

50/75 TON

AIR/MANUAL SHOP PRESS

Instruction Manual

Please read this instruction manual carefully before use.

IMPORTANT

PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFETY INSTRUCTIONS 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 50/75tons. **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. Burst hazard exists if hose or connection pressure exceeds rated pressure.
- 1.3 Shop press are designed for automotive, truck, implement, fleet, and industrial repair shops where pressing, bending, straightening, forming, holding is required. Each press includes a cylinder, a pump, a winch assembly which provides safe way to raise and lower the bed frame, and a pressure gauge which provides for monitoring the applied press force.
- 1.4 Keep children and unauthorized persons away from the work area.
- 1.5 Remove unbecoming 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 need repairing and/or there are any parts that need 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	50/75ton	Stroke	200mm (7-4/5")/250mm(9-4/5")
Ram remove range	250mm (9-4/5")/280mm(11")	Bed Width	730mm (28-7/10")/800mm(31-2/5")
Air Inlet Fitting	1/4" NPT /1/4"NPT	Air Pressure	120-200PSI/120-200PSI
Working Range	0-1053mm (0-41-2/5")/0-920mm(0-36-1/5")		

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:

50T SHOP PRESS:

- 3.1 The bed frame(23) is put in the bottom in order to convenient for package and transport, then fixed on the post (10) by two bolts M12.
- 3.2 Attach the base section (01) and support (03) to left and right tightening post (10) using bolt (02),washer (06), lock washer (05) and nut (04).
- 3.3 Move the pump assy (51) to the outside of the post, use bolt (47) and washer (48) which were dismantled just now to twist tight.
- 3.4 Move the hand winch (11) to the outside of the post, then use bolt (02),washer (06), lock washer (05) and nut (04) which were dismantled just now to twist tight and fix to the relevant roller.
- 3.5 Assemble the nylong ring(42) to gauge fitting (43), then put the pressure gauge (41) and twist tight. Remark: twist as tight as possible, otherwise it will be leak. Attach the gauge fitting to the suitable upper cross beam (34)and twist bolt(44), dismantle the plug screw of T-fitiing (46) after adjust and tight the gauge direction. attach the T-fitting (46) to the gauge fitting (43) and twist tight.

75T SHOP PRESS:

- 3.1 The bed frame(23) is put in the bottom in order to convenient for package and transport, then fixed on the post (10) by two bolts M12.
- 3.2 Attach the base section (01) and support (03) to left and right tightening post (10) using bolt (02),washer (06), lock washer (05) and nut (04).
- 3.3 Assemble the nylong ring(42) to gauge fitting (43), then put the pressure gauge (41) and twist tight. Remark: twist as tight as possible, otherwise it will be leak. Attach the gauge fitting to the suitable upper cross beam (34)and twist bolt(44).
- 3.4 Pump assemble: attach the pump assy'(57) to pump setting plate (51) by using three bolts (50) and lock washer (48) and twist tight.
Oil hose 1 assemble: dismantle the plug from oil hose 1 (58) then assemble the o-ring (45), also dismantle the plug from ram assy' (37), connect the oil hose 1 (58) to ram assy' (37) and twist tight.
Oil hose 2 assemble: attach the o-ring (45) to gauge fitting (43), then put the oil hose 2(59) into the gauge fitting (43)and twist tight, connect the PU pipe (A-A). Attach the handle (53) to the pump pin by using bolt (56) and twist tight. also the same as handle 2(54).
Remark: before assemble, open the breather valve (61) first which is on the cylinder (pull up the breather valve)
- 3.5 Move the hand winch (11) to the outside of the post, then use bolt (02),washer (06), lock washer (05) and nut (04) which were dismantled just now to twist tight and fix to the relevant roller.

4. BEFORE FIRST USE

- 4.1 Inspect before each use. Do not use if bent, broken or cracked components are noted. Check for and tighten any loose assemblies.
- 4.2 Before first use of this product, pour a teaspoon of good quality, air tool lubricant into the air valve(52),open the air valve(52) to operate for 3 seconds to evenly distribute lubricant.
- 4.3 Purge away air from the hydraulic system.
Manual operating system: open the release valve (50/55) by turning it counterclockwise. Pump several full strokes to eliminate any air in the system.
Air operating system: open the release valve (50/55) by turning it counterclockwise. Connect the quick coupler-male into the air supply hose quick coupler-female, then turn on the air valve (52) letting the pump work for several times to eliminate any air in the system.
- 4.4 Inspect all the workpiece, please stop using and connect with supplier if there parts damaged.

5. OPERATING INSTRUCTIONS

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

WARNING! Ensure that you are familiar with this shop press and sufficient know there will be injure with wrong operation.

