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machinery specialists since 1968

75 Ton Shop Press *(Pneumatic/Hydraulic)*



03696

**FOR HELP OR ADVICE ON THIS PRODUCT PLEASE CONTACT YOUR DISTRIBUTOR,
OR SIP DIRECTLY ON:
TEL: 01509500400
EMAIL: sales@sip-group.com or technical@sip-group.com
www.sip-group.com**

***Please read and fully understand the instructions in this manual
before operation. Keep this manual safe for future reference.***

DECLARATION OF CONFORMITY

Declaration of Conformity

We

SIP (Industrial Products) Ltd
Gelders Hall Road
Shepshed
Loughborough
Leicestershire
LE12 9NH
England

As the manufacturer's authorised representative within the EC
declare that the


75 Ton Shop Press (Pneumatic/Hydraulic) - SIP Part No. 03696

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC Machinery Directive

And the relevant standard(s), including:

EN ISO 12100:2010
EN 1494:2000+A1:2008

Signed: 

Mr P. Ippaso - Managing Director - SIP (Industrial Products) Ltd
Date: 02/09/2016.



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SAFETY SYMBOLS USED THROUGHOUT THIS MANUAL



Danger / Caution: Indicates risk of personal injury and/or the possibility of damage.



Note: Supplementary information.

SAFETY INSTRUCTIONS



IMPORTANT: Please read the following instructions carefully, *failure to do so could lead to serious personal injury and / or damage to the Shop press.*

When using your Shop press, basic safety precautions should always be followed to reduce the risk of personal injury and / or damage to the Shop press or load.

Read all of these instructions before operating the Shop press and save this user manual for future reference.

The Shop press should **not** be modified or used for any application other than that for which it was designed.

It was designed for the removal or installation of bearings, universal joints, pulleys, etc.

If you are unsure of its relative applications do not hesitate to contact us and we will be more than happy to advise you.

Before operating the Shop press always check no parts are broken, that no oil is leaking and that no parts are missing.

Always operate the Shop press safely and correctly.

KNOW YOUR SHOP PRESS: Read and understand the owner's manual and labels affixed to the Shop press. Learn its applications and limitations, as well as the potential hazards specific to it.

KEEP CHILDREN AND UNTRAINED PERSONNEL AWAY FROM THE WORK AREA: All visitors should be kept at a safe distance from the work area; never allow untrained persons to operate the Shop press.

STAY ALERT: Always watch what you are doing and use common sense.

NEVER LEAVE THE SHOP PRESS UNATTENDED: When in use / under load.

HAVE YOUR SHOP PRESS REPAIRED BY A QUALIFIED PERSON: The Shop press is in accordance with the relevant safety requirements. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user and void the warranty.

DANGER! Check that the shop press is in sound condition and good working order; Take immediate action to repair or replace damaged parts.

NOTES

WARNING! Only operate on a level and stable surface and never use on soft ground where the Shop press is likely to “sink” whilst in operation.

Ensure that the shop press is securely bolted to the ground before putting into service.

NEVER STAND ON THE SHOP PRESS: The Shop press is not designed for this purpose.

DO NOT dismantle or tamper with the Shop press, as this may be dangerous and will invalidate the warranty.

- If a problem with the Shop press is experienced or suspected stop using the Shop press **immediately** and contact your distributor for repair.
- Do not attempt to press a load that exceeds the rated capacity of the shop press.
- Never work under the Shop press whilst in operation.
- Regularly inspect, clean and lubricate the Shop press, ensuring that it is in good working order and condition.
- Always ensure that the work area is clean and tidy, free from unrelated materials and has adequate lighting.
- Keep hands, limbs etc. clear of moving parts during operation of the ram.
- **DO NOT** top-up the Shop press with brake fluid, or other oil types; use hydraulic oil only.
- **DO NOT** adjust the safety overload valves.
- Ensure that there are no persons or obstructions beneath the Shop press whilst its in operation.
- Clean the Shop press correctly, with the ram in the retracted position, **DO NOT** leave it extended.
- Failure to follow the warnings in this manual, may result in personal injury and/or property damage.
- Prior to applying the load, be sure that the hydraulic ram collar threads are fully engaged to the head assembly.
- Components of this Shop press are specially designed to withstand the rated capacity. Do not substitute bolts, pins, or any other components.
- Always press the load on the centre of the ram. Offset loads can damage the ram, and may cause a workpiece to eject.
- Before operating, check for signs of cracked welds, bent bed support pins, loose or missing bolts, or any other structural damage. Do not operate if any of these conditions exist. Have repairs made only by authorised service centre.
- Remove all loads and arbor plates from the bed before attempting to adjust the bed height.
- Press only on the workpiece supported by the bed and arbor plates.
- When using accessories, such as arbor plates, be sure that they are centered on the bed, and are in full contact with the bed.
- Parts being pressed may splinter, shatter or eject from the press. Due to various applications, it is your responsibility to always use adequate guards, such as eye protection and heavy protective clothing, when operating this Shop press.
- Do not stand in front of work area where the load is applied.

SAFETY INSTRUCTIONS....cont

- If the Shop press appears to be damaged in any way, is found to be badly worn, or operates abnormally **IT SHOULD BE REMOVED FROM SERVICE** until necessary repairs are made by an authorised service centre.
- **DO NOT** use the Shop press to compress springs or any other item that could disengage and cause a potential hazard.
- Understand the operating environment; Before each use the operator should assess, understand and where possible reduce the specific risks and dangers associated with the operating environment. Bystanders should also be made aware of any risks associated with the operating environment.



