

## FREQUENTLY ASKED QUESTIONS

### How do I bleed my Standard or Air Over pump?

1. Turn valve handle on front of pump assembly clockwise until the valve is closed. DO NOT OVER TIGHTEN.
2. Turn petcock valve on top of pump assembly counter clockwise to open and make sure both cradles are in the down position.
3. Use an adapter on your air hose and allow air to flow through the opening in the petcock valve into the pump. As air flows into the pump, both cradles should move into the up position and the ram should extend down toward the press bed.  
DO NOT ALLOW THE RAM TO EXTEND OVER 5".
4. If the cradles move up and the ram moves down, proceed to step 6. If not, check the petcock valve to ensure it is open and repeat step 3.
5. Place press bed in highest position and lock into place using all provided press pins. Place two press plates, centered directly under the ram.
6. Insert the pump handle into the low pressure cradle (the larger of the two pump pistons) and pump ram against the press plates until the pressure gauge reads 5 tons.
7. Insert the pump handle into the high pressure cradle (the smaller of the two pump pistons) and pump until the pressure gauge indicates 10 tons.
8. Turn valve handle on front of pump assembly counter clockwise a maximum of 1-1/2 turns to open valve. Ram will retract as pressure is released.
9. Pump should now operate normally. Repeat procedure as needed.

### My 20 / 40 / 50 / 50 ton A.O.H. (Air Over Hydraulic) pump will not work.

There are 4 reasons the pump will not operate after the initial application:

1. The drain cock on the top of the pump is not open.
2. The release valve on the front of the pump is open.
3. The check valve is stuck.
4. Air has been purged into one of the pockets of the pump body. Nine out of ten chances, it is an air pocket.

Any one of these things can happen during shipping.

First, advise the customer to make sure the drain cock is fully open (screwed all the way into the pump), and tell them to make sure the valve is closed (screwed in clockwise until tight). If these things are not the issue, ask if they have bled the pump properly, according to instruction.

One test they can do to troubleshoot the area of the pump which is having problem is to follow the bleed out procedure. While following the instructions on bleeding the pump, if the ram comes down to the press bed and immediately comes up after removing the air line, then they have lost the 5/16 ball bearing out of the release valve chamber. There should be a puddle of oil at their feet and a 5/16 ball bearing somewhere. Recommendation for this scenario: have them go to their local hardware store and purchase a 5/16 steel ball bearing, reinstall it into the valve chamber, and tighten the release valve. The pump should now be operational. If not, run through the bleed out procedure. If the bleed out procedure has been completed and the pump is still not operating properly, please contact customer service.

### My E.O.H. (Electric Over Hydraulic) pump is not working properly.

The biggest question we receive on the E.O.H. is that it has stopped working as if it may be vapor locked. In this case, they need to insure they have screwed the oil filter cap in on the top of the tank. This unit must have air coming in and out of the tank or it builds up pressure and will not operate properly.

### My E.O.H. pump is not holding pressure.

The E.O.H. pumps are not designed to hold pressure. After they have built up to the tonnage required, pressure will automatically release slightly, decreasing more as it sets. You will still need to push the up button on the pendant control to release the pressure all the way.

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### **My E.O.H. ram is slow on the upstroke.**

The E.O.H. ram is designed with a safety release check valve, which releases pressure if the ram is retracted too far. This creates a slightly slower upstroke than downstroke. This action is noticeable to a stopwatch, but not so much to the eye.

### **What type of hydraulic fluid should I use?**

Our pumps are 100% maintenance free, so if a customer is calling to ask you what type of fluid is to be used in the units, he/she has probably done something to create a hydraulic fluid loss. We do not require a specific brand of hydraulic fluid to be used, but we do recommend 30 weight fluid. Our E.O.H. pump and ram are virtually the same.

### **What type of warranty is provided?**

All of our pumps and rams are 100% maintenance free; each has been filled to proper levels and tested at the factory. A 100% inspection has been performed on every one of our American made pump and rams before being shipped out. We do not ship any pump which is faulty or has any signs of fault, and we offer a full One Year Replacement or Repair Warranty. There is a repair facility at our home office where the pump and/or ram can be sent in for repair with a copy of the receipt. If the warranty has lapsed we will offer repair, usually for a cost of less than \$100, and through normal shipping approximately 7-10 business days. We have not had one repair costing over \$100 yet.

