



Edition : 1
Date: (09/26)

Instruction Manual

10T HYDRAULIC PRESS HP-10

Order Code: (P1415)

MACHINE DETAILS

MACHINE.

10T Hydraulic Press

MODEL NO.

HP-10

SERIAL NO.

DATE OF MANF.

IMPORTED BY

AUSTRALIA



www.machineryhouse.com.au

NEW ZEALAND



www.machineryhouse.co.nz

NOTE:

This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the HAFCO Metalmaster machine, 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.

SAFETY SYMBOLS:

The purpose of safety symbols is to attract your attention to possible hazardous conditions



WARNING Indicates a potentially hazardous situation causing injury or death



CAUTION Indicates an alert against unsafe practices.

Note: Used to alert the user to useful information



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)

Fig.1



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WARNING!

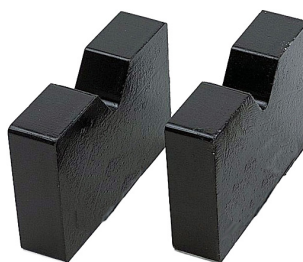
The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

1.1 SPECIFICATIONS

Order Code	P1415
MODEL	HP-10
Pressing Capacity (Tonne)	10
(Type)Hydraulic Ram Operation	Manual Hand Lever
(Yes / No)Sliding Ram (left-right)	Yes
(mm)Width Between Front Posts	335
(mm)Width Between Side Posts	95
(mm)Table Top Opening - (Front to Back)	115
(mm)Ram To Table (Max.)	367
(mm)Cylinder Stroke	175
(mm)Ram Diameter	40
(mm)Piston Diameter	45
(mm)Floor Space (W x D x H)	568 x 495 x 1060
(kg)Nett Weight	54.5

1.2 ACCESSORIES INCLUDED

Bending plates
Instruction Manual



WARNING!

DO NOT operate any machine before it is fully assembled and all the safety guards have been fitted and secured. Failure to do so may cause death or severe injury.

1.3 IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to better understand the instructions when mentioned later in this manual.



A	Pressure Gauge
B	Hydraulic Ram
C	Sliding Head Clamp
D	Pump
E	Pressure Relief Valve

F	Pump Handle
G	Working Table
H	Support Rod
I	Safety Clips
J	Main Frame



WARNING!

Read and understand the instructions in this manual, before operating this machine to reduce the risk of serious injury or even death. Save all warnings and instructions for future reference.

2. SAFETY

2.1 GENERAL METALWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation.



WARNING!

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury, including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the work piece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECT THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL SAFETY REQUIREMENTS CONT.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT

- × Do not distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry that can become entangled in moving parts. Confine long hair.
- × Do not handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × Do not use rags or wear gloves near moving parts of machines.
- × Do not use compressed air to blow debris from machines or to clean dirt from clothes.
- × Do not force the machine. It will do the job safer and better at the rate for which it was designed.



CAUTION!

It is impossible to cover all possible hazards Every workshop environment is different. These are designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Always consider safety first, as it applies to the individual working conditions.

2.1 GENERAL SAFETY REQUIREMENTS Cont.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery.
- Being struck by material ejected from the machinery.
- Contact or entanglement with the machinery.
- Contact or entanglement with any material in motion.

Health Hazards (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin.
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust.
- Heat, noise, and vibration.
- Ionizing or non-ionizing radiation. (X-ray, lasers, etc.)
- Biological contamination and waste.
- Soft tissue injuries (for example, to the hands, arms, shoulders, back or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip.

Other Hazards

- Slips and falls from and around machinery during maintenance.
- Unstable equipment that is not secured against falling over.
- Safe access to/from machines. (access, egress)
- Fire or explosion.
- Pressure injection injuries from the release of fluids and gases under high pressure.
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components.
- Environment in which the machine is used. (in a machine shop, or on a work site)



WARNING!

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WARNING!

Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

2.2 SPECIFIC SAFETY FOR HYDRAULIC PRESS

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual



Safety glasses must be worn at all times in work areas



Close fitting/protective clothing must be worn



Sturdy footwear must be worn at all times in work areas



Rings and jewellery must not be worn.

