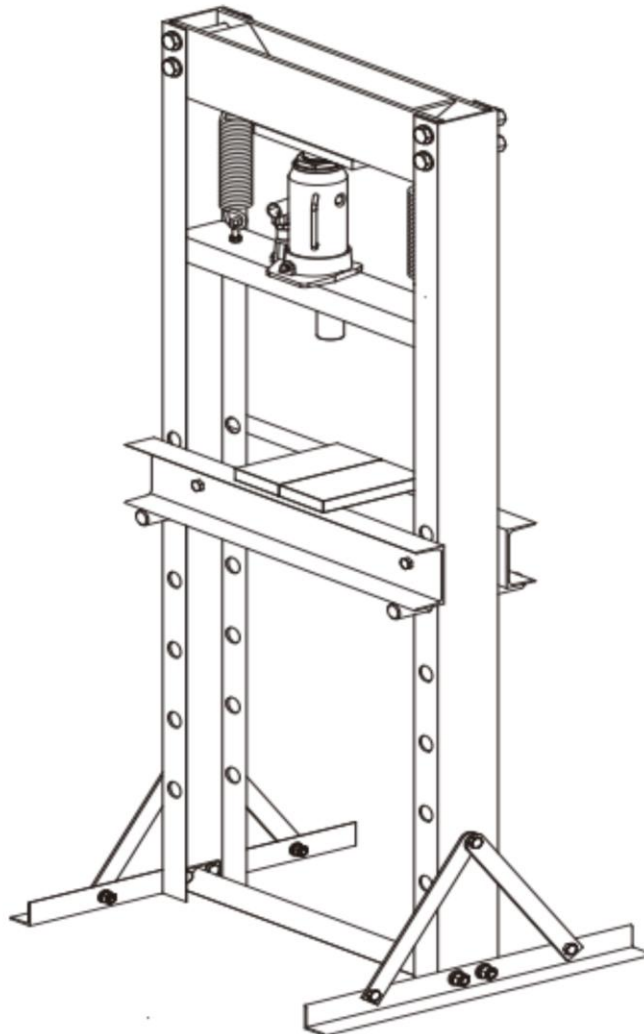
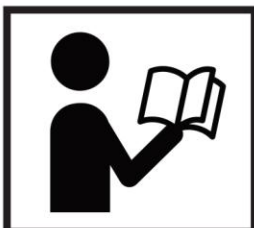


# 20 TON SHOP PRESS



## ⚠ WARNING



- Please read and understand the product manual completely before assembly
- Check against the parts list to make sure all parts are received
- Wear proper safety goggles or other protective gears while in assembly
- Do not return the product to dealer. They are not equipped to handle your requests.

Missing parts or have questions on assembly?

Please call: 1-877-761-2819 or email: [cs@tmgindustrial.com](mailto:cs@tmgindustrial.com)

