

50T Electric Shop Press






Operation Manual

Important Information

1.1 Safety Information

1.1.1 Hazard Symbols Used in the Manuals

This manual includes the hazard symbols defined below when the operations or maintenance job involves a potential danger. These symbols describe the level of danger involved in performing a job on the tool and the precautions to take to avoid the hazard.

Term	Sign	Description
Danger Label		Danger Labels indicate an imminently hazardous situation that if not avoided, WILL result in death or serious injury.
Warning Label		Warning Labels indicate a potentially hazardous situation, which if not avoided, COULD result in death or serious injury.
Caution Label		Caution Labels indicate a potentially hazardous situation, which if not avoided, MAY result in minor or moderate injury.
Note	NOTE:	Short piece of additional information with the purpose of adding or emphasizing important points in the text.

1.1.2 Safety Requirements

Important

Make sure to read, understand, and strictly follow all safety related instructions before operation or maintenance of this equipment.

Intended Users

This manual is to be made available to all persons who are required to install, configure or service equipment described herein, or any other associated operation.

Application Area

The machinery described is intended for machinery production and assembling spare parts. It is used to press, size, assemble, rivet small parts in process and not for other use.

Personnel

Installation, operation and maintenance of the equipment should be carried out by qualified personnel. A qualified person is someone who is technically competent and familiar with all safety information and established safety practices with the installation process, operation and maintenance of this equipment; and with all the hazards involved.

1.1.3 Hazards



Personnel safety must have top priority. Thoroughly read the operation manuals to completely understand proper procedures before maintenance or inspection work.

Basic Safety Instructions



Failure to comply with the following could result in serious injury or death.

1. Periodic inspections or maintenance work must be carried out by two or more persons.
2. Read and understand the safety manual.
3. Read and understand all the attached manuals.
4. Attach visible signs on the equipment so that anyone recognizes and understands that maintenance or inspection is on going.
5. Post a list with emergency phone numbers nearby the working area.
6. Should be aware of what to do in case of an emergency (refer to the Procedures for Emergency Situations); know the location of the first-aid-kit, and the location of the fire extinguisher. Also learn how to use a fire extinguisher.
7. Alert anyone around the Tool whenever planning to operate it during maintenance or inspection work.
8. Always use proper hand tools and jigs during maintenance or inspections. Before operating the machine, check for any hand tools or jigs left inside it. For your own safety, **NEVER** try to remove them with the machine under operation. Consider **SAFETY FIRST**.
9. Please make sure that the operator must wear protective cloth, gloves, safety helmet, and shoes during operating.
10. To prevent back injury, heavy parts (or units), must be moved by two persons or more.
11. Before powering the machine, alert the persons around it.
12. Be careful not to be pinched by motion parts.
13. Use **ONLY CARRIER** specified for the tool, and set it in a correct position.
14. To avoid accidents, always be aware of any on-going work on the machine. Also, always stay focused on the job to be done.

1.1.4 Safety Instruction



1. Before maintenance pressured parts in the machine, you **MUST** release the pressure in the pressured system. At the same time, **DO NOT** stand in the direction facing the charger, the operator should on the opposite side and remember **DO NOT** strike, press or transfer until it is discharged.
2. When it is necessary to exchange die after running, operators should wear glove or use tools to operate avoid being hurt.

NOTE: Immediately stop operating the equipment if not working properly. Contact a certified technical support engineers for repair. The equipment must not be operated without approval from the certified technical support engineer.



Be careful when you are near the caution signs.

Safety for material used in the machine

The MSDS (Material Safety Data Sheet) information document of lubricant oils offered by supplier should be placed at the convenient place.

1.1.5 Prohibited Dangerous Actions



This section describes examples of dangerous actions not only during equipment operation, but also during maintenance and inspections. To avoid accidents, thoroughly read and understand the instructions below regarding dangers related to each mechanism prior to any maintenance or inspection work.

