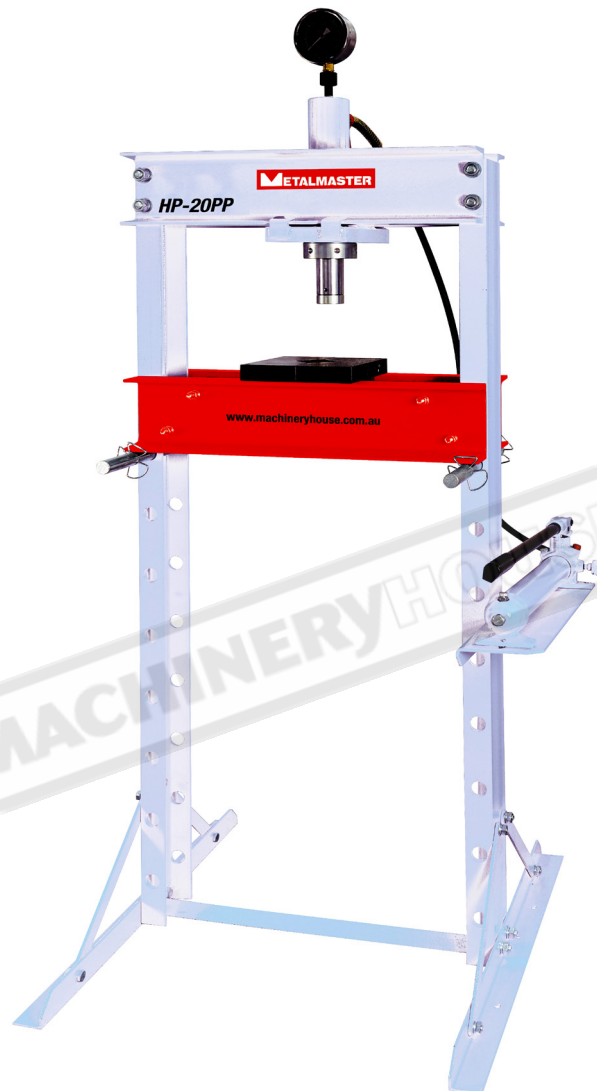




OPERATION MANUAL



HYDRAULIC PRESS

Model. HP-20PP

Order Code P142

Edition No : HP-20PP-3

Date of Issue : 05/2020

MACHINE DETAILS**MACHINE**

HYDRAULIC PRESS

MODEL NO.

HP-20PP

SERIAL NO.**DATE OF MANF.**

Distributed by

MACHINERYHOUSEwww.machineryhouse.com.auwww.machineryhouse.co.nz**Note:**

This manual is only for your reference. Owing to the continuous improvement of the Metalmaster machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

**NOTE:**

In order to see the type and model of the machine, please see the specification plate. Usually found on the side or back of the machine. See example (Fig.1)

METALMASTER	
PRODUCT SPECIFICATIONS	
Model: HP-20PP	Weight: 112kg
Capacity: 20 Tonne	MFG Date:
Serial No:	
www.machineryhouse.com.au	www.machineryhouse.co.nz
Made in China	

Fig.1

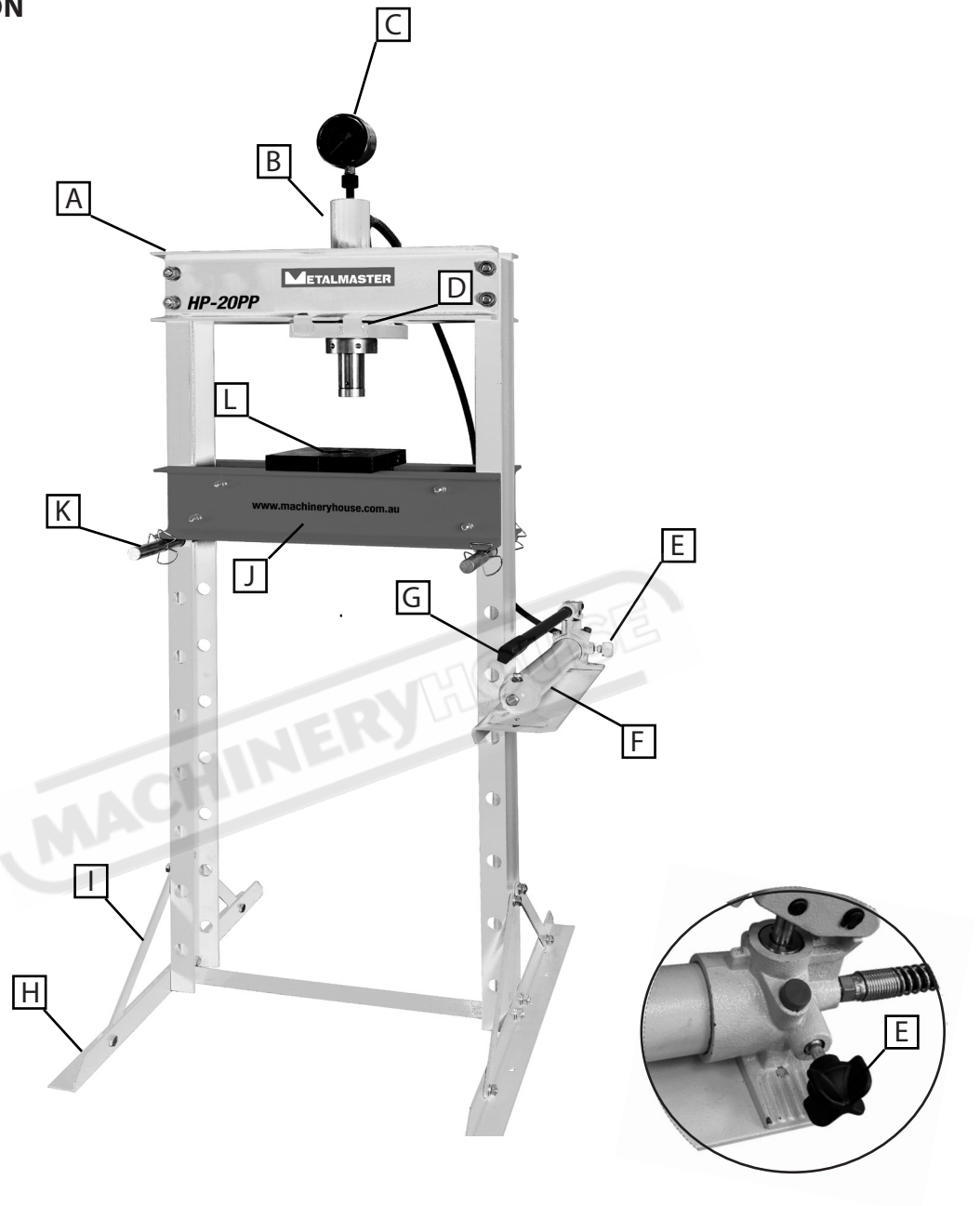
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1.1 SPECIFICATIONS