## TECHNICAL SPECIFICATIONS

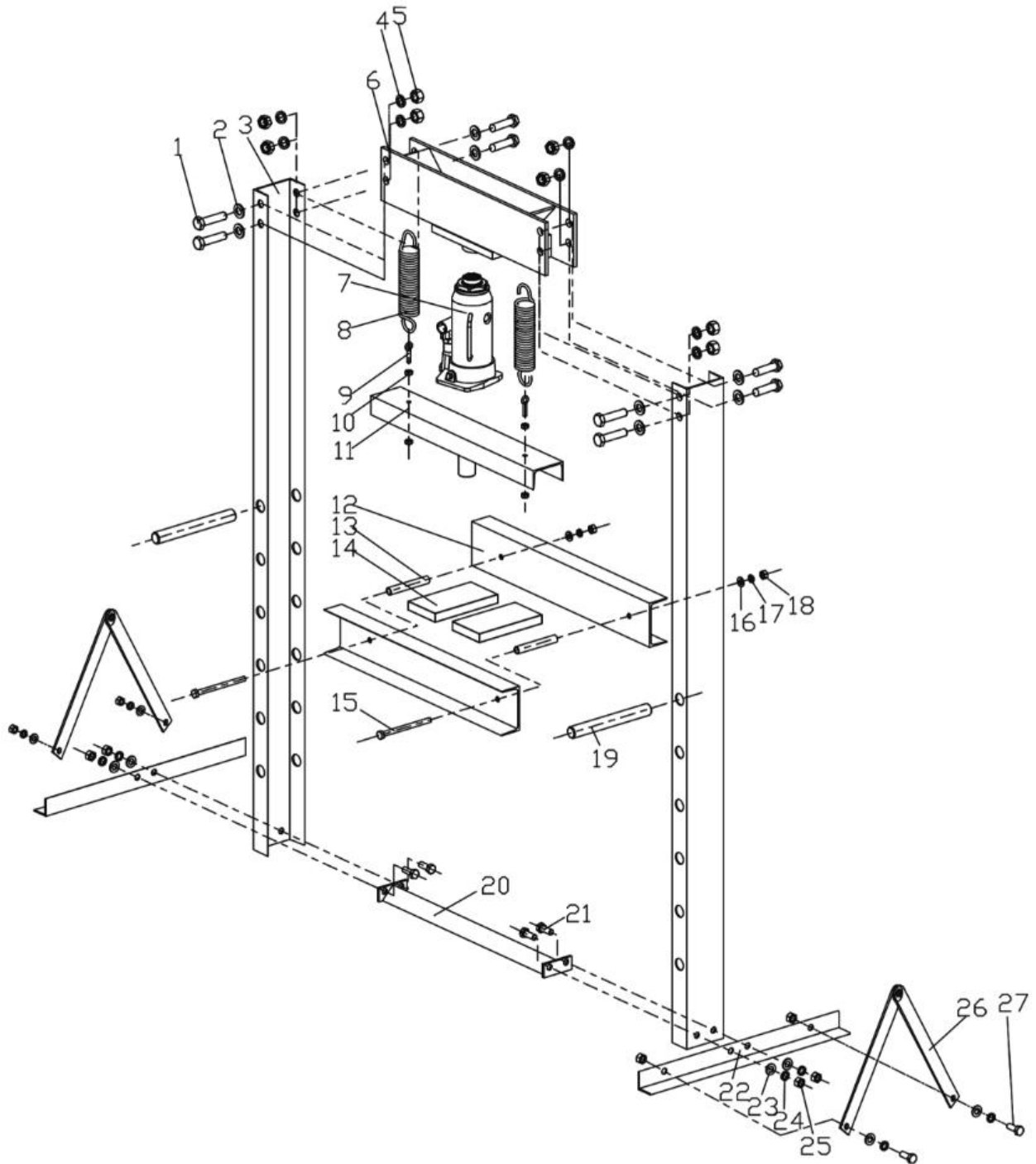
	DESCRIPTION
Item	TMG-ASP20
Capacity	20TON
Bed Opening	100mm
Work Range	0~710mm
Stroke Length	150mm
Inside Bed Dimensions L x W	100x460mm
Dimensions L x W x H	640x540x1495mm
Hydraulic Oil	ISO VG 15

## SAFETY MARKINGS

### **WARNING!**

1. Study, understand, and follow all instructions before operating the device.
2. Do not exceed rated capacity.
3. Prior to use, make sure the press is securely anchored.
4. The press shall be installed and operated in accordance with instructions.
5. Ensure the work area is clean and free of any hazards before operation.
6. Keep hands, arms, feet, and legs out of the work area. Accidental slippage can result in personal injury.
7. Use appropriate guarding to contain any pieces that may break or fly apart when applying force.
8. Use only press accessories having a capacity rating equal to or greater than the capacity of the press.
9. Verify lift cables are slack before pressing on the bolster.
10. Avoid off-center loads.
11. No alterations shall be made to the product.
12. Do not use this press for any use other than the manufacturer specified usage.
13. Failure to heed and understand these instructions and markings may result in personal injury, property damage, or both.