PRE-OPERATIONAL SAFETY CHECKS

1. Ensure you are familiar with the operation of the hydraulic press.
2. Check for any hydraulic fluid leaks.
3. The press table must be clean and steel weights are flat and secure on press table.
4. Any forming die or cutting die must be inspected for safe use i.e. no cracks.
5. Ensure safety glasses or goggles are available and are worn by all persons in the vicinity.
6. Any test piece, project or material (work piece) to be pressed must be of an appropriate thickness and safe to use on this equipment.
7. Faulty equipment must not be used. Immediately report suspect machinery.

OPERATIONAL SAFETY CHECKS

1. Place your test piece, project or material (work piece) securely on the press table.
2. Ensure the pressure valve is closed before operation.
3. Use the press handle in a pumping action to slowly lower the press hammer.
4. Use your shoulder muscles when operating, NOT your lower back.
5. Keep hands and fingers away from all clamping and moving parts.
6. Carefully and accurately align the press hammer face with the work piece for even force to be applied.
7. Once the press hammer makes contact with the work piece, closely watch the PSI gauge and note the pressure applied.
8. Once the work piece is pressed sufficiently, release the hammer pressure at the release valve.
9. DO NOT apply excessive force with the press.

HOUSEKEEPING

1. After use, clean the press down and return any tools and equipment to the appropriate storage areas – including the press handle.
2. Place all scrap or waste in the appropriate bin.

POTENTIAL HAZARDS

- | | |
|--|---|
| ■ Beware of high forces applied | ■ Eye injuries – flying or shattering objects |
| ■ Pinch and squash | ■ Laceration injuries |
| ■ Potentially uneven forces being applied to the work piece. | |

3 SET-UP

3.1 UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.

When unpacking, check the packing list to make sure that all parts shown are included. If any parts are missing or broken, please contact your distributor.

3.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust preventive products.

It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

3.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of work-piece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

3.4 LIFTING INSTRUCTIONS

On the day that the machine arrives, make sure that a forklift or lifting device, with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.



WARNING

This machine is very heavy.

Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance from another person when moving the shipping crate and removing the machine from the crate.

2 PERSON LIFT



OR MECHANICAL AID



WARNING!

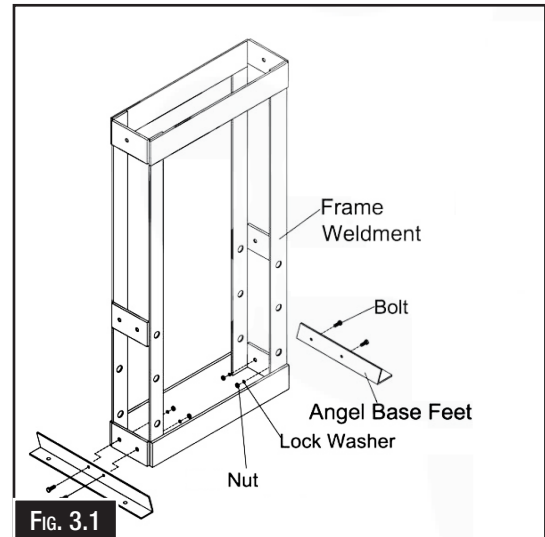
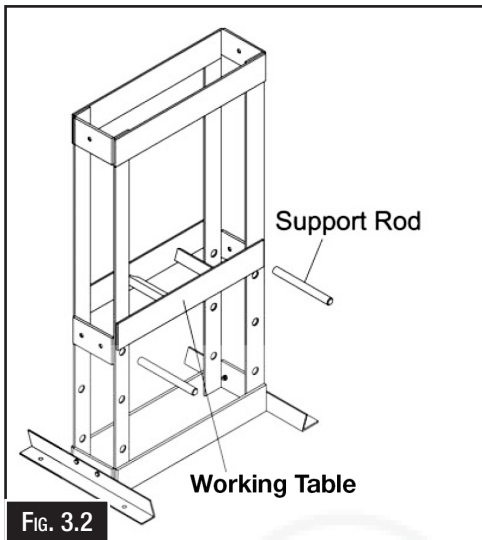
Make sure everyone is away from the load before hoisting. The load must be under control when lowering loads suspended. Rigging and crane operation must be carried out by persons with approved qualifications.

3.5 ASSEMBLY

The machine must be fully assembled before it can be operated. First clean any parts that are coated in rust preventative to ensure the assembly process can proceed smoothly.