Order Code	P142
Model	HP-20PP
Pressing Capacity (Tonne)	20
Hydraulic Ram Operation (Type)	Manual-Hydraulic
Sliding Ram (left-right) (Yes/No)	Yes
Width Between Front Posts (mm)	542
Width Between Side Posts (mm)	85
Table Top Opening - (Front to Back) (mm)	105
Ram To Table (Max.) (mm)	980
Piston Ram Stroke (mm)	185
Ram Diameter (mm)	Ø48
Operating Pressure (p.s.i)	110 -120
Dimensions (W x D x H) (mm)	738 x 700 x 1790
Shipping Dimensions (W x D x H) (mm) Carton 1	1560 x 195 x 135 (80kg)
Shipping Dimensions (W x D x H) (mm) Carton 2	730 x 270 x 170 (35kg)
Nett Weight (kg)	112

1.2 IDENTIFICATION



A	Main Frame	G	Hydraulic Pump Handle
B	Cylinder	H	Press Feet
C	Pressure Gauge	I	Press Feet Support Bars
D	Ram Baseplate	J	Bed or Working Table
E	Pump Release Valve	K	Safety Pins with Retaining Clips
F	Hydraulic Pump	L	Pressing Plates

2.1 GENERAL SAFETY REQUIREMENTS

DO NOT use any machine unless you have read the manual or have been instructed in the use of the machine in its safe use and operation



WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in serious personal injury—including amputation, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension, of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



Safety glasses must be worn at all times in work areas. Earmuffs should be worn if the work area is noisy.



Sturdy footwear must be worn at all times in work areas.



Gloves should NOT be worn when operating this machine



Long and loose hair must be contained with a net or under a hat

OWNER'S MANUAL. Read and understand this owner's manual before using the machine.

CHECK DAMAGED PARTS. Regularly inspect the machine for any condition that may affect the safe operation. Immediately repair or replace damaged or parts that are incorrectly fitted before operating.

TRAINED OPERATORS ONLY. Operators that have not been trained have a higher risk of being seriously injured. Only allow trained or supervised people to use this machine. When the machine is not being used, disconnect the power, to the machine to prevent unauthorized use—especially around children. Make the workshop safe.

2.1 GENERAL WORKSHOP SAFETY Cont.

WEARING PROPER APPAREL Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of operating control.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose. Do not force the machine or its attachments to do a job for which they were not designed. Never make unapproved modifications. Modifying the machine or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating the machine. Do not overreach! Avoid awkward hand positions that make operating control difficult. This could increase the risk of accidental injury.

FORCING MACHINERY. Do not force the machine. It will do the job safer and better at the rate for which it was designed.

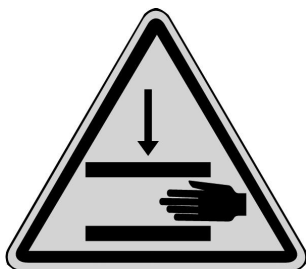
NEVER STAND ON MACHINE. Serious injury may occur if the machine is tipped or if crush points are unintentionally contacted

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before using the machine , verify that it is stable

UNATTENDED OPERATION. To reduce the risk of accidental injury, never leave the machine in use while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep the machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.



Warning: Crush Points can occur between the Ram and the workpiece or between the workpiece and the table.

2.2 SAFE OPERATING PROCEDURE FOR HYDRAULIC PRESS

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual.



Safety glasses must be worn at all times in work areas.



Close fitting protective clothing or overalls are encouraged



Appropriate protective footwear with substantial uppers must be worn.



Rings and jewellery must NOT be worn in the workshop

PRE-OPERATIONAL SAFETY CHECKS

1. Ensure you are familiar with the operation of the hydraulic press.
2. Check for any hydraulic fluid leaks.
3. The press table must be clean and steel weights are flat and secure on press table.
4. Any forming die or cutting die must be inspected for safe use i.e. no cracks.
5. Ensure safety glasses or goggles are available and are worn by all persons in the vicinity.
6. Any test piece, project or material (work piece) to be pressed must be of an appropriate thickness and safe to use on this equipment.
7. Faulty equipment must not be used. Immediately check suspect machinery.

OPERATIONAL SAFETY CHECKS

1. Place your test piece, project or material (work piece) securely on the press table.
2. Ensure the pressure valve is closed before operation.
3. Use the press handle, in a pumping action, to slowly lower the press hammer.
4. Use your shoulder muscles when operating – NOT your lower back.
5. Keep hands and fingers away from all clamping and moving parts.
6. Carefully and accurate alignment the press hammer face with the work piece for even force to be applied.
7. Once the press hammer makes contact with the work piece, closely watch the PSI gauge and note the pressure applied.
8. Once the work piece is pressed sufficiently, release the hammer pressure at the release valve.
9. DO NOT apply excessive force with the press.

AFTER OPERATION COMPLETED

1. After use, clean the press down and place any tools and equipment in the appropriate storage area – including the press handle.
2. Place all scrap or waste in the appropriate bin.

POTENTIAL HAZARDS

- Beware of high forces applied
- Pinch and squash
- Potentially uneven forces being applied to the work piece
- Eye injuries – flying or shattering objects
- Laceration injuries

2.3 LIFTING INSTRUCTIONS

Make sure that a crane or forklift with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

The machine is heavy and will require two or more to lift and assemble.



