

# Operation Manual

**6, 12, 20 and 30 Tons Shop Press**  
51727, 51257, 51728, 51973



Illustration similar, may vary depending on model

Read and follow the operating instructions and safety information before using for the first time.

Technical changes reserved!

Due to further developments, illustrations, functioning steps and technical data can differ insignificantly.

Updating the documentation

If you have suggestions for improvement or have found any irregularities, please contact us.



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## Introduction

Thank you for purchasing this quality product. **To minimize the risk of injury we urge that our clients take some basic safety precautions when using this device. Please read the operation instructions carefully and make sure you have understood its content.** Keep these operation instructions safe.

## Safety instructions/warnings



The owner and/or user must have read and understood the operating instructions of the device before using it. Installed personnel should be cautious, competent, trained and qualified in the safe handling of the working equipment used when working with the shop press. Warnings should be read and understood.

- Be familiar with the application control, the application process and the warnings.
- Ensure that all connectors are secure.
- Make sure you know the contents of the instructions for use.
- This device is not intended to be used by persons (or even children) with reduced physical, sensorial or mental abilities or persons who do not have the appropriate experience or knowledge, unless they are observed by a person responsible for their safety or have previously been instructed to use the equipment by such person.
- Children must be supervised to ensure that they do not play with the appliance.
- Stay concentrated and do not allow any distraction during the process.
- Do not use welding equipment near the support.
- Always pay attention to the optimal lighting of the workplace.
- Be sure to wear solid footwear.
- Use a hairnet for long hair.
- Wear tight clothing.
- Take off jewellery (rings, earrings, watches, etc.).
- Be careful not to wear loose straps or belts.
- Long working in a standing position can lead to dizziness. Make regular breaks and drink enough.
- Never open the screw connections under pressure/load.
- Set the press to the lowest position when refilling hydraulic oil. Use only high quality hydraulic oil, **NEVER** use other fluids such as alcohol, glycerine, detergent, engine oil, water, contaminated oil or other inappropriate fluids.
- The hydraulic cylinder is under pressure and must not be opened by force.

## Control/inspection

- Prior to commissioning the shop press, visual inspection must be carried out to detect leaks, damage, loose or missing and worn parts.
- Check the oil level regularly. Set the press to the lowest position when refilling hydraulic oil. Remove the cap; the oil level must reach exactly to the opening. If necessary, refill with high-quality hydraulic oil. Perform a complete oil change every year.
- If it should be necessary to scrap the press, the oil should be purged and disposed of properly, the rest of the press should be recycled.



## Operation

1. Place the work piece on the bed frame.
2. Locate and close the release valve by turning it clockwise until it is tight.
3. Pump the handle until the ram nears the work piece.
4. Align the ram and the work piece to ensure a centred loading.
5. Apply the load to the work piece by pumping the handle. Do not overload the work piece.
6. Remove the load from the work piece by turning the release valve counter-clockwise. Stabilize the work piece so it does not fall while the pressure is released.
7. Remove the work piece until the ram is fully retracted.

## Warning

- Read and understand the entire instruction manual before operation.
- This press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a hydraulic press, do not use it until proper training and knowledge has been obtained.
- Do not operate this press beyond its rated capacity.
- This press is designed for pressing, bending and straightening purposes only. **DO NOT** compress springs or other objects that could be ejected from the press.
- **DO NOT** compress objects that could shatter.
- Check the press for loose or damaged parts before each operation. Replace damaged parts and tighten all loose bolts before operating.
- Some parts being pressed may have a tendency to pop out of the press or explode under pressure. Protect yourself accordingly. Keep hands away from the pressure head and out of support rod holes. Always centre the work piece on the table plates and centre the pressure head on the work piece to prevent injury by ejection of the work piece.
- Always wear safety glasses and safety equipment.

## Maintenance

- Before each use inspect press for damage. Do not use it bent, broken, cracked, leaking, or otherwise damaged in any way.
- Periodically lightly oil all moving parts including pump piston and hydraulic ram.
- Check hydraulic connections and hoses before each use. Do not use if cut, damaged, leaking, or connections and/or hoses or connection damaged otherwise are noted.

