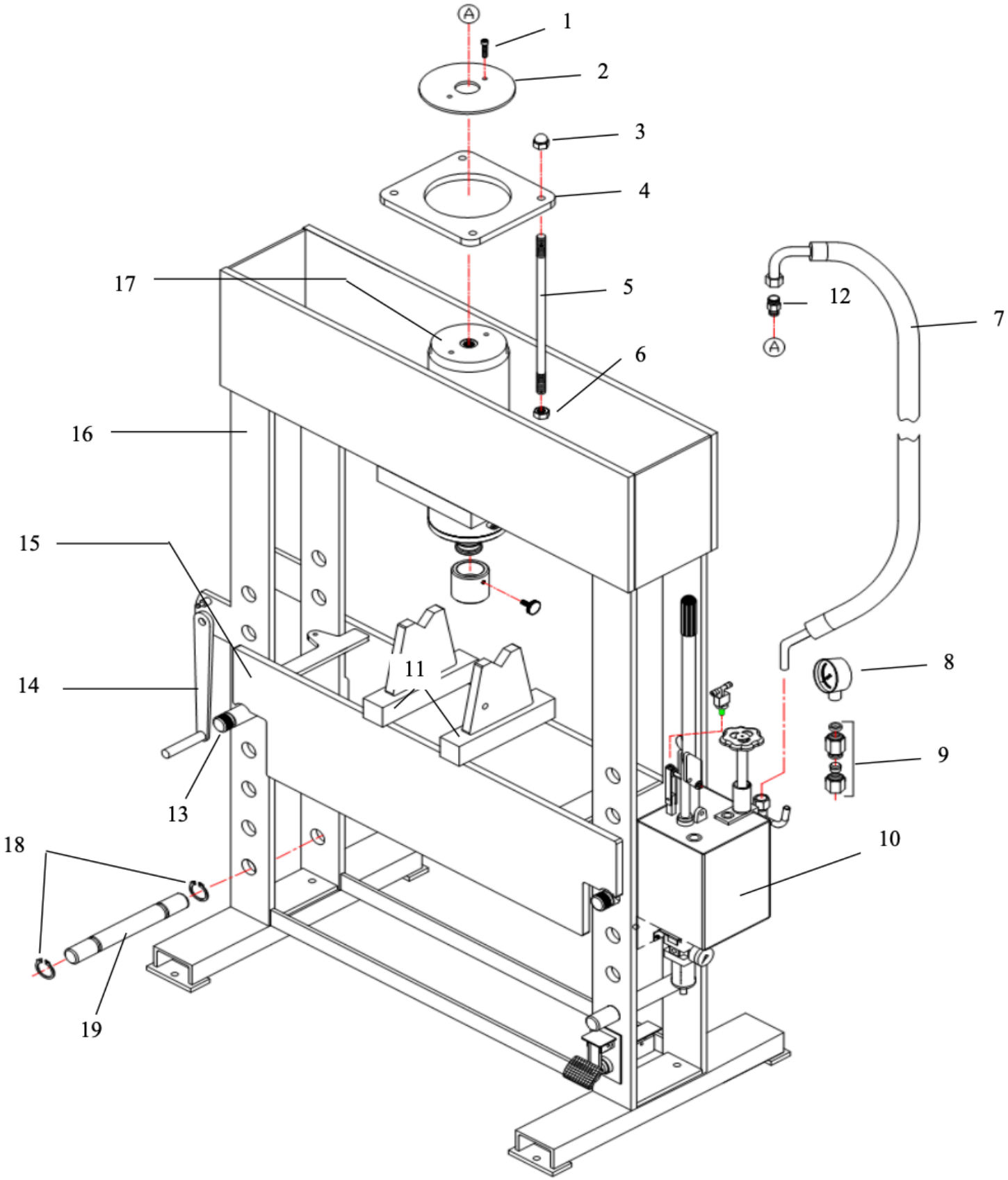
HP 40 G2

2015.08.20 →



2018.06.27

Instruction Manual

Press with air operated fast approach and air return piston.

Model: HP/FP40 G2, HP/FP50 G3, HP60 G2, HP70 G2

Important: Read and understand this manual before use.

Warning!

If the instructions below are not followed, it can cause serious personal injury.

Instruction:

Make sure that you and your colleagues are aware of the product and its possibilities. All users must for their own safety and the safety of others follow the operating/safety instructions. Always keep this manual intact and stored nearby the product.

