

20 TON HYDRAULIC SHOP PRESS

Item Number W41063

OWNER'S MANUAL

1 YEAR WARRANTY

PERFORMANCE TOOL® extends only the following warranties, and only to original retail purchasers. These warranties give specific legal rights. Except where prohibited by local law, the law of the State of Washington governs all warranties and all exclusions and limitations of warranties and remedies. There may be other rights which vary from state to state.

PERFORMANCE TOOL® warrants the product to be free from defects in materials and workmanship under normal use and service. A defective product may be returned for a free replacement within 90 days from the date of purchase, provided that product is returned to place of purchase immediately after discovery of defect. After 90 days and up to one year from date of purchase, PERFORMANCE TOOL® will replace at no charge any parts which our examination shall disclose to be defective and under warranty. These warranties shall be valid only when a sales receipt showing the date of purchase accompanies the defective product or defective part (s) being returned. For part (s) after 90 days, please remit your request, postage prepaid to:

PERFORMANCE TOOL, P.O. Box 88259 Tukwila, WA 98138

These warranties exclude blades, bits, punches, dies, bulbs, fuses, hoses, and other consumables which must be replaced under normal use and service. These warranties shall not apply to any product or part which is used for a purpose for which it is not designed, or which has been repaired or altered in any way so as to affect adversely its performance or reliability, nor shall these warranties apply to any product or part which has been subject to misuse, neglect, accident or wear and tear incident to normal use and service.

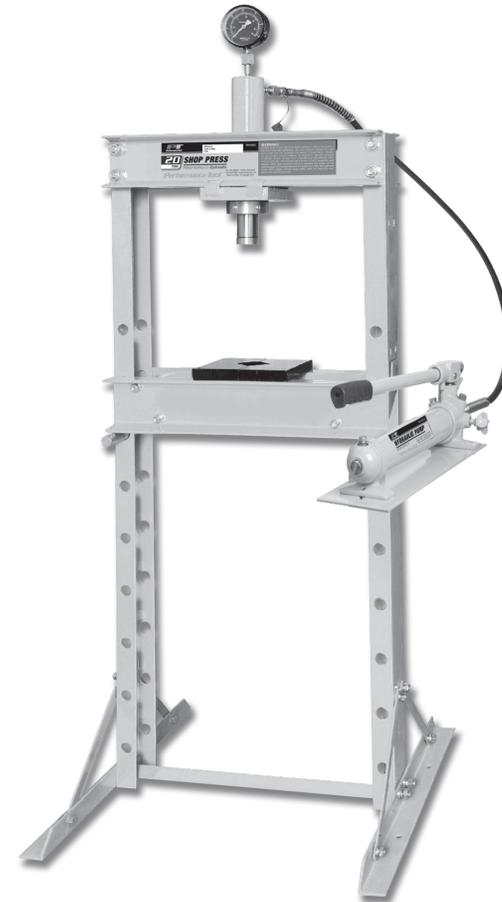
PERFORMANCE TOOL® does not authorize any other person to make any warranty or to assume any liability in connection with its products.

Except for warranties of title and the limited express warranties set forth above, PERFORMANCE TOOL® makes no express or implied warranties of any kind with respect to its products. In particular, PERFORMANCE TOOL® makes no implied warranty of merchantability and no implied warranty of fitness for any particular purpose, except that for goods purchased primarily for personal, family or household use and not for commercial or business use. PERFORMANCE TOOL® makes an implied warranty of merchantability (and, if otherwise applicable, an implied warranty of fitness for a particular purpose), but only for the particular qualities or characteristics, and for the duration, expressly warranted above.

The laws on limitation of implied warranties may differ from state to state, so the above limitations may not apply in all cases.

PERFORMANCE TOOL® shall not be liable for consequential, incidental or special damages resulting from or in any manner related to any product, or to the design, use, or any inability to use the product. The sole and exclusive remedy for a defective product or part shall be the repair, or replacement thereof as provided above. The laws on limitation of remedies or on consequential, incidental or special damages may vary from state to state, so the above limitations may not apply in all cases.

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▲WARNING!

READ, UNDERSTAND AND FOLLOW ALL INSTRUCTIONS AND WARNINGS BEFORE OPERATING THIS TOOL. FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY AND/OR PROPERTY DAMAGE AND WILL VOID WARRANTY.

