

# How Do I Prime My Press Pump?

(For Sunex, Ramco, Carolina, Red Arrow and Arcan)

## 40/50 TON PUMP WILL NOT WORK OUT OF THE BOX?

There are 4 reasons the pump will not operate after the initial application:

1. The drain cock on the top of the pump is not open
2. The release valve on the front of the pump is open.
3. The check valve is stuck.
4. Air has been purged into one of the pockets of the pump body. Nine out of ten chances, it's an air pocket.

First make sure the drain cock is fully opened (screwed all the way into the pump), this valve should always remain open when operating the press and make sure the valve is closed (screwed in clockwise until tight).

## RAM WILL NOT HOLD PRESSURE? PUMP WILL NOT HOLD PRESSURE? PUMP IS LEAKING AIR?

(These are all the same question)

Troubleshoot: While following the instructions on bleeding the pump (found in manual), if the ram comes down to the press bed and immediately comes up after removing the air line, then the 5/16 ball bearing out of the release valve chamber. There will be a puddle of oil on the ground and they may find the ball bearing somewhere. Available in seal kit/ or 5/16 steel ball bearing at local hardware store.

## TO BLEED MANUAL PRESS

1. Turn valve handle on front of pump assembly clockwise until the valve is closed. DO NOT OVERTIGHTEN.
2. Turn petcock valve on top of pump assembly counter clockwise to open and make sure both cradles are in the down position.
3. Use an adapter on your air hose and allow air to flow through the opening in the petcock valve into the pump. As air flows into the pump, both cradles should move into the up position and the ram should extend down toward the press bed. DO NOT ALLOW THE RAM TO EXTEND OVER 5".
4. If the cradles move up and the ram moves down, proceed to step 6. If not, check the petcock valve to ensure it is open and repeat step 3.
5. Place press bed in HIGHEST POSITION and LOCK into place using provided press pins. Place 2 press plates, centered directly under the ram.
6. Insert the pump handle into the low pressure cradle (the larger of the pump pistons) and pump ram against the press plates until the pressure gauge reads 5 tons.
7. Insert the pump handle into the high pressure cradle (the smaller of the two pump pistons) and pump until the pressure gauge indicates 10 tons.
8. Turn valve handle on front of pump assembly counter clockwise a maximum of 1+1/2 turns to open valve. Ram will retract as pressure is released.
9. Pump should now operate normally. Repeat procedure as needed.