1.1.6 Environmental Pollution






If the substances you use come under the ordinances concerning environmental pollution, follow the ordinances to discharge and dispose of such substances. If you commission industrial waste companies, you should confirm the way of final processing.










Check for the security of people working around the Tool, before powering it back.

1.2 Warning Label

Below drawing show warning labels attached on the machine.

1		Hand crush force from above
2		Read operator's manual
3		Consult technical manual for proper service procedures
4		Must wear protective clothes
5		Must wear protective gloves

6		Must wear safety helmet
7		Must wear protective shoes
9		Caution, stumbling
10	<div style="border: 1px solid black; padding: 5px;">  WARNING <ul style="list-style-type: none"> • Wear ANSI approved impact safety goggles, full-face impact safety shield and heavy-duty work gloves when operating the press. • 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. • Check to ensure that all applicable bolts and nuts are firmly tightened. • Ensure that workpiece is center-loaded and secure. • Keep hands and feet away from bed area when applying load to the workpiece. • DO NOT use the shop press to compress spring or any other item that could disengage and cause a potential hazard. • DO NOT make any modifications to the press. • Keep children and unauthorized persons away from the work area. • Failure to heed these instructions may result in property damage and/or serious personal injury. </div>	Warning
11		Electrical power, danger!
12		High Temperature
13		No touching

2 Compliance with standards

European Community Directive	Manufacturer's Assurance	Harmonized Standards
2006/42/EC Machinery Directive		EN60204-1:2006 Electrical Equipment of Industrial machines

3 Specification

3.1 Application Area

The machinery described is intended for machinery production and assembling spare parts. It is used to press, size, assemble, rivet small parts in process and not for other use.

3.2Dimension & Weight

Main body dimension: 988x315x2020 (mm)

