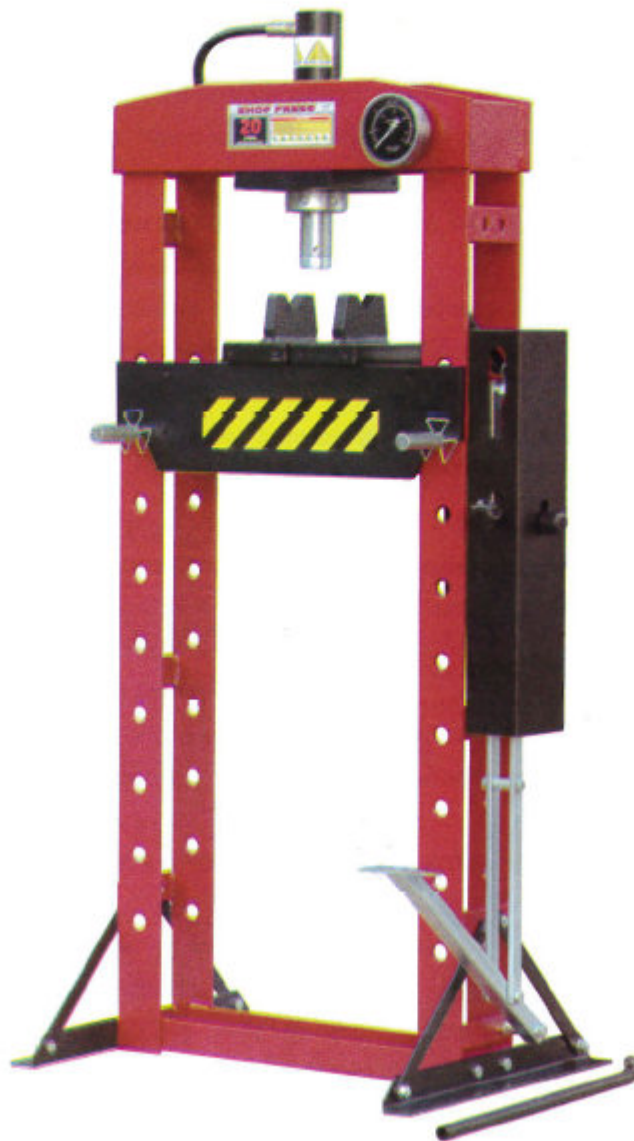


# P20T-HD

20 TON

FOOT/MANUAL SHOP PRESS



Instruction Manual

## **IMPORTANT**

**PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFETY INSTRUCTIONS N WARNINGS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE TO PROPERTY AND/OR SERIOUS PERSONAL INJURY. PLEASE KEEP THIS INSTRUCTION MANUAL SAFE FOR FUTURE USE.**

### **1. SAFETY INSTRUCTIONS AND WARNINGS**

- 1.1 Use a qualified person to maintain the press in good condition. Keep it clean for best and safest performance.
- 1.2 The maximum load is 20tons. **DO NOT** exceed this rated capacity. Never apply excessive force to a workpiece and always use the pressure gauge to accurately determine the applied load.
- 1.3 Use this press for the purpose for which it is intended. **DO NOT** use it for any other purpose it is not designed to perform.
- 1.4 Keep children and unauthorized persons away from the work area.
- 1.5 Remove ill fitting clothing. Remove ties, watches, rings and other loose jewelry, and contain long hair.
- 1.6 Wear ANSI approved impact safety goggles, full-face impact safety shield and heavy-duty work gloves when operating the press.
- 1.7 Keep proper balance and footing, do not overreach and wear nonslip footwear.
- 1.8 Only use this press on a surface that is stable, level, dry and not slippery, and capable of sustaining the load.  
Keep the surface clean, tidy and free from unrelated materials and ensure that there is adequate lighting.
- 1.9 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.
- 1.10 Check to ensure that all applicable bolts and nuts are firmly tightened.
- 1.11 Ensure that workpiece is center-loaded and secure.
- 1.12 Keep hands and feet away from bed area at all times.
- 1.13 **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 a loaded press and never leave loaded press unattended.
- 1.14 **DO NOT** operate the press when you are tired or under the influence of alcohol, drugs or any intoxicating medication.
- 1.15 **DO NOT** allow untrained persons to operate the press.
- 1.16 **DO NOT** make any modificatoins to the press.
- 1.17 **DO NOT** use brake fluid or any other improper fluid and avoid mixing different types of oil when adding hydraulic oil. Only a good quality hydraulic jack oil can be used.
- 1.18 **DO NOT** expose the press to rain or any other kind of bad weather.
- 1.19 If the press need repairing and/or there are any parts that need to be replaced, have it repaired by authorized technicians and only use the replacement parts supplied by the manufacturer.
- 1.20 **WARNING:** the warnings, cautions and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

