

**HI-FORCE HPF/ HBP WORKSHOP AND BENCH PRESS OPERATING
INSTRUCTIONS**

For use with the following presses:

HPB 10 tonne Bench Presses.

HPF 10, 25, 50, 100, 200 tonne Workshop Presses.

NOTE: FOR PUMP INSTRUCTIONS PLEASE REFER TO INSTRUCTION SHEETS FOR SPECIFIC PUMP MODELS.

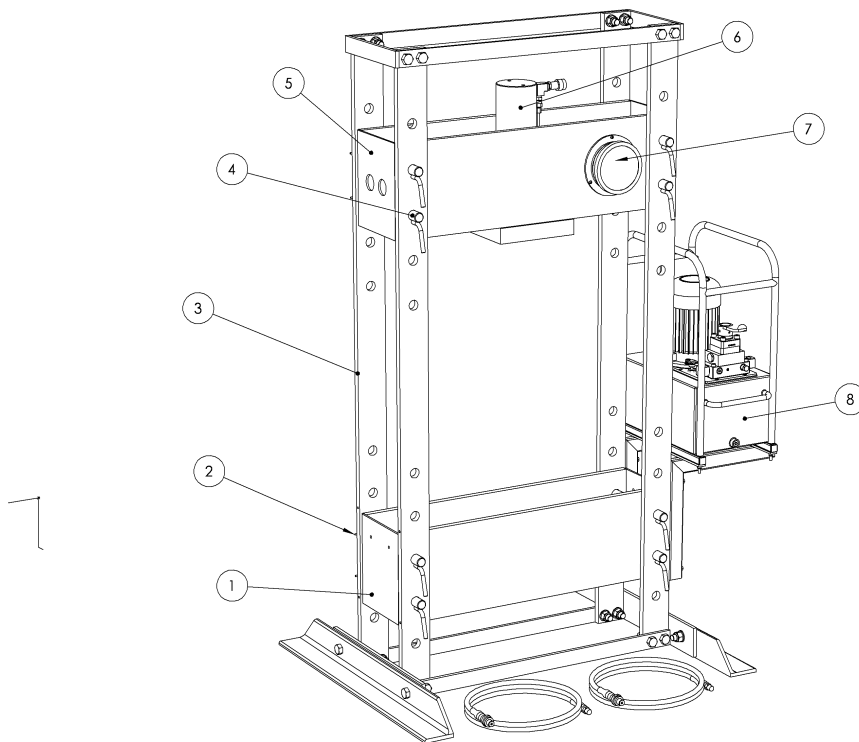
Safety Precautions.

- The press should be sited in a restricted access area and adequate barriers should be employed to prevent unauthorised approach.
- Take care that all bodily parts are clear of the press cylinder and work piece during operation of the press. Extra care is required when more than one person is in the work area. Maintain adequate communication between personnel.
- Never exceed the rated capacity of the press.
- Observe the pressure gauge regularly to monitor the load applied.
- Ensure that the press bed and head are fully supported by the load pins and that the 'R' clips are fitted to the load pins to prevent accidental movement.
- Do not attempt to remove the load pins with the press in operation.
- The press bed and head are heavy items. Suitable lifting/ handling equipment should be employed when adjusting the working height. A mechanical bed winch is available as an optional extra (50 and 100 tonne models only) to assist in this procedure.
- Always ensure that work pieces are adequately supported and cannot move laterally under load. Vee blocks are available as an optional extra to restrain cylindrical work pieces.
- Ensure that the load is applied vertically through the work piece.

READ THIS MANUAL BEFORE OPERATING THE TOOL. FAILURE TO OBSERVE THE FOLLOWING WARNINGS COULD RESULT IN SERIOUS BODILY INJURY.

Identifying major components

1. Press bed
2. 'R' clip.
3. Press upright.
4. Load pins.
5. Press head
6. Cylinder
7. Gauge
8. Pump.



Adjusting Press bed position prior to use.

1. When a mechanical bed winch is not fitted support the bed of the press with suitable lifting equipment.

Note: If the Press bed (1) has not been moved in some time, it may be necessary to free it from the Load pins (4) and /or the Press uprights (3) by gently tapping with a hammer.

When using a mechanical bed winch ensure that the cables are ALWAYS in contact with the pulleys, and that any slack in the system is ALWAYS taken up with the mechanical winch mechanism before removing the load pins. Failure to do so could result in serious personal injury.

2. Remove 'R' clips (2)
3. Pull out Load pins (4).
4. Adjust Press bed (1) and/ or Press head (5) vertically, to suit job. Take care during raising or lowering operations that the bed does not become jammed between press uprights or on any other obstruction.
5. Replace Load pins.
6. Replace 'R' clips.