

KRAFTWERK®

FAVORITE TOOLS SINCE 1979

Instruction Manual Hydraulic shop press

Art. 38121

EN


20 T



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SAFETY INSTRUCTIONS

PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFETY INSTRUCTIONS AND WARNINGS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE OF 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.

We've done all we can to assure this press offers the outmost in safety, but you have to do your part. No amount of warning can take the place of your good judgment, so make sure it's the first thing you bring to any job. Beyond that here are some obvious tips:

- Steel and others materials can shatter, so always use protective eye-wear that complies with the appropriate ANSI code.
- If you detect anything that may indicate imminent structural failure, stop using the press immediately and inspect it thoroughly.
- Bolt the press to the floor if it is to be used on bulky or unstable items.
- Do not use press to compress springs or any other item that could disengage and cause a potential hazard.
- Use a qualified person to maintain the press in good condition. Keep it clean for best and safest performance.
- Do not exceed the rated capacity. Never apply excessive force to a workpiece and always use the pressure gauge to accurately determine the applied load.
- 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.
- Keep children and unauthorized persons away from the work area.
- Remove ill fitting clothing. Remove ties, watches, rings and other loose jewelry and contain long hair.
- Wear ANSI approved impact safety goggles, full-face impact safety shield and heavy-duty work gloves when operating the press.
- Keep proper balance and footing, do not over-reach and wear nonskid footwear.
- 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.
- Inspect the press before each use. DO NOT use if bent, broken, cracked, leaking or otherwise damaged.
- Check to ensure that all applicable bolts and nuts are firmly tightened.
- Ensure that workpiece is center-loaded and secure.
- Keep hands and feet away from bed area at all times.
- Never stand directly in front of loaded press and never leave loaded press unattended.
- DO NOT operate the press when you are tired or under the influence of alcohol, drugs or any intoxicating medication.
- DO NOT allow untrained persons to operate 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. Only good quality hydraulic oil can be used.
- DO NOT expose the press to rain or any other kind of bad weather.
- If the press needs 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.

WARNING! The warnings, cautions and instructions discussed in this manual cannot cover all 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.

BEFORE FIRST USE

- a) Before first use of this product, purge away air from the hydraulic system: open the release valve by turning it counterclockwise. Pump several full strokes to eliminate any air in the system.
- b) Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.
- c) If under plate (37) is not in the centre, loose the screw (15) slightly, then slide the under plate to the position you need and tighten the screw.

OPERATIONG INSTRUCTIONS

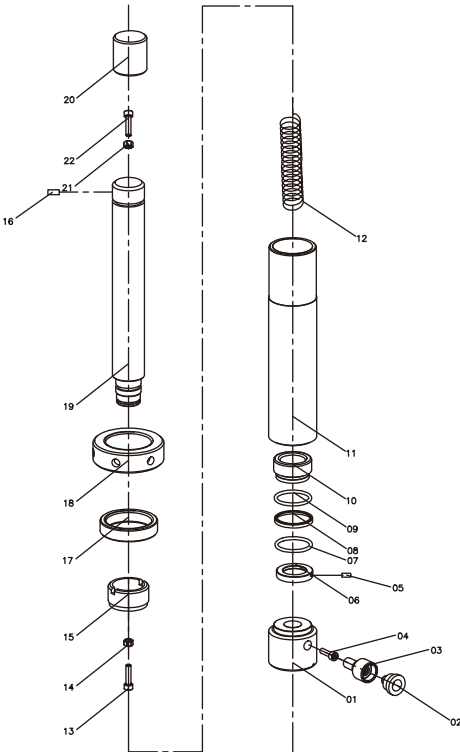
WARNING! ENSURE THAT YOU READ, UNDERSTAND AND APPLY THE SAFETY INSTRUCTIONS AND WARNINGS BEFORE USE.

- Place the heel block on press bed frame, then insert workpiece onto the heel block.
- Close the release valve by turning it clockwise until it is firmly closed.
- Pump the handle until the ram nears to the workpiece.
- Align workpiece and ram to ensure center-loading.
- Pump the handle to apply load onto workpiece.
- When work is done, stop pumping the handle, slowly and carefully remove load from workpiece by turning the release valve counterclockwise in small increments.
- Once ram has fully retracted, remove workplace from bed frame.

