

INSTRUCTION MANUAL REPAIR PARTS LIST

SHOP PRESSES

12 Ton (10886 Kg.) Capacity

MODEL B67618 (With Hydraulics)

MODEL B67619 (Without Hydraulics)

WARNING

1. Do not exceed rated capacity. Always use an accurate pressure gauge to measure pressing force.
2. Components of this press are specially designed to withstand rated capacity. Do not substitute bolts, pins, or any other components.
3. Always apply load on the center of ram plunger. Offset loads can damage ram or ram mount, and may cause work piece to eject.
4. Before applying load, be certain all press bed support pins are fully engaged, and hydraulic ram is fully threaded into ram mount.
5. Before operating, check for signs of cracked welds, bent bed pins, loose or missing bolts, or any other structural damage. Do not operate if any of these conditions exist. Have repairs made only by factory authorized service centers.
6. Remove all loads from press bed before attempting to adjust bed height. Beware of possible falling bed.
7. Press only on work piece supported by press bed.
8. When using accessories such as arbor plates, be certain they are centered on press bed, and are in full contact with the bed.
9. Parts being pressed may splinter, shatter, or be ejected from the press. Due to varied applications, it is your responsibility to always use adequate guards, wear eye protection and heavy protective clothing when operating this press.
10. Keep hands and fingers out of the press and away from parts that may shift and pinch.
11. Do not stand in front of work area where load is applied.
12. It is your responsibility to keep warning decal legible and intact. Replacement decals may be obtained from the factory.
13. Study, understand, and follow all instructions provided with this equipment prior to operation.
14. Failure to heed these warnings may result in damage to the equipment, or failure resulting in property damage, personal, or fatal injury.

OWNER'S RESPONSIBILITY

Operation. The owner and/or operator shall have an understanding of these operating instructions and warnings before operating the press. Warning information shall be emphasized and understood. If the user is not fluent in English, the instructions and warnings shall be read to and discussed with the operator in the operator's native language by the purchaser/owner, making sure that the operator comprehends its contents.

25 Ton (22680 Kg.) Capacity

MODEL B67620 (With Hydraulics)

MODEL B67621 (Without Hydraulics)

Maintenance. The press shall be maintained in accordance with instructions listed under "Maintenance."

Inspection

1. Visual inspection shall be made before each use of the press, checking for leaking hydraulic fluid, and damaged, loose or missing parts.
2. Each press, if subjected to an abnormal load or shock, shall be inspected immediately by an authorized Blackhawk service center.
3. Owners and/or users should be aware that repair of this equipment may require specialized knowledge and facilities. It is recommended that an annual inspection of the press be made by an authorized service center and that any defective parts, decals or warning labels be replaced with genuine Blackhawk parts. A list of authorized service centers is available upon request.

Damaged Presses. Any press which appears to be damaged in any way, is found to be badly worn, or operates abnormally SHALL BE REMOVED FROM SERVICE until necessary repairs are made by an authorized service center.

Assembly. (See Illustration, Page 2)

1. Attach (1) base leg (item 3) to each column (items 1 and 2) using (2) bolts, lockwashers and nuts (items 12, 13 and 14) per side. Tighten bolts finger tight.
2. Stand both columns upright, with the mounting holes for the column support (item 4) facing the same direction. Attach column support to both columns using (4) bolts, lockwashers and nuts (items 12, 13 and 14). Tighten bolts finger tight.
3. Attach (2) frame supports