Danger / Caution: Never exceed the maximum capacity of 75 tons, over-loading can lead to personal injury or damage to the Shop press.



CAUTION: The warnings and cautions mentioned in this user manual can not 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 applied.

GUARANTEE

This SIP Shop press is covered by a 12 month parts and labour warranty covering failure due to manufacturers defects. This does not cover failure due to misuse or operating the Shop press outside the scope of this manual - any claims deemed to be outside the scope of the warranty may be subject to charges including, but not limited to parts, labour and carriage costs.

This guarantee does not cover consumables such as oil, arbor plates etc.

In the unlikely event of warranty claims, contact your distributor as soon as possible.

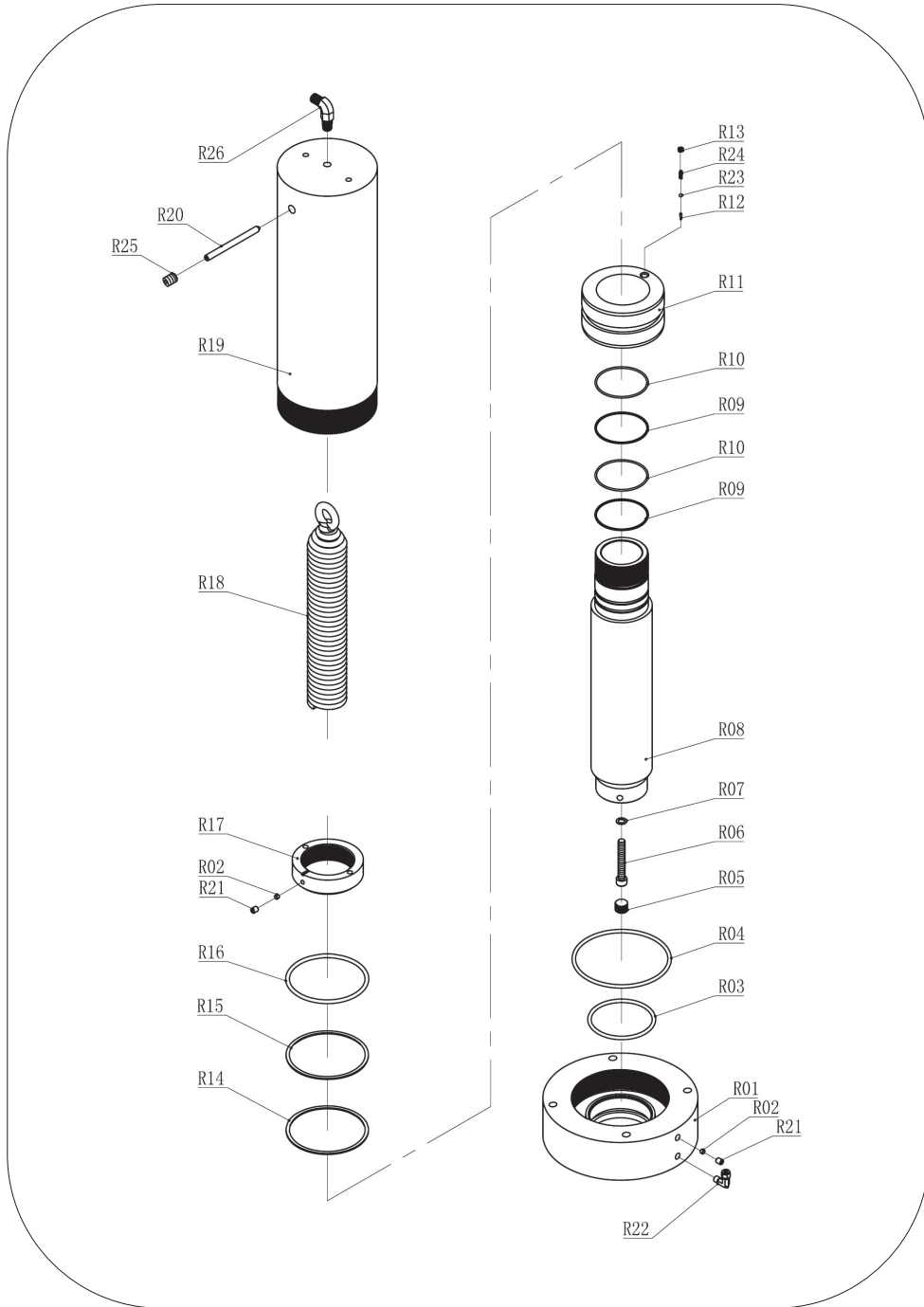


Note: Proof of purchase will be required before any warranty can be honoured.

