

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 work piece 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 working 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 work piece 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.
- 1.20 **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
Working Range	77-917mm	Bed Width	514mm

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 the left base with the upright by using bolts, washers, lock washers and nuts. Repeat the same step for the right base.
- 3.2 Put the press frame in an upright position, attach the two beams to left and right uprights by using bolts, washers, lock washers and nuts.
- 3.3 Put the ram plate onto the beam, insert the bolt into the hole of the ram plate then insert the ram into the ram plate.
- 3.4 Screw the upper round nut onto the ram until end, then put the under plate onto the ram through the bolt, secure the upper plate and under plate by tightening the washers and nuts to the bolt.
- 3.5 Insert bed frame pin into the holes in the posts, then insert the press bed frame into press frame and onto bed frame pin.
- 3.6 Attach the setting plate to the right post using bolts, washers, lock washers and nuts, then secure the pump assemblies using the bolt and washers, and then insert the handle to the handle bracket.
- 3.7 Connect the hydraulic hose fitting to the connection nut and assemble the pressure gauge on the pressure gauge connection nut which is on the top of ram.
- 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 air in the system.
- 4.2 Check all the parts and conditions, stop using it and contact your supplier immediately if there is any parts broken,

5. OPERATING INSTRUCTIONS

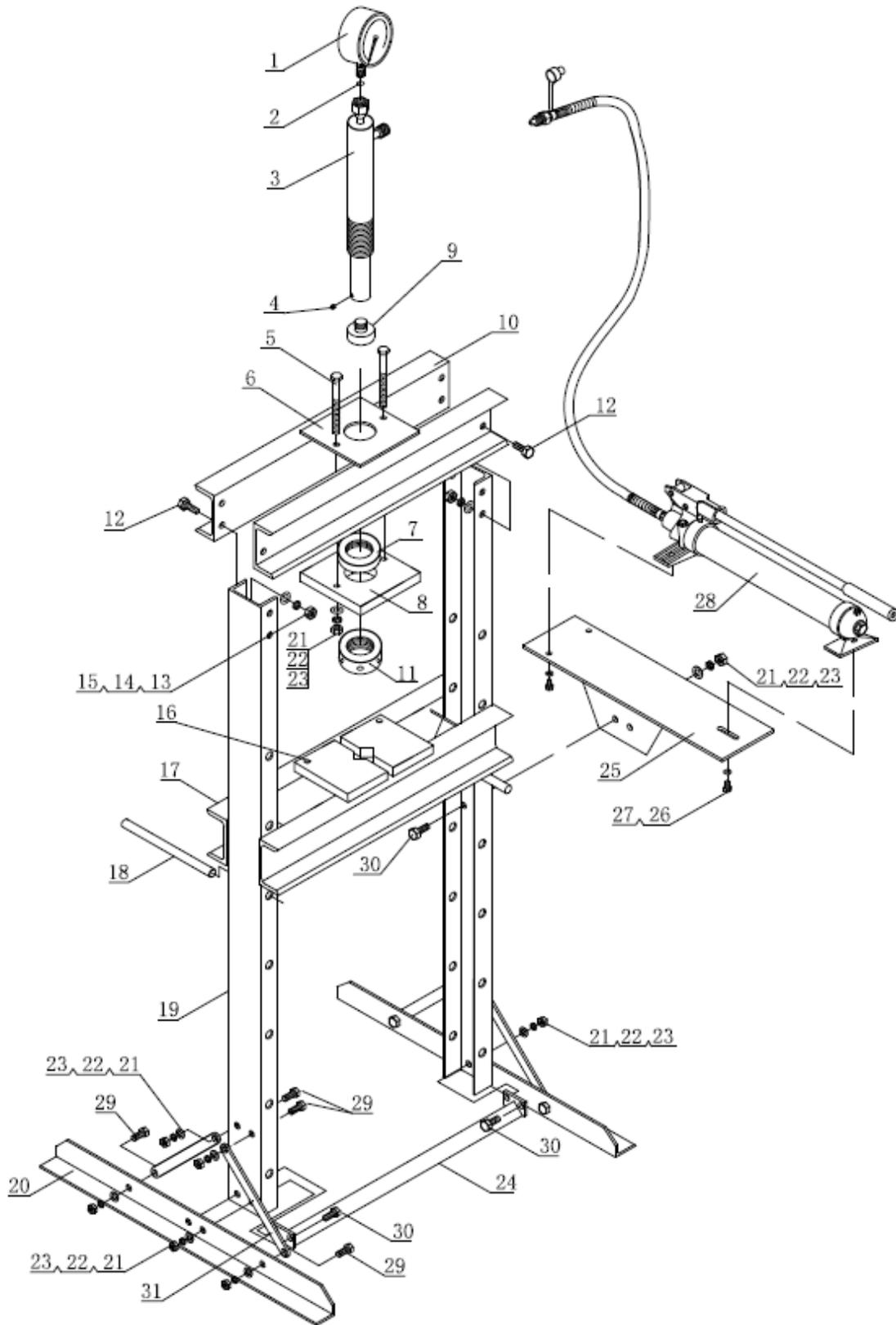
WARNING! Ensure that you read, understand and apply the safety instructions and warnings before use.

