

Operation Manual

Workshop Press 12 and 20 Tons with Gauge

61480, 61481

wiltec



Illustration similar, may vary depending on model

Read and follow the operating instructions and safety information before using for the first time.

Technical changes reserved!

Due to further developments, illustrations, functioning steps, and technical data can differ insignificantly.

Updating the documentation

If you have suggestions for improvement or have found any irregularities, please contact us.



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Introduction

Thank you for purchasing this quality product. **To minimise the risk of injury we urge that our clients take some basic safety precautions when using this device. Please read the operation instructions carefully and make sure you have understood its content.**

Keep these operation instructions safe.

Safety instructions/warnings



The owner and/or user must have read and understood the operating instructions of the device before using it. Installed personnel should be cautious, competent, trained and qualified in the safe handling of the working equipment used when working with the shop press. Warnings should be read and understood.

- Be familiar with the application control, the application process and the warning notices.
- Make sure that all connection brackets are tight and secure.
- Be familiar with the contents of the instructions for use.
- This device is not intended to be used by persons (or children) with reduced physical, sensory, or mental capabilities or persons without the appropriate experience or knowledge, unless they are supervised by a person responsible for their safety or have before been instructed concerning the use of the device.
- Children must be supervised to ensure that they do not play with the device.
- Stay focused and do not get distracted while working.
- Do not use welding equipment near the press.
- Your workplace should always be tidy and well lit. Untidy and dark work areas can lead to accidents.
- Make sure to wear sturdy shoes.
- If you have long hair, use a hairnet or tie it securely.
- Do not wear loose clothing, belts, or jewellery. These can get caught in the moving parts and lead to serious injuries.
- Do not use the press if you are under the influence of alcohol, drugs or other medicine impairing consciousness. Read warnings on the package inserts to determine if your judgment or reflexes are impaired while taking medication. In case of doubt, the press must not be put into operation.
- Never open screw connections under pressure/load.
- Put the press in the lowest position when topping up hydraulic oil. Only use high-quality hydraulic oil, **NEVER** use brake fluid, alcohol, glycerine, cleaning agents, engine oil, water, contaminated oil, or other unsuitable liquids.
- The hydraulic cylinder is under pressure and must not be opened with force.
- Do not operate the workshop press beyond its capacity.
- This workshop press is intended exclusively for aligning, bending, and straightening work. Do not compress any feathers or other objects that could be ejected from the press. Furthermore, no objects may be compressed that could break during the work process.
- Before operating the workshop press, make sure that there are no damaged parts. Tighten all loose screws.
- There are parts that tend to be thrown out of the press because of the pressing. Protect yourself appropriately to prevent injuries. Do not reach into the device or near the plunger. Make sure that the workpiece to be processed is centred evenly and rests firmly on the pressure plate so that it cannot be thrown out during the work process and thus cause injuries.
- Always wear protective goggles and appropriate safety clothing.



Inspection

- Prior to commissioning the shop press, a visual inspection must be carried out to detect leaks, damage, lose, or missing parts and worn parts.
- Check the oil level regularly. Set the press to the lowest position when refilling hydraulic oil. Remove the cap, the oil level must reach exactly to the opening. If necessary, refill with high-quality hydraulic oil. Perform a complete oil change every year.
- If scrapping of the press lever is necessary, the oil should be drained and disposed of properly, the rest of the press should be recycled.

Commissioning

1. Place the work piece on the bed frame.
2. Locate and close the release valve by turning it clockwise until it is tight.
3. Pump the handle until the ram nears the work piece.
4. Align the ram and the work piece to ensure a centre loading.
5. Apply load to the work piece by pumping the handle. Do not overload the work piece.
6. Remove load from the work piece by turning the release valve counter-clockwise. Stabilise the work piece so that it does not fall while pressure is released.
7. Remove the work piece when the ram is fully retracted.

Maintenance

1. Before each use inspect the press for damage. Do not use it bent, broken, cracked, leaking or otherwise damaged.
2. Periodically lightly oil all moving parts including the pump piston and hydraulic ram.
3. Check the hydraulic connections and hoses before each use. Do not use if cut, damaged, leaking or otherwise damaged connections and/or hoses are noted.

Features

- Used for parts straightening, bending, and crossing
- Multi-position bed for work height adjustment

Technical specifications

Item №	Capacity (t)	Work range (mm)	Lift (mm)		Weight (kg)
			min.	max.	
61480	12	90–1035	145	330	42.5
61481	20				70



Troubleshooting

Symptom	Possible cause	Corrective action
Piston cannot be moving	The mechanical parts are corrupt	Add lubricate oil or grease.
Piston cannot be auto retracted or retracts slowly	Reservoir overfilled	Drain jack oil to proper level.
	Connections binding	Clean and lubricate moving parts.
Piston not lifted to full extension	Jack oil level low	Add jack oil.