Transportation:

1. **Using a forklift:** The forks are placed under the top frame, the lifting points are marked on the transport packaging.

2. **Using a crane:** Only use straps with a capacity high enough to lift the weight of the press. Note: The straps must only be mounted at the top of the press and must be protected from sharp edges .

3. **Using a lifting trolley**: The press must be supported so it cannot tip over.

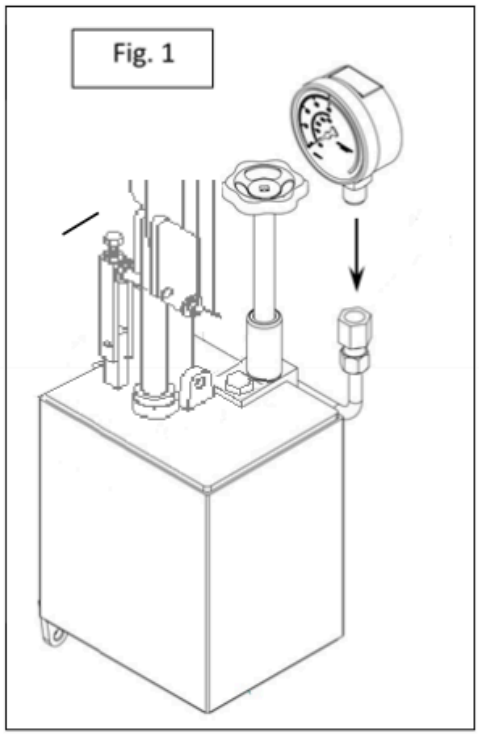
Safety:

Do not use the press beyond its intended purpose.
When using the press be aware of the risk of ejection of work pieces.

Preparation:

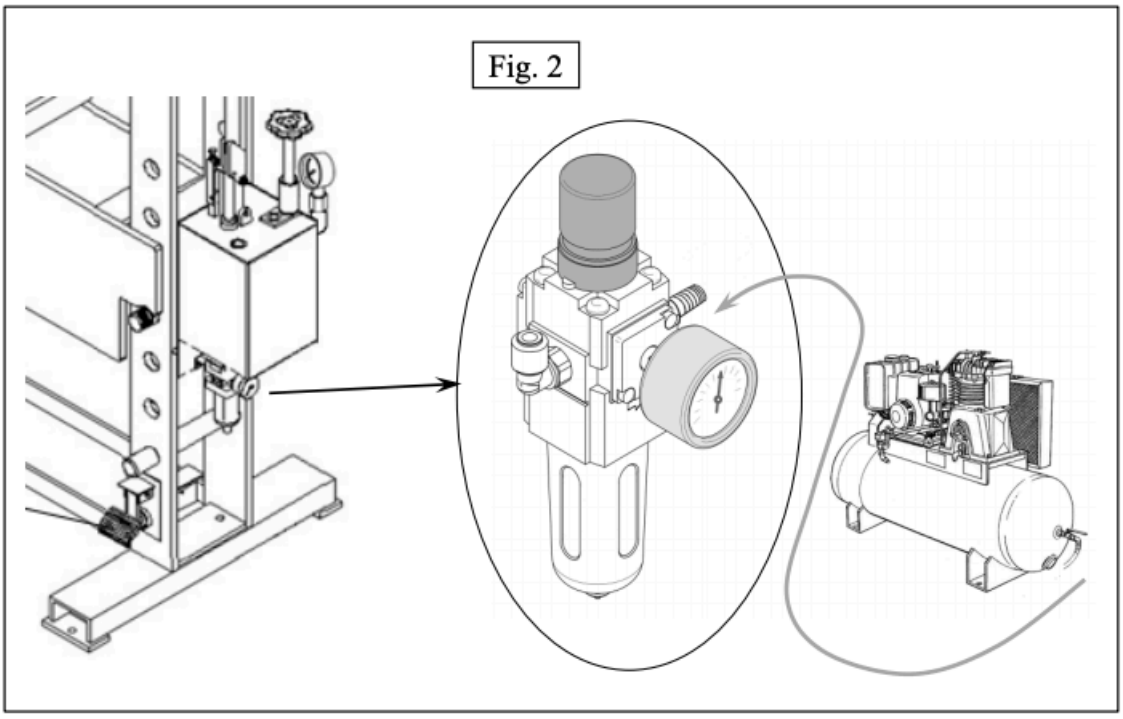
1. An authorized/skilled operator must visually check the press for leaks and damages, this inspection must be made at least one time annually.

