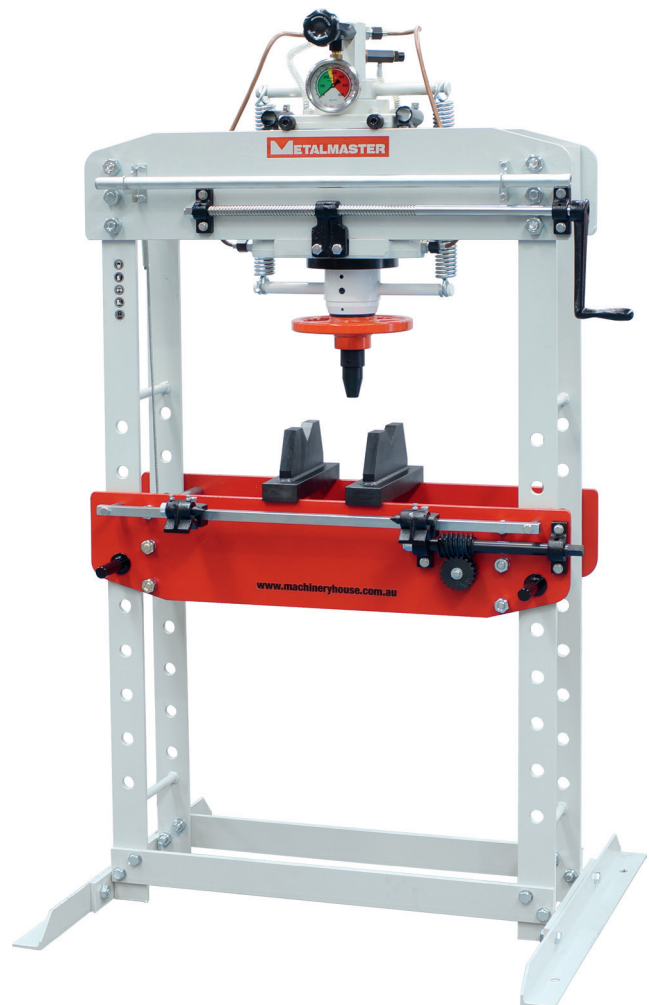


METALMASTER

WORKSHOP HYDRAULIC PRESS OPERATION MANUAL



MODELS

HDP-15, HDP-35

Order Code P127 Order Code P129

Edition No : WSP001

Date of Issue : 07/2018

www.machineryhouse.com.au

MACHINE DETAILS**MACHINE**

WORKSHOP PRESS

MODEL NO.**SERIAL NO.****DATE OF MANF.**

Distributed by

www.machineryhouse.com.auwww.machineryhouse.co.nz**NOTE:**

This manual is only for your reference. Owing to the continuous improvement of the METALMASTER machines, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

**NOTE:**

In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)

A rectangular specification plate with a red header containing the METALMASTER logo. Below the header, the text "PRODUCT SPECIFICATION" is centered. There are four rows of labels followed by empty rectangular boxes: "MODEL:", "SER NO:", "MFG DATE:", and "CAPACITY:". At the bottom of the plate, the website "www.machineryhouse.com.au" and "Made in China" are printed.

METALMASTER	
PRODUCT SPECIFICATION	
MODEL:	<input type="text"/>
SER NO:	<input type="text"/>
MFG DATE:	<input type="text"/>
CAPACITY:	<input type="text"/>
www.machineryhouse.com.au Made in China	

Fig.1

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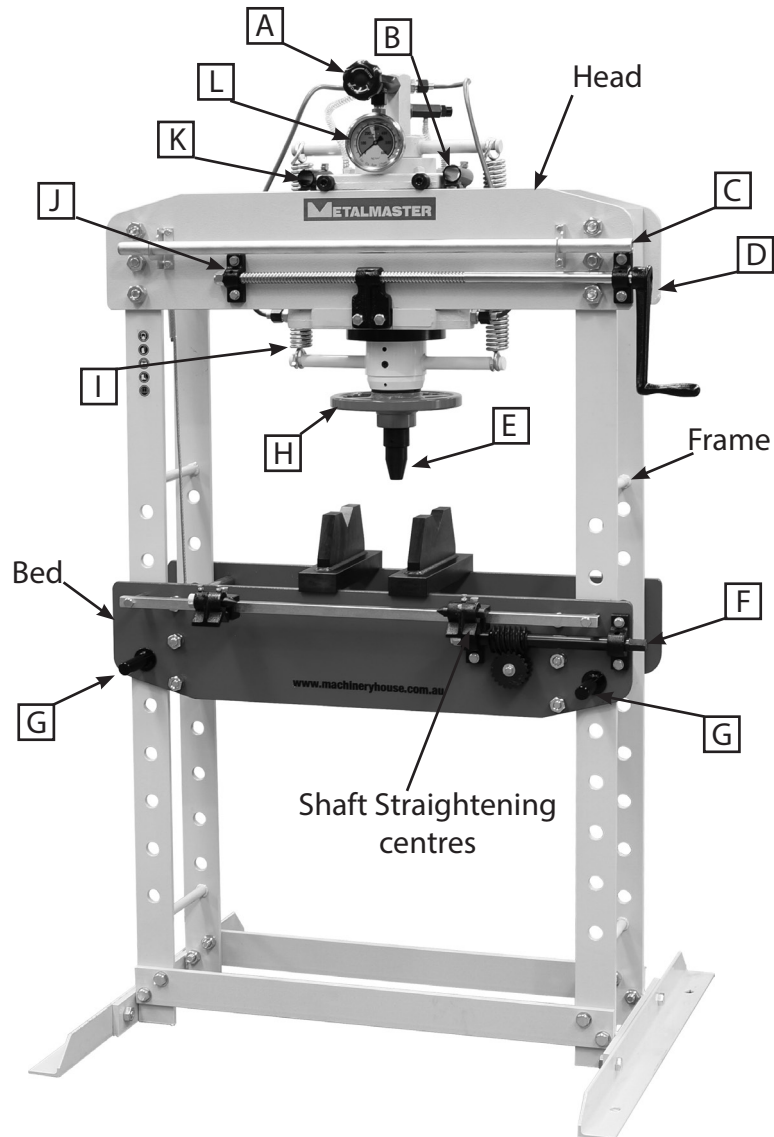
1.1 SPECIFICATIONS

Oder Code	P127	P129
Model	HDP-15	HDP-35
Pressing Capacity (Tonne)	15	35
Hydraulic Ram Operation (Type)	Manual / Hydraulic	Manual / Hydraulic
Sliding Ram (left-right) (Yes/No)	Yes	Yes
Width Between Front Posts (mm)	628	790
Width Between Side Posts (mm)	140	208
Table Top Opening - Front to Back (mm)	170	240
Maximum Ram To Table (mm)	840	730
Piston Ram Stroke (mm)	130	130
Ram Diameter (mm)	Ø69	Ø80
Floor Space (W x D x H) (mm)	970 x 745 x 1830	1170 x 850 x 1870
Shipping Dimensions (L x W x H) (mm)	1950 x 900 x 450	1950 x 1100 x 500
Nett Weight (kgs)	226	380