LIFTING POINTS

When lifting the machine only certified lifting slings should be used. (Fig.2.1)

Ensure that when lifting, the machine does not tip over. Check that the lifting slings do not interfere with the hydraulic pipes.

Failure to follow these instructions could cause damage to the machine

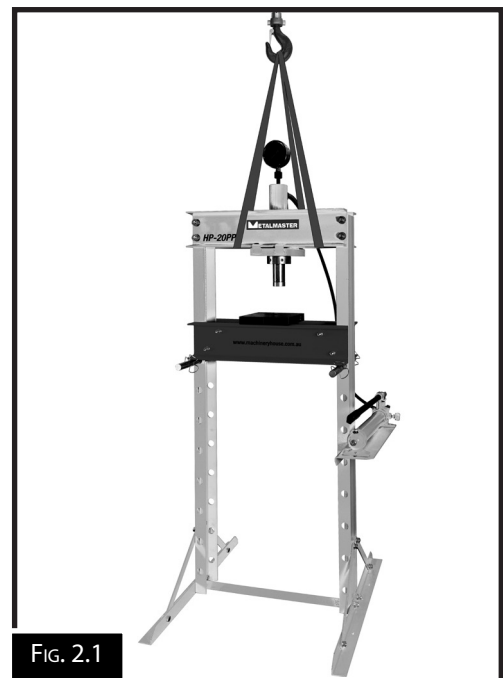


FIG. 2.1

3. INSTALLATION

The position where your machine is operated is important for safe operation and the longevity of its components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions.

Extreme conditions for this type of machinery are generally those where the environment is subject to vibration, shocks, or bumps.

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Lighting around the machine must be adequate enough that operations can be performed safely.

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment.

3.1 ASSEMBLY

Ensure the press and its components suffered no damage during transit and that all the parts are present. Should any loss or damage become apparent, please contact your local dealer immediately.

IMPORTANT: Due to the weight of the press components, we recommend that you get assistance during assembly.

IMPORTANT: Do not locate your press where it will be open to the elements, as severe weather conditions will damage the hydraulic parts.

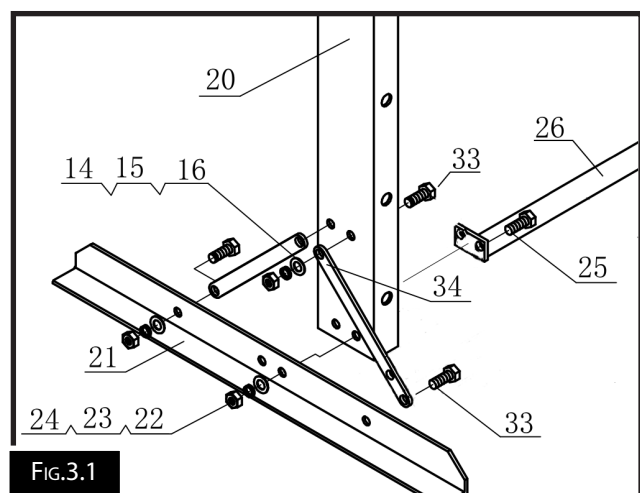
Use the spare part exploded drawing on page 23 as your guide to assemble.

Lay all parts and assemblies out in front of you before beginning.

Loosely attach all frame parts first then once the frame is all assembled tighten all the fasteners.

The following procedure is recommended:

1. Attach one base section (21) to a main post (20) and lower cross member (26) using bolts M12 x 35mm (25), washers M12 (22), spring washers M12 (23) and nuts M12 (24), then attach the other post to the opposite side of the lower cross member, using the same fasteners as above. (Fig.3.1)
2. Attach the 4 x Support bars (34) to the base section (21) and the main posts (20) using bolts M10 x 25mm (33), washers M10 (14), spring washer M10 (15) and nuts M10(16). (Fig.3.1)



3. Put the press frame in an upright position, attach the 2 x upper cross beams (10) to left and right main posts (20) using bolts M16 x 35 (9), M16 washers (13), M16 spring washers (12) and M16 nuts (11). The upper cross beam with the Metalmaster logo is to be facing the front of the press. (Fig.3.2)

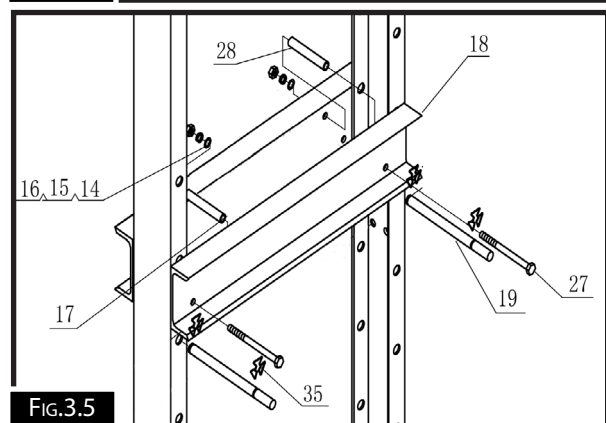
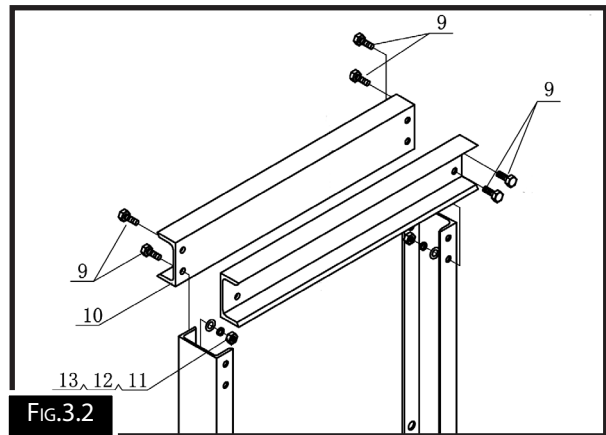
4. Tighten all frame bolts

5. Attach the sliding plate (7) to the upper cross beams, with the handle hook side facing the front of the press. Using the 4 x M8 x 20 bolts, flat and spring washers. (Fig.3.3)

