

## C-Frame Bench Press

Max. Capacity: 25 Tons

### SAFETY PRECAUTIONS

- Operators must read and carefully follow the operating and safety precautions before assembling or using this press. Most problems with new equipment are caused by incorrect assembly or operation.
- Operators must read and carefully follow the operating and safety precautions for the pump and ram used with this press.
- The owner of the press is responsible for the press being installed and operated according to federal (OSHA), state, and local safety standards. Safety-related decals must be replaced if they become hard to read.
- Safety glasses must be worn at all times by the press operator and anyone within sight of the press.
- Keep hands out of the work area during a pressing operation.
- Locate the press in an isolated area or shield the press to minimize danger to others.
- Work pieces must be well supported and aligned so that ram force is straight, and parts being pressed cannot slip out or break.
- To prevent accidental slippage, do not place work pieces on the press bed or apply hydraulic force until the cylinder mounting pins are in place.
- To prevent breakage, do not overload adapters. Pushing or pulling adapters used with this press must have a maximum tonnage rating equal to or higher than the maximum tonnage rating of the press.
- It is impossible for the manufacturer to provide practical "all-purpose" shielding because this is a general purpose press that can be used in many different ways. The owner of the press must provide shielding that is practical and necessary for each application. Some safety is provided by wrapping the piece in a protective blanket, such as those offered in the Power Team catalog, before applying pressure.
- This press can exert an extremely high force at a moderate hydraulic pump pressure. If you have any questions concerning how much force is exerted at a given pressure, contact Power Team Technical Services.

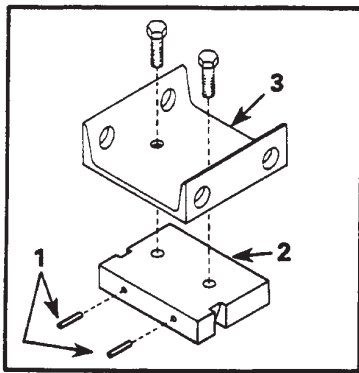


FIG. 1

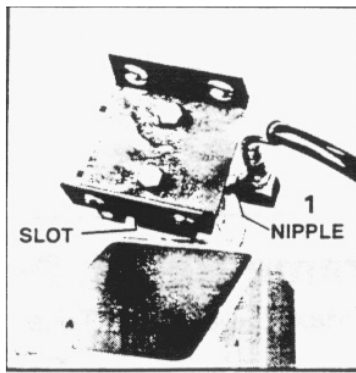


FIG. 2

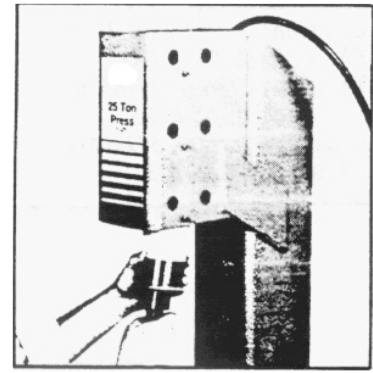


FIG. 3

### ASSEMBLY:

1. Drive the two roll pins (FIG. 1, Item 1) into the top plate (FIG. 1, Item 2) until the roll pins "bottom out".  
**IMPORTANT:** The slot on the top plate must be positioned as shown in FIG. 2.
2. Using the two 1/2" cap screws, securely attach the ram mounting channel (FIG. 1, Item 3) and top plate (FIG. 1, Item 2) to the ram.

**WARNING** — Do not over-tighten hydraulic connections, connections need only be tightened securely and leak-free.

**IMPORTANT:** Either a high grade of non-hardening pipe sealer or teflon tape may be used to seal hydraulic connections provided only one layer of tape is used. Apply carefully to prevent the tape from being pinched by the coupler and broken off inside the system. Any loose pieces of tape could travel through the system and obstruct the flow of oil or cause jamming of precision fit parts.