1.2 STANDARD EQUIPMENT

- Screw type rapid approach on ram
- Heavy duty winch on table rise and fall
- 100mm pressure gauge
- Spring return on ram
- Adjustable dead centres for shaft straightening
- Vee blocks

1.3 IDENTIFICATION



HDP-35 DISPLAYED

- | | |
|---|---|
| A. Release Valve
Controls pressure to the ram. | G. Bed Pins
Supports the table once it is in place |
| B. Pump Handle Socket (Slow)
Takes the handle for slow travel of the ram when pumped. | H. Hand Wheel
Rapidly moves the press head up or down |
| C. Handle Storage
Storage point for the pump handle. | I. Return Springs.
Returns the press head to top position |
| D. Head Handle
Moves the head sideways | J. Moving Head Shaft
Slides the head from side to side |
| E. Press Head
Pressing point | K. Pump Handle Socket (Fast)
Moves the head down fast.(HDP-35 Only) |
| F. Crank Gear Shaft
Raises and lowers the table | L. Pressure Gauge
Displays the pressure applied to the ram |

2. IMPORTANT INFORMATION

2.1 GENERAL MACHINERY SAFETY REQUIREMENTS.

Read and adhere to the manufacturer's operating instructions and warnings. Ensure that the operators are properly trained in safe operation of the machine, and experienced for each type of task to be conducted before operating.

Know the emergency stop/shut-down procedures for the specific machine operated.

Prior to operating ensure that:

- Operating controls and surrounding areas are clean of debris and other hazards.
- Shields and guards are in place and controls and interlocks or other safety devices are accessible and operating properly (pay attention to the point of operation, as well as the area behind, to the side, and above the machine).
- Machine components are in good working condition (do not use damaged equipment).
- Labels and warnings are present and legible.
- Inspect the ancillary hazard control devices for proper operation, such as dust collectors used with wood working equipment, etc.
- Do not operate equipment that is damaged or that has missing/defective guards or shields and promptly tag the equipment as "Out-of-Service" and notify the appropriate authority.
- Follow the manufacturer's recommendations for routine cleaning and preventative maintenance. Do not use compressed air for cleaning of debris.
- Do not attempt to override or defeat safety features. Guards and shields must be in place during normal operation. Observe appropriate Lockout/Tagout procedures when guards, shields, or other safety devices are removed or deactivated for maintenance or repair.
- Only operate machinery within its designed limits.
- Do not operate a machine outside the scope of your abilities, even if it is within the machine's operating limits.
- Understand the hazards of each type of operation to be conducted, and adhere to the risk assessment measures that have been prescribed for the machine or task.
- Do not wear loose clothing or jewelry while operating machines.
- Confine long hair, including restraint of ponytails and beards.
- Wear appropriate work attire and prescribed Personal Protective Equipment, including, at a minimum, safety glasses and closed-toed and slip-resistant shoes.
- Avoid distractions and actions that could interfere with good communication (e.g., head phones, loud music, etc.).
- Do not engage in horseplay.
- Restrict people not involved directly in the operation from the immediate area.
- Ensure there is adequate space for the machine and operator to avoid cramped conditions
- Communicate with others that may be working or occupying space the machine
- Ensure unimpeded access to all operating controls, emergency shut-down devices, and electrical panels/shut-offs servicing the equipment.
- Ensure adequate lighting to safely operate the equipment.
- If a machine is designed to be anchored to the floor, then it must be securely attached.
- Observe good housekeeping. Keep floors and equipment/machines clean. Store stock materials in a neat and secured manner. Do not accumulate excess combustibles. Keep aisles and exits clean.

2.2 MACHINE SAFETY PRECAUTIONS

DO NOT use this machine unless you have been trained in its safe use and operation

- Components of this press are specially designed to withstand the rated capacity. Do not substitute bolts, pins, or any other components.
- The operator shall have an understanding of operating instructions and warnings before operating the hydraulic press. Failure to follow warnings may result in loss of work piece, damage to the press, property damage, personal or fatal injury

1. PRE-OPERATION:

- Before operating, check for signs of cracked welds, bent bed pins, loose or missing bolts, or any other structural damage or leaks. Do not operate if any of these conditions exist.
- Before applying the work piece, be sure all table pins have been fully inserted.
- Remove all work pieces from the Working Table before attempting to adjust Working Table height. Be aware that the Working Table may drop when the pins are removed.
- Task is clearly understood. (E.g. Drawings, instructions, specifications etc.) .
- Ensure work piece is placed squarely on the Working Table.
- Ensure that long or wide work pieces are supported and will not slip.
- Clamp work piece (if appropriate).

2. OPERATION:

- Keep hands and body clear of press mechanism when lowering.
- Lower ram until it contacts the work piece.
- Adjust pressure of ram slowly to the desired setting.
- Press only on the work piece that is supported by the Working Table.
- Always apply the work piece on the center of the ram. An offset work piece can cause damage to the ram or ram mount, and may cause the work piece to suddenly eject.
- Do not exceed the rated capacity. Always use the attached pressure gauge to measure pressing force
- Never apply excess pressure to objects that may break, fragment, bend or eject. Parts being pressed may splinter, shatter or be ejected from the press. Due to varied applications, it is your responsibility to always use adequate guards, such as eye protection and heavy protective clothing, when operating this press
- Identify ON/OFF switch and emergency stop button (if applicable).

3. POST-OPERATION:

- Ensure the area is clear of other people.
- Release pressure on hydraulic press.
- Slowly raise ram and remove work piece from plate.
- Return work pieces and other items to storage area as appropriate.

POTENTIAL HAZARDS:

Potential to cause harm as a result of crushing from moving parts, hazardous manual handling, materials being ejected from the plant and chemical hazard (release of hydraulic fluid).

2.3 LIFTING INSTRUCTIONS

When the press arrives, visually inspect all components for damage which may have been caused during shipping. If shipping damage is found, notify the carrier at once, as they are responsible for all repair and replacement costs. This damage is not covered under warranty.

Metalmaster recommend that the machine is moved with a forklift, with the tines under the top beam of the press. Use thick cardboard or timber between the tines and the machine to eliminate damage. (Fig.2.1)

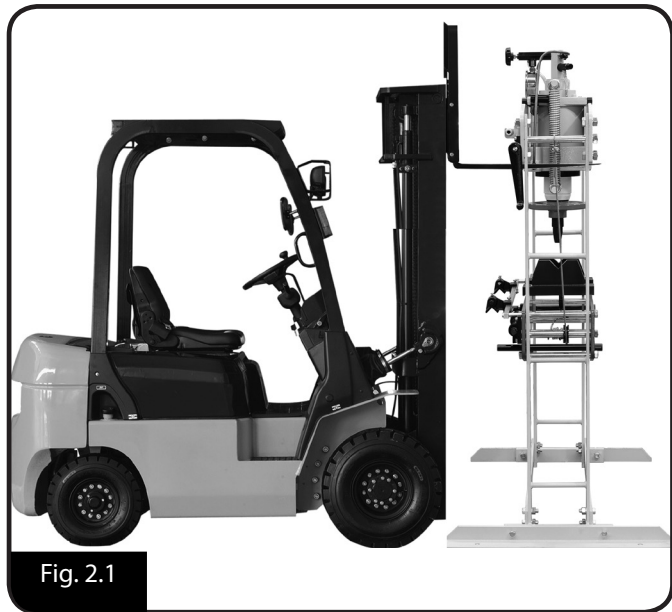


Fig. 2.1

3. INSTALLATION

3.1 SITE LOCATION

When selecting a location for the press the ground should be flat and even. The floor must be able to support the weight of the machine including any work piece that will be worked on. Metalmaster recommend that the floor be reinforced concrete at least 150mm thick. The machine should be secured to the ground with anchor bolts to ensure optimum performance of the machine.