Weight: 360kgs

3.3Environmental conditions

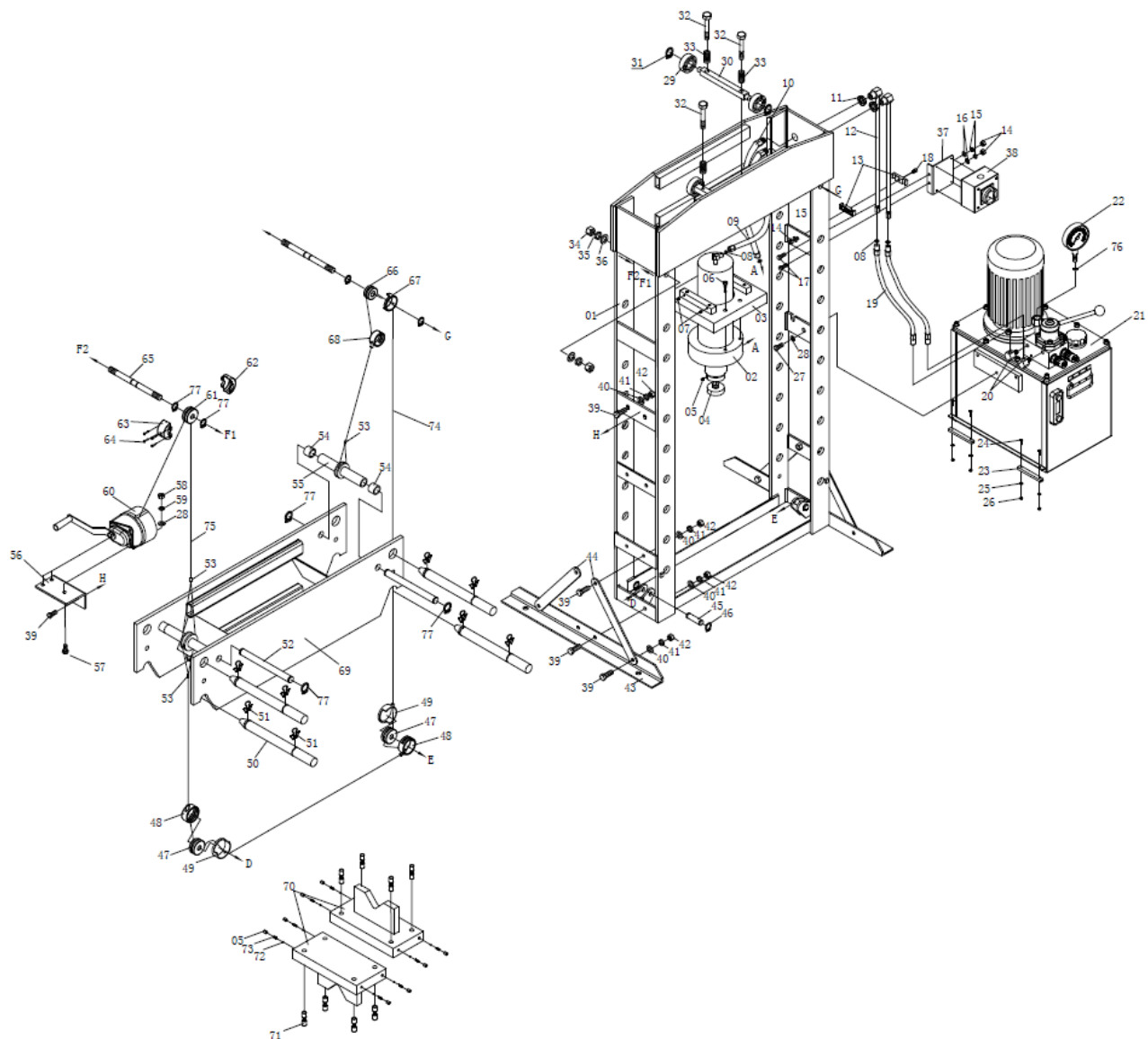
Operating Temperature	-5℃ to +40℃
Storage Temperature	-25℃ to +55℃
Shipping Temperature	-25℃ to +70℃(not exceeding 24 hours)
Altitude	Equipment should be installed at an altitude of maximum 1000m.
Humidity	Maximum 85% relative humidity at 40℃ non-condensing.
Atmosphere	Non-flammable, corrosive and dust free.
Ambient light	>300LUX
Noise	—

3.4 Technical Capacity

3.4.1 Mechanical part

No.	Item		Unit	Value
1	Capacity		Ton	50
2	Stroke		mm	200
3	Voltage		V	380
4	Output		KW	1.5
5	Working Range		mm	0~1018
6	Bed Size		Width	730mm
7	speed		mm/s	—
8	Height above floor		mm	2020
9	Covered area	Width	mm	988
		Length	mm	315
10	Gross weight		Kg	360

