

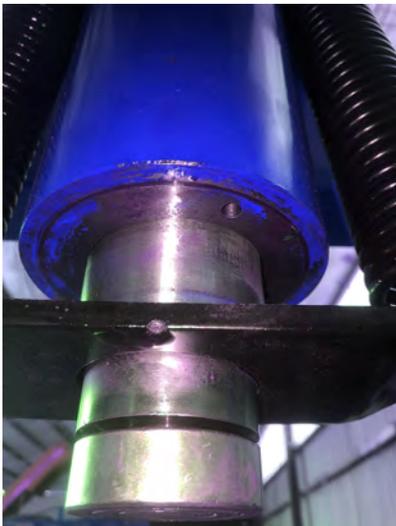
# IMPORTANT OPERATING INSTRUCTIONS

## HYDRAULIC WORKSHOP PRESS

### 2-Speed Hydraulic Pump

The 2-Speed hydraulic pump uses a slow-fast pump system that in **Fast** mode, is used only to advance the ram to the load surface. Once the ram takes up the load the slow-fast knob must be turned to **Slow** mode to provide the high pressure delivery of oil required for efficient pressing application.

**⚠ IMPORTANT ⚠**  
**PUMP SPEED SETTINGS**  
**ONLY OPERATE 'FAST' UP TO LOAD**  
**SWITCH TO 'SLOW' WHEN UNDER LOAD**  
**ALWAYS LIFT LOAD TO RAM**  
**NEVER OVER EXTEND THE RAM**



### Over Extending the Hydraulic Ram Piston

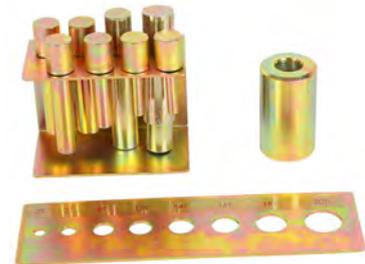
The loosening of the “Hydraulic Ram Piston Retaining Plate” becomes apparent ‘only’ when the hydraulic ram piston has been over extended.

OVER EXTENDING THE PISTON RAM results in a loosening of the retaining plate that secures the ram cylinder in the ram. This is rectified by knocking the RETAINING PLATE back into the locked position (see image) using a light hammer and a pin punch. Insert the pin punch into the hole at the bottom of the ram cylinder and knock the RETAINING PLATE back into the locked position.

Note: The cross beam working table (BED) should always be lifted to the ram and will prevent loosening of the “Hydraulic Ram Piston Retaining Plate”.

### It's Safer to use a correct size Mandrel

Borum Hydraulic Press Adaptor Kits include 8 different sized pins (mandrels) ranging from 2,000kg to 20,000kg capacity, a pin holder, a storage shelf along with a mounting kit, and a pin plate with the weight capacity shown for each pin. This very handy set of eight steel mandrels, adaptor and press plate expands the safe uses of your workshop press for a wider range of applications involving different sized work pieces. Simply select your mandrel according to the size of the work piece load bearing surface.



#### Other hints...

- Oil leaks.** All hydraulic parts and lines should be regularly checked as a very small leak can turn into a very big mess. Loose fittings should be tightened and wiped clean of spilled oil. Keeping a press clean will help you locate any new leaks that might develop.
- Oil level.** If necessary, top it off. To determine the type of oil you should use, always refer to the Owners Manual.
- Loose bolts.** Some jobs cause vibration and shock that can loosen bolts around the tooling area.
- Press ram.** It should always be clean and moist, but not dripping oil. Always retract after use.
- Cleanliness.** Check to be sure the work area is clean. This helps to ensure a safe work environment and prevent accidents.