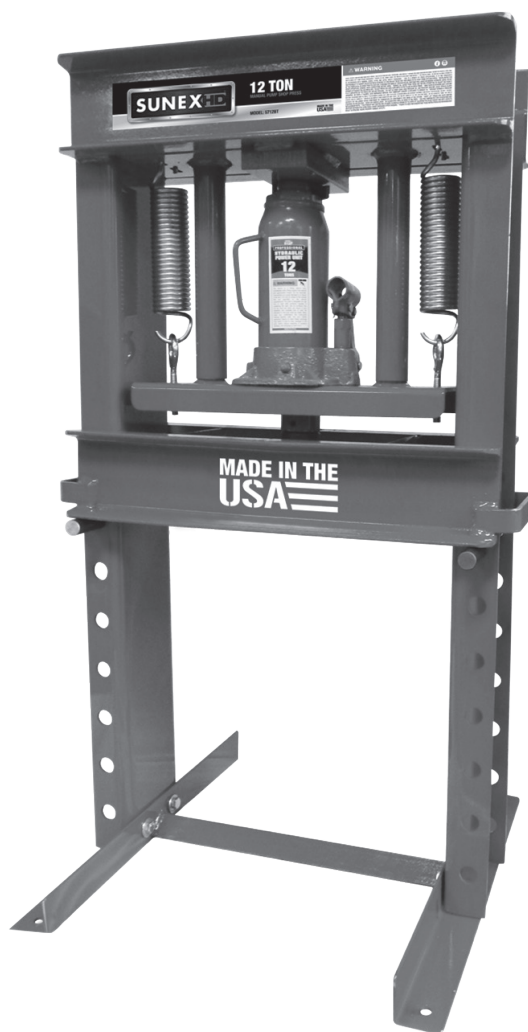


OWNER'S MANUAL

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	5	Exploded View Drawing and Parts List



SPECIFICATIONS

Capacity	12 Tons
Height	36-3/4"
Base Width	19-1/2"
Stroke	6"
Shipping Wt.....	93 Lbs.

WARNING INFORMATION



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

WARNING

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.



IMPORTANT: READ THESE INSTRUCTIONS BEFORE OPERATING

BEFORE USING THIS DEVICE, READ THIS MANUAL COMPLETELY AND THOROUGHLY, UNDERSTAND ITS OPERATING PROCEDURES, SAFETY WARNINGS AND MAINTENANCE REQUIREMENTS.

It is the responsibility of the owner to make sure all personnel read this manual prior to using the device. It is also the responsibility of the device owner to keep this manual intact and in a convenient location for all to see and read. If the manual or product labels are lost or not legible, contact Sunex for replacements. If the operator is not fluent in English, the product and safety instructions shall be read to and discussed with the operator in the operator's native language by the purchaser/owner or his designee, making sure that the operator comprehends its contents.

THE NATURE OF HAZARDOUS SITUATIONS

WARNING

The use of shop presses and their accessories is subject to certain hazards that cannot be prevented by mechanical means, but only by the exercise of intelligence, care, and common sense. It is therefore essential to have owners and personnel involved in the use and operation of the equipment who are careful, competent, trained, and qualified in the safe operation of the equipment and its proper use. Examples of hazards are components being pressed and breaking resulting in flying parts that are not secured from hitting the operator, the set up in the press is not secure, guards, shields or protective blankets are not used, improperly securing adjustments on the press, overloading and off-center loads.

METHODS TO AVOID HAZARDOUS SITUATIONS

WARNING



- Read, study, understand and follow all instructions before operating this press.
- Always wear safety goggles, users and bystanders.
- Parts being pressed may splinter, shatter, or be ejected from the press at a dangerous rate of speed. Because there are a variety of press applications, it is the responsibility of the press owner to provide adequate guards, eye protection and protective clothing to the press operator.
- Visual inspection of the press should be made before use, checking for signs of cracked welds, bent bed pins, loose or missing bolts, leaks, or any other structural damage. Corrections must be made before using the press.
- Do not go near leaks. High pressure hydraulic fluid can puncture skin and cause serious injury, gangrene, or death. If injured, seek emergency medical help as immediate surgery is required to remove the fluid.
- Prior to use make sure the press is securely anchored to a concrete floor.
- Keep hands, arms, feet, and legs out of work area. Accidental slippage can result in personal injury.
- Always use an accurate force gauge to measure pressing force.
- Do not exceed the rated capacity or tamper with the pressure/force settings. When attachments and adapters are used the rated capacity of the system shall be no greater than the rated capacity of the lowest rated component or combination of components that make up the system.
- Avoid off-center loads. Offset loads can damage ram and may cause load to eject at a dangerous rate of speed. Do not use any spacer or extender between the press ram plunger and the item being pressed. If there is not enough ram stroke, adjust the height of the movable bolster.
- Remove all loads from movable bolster before attempting to adjust bolster height. Beware of possible falling bolster.
- Press only on loads supported by movable bolster and press plates included. Do not support loads on floor or press frame legs.
- When using any accessories such as press plates or arbor plates, be certain they are centered on the movable bolster and in full contact with both sides of the bolster.
- Before applying load, be certain all movable bolster supporting pins are fully engaged. Verify lift cables (if equipped) are slack before pressing on the bolster.
- Always use a bearing shield when pressing bearings.
- Use caution when positioning work to be pressed to ensure the item to be pressed cannot be ejected at a dangerous rate of speed.
- Release hydraulic pressure before loosening any fittings.
- Maintain proper hydraulic fluid levels.
- Do not make any alterations or modifications to the press.
- This product may contain one or more chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. *Wash hands thoroughly after handling.*
- Failure to heed and understand these markings may result in serious or fatal personal injury and/or property damage.