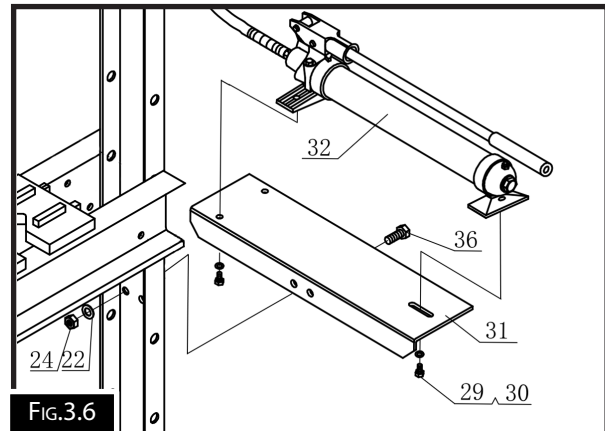
6. Screw the upper round nut (6) onto the ram (3), insert the ram into the hole in the under plate (7), then screw the under round nut (8) onto the ram and attach the serrated saddle (5) to the ram. (Fig.3.4)

7. Join the two press bed frame (18) together by inserting the four bolts M10 x 140 (27) through the bushings (28) and the holes in the bed frames, then secure the four bolts by tighten the M10 washer (14), M10 lock washer (15) and M10 nut (16) on it. (Fig.3.5)

8. Insert bed frame pin (19) into the holes in the posts, then insert the joined press bed frame (18) into press frame and onto bed frame pin. Use the retaining clip (35) to secure the pins in place.



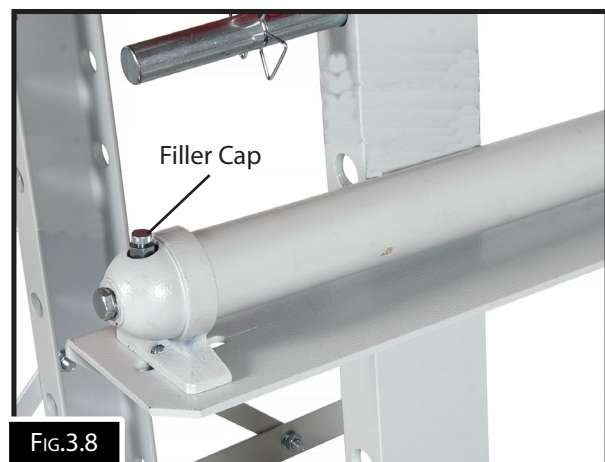
8. Attach the setting plate (31) to the right hand post using bolts M12 x 30 (36), M12 washers (22), M12 lock washers (23) and M12 nuts (24), then secure the pump assembly using the M8 x 16 screws (30) and M8 washers (29), and then insert the handle to the handle bracket (Fig.3.6)



9. Assemble the pressure gauge to the pressure gauge connection nut (R13) and nylon ring (2) which are on the top of ram (3). Use PTFE sealing tape to seal the threads (Fig.3.7)
10. Unfasten the protective hose caps and screw the hose onto the threaded connection of the hydraulic ram.



11. With the ram in the fully retracted position, unscrew the filler plug on top of the cylinder and check that the pump is filled with oil up to the bottom of the thread. (Fig.3.8)



3.2 BLEEDING THE HYDRAULIC SYSTEM

Before using the press, any air needs to be removed from the system.

To Bleed the system:

1. Opening the release valve by turning it anticlockwise
2. Pump the handle of the pump around ten full strokes to eliminate any air bubbles. (Fig.3.9)
3. Close the release valve by turning it clockwise and start to pump. If the pressing seems spongy then repeat the process.

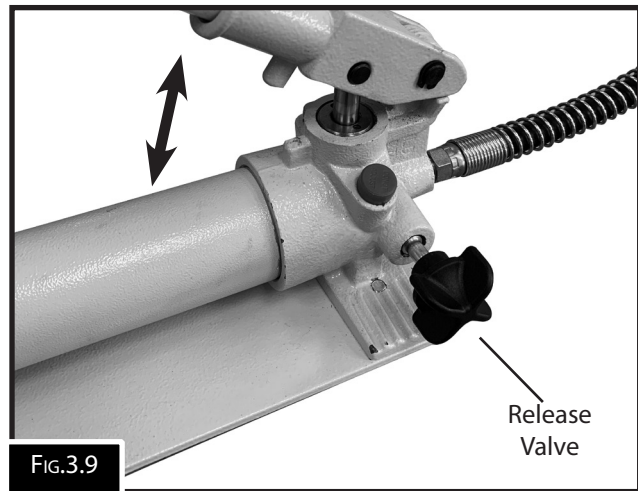


FIG.3.9

- The press is now ready for use.

3.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

3.4 OPTIONS FOR MOUNTING

The machine is best mounted on a concrete slab.

Masonry anchors with bolts are the best way to anchor the machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. (Fig. 3-8)

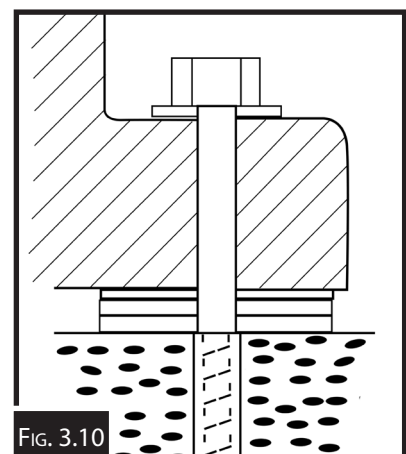


FIG. 3.10

4. OPERATION

4.1 POSITIONING THE BED

IMPORTANT: *Due to the weight of the bed, we recommend that you get assistance from another person when adjusting the bed height.*

1. Position the bed at the desired height, so that it will be as close as possible to the ram when the workpiece is mounted on it.
2. Raise one side of the bed and insert a supporting pin into the next locating hole.
3. Repeat at the other end to level the bed.
4. Repeat until the bed is at the desired height, with the supporting pins fully 'home'.
5. Replace the safety clips on both end of the supporting pins.