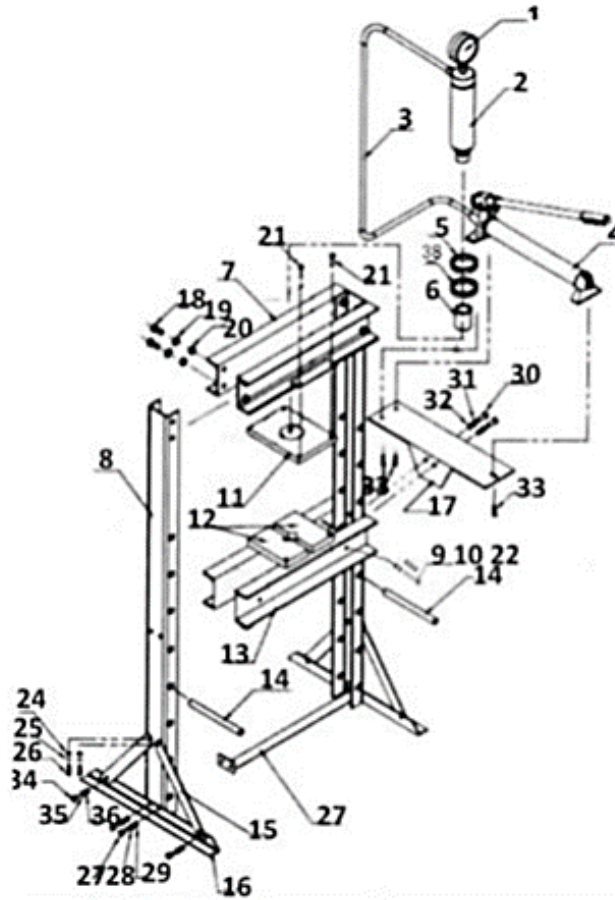
Operation instruction

1. The 12/20 tons workshop press comes with two arbour plates. The arbour plates can be used individually or connected as shown below by the arbour lock.
2. The gap between the two plates is expandable from 0–12,7 cm (0–5"). To adjust the space between the two arbour plates, loosen each bolt on the side of the plates, adjust the gap between the plates, then re-tighten the bolts before use.
3. To set the aprons at a specific height, slide the two pins through opposite adjustment holes on the press frames legs and secure in place using the two R-clips.
4. Place the Arbor plate onto the press apron, making sure to centre it on the press apron.
5. **WARNING!** If the arbour plates rest on an obstruction (such as bolt, debris, etc.), an uneven base can be created. This can lead to unusual stress on the arbour plates and possibly a break and /or personal injury.
6. Insert the narrower jack handle (the end with the pin) into the larger handle and engage the pin into the "T" slot.
7. Using the slotted end of the jack handle, tighten (turn clockwise) the relief valve of the jack.
8. Insert the larger tube of jack handle into the jack handle connector located to the side of the jack.
9. Pump the handle up and down to extend the jack and operate the shop press.
10. **WARNING!** Should you detect any kind of structural failure, stop using the shop press immediately. If necessary, have the unit repaired by a qualified service technician.
11. When finished, remove the jack handle from the jack handle connector and loosen (turn counter-clockwise) the relief valve of the jack.

De-aeration

1. Remove the oil fill plug located on the back of the jack to expose the oil fill hole.
2. Open the release valve located on the front of the jack above. Insert the jack handle into the pump core. Slowly pump handle to force air out of the oil fill hole.
3. As soon as the oil start to come out of the hole, stop pumping. Replace the oil fill plug. Close the release valve.
4. Check the oil level. It must be just below the oil file hole. If necessary, fill with high quality hydraulic oil.

Exploded view and parts list



No	Description	Qty	No	Description	Qty
1	Press meter	1	20	M12 nut	8
2	Ram	1	21	M8×20 bolt	4
3	Hose	1	22	M12 nut	4
4	Pump	1	23	–	–
5	Fixing ring	1	24	M12×30 bolt	4
6	Press head	1	25	Washer 12	4
7	Cross beam	1	26	M12 nut	1
8	Post	2	27	M12×30 bolt	4
9	M12×120 bolt	4	28	Washer 12	4
10	Washer 12	4	29	M12 nut	4
11	Fixing block	1	30	M12×30 bolt	2
12	Arbour plate	2	31	Washer 12	2
13	Press bed	2	32	M12 nut	3
14	18×220 pin	2	33	M10×16 bolt and washer	4
15	Bracing	4	34	M12×30 bolt	4
16	Foot	2	35	Washer 12	4
17	Shelf	1	36	M12 nut	4
18	M12×30 bolt	8	37	–	–
19	Washer 12	8	38	Fixing ring	1

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