PARTS LIST - RAM

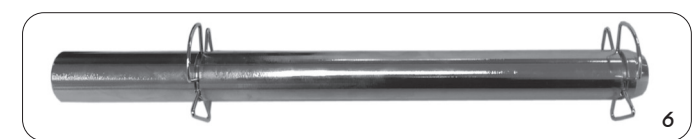
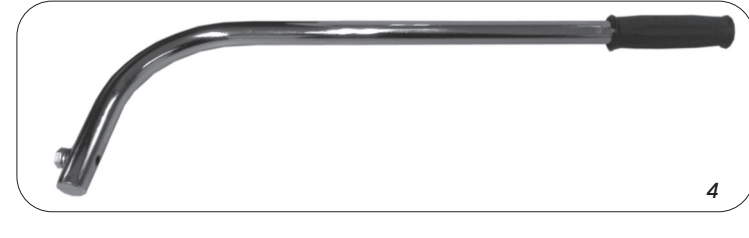
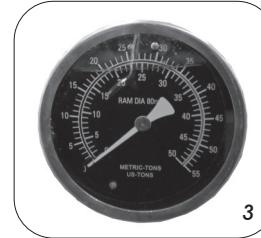
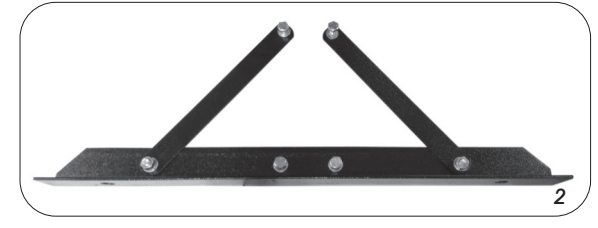
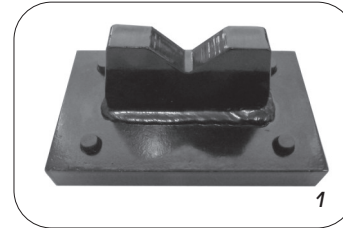
Ref. No.	Description	Ref. No.	Description
R01.	big round nut	R14.	washer
R02.	block	R15.	retainer ring
R03.	o ring	R16.	o ring
R04.	o ring	R17.	nut
R05.	plug	R18.	spring
R06.	screw	R19.	ram
R07.	copper ring	R20.	pin
R08.	piston rod	R21.	screw
R09.	washer	R22.	connector
R10.	o ring	R23.	steel ball
R11.	piston head	R24.	spring
R12.	valve core	R25.	plug
R13.	screw	R26.	connector

EXPLODED DRAWING - RAM



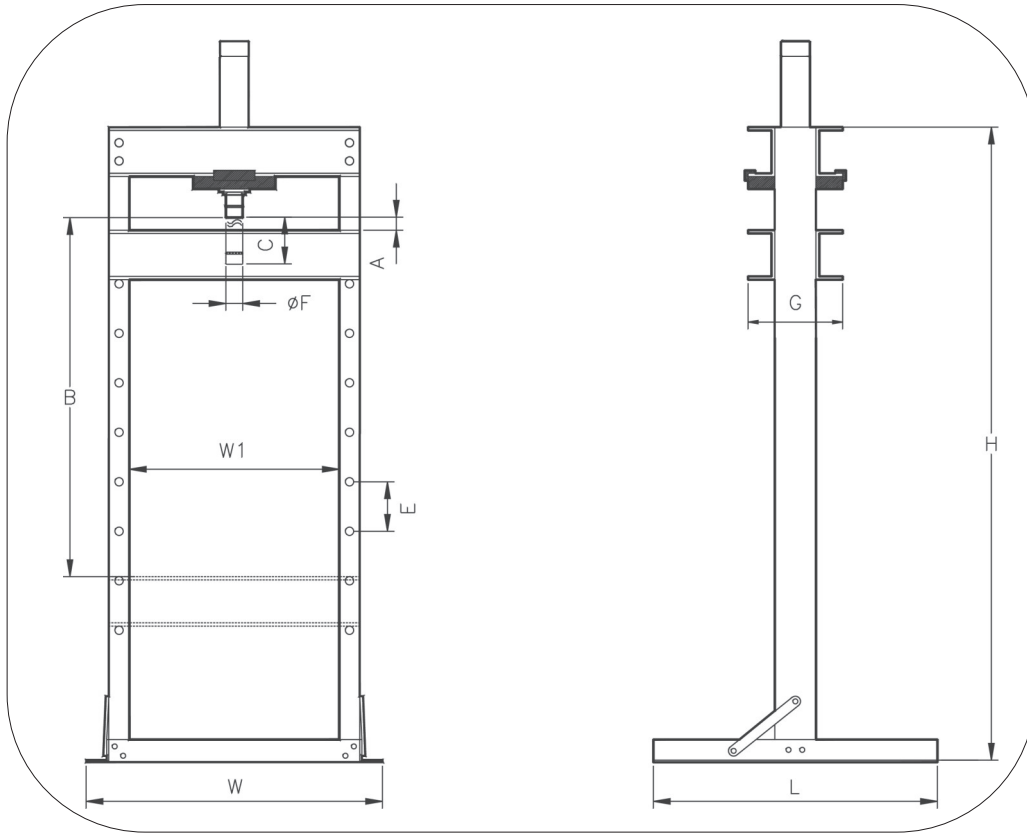
CONTENTS & ACCESSORIES

1. Arbor plate x2	5. Air Pedal
2. Leg / Leg Supports x2 (c/w Fixings)	6. Bed Pin x4 inc. Clips x8
3. Manometer	N/A. Frame (c/w ram/winch/pump/bed)
4. Pump Handle	N/A. Instruction Manual



Note: If any of the above are missing or damaged, contact your distributor immediately.

