

OWNER'S MANUAL

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PRESS SPECIFICATIONS

Sunex Part No.	A	B	C	D	E	F	G	H	I	J
57100AH	78"	34"	40"	15-1/2"	5"	1-1/4"	SPX	Y	Y	Y (2)

- A - Total Height
B - Inside Width
C - Press Feet Length
D - Bed Width
E - Stroke (ram travel distance from fully retracted position to fully extended position)
F - Pin Diameter
G - Motor Control
H - PB Winch
I - Sliding Head
J - Press Plates Included

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 and use employer supplied personal protective equipment (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.

SETUP & OPERATING INSTRUCTIONS

SETUP

1. Pick a place in the shop for positioning of the press. Make sure there is enough adequate room around the press for the operator, placement of protection shields and temporary storage for components to be pressed. The press area should not be in conflict with other machine or production areas or restrict the 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 must be anchored to the shop floor, make sure the floor provides a thick and secure enough concrete base for installation grade 8 hardware is used to secure the press to the floor.
3. **IMPORTANT** - before anchoring press to floor, make sure all press components, including protector shield (if installed) are properly aligned and hardware tightened. If the two vertical side extrusions of the protector shield are not properly aligned the shield will not slide up and down properly.
4. On all presses operated by air, install a quick disconnect air nipple that is compatible with the shop's system, to the press's air pump. Connect an unobstructed air line to the nipple. All air operated presses require 120 psi air pressure.
5. On all presses which are operated by electro-hydraulic pumps, plug the pump's power cord into a dedicated and approved 110v outlet.
6. The air/hydraulic pump for the 100 ton capacity press has a pendant with "ON" and "OFF" buttons that control the pump motor. The hydraulic pump has a three position lever located at the pump. The center position is neutral and pushing the lever in one direction extends the ram for pressing, pushing the lever in the opposite direction retracts the ram.

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. Consider the work to be accomplished and then determine:
 - a. The amount of ram stroke required to accomplish to the job.
 - b. The correct punch or adapter to be used and then install on 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. The proper positioning of the ram on the top press bolster since the ram can be slid across the length of the press bolster.
2. Raise the press bed to the required height by first removing the press bed pins. This might require the winch to be activated in order to release pressure off the pins. Once the pins are removed, turn the winch crank to 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 and both channel flanges on both press frame uprights. **DO NOT ATTEMPT ANY PRESS WORK WITHOUT FULL ENGAGEMENT OF ALL PINS.**
3. Prepare set up of 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.
4. Position appropriate guarding (protector shield, protective blanket, etc.) between the work setup and the press operator.
5. Wear eye protection, protective clothing and shoes before operating the press.

NOTES

INSPECTION

Visual inspection of the shop press should be made before each use of the press, checking for damaged, loose or missing parts. Each press must be inspected by a manufacturer's repair facility immediately, if subjected to an abnormal load or shock. Any press which appears to be damaged in any way, is found to be badly worn, or operates abnormally must be removed from service until necessary repairs are made by a manufacturer's authorized repair facility. It is recommended that an annual inspection of the press be made by a manufacturer's authorized repair facility and that any defective parts, decals or warning labels be replaced with manufacturer's specified parts. A list of authorized repair facilities is available from the manufacturer.

SAFETY INSTRUCTIONS

- CHECK YOUR LOCAL, STATE AND FEDERAL REGULATIONS REGARDING THE SAFE USE OF THIS EQUIPMENT.
- Your safety is top priority. Please handle equipment with care.
- Fully retract unit and remove all items from the press bed frame.
- Support the press bed, and remove the pins.
- Raise or lower bed to desired height and reinstall press pins. Be certain pins are fully engaged in the parallel flanges of the upright columns.
- Position press on a flat, level, hard surface, preferably concrete. Make sure all nuts and bolts are tight.
- Clear the area of bystanders, especially small children, before using.
- Set the press bed to the required height. The press is most effective when the work piece is located 1 inch below the ram's retracted position. The compression stroke can include the entire 6 inch working range.
- The press is designed to exert a force on anything which is positioned beneath its ram. The work piece can pop out from under the ram at a high rate of speed and injure someone.
- Pressing Bearings: It is essential that you use the bearing shield when pressing bearings on or off.

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.