STEP 1: Attach Feet to Frame

1. Attach angle steel feet to the frame using M8x25 bolt, Ø8 lock washers and M8 nut. (Fig. 3.1)

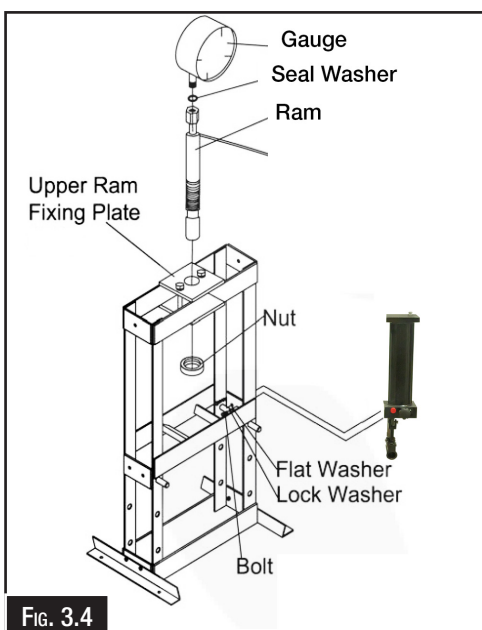
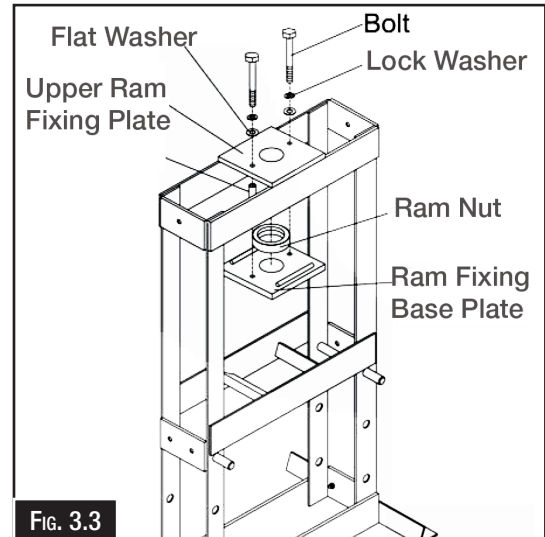


STEP 2: Install the Working Table to the Frame

1. Position the working table between the frames and secure with the two support rods. (Fig. 3.2)

STEP 3: Attach Ram Fix Plates to the Frame

1. Attach the upper ram fix plate and ram fix base plate to the frame using M10x110 bolts Ø10 lock washers Ø10 flat washers and sleeves. Loosely tighten the hardware.(Fig. 3.3)
2. Place the round ram nut on ram fix base plate.



STEP 4: Attach Gauge to Ram & Pump Assembly

1. Attach the gauge with seal washer to the top of the ram assembly. (Fig. 3.4)
2. Insert the ram assembly through the hole on the ram fix plate and tighten the ram nut.
3. Use the ram nut to secure the bottom of the ram assembly and tighten all hardware.
4. Attach the pump on left or right side of the frame using M10x16 bolts, Ø10 lock washers and Ø10 flat washers.

3.5 ASSEMBLY Cont.

STEP 5: Bolt Bench Press to Work Bench

1. Always use the help of another person when moving the bench press.

NOTE: The hardware for mounting or strapping the bench press to the work bench / table is not included but is available at your local hardware store.

2. Make a template of the holes in the bench press feet to mark the spot where the holes need to be drilled in the work bench or table.
3. Temporarily move the bench press to the side and use a drill bit to drill the four holes into the bench or table.
4. Position the bench press and align the holes in the feet with the holes in the bench / table.
5. Use four bolts, washers and nuts (not included) to secure the press to the work bench / table.

NOTE: Using straps instead of bolts make sure both the front and back of the feet are securely strapped down to a work bench to avoid movement during operation (hardware not included).