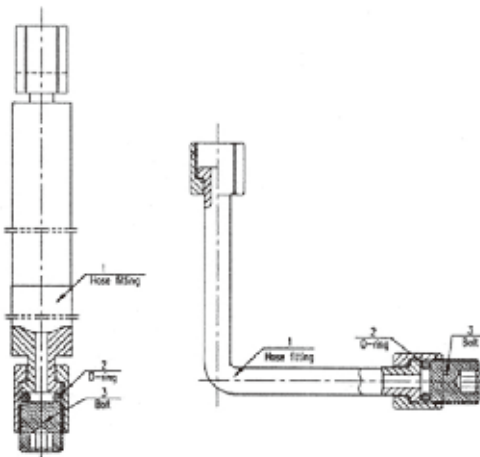
MAINTENANCE

- 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.
- When not in use, store the press in a dry location with ram and piston fully retracted.
- When press efficiency drops, purge always air from hydraulic system as described before.
- Check the hydraulic oil; remove the oil filler nut 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.

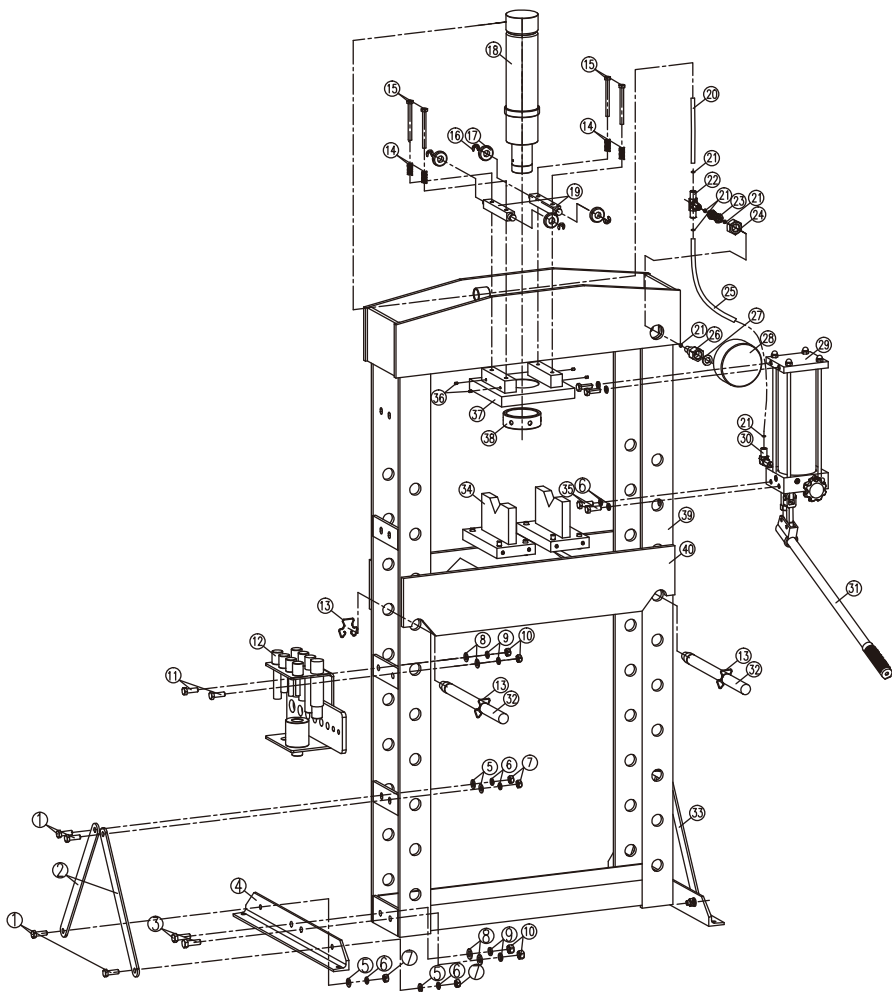
PART LIST
SHOP PRESS CYLINDER PARTS



No.	Description	QTY
1	Seat Of Cylinder	1
2	Dust Cap	1
3	Coupling Bolt	1
4	Screw	1
5	Bolt M6x7	1
6	Spacing Ring	1
7	Mow—ring	1
8	O-ring	1
9	Cup	1
10	Piston Ring	1
11	Cylinder	1
12	Spring	1
13	Bolt M8x40	1
14	Nut M6	1
15	Retainer Nut	1
16	Pin M8x10	1
17	Protecting Ring	1
18	Protecting Ring	1
19	Ram	1
20	Protecting Cap	1
21	Rectangular Ring	1
22	Bolt M8x10	1



The o-ring (2) and the bolt (3) are required for transportation only and must be removed before assembling.