# SHOP PRESS PARTS LIST



# PARTS LIST

## SHOP PRESS PARTS LIST

NO	DESCRIPTION	QTY
1	Bolt M16x40	8
2	Washer 16	8
3	Knighthead	2
4	Spring washer 16	8
5	Nut M16	8
6	Top beam component	1
7	Pump	1
8	Spring	2
9	Hook	2
10	Nut M6	4
11	Upper slot part	1
12	Middle slot	2
13	Support tube	2
14	Block	2

NO	DESCRIPTION	QTY
15	Bolt M10x130	2
16	Washer 10	10
17	Spring washer 10	10
18	Nut M10	10
19	Support pin	2
20	Connection plate	1
21	Bolt M12x30	4
22	Base support	2
23	Washer 12	4
24	Spring washer 12	4
25	Nut M12	4
26	Support arm	4
27	Bolt M10x25	8

## 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 Base support (22) to left and right posts and Connecting part (20) using Bolt (21), Washer (23), Spring washer (24) and Nut (25).
- Fix one end of Arm support (26) to the Base support (22) and another end to the Side frame (3) using bolt (27), washer (16), spring washer (17) and nut (18).
- Put the press frame in an upright position, attach Upper beam part (6), to left and right Knighthead (3) using Bolt (1), Washer (2), Lock washer (4) and Nut (5). Hook mounts should face down on Upper beam part.
- Put the frame in an upright position, and attach the Upper beam part (6) and attached the spring (8). Then attach Hook (9). The attach springs to middle bolster. (Middle bolster will then suspend between left and right frame posts.) Carefully place 20 ton Hydraulic bottle jack (7) in between the Bed flat (11) and Upper beam part (6). Adjust the Nut (10) to the proper position once jack has been installed.
- Insert lower Support pin (19) into the holes in the posts. The insert the Bracket part (12) into press frame and onto lower support pin, using support tube (13), bolt (15), washer (16), spring washer (17) and nut (18).
- Place the Heel block (14) on Bracket part (12).
- Tighten all bolts and screws.

## BEFORE FIRST USE

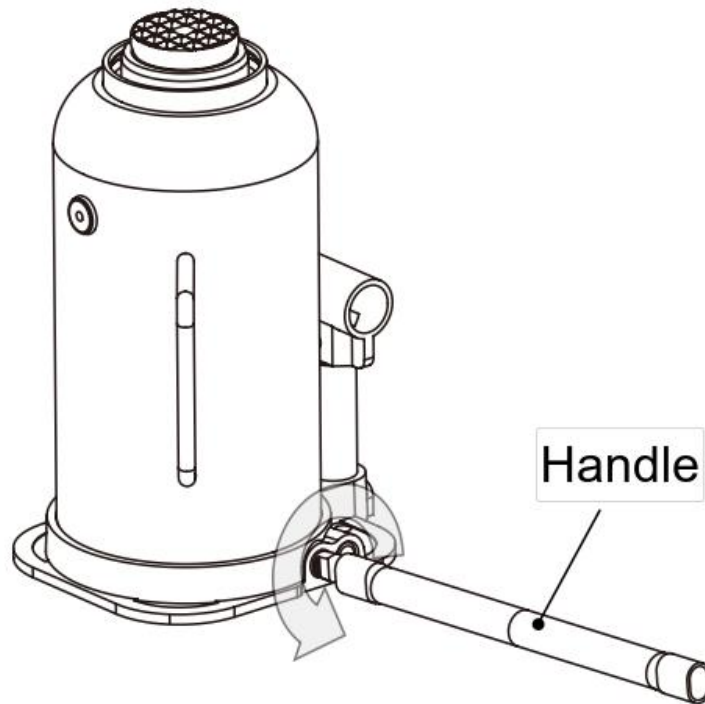
### IMPORTANT: BEFORE FIRST USE

- All numbers in parenthesis () refer to the index number from the parts breakdown.
- Perform the following Air Purge Procedure to remove any air that may have been introduced into the hydraulic system as a result of product shipment and handing. This step is to be completed without and weight on the jack.

