-loaded, positive lock, die retaining buttons.

All the tools install a full range of connectors including service entrance splices and terminals, stacking lugs, street light, stirrup, and repair sleeves.

The tools incorporate an over center toggle action mechanism, allowing for easy crimping operations and field adjustability.

### For use on:

- Copper taps from #10 solid to #2/0 stranded
- Aluminum/ACSR taps from #14 solid to #4/0 ACSR
- Stirrups from #6 AWG to #4/0 ACSR
- Copper and aluminum code conductor connectors from #6 AWG to #4/0 stranded
- Overhead full tension deadend, full and non-tension splices and terminals from #10 stranded to #4/0 ACSR
- 5/8" and .840" service entrance sleeves

## Safety

Safety is essential in the use and maintenance of Greenlee tools and equipment. This 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 tools:

K425BG, K425O, K425K58, and K425KO  
Mechanical Crimping Tools

Keep this manual available to all personnel. Replacement manuals are available upon request at no charge at [www.greenlee.com](http://www.greenlee.com).

## IMPORTANT SAFETY INFORMATION

	<b>⚠ WARNING</b>
	<p>Electric shock hazard: This tool is not insulated. Do not use on live circuits. Contact with live circuits could result in severe injury or death.</p>

<b>⚠ WARNING</b>
<p>An incomplete crimp can cause a fire. Use proper connector and cable combinations. Improper combinations can result in an incomplete crimp. Failure to observe this warning could result in severe injury or death.</p>

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

<b>⚠ CAUTION</b>
<ul style="list-style-type: none"> <li>• This tool is intended for two-handed operation. Maintain a firm grip on both handles when using this tool.</li> <li>• Inspect tool before use. If any parts are worn or damaged, send the tool to an authorized Greenlee service center.</li> <li>• Do not perform any service or maintenance other than as described in this manual.</li> <li>• Do not exceed the rated capacity of this tool.</li> </ul> <p>Failure to observe these precautions may result in injury or property damage.</p>

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

# KEEP THIS MANUAL



## Specifications

Crimp Force Developed ..... 9,000 lb (4,091 kg)  
Weight (tool only)..... 6 lb (2.7 kg)

## Operation

### K425BG and K425O Die Selection

- For the K425BG, the upper opening is a “BG” die.
- For the K425O, the upper opening is an “O” die.
- For both the K425BG and K425O tools, the lower opening is a “D<sub>3</sub>” die.
- Interchangeable dies may be used in the lower die opening. Dies that may be used include:
  - Greenlee KD6 series
  - Burndy W and X series
  - ILSCO ND series
  - Huskie HT58 series
  - Panduit CD-2001 series
  - Other industry W-type dies

### K425K58 and K425KO Die Selection

- For the K425K58, the upper opening is a “5/8” die.
- For the K425KO, the upper opening is an “O” die.
- For both the K425K58 and K425KO tools, the lower opening accepts interchangeable Kearney O-type, T&B 6-ton, and Blackburn “OD” dies.
- When used with Kearney O-type “D” die, additional interchangeable dies that may be used include:
  - Greenlee KD6 series
  - Burndy W and X series
  - ILSCO ND series
  - Huskie HT series
  - Panduit CD-2001 series
  - Other industry W-type dies

### Operation Procedure

1. Select the proper dies for the connector to be crimped.
2. Install dies in jaws making certain that they are properly secured by the spring-loaded, positive lock, die buttons.

## IMPORTANT

To help minimize hand and arm fatigue and perceived handle force during use, hold the crimping tool with your hands at the end of the handles.

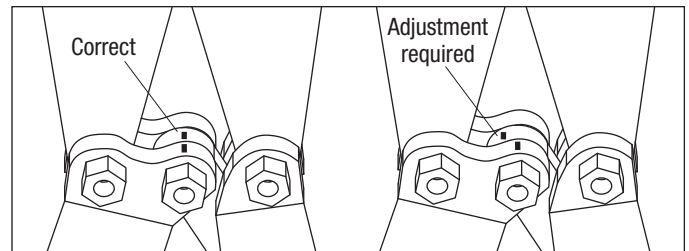
3. Insert conductor into the connector and align the tool and die on the connector. Start in the center for splices and “H” frames, and on the end, nearest the pad, for terminals.

4. Operate the tool by closing, and allowing, the handle butt/stop blocks to touch. Normally a “pop” will be heard as the tool goes over center after the crimp is made.
5. Continue crimping the connector until the correct number of crimps have been completed. Work from the center to the outer edges for splices and “H” frame connectors, alternating sides if possible, for the best compression connection.
6. Reposition tool for next crimp, if required. Unless non-bowing dies are used, it is recommended that the tool be rotated 90° for each adjacent crimp on large splice connections.

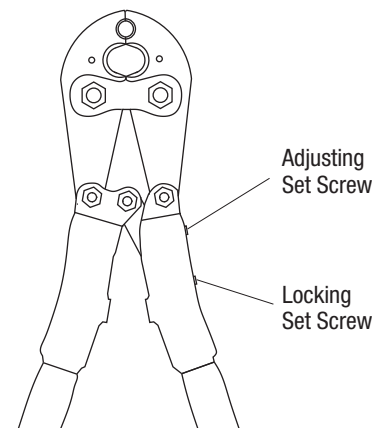
## Inspection and Adjustment

Check tools periodically for correct adjustment. As with any tool, a slight amount of wear may occur over time. This wear may be corrected by readjusting the tool as follows:

1. Remove any die inserts from the tool and make sure the jaw tips are free of dirt, etc.
2. Open tool and close handles until jaw tips just touch. **DO NOT CLOSE HANDLES COMPLETELY!**
3. Check that the index marks (red grooves) on the toggle link and frame line up.