## Features

- For straightening, bending and crossing
- Multi-position bed for work height adjustment

## Technical specifications

Item number	Model	Capacity
51727	Shop press with	6 t
51257		12 t
51728		20 t
51973		30 t

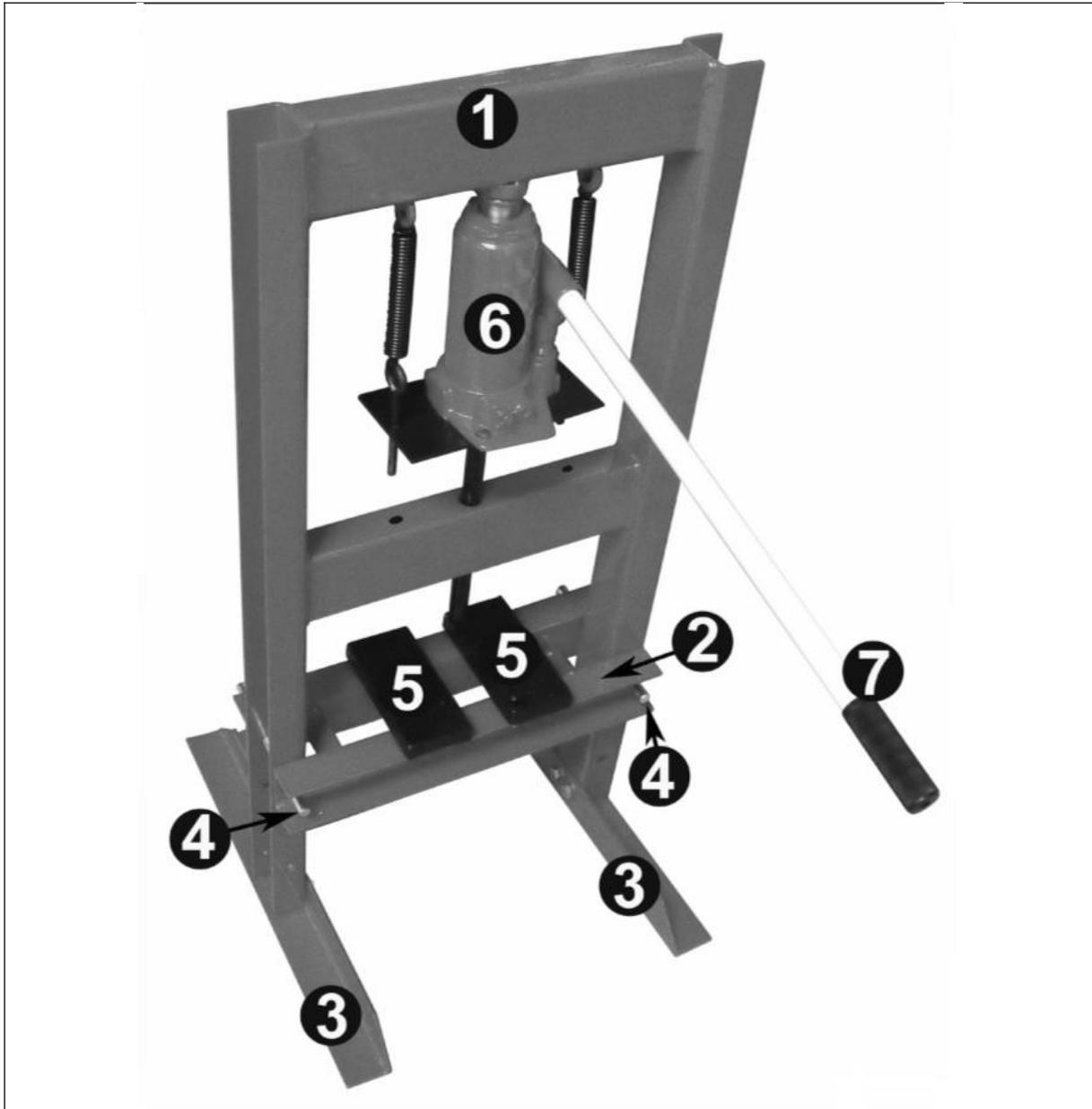


## Troubleshooting instructions

Symptom	Possible cause	Solution
Piston cannot move	Mechanical parts are corrupt	Add lubricating oil or grease
Piston cannot retract by itself or retracts slowly	1. Reservoir overfilled 2. Improper connections	1. Drain jack oil to proper level 2. Clean and lubricate moving parts
Piston does not fully lift	Jack oil level low	Add jack oil