## 2. SPECIFICATIONS

Capacity	20ton	Stroke	190mm
Working Range	35-912mm	Bed Width	510mm

## 3.ASSEMBLY

Use the exploded drawing as your guide to assemble the press. Lay all parts and assemblies out in front of you before beginning. The following procedure is recommended:

- 3.1 Attach one base section (b4) to left post (b8) using bolts (b1), washers (b5), lock washers (b6) and nuts (b7), then attach another to right post (b8)
- 3.2 Insert bed frame pins (a8) into the holes in the posts, then insert the joined press bed frame (a6) into press frame and onto bed frame pin.
- 3.3 Attach the pump and protection cover assemblies to the right post using bolts (d1) and washers (b5), Connect the oil hose (c27) to the connection joint (c26) and assemble the pressure gauge (c15) to the pressure gauge union nut (c18) and oil hose (c14) connection the direct fitting (c25) and ram (c7)
- 3.4 Tighten all bolts and nuts.

## 4. BEFORE FIRST USE

- 4.1 Purge away air from the hydraulic system.  
**Manual operation system:** open the long release valve (d26) and short release valve (d33) by turning it counterclockwise. Pump several full strokes to eliminate any air in the system.
- 4.2 Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.

## 5. OPERATING INSTRUCTIONS

**WARNING! Ensure that you read, understand and apply the safety instructions and warnings before use.**

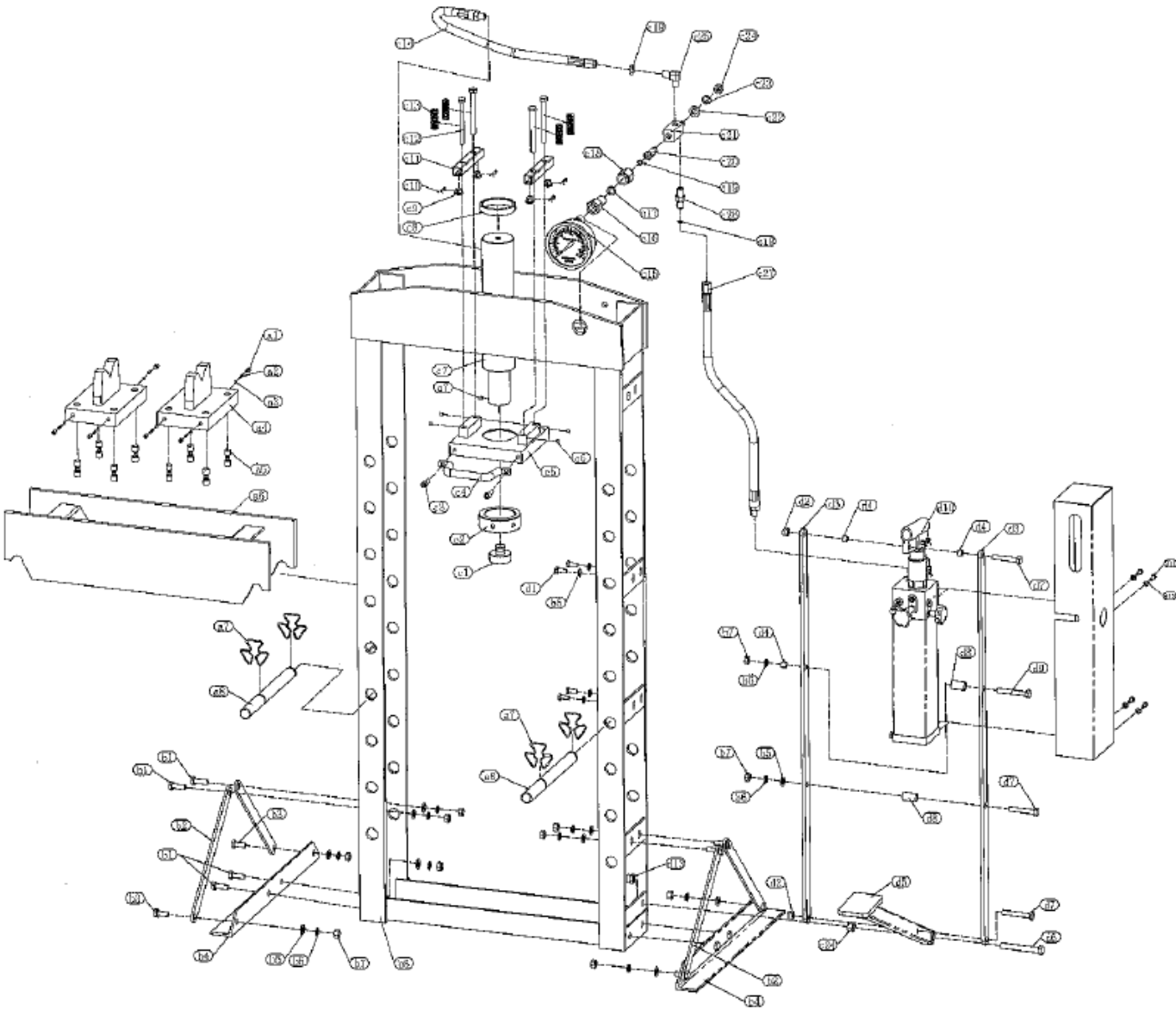
**WARNING! Ensure that you have familiarized yourself thoroughly with the product and the hazards associated with its improper use.**