3. Attach the nipple (FIG. 2, Item 1) to the ram. Attach elbow to the nipple, positioning the elbow as shown.
4. Attach the gauge assembly to the hydraulic pump so the gauge can be easily read while operating the C-Frame Press. If your press is equipped with a pedestal, do not position the gauge until the press is fully assembled.
5. Install the six ram support screws, see FIG. 5.
6. Lower the ram assembly into the press frame until it rests on the support screws (see FIG. 3).
7. Install the two bolster pins (see FIG. 4).  
**IMPORTANT:** After installing the bolster pins, adjust the support screws (FIG. 5) evenly until the ram assembly is centered. The ram assembly must be positioned so the bolster pins can be easily installed. Repeat this procedure for the two additional ram positions.
8. Adjust the set screws to the proper depth. See FIG. 5.  
**IMPORTANT:** If your press is equipped with a pedestal, the pump must be mounted on the pedestal. See pedestal section. The following procedure applies only to units without pedestals.
9. Determine which of the mounting holes (see FIG. 6) are correct for your pump. Mount the two pump mounting brackets using the four 5/8" cap screws.
10. Fasten the pump to the pump mounting brackets using the four 5/16" nuts and cap screws, see FIG. 6.
11. Using four 1/2" fasteners, securely attach the press to your working surface.
12. Bleed the hydraulic system by following the instructions for pump and ram.  
**IMPORTANT:** Always check the pump oil level after bleeding the system.

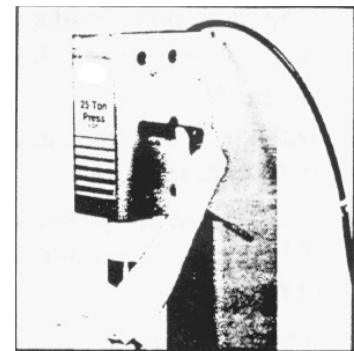


FIG. 4

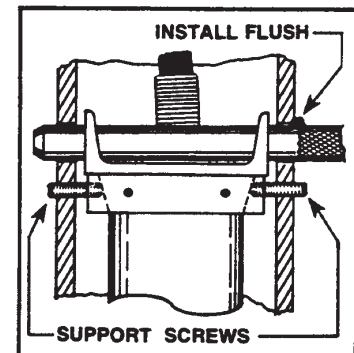


FIG. 5

### Ram Adjustment

To reposition the ram, the bolster pins must be removed and the ram moved up and back to clear the set screws. Raise or lower the ram to the desired level and slide it forward until it rests on the set screws.

Once the ram is in the desired position, secure in place using both bolster pins. (See FIG. 5).

**WARNING:** Both bolster pins must be inserted until their stops are flush against the tube wall. (See FIG. 5.)

### OPERATION:

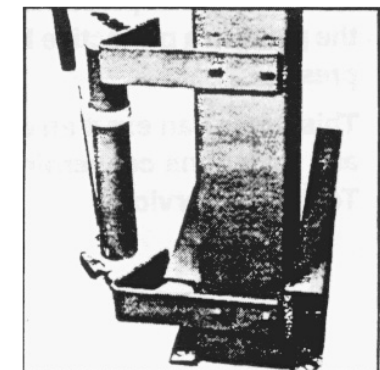


FIG. 6

**Adapter Attachment**

When using this or any other maximum strength. (See FIG. 8.)