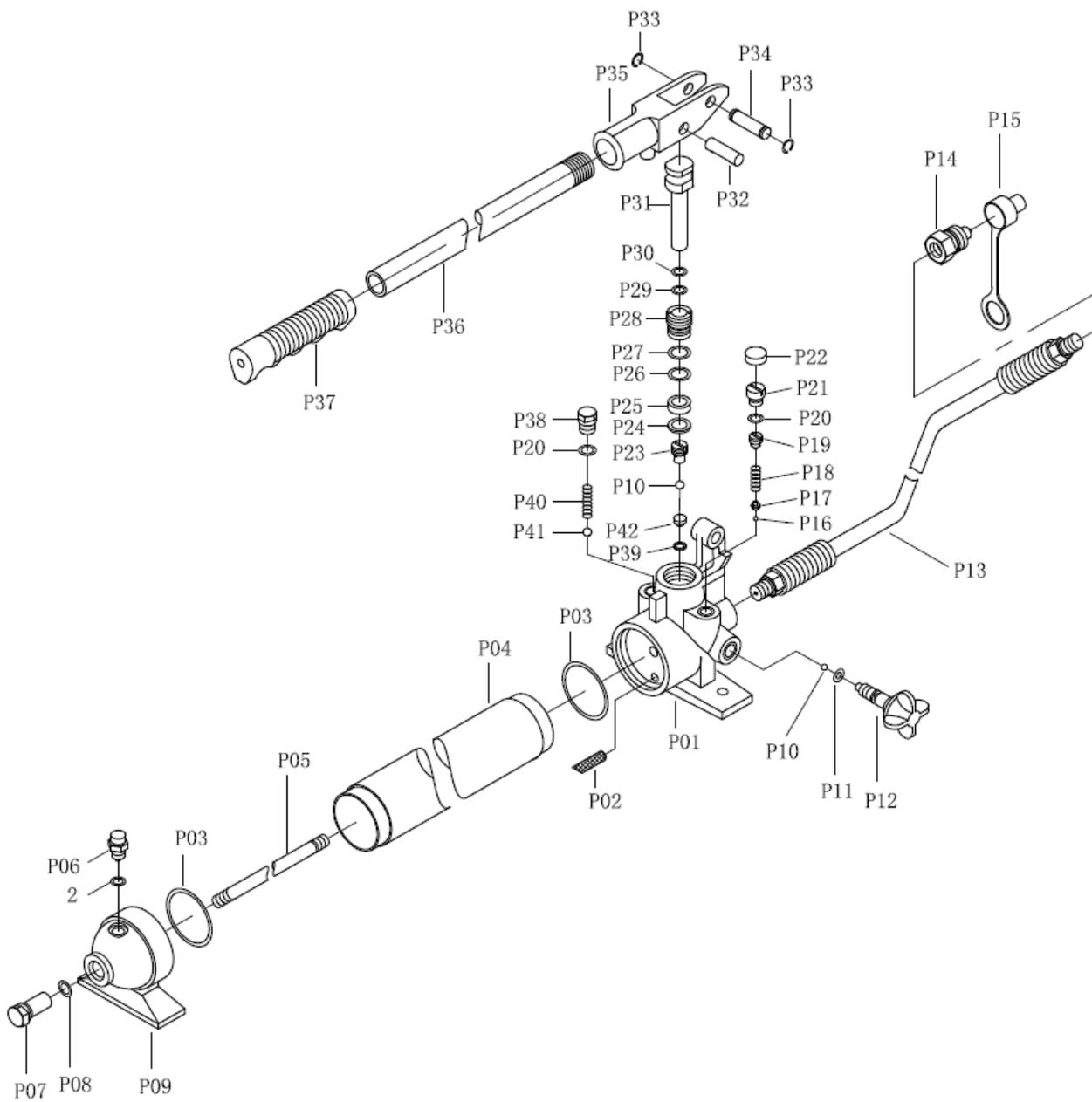
- 5.1 Place the steel block on press bed frame, then insert workpiece onto the heel block.
- 5.2 Close the release valve by turning it clockwise until it is firmly closed.
- 5.3 Pump the handle until serrated saddle nears work piece.
- 5.4 Align work piece and ram to ensure center-loading.
- 5.5 Pump the handle to apply load onto work piece.
- 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.