- 5.1 Place the heel block (a4) onto the press bed frame(a6), then insert workpiece onto the heel block.
- 5.2 Close the long release valve (d26) and short release valve (d33) by turning it clockwise until it is firmly closed. Use foot pedal(d5) or handle let the piston rod fast down ,if only close the long release valve (d26) the piston rod slow down ,when the serrated saddle contact pressure was objects ,can open the short release valve (d33) ,that enables you to use more energy .
- 5.3 Align workpiece and ram to ensure center-loading.
- 5.4 Once ram has fully retracted, remove workpiece from the press bed frame.

## 6. MAINTENANCE

- 6.1 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.
- 6.2 When not in use, store the press in a dry location with ram and piston fully retracted..
- 6.3 When press efficiency drops, purge away air from hydraulic system as described in 4.1
- 6.4 Check the hydraulic oil level: remove the filler nut (d34) on the top of the reservoir, if the oil is not adequate, fill with high quality hydraulic jack oil as necessary, then replace the oil filler nut, purge away air from the hydraulic system as described in 4.1

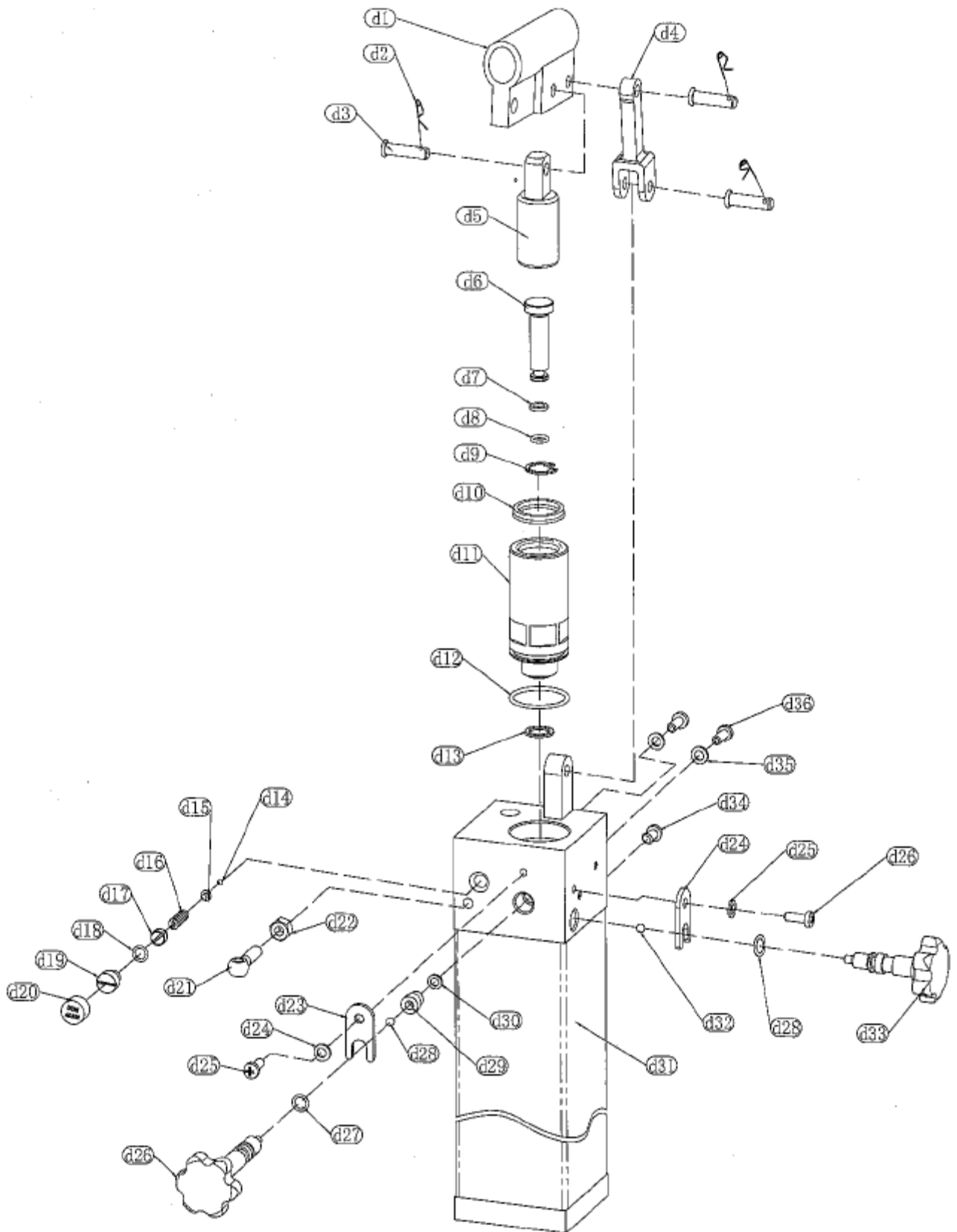
# EXPLODED DRAWING



# PARTS LIST.

d13	nut	1	c12	bolt	4
d12	washer	4	c11	conecting plate	2
d11	screw	4	c10	R-pin	4
d10	pump	1	c9	slide block	4
d9	bolt	1	c8	upper round nut	1
d8	conntcting pipe	2	c7	ram	1
d7	bolt	3	c6	screw	5
d6	bolt	1	c5	under plate	1
d5	foot pedal	1	c4	handle	1
d4	bushing	3	c3	screw	2
d3	support	2	c2	under round nut	1
d2	nut	2	c1	serrated saddle	1
d1	bolt	4	b8	post	1
c27	oil hose	1	b7	nut	14
c26	joint	1	b6	lock washer	14
c25	direct fitting	1	b5	washer	17
c24	bolt	1	b4	base section	2
c23	lock washer	1	b3	bolt	4
c22	washer	1	b2	support	4
c21	union seat	1	b1	bolt	8
c20	union screw	1	a8	pin	2
c19	O-ring	3	a7	circlip	4
c18	union nut	1	a6	bed frame	1
c17	nylon ring	1	a5	screw	8
c16	gauge fitting	1	a4	heel block	2
c15	pressure gauge	1	a3	ball	8
c14	oil hose	1	a2	spring	8
c13	spring	4	a1	screw	8
Item	Description	QTY	Item	Description	QTY