3.5 Mechanical construction



4. Motor Instruction For Operation

4.1 Power Supply

Voltage: 380V AC

Frequency: 50HZ

Input power: 3--3.5KVA

output power: In 5A

Ambient temperature: $\leq 40^{\circ}\text{C}$

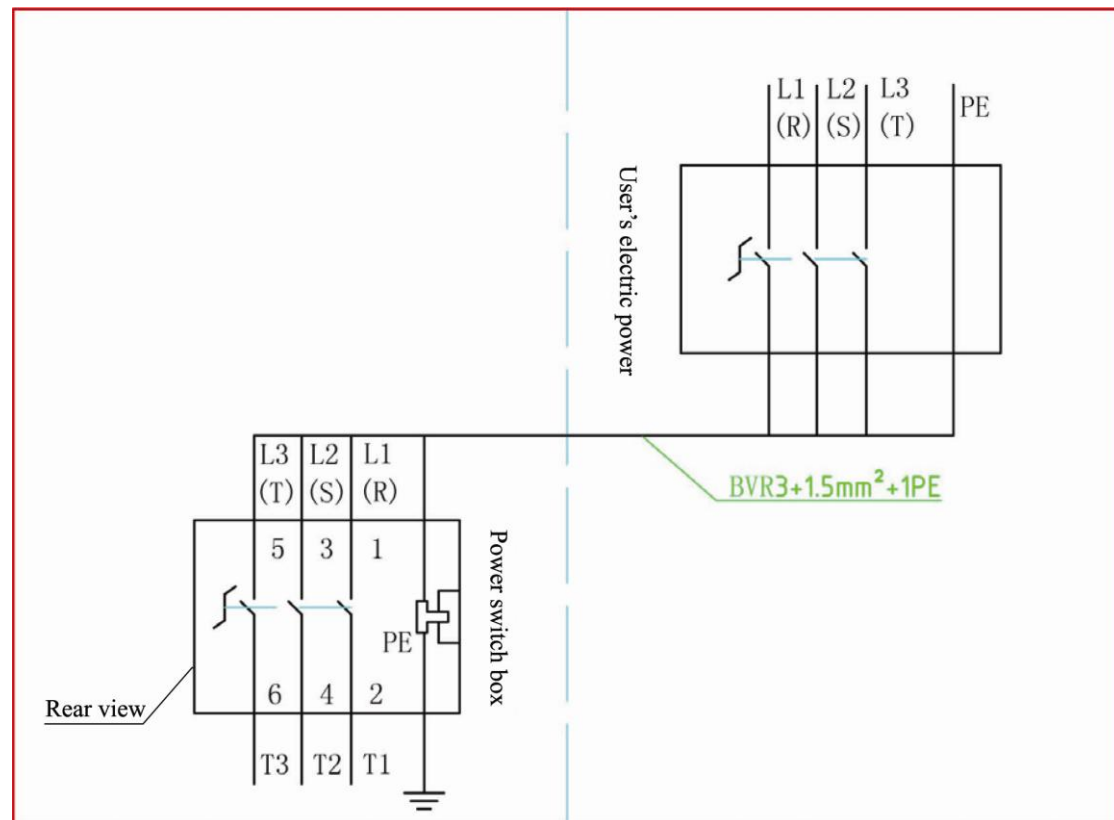
Height above sea level: $\leq 1000\text{M}$

4.2 Mounting and Operating

(1) Connect the end user's power source to the shop press' switch by cable according to sketch map as follows, and please make sure that the cable must be $\text{BVR } 3 \times 1.5\text{mm}^2 + 1\text{PE}$.

(2) Special Notice:

For the sake of your society, please be sure to fasten the earth wire onto PE terminal box.



(2) Debugging:

Power switch can be placed in "ON" position when the power cord is connected. Then, you can judge the wiring in the light of blade rotation direction. When the motor blade turn clockwise, which shows wiring is right. But if the motor blade turn counter-clockwise, you can solve this by exchanging any two from L1,L2,L3.

4.3 Attention: All work must be done under the premise of power-off. Otherwise your personal security will be likely to be a serious threat.