When checking the location ensure that there is enough room around the machine to accommodate the machine and any work piece that may be used. The site should be well lit and give clear easy access around the press.

3.2 CHECKING THE PRESS

Check the machine parts for loose bolts and for any oil leaking issue. Tighten any loose bolts and tighten each oil pressure connection that display signs of leaking. Should there be any problem which cannot be solved, contact your distributor and advise them of the problem.

4. OPERATION

When operating the press there are a few procedures that need to be done before pressing begins.

Make sure there is enough travel in the ram to complete the task. If out of range then the bed needs to be raised or lowered accordingly.

To raise or lower the press bed, lift the bed by rotating the handle (A in Fig.4.1) so that the weight of the bed no longer rests on the bed pins. Pull out the bed pins,(B in Fig.4.1) and raise or lower the bed to the desired height and line up the holes in the bed and the main frame then re-install the bed pins making sure the flanges on the pins are hard up against the bed.

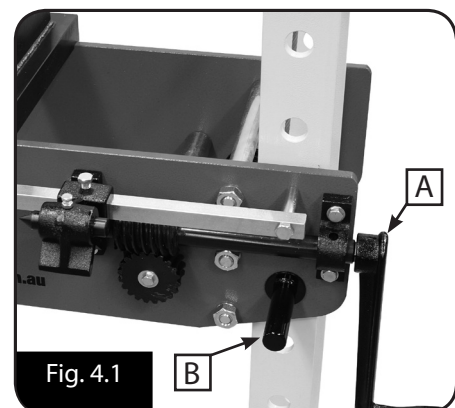


Fig. 4.1

4.1 PRESSING**⚠ WARNING**

Before operating the press, make sure that both the bed support pins are fully inserted so that flange on the pin is flat against the bed.

Check the press set-up and any locating fixtures being used, for safe operation.

1. Move the head (Fig. 4.2) to center the work piece and all parts of the set-up in line with the force direction. If using spacers in the set-up, they should be constructed of one solid piece or tack welded together for stability.

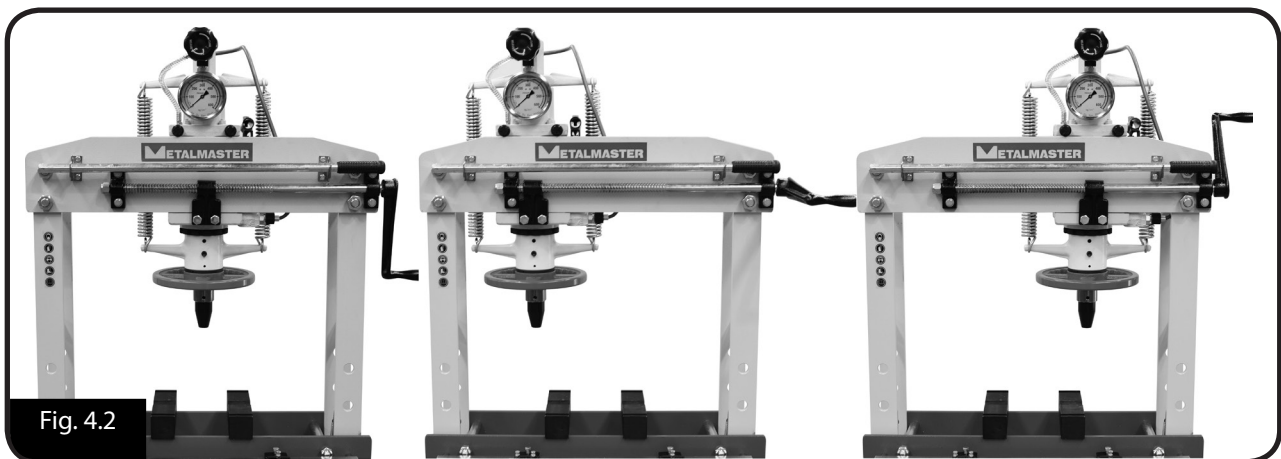


Fig. 4.2

2. Using the hand wheel (Fig. 4.3) move the press head close to the workpiece
 3. Close the release valve finger tight.(C in Fig.4.4)
 4. Operate the pump handle to build pressure.(D in Fig.4.4)
- NOTE: The model HDP-35 has a two stage pump. Pressure can be quickly applied using the fast pump position (E in Fig.4.4) then changed to the slow position. (D in Fig.4.4) for better control



Fig. 4.3

3. Pressure will be maintained and can be monitored on the gauge (F in Fig.4.4) until the release valve is opened.
3. Open release valve (C in Fig.4.4) to release pressure, and the ram will retract.

**NOTE:**

Never exceed the maximum pressure allowed for the press
HDP-15 - 15 Tonnes
HDP-35 - 35 Tonnes

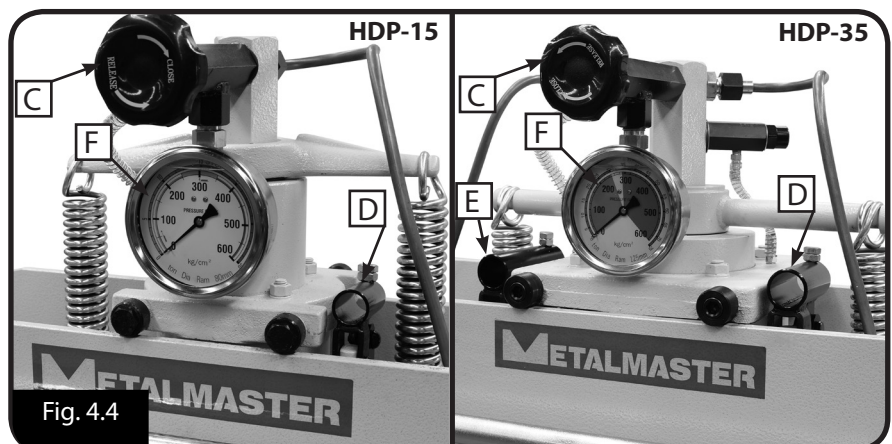


Fig. 4.4

5. MAINTENANCE

To prevent oil leakage during transportation a hex bolt filler plug is used to seal the hydraulic system. To provide better performance, replace the hex bolt with the air vent filler bolt supplied with the machine. The filler bolt can be found at the back of the head (see Fig.5.1)

Be sure that all parts are wiped clean before and after each use. A light grade of oil should be used on moving parts to prevent rusting and to extend life.