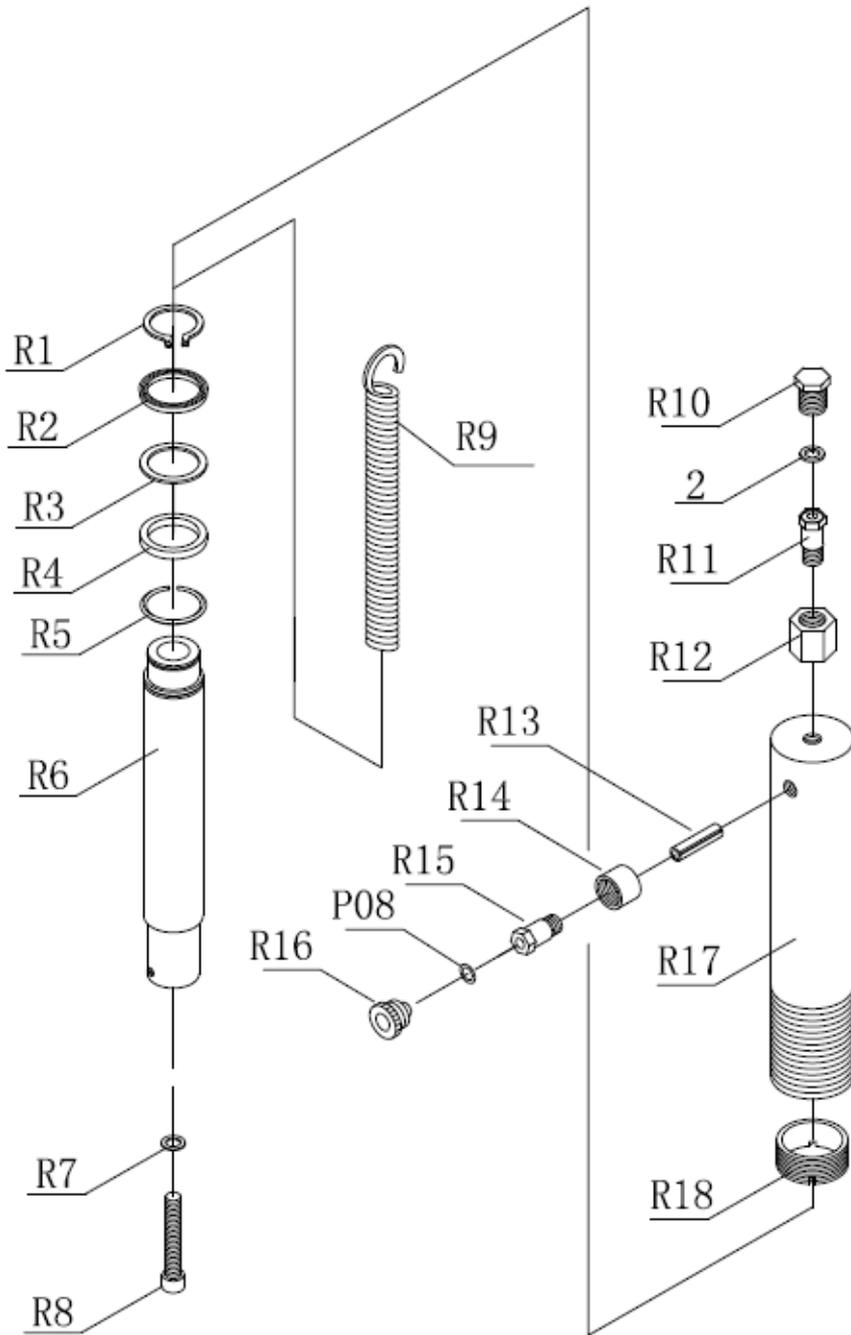
6. MAINTENANCE

- 6.1 Clean the outside of the press with dry, clean and soft cloth and periodically lubricate the joints and all moving parts with 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 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.

7. EXPLODED DRAWING AND PARTS LIST







Part No.	Description	Qty.	Part No.	Description	Qty.
1	Pressure Gauge	1	17	Workign Table	1
2	Nylon Washer	1	18	Pin	2
3	Ram	1	19	Upright	2
4	Screw	1	20	Base	2
5	Bolt	2	21	Washer	16
6	Ram Plate	1	22	Lock Washer	16
7	Upper Round Nut	1	23	Bolt	16
8	Ram Plate	1	24	Base Connector	1
9	Saddle	1	25	Base for Pump	1
10	Beam	2	26	Washer	3
11	Round Nut	1	27	Bolt	3
12	Bolt	8	28	Pump	1
13	Washer	8	29	Bolt	8
14	Lock Washer	8	30	Bolt	6
15	Nut	8	31	Support Bar	4
16	Steel Block	2			

Part No.	Description	Qty.	Part No.	Description	Qty.
P01	Pump Body	1	P23	Valve Cover	1
P02	Filter	1	P24	Nylon Washer	1