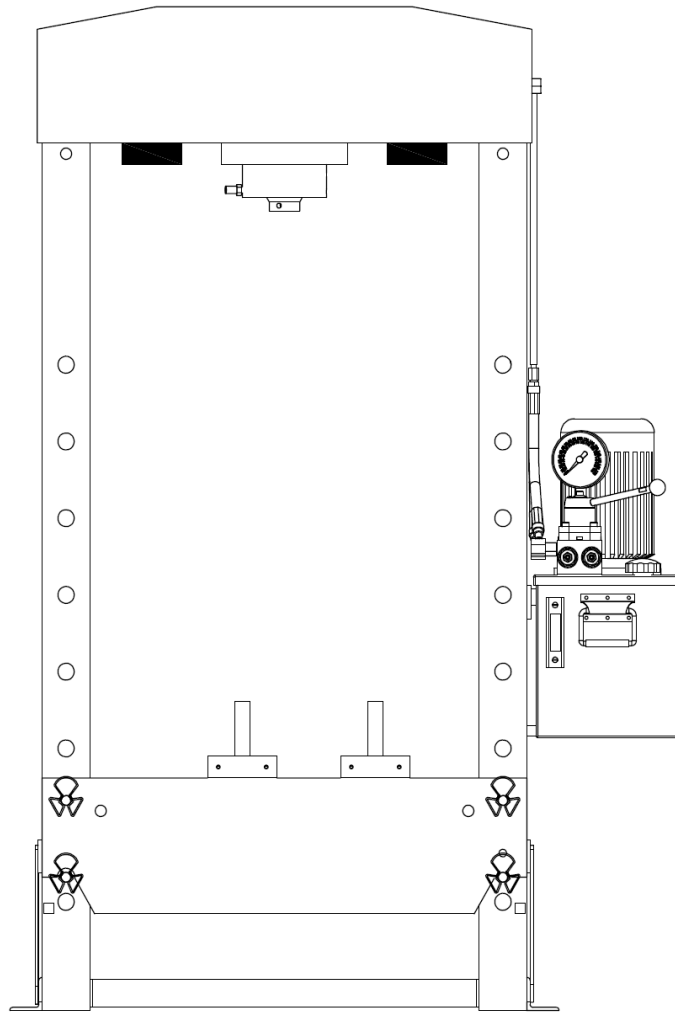
5.Prepare before using

5.1 Transport



The units are generally too heavy to be moved by hand. Therefore, use the correct transport and lifting equipment. The weights and dimensions of this machine (unit) are shown on the label in clause 3.

During moving the machine, please make sure to use the proper lifting equipment and follow the instructions as follows.



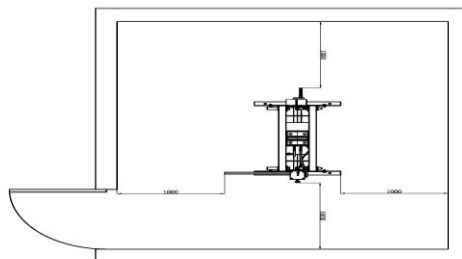
Hydraulic part

5.2 Working Area Conditions

Users should provide enough space for the equipment and the environment should be clean, non-flammable, corrosive and dust free.



A working area of 1,000mm is to be kept free both in front of and behind the machine while it is in operation so that it is always easily accessible.



5.3 Unpacking & Check

CAUTION

When open the packing, please make sure to use the proper tools, wear protective cloth, gloves, safety helmet

Make sure that the product and parts in box should be complete and identical with the part list. If not, please contact with the manufacturer in time.

5.4 Disposal of the packaging

The packaging of these machines consists of PVC film and carton box. The proper disposal of the packaging is the responsibility of the customer.