The hydraulic oil is filled before the machine leaves the factory but should be checked regularly. To check the oil remove the filler plug and using the long end of an hex key insert it into the hole and check if oil is present on the key. The oil level should be around 50mm from the top of the casting. Should the hydraulic oil need of be topped up open the filling point located on the rear side of machine and add R32 or AW32 hydraulic oil. (F in Fig. 5.1)

NOTE: Always check or replenish the oil when the ram is in the fully up position.

5.1 REMOVING AIR FROM THE HYDRAULIC SYSTEM

Advance and retract the ram several times, without building up pressure. Air is fully removed from the system when the cylinder advances and retracts smoothly.

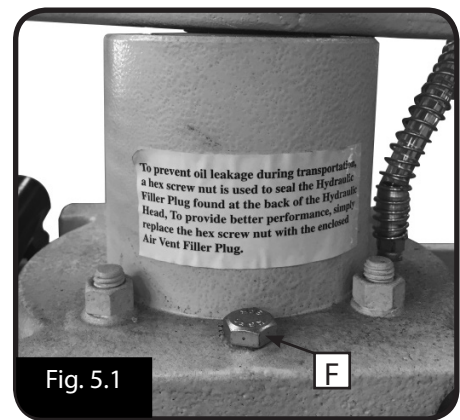


Fig. 5.1

5.2 TROUBLESHOOTING

Problem	Possible Cause	Solution
Cylinder does not advance, advances slowly, or advances in spurts.	Oil level in pump is low. Pump release valve open. Loose hydraulic coupler. Load is too heavy. Air trapped in the system. Cylinder plunger binding.	Add oil according to the pump instructions. Close pump release valve. Check that all couplers are fully tightened. Do not attempt to exert more than rated tonnage. Remove air according to the instructions. Check for damage to cylinder. Have cylinder serviced by a qualified hydraulic technician.
Cylinder advances, but does not hold pressure.	Leaking connection. Leaking cylinder seals. Internal leakage in pump.	Check that all connections are tight and leak free. Locate any external leaks and have equipment serviced by a qualified hydraulic technician. Have pump serviced by a qualified hydraulic technician
Cylinder does not retract, retracts part way, or retracts more slowly than normal	Pump reservoir is overfilled Loose hydraulic coupler Air trapped in the system.	Drain oil level to full mark. See pump instructions for adding oil. Check that all couplers are fully tightened. Remove air according to the instructions
Cylinder does not retract, retracts part way, or retracts more slowly than normal	Pump release valve closed. Cylinder retraction spring broken or other cylinder damage. Cylinder attachments are too heavy for a single-acting cylinder. Coupler not connected fully.	Open pump release valve. Have cylinder serviced by a qualified hydraulic technician. Remove attachments and see if ram retracts. Tighten the connections.

SPARE PARTS SECTION

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

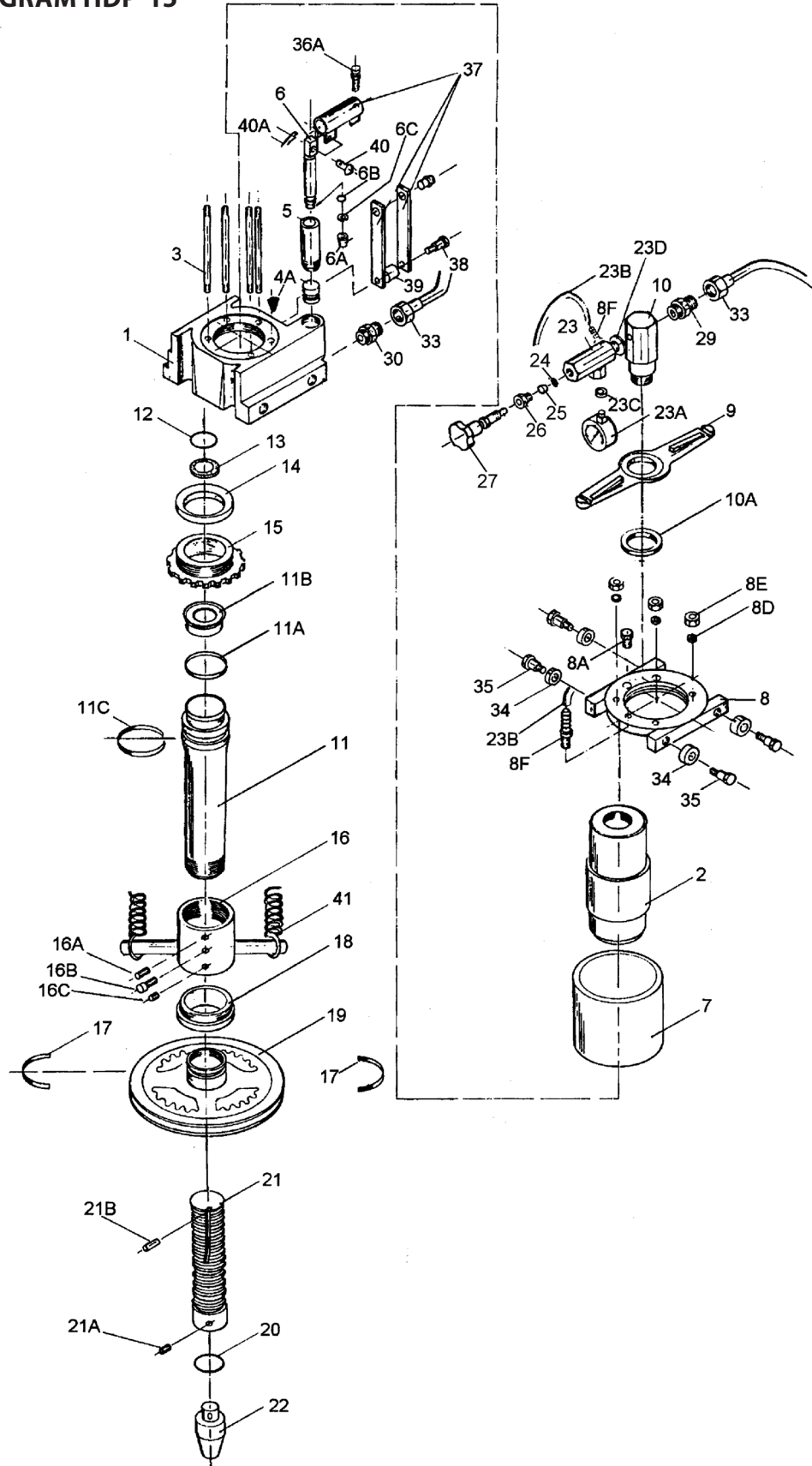
HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to www.machineryhouse.com.au/contactus and fill out the enquiry form attaching a copy of scanned parts list.