TECHNICAL SPECIFICATIONS

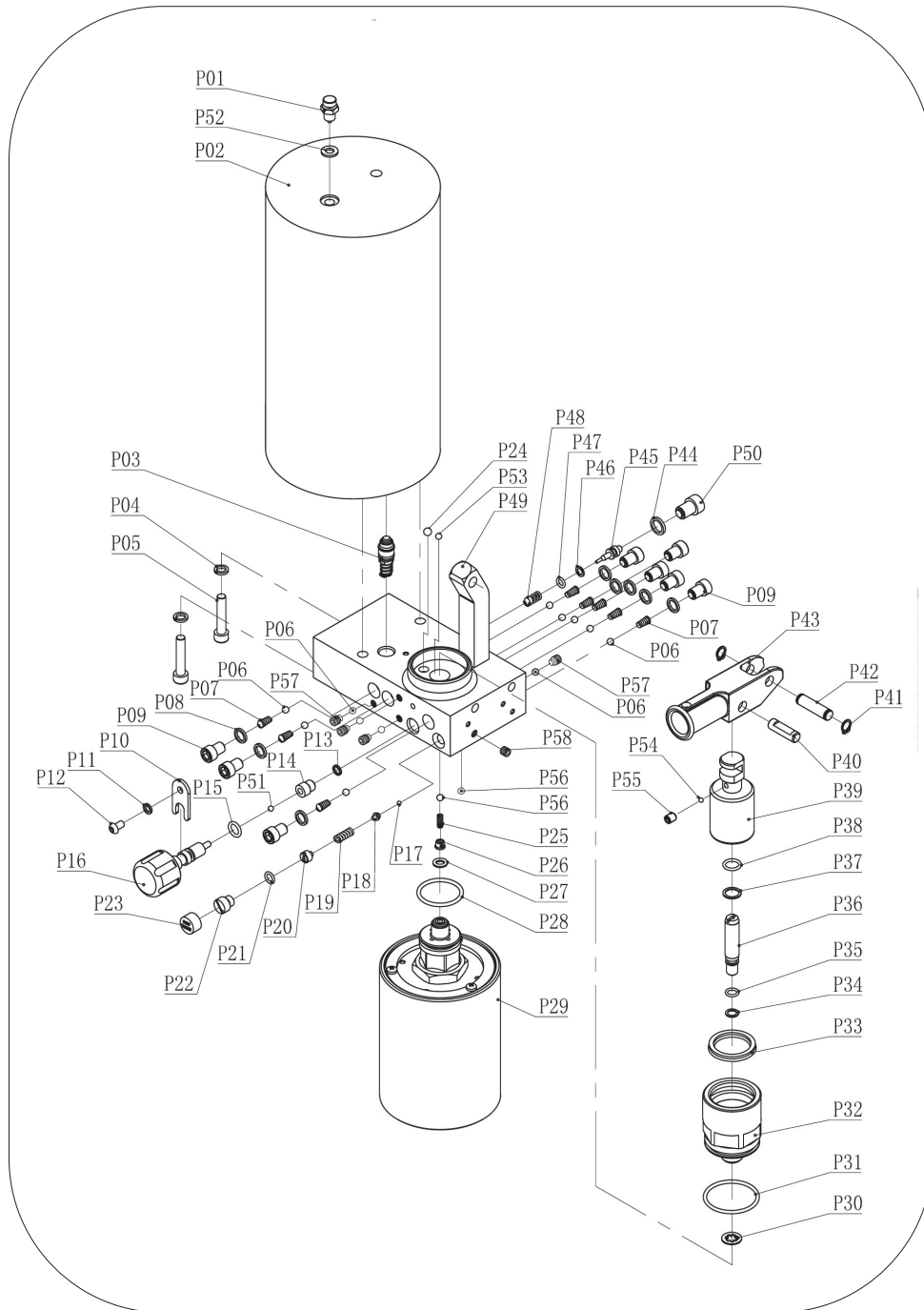


A.	160mm	H.	1840mm
B.	880mm	W.	1150
C.	250mm	W1.	800mm
E.	105mm	L.	800mm
F.	75mm	Total Height.	1940mm
G.	280mm	Operating Air Pressure.	7.5-8.5 bar