5.5 Installation

CAUTION

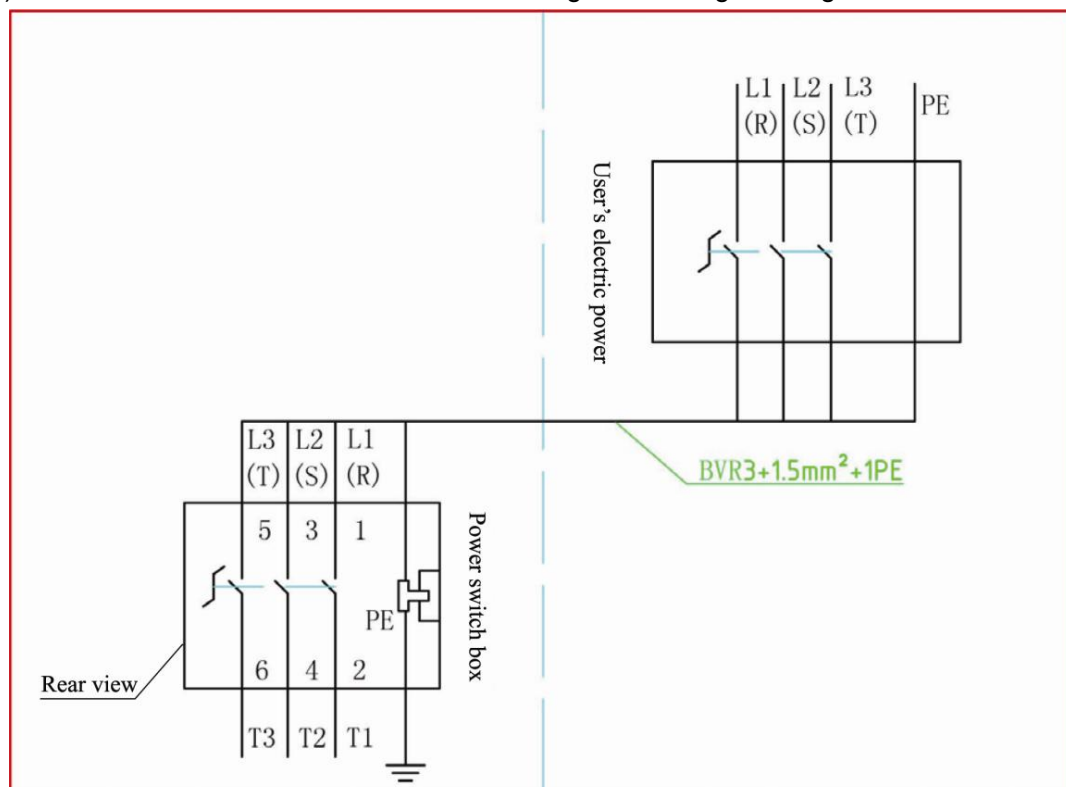
The machine must only be installed and commissioned by qualified personnel!

All relevant safety regulations must be strictly adhered to!

➤ Electrical wire connection

Notice:

- 1) The voltage must be 380V, and three-phase alternating current
- 2) The section area of electrical wire should be no less than 2 square mm
- 3) The electrical wire connection should meet EN60204-1 standard
- 4) Before connect the electrical wire, please read the operating manual carefully
- 5) The electrical wire must be connected by certified technical people
- 6) Please connect the electrical wire according to following drawings



Electrical Pump Assembling Put the electrical pump on the plate of the body frame of shop press (please refer to bellowing drawing)

- 1) Take off the filling plug and connect the oil hose to the electrical pump as following drawing:
- 2) Assemble the wire box to the shop press' frame by bolt
- 3) Connect the wire to the electrical power

Before the first use, please fix the machine to the floor by anchor bole. It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

5.6 Commissioning the machine



Before the commissioning

- Clean the machine thoroughly
- Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.
- Open the breath valve on the oil tank and operate the machine for one minute to exhausting the air in the system, then close the breath valve.

6 Operation

- Place the heel block on press bed frame, then insert workpiece onto the heel block.
- Turn on the switch
- Turn the operation lever to “A” position, the piston rod will come down quickly.
- Align workpiece and ram to ensure center-loading.

When work is done, stop pumping the handle, slowly and carefully remove load from workpiece by turning the lever to “B” position, the piston rod will go back quickly.

- Once ram has fully retracted, remove workpiece from bed frame.

7.Maintenance

Maintenance should be acted before daily working everyday.

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.