STEP 6: Install Press Plates on the Working Table

1. Put the steel press plate onto the working table.
2. Before operating the bench press make sure all hardware is fully tighten. (Fig. 3.5)

 WARNING	
SAFETY FIRST 	<i>The safety instructions given in this manual cannot be complete. The environment in every shop is different. Always consider your safety first as it applies to your individual working conditions.</i>

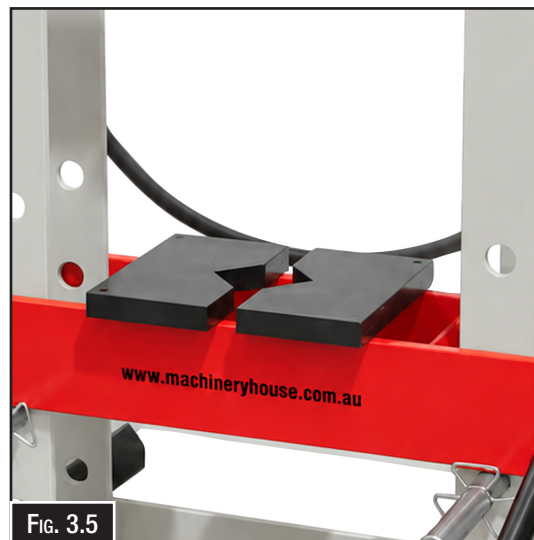


FIG. 3.5

3.6 BLEEDING THE HYDRAULIC SYSTEM

Before using the press, any air needs to be removed from the system.

To Bleed the system:

1. Opening the release valve by turning it anticlockwise
 2. Pump the handle of the pump around ten full strokes to eliminate any air bubbles. (Fig.3.9)
 3. Close the release valve by turning it clockwise and start to pump. If the pressing seems spongy then repeat the process.
- The press is now ready for use.

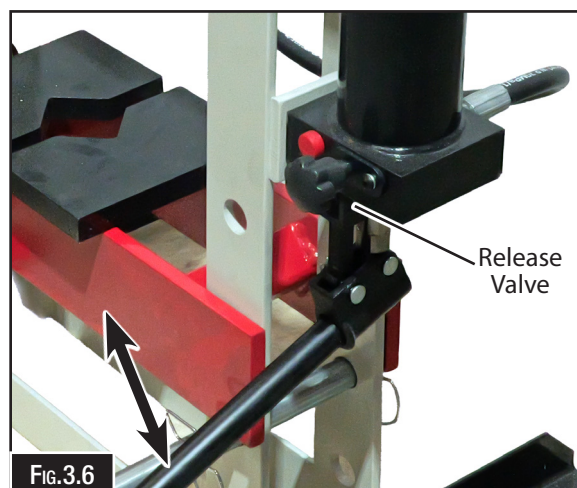


FIG.3.6

4. OPERATION

This machine may perform many types of operations that are beyond the scope of this manual. Many of these operations may be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine! **Above all, your safety should come first!**

4.1 OPERATION OVERVIEW

This overview purpose is to provide a novice machine operator with a basic understanding of how the machine is used during operation, and so that if the machine controls or components are mentioned later in this manual, it will be easy to understand. The overview is not intended to be an instructional guide and is only generic in nature. To learn more about the specific operation, read this entire manual and seek additional training from an experienced machine operator. Another source of information may be found in video's on websites or by reading trade magazines.

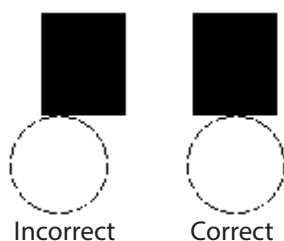
A Typical Operation:

1. Examine the work piece to make sure it is suitable for the pressing operation.
2. Adjust the press bed height to accommodate workpiece.
3. Lower the safety guard (if fitted) and place workpiece on press bed or press blocks as needed, and centre the work piece pressing point under the ram.
4. Raise the safety guard (if fitted) to highest position possible to shield the entire operating area and to protect the operator.
5. Put on an approved pair of safety glasses or a face shield.
6. Close the pump relief valve and open the breather valve on hydraulic pump.
7. Pump the handle or if air assisted, connect the pressurized air supply and use the air to lower the ram until it just touches workpiece.
8. Check to make sure the workpiece has not shifted position and then complete the pressing operation.

