



20 TON AIR-OPERATED SHOP PRESS

Instructions for Part # BD-PRESS-20A

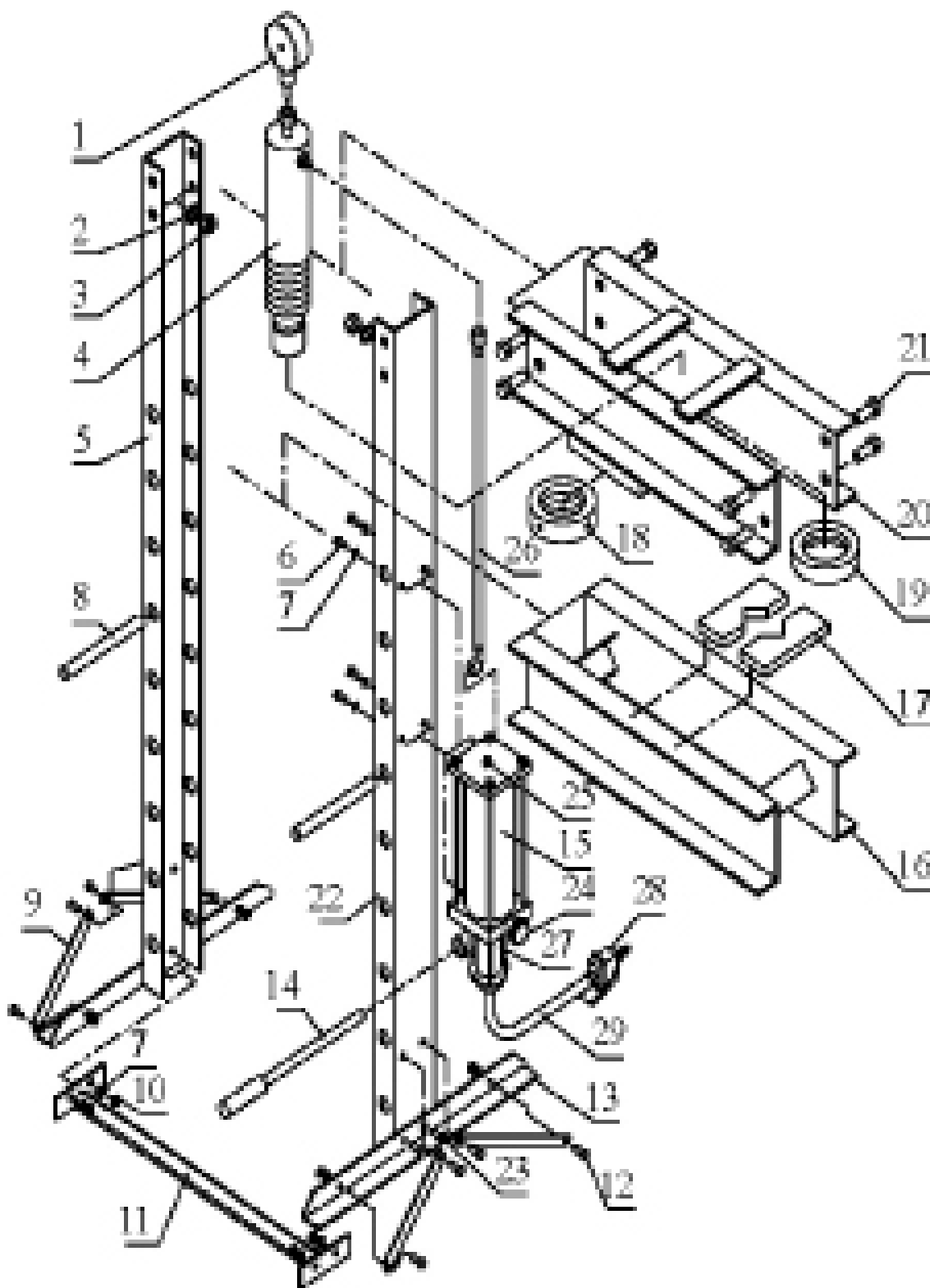
GENERAL GUIDELINES & SAFETY

- It is the user's responsibility to read and follow all instructions.
- Keep these instructions with the product at all times and review before each use.
- It is the responsibility of this product's owner to furnish the instructions to any person that borrows or purchases the product.
- Inspect the product before use to ensure it is assembled properly and all parts are in safe working order and free of defects.
- Never modify this product in any way.
- All circumstances cannot be addressed in these instructions.
- Please use common sense and practice general safety measures when using this product.
- Parts and/or instructions are subject to change without notice.
- Steel and other materials can shatter, so always use protective eye wear that complies with the appropriate ANSI code, a full-face safety shield, and work gloves when operating the press.
- Do not wear loose-fitting clothing when operating. Remove ties, watches, rings, and other loose jewelry and contain long hair.
- Do not use the press when tired or under the influence of alcohol, drugs, or any intoxicating medication.
- Do not allow untrained persons to operate the press.
- If you detect anything that may indicate imminent structural failure, stop using the press.
- Only use the press on stable, level, and dry surfaces capable of sustaining the load.
- Bolt the press to the floor it is to be used with bulky or unstable items. If the press will be getting almost daily use, it is recommended to bolt it down.
- Do not use the press to compress springs or any other item that could disengage and cause a potential hazard.
- Safe assembly may require two people.
- Do not exceed the ram stroke, so as not to damage the press. Do not make any modifications to the press.
- Do not use brake fluid or any other improper fluid and avoid mixing different types of oil when adding hydraulic oil.
- Do not use the shop press to compress spring or any other item that could disengage and cause a potential hazard. Never stand directly in front of loaded press and never leave loaded press unattended.