CONSEQUENCES OF NOT AVOIDING HAZARDOUS SITUATIONS

WARNING

Failure to read this manual completely and thoroughly, failure to understand its OPERATING INSTRUCTIONS, SAFETY WARNINGS, MAINTENANCE INSTRUCTIONS and comply with them, and failure to comply with the METHODS TO AVOID HAZARDOUS SITUATIONS could cause accidents resulting in serious or fatal personal injury and/or property damage.

ASSEMBLY INSTRUCTIONS

1. Pick a place in the shop for positioning of the press. Make sure there is adequate room around the operator, placement of the protection shields and temporary storage for components to be pressed. The press area should not be in conflict with other machinery, production areas, or restrict normal flow of shop activities during the work period. The floor should be clean and free from any obstacles or oil that could cause the operator to slip.
2. Since the shop press should be anchored, make sure the base of the press being mounted to is secure and provides adequate stability. Use grade 8 hardware to secure press feet to installation base.
3. Important – before anchoring press, make sure all press components are properly aligned and hardware is tightened. If the two vertical side extrusions of the protector shield (optional) are not properly aligned, the shield will not slide up and down properly.
4. Place press in vertical position (on head part of press), place press pin (#3) into the second hole of press leg (open end of press), left and right side.
5. Place press bed (#2) onto the pins (from open end of press), allowing press bed to rest on pins. Handles of the press bed must be on the feet side of the press to ensure proper operation.
6. Attach feet (#8) to right and left using (2) 3/8" bolts, 3/8 x 1 1/4" washer (#11) and 3/8" hex head nuts with lock washers, (#11), one on each foot.
7. Insert Z Bar leg (#9) between press legs. Attach Z bar to both right and left foot using remaining (2) 3/8 x 1 1/4" bolts, 3/8" washer (#11) and 3/8" hex head nuts with lock washers, (#11).
8. Stand press into upright position (feet on floor), allow press bed to rest on feet, remove press pins and position press bed into desired height location, place press pins under press bed, allowing bed to rest on pins.
9. Square up assembly making sure that the legs are not leaning in any direction and tighten bolts securely.
10. Place hydraulic unit on press carriage (#1) and position so that when the ram is extended, it will seat in the inside corner of the ram position bracket.
11. Place press plates (#5) onto press bed.
12. Check all bolts for tightness and hydraulic unit for any leaks. **Note: Always use bearing shield when pressing bearings.** If press rocks and is not level, loosen feet slightly to compensate, once level retighten bolts to ensure security.

OPERATING INSTRUCTIONS



This is the safety alert symbol used for the OPERATING INSTRUCTIONS section of this manual to alert you to potential personal injury hazards. Obey all instructions to avoid possible injury or death.