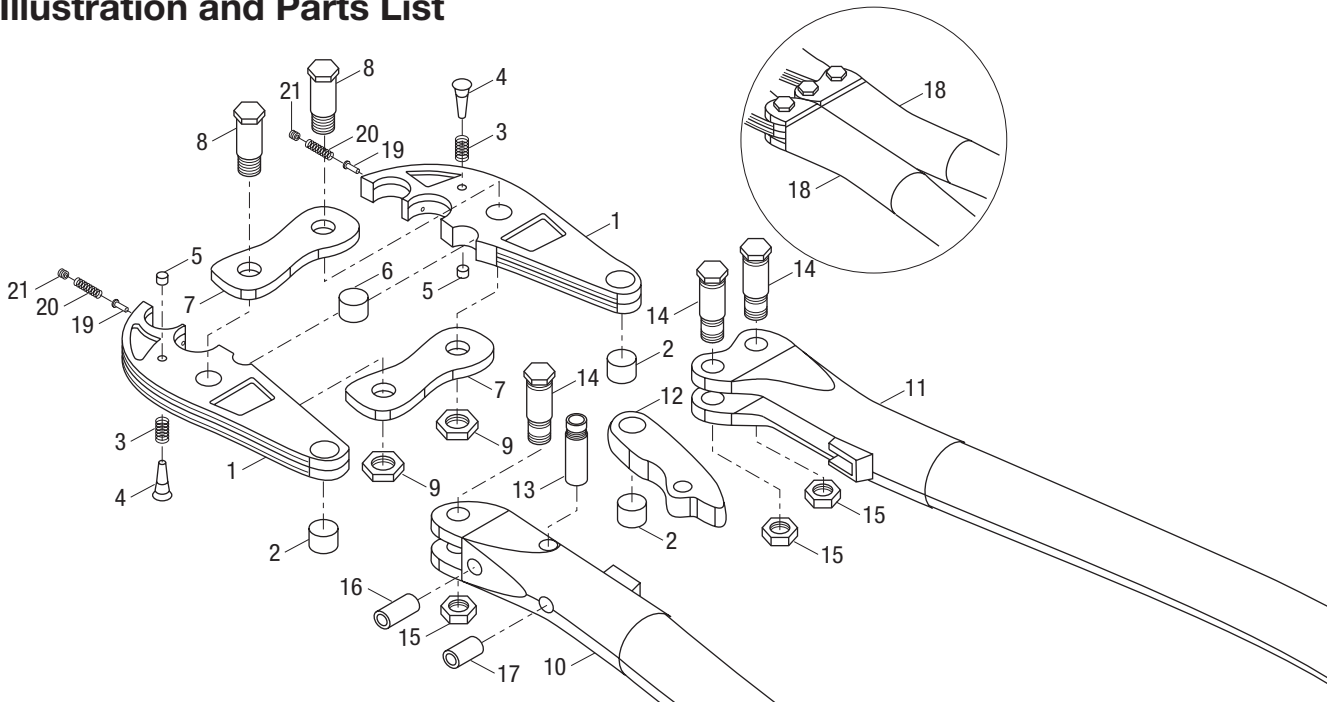


4. If the marks line up, the tool is in proper adjustment.
5. If the marks do not line up, loosen the locking set screw using a 1/4" (6.4 mm) hex key, and then turn the adjustment screw clockwise or counterclockwise until the marks line up.
6. Tighten the locking set screw securely; the tool is now properly adjusted and ready for use.





**Illustration and Parts List**



Key	Description	Qty
1	Jaw (K425BG).....	2
	Jaw (K425O).....	2
	Jaw (K425K58).....	2
	Jaw (K425KO).....	2
2	Bushing, oil free.....	3
3	Spring, ø 6 x L10.8.....	2
4	Pin, push.....	2
5	Nut.....	2
6	Spindle.....	1
7	Link.....	2
8	Bolt, shoulder.....	2
9	Nut, lock 1/2-20.....	2
10	Head, handle (A).....	1
11	Head, handle (B).....	1
12	Toggle.....	1
13	Pin, drive.....	1
14	Bolt, shoulder.....	3
15	Nut, lock 7/16-20.....	3
16	Screw, 1/2-13 x 1 (1/4" hex skt, CP point).....	1
17	Screw, 1/2-13 x 3/4 (1/4" hex skt, CP point).....	1
18	Tube, shrinkage.....	2
19	Pin, die retaining (K425K58 and K425KO).....	2
20	Spring (K425K58 and K425KO).....	2
21	Screw, set (K425K58 and K425KO).....	2

**Repair Kits**

50021303	Kit, blade replacement (K425BG); includes two of items 1-5, 7-9, and one of item 6
50021311	Kit, blade replacement (K425O); includes two of items 1-5, 7-9, and one of item 6
52020877	Kit, blade replacement (K425K58); includes two of items 1-5, 7-9, and one of item 6
52020879	Kit, blade replacement (K425KO); includes two of items 1-5, 7-9, and one of item 6
50021370	Kit, plate replacement; includes two of items 7-9
50021486	Kit, handle-adjusting replacement; includes one of items 10, 12-18
50021494	Kit, bolt-handle replacement; includes three of items 2, 14, 15
50021508	Kit, pin-die replacement; includes two of items 3-5
50021524	Kit, handle replacement; includes one of items 11, 18, and two of items 14, 15
52021491	Kit, pin-Kearney die; includes two each of items 19-21



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