2. Install the pressure gauge. (Pressure gauge is not mounted on the press, to avoid damage during transport).
   Do not use packing tape or equivalent.
   Tighten the presser gauge with a 22 mm wrench while holding a 27 mm wrench counter to tighten the base of the pressure gauge towards a cutting ring. In case the pressure gauge isn't turned into the right position it can be rotated by loosening the bottom nut with a 24 mm wrench while holding a 27 mm wrench counter, Turn the manometer so it's facing the right way and tighten the lower nut again.



3. Connect the Air supply: 6 to12 bar (88 to 176 psi). (See Fig.2)

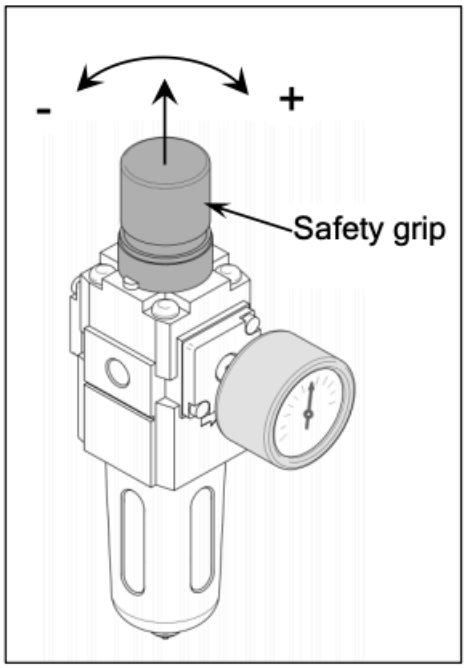
Fig. 2



4. This press has air operated fast approach and air return, and is therefore fitted with a water separator and a pressure regulator located under the oil tank.
Adjust the pressure regulator for **Max** 0.7 MPa (7 bar) (102 psi).

Adjustment of the air pressure regulator.
The pressure regulator can be adjusted by pulling up the safety grip (see Fig. 3)
To increase the pressure the safety grip is turned clockwise (+).
To lower the pressure the safety grip is turned counterclockwise (-).
Adjust the pressure regulator to Maximum 0.7 Mpa (7 Bar) (102 psi)
When the correct working pressure is reached, click the safety grip down to lock the regulator.

Fig. 3



5. The press is from the factory filled with the correct olie volume (See section Oil change)
The immediate visual low oil level in the oil container is normal.

Operation Instruction:

Raise the table just above the desired working height, insert rivets (A) and lower the table until it is strikes the rivets, place the V-blocks (B) on the table. **Please note!** From 55 % of the max. pressure and onwards the material must always be supported by both of the V-blocks.

These presses have a manual pump with 3 functions / systems:

1. An air operated function for quick approach of the piston (H) to the work piece.
2. A manual operated high pressure hydraulic function, which is pumped manually with hand or foot (depending on the model) to build up pressure to the press maximum capacity (Maximum working pressure)
3. An air operated returning function which returns the piston by air pressure.

Functions descriptions

Make sure that the pump return handle (C) is closed before initiating a press job.

Air featured approach of piston (H)

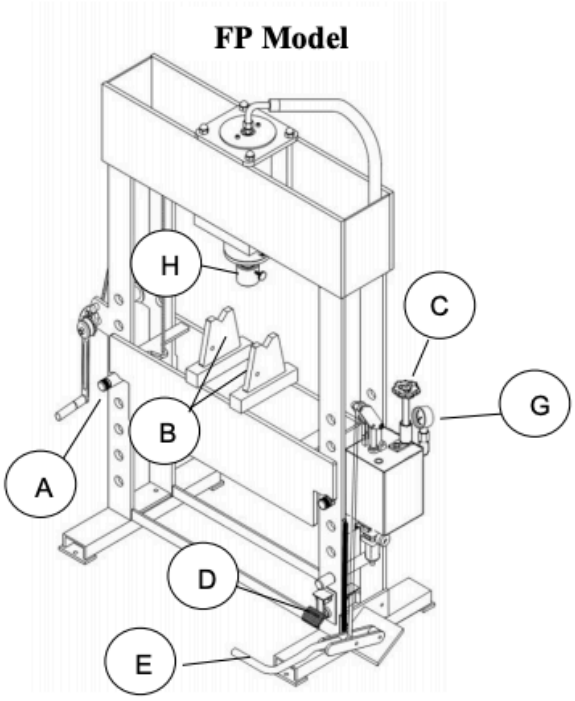
In the bottom right hand side of the press there is a small foot pedal (D). When this is activated the piston (H) is approaching the work piece by air pressure. When releasing the foot pedal (D) the piston (H) stops. Please notice! This air approach feature is only for approach of the piston – not for pressing.