PT
Performance Tool

Performance Tool®

SPECIFICATIONS

Max. Capacity:.....40,000 lbs.
 Working Range:.....0 to 35-3/4 in. (0-910 mm)
 Stroke:.....7.5 in. (180 mm)
 Bed Width:.....19.5 in.(495 mm)

Specifications are subject to change without notice.

SAFETY GUIDELINES / DEFINITIONS

This instruction manual is intended for your benefit. Please read and follow the safety, installation, maintenance and troubleshooting steps described within to ensure your safety and satisfaction. The contents of this instruction manual are based upon the latest product information available at the time of publication. The manufacturer reserves the right to make product changes at any time without notice.

▲WARNING: Read and understand this entire instruction manual before attempting to assemble, install, operate or maintain this product. Failure to comply with the instructions may result in serious personal injury and/or property damage!

The following signal words are used to emphasize safety warnings that must be followed when using this product:

▲DANGER: Indicates an imminently hazardous situation that, if not avoided, WILL result in death or serious injury.

▲CAUTION: Indicates a potentially hazardous situation that, if not avoided, MAY result in minor or moderate injury.

▲WARNING: Indicates a potentially hazardous situation that, if not avoided, COULD result in death or serious injury.

▲NOTE: Indicates important information, which if not followed, MAY cause damage to equipment.

UNPACKING AND INSPECTION

After opening the carton, unpack your new product and related parts and accessories. Please inspect it carefully for any damage that may have occurred during transit. Please check it against the photograph on carton. If any parts are missing, please call customer service at 1-800-426-1262 between 6 a.m. and 5 p.m. Pacific time.

▲WARNING: DO NOT operate this product if damaged during shipment, handling or misuse. Do not operate the product until the parts have been replaced or the fault rectified. Failure to do so may result in serious personal injury or property damage. All damaged parts must be repaired or replaced as needed prior to operating this product. Check to see that all nuts, bolts and fittings are secure before putting this product into service.

If you have any questions, or require assistance with damaged or missing parts, please contact our customer service department at 1-800-426-1262. Please have the serial number, model number, and date of purchase available for reference when calling.

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

1. Use a qualified person to maintain the press in good condition. Keep it clean for best and safest performance.
2. The maximum load is 20 tons. 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.
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.
4. Keep children and unauthorized persons away from the work area.
5. Remove loose fitting clothing. Remove ties, watches, rings and other loose jewelry, and contain long hair.

OPERATING INSTRUCTIONS

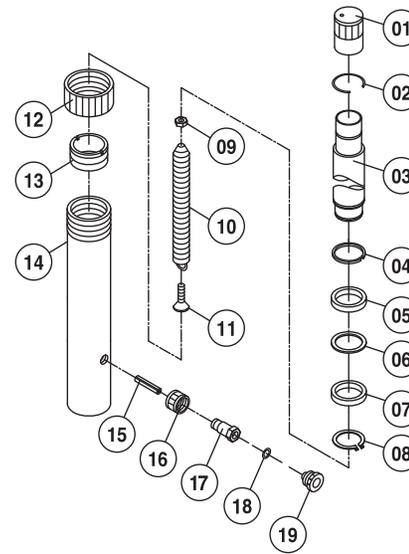
1. Place the heel block on press bed frame, then insert workpiece onto the heel block.
2. Close the release valve by turning it clockwise until it is firmly closed.
3. Pump the handle until serrated saddle nears workpiece.
4. Align workpiece and ram to ensure center-loading.
5. Pump the handle to apply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

CARE & MAINTENANCE

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.
2. When not in use, store the press in a dry location with ram and piston fully retracted.
3. When press efficiency drops, purge the hydraulic system to eliminate any air in the system.
4. Check the hydraulic oil: Remove the oil filler nut on the pump, if it 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.