- 5.1 Ensure bed frame at lowest position and winch cable is slack.
- 5.2 Place the heel block (24) on bed frame (23), then insert workpiece onto the heel block.
- 5.3 Close the release valve (50/55) by turning it clockwise until it is firmly closed.
- 5.4 Connect the quick air valve (52) into the junction of air source, turn on the air valve(52) to let the pump work until serrated saddle(40) nears workpiece, then turn off the air valve. When air source is unavailable, pump the handle(49/53) until serrated saddle(40) nears workpiece.
- 5.5 Align workpiece and ram to ensure center-loading.
- 5.6 Turn on air valve (or pump the handle) to apply load onto workpiece.
- 5.7 When work is done, turn off the air valve (or stop pumping handle), slowly and carefully remove load from workpiece by turning the release valve (50/55) counterclockwise in small increments. (must turn with the small angle, the biggest is two circles.)
- 5.8 Once ram has fully retracted, remove workpiece.
- 5.9 Disconnect the air inlet fitting from the air source.

CAUTION: Before disassemble, slide bed frame section down, into its lowest position.

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, keep the piston back fully and put in the dray plate.
- 6.3 When press efficiency drops open the release valve (50/55) counterclockwise(never to two circles), pump the handle(49/53, 54) several time to purge away air from hydraulic system as described in section.
- 6.4 Check the hydraulic oil: remove the oil filler nut on the top of the reservoir, if the oil 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 4.2.

TROUBLESHOOTING

A system failure may or may not be the result of a pump malfunction. The following information is intended to be used as an aid in determining if problem exist.

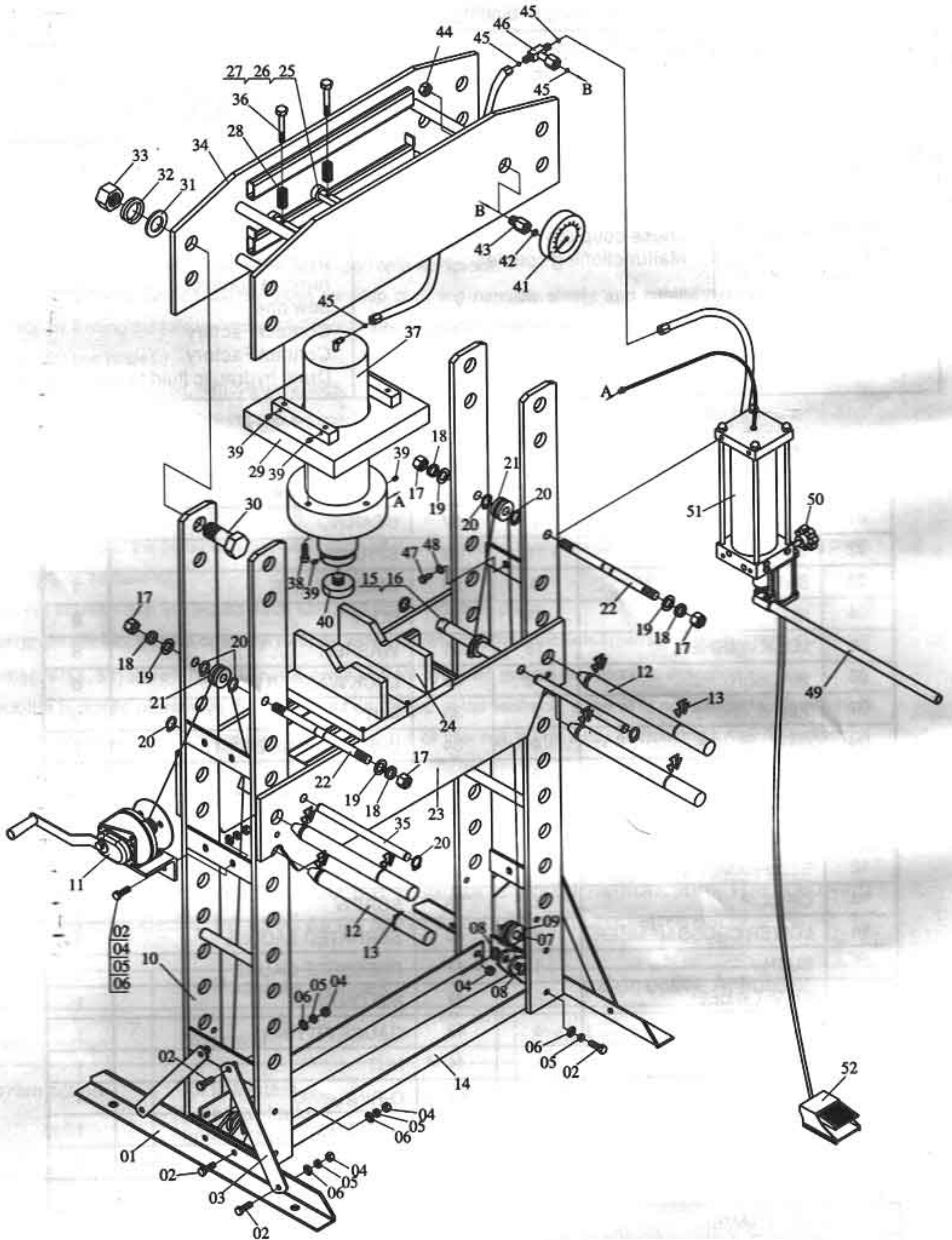
Symptom	Possible Causes	Corrective Action
Motor will not start	No power	Check the power supply
Erratic ram action	Air in system Externall leak Internal hydraulic leak	Follow pump instructions for bleeding air Tighten all connections Contact Factory
Pump or ram fails to maintain pressure	Overload condition External leak Internal hydraulic leak Ram seals leaking Pump or valve malfunctioning	Ramedy overload condition Tighten all connections Contact Factory Contact Factory Check pump operating instructions