CAUTION

The bed height should only be raised or lowered one hole at a time, working alternately from one side and then the other, failure to work in this way may cause the bed to fall and cause injury to the operator

4.2 POSITIONING THE RAM

The press is designed with a quick action method when moving the ram. It can be quickly positioned in either direction as required by sliding the ram baseplate along the cross-beam using the handle. The head is secured when pressure is applied to the ram.



CAUTION

Always position the ram directly above the workpiece.



FIG.4.1



Incorrect



Correct

NOTE:

Always make sure you are pressing with the whole ram. Center the ram over the work, do not press with only the edge of the nose piece. This can cause injury by ejecting the part, or damage to the ram.

4.3 PRESSING PROCESS

1. Place the workpiece on the bed. It must be completely stable and supported by packing or shims where required. Steel pressing plates are supplied, (Fig.4.2) which locate on the bed in either flat or vertical position. Place the workpiece on a combination of these to give it stability.

NOTE: Any packing pieces or shims used **MUST** be capable of withstanding the pressure that will be brought to bear, and **MUST** be of sufficient size with sufficient surface area, so as to avoid the possibility of slipping or springing out. Mating surfaces **MUST** be horizontal so that the force being exerted will **NOT** be at an angle.

2. Close the release valve by turning it clockwise until tightly closed. (Fig. 4.3)
3. Pump the handle to bring the ram very lightly into contact with the workpiece.
4. Position the workpiece or slide the ram to one side so that the desired point of contact is directly beneath the centre of the ram
5. When satisfied that the workpiece is correctly aligned and is completely stable in that position, slowly pump the handle so that the ram begins to exert pressure on the work piece. Continue to pump the handle whilst standing to the side. Do **NOT** stand directly in front of the work, and constantly monitor the process, ensuring the ram and work remain completely in line and there is no risk of slipping.
6. When the process is complete, turn the release valve anticlockwise in small increments to release ram pressure and allow removal of the workpiece.

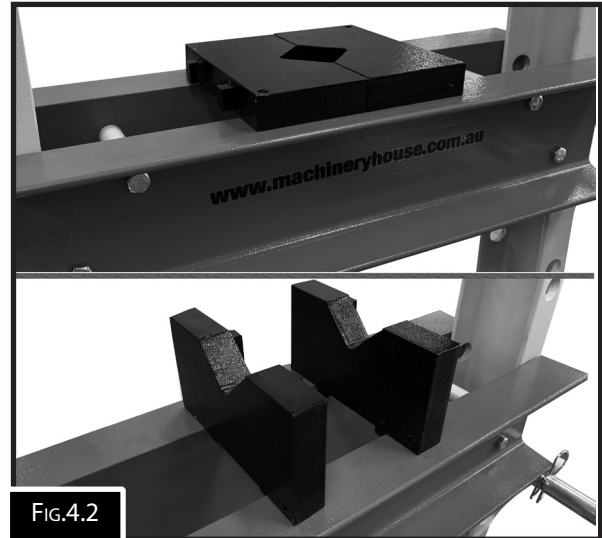


FIG.4.2

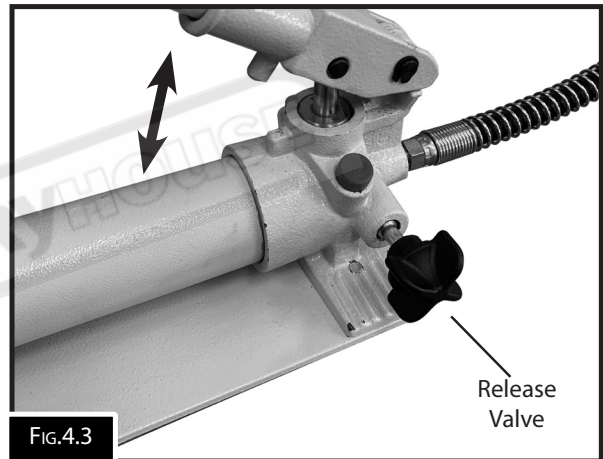


FIG.4.3

WARNING

Do not exceed the rated capacity of the press. Do not allow any person who is inexperienced in the use of hydraulic presses, to use the press unless they are under direct supervision

5. MAINTENANCE

- A visual inspection must be made before each use of the press, checking for leaking hydraulic fluid and damaged, loose, or missing parts.
- Owners and/or users should be aware that repair of this equipment requires specialized knowledge and facilities. It is recommended that a thorough annual inspection of the press be made and that any defective parts be replaced with genuine Metalmaster parts.
- Any press which appears to be damaged in any way, is found to be badly worn, or operates abnormally **SHOULD BE REMOVED FROM SERVICE** until the necessary repairs are made.
- If the press is not to be used for any length of time, store it with the ram retracted and the operating handle in the lowered position to protect the moving parts.

5.1 INSPECTION SCHEDULE

- Check the press frame to make sure all bolts are tight and inspect for cracked welds, bent, loose or missing parts.
- Check the hydraulic connections for leaks. Replace or properly repair any damaged or leaking hydraulic components before using. In the event of leaking seals, oil can be topped up via the plug on the end of the pump. Oil should be level with the bottom of the hole. If necessary top up with hydraulic oil, This task is carried out with the ram fully retracted.
- If any rust is apparent it must be removed completely and the paint restored

5.2 TROUBLESHOOTING

Problem	Probable Cause	Remedy
Pump unit will not work	Dirt on the valve seat/worn seals	Bleed pump unit or have unit overhauled with new seals
Pump will not produce pressure. Pump feels hesitant under load. Pump will not lower completely	Air-lock	Open the release valve and remove the oil filler plug. Pump the handle a couple of full strokes and close the release valve. Replace the filler plug.
Pump will not deliver pressure	Reservoir could be overfilled or have low oil level	Check oil level by removing the filler plug and topping up to the correct level.
Pump feels hesitant under load	Pump cup seal could be worn out	Have the cup seal replaced.
Pump will not lower completely	Air-lock	Release air by removing the filler plug

5.3 FILLING THE HYDRAULIC OIL

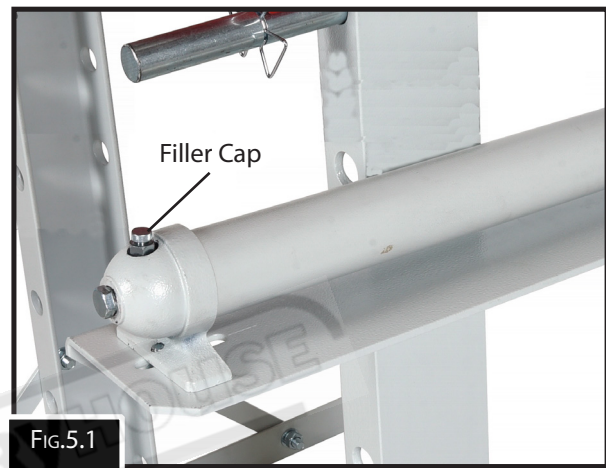


WARNING

When filling the oil the ram must be in the FULLY UP POSITION before any filling of the oil takes place. Failure to do so will cause overflowing of the oil, creating a slip hazard.