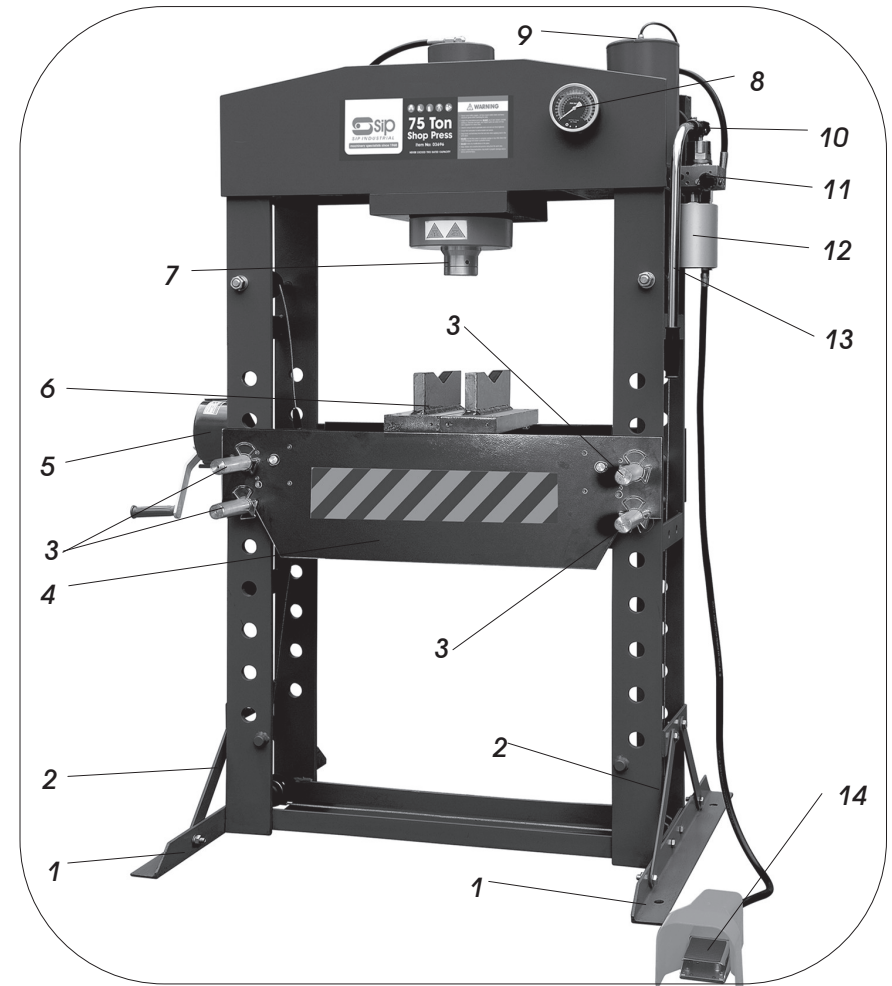
PARTS LIST - PUMP

Ref. No.	Description	Ref. No.	Description
P1.	breath screw	P30.	copper washer
P2.	oil tank	P31.	o ring
P3.	connector	P32.	hand pump core
P4.	lock washer	P33.	u ring
P5.	screw	P34.	o ring
P6.	steel ball	P35.	washer
P7.	spring	P36.	small pump core
P8.	copper ring	P37.	washer
P9.	screw	P38.	o ring
P10.	limit	P39.	big pump core
P11.	lock washer	P40.	pin
P12.	screw	P41.	retainer ring
P13.	washer	P42.	pin
P14.	valve base	P43.	handle socket
P15.	o ring	P44.	copper washer
P16.	release valve	P45.	control valve core
P17.	steel ball	P46.	o ring
P18.	base for steel ball	P47.	washer
P19.	spring	P48.	spring
P20.	screw	P49.	pump
P21.	o ring	P50.	screw
P22.	screw	P51.	steel ball
P23.	cap	P52.	washer
P24.	steel ball	P53.	steel ball
P25.	spring	P54.	steel ball
P26.	spring base	P55.	screw
P27.	copper washer	P56.	steel ball
P28.	o ring	P57.	screw
P29.	air pump	P58.	screw

EXPLODED DRAWING - PUMP



GETTING TO KNOW YOUR SHOP PRESS



Ref. No	Description	Ref. No	Description
1.	Leg	8.	Manometer (gauge)
2.	Leg Supports	9.	Air Vent / Oil Filler Screw
3.	Bed Pin	10.	Hydraulic Pump
4.	Bed	11.	Release Valve
5.	Bed Winch	12.	Air Motor
6.	Arbor Plate	13.	Pump Handle
7.	Hydraulic Ram	14.	Air Pedal (Valve)

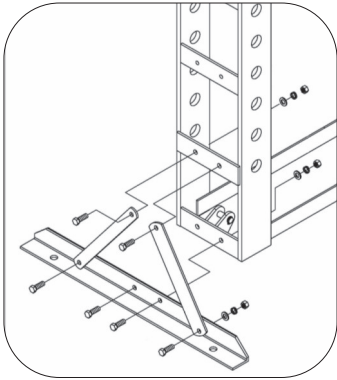
ASSEMBLY INSTRUCTIONS



Caution: Due to the weight of the shop press; Correct lifting equipment should be used during assembly.

FITTING THE LEGS

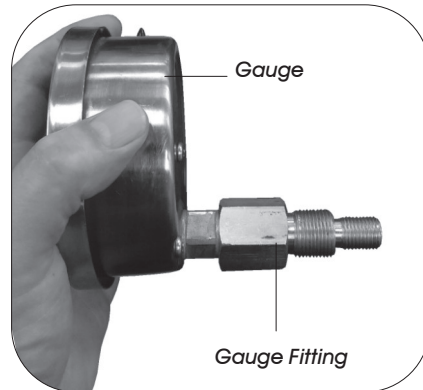
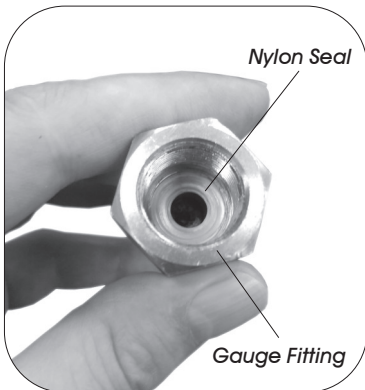
- ⇒ Connect the leg (1) to either the left or right post by using the bolts (2), washers (6), spring washers (5) and nuts (4), do not tighten fully just yet.
- ⇒ Connect both leg supports (3) to the post and leg, by using bolts, washers, spring washers and nuts.