4.2 OFFSET PRESSING

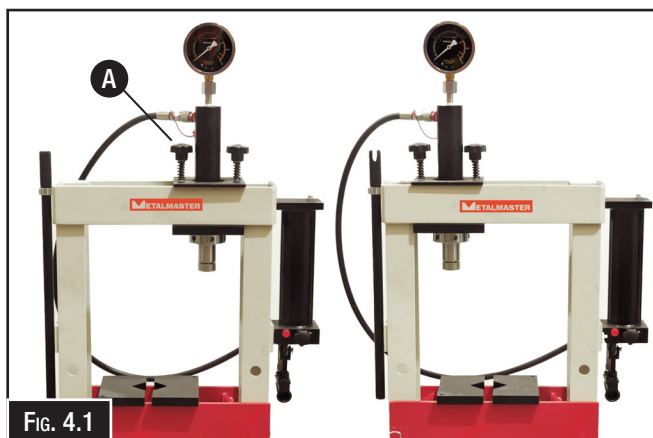
The sliding head moves horizontally along the top crossbeam so you can align the ram with off-center parts without repositioning the entire workpiece on the bed.

To move or adjust the lateral position of the ram (the hydraulic cylinder head) horizontally across the top frame of a sliding-head workshop press, loosen the top clamping screws (A in Fig. 5.1) or fixing handles, slide the assembly along the guide rails to your offset location, and securely re-tighten the hardware.



NOTE:

Always make sure you are pressing with the whole ram. Center the ram over the work, do not press with only the edge of the nose piece. This can cause injury by ejecting the part, or damage to the ram.



4.3 PRESSING PROCESS

1. Place the workpiece on the bed. It must be completely stable and supported by packing or shims where required. Steel pressing plates are supplied, (Fig.4.2) which locate on the bed in either flat or vertical position. Place the workpiece on a combination of these to give it stability.

NOTE: Any packing pieces or shims used **MUST** be capable of withstanding the pressure that will be brought to bear, and **MUST** be of sufficient size with sufficient surface area, so as to avoid the possibility of slipping or springing out. Mating surfaces **MUST** be horizontal so that the force being exerted will **NOT** be at an angle.

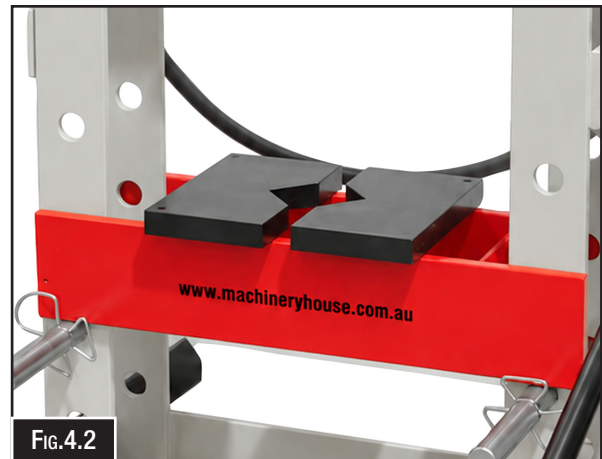


FIG.4.2

2. Close the release valve by turning it clockwise until tightly closed. (Fig. 4.3)
3. Pump the handle to bring the ram very lightly into contact with the workpiece.
4. Position the workpiece or slide the ram to one side so that the desired point of contact is directly beneath the centre of the ram.

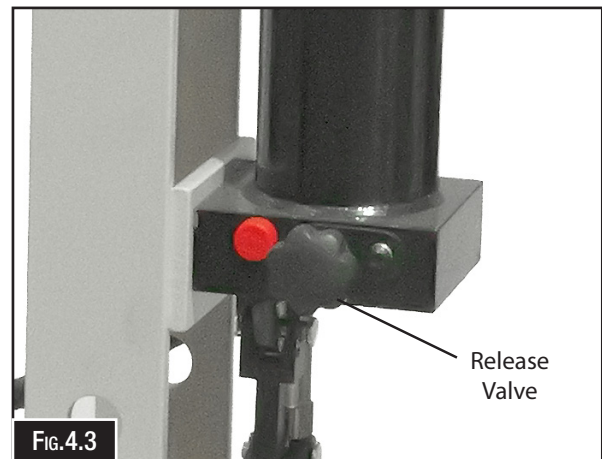


FIG.4.3

5. When satisfied that the workpiece is correctly aligned and is completely stable in that position, slowly pump the handle so that the ram begins to exert pressure on the work piece. Continue to pump the handle whilst standing to the side. Do NOT stand directly in front of the work, and constantly monitor the process, ensuring the ram and work remain completely in line and there is no risk of slipping.
6. When the process is complete, turn the release valve anticlockwise in small increments to release ram pressure and allow removal of the workpiece.