1. Press operator and all observers must wear eye protection, protective clothing and shoes before operating the press.
2. Keep body parts out of work area during a pressing operation. Make sure all guards are properly adjusted and secured.
3. Consider the work to be accomplished and then determine:
 - a. The amount of ram stroke required to accomplish the job.
 - b. The correct punch or adapter to be used and then install on the ram.
 - c. The distance the ram should be from the component to be pressed and the required press bed height to support the component.
 - d. Any adapters used for pressing must have a maximum tonnage rating equal to or higher than the rated capacity of the press.
4. Raise the press bed to the required height by first removing the press bed pins. Once the pins are removed, raise or lower the press bed to the required height. The holes in the press bed must align with the closest holes in the press frame uprights before the bed pins can be installed. Make sure the press bed pins are fully engaged with the holes in the press bed or the channel flanges or back sides of the press bed and the holes in the paralleled uprights on both sides of the press frame. **DO NOT ATTEMPT ANY PRESS WORK WITHOUT FULL ENGAGEMENT OF ALL PINS.**
5. Prepare set up of the component to be pressed and appropriate adapters or fixtures to adequately support the component during the pressing operation. Make sure set up is stable and secure, the ram force is straight, and parts being pressed cannot slip out or break. The owner of the press must provide shielding that is practical and necessary for each application.
6. Position appropriate guarding (protective shield, protective blanket, etc.) between work setup and press operator.
7. Never attempt to raise or lower the press bed until the work piece and adaptors are removed from the bed.
8. Inspect the length of the bed lifting cables (if so equipped) every 3 months to make sure they are not frayed, worn, crushed or stretched. Replace, adjust or repair before using press.
9. Air may become trapped in the hydraulic jack during shipping and/or handling. An air trapped jack will not pump up the required incremental pump strokes or pumping may feel spongy. Follow these instructions to purge air from the jack's hydraulic system?
 - a. Turn the jack's release valve with the handle provided all the way in a clockwise direction until tight. Now turn the release valve two full rotations in a counterclockwise direction.
 - b. Now put the pump handle in the pump handle receiver and activate the jack approximately 15 times.
 - c. Close the release valve by turning it clockwise until it stops. Pump the jack until the ram reaches maximum height.
 - d. Repeat steps "a" through "c" until all air is purged.

PREVENTATIVE MAINTENANCE



This is the safety alert symbol used for the PREVENTATIVE MAINTENANCE section of this manual to alert you to potential personal injury hazards. Obey all instructions to avoid possible injury or death.

1. Inspect the press before each use for cracks, breaks, signs of damage/fatigue, hydraulic or air leaks, loose or missing hardware or modifications. Do not use the press if any of the above conditions exist until the conditions are corrected.
2. The location of the press should not expose it to inclement weather, corrosive vapors, abrasive dust, or any harmful elements.
3. Lubricate moving parts once a month with a general purpose marine grease. Do not lubricate press accessories, press bed work surface or ram.
4. It should not be necessary to refill or top off any pump reservoirs with hydraulic fluid unless there is an external leak. External leaks, if caused from other than tightening hydraulic components, must be handled by calling Sunex customer service. NEVER USE ALCOHOL, HYDRAULIC BRAKE FLUID OR TRANSMISSION FLUID IN THE HYDRAULIC SYSTEM. Use Chevron Hydraulic Oil AW ISO 32 or its equivalent Unocal Unax AW 150.
5. Every press owner is responsible for keeping press labels and owner's manual readable. Contact Sunex for replacement labels and manual if unreadable.

LIMITED WARRANTY

SUNEX INTERNATIONAL, INC. WARRANTS TO ITS CUSTOMERS THAT THE COMPANY'S SUNEX TOOLS® BRANDED PRODUCTS ARE FREE FROM DEFECTS IN WORKMANSHIP AND MATERIALS.

Sunex International, Inc. will repair or replace its Sunex Tools® branded products which fail to give satisfactory service due to defective workmanship or materials, based upon the terms and conditions of the following described warranty plans attributed to that specific product.

This product carries a ONE-YEAR warranty. During this warranty period, Sunex Tools will repair or replace at our option any part or unit which proves to be defective in material or workmanship.

Other important warranty information

This warranty does not cover damage to equipment or tools arising from alteration, abuse, misuse, damage and does not cover any repairs or replacement made by anyone other than Sunex Tools or its authorized warranty service centers. The foregoing obligation is Sunex Tools' sole liability under this or any implied warranty and under no circumstances shall we be liable for any incidental or consequential damages.

NOTE: Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. Return equipment or parts to an authorized service center, transportation prepaid. Be certain to include your name and address, evidence of the purchase date, and description of the suspected defect. If you have any questions about warranty service, please write to Sunex Tools. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

Repair kits and replacement parts are available for many of Sunex Tools products regardless of whether or not the product is still covered by a warranty plan.

