

12 TON

HYDRAULIC SHOP PRESS

Instruction Manual

Please read this instruction manual carefully before use.

IMPORTANT

PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFETY INSTRUCTIONS AND WARNINGS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE TO PROPERTY AND/OR SERIOUS PERSONAL INJURY. PLEASE KEEP THIS INSTRUCTION MANUAL SAFE FOR FUTURE USE.

1. SAFETY INSTRUCTIONS AND WARNINGS

- 1.1 Use a qualified person to maintain the press in good condition. Keep it clean for best and safest performance.
- 1.2 The maximum load is 12tons. **DO NOT** exceed this rated capacity. Never apply excessive force to a workpiece and always use the pressure gauge to accurately determine the applied load.
- 1.3 Use this press for the purpose for which it is intended. **DO NOT** use it for any other purpose it is not designed to perform.
- 1.4 Keep children and unauthorized persons away from the work area.
- 1.5 Remove ill fitting clothing. Remove ties, watches, rings and other loose jewelry, and contain long hair.
- 1.6 Wear ANSI approved impact safety goggles, full-face impact safety shield and heavy-duty work gloves when operating the press.
- 1.7 Keep proper balance and footing, do not overreach and wear nonskid footwear.
- 1.8 Only use this press on a surface that is stable, level, dry and not slippery, and capable of sustaining the load. Keep the surface clean, tidy and free from unrelated materials and ensure that there is adequate lighting.
- 1.9 Inspect the press before each use. **DO NOT** use if bent, broken, cracked, leaking or otherwise damaged, any suspect parts are noted or it has been subjected to a shock load.
- 1.10 Check to ensure that all applicable bolts and nuts are firmly tightened.
- 1.11 Ensure that workpiece is center-loaded and secure.
- 1.12 Keep hands and feet away from bed area at all times.
- 1.13 **DO NOT** use the shop press to compress spring or any other item that could disengage and cause a potential hazard. Never stand directly in front of loaded press and never leave loaded press unattended.
- 1.14 **DO NOT** operate the press when you are tired or under the influence of alcohol, drugs or any intoxicating medication.
- 1.15 **DO NOT** allow untrained persons to operate the press.
- 1.16 **DO NOT** make any modifications to the press.
- 1.17 **DO NOT** use brake fluid or any other improper fluid and avoid mixing different types of oil when adding hydraulic oil. Only good quality hydraulic jack oil can be used.
- 1.18 **DO NOT** expose the press to rain or any other kind of bad weather.
- 1.19 If the press needs repairing and/or there is any part that needs to be replaced, have it repaired by authorized technicians and only use the replacement parts supplied by the manufacturer.

WARNING: the warnings, cautions and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

2. SPECIFICATIONS

Capacity	12ton	Stroke	180mm (7-1/16")
Working Range	0-918mm (0~36-1/8 ")	Bed Width	510mm (20-1/16")

3.ASSEMBLY

Use the exploded drawing as your guide to assemble. Lay all parts and assemblies out in front of you before beginning. The following procedure is recommended:

- 3.1 Attach one base section (20) to left post and lower cross member (25) using bolts (24), washers (21), lock washers (22) and nuts (23), then attach another to right post and the lower cross member.
- 3.2 Put the press frame in an upright position, attach the two upper cross beams (32) to left and right posts (19) using bolts (12), washers (15), lock washers (14) and nuts (13).
- 3.3 Put the upper plate (6) onto the upper crossbeam, insert the bolt (5) into the hole in the upper plate, then insert the ram into the hole in the upper plate.
- 3.4 Screw the upper round nut (7) onto the ram until end, then put the under plate (8) onto the ram through the bolt (5), secure the upper plate and under plate by tightening the washers (9) and nuts (10) to the bolt (5).
- 3.5 Insert bed frame pin (18) into the holes in the posts, then insert the press bed frame (17) into press frame and onto bed frame pin.
- 3.6 Attach the setting plate (26) to the right post using bolts (24), washers (21), lock washers (22) and nuts (23), then secure the pump assemblies using the bolt (27) and washers (28), and then insert the handle (30) to the handle bracket.
- 3.7 Connect the hydraulic hose fitting (33) to the connection nut (34) and assemble the pressure gauge (1) to the pressure gauge connection nut (35) which is on the top of ram (3).
- 3.8 Tighten all bolts and screws.