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HEAD PARTS DIAGRAM HDP-15



HEAD SPARE PARTS LIST HDP-15

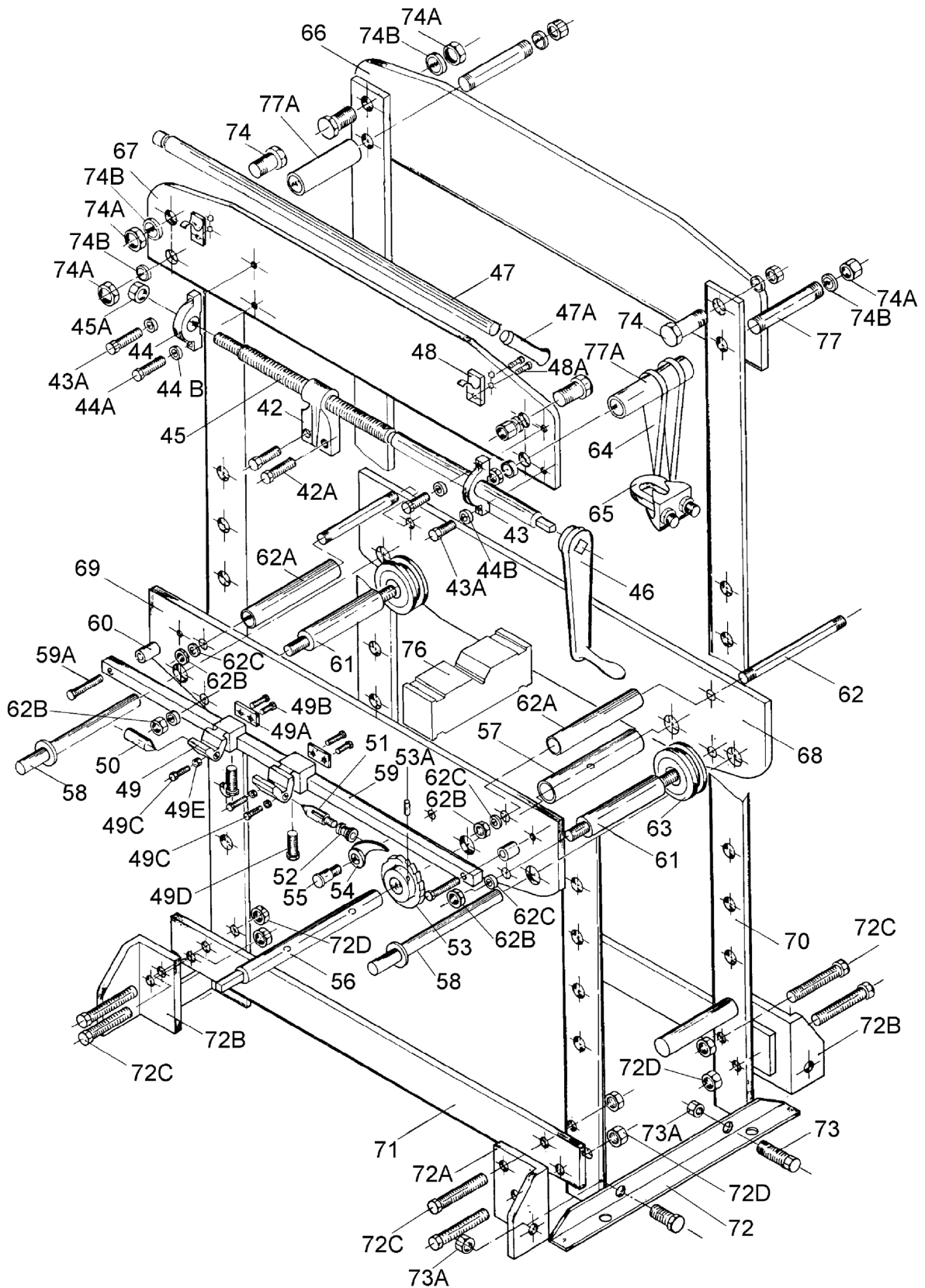
No.	Part No.	Description	Size	Qty.
1	JL-15A-01	Hydraulic Base		1
2	JL-15A-02	Cylinder		1
3	JL-15A-03	Support Rod		4
4	JL-15A-04	Single Action Valve		1
4A	JL9511-50-3	Base Filter		1
5	JL-15A-05	Pump Cylinder		1
5A	JL-15A-05A	O-Ring		1
6	JL-15A-06	Piston**		1
6A	JL-15A-6A	Cup Seal **		1
6B	JL-15A-6B	Seal **		1
6C	JL-15A-6C	Wiper Seal **		1
7	JL-15A-07	Reservoir		1
	SCR641	Bolt	(JL-15A-06)	1
	WAS101	Washer	(JL-15A-06)	1
8	JL-15A-08	Top Base		1
8A	SCR134	Hex Filler Plug w/ Seal		1
8D	WAS230	Spring Washer	3/8	4
8E	NUT230	Nut	3/8	4
8F	JL-15A-8F	Brass Tube Connector		2
9	JL-15A-09	Spring Top Holder		1
10	JL-15A-10	Oil Pass Connector		1
10A	JL-15A-10A	Spacer		1
11	JL-15A-11	Plunger		1
11A	JL-15A-11A	Support Seal **		1
11B	JL-15A-11B	Cup Seal **		1
11C	JL-15A-11C	Teflon Support Ring **		1
12	JL-15A-12	Seal **		1
13	JL-15A-13	Oil Absorber **		1
14	JL-15A-14	Gasket		1
15	JL-15A-15	Plug Nut Fixer		1
16	JL-15A-16	Connector Post		1
16A	SCR331	Screw		1
16B	SCR220	Screw		1
16C	SCR310	Screw		1
17	JL-15A-17	Hand Wheel Fixer		2
18	JL-15A-18	Hand Wheel Spacer		1
19	JL-15A-19	Hand Wheel		1
20	JL-15A-20	Seal		1
21	JL-15A-21	Extension Screw		1
21A	SCR331	Set Screw		1
21B	WAS360	Stopper Roll Pin		1
22	JL-15A-22	Press Head		1

HEAD SPARE PARTS LIST HDP-15

No.	Part No.	Description	Size	Qty.
23	JL-15A-23	Release Valve Block		1
23A	JL-15A-23A	Pressure Gauge		1
23B	JL-15A-23B	Plastic Tube		1
23C	JL-15A-23C	Washer		2
23D	JL-15A-23D	Spacer		2
23E	JL-15A-23E	Protection Spring		1
24	SB-04	Steel Ball		1
25	JL-15A-25	Release Valve Seal **		1
26	JL-15A-26	Release Valve Nut		1
27	JL-15A-27	Release Valve		1
29	JL-15A-29	Male Connector		1
30	JL-15A-30	Male Connector		1
33	JL-15A-33	Bronze Tube		1
34	JL-15A-34	Sliding Wheel		4
35	JL-15A-35	Locking Screw		4
36A	SCR135	Hand Stopper		1
37	JL-15A-37	Complete Handle Sleeve Assembly		1
38	JL-15A-38	Fixed Screw		1
39	JL-15A-39	Spacer		1
40	JL-15A-40	Pin		1
40A	WAS409	Cotter Pin		1
41	JL-15A-41	Return Spring		2