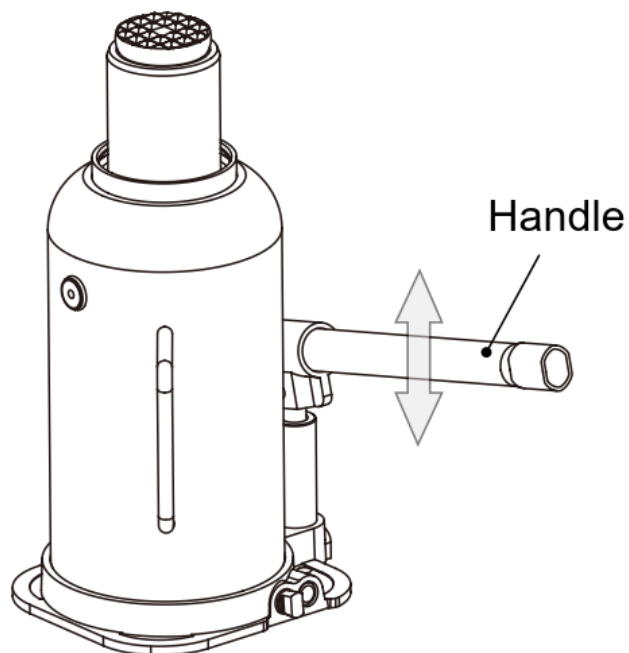
## SYSTEM AIR PURGE PROCEDURE

THIS PRODUCT HAS COMPLETED THE AIR PURGE PROCEDURE BEFORE LEAVING THE FACTORY AND CAN BE USED DIRECTLY

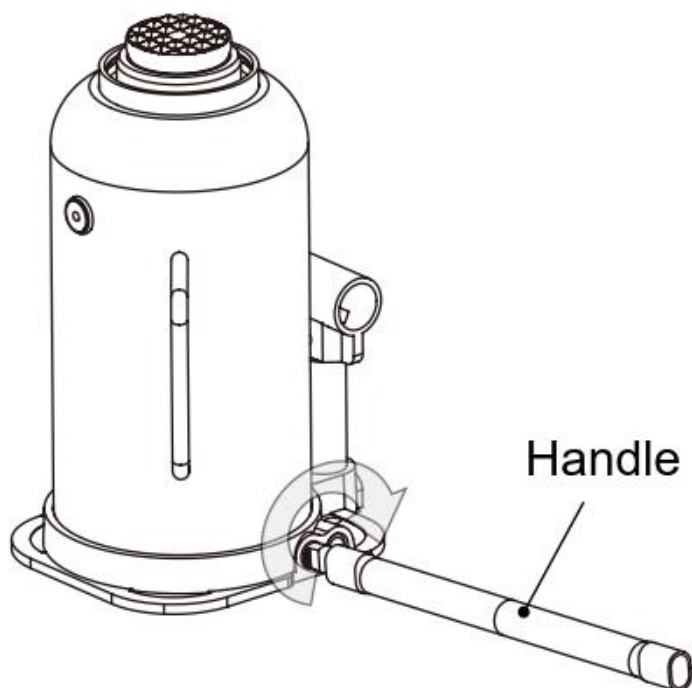
- Check all parts and conditions, if there is any part broken, stop using it and contact your supplier immediately.
1. Turn release valve counterclockwise one full turn to the open position.