PARTS

	Description	Qty
1	Pressure gauge	1
2	M16 washer	8
3	Nut M16	8
4	Cylinder	1
5	Post left	1
6	Bolt M10×15	4
7	Washer M10	16
8	Pin	2
9	Support	4
10	Nut M10	12
11	Bottom crossbeam	1
12	Bolt M10×25	8
13	Base	2
14	Handle	1
15	Pump	1
16	Working table	1
17	Block plate	2
18	Limit circle	1
19	Limit ring	1
20	Upper crossbeam	1
21	Bolt M16×35	8
22	Post right	1
23	Bolt M10×30	4
24	Release valve	1
25	Vent screw	1
26	Hose	1
27	Air pump	1
28	Manual switch	1
29	Air hose	1



ASSEMBLY

***The machinery must be installed and commissioned by qualified personnel. All relevant safety regulations must be strictly adhered to! Use the parts diagram as your guide to assemble.

BEFORE USE

Purge air away from hydraulic system.

1. Manual operating system: open the release valve by turning it counterclockwise. Pump several full strokes to eliminate any air in the system.
2. Open the vent screw by turning it counterclockwise which is on top of the pump to release any trapped air from oil tank.
3. Inspect for leaks or damaged parts.

OPERATION

1. Place the arbor plate on the working table, then insert work-piece onto arbor plate.

CAUTION **THE BLOCK PLATE MUST BE USED BY PAIR, NOT BY PIECE!

** THE ARBOR PLATE CAN BE USED BY BOTH SIDES.

2. Close release valve by turning clockwise until it is firmly closed.
3. Pump the handle until ram nears work-piece.
4. Align work-piece and ram to ensure center loading.
5. Pump handle to apply load onto work-piece (please see numeration in pressure gauge).
6. When the work is done, stop pumping the handle or supplying air. Carefully remove load from work-piece by turning the release valve counterclockwise in small increments. (Must turn with the small angle, the biggest is two circles).
- 4.7. After ram has fully retracted, remove work-piece from working table.

MAINTENANCE

1. Periodically, lubricate all moving parts including the pump piston and hydraulic ram.
2. When not in use, store the press in a dry location with ram and piston fully retracted.
3. Check hydraulic oil level and ensure all connections and hoses are not damaged before use.
4. If the press needs repair or parts need replacement, have it repaired by authorized and trained technicians and only use the replacement parts supplied by the manufacturer.

Problem	Cause	Solution
The pump is working, while the cylinder ram is not operating.	1. Loose hose connection 2. The ram is leaking 3. Release valve not completely closed 4. Air in hydraulic system	1. Check the hose connection 2. Replace the oil seals 3. Check the release valve 4. Purge air away, see BEFORE USE, 3.1
When open release valve, the ram will not reset.	1. Loose hose connection 2. The ram is damaged	1. Check the hose connection 2. Repair or replace the ram
The cylinder ram will not fully open.	1. Low oil	1. Add oil
Oil leaking	1. Seals broken 2. Loose connections.	1. Replace the seal kits 2. Tighten loose connections

PRODUCT WARRANTY & LIABILITY

GENERAL PRODUCT WARRANTY: Products purchased from the Authorized Dealer (original place of purchase) or Merchant ("Dealer") will be free of defects in material and workmanship at the time of receipt, and will meet the specifications stated at the place of purchase transaction or online at the Dealer's website, under normal use and service when correctly installed, operated and maintained. This product warranty is effective for the period of time stated below, unless otherwise stated in the product instructions or depicted in the product advertisement. All Authorized Dealer warranties are NON-TRANSFERABLE and cover only the original end purchaser. This limited warranty does not cover products purchased through non-authorized dealers. Non-authorized dealer receipts are not accepted for warranty verification.

*****WARRANTY CLAIMS MUST BE MADE DIRECTLY TO THE ORIGINAL PLACE OF PURCHASE.*****

WARRANTY PERIOD: This warranty remains in force for one year from the date of the product's accepted delivery. The Authorized Dealer offers a one year manufacturer's warranty for most products unless otherwise specified on the product advertisement.

WARRANTY SERVICE: The Authorized Dealer will replace any defective or malfunctioning part at no charge, including payment of the shipping costs of parts or replacement product to and from the manufacturer. The purchaser is responsible for labor charges. If the product does not meet specifications as depicted in the advertisement, the Authorized Dealer will refund the full purchase price of the product. Questions regarding the warranty on a specific product and warranty claims should be directed to the Authorized Dealer with whom the purchase transaction was made.

WARRANTY LIMITATIONS: The above warranty does not apply to products that are repaired, modified or altered by any party other than the Authorized Dealer; are subjected to unusual physical stress or conditions (such as overloaded ramps or corrosion), natural disaster, governmental actions, wars, strikes, labor disputes, riots, theft, vandalism, terrorism or any reason beyond reasonable control; are damaged due to improper installation, misuse, abuse, accident or negligence in use, storage, transportation or handling, or tampering; or to products that are considered consumable items or items requiring repair or replacement due to normal wear and tear. Product should be inspected prior to signing for delivery. Product damage incurred during shipping, unless noted on the Bill of Lading at the time of delivery, renders this warranty void.

LIMITED LIABILITY: In no event shall **THE AUTHORIZED DEALER** be liable to the purchaser or any third party for any indirect, incidental, consequential, special, exemplary or punitive damages arising out of the use of the product, including, without limitation, property damage, loss of value of the product or any third party products that are used in or with the product, or loss of use of the product or any third party products that are used in or with the product.