4. BEFORE FIRST USE

- 4.1 **Note:** Before first use of this product, purge away air from the hydraulic system: open the release valve by turning it counterclockwise. Pump several full strokes to eliminate any air in the system.
- 4.2 Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.

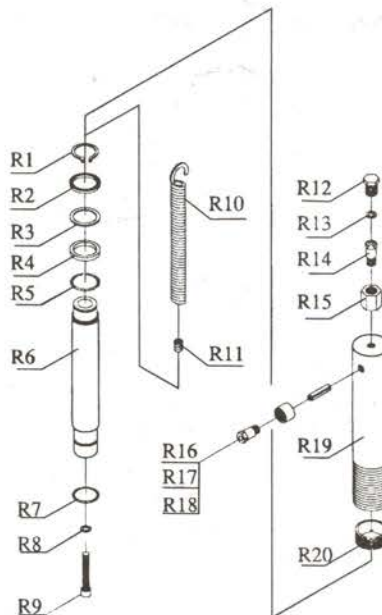
5. OPERATING INSTRUCTIONS

WARNING! Ensure that you read, understand and apply the safety instructions and warnings before use.

- 5.1 Place the heel block (16) on press bed frame (17), then insert workpiece onto the heel block.
- 5.2 Close the release valve by turning it clockwise until it is firmly closed.
- 5.3 Pump the handle until serrated saddle nears workpiece.
- 5.4 Align workpiece and ram to ensure center-loading.
- 5.5 Pump the handle to apply load onto workpiece.
- 5.6 When work is done, stop pumping the handle, slowly and carefully remove load from workpiece by turning the release valve counterclockwise in small increments.
- 5.7 Once ram has fully retracted, remove workpiece from bed frame.