Ram extends partially	Hydraulic oil level too low in pump Load is above the capacity of system Ram is sticking or binding	Fill and bleed the system Use the correct equipment Contact Factory
Ram moves slower than normal	Loose connection or coupler Restricted hydraulic line or fitting Pump not working correctly Ram seals leaking	Tighten connection or coupler Clean and replace if damaged Check pump operating instructions Replace cylinder
Ram leaks hydraulic fluid	Worn or damaged seals	Contact Factory
Ram will not retract or retracts slower than normal	Linkage binding Loose couplers Malfunctioning coupler Weak or broken retraction springs Ram damaged internally Pump reservoir too full	Lubricate all moving parts Tighten couplers Depressurize pump and hose, remove application, then replace a new one. Contact Factory Contact Factory Drain hydraulic fluid to correct level

PARTS LIST (50T SHOP PRESS)

NO.	DESCRIPTION	QTY	NO.	DESCRIPTION	QTY
01	BASE SECTION	2	27	BEARING	4
02	BOLT	18	28	SPRING	4
03	SUPPORT	4	29	UNDER PLATE	1
04	NUT	18	30	BOLT	8
05	LOCK WASHER	18	31	WASHER	8
06	WASHER	18	32	LOCK WASHER	8
07	PIN	2	33	NUT	8
08	CIRCLIP	4	34	UPPER CROSS BEAM	1
09	ROLLER	2	35	PIN	2
10	POST	2	36	BOLT	4
11	HAND WINCH	1	37	RAM ASSY'	1
12	BED FRAME PIN	4	38	BOLT	4
13	CIRCLIP	8	39	SCREW	6
14	LOWER CROSS MEMBER	2	40	SERRATED SADDLE	1
15	BUSH	4	41	PRESSURE GAUGE	1
16	SHAFT WHEEL	2	42	NYLON RING	1
17	NUT	4	43	GAUGE FITTING	1
18	LOCK WASHER	4	44	NUT	1
19	WASHER	4	45	O-RING	4
20	CIRCLIP	8	46	T-FITTING	1
21	ROLLER	2	47	BOLT	4
22	BOLT	2	48	WASHER	4
23	BED FRAME	1	49	HANDLE	1
24	HEEL BLOCK	2	50	RELEASE VALVE	1
25	CIRCLIP	4	51	PUMP ASSY'	1
26	CONNECTING ROD	2	52	AIR VALVE	1

EXPLODED DRAWING



PARTS LIST (75T SHOP PRESS)

NO.	DESCRIPTION	QTY	NO.	DESCRIPTION	QTY
01	BASE SECTION	2	32	LOCK WASHER	8
02	BOLT	18	33	NUT	8
03	SUPPORT	4	34	UPPER CROSS BEAM	1
04	NUT	18	35	PIN	2
05	LOCK WASHER	18	36	BOLT	4
06	WASHER	18	37	RAM ASSY'	1
07	PIN	2	38	BOLT	4
08	CIRCLIP	4	39	SCREW	6
09	ROLLER	2	40	SERRATED SADDLE	1
10	POST	2	41	PRESSURE GAUGE	1
11	HAND WINCH	1	42	NYLON RING	1
12	BED FRAME PIN	4	43	GAUGE FITTING	1
13	CIRCLIP	8	44	NUT	1
14	LOWER CROSS MEMBER	2	45	O-RING	4
15	BUSH	4	46	BOLT	2
16	SHAFT WHEEL	2	47	WASHER	5
17	NUT	4	48	LOCK WASHER	2
18	LOCK WASHER	4	49	NUT	2
19	WASHER	4	50	BOLT	3
20	CIRCLIP	8	51	PUMP SETTING PLATE	1
21	ROLLER	2	52	AIR VALVE	1
22	BOLT	2	53	HANDLE 1	1
23	BED FRAME	1	54	HANDLE 2	1
24	HEEL BLOCK	2	55	RELEASE VALVE	1
25	CIRCLIP	4	56	BOLT	2
26	CONNECTING ROD	2	57	PUMP ASSY'	1
27	BEARING	4	58	OIL HOSE 1	1
28	SPRING	4	59	OIL HOSE 2	1
29	UNDER PLATE	1	60	OIL PLUG	1
30	BOLT	8	61	BREATHER VALVE	1
31	WASHER	8			

EXPLODED DRAWING

