**MODELS:** W93611, W93612, 91-611, 91-612, B67622, B67624

**12 AND 20 TON SHOP PRESS**

<table>
<thead>
<tr>
<th>PRODUCT LABEL</th>
<th>MODEL (12 TON)</th>
<th>PRODUCT LABEL</th>
<th>MODEL (20 TON)</th>
</tr>
</thead>
<tbody>
<tr>
<td>420642</td>
<td>W93611</td>
<td>420645</td>
<td>W93612</td>
</tr>
<tr>
<td>420640</td>
<td>91-611</td>
<td>420643</td>
<td>91-612</td>
</tr>
<tr>
<td>420641</td>
<td>B67622</td>
<td>420644</td>
<td>B67624</td>
</tr>
</tbody>
</table>

(1 PAIR) 248812 SPRING KIT (12 & 20 TON PRESS)

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

7/16" FLAT WASHER (2 REQD 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" LOCKNUT

248811 BEARING SHIELD

248809 (1 PAIR) ADJUSTMENT PIN KIT

248806 (1 PAIR) ARBOR PLATES

3/8" X 1" BOLT

3/8" LOCKNUTS

One Lincoln Way
St. Louis, Missouri 63120-1578
Customer Service (314) 679-4300

**SECTION 6**
**SPECIAL EQUIPMENT**

FORM 420599
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 EYEBOLT

AIR RATCHET SPEEDS ASSEMBLY OF LOCKNUTS

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

3/8" X 1" BOLT
SHOP PRESS

OWNER/OPERATOR MANUAL

OWNER/OPERATOR RESPONSIBILITIES
It is the responsibility of the owner and/or operator to properly use and maintain this equipment and the legibility of all warning and instruction labels. Carefully read and understand the instructions and warnings in this manual before operating this equipment.

SPECIFICATIONS
See product labels for model number and capacity rating.

WARNING
Failure to heed the following warnings may result in personal injury or property damage.

1. Wear safety glasses or protective face shield.
2. Install safety shield around work unit whenever possible.
3. Align and support all work to provide a straight ram pressure against a solid base.
4. Do not overload.
5. Use only manufacturer approved accessories.
6. Do not modify press.

OPERATION
Before operating the press, it may be necessary to purge air from the jack hydraulic circuits. Purging is required if the jacks ram fails to extend when pumped or if it appears to require excessive number of pump strokes because of air trapped in the jacks 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.

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.