- ⇒ Repeat the process for the opposite post.
- ⇒ Ensure everything is level, then proceed to tighten all the bolts/nuts.

FITTING THE GAUGE

- ⇒ Fit the nylon seal (72) into gauge fitting (51), then fit the pressure gauge (50) to the fitting and tighten fully.



PARTS LIST - MAIN...cont

Ref. No.	Description	Ref. No.	Description
59.	air inlet hose	68.	handle grip
60.	plug	69.	steel cable
61.	air valve	70.	steel cable
62.	wire protect cover	71.	connector
63.	steel ball	72.	Nylon Seal
64.	handle	73.	screw
65.	air inlet hose	74.	connector
66.	bolt	75.	air hose connector
67.	flat washer	76.	spring

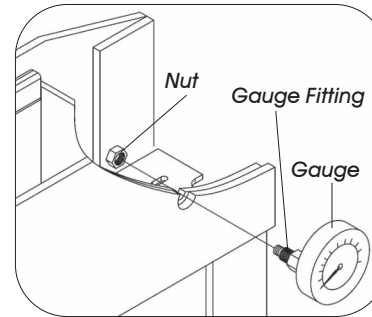
PARTS LIST - MAIN

Ref. No.	Description	Ref. No.	Description
1.	foot	30.	pin
2.	bolt	31.	working table
3.	support bar	32.	steel block
4.	nut	33.	screw
5.	lock washer	34.	spring
6.	flat washer	35.	roller wheel
7.	pin	36.	cover
8.	retainer ring	37.	cover
9.	big roller wheel	38.	beam
10.	cover 1	39.	bearing
11.	cover 2	40.	retainer ring
12.	hand winch	41.	spring
13.	fix plate	42.	ram plate
14.	bolt	43.	frame
15.	flat washer	44.	lifting beam
16.	lock washer	45.	bolt
17.	nut	46.	ram
18.	pin	47.	screw
19.	retainer ring	48.	screw
20.	bushing	49.	adaptor
21.	bushing assembly	50.	pressure gauge
22.	nut	51.	gauge connector
23.	lock washer	52.	nut
24.	flat washer	53.	pump
25.	retainer ring	54.	bolt
26.	roller wheel	55.	o ring
27.	cover	56.	hose
28.	cover	57.	hose
29.	screw	58.	PU hose

ASSEMBLY INSTRUCTIONS....cont



Note: Ensure that the gauge is tight against the fitting so that it will not leak oil from the connection.

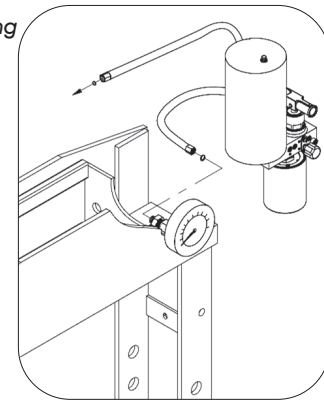
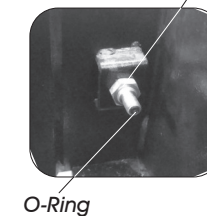
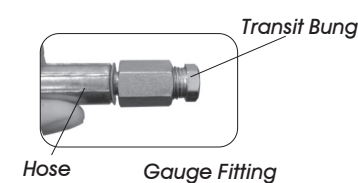
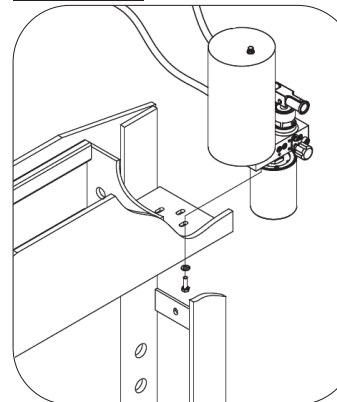


⇒ Attach the gauge fitting to the upper cross beam and secure by fully tightening the nut (52).

FITTING THE PUMP



Note: before assembly open the bleed valve on top of the pump.

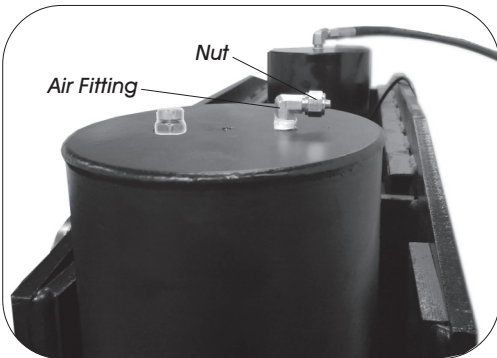


- ⇒ Fit the pump assembly (53) to frame by using bolts (54) and washers (15) and fully tighten to secure.
- ⇒ Remove the transit bung from the shortest hose.
- ⇒ Ensure that an o-ring is fitted to the gauge fitting.
- ⇒ Fit the hose onto the gauge fitting and tighten to fully secure.
- ⇒ Follow these instructions to fit the longer hose from the top of the ram to the fitting next to the gauge hose on the pump..