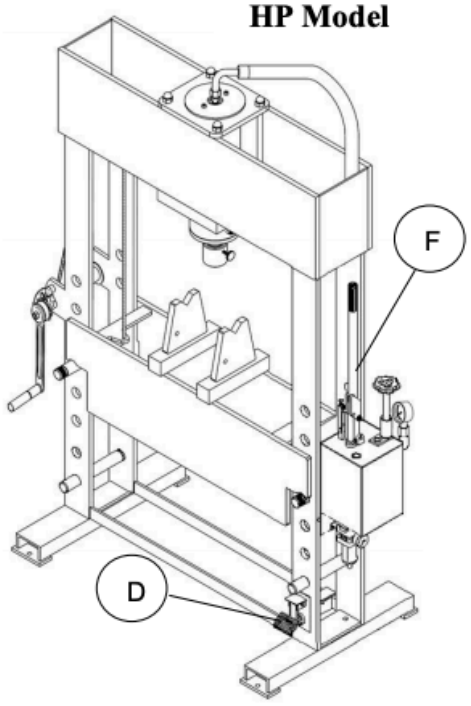
High pressure

When the piston (H) is close to the work piece, the pressure is build up by pumping the foot pedal (E) / pump handle (F). When building up the pressure the operator can see the pressure building on the pressure gauge (G).
Please notice! Never use the press without tooling or pressure head. Using the piston to press directly on the working piece can damage the piston.

Returning the piston

The Piston (H) is returned by air pressure. When the return handle (C) is turned counterclockwise, the piston is return by air pressure. By turning the return handle (C) clockwise the return of the piston is stopped.





WARNING! Do not press beyond the specified max. pressure and max. stroke, as this can cause damage to the cylinder gaskets. If this should happen please do not continue to activate the pump when the press has reached the full stroke.

Use of the hydraulic Compac press:

The hydraulic press may be damaged if the following instructions for the use of this press are not followed. Any damage that occurs from wrong use is not covered by warranty.
The item which is inserted into the press should always be supported correctly, this means that the item should be stable and it should not be able to move during the compression phase.
The press must constantly during the whole compression phase be able to make a vertical pressure.
As a general protection of the stuffing box, piston and cylinder, it is recommended to use the shortest possible length of stroke. This can be obtained by lifting the press table as close to the returned piston as possible. This will decrease the risk of excess sideways pressure on the piston and increase the expected service life of the press.
Warning! If the above instructions are ignored, there will be a great risk of person injury and damaging of the press.

Maintenance and service:

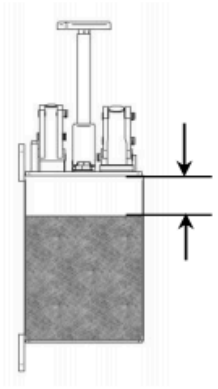
Drain the water separator regularly by turning the plug at the bottom of the water separator.
When emptying the water separator turn counter clockwise, and remember to fasten the plug after emptying.
A lack of emptying the water separator will cause corrosion of the piston and cylinder.
Errors occurred by lack of emptying the water separator is not covered by warranty.

The cylinder and the pump are self-lubricating.
All moveable parts are lubricated as needed.
Oil Change is needed every 1 to 2 years.

The press must be filled with hydraulic oil - Castrol type Hyspin AWS22 (viscosity 22 at 40°C) or any equivalent oil specification.

Oil Change:
Remove the oil plug on the oil tank. Drain the oil and fill it with new oil (see oil specification).
When changing the oil it is important that no impurity gets into the pump, this can cause damage to the hydraulic system.

Model:	Oil Volume	Oil level
HP40, HP50	5,5 L	70 mm
HP60, HP70	9 L	100 mm



Oil specification:

Castrol Hyspin AWS 22 or any equivalent hydraulic oil from other suppliers.

Spare parts: Please look for the spare parts drawing on our webpage www.compac.dk

Decommissioning: When disposing of the press. Drain the hydraulic oil and hand it over to an approved receiving station.