WARNING!

Always check the capacity of the machine. Exceeding the capacity of the machine may result in sudden breakage that ejects dangerous metal debris at the operator or bystanders.

5. MAINTENANCE

- A visual inspection must be made before each use of the press, checking for leaking hydraulic fluid and damaged, loose, or missing parts.
- Owners and/or users should be aware that repair of this equipment requires specialized knowledge and facilities. It is recommended that a thorough annual inspection of the press be made and that any defective parts be replaced with genuine Metalmaster parts.
- Any press which appears to be damaged in any way, is found to be badly worn, or operates abnormally **SHOULD BE REMOVED FROM SERVICE** until the necessary repairs are made.
- If the press is not to be used for any length of time, store it with the ram retracted and the operating handle in the lowered position to protect the moving parts.

5.1 INSPECTION SCHEDULE

- Check the press frame to make sure all bolts are tight and inspect for cracked welds, bent, loose or missing parts.
- Check the hydraulic connections for leaks. Replace or properly repair any damaged or leaking hydraulic components before using. In the event of leaking seals, oil can be topped up via the plug on the end of the pump. Oil should be level with the bottom of the hole. If necessary top up with hydraulic oil, This task is carried out with the ram fully retracted.
- If any rust is apparent it must be removed completely and the paint restored

5.2 TROUBLESHOOTING

Problem	Probable Cause	Remedy
Pump unit will not work	Dirt on the valve seat/worn seals	Bleed pump unit or have unit overhauled with new seals
Pump will not produce pressure. Pump feels hesitant under load. Pump will not lower completely	Air-lock	Open the release valve and remove the oil filler plug. Pump the handle a couple of full strokes and close the release valve. Replace the filler plug.
Pump will not deliver pressure	Reservoir could be overfilled or have low oil level	Check oil level by removing the filler plug and topping up to the correct level.
Pump feels hesitant under load	Pump cup seal could be worn out	Have the cup seal replaced.
Pump will not lower completely	Air-lock	Release air by removing the filler plug



WARNING!

A hydraulic hose burst can have devastating effects. Hydraulic fluid has the capacity to travel at lightning speed. Hydraulic fluid in the eyes can cause blindness or hydraulic poisoning. Always wear safety glasses.

10T HYDRAULIC PRESS HP-10

Order Code: (P1415)

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 anytime 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.

NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.



WARNING!

