

30T Hydraulic Shop Press

Operation Manual






1. 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.

1.1.7 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
		Must wear protective gloves

6		Must wear safety helmet
7		Must wear protective shoes
9		Caution, stumbling
10	 <p>WARNING</p> <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. 	Warning

2.3 Compliance with standards

European Community Directive /欧盟指令	Manufacturer's Assurance /制造商担保	Harmonized Standards /符合标准
Machinery Directive 98/37/EC	Declaration of Incorporation	Annex I of Machinery Directive 98/37/EC

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.

3.2 Environmental conditions

Operating Temperature	-5°C to +40°C
Storage Temperature	-25°C to +55°C
Shipping Temperature	-25°C to +70°C(not exceeding 24 hours)
Altitude	Equipment should be installed at an altitude of maximum 1000m.

Humidity	Maximum 85% relative humidity at 40°C 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	30
2	Stroke	mm	150
3	Working Range	mm	0~820

4. Prepare before using

4.1 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.

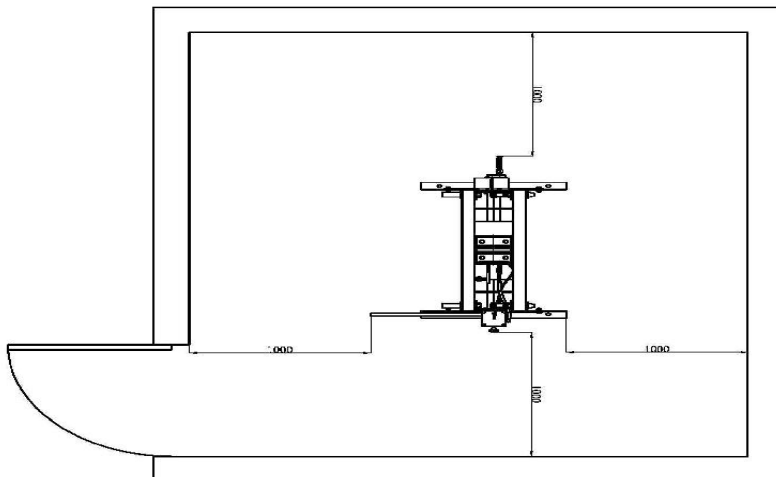
Hydraulic part

4.2 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.



4.3 Unpacking & Check



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.

4.4 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.

4.5 Installation



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

All relevant safety regulations must be strictly adhered to!

It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

4.6 Commissioning the machine



Before the commissioning

Clean the machine thoroughly

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.

Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.

5 Operation

Place the heel block on press bed frame, then insert workpiece onto the heel block.

Close the release valve by turning it clockwise until it is firmly closed.

Pump the handle until serrated saddle nears workpiece.

Align workpiece and ram to ensure center-loading.

Pump the handle to apply load onto workpiece.

When work is done, stop pumping the handle, slowly and carefully remove load from workpiece by turning the release valve counterclockwise in small increments.

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

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6.Trouble shooting

No.	Fault	Cause	Remedy
1	The pump is working, while the ram can't work	<ol style="list-style-type: none"> 1. the oil pipe loosed 2. the ram is leaking 	<ol style="list-style-type: none"> 1. checkingtheconnecting situation of oil pipes 2. replace the oil seals
2	When open release valve, the ram can't reset	<ol style="list-style-type: none"> 1. the oil pipe loosed 2. no enough space in pump/ 3. the ram become invalid/ 	<ol style="list-style-type: none"> 1. checking the connecting situation of oil pipes 2. open the exhaust valve 3. replace the ram
3	manual normal, while ram can't work	<ol style="list-style-type: none"> 1. release valve not complete closed 2. air in system 	<ol style="list-style-type: none"> 1. check the release valve 2. purge away the air according to manual
4	the ram can't fully work/	<ol style="list-style-type: none"> 1. the oil is not enough 	<ol style="list-style-type: none"> 1. Add oil
5	Oil leaking	<ol style="list-style-type: none"> 1. seal kits broken/密封件损坏 2. screw parts loosed 	<ol style="list-style-type: none"> 1. replace the seal kits 2. Tighten the screw parts

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.

When press efficiency drops, purge away air from hydraulic system as described in section 4.2.

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.