P03	O Ring	2	P25	U Ring	1
P04	Oil Tank	1	P26	O Ring	1
P05	Bar	1	P27	Nylon Washer	1
P06	Screw	1	P28	Base For Pump Core	1
P07	Screw	1	P29	O Ring	1
P08	O Ring	1	P30	Nylon Washer	1
P09	End Base	1	P31	Pump Core	1
P10	Steel Ball	2	P32	Pin	1
P11	O Ring	1	P33	Retainer Ring	2
P12	Release Valve	1	P34	Pin	1
P13	Oil Hose	1	P35	Handle Base	1
P14	Hose Connector	1	P36	Handle	1
P15	Dust Cap	1	P37	Handle Grip	1
P16	Steel Ball	1	P38	Screw	1
P17	Base for Steel Ball	1	P39	Nylon Washer	1
P18	Spring	1	P40	Spring	1
P19	Screw	1	P41	Steel Ball	1
P20	O Ring	2	P42	Base For Valve	1
P21	Screw	1	2	Nylon Washer	1
P22	Cap	1			

Part No.	Description	Qty.	Part No.	Description	Qty.
R01	Ring	1	R11	Sceew	1
R02	U Ring	1	R12	Nut	1
R03	PTFE Washer	1	R13	Pin	1
R04	Washer	1	R14	Nut	1
R05	Ring	1	R15	Ram Connector	1
R06	Piston Rod	1	R16	Dust Cap	1
R07	Copper Ring	1	R17	Ram	1
R08	Sceew	1	R18	Ring	1
R09	Spring	1	P08	O Ring	1
R10	Cap	1	2	Nylon Washer	1