ASSEMBLY INSTRUCTIONS....cont



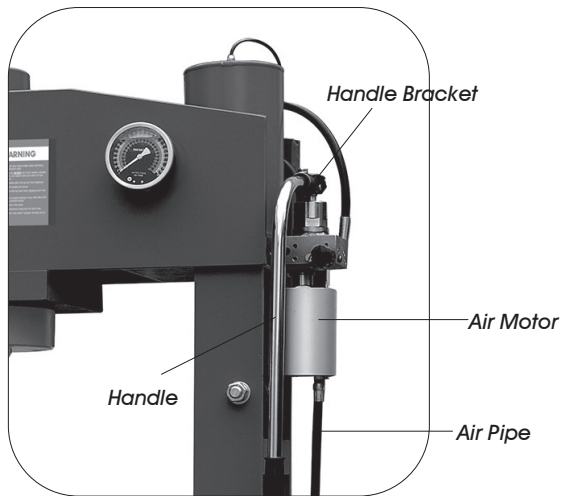
Note: Take care when removing the transit bungs as there is oil in the system that could leak if the hose is not handled carefully.



Air Fitting
Nut



- ⇒ Remove the nut from the air fitting on top of the pump.
- ⇒ Locate the air pipe from the ram unit.
- ⇒ Fit the nut over the air pipe.
- ⇒ Push the pipe over the fitting on top of the ram and tighten the nut to secure.



Handle Bracket

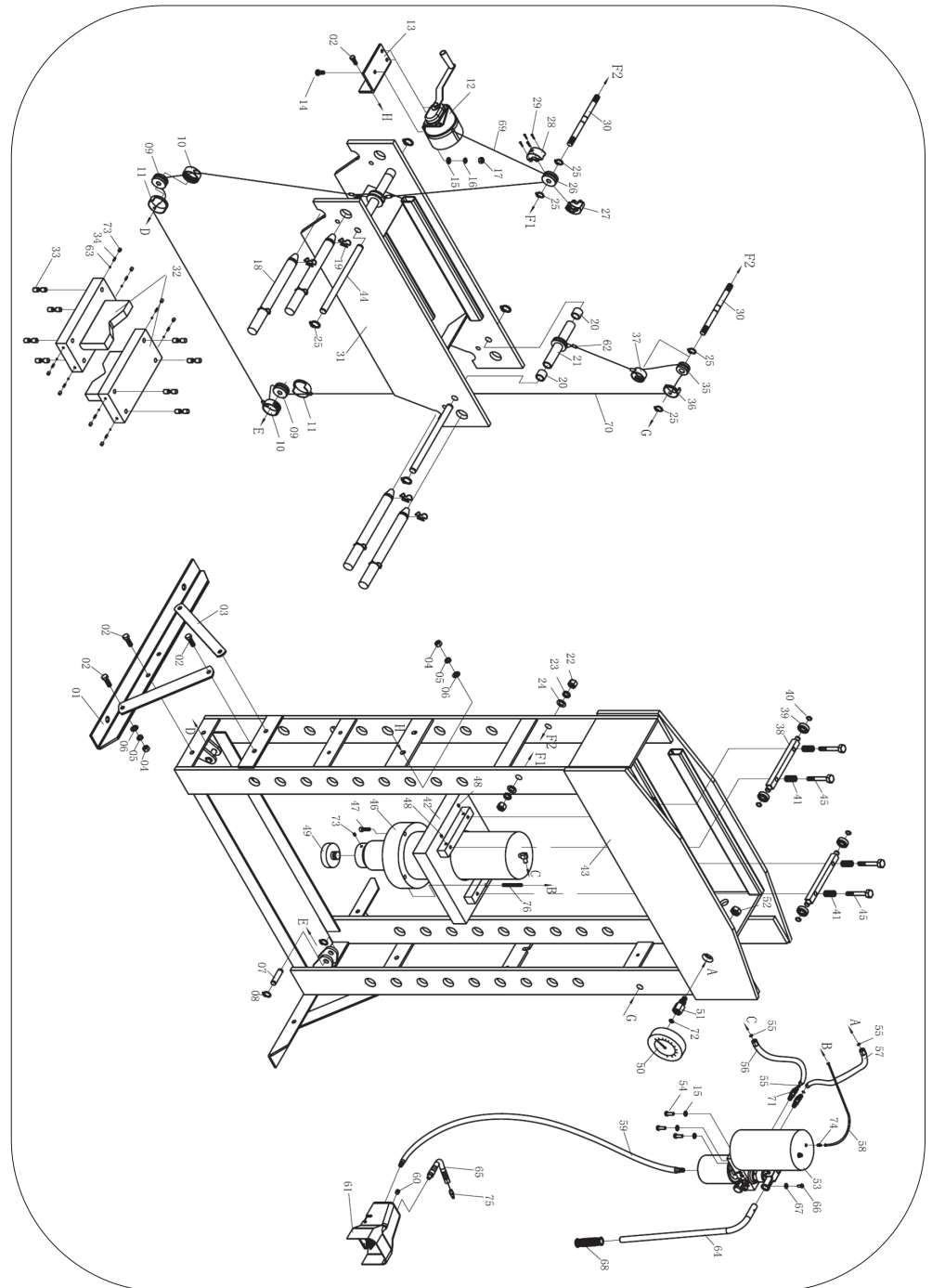
Air Motor

Handle

Air Pipe

- ⇒ Place some thread seal, or similar around the threads at the end of the foot pedal air pipe.
- ⇒ Fit the pipe to the bottom of the air motor and fully tighten to secure.
- ⇒ Fit the handle into the handle bracket and use the bolt to secure in place.