**Included in Hydraulic Repair Kit

FRAME SPARE PARTS DIAGRAM HDP-15



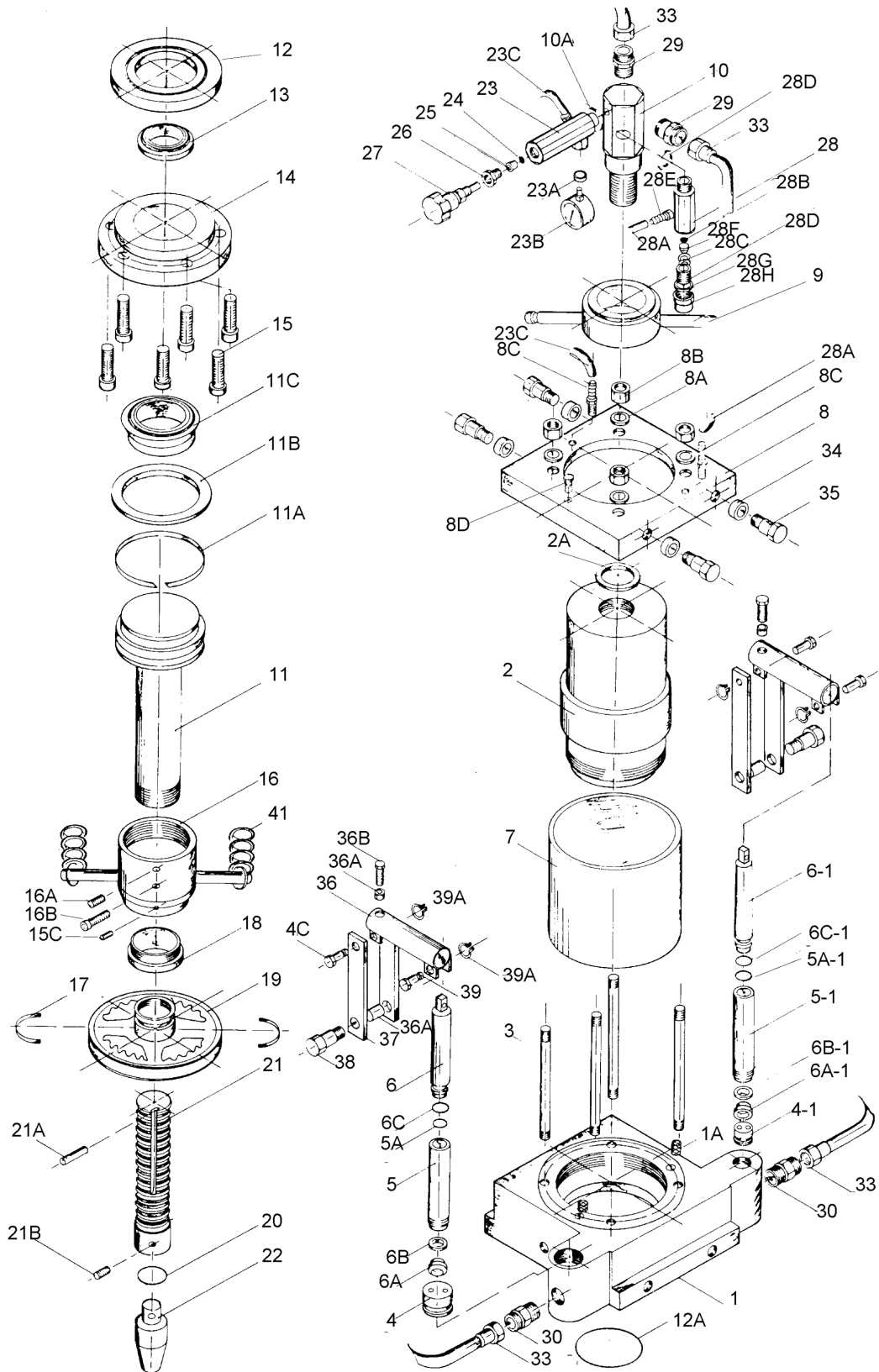
FRAME SPARE PARTS LIST HDP-15

No.	Part No.	Description	Size	Qty.
42	JL-15A-42	Shaft Holder		1
42A	SCR140	Hex Head Bolt	1/2x1	2
43	JL-15A-43	Rolling Shaft Block w/o Thread		1
43A	SCR131	Hex Cap Bolt	3/8x1 1/4	3
44	JL-15A-44	Rolling Block		1
44A	SCR130	Hex Cap Bolt	3/8x1	1
44B	WAS132	Washer	3/8	4
45	JL-15A-45	Rolling Shaft		1
45A	NUT351	Nut		2
46	JL-15A-46	Hand Crank		1
47	JL-15A-47	Pump Handle		1
47A	JL-15A-47A	Rubber Grip		1
48	JL-15A-48	Handle Holder		2
48A	JL-15A-48A	Handle Holder Screw		2
49	JL-15A-49	V-Block Body		2
49-1	JL-15A-49-1	V-Block Body		2
49A	JL-15A-49A	Plates		2
49B	SCR135	Hex Screw		4
49C	SCR110	Hex Screw		4
49D	SCR121	Hex Screw		3
49E	NUT110	Stopper		2
50	JL-15A-50	Center Tails		2
51	JL-15A-51	Adjustable Center -Tail Body		1
52	JL-15A-52	Adjustable Center - Tail Knob		1
53	JL-15A-53	Crank Gear		1
53A	WAS361	Roll Pin		1
54	JL-15A-54	Crank Gear Pawl		1
55	JL-15A-55	Pawl Stud Screw		1
56	JL-15A-56	Crank Gear Shaft		1
57	JL-15A-57	Spindle Sleeve		2
58	JL-15A-58	Table Holder		1
59	JL-15A-59	Square Bar		1
59A	SCR136	Center Tail Assembly Screw		2
60	JL-15A-60	Screw Spacer		2
61	JL-15A-61	Cable Sliding Spindle		1
62	JL-15A-62	Table Spindle		2
62A	JL-15A-62A	Crank Shaft Sleeve		1
62B	WAS250	Washer		8
62C	NUT150	Bolt		8
63	JL-15A-63	Cable Slide Wheel		1
64	JL-15A-64	Cable		1
65	JL-15A-65	Wire Rope Clip		1

FRAME SPARE PARTS LIST HDP-15

No.	Part No.	Description	Size	Qty.
66	JL-15A-66	Top Frame (rear)		1
67	JL-15A-67	Top Frame (front)		1
68	JL-15A-68	Table Frame (rear)		1
69	JL-15A-69	Table Frame (front)		1
70	JL-15A-70	Main Frame (Left/Right Post)		2
71	JL-15A-71	Lower Frame Support		2
72	JL-15A-72	Frame Bracket		2
72A	JL-15A-72A	Frame Base Bracket		2
72B	JL-15A-72B	Frame Base Bracket		2
72C	SCR144	Bolt		8
72D	NUT140	Nut		8
73	SCR140	Bolt		4
73A	NUT140	Nut		4
74	SCR460	Hex Bolt		4
74A	NUT160	Nut		4
74B	JL-15A-74B	Washer		8
76	JL-15A-76	Bed Plate		2
77	JL-15A-77	Frame Spindle		2
77A	JL-15A-77A	Spindle Sleeve		2

