ASSEMBLY INSTRUCTIONS
12 TON AND 20 TON SHOP PRESS

TO ASSEMBLE SIDE RAILS
PLACE UPPER CHANNELS
AND BED ON FLOOR. RAILS
MAY HAVE TO BE TAPPED
BETWEEN CHANNELS.

TAP TOGETHER TO
ENGAGE DIMPLES.

TO INSTALL JACK
SPRING PULLDOWN
EYE BOLT

LOosen and re-tighten upper and
lower bolts to correct frame tilt
and wobble.

3/8" X 1-1/4" BOLT

7/16" FLAT WASHER
(ONE ON EACH SIDE
OF SPRING)

5/8" LOCKNUT

3/8" LOCKNUT

5/8" X 4" BOLT
(12 TON PRESS)
5/8" X 5" BOLT
(20 TON PRESS)

3/8" X 1-3/4" BOLT

3/8" LOCKNUT

3/8" X 2-3/4" BOLT
(12 TON PRESS)
3/8" X 3-3/4" BOLT
(20 TON PRESS)

3/8" LOCKNUTS

AIR RATCHET SPEEDS
ASSEMBLY OF LOCKNUTS

3/8" X 1" BOLT

3/8" X 1" BOLT
OPERATION
Before operating the press, it may be necessary to purge air from the jack hydraulic circuits. Purging is required if the jack's ram fails to extend when pumped or it appears to require excessive number of pump strokes because of air trapped in the jack's hydraulic cylinder. See instructions on "Purging Air" under "Troubleshooting".

Support the press bed and move the bed/pins to the highest position that will allow you to position your part on the press bed. This will lessen the number of pump strokes needed to contact the part. The pins must be fully inserted to distribute the load equally. Make sure the arbor plates are stable and safety shields are in place.

INSPECTION
Visually inspect for damaged, loose, or missing parts. If press is worn or damaged, remove from service. Contact an authorized service center for damage assessment or repairs.

TROUBLESHOOTING
PURGING AIR:
With the ram fully retracted, open (1-2 turns) the filler/vent screw on the side of the oil reservoir and close (clockwise) the release valve in the base of the jack. Pump the jack to maximum extension. Continue to pump the jack (slowly) for several more strokes. Open the release valve to fully retract the ram. The jack should now be ready for normal operation. Repeat if necessary.

RAM DOESN'T EXTEND FULLY:
Check jack oil level. Level should be slightly below the filler hole. Add clean jack oil if needed.

WILL NOT HOLD LOAD:
A. Release valve leaking. Tighten valve.
B. Oil not clean/hydraulic circuit dirty. Try rapid pumping and/or fast retraction of ram to flush oil thru hydraulic circuits. If this doesn't correct problem, drain, flush, and replace oil. Use clean jack oil.

MAINTENANCE
Periodically check all the press frame and base bolts to make sure they are tight. Apply light jack oil to the ram if it appears dry and retraction is not smooth. If this does not correct the problem, internal ram seals may have to be replaced.

SERVICE
If troubleshooting procedures do not correct problem, contact your nearest authorized service center for repairs and/or replacement parts.