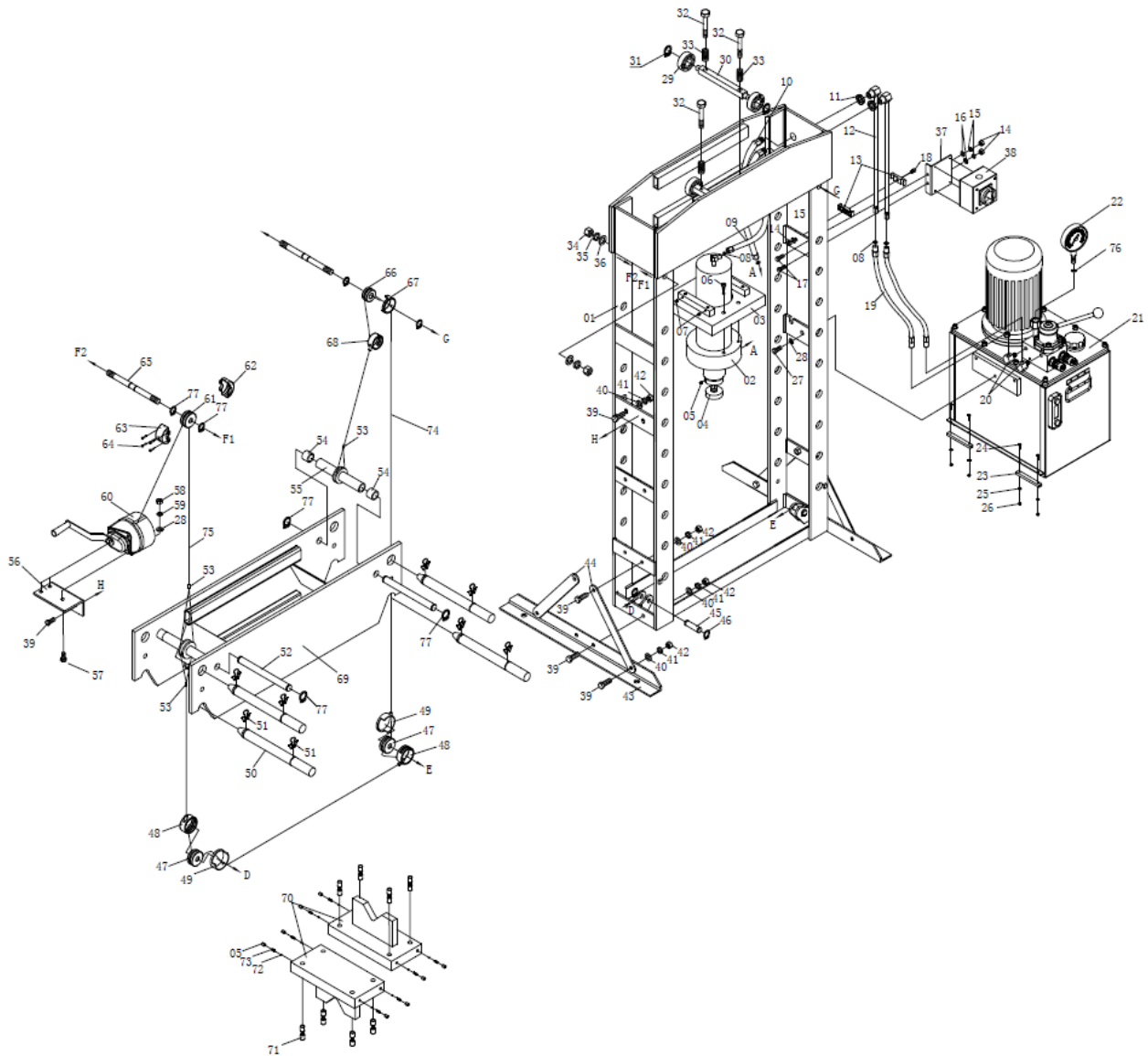
When not in use, store the press in a dry location with ram and piston fully retracted.

Check the hydraulic oil: remove the oil filler nut on the top of the reservoir, if the oil is not adequate, fill with 22#(ISO6743) hydraulic jack oil as necessary, then replace the oil filler nut, purge away air from the hydraulic system as described in 4.2.

The equipment must not be repaired or changed spare parts by whom without approval from the certified technical support engineer.