### **What is a bearing shield?**

For safety purposes, we offer a bearing shield on our 20 ton presses, as well as some of our press kits. The bearing shield is used to surround your work piece, specifically a bearing ring, to guard from shattering the bearing rings or bearings which can cause serious injury to the individual. A bearing under 40,000 lbs of pressure can shoot out like a .38 caliber bullet. **GUARD YOURSELF FROM INJURY!**

### **Where can I find the specifications for presses?**

If specifications for a press are needed for a press already purchased, they are listed in the operation manual. If you have a customer inquiring about a press specification, please notify our customer service department, and it will be sent to you. If you need a specification for an area of the press not listed, please contact our customer service department, and they will be more than happy to research that information for you.

### **Which press would be best for my business application?**

For more repetitive work, an E.O.H. would be best. If the press is to be used on a daily basis (rather than for production), an A.O.H. is recommended. If the press is to be used once a week or on a monthly basis, a standard 40 ton or 20 ton A.O.H. press is usually more than they need. However, it depends on size of work, tonnage, speed or in some cases PSI required. One of our biggest complaints about the E.O.H. press is the customer does not realize 3" per minute (CP402) is not very fast when the unit is purchased, and right away he assumes something is wrong when in fact he should have purchased a production press which runs 40" per minute. Make sure you inquire about all of the customer's needs before completing the purchase. Our 40 Ton standard unit, the CP40W maintains approximately 8600 PSI at (40 ton) 80,000 lbs. Our 40 Ton electric over shop press runs at 2800 PSI at (40 ton) 80,000 lbs. However, if you are unable to contact someone, and the customer is persistent that he just needs a press, the CP40W is our standard 40 ton press.

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### Can my unit be upgraded?

Yes. For example, our standard 40 ton press, the CP40W, can be upgraded multiple times. We can upgrade that unit to an A.O.H. by adding a retro kit which has an A.O.H. motor and an A.O.H. motor adapter. It can also be retro fitted with an air assist valve, as well as the A.O.H. motor. The frame can be upgraded to a 40 ton E.O.H. pump and ram. Our 40 ton E.O.H. shop press can be upgraded with a two speed pump retro kit. It can also be upgraded to a 2hp motor, making it a 40 ton high speed production press, allowing them to take one of our most economical units, and turn it into one of our most elite models. All E.O.H. have the pendant control now. Up until 2005, all CP402 had hand valves. All of those units can now be fitted with pendant control retro kits. So, in turn, if a customer buys any of the two 40 ton basic models (CP40W or CP402), they can upgrade later if their needs change.

### How do I calculate the PSI needed for my ram ?

There is a simple formula which enable the customer to calculate his PSI for the ram.

$$\text{PSI} = \frac{\text{Tonnage}}{\pi \times r^2}$$

1 ton = 2,000 lbs.

$\pi = 3.14$

r = radius (or half of the diameter)

i.e.: The standard 40 ton E.O.H. press inside ram diameter is 6". Take half the diameter ( r ) which is 3" and multiply it by itself which is 9.  $9 \times 3.14 = 28.26$ . Take tonnage required, which in this case, is 80,000 lbs and divide by 28.26. That will give an answer of 2830 PSI for a 6" diameter ram at 40 tons (80,000 lbs).

### How much PSI do I have on the upstroke of my E.O.H. ram?

The answer is zero. This ram is not designed for pulling or lifting heavy die plates. All of our units are designed for PRESSING ONLY.

### What do I do if the gauge is not working and/or the needle is on the wrong side of the zero peg?

If your ram appears to building pressure but your needle is not moving on the gauge, check to ensure the needle is on the top of the peg. If your needle is on the bottom side of the peg, release pressure from your ram, remove the front cover of gauge, and gently place the needle on the top of the peg. If the needle is in its proper position and ram appears to be building pressure, and is still not working properly, contact customer service.

### Can I change my PSI setting on my E.O.H. press?

All of our units are 100% tested and preset. NEVER attempt to change any preset PSI settings. If more tonnage and/or PSI is required, please contact customer service. All of our E.O.H. presses are set to maximum PSI.

### I've elongated my upright press pin holes, why?

In the 40, 50, 100 and 150 ton presses 4 bed pins are provided. All 4 pins MUST BE USED or personal injury and/or damage to equipment may occur. If only 2 pins are used, elongation will take place, causing damage to the frame.