HEAD PARTS DIAGRAM HDP-35



HEAD SPARE PARTS LIST HDP-35

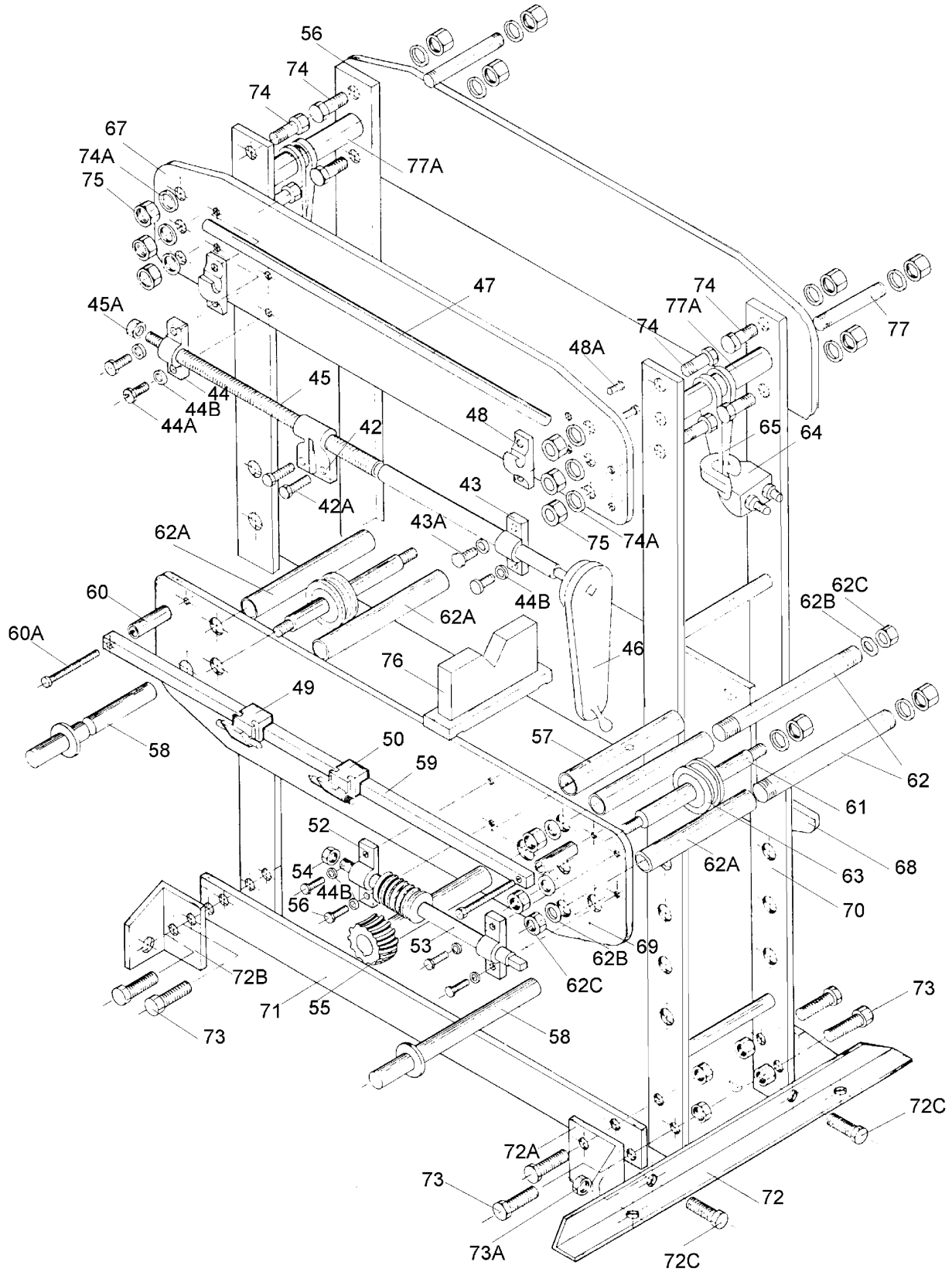
No.	Part No.	Description	Size	Qty.
1	JL-35A-01	Hydraulic Base		1
1A	JL-9511-50-3	Base Filter **		2
2	JL-35A-02	Cylinder		1
2A	JL-35A-2A	Spacer **		2
3	JL-35A-03	Support Rod		4
4	JL-35A-04	Single Action Valve		1
4-1	JL-15A-04	Single Action Valve		1
5	JL-35A-05	Pump Cylinder		1
5A	AG-27A	O-Ring		1
5A-1	JL-15A-05A	O-Ring		1
5-1	JL-35A-05-1	Pump Cylinder		1
6	JL-35A-06	Shaft		1
6-1	JL-35A-06-1	Shaft		1
6A	JL-35A-06A	Cup Seal **		1
6A-1	JL-15A-6A	Cup Seal **		1
6B	JL-35A-06B	Wiper Seal **		1
6B-1	JL-15A-6C	Wiper Seal **		1
6C	JL-35A-06C	O-Ring **		1
6C-1	JL-15A-6B	O-Ring **		1
7	JL-35A-07	Reservoir		1
8	JL-35A-08	Hydraulic Top Base		1
8A	WAS240	Lock Washer	1/2	1
8B	NUT240	Hex Nut	1/2	5
8C	JL-15A-08F	Brass Tube Connector		4
8D	SCR134	Hex Filler Plug w/Seal		4
9	JL-35A-09	Connector Post		1
10	JL-35A-10	Oil Pass Connector		1
10A	JL-15A-23D	Spacer		2
11	JL-35A-11	Plunger		1
11A	JL-35A-11B	Spacer Ring **		1
11B	JL-35A-11A	Teflon Support Ring		1
11C	JL-35A-11C	Cup Seal **		1
12	JL-35A-12	Brass Gasket		1
12A	JL-35A-12A	O-Ring **		1
13	JL-35A-13	Seal **		1
14	JL-35A-14	Plunger Plate w/ Gasket		1
15	SCR230	Socket Head Cap Screw	3/8-1 1/4	6
16	JL-35A-16	Connector Post		1
16A	SCR331	Socket Set Screw		1
16B	SCR220	Set Screw		1
16C	SCR311	Socket Set Screw		1
17	JL-15A-17	Hand Wheel Retainer Clips		2

