

20 ton Electric Press Set-up Instructions

All warranties void if instructions are not followed

Shipping Crate: *Please save the shipping crate*, it has been specially designed to protect the ram and gauge during shipping. You will need to ship the ram back to the factory for new seals every 3-5 years depending upon use. It must be shipped in this crate.

SAVE THIS MANUAL

You will need this manual for safety instructions, assembly and operating instructions and parts list. Put it in a safe, dry place for further reference.

READ ALL INSTRUCTIONS BEFORE ASSEMBLING OR OPERATING THE PRESS

SAFETY WARNINGS & CAUTION

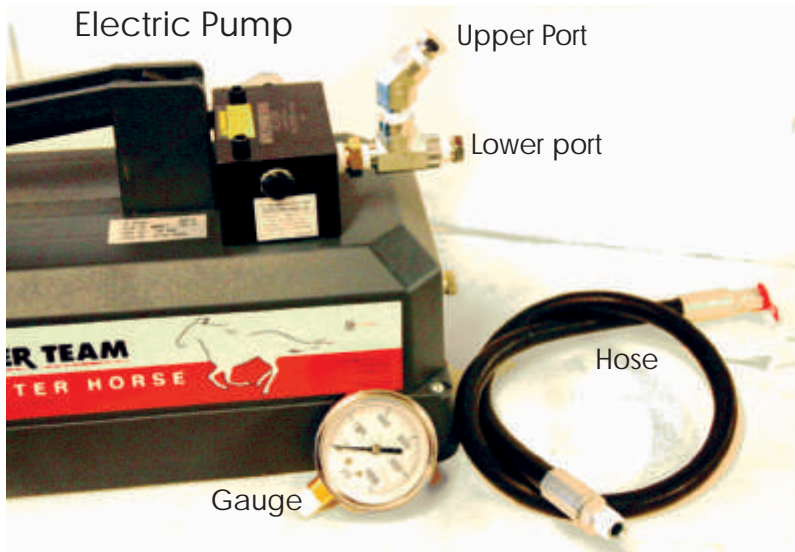
- 1. KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
- 2. KEEP CHILDREN AWAY.** All children should be kept away from work area.
- 3. DO NOT ASSEMBLE OR OPERATE THE PRESS IF UNDER THE INFLUENCE OF ALCOHOL, OR DRUGS.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not attempt to assemble or operate.
- 4. AVOID MOVING PARTS DURING OPERATION.** Keep fingers and hands away from all moving parts.
- 5. USE EYE and FACE PROTECTION.** Wear ANSI approved impact safety face and eye protection.
- 6. DRESS SAFELY.** Protective, gloves and non-skid footwear or safety shoes are recommended when working with and operating the Press. Don't wear loose clothing or jewelry. They can get caught in moving parts. Also, wear a protective hair covering to prevent long hair from getting caught in the Press.
- 7. DON'T OVERREACH.** Keep proper footing and balance at all times.
- 8. DO NOT COMPRESS SPRINGS, do not press cast iron, or any fragile or brittle objects.** Do not press items that could disengage and cause a potential hazard.
- 9. STAY ALERT.** Watch what you are doing. Use common sense. Do not operate any tool when you are tired.
- 10. 20 TON LIMIT.** Do not operate the hydraulic jack beyond rated capacity.
- 11. BOLT PRESS TO BENCH.**
- 12. ALWAYS CENTER YOUR WORK,** do not press anything off-center. Look at your setup from multiple angles to insure that everything is centered within the press.
- 13. REPLACEMENT PARTS AND ACCESSORIES.** When servicing, use only identical replacement parts. Only use Approved accessories intended for use with this Press.

Identify all Parts Electric Press

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Identify all parts



* only used with MKIII models



Lay the ram on it's side, have a rag or two handy to wipe up leaks.



Use the supplied hex ket to undo the port plug at the base of the ram.

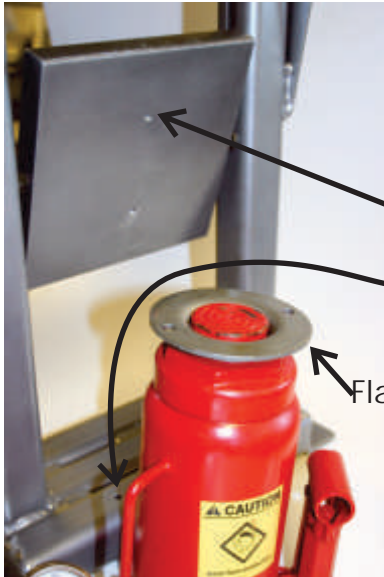


Hand thread the brass colored nipple into the port, hand thread only at least two turns.



Only after hand threading should you tighten the nipple with a 9/16" wrench.

Assembly



Step 1. Place the flange over the top of the ram as shown at left in *Figure 1*.

Note the two threaded holes in the bottom of the lower platen, check the threads to make sure they are clear of debris. Also notice the one hole in the bottom of the press frame.