RAM EXPANDED PARTS LIST

No.	Description	Qty.
1	Cover	1
2	Circlip.....	1
3	Piston Rod	1
4	Circlip.....	1
5	Bushing	1
6	Nylon Ring	1
7	Sealing Ring.....	1
8	Circlip.....	1
9	Nut	1
10	Spring	1
11	Screw	1
12	Protection Cup.....	1
13	Ring.....	1
14	Cylinder.....	1
15	Screw	1
16	Coupling Ring	1
17	Coupling Ring	1
18	O-ring.....	1
19	Dust Cap.....	1



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:

1. Attach one base section (21) to left post (20), add the support straps (39) to the base and post. Do this using the bolts, washers, lock washers and nuts (22, 23, 24, 25). Attach the other base section and straps to the right post.
2. Attach the lower cross member (26) to the posts using bolts, washers, lock washers and nuts (22, 23, 24, 25).
3. Put the press frame in an upright position. Slide the under plate (7) onto the lower lip of the two upper cross beams (10). Attach the two upper cross beams with the under plate to left and right posts using bolts, washers, lock washers and nuts (9, 11, 12, 13).
4. Insert the upper round nut (6) into the hole in the under plate. Insert the ram (3) into the hole in the under plate.
5. Screw the upper round nut onto the ram until snug. Screw the under round nut (8) onto the ram and secure with a punch and soft face mallet.
6. Insert bed frame pins (19) into the holes in the posts, then insert the press bed frame (18) into press frame and onto bed frame pin. Attach bed frames using bolts washers, lock washers and nuts (27, 14, 15, 16).
7. Attach the setting plate (31) to the right post using bolts, washers, lock washers and nuts, (22, 23, 24, 25) then secure the pump assemblies (32) using the bolt and washers (29, 30), and then insert the handle (33) to the handle bracket.
8. Connect the hydraulic hose fitting (36) to the connection nut (37) and assemble the pressure gauge (1) on the pressure gauge connection nut (2, 38) which is on the top of ram.
9. Tighten all bolts and screws.
10. Place heel block (17) on the press bed frame.

BEFORE FIRST USE

1. 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. Close release valve.
2. Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.

IMPORTANT SAFETY INFORMATION

▲WARNING! PLEASE READ THESE SAFETY INSTRUCTIONS AND 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.

6. Wear ANSI approved impact safety goggles, full-face impact safety shield and heavy-duty work gloves when operating the press.
7. Keep proper balance and footing, do not overreach and wear nonskid footwear.
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.
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.
10. Check to ensure that all applicable bolts and nuts are firmly tightened.
11. Ensure that workpiece is center-loaded and secure.
12. Keep hands and feet away from bed area at all times.
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 loaded press and never leave loaded press unattended.
14. DO NOT operate the press when you are tired or under the influence of alcohol, drugs or any intoxicating medication.
15. DO NOT allow untrained persons to operate the press.
16. DO NOT make any modifications to the press.
17. 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 jack oil can be used.
18. DO NOT expose the press to rain or any other kind of bad weather.
19. If the press needs repairing and/or there is any part that needs 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 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.

EXPANDED PARTS LIST

No.	Description	Qty.	No.	Description	Qty.
1.	Pressure gauge	1	21.	Base section	2
2.	Nylon ring	1	22.	Washer Ø12	10
3.	Ram assy.....	1	23.	Lock washer Ø12	10
4.	Lock nut M6	1	24.	Nut M12.....	10
5.	Serrated saddle	1	25.	Bolt M12x30	6
6.	Upper round nut	1	26.	Lower cross member.....	1
7.	Under plate.....	1	27.	Bolt M10x130	4
8.	Under round nut	1	28.	Bushing	4
9.	Bolt M16x35	8	29.	Screw M8x15.....	3
10.	Upper cross beam.....	2	30.	Washer Ø8.....	3
11.	Nut M16.....	8	31.	Setting plate	1
12.	Lock washer Ø16	8	32.	Pump assy.....	1
13.	Washer Ø16.....	8	33.	Handle	1
14.	Washer Ø10.....	14	34.	Oil filler nut	1
15.	Lock washer Ø10	14	35.	Hydraulic hose.....	1
16.	Mut M10	14	36.	Hose fitting	1
17.	Heel Block	2	37.	Connection nut.....	1
18.	Press bed frame	2	38.	Gauge connection nut.....	1
19.	Bed frame pin.....	2	39.	Support.....	4
20.	Post	2	40.	Bolt M10x25	10