HEAD SPARE PARTS LIST HDP-35

No.	Part No.	Description	Size	Qty.
18	JL-15A-18	Hand Wheel Spacer		1
19	JL-35A-19	Hand Wheel		1
20	JL-15A-20	Seal		1
21	JL-35A-21	Extension Screw		1
21A	WAS361	Stopper Roll Pin		1
21B	SCR331	Set Screw		1
22	JL-15A-22	Press Head		1
23	JL-35A-23	Release Valve Block		1
23A	JL-15A-23C	Spacer		1
23B	JL-35A-23B	Pressure Gauge		1
23C	JL-15A-23B	Plastic Tube		1
24	SB-04	Steel Ball		1
25	JL-15A-25	Release Valve Seal **		1
26	JL-15A-26	Release Valve Nut		1
27	JL-15A-27	Release Valve		1
28	JL-35A-28	Safety Valve Block		1
28A	JL-15A-23B	Plastic Tube		1
28B	SB-04	Steel Ball		1
28C	JL-35A-28C	Safety Spring		1
28D	JL-35A-28D	Safety Valve Set Screw		1
28E	JL-15A-08F	Brass Tube Connector		1
28F	JL-35A-28F	Release Valve Seal **		1
28G	JL-35A-28I	Washer		1
28H	JL-35A-28H	Hex Nut		1
28I	JL-15A-23D	Spacer		1
29	JL-15A-29	Male Connector		2
30	JL-15A-30	Male Connector		2
33	JL-35A-33	Bronze Tube		2
34	JL-35A-34	Sliding Wheel		4
35	JL-35A-35	Hex Locking Screw		4
36	JL-35A-36	Handle Socket		2
36A	NUT130	Nut	3/8	2
36B	SCR135	Hex Head Screw	3/8-16x1	2
37	JL-35A-37	Linking Sleeve		4
38	JL-35A-38	Bottom	Fixed Bolt	2
38A	JL-35A-38A	Spacer		2
39	JL-35A-39	Bolt		2
39A	WAS413	C-Clip		4
40	JL-35A-40	Bolt		2
41	JL-35A-41	Return Spring		2
	JL-35A-RK	Hydraulic Repair Kit		1

**Included in Hydraulic Repair Kit

FRAME SPARE PARTS DIAGRAM HDP-35



FRAME SPARE PARTS LIST HDP-35

No.	Part No.	Description	Size	Qty.
42	JL-35A-42	Shaft Holder		1
42A	SCR142	Hex Cap Head Bolt	1/2xl	2
43	JL-15A-43	Rolling Shaft Block		1
43A	SCR131	Hex Head Bolt	3/8xl 1/4	2
44	JL-15A-44	Rolling Shaft Block		1
44A	SCR130	Hex Cap Bolt	3/8-16xl	2
44B	WAS132	Washer	3/8	8
45	JL-35A-45	Rolling Shaft		1
45A	NUT351	Nut	5/8-18	1
46	JL-15A-46	Hand Crank		1
47	JL-35A-47	Handle		1
48	JL-35A-48	Handle Holder		2
48A	SCR121	Hex Cap Bolt	5/16x1	4
49	JL-15A-49-1	Center Post Assy.(Left)		1
50	JL-15A-49-2	Center Post Assy.(Right)		1
51	JL-35A-51	Fixed Holder		1
52	JL-35A-52	Shaft Fixed Block		1
53	JL-35A-53	Drive Gear Shaft Assembly		1
54	NUT361	Hex Nut		1
55	JL-35A-55	Worm Gear / Shaft Assembly		1
56	SCR131	Hex Head Screw	3/8x1	4
57	JL-35A-57	Spacer Sleeve		1
58	JL-35A-58	Table Holder Pin		1
59	JL-35A-59	Square Bar		1
60	JL-35A-60	Screw Spacer		2
60A	SCR430	Hex Cap Bolt	3/8x3 1/2	2
61	JL-35A-61	Slide Wheel Shaft		2
62	JL-35A-62	Table Spindle		4
62A	JL-35A-62A	Spindle Sleeve		8
62B	WAS250	Lock Washer	5/8	12
62C	NUT150	Hex Nut	5/8	12
63	JL-15A-63	Cable Slide Wheel		2
64	JL-15A-65	Wire Rope Clip		2
65	JL-15A-64	Cable		1
66	JL-35A-66	Top Frame (Rear)		1
67	JL-35A-67	Top Frame (Front)		2
68	JL-35A-68	Table Frame (Rear)		1
69	JL-35A-69	Table Frame (Front)		1
70	JL-35A-70	Main Frame		2
71	JL-35A-71	Lower Frame Support		2
72	JL-35A-72	Base Frame Bracket		2

FRAME SPARE PARTS LIST HDP-35

No.	Part No.	Description	Size	Qty.
72A	JL-35A-72A	Frame Bracket(Left)		2
72B	JL-35A-72B	Frame Bracket(Right)		2
72C	SCR150	Hex Cap Bolt	5/8x1 1/2	8
73	SCR151	Hex Cap Bolt	5/8x2	4
73A	NUT150	Nut	5/8	12
74	SCR460	Hex Head Bolt	3/4x2	8
74A	WAS260	Lock Washer	3/4	12
75	NUT160	Nut	3/4	12
76	JL-35A-76	V-Block Bed Plate		2
77	JL-35A-77	Top Link Bolt		2
77A	JL-35A-77A	Spacer Sleeve		2

WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

WARNING

Hydraulic Press Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Check oil levels and fill to correct oil levels if necessary. Apply oil to surface of ram to maintain good lubrication.
- 2. Press Condition.** Press must be maintained for a proper working condition. Never operate a Press that has low oil levels, damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis. Check all hoses, pressure head, and support rods for cracks or damage. Replace if necessary.
- 3. V-Block Condition.** Never operate a Press with damaged or badly worn V-blocks. Replace if required.
- 4. Hand Hazard.** Keep hands away from the pressure head and out of support rod holes, under any circumstances, while the machine is in operation mode. Serious injury can occur.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Work area hazards.** Keep the area around the Press clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 7. Overloading Press.** Do not exceed the press capacity indicated on the gauge.
- 8. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 9. Material Hazard.** Do not compress springs or other objects that could be ejected from the press. Do not compress objects that could shatter. Serious injury can occur.
- 10. Secure Press.** Make sure you bolt the machine down so it is secure when in operation.
- 11. Use Correct Air Pressure** Exceeding the maximum PSI rating of Press may cause unpredictable operation, injury and damage to machine. If this rating is not stated in manual suggest NOT to exceed 125psi.
(Applies to Pneumatic model only).
- 12. Disconnect Air Pressure** before servicing Press, or leaving unattended.
(Applies to Pneumatic model only).
- 13. Air Hose - Trip Hazard** Hoses can easily become a tripping hazard when laid across the floor in a disorganized fashion.
(Applies to Pneumatic model only).
- 14. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Hydraulic Press

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace (WHSA 2011 No10)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies (Recommended for Purchase / Buyer / User)
B	CRUSHING	HIGH	Do not exceed maximum capacity. Check equipment for damage prior to use. Wear safety boots. Never put any part of your body between hydraulic ram and material. Always support material properly on hydraulic press. Ensure press is bolted down on level solid ground. Ensure table is as close as possible to ram and support pins are correctly positioned before using. Do not exceed recommended maximum PSI rating. (applies to Pneumatic model only) Use equipment in the correct manner as to avoid parts being ejected out under pressure.
C	CUTTING, STABBING OR PUNCTURING	MEDIUM	Use equipment in the correct manner as to avoid parts being ejected out under pressure.
E	STRIKING	MEDIUM	Use equipment in the correct manner as to avoid parts being ejected out under pressure.
G	HIGH PRESSURE AIR	MEDIUM	Disconnect air supply to press prior to checks or maintenance. Do not exceed recommended maximum PSI rating. (applies to Pneumatic model only)
Plant Safety Program to be read in conjunction with manufactures instructions			




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Authorised and signed by:

Safety officer: 

Manager: 

Revised Date: 4th December 2017