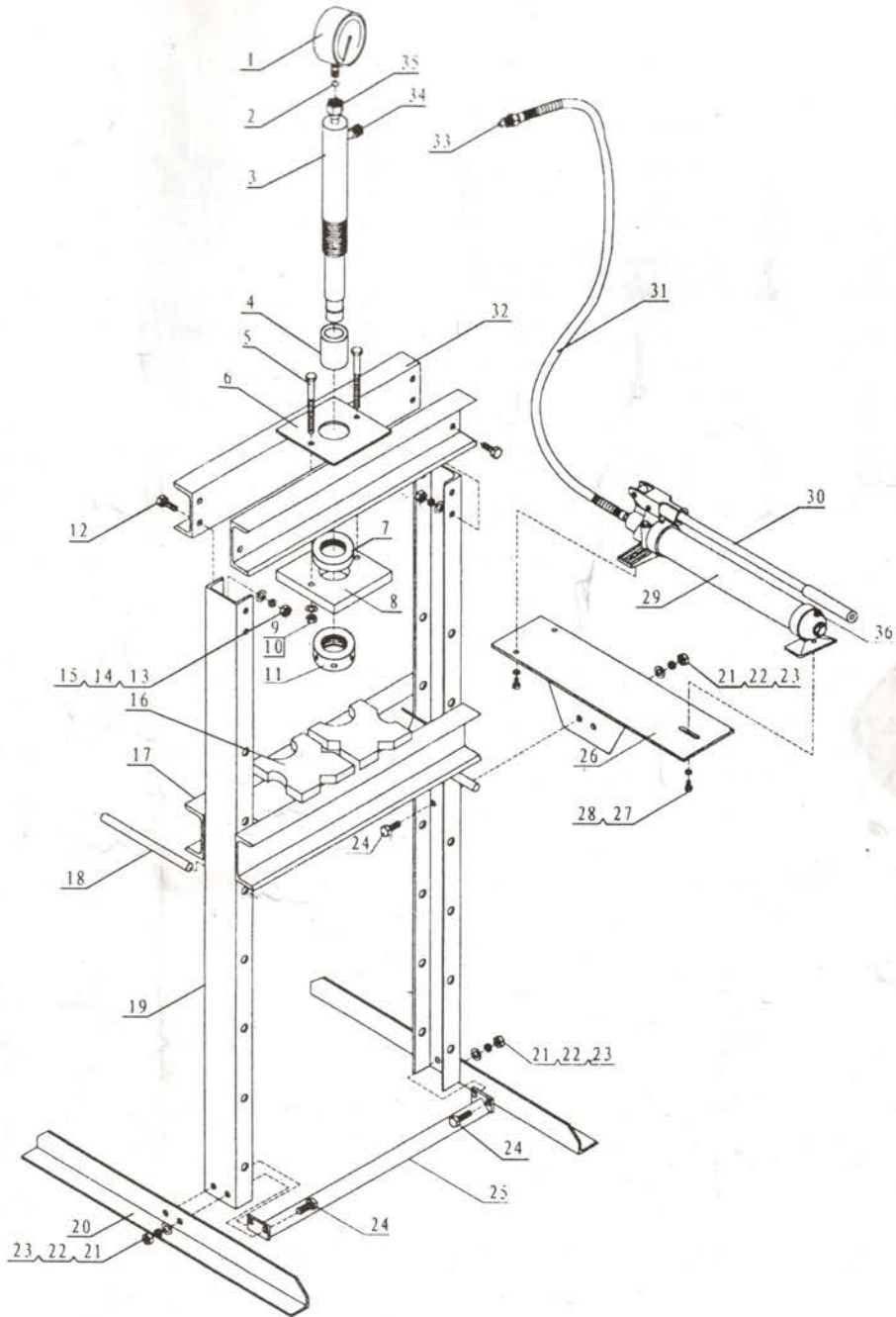
6. MAINTENANCE

- 6.1 Clean the outside of the press with dry, clean and soft cloth and periodically lubricate the joints and all moving parts with a light oil as needed.
- 6.2 When not in use, store the press in a dry location with ram and piston fully retracted.
- 6.3 When press efficiency drops, purge the hydraulic system to eliminate any air in the system as described in 4.1.
- 6.4 Check the hydraulic oil: remove the oil filler nut (36) on the pump, if it is not adequate, fill with high quality hydraulic jack oil as necessary, then replace the oil filler nut, purge away air from the hydraulic system as described in 4.1.



RAM PARTS LIST

Part No.	Description	Qty	Part No.	Description	Qty
R1	Retaining ring	1	R11	Screw	1
R2	Sealing ring	1	R12	Screw	1
R3	Ring	1	R13	Nylon ring	1
R4	O-ring	1	R14	Gauge coupler	1
R5	Circlip	1	R15	Gauge connection nut	1
R6	Piston	1	R16	Pin	1
R7	Circlip	1	R17	Connection nut	1
R8	Sealing washer	1	R18	Coupler	1
R9	Bolt M10	1	R19	Ram	1
R10	Spring	1	R20	Ring for ram	1



PARTS LIST

Part No.	Description	Qty	Part No.	Description	Qty	Part No.	Description	Qty
1	Pressure gauge	1	13	Nut M16	4	25	Lower cross member	1
2	Nylon ring	1	14	Lock washer Ø 16	4	26	Setting plate	1
3	Ram assy	1	15	Washer Ø 16	4	27	Bolt M8 x 15	3
4	Serrated saddle	1	16	Heel block	2	28	Washer Ø 8	3
5	Bolt M10	2	17	Press bed frame	1	29	Pump assy	1
6	Upper plate	1	18	Bed frame pin	2	30	Handle	1
7	Upper round nut	1	19	Post	2	31	Hydraulic hose	1
8	Under plate	1	20	Base section	2	32	Upper cross beam	1
9	Washer Ø 10	2	21	Washer Ø 12	6	33	Hose fitting	1
10	Nut M10	2	22	Lock washer Ø 12	6	34	Connection nut	1
11	Under round nut	1	23	Nut M12	6	35	Gauge connection nut	1
12	Bolt M16 x 35	4	24	Bolt M12 x 30	6	36	Oil filler nut	1