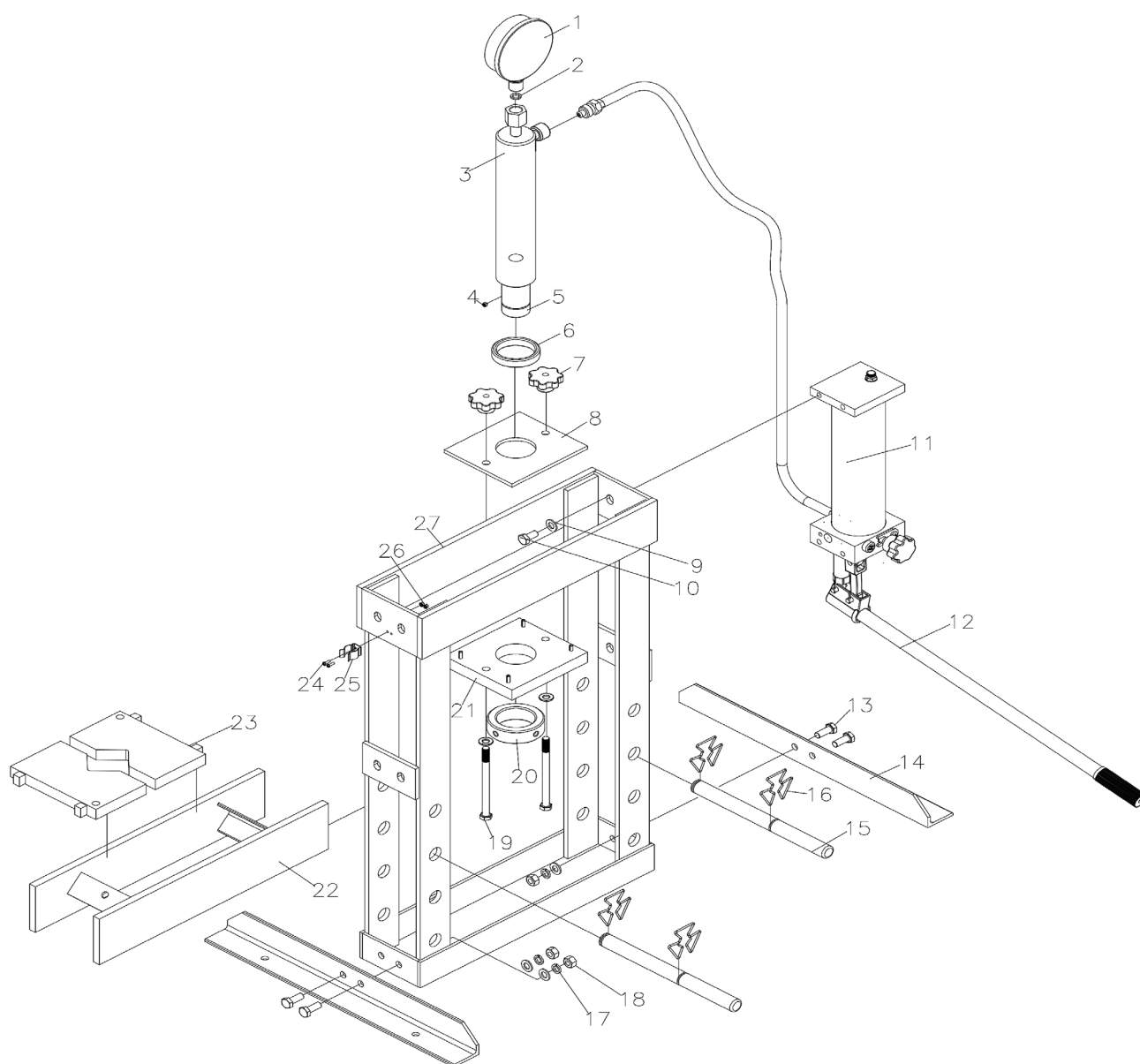
*Electricity is dangerous and could cause death
All electrical work must be carried out by a qualified electrician.*



CAUTION!

It is impossible to cover all possible hazards Every workshop environment is different. These are designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Always consider safety first, as it applies to the individual working conditions.