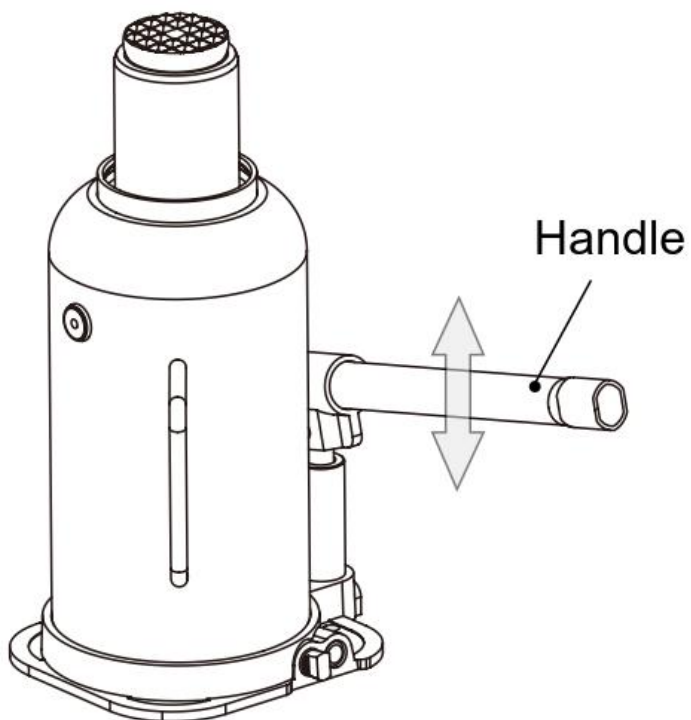
2. Pump handle 6 to 8 full strokes. Leave handle in down position to expose oil fill plug.



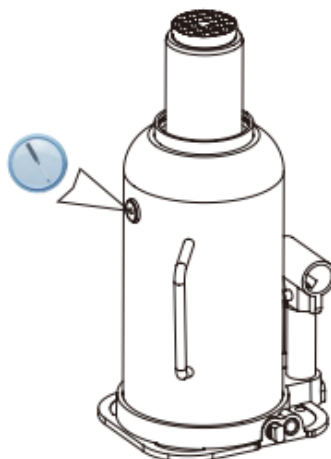
3. Turn release valve clockwise to the closed position.



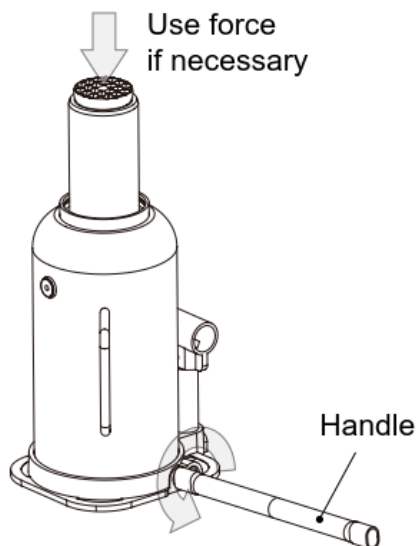
4. Pump handle until the ram reaches maximum height and continue to pump several times to remove trapped air in the ram.



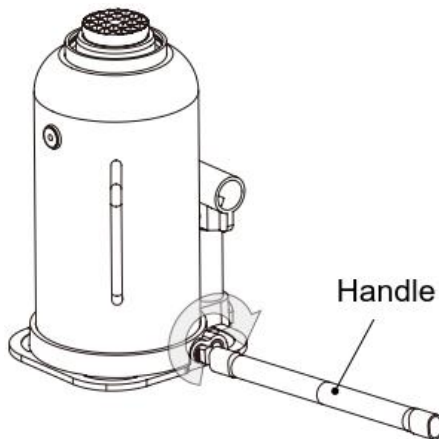
5. Carefully and slowly pinch oil fill plug to release trapped air.



6. Turn release valve counterclockwise to the open position one full turn and lower ram to the lowest position.



7. Turn release valve (R7) clockwise to the closed position and check for proper pump action. It may be necessary to perform the above step more than once to assume air is evacuated totally.



8. Secure the handle in place inside the handle socket. Without any weight on the jack. Cycle the lift up and down several times to insure the hydraulic system is operating properly. (Perform to the Air Purge Procedure again if necessary.)

## **OPERATING 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 work piece onto the heel block.
- Close the release valve by turning it clockwise until it is firmly closed.
- Pump the handle until serrated saddle nears work piece.
- Align work piece and ram to ensure center-loading.
- Pump the handle to apply load onto work piece.
- When work is done, stop pumping the handle, slowly and carefully remove load from work piece 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 until full, then replace the oil filler nut, purge away air from the hydraulic system.