No.	Description	QTY	No.	Description	QTY	No.	Description	QTY	No.	Description	QTY
01	Screw bolt M10x30	8	11	Screw bolt M12x30	2	21	O-ring	5	31	Handle	1
02	Support beam A	3	12	Press Pin Adapter Kit*	1	22	Connector	1	32	Support pins	2
03	Screw bolt M12x35	4	13	Retaining ring	4	23	Connector	1	33	Support beam B	1
04	Base support	2	14	Spring	4	24	Nut M20	1	34	Press V blocks set	2
05	Washer 10	8	15	Screw bolt M8x110	4	25	Hose fitting	1	35	Screw nut M10x25	4
06	Spring Washer 10	12	16	E-ring	4	26	Connector	1	36	Screw M5x8	4
07	Nut M10	8	17	Ball bearing	4	27	Nylon seal	1	37	Under plate	1
08	Washer 12	6	18	Press cylinder	1	28	Pressure gauge	1	38	Round lifting ring	1
09	Spring washer 12	6	19	Roller shaft	2	29	Hydraulic pressure pump	1	39	Frame	1
10	Nut M12	6	20	Hose fitting	1	30	Right angle connector	1	40	Bed frame	1

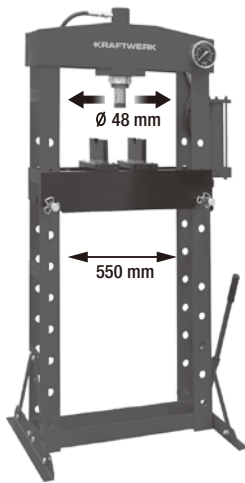
*Press Pin Adapter Kit (12) incl. connection material (8, 9, 10, 11) is available separately

ASSEMBLY INSTRUCTIONS

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

- Attach one base support (04) to left post and lower frame (39) using washers (05), spring washers (06), nuts (07) and screw bolts (03), then attach another to right post and the lower frame.
- Fix one end of support beam A (02) to the base support (04) and another end to the frame (39) using washers (05), washers (06), nuts (07) and screw bolts (01).
- Put another upper crossbeam into position and insert the under plate make a gap (37) to the two upper cross beams at the same time, then secure this cross beam to the posts using spring (14) and screw bolts (15).
- Screw the upper round nut onto the press cylinder (18), insert the ram into the hole in the under plate (37), then screw the under round nut onto the ram and attach the serrated saddle to the press cylinder.
- Insert bed support pins (32) into the holes in the posts, then insert the joined press bed frame (40) into press frame and onto bed frame pin.
- Attach the hydraulic pressure pump (29) to the right post using screw nuts (35), washers (06). Then insert the handle to the handle bracket.
- Connect the hydraulic hose fitting (25) to the nut (24) and assemble the pressure gauge (28) to the pressure gauge connection nut which is on the top of press cylinder (18).
- Tighten all bolts and screws.

PRODUCT DESCRIPTION



- Lateral movable cylinder with bearing (moving range: 360 mm)
- Pressure gauge with integrated housing
- Including pair of V-blocks

Capacity:	20 t
Stroke:	190 mm
Work range:	1000 mm
Work width:	550 mm
Stamp-Ø:	48 mm
Product size:	1610 x 865 x 560 mm
N.W.:	115 kg

DECLARATION OF CONFORMITY

Model: **38121**

Hydraulic shop press 20 T

KRAFTWERK Sàrl, 25 rue due Stade, F-67870 Bischoffsheim

Declares under sole responsibility that the product to which this declaration relates is in conformity with the following standard(s) or other normative document(s):

EN 1494: 2000+A1/2008

EN ISO 12100: 2010

EN ISO 13857: 2008

EN 349: 1993+A1/2008

Following the provisions of Directive(s)
Machinery Directive:

2006/42/EC

Bischoffsheim, 01/07/2018



Alexander Pieper
CEO

WARRANTY

We do not take responsibility for any damage caused by misuse or any use that is not in compliance with the safety standards described herein.

CUSTOMER SERVICES

Contact your local importer or your specialized dealer to obtain address of our service department.

**FROM DATE OF PURCHASE RECEIPT
2 YEAR GUARANTEE
ON MATERIAL OR PRODUCTION DEFECTS**

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