25 Ton Adapter, tighten to the full thread length available to have

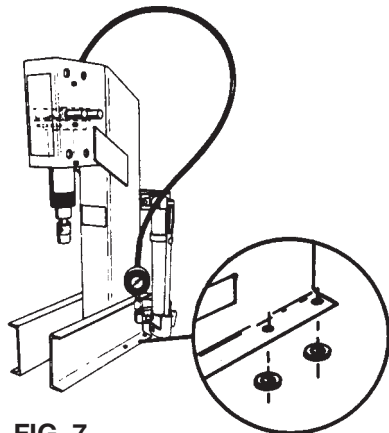


FIG. 7

INSET A

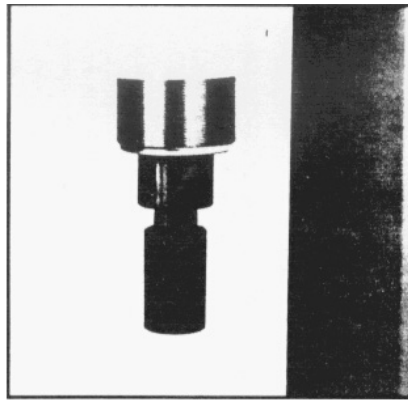


FIG. 8

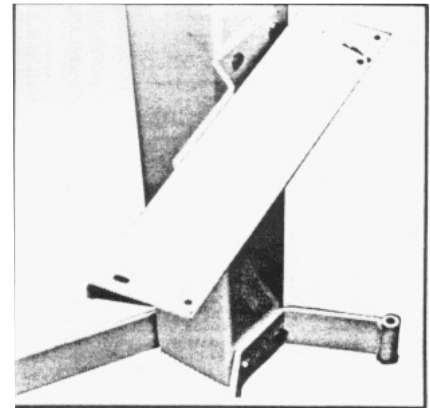


FIG. 9

**NOTE:** The press may require shimming (see Figure 7 Inset A) before attachment to a work bench or the pedestal. Add Washers (P.N. 12004) under the press mounting holes on the low side until the press is vertical.

**Pedestal**

**⚠ WARNING:** The pump must be mounted on the pump mounting bracket when using the pedestal otherwise the press will tip over in use.

**Note:** The press pedestal must be fully assembled before attaching it to the C-frame bench press.

**Pedestal Assembly**

1. With the pump bracket mounting holes on the right-hand side of the main tube, attach the two legs to the main tube using four 3/8" cap screws and nuts. See FIG. 9, Item 1.

**Note:** The air pump used on the 207511 does not have a mounting bracket and is located on the floor.

2. Using two 3/8" cap screws and nuts, fasten the pump mounting bracket to the main tube. See FIG. 9, Item 2.

3. Securely fasten the pedestal to the C-frame press using the four 1/2" cap screws and nuts.

4. Attach the pump to the pedestal pump mounting bracket reusing the 1/4" mounting bolts.

**Note:** Position the gauge so that it can be easily read while operating the C-frame press.

5. Position the hose so it does not make contact with the press frame. This can be done by loosening the swivel fitting near the gauge, rotating the hose slightly and retightening the swivel fitting.

6. After the assembled press/pedestal has been moved to its desired location, level the machine using two leveling screws shown in FIG. 10.

7. Bleed the hydraulic system by following the instructions for the pump and ram.

**IMPORTANT:** Always check the pump oil level after bleeding the air from the system.

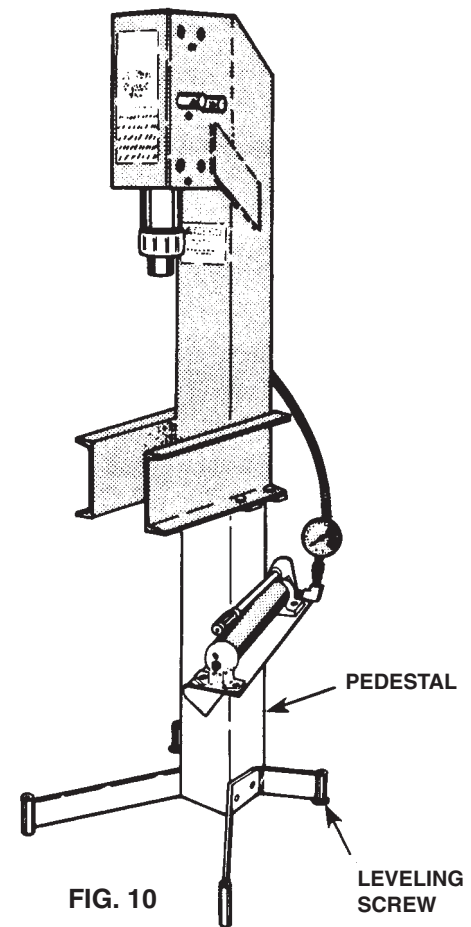


FIG. 10

PEDESTAL

LEVELING SCREW