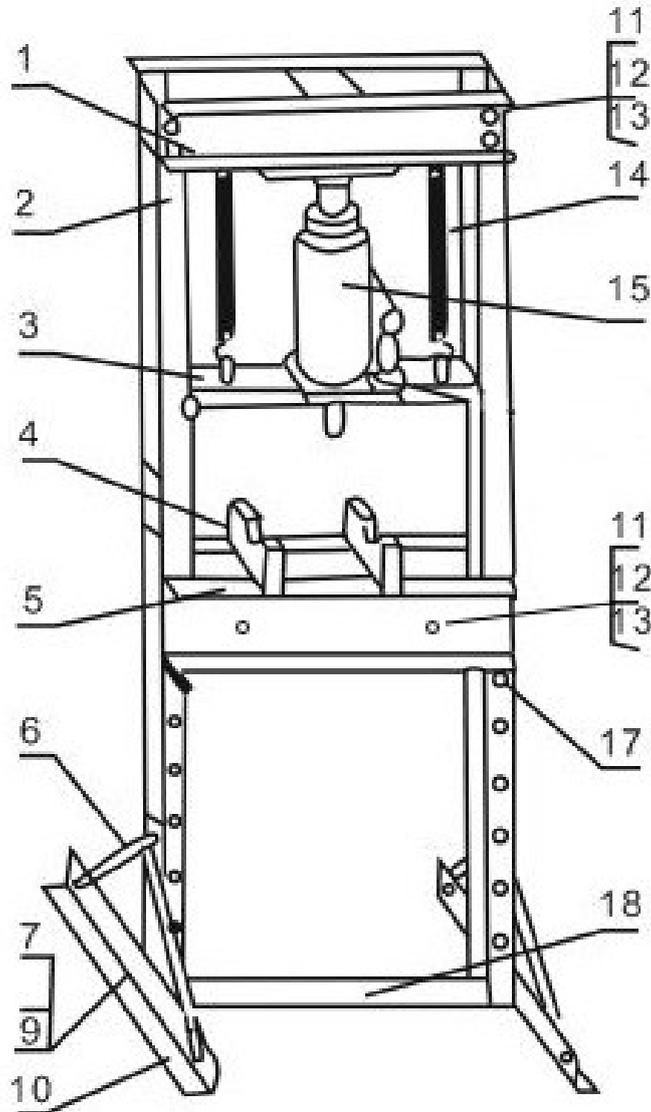
**Part lists**

**6 tons shop press**



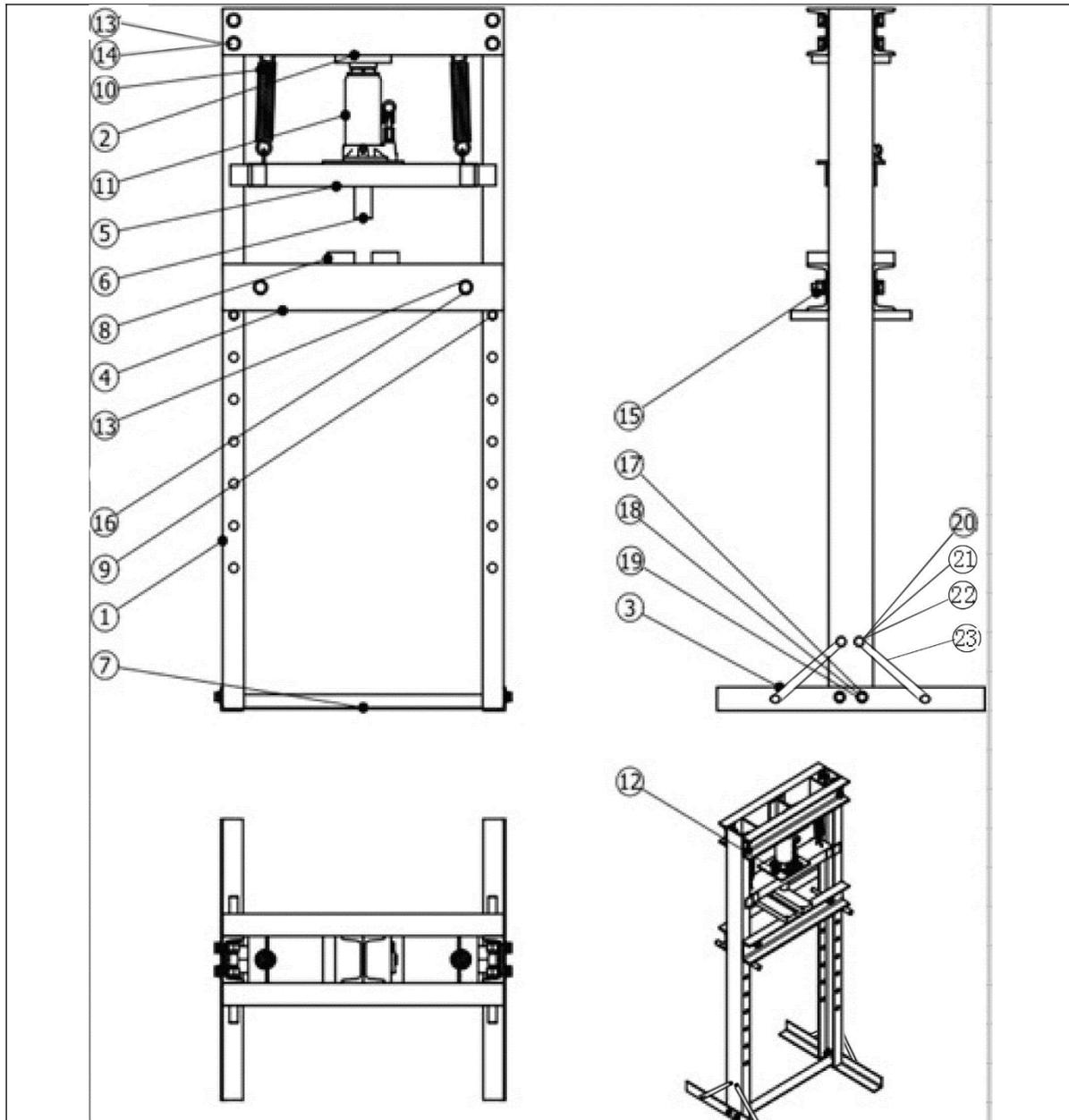
No	Name
1	Traverse
2	Fixing plate
3	Foot
4	Nut
5	Steel plate
6	Lifter
7	Lever

**12 tons shop press**



No	Name	Qty.	No	Name	Qty.
1	Cross beam	1	10	Leg	2
2	Pole	2	11	Bolt	8
3	Jack plate	1	12	Washer	8
4	Steel plate	2	13	Nut	8
5	Adjust beam	1	14	Spring	2
6	Crossbrace	4	15	Jack	1
7	Bolt	12	17	Pin	2
9	Nut	12	18	Fixing plate	1

## 20 and 30 tons shop press



#	Name	#	Name	#	Name	#	Name	
1	Post	2	9	Pin	2	17	Flat washer 12	4
2	Head support	1	10	Spring	2	18	Bolt M12×30	4
3	Leg	2	11	20 ton bottle jack	1	19	Nut M12	4
4	Press platform	2	12	Screw M8×16	2	20	Bolt M10×20	8
5	Middle piece	1	13	Flat washer 16	10	21	Nut M10	8
6	Mandrel and plate	1	14	Bolt M16×30	8	22	Flat washer 10	8
7	Connect tube	1	15	Nut M16	10	23	Brace bar	4
8	Pad plate	2	16	Bolt M16×150	2			

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