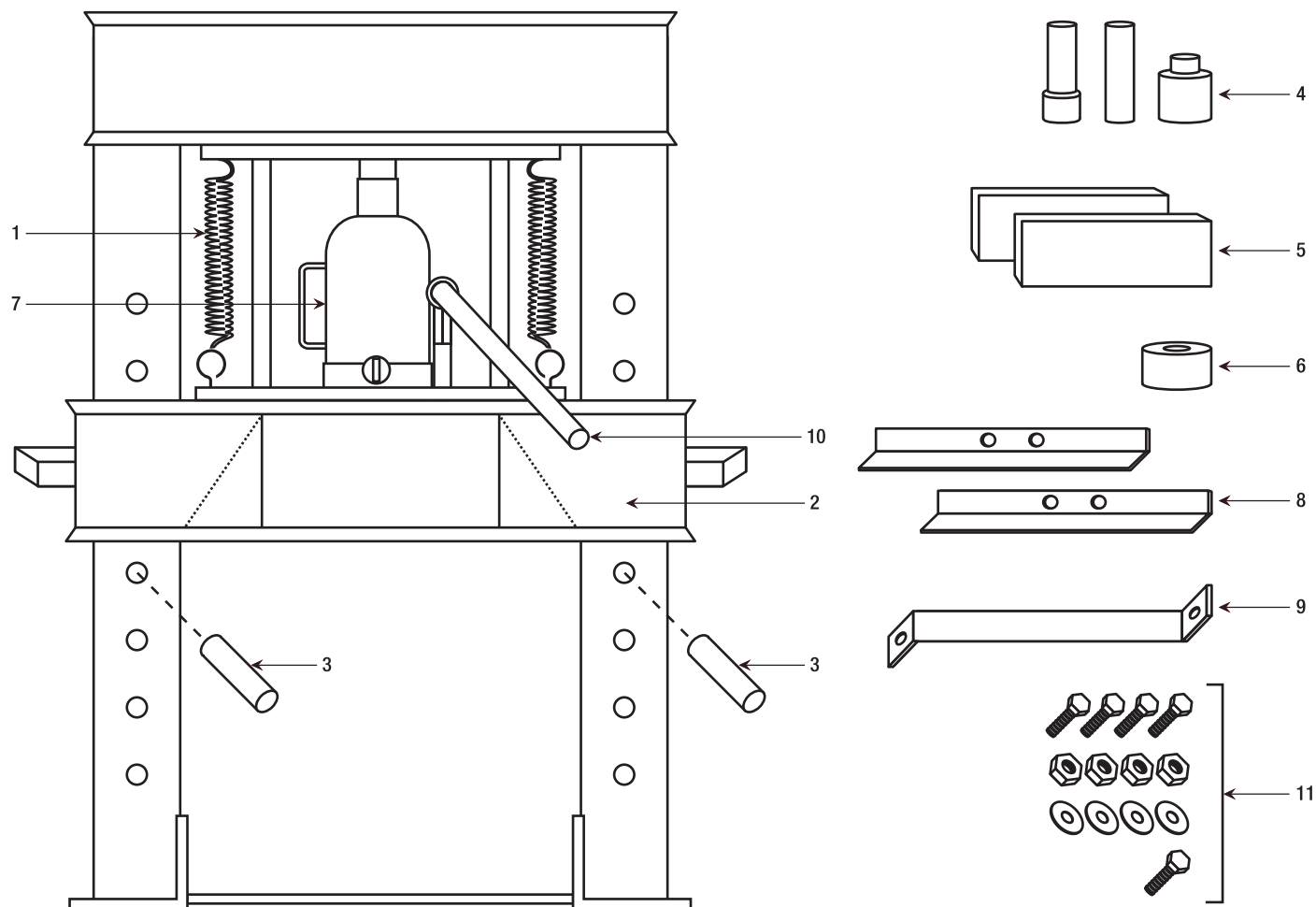
SHIPPING ADDRESS:

Sunex Tools
315 Hawkins Rd.
Travelers Rest, South Carolina 29690

MAILING ADDRESS:

Sunex Tools
P.O. Box 1233
Travelers Rest, South Carolina 29690

PARTS LIST AND DRAWING



INDEX NO.	PART NO.	DESCRIPTION	QTY.
1	RS345009	2" Pushing Adapter (Spring)	2
2		Press Bed	1
3	RS550012	Press Pin	2
4	52PPK3	3 Piece Punch Kit	1
5	RS550041	Press Plate	2
6	RSBS1	Bearing Shield	1
7	912P	12 Ton Power Unit (includes handle)	1
8	RS12FT	Press Feet	2

INDEX NO.	PART NO.	DESCRIPTION	QTY.
9	RS550049	Z Bar Leg	1
10	RS49HDL12	Power Unit Handle	1
11	RS5712BK	Press Hardware Kit	1 set
		3/8" x 1-1/4" Hex Head Bolt	4
		3/8" Nut	4
		Washer	4
		5/16"-13 x 1" Hex Head Bolt	1
not shown	RS5712BTLK	Product Label Kit	1 set

Only items identified by part number are available separately.

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins or other markings on the paper.



This image shows a single page of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page, leaving small margins at the top and bottom. There is no handwriting or other markings on the paper.



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