Checking the hydraulic oil:

The hose must not be remove when checking the oil. To check or fill the pump, open the oil filler cap on the top of the reservoir. (Fig.5.1). The oil should be filled to the bottom of the thread. If the oil is not adequate, fill with 32# hydraulic oil as necessary. Once filled, then replace the filler cap, and bleed the air from the hydraulic system as described on page 13. Metalmaster have technical support engineers available for service.



SPARE PARTS SECTION

HYDRAULIC PRESS

Model. HP-20PP

Order Code P142

Edition No : HP-20PP-3

Date of Issue :05/2020

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

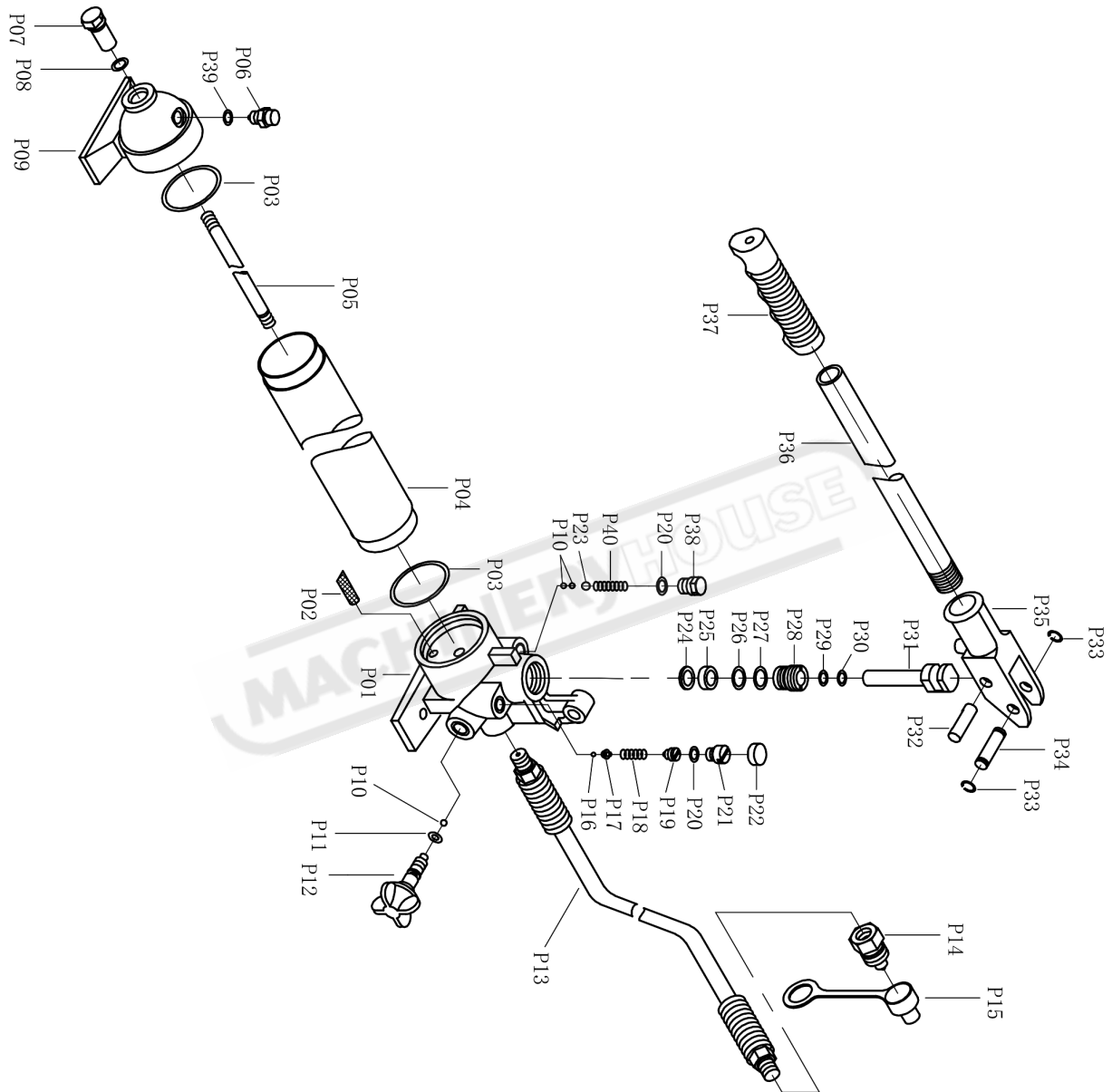
HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to www.machineryhouse.com.au/contactus and fill out the enquiry form attaching a copy of scanned parts list.