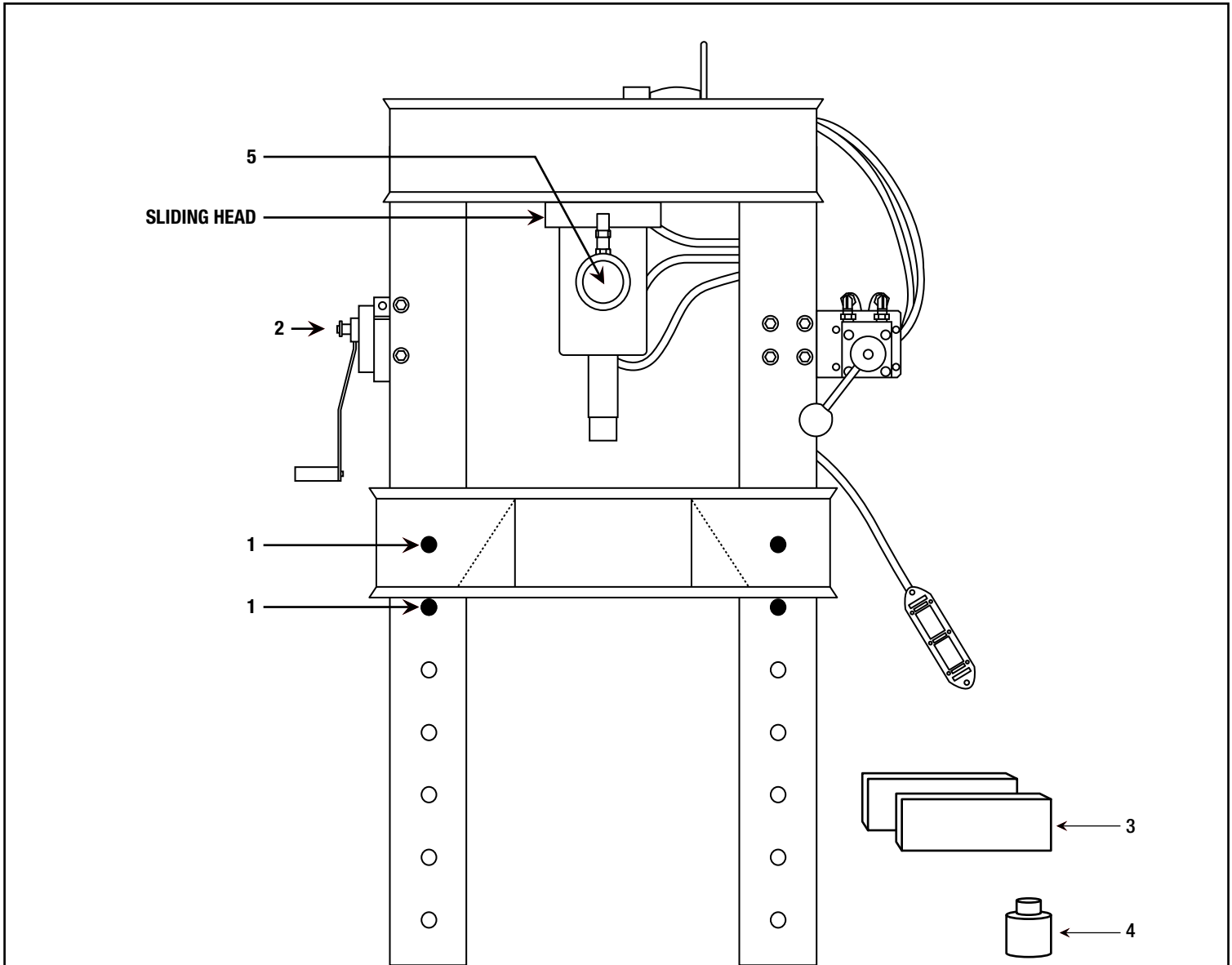
SHIPPING ADDRESS:

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

MAILING ADDRESS:

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

PARTS DIAGRAM



ITEM NO.	SUNEX PART NO.	DESCRIPTION	QTY.
1	RS57100PP	Press Pin (100 Ton Press)	4
2	RS150W	Winch (only)	1
3	RS150PP	Press Plate	2
4	RS57100PA	Pushing Adapter	1
5	57100LFG	Liquid Filled Gauge	1
not shown	RS57100EPLK	Product Label Kit (57100EP)	1

Only items identified by part number are available separately.