Flange

Figure 1

Step 2. Placing the jack into the press frame: Slide the ram with flange into place on the frame (*Figure 2*). If needed, use a screwdriver to pry up the platen bolt located inside the hole (see *Figure 3*) on one of the upright posts as you slide the ram into position.

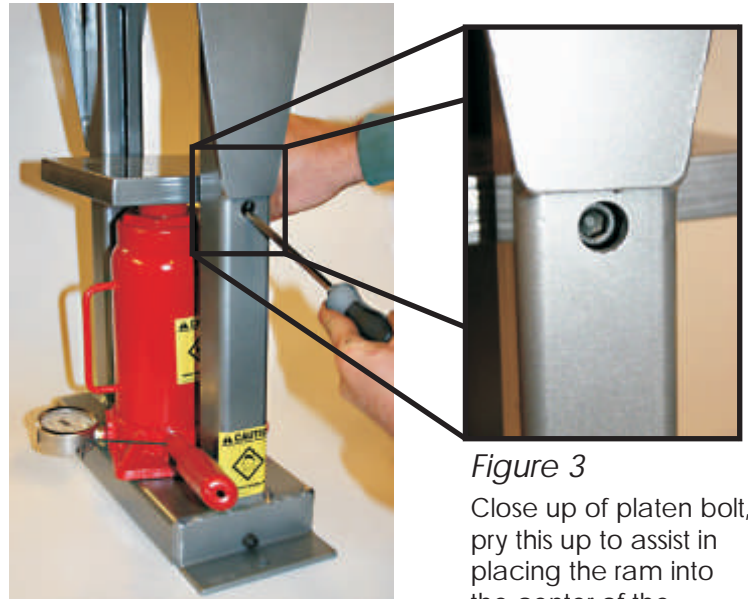


Figure 2

Lift the lower platen by using a screwdriver to pry the platen bolt.

Figure 3

Close up of platen bolt, pry this up to assist in placing the ram into the center of the frame.

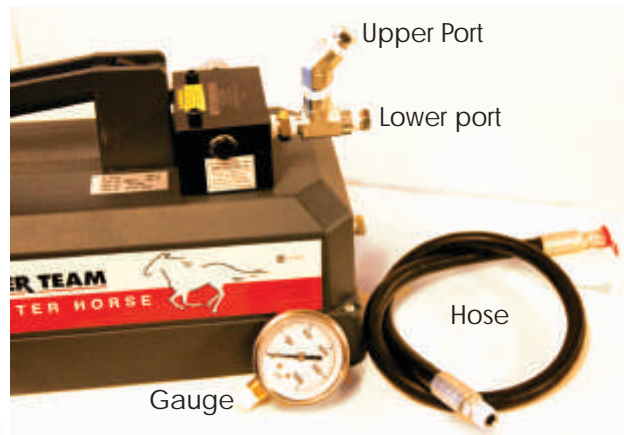


Step 3. Thread the two supplied cap-head screws through the holes in the flange and into the two threaded holes in the lower platen using the supplied hex key.



Step 4. Locate the hole in the ram body over the hole located in the press frame. Drop the pin* in place to keep the ram located in the center of the frame. * only used with MKIII models

Identify the parts of the electric pump



Unscrew the plug on the upper port shown using a 9/16" wrench



Hand thread the gauge into the upper port a minimum of 2 full threads before applying a wrench.



Use a 9/16" wrench to tighten



Reorient the pump in the upright position, unscrew the plug on the lower port as shown.

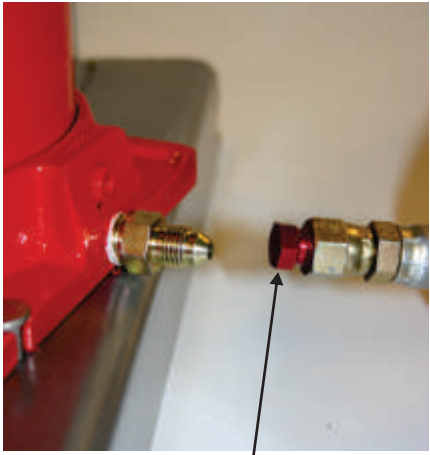


Hand thread the hose into the lower port a minimum of two full turns.



Tighten the hose with a 9/16" wrench.

Electric Press Attach the pump hose



Remove and save the hose end plugs
Replace end plugs when shipping.



Carefully align the hose end to the ram nipple



Tighten with a 9/16" wrench
Do not use teflon tape on this connection.

When using the electric pump for the first time there may be a delay in the ram movement at first. Raise the ram three or four inches and release to the bottom of the stroke, repeat several times to help bleed any excess air.

Never raise the ram more than 5" with an electric press. if you raise the ram more than 5" you will pump hydraulic oil into the rams reservoir by way of an overflow valve (similar to your bathroom sink) which prevents the oil from returning to the pumps reservoir. This will possibly void all warranties and may make it necessary to ship the ram and pump back to the manufacturer for repair.



