

# Instruction Manual

Press, HP20 / HP25 G6, FP20 / FP25 G6

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## Important: Read and understand this manual before use

FP20 / FP25 is a foot operated press with air operated fast approach and with air return on ram.

HP20 / HP25 is a hand operated press with air operated fast approach and with air return on ram.

## Transportation:

By forklift: Place the forks under the top frame. The lifting points are marked on the packing.

By crane: The same lifting points as for the forklift.

By pallet truck: The press must be supported during transportation so it can't tip over.

## Safety:

**Important!** When using the fast approach air system, the press piston may obtain a pressure up to 600kg, and there may be danger of damaging body parts, if they get caught under the press piston.

Use the press for pressing purpose ONLY! Always take care of the risk for items to be thrown out of the press.

## Installation:

Before use the press must be inspected visually by a skilled person for any leakages and damages. This inspection is to be made at least once a year.

Mount the pressure gauge so it is placed in the correct position. It is demounted for transportation reasons.

Tighten the pressure gauge with a 22 mm spanner while holding a 27 mm spanner counter to tighten the base of the pressure gauge towards a cutting ring. Don't use any tape or equivalent.

In case the pressure gauge isn't turned into the right position then adjustment is done by loosening the bottom nut with a 24 mm spanner while holding counter with a 27 mm spanner. Now adjust the pressure gauge into its right position and tighten the nut again while holding counter.

Connect the Air supply: 6-8 bar (88 - 115 psi).

## Operating:

Raise the table slightly above the required working height, insert the pins and take care these are placed correctly. Place the straightening blocks and the press is ready for use.

Please note! From 55 % of the max. pressure (14 tonnes) and onwards the material must always be supported by both of the straightening blocks.

Activate the fast approach with air pressure by activating the small pedal, placed at the bottom on the right side of the press frame just above the press foot. Activating the small pedal / valve moves the piston downwards. Full capacity is obtained by pumping with the handle/foot pedal.

Return the piston by activating the air return.

HP: Push the handle gently in the backwards direction and the piston returns.

FP: Lift the foot pedal gently and the piston returns.

Do not use the press beyond the indicated max. Pressure and max. Stroke length, as this may damage the seals in the cylinder. DO NOT continue pumping or activating the air hydraulic pump in case the full stroke of the press is attained.

## Maintenance:

Empty the water separator regularly by turning the plug which is placed in the spill-box anti-clockwise.

**IMPORTANT!** Tighten the plug again before use. In case the user doesn't empty the water separator this could cause corrosion damage to the piston and the cylinder. Damage to the hydraulic system caused by above will invalidate the warranty.

The cylinder and the pump are self-lubricating. Lubricate hinge and pivots at the pump pistons as required.

Change oil as required every 1 or 2 years.

Fill the oil tank with hydraulic oil type Castrol Hyspin AWS 22 (viscosity 22 at 40°C) or a equivalent type of hydraulic oil (see the table further down this page).

Oil level: (HP/FP G2 70-80mm) (HP/FP G5 85-95mm) below the top plate of the oil tank (with the piston fully returned). Always take care that the pump is filled up to the correct oil level.

While changing oil or filling up with oil, it is important to avoid particles getting access to the pump which could damage the hydraulic system.

<b>Oil Company</b>	<b>Type: ISO 22/DIN 51524</b>
Castrol	Hyspin AWS 22
Mobil	DTE 22
Statoil/Esso	Univis N 22
Texaco	Rando HD 22
ELF	Olna/Hydrelf 22
Shell	Tellus S 22
BP	Bartran 22
Kuwait Petr.(Q.8)	Haydn 22
Delta Oil	EP Hydraulic Oil 22
Valvoline	Ultramax HLP 22
Nynæs	TD-17 EX

## Bleeding:

Under normal circumstances the pump shouldn't require bleeding, but in case it should be necessary then proceed as follows:

1. Check the oil level is correct - otherwise fill up with oil as described above.
2. Check that the correct oil plug (with a hole) is mounted.
3. Operate the piston to max. stroke and return fully. Repeat this 2-3 times.
4. The press should now function normally, in case the problem remains unsolved repeat the above procedure.

**USE ONLY ORIGINAL SPARE PARTS!**

## Decommissioning:

If the press should ever be scrapped, draw off the oil into an approved container and dispose it at an approved authority.