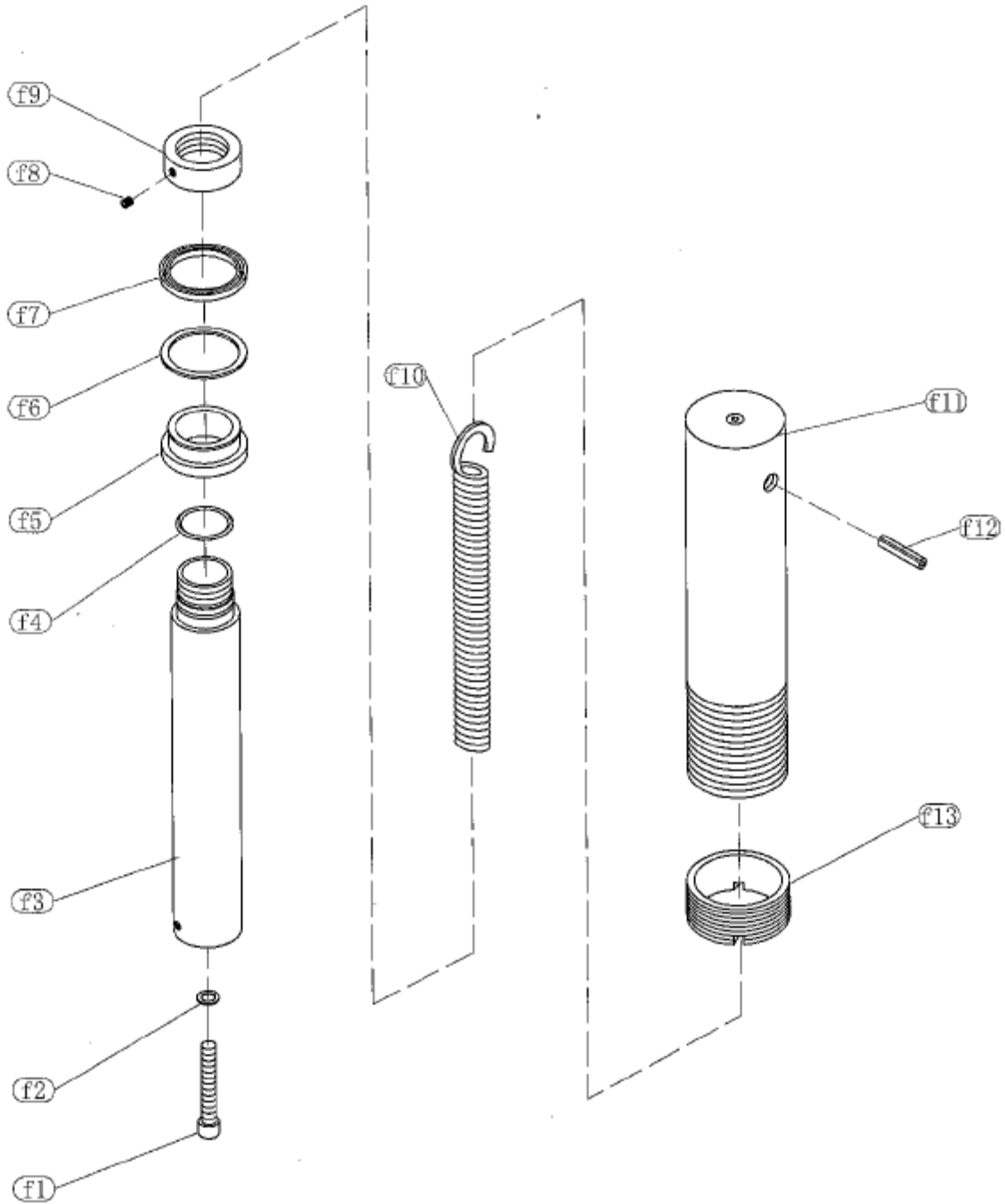
# PUMP DRAWING



# PARTS LIST.

d36	screw	2	d18	O-ring	1
d35	washer	2	d17	screw	1
d34	oil filler	1	d16	sping	1
d33	short release valve	1	d15	ball seat	1
d32	ball	1	d14	ball	1
d31	pump	1	d13	washer	1
d30	washer	1	d12	O-ring	1
d29	release seat	1	d11	piston seat	1
d28	ball	1	d10	sealing ring	1
d27	O-ring	2	d9	ring	1
d26	long release valve	1	d8	O-ring	1
d25	screw	2	d7	washer	1
d24	washer	2	d6	piston	1
d23	ring	2	d5	piston	1
d22	nut	1	d4	connecting rod	1
d21	bolt	1	d3	pin	3
d20	dust cap	1	d2	R-pin	3
d19	screw	1	d1	handle socket	1
Item	Description	QTY	Item	Description	QTY

# RAM DRAWING





# PARTS LIST.

f13	ring for ram	1
f12	pin	1
f11	ram	1
f10	spring	2
f9	screw	2
f8	nut	1
f7	sealing ring	1
f6	washer	1
f5	piston	1
f4	O-ring	1
f3	piston rod	1
f2	washer	1
f1	screw	1
Item	Description	QTY