PARTS DIAGRAM

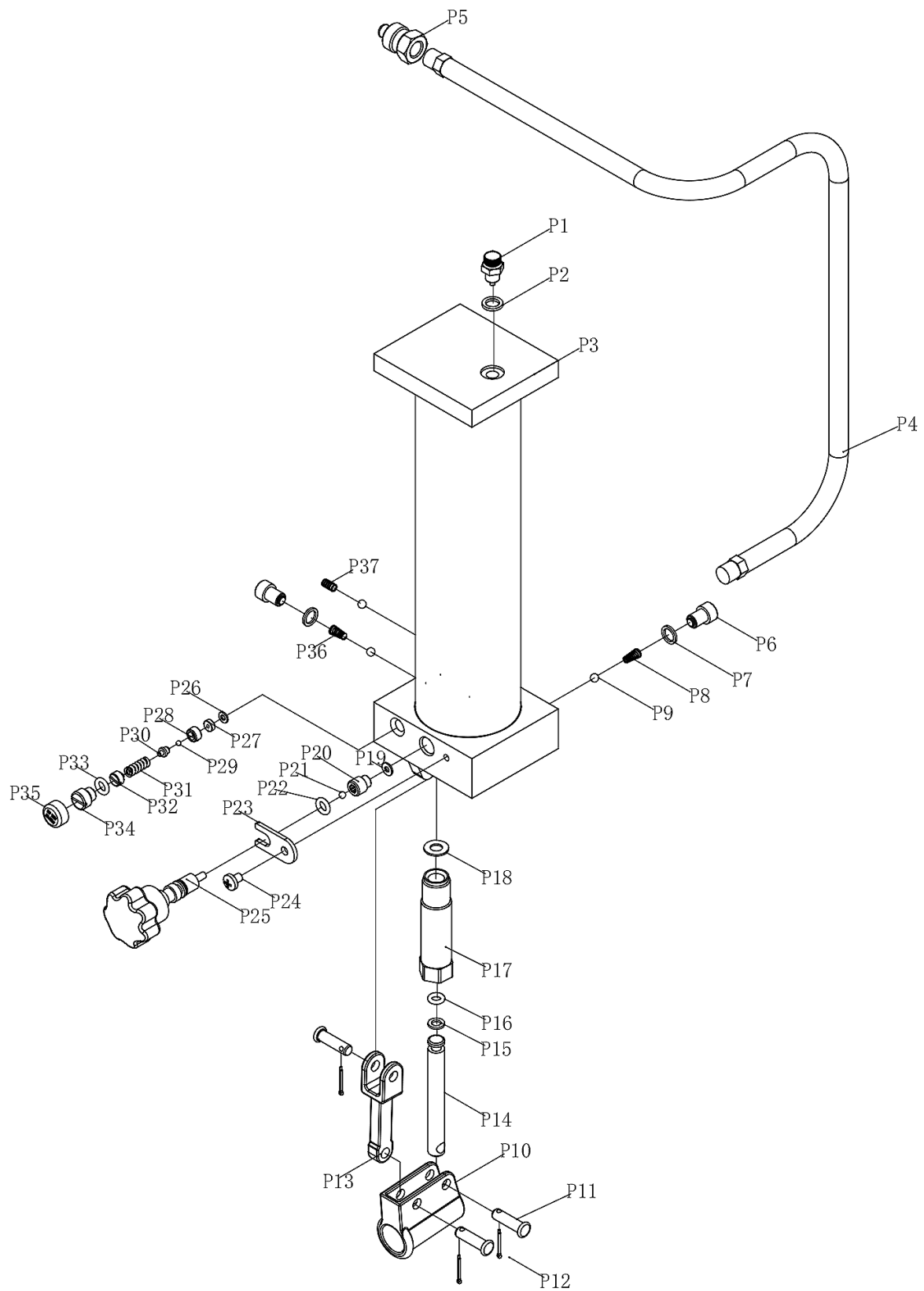


PARTS LIST

ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY
1	PRESSURE GAUGE	1	15	PIN	2
2	NYLON WASHER	1	16	CIRCLIP	4
3	RAM	1	17	SPRING WASHER	4
4	SCREW	1	18	NUT	4
5	SADDLE	1	19	BOLT	2
6	UPPER ROUND NUT	1	20	ROUND NUT	1
7	HANDWHEEL NUT	2	21	RAM PLATE	1
8	UPPER RAM PLATE	1	22	WORKING TABLE	1
9	WASHER	10	23	STEEL BLOCK	2
10	BOLT	4	24	SCREW	2
11	PUMP	1	25	HANDLE CLAMP	1
12	HANDLE	1	26	LOCK NUT	2
13	BOLT	4	27	FRAME	1
14	BASE SECTION	2	28		

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

PUMP - DIAGRAM



PUMP - PARTS LIST

ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY
P1	Screw	1	P20	Base For Rse valve	1
P2	Nylon Washer	1	P21	Ball	1
P3	Pump Base	1	P22	O Ring	1
P4	Oil Pipe	1	P23	U Limit	1
P5	Connector	1	P24	Screw	1
P6	Screw	2	P25	Release Valve	1
P7	Washer	2	P26	Washer	1
P8	Spring	1	P27	Valve Seat	1
P9	Ball	3	P28	Screw	1
P10	Handle Bracket	1	P29	Ball	1
P11	Pin	2	P30	Ball Cup	1
P12	Cotter Pin	3	P31	Spring	1
P13	Connector	1	P32	Screw	1
P14	Small Piston	1	P33	O Ring	1
P15	Washer	1	P34	Piston Ring	1
P16	O Ring	1	P35	Cap	1
P17	Piston Set	1	P36	Spring	1
P18	Washer	1	P37	Screw	1
P19	Washer	1			

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

NOTES:

[illegible]



ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

IMPORTED BY



Australian Distributor

**Hare & Forbes
Machineryhouse**
Sydney - Melbourne
Adelaide - Brisbane - Perth

Ph: 1300 202 200
www.machineryhouse.com.au



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