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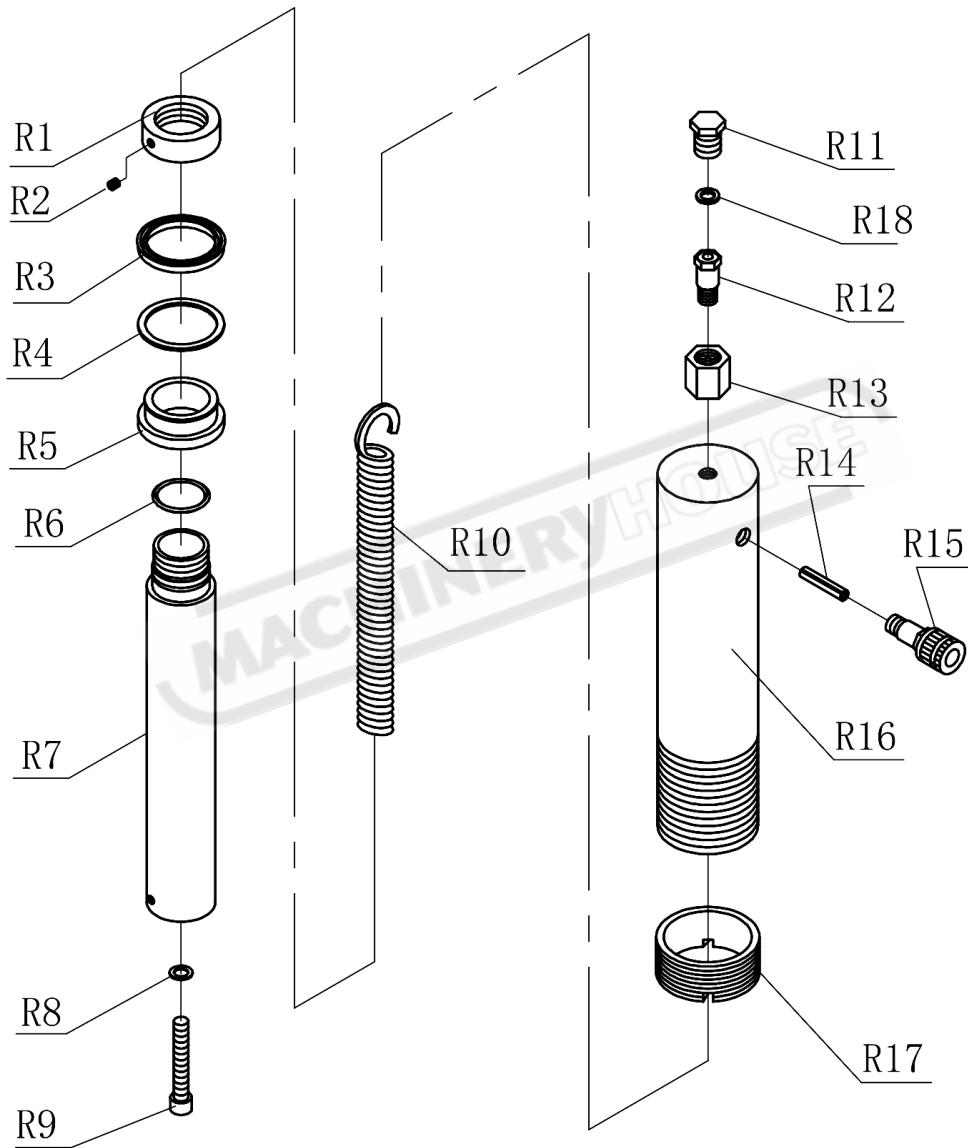
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HP-20PP PUMP SPARE PARTS DIAGRAM



HP-20PP PUMP SPARE PARTS LIST

No.	Description	Qty	No.	Description	Qty
P01	Pump	1	P21	Screw	1
P02	Filter	1	P22	Cap	1
P03	O-ring	2	P23	Steel ball	1
P04	Reservoir	1	P24	Nylon ring	1
P05	Tie rod	1	P25	Sealing ring	1
P06	Screw	1	P26	O-ring	1
P07	Screw	1	P27	Nylon ring	1
P08	O-ring	1	P28	Base of pump core	1
P09	Pump foot	1	P29	O-ring	1
P10	Steel ball	3	P30	Nylon ring	1
P11	O-ring	1	P31	Pump core	1
P12	Release valve	1	P32	Pin	1
P13	Hydraulic hose	1	P33	Retaining ring	2
P14	Coupler	1	P34	Pin	1
P15	Dust cap	1	P35	Base of handle	1
P16	Steel ball	1	P36	Handle	1
P17	Base of steel ball	1	P37	Handle sleeve	1
P18	Spring	1	P38	Screw	1
P19	Screw	1	P39	Nylon ring	1
P20	O-ring	2	P40	Spring	1