EXPLODED DIAGRAM - MAIN



TROUBLESHOOTING

The following form lists the common operating issues with problems and solutions. Please read the form carefully and follow it.



If any of the following symptoms occurs during your operation, stop using the Shop press immediately, or serious personal injury could result. Only a qualified person or an authorised service centre should perform repairs on the Shop press. Disconnect from the air supply before attempting repairs or adjustments. When replacing parts etc.

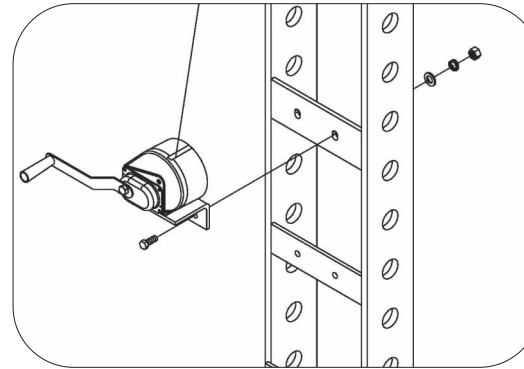
FAULT	POSSIBLE CAUSES	POSSIBLE REMEDIES
Loses pressure under load.	<ul style="list-style-type: none"> ● Release valve is open. ● Pump or piston fault. 	<ul style="list-style-type: none"> ● Close release valve. ● Replace pump.
Pump feels spongy during pumping, or lever has lost stroke.	<ul style="list-style-type: none"> ● Pump low on oil. ● Air trapped in pump. ● Pump or ram fault. 	<ul style="list-style-type: none"> ● Top up with oil. ● Bleed air out of system. ● Replace pump/ram.
Ram is weak or does not reach rated pressing capacity.	<ul style="list-style-type: none"> ● Pump low on oil. ● Air trapped in pump. ● Release valve is open. ● Pump or piston fault. 	<ul style="list-style-type: none"> ● Top up with oil. ● Bleed air out of system. ● Close release valve. ● Replace pump.



Note: Repairs should be carried out by a qualified person.

ASSEMBLY INSTRUCTIONS...cont

FITTING THE WINCH



⇒ Move the hand winch (12) to the outside of the post, then use bolts (02), washers (06), lock washers (05), and nuts (04) to secure it in place.

OPERATING INSTRUCTIONS

- ⇒ Place the bed to your desired height; Turn the winch clockwise to raise the bed and anti clockwise to lower.
- ⇒ Use the bed support pin (x4) and bed support pin clips (x8) to secure in place.
- ⇒ Place the arbor plate on the bed, then place the workpiece onto the arbor plate.



Danger / Caution: At all times use all 8 bed support pin clips to secure the bed support pins, using without the bed support pin clips is dangerous, this could cause injury to you or any one in the vicinity, this will also damage the Shop press and void your warranty.

- ⇒ Turn the release valve clockwise to close it.
- ⇒ Open the air vent / oil fill screw on top of the pump.
- ⇒ Connect the air supply to the air valve inlet connection on the foot pedal, press the foot pedal down and the ram will start to move (use the pump handle if no air supply is available).
- ⇒ Once the serrated saddle is near the workpiece take your foot off the pedal (or stop pumping the handle).
- ⇒ Align the workpiece and ram to ensure centre loading.
- ⇒ Press the foot pedal down again (or pump the handle) to start the pressing.
- ⇒ Once the work is done take your foot from the foot pedal (or stop pumping the handle).
- ⇒ Turn the release valve anti-clockwise to retract the ram.
- ⇒ When the ram has fully retracted, remove the workpiece.
- ⇒ If no more work is to be done, then disconnect from the air supply and retighten the release valve and air vent / oil fill screw.

MAINTENANCE

- ⇒ Periodically check the press frame to make sure all bolts are tight and inspect for cracked welds, bent, loose, or missing parts.
- ⇒ Periodically check hydraulic connections for possible leaks, replace or properly repair damaged or leaking hydraulic components before use.
- ⇒ Change hydraulic oil in the hydraulic system every 100 working hours, or more frequently in unusual dirty or dusty areas.
- ⇒ If the paint becomes badly chipped, it is suggested to repaint the press. This will prevent rusting.
- ⇒ Always ensure that ram is in the fully retracted position if the press is not used for extended periods.

ADDING OIL

- ⇒ Make sure the ram is fully retracted.
- ⇒ Remove the air vent / oil fill screw.
- ⇒ Fill with hydraulic oil (#22 ISO6743) through the oil fill hole, until the oil reaches the top of the oil chamber.
- ⇒ Refit the air vent / oil fill screw.

BLEEDING

- ⇒ Loosen the air vent / oil fill screw.
- ⇒ Insert the handle into the handle base.
- ⇒ Pump the handle about 10 times, this will purge the air out of the system.
- ⇒ retighten the air screw.

CLEANING

Periodically check the ram and ram piston for signs of rust or corrosion. Clean as needed and wipe with an oily cloth.



Note: Never use sandpaper or abrasive material on these surfaces.