When the pump switch is set to "Hold" the ram will stay in position when the pump is off.



With the pump switch set to "Return" the ram will descend after each use.

Only use "Hydraulic Jack Oil".

Electric Press: Check the level through the reservoir fill plug hole located at the gauge end of the electric pump with the gauge end of the pump oriented up. With the ram all the way down follow the instructions located on the gauge end of the electric pump.

Use only "Hydraulic Jack Oil".

Change the oil often to save the seals. The first oil change should be performed no more than 6 months after purchase, change every 6 months thereafter, more frequently with heavy use.

The ram should be lowered all the way down at the end of each days use. This keeps the ram clean and free of dust and debris which wears on the seals.

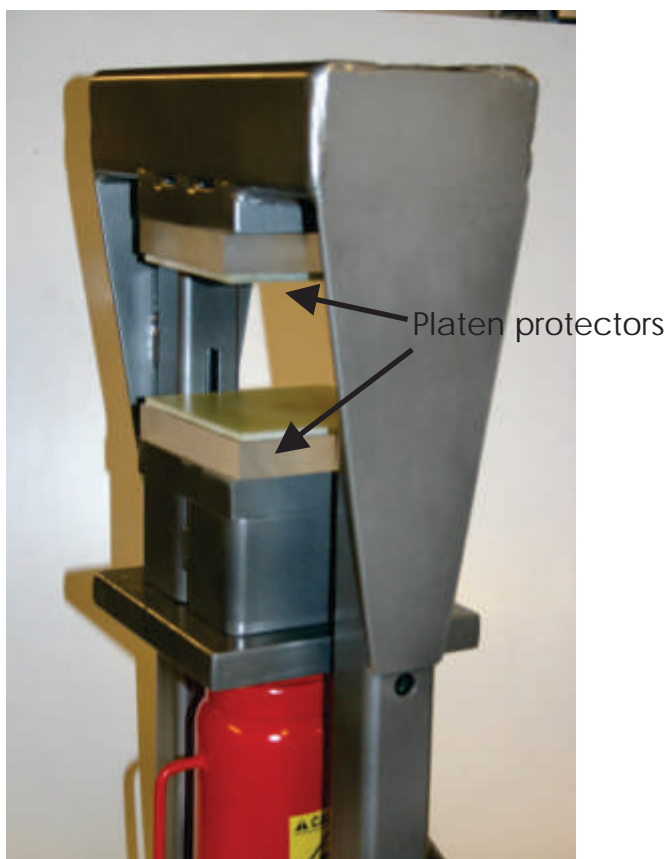
Always center your work in the press, look at your work from multiple angles to insure that the work and dies are well centered.

Always wear face protection.

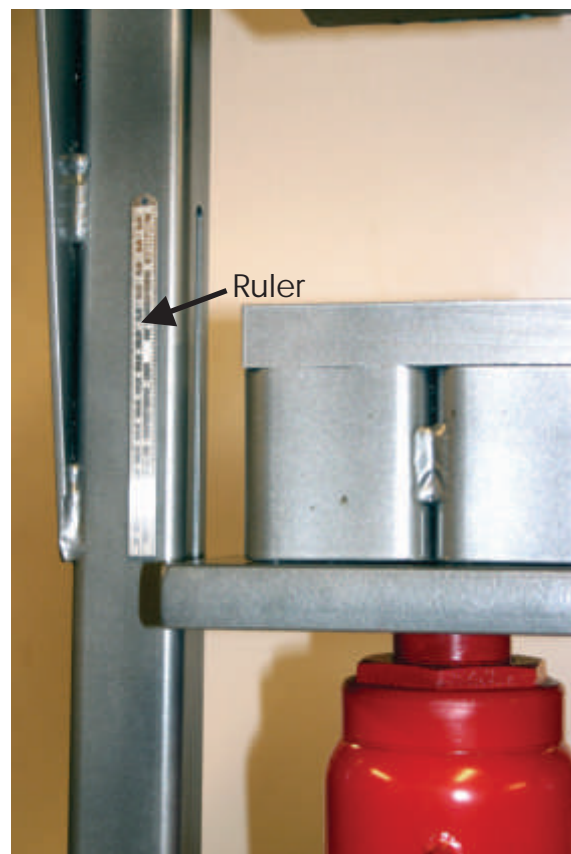
Never extend the ram more than 5", (*This is most important with the electric pump models.*) Always use at least (1) 1" thick platen which prevents over extension of the ram.

Tip: add a 6" ruler to the uprights with the "0" mark of the ruler adjacent to the top side of the lower platen. See below right.

If you have problems that you are unable to solve please call Rio Grande Tech Support @800-545-6566 Have your model and serial number ready for fast help.



Press shown with two platen protectors in place which keeps the ram from over-extending.



Place a ruler on an upright and use it to keep from over-extending the ram.