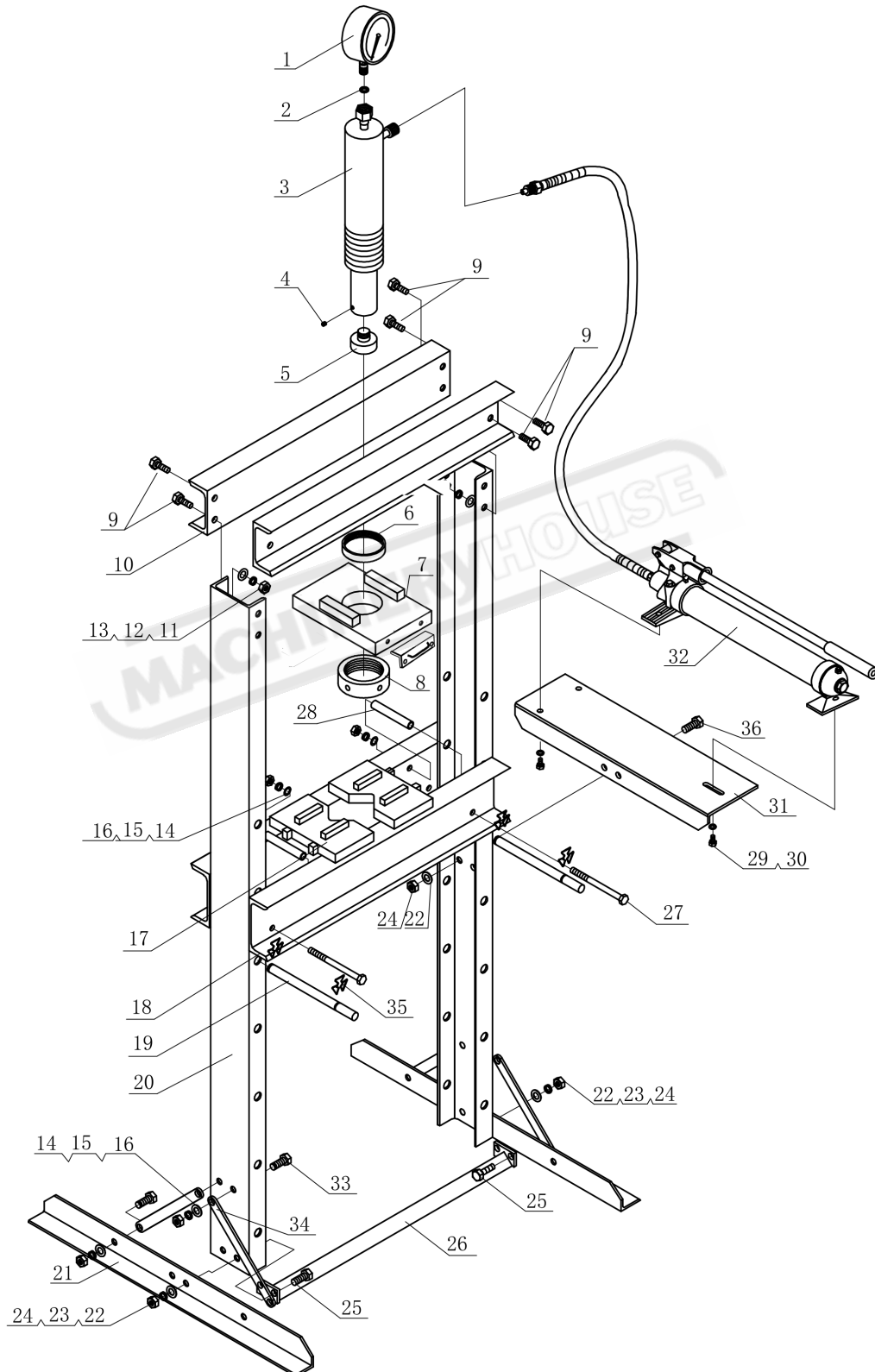
HP-20PP RAM SPARE PARTS DIAGRAM

HP-20PP RAM SPARE PARTS LIST

No.	Description	Qty	No.	Description	Qty
R1	Nut	1	R10	Spring	1
R2	Screw	1	R11	Screw	1
R3	Sealing Ring	1	R12	Gauge Coupler	1
R4	PTFE Ring	1	R13	Gauge Connecting Nut	1
R5	Bushing	1	R14	Pin	1
R6	O-Ring	1	R15	Joint	1
R7	Piston	1	R16	Ram	1
R8	Copper Ring	1	R17	Limited Ring	1
R0	Screw	1	R18	Nylon Ring	1

MACHINERYHOUSE

HP-20PP PRESS SPARE PARTS DIAGRAM



HP-20PP PRESS SPARE PARTS LIST

No.	Description	Qty	No.	Description	Qty
1	Gauge	1	19	Pin	2
2	Nylon washer	1	20	Post assembly	2
3	Ram assembly	1	21	Base section	2
4	Bolt	1	22	Washer M12	6
5	Serrated saddle	1	23	Locking washer M12	4
6	Upper round nut	1	24	Nut M12	6
7	Under plate	1	25	Bolt M12 x 35	4
8	Under round nut	1	26	Lower cross member	1
9	Bolt M16 x 35	8	27	Bolt M10 x 140	4
10	Upper crossbeam	2	28	Bushing	4
11	Washer M16	8	29	Bolt M8 x 16	3
12	Locking washer M16	8	30	Washer M8	3
13	Nut M16	8	31	Setting plate	1
14	Washer M10	12	32	Pump assembly	1
15	Locking washer M10	12	33	Bolt M10 x 25mm	8
16	Nut M10	12	34	Support bar	4
17	Heel block	2	35	Retaining clip	4
18	Press bed frame	2	36	Bolt M12 x 30	2



WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



WARNING

Hydraulic Press Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Check oil levels and fill to correct oil levels if necessary. Apply oil to surface of ram to maintain good lubrication.
- 2. Press Condition.** Press must be maintained for a proper working condition. Never operate a Press that has low oil levels, damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis. Check all hoses, pressure head, and support rods for cracks or damage. Replace if necessary.
- 3. V-Block Condition.** Never operate a Press with damaged or badly worn V-blocks. Replace if required.
- 4. Hand Hazard.** Keep hands away from the pressure head and out of support rod holes, under any circumstances, while the machine is in operation mode. Serious injury can occur.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Work area hazards.** Keep the area around the Press clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 7. Overloading Press.** Do not exceed the press capacity indicated on the gauge.
- 8. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 9. Material Hazard.** Do not compress springs or other objects that could be ejected from the press. Do not compress objects that could shatter. Serious injury can occur.
- 10. Secure Press.** Make sure you bolt the machine down so it is secure when in operation.
- 11. Use Correct Air Pressure** Exceeding the maximum PSI rating of Press may cause unpredictable operation, injury and damage to machine. If this rating is not stated in manual suggest NOT to exceed 125psi.
(Applies to Pneumatic model only).
- 12. Disconnect Air Pressure** before servicing Press, or leaving unattended.
(Applies to Pneumatic model only).
- 13. Air Hose - Trip Hazard** Hoses can easily become a tripping hazard when laid across the floor in a disorganized fashion.
(Applies to Pneumatic model only).
- 14. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Hydraulic Press

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace (WHSA 2011 No10)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies (Recommended for Purchase / Buyer / User)
B	CRUSHING	HIGH	Do not exceed maximum capacity. Check equipment for damage prior to use. Wear safety boots. Never put any part of your body between hydraulic ram and material. Always support material properly on hydraulic press. Ensure press is bolted down on level solid ground. Ensure table is as close as possible to ram and support pins are correctly positioned before using.
C	CUTTING, STABBING OR PUNCTURING	MEDIUM	Do not exceed recommended maximum PSI rating. (applies to Pneumatic model only) Use equipment in the correct manner as to avoid parts being ejected out under pressure.
E	STRIKING	MEDIUM	Use equipment in the correct manner as to avoid parts being ejected out under pressure.
G	HIGH PRESSURE AIR	MEDIUM	Disconnect air supply to press prior to checks or maintenance. Do not exceed recommended maximum PSI rating. (applies to Pneumatic model only)
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by: 
Safety officer:
Manager: 

Revised Date: 4th December 2017