Annex A

Overall drawing of machine

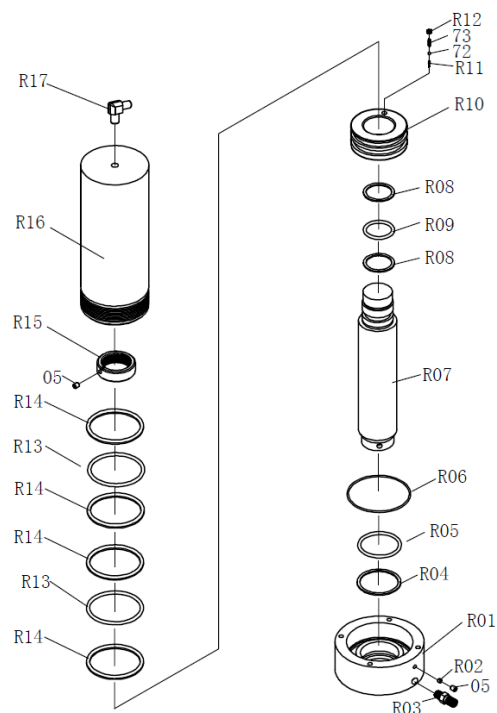


No.	Description	Qty.	No.	Description	Qty.
1	Frame	1	40	Washer	14
2	Ram Assy.	1	41	Lock Washer	14
3	Under Plate	1	42	Nut M12	14
4	Serrated Saddle	1	43	Foot Base	2
5	Screw M8*10	9	44	Support	4
6	Screw	4	45	Roller Pin	2
7	Screw M8*10	4	46	Circlip	4
8	O-ring	4	47	Roller	2
9	Oil Hose 1	1	48	Roller Cover1	2
10	Oil Hose 2	1	49	Roller Cover2	2
11	Bolt M24*1.5	2	50	Pin	4
12	Seamless tube	2	51	Circlip	8
13	Pipe clamp	2	52	Pin	2
14	Nut M8	3	53	Cable Sheath	3

15	Spring Washer	3	54	Drivepipe	4
16	Washer	2	55	Drivepipe assy.	2
17	Bolt M8*30	2	56	Fixation With Plate	1
18	Screw M8*40	1	57	Bolt M10*25	3
19	Oil Hose (short)	2	58	Nut	3
20	Connector	2	59	Lock Washer	3
21	Electric Hydraulic Pump	1	60	Hand Winch	1
22	Pressure Gauge	1	61	RollerIII	1
23	Rubber Plate	2	62	Roller Cover I	1
24	Screw M4*16	4	63	Roller Cover II	1
25	Washer	4	64	Screw	4
26	Lock nut M4	4	65	Pin	2
27	Bolt M10	3	66	Roller	1
28	Washer	6	67	Roller Cover3	1
29	Roller	4	68	Roller Cover4	1
30	Beam	2	69	Working Bed	1
31	Circlip	4	70	Heel Block	2
32	Bolt M10*120	4	71	Screw	8
33	Spring	4	72	Steel ball	8
34	Nut M20	4	73	Spring	8
35	Lock Washer	4	74	Cable(4300mm)	1
36	Washer	4	75	Cable(2450mm)	1
37	Mounting Plate	1	76	Nylon Block	1
38	Switch Box	1	77	Circlip	8
39	Bolt M12*35	14			

Annex B

RAM



No.	Description	Qty.
R01	Ring For Ram	1
R02	Nylon Block	2
R03	Connector I	1
R04	PTFE Ring2	1
R05	O-ring	1
R06	O-ring	1
R07	Piston Rod	1
R08	PTFE Ring1	2
R09	O-ring	1
R10	Piston	1
R11	Valve Core	1
R12	Screw	1
R13	O-ring	2
R14	PTFE Ring	4
R15	Nut	1
R16	Cylinder	1
R17	Elbow	1
72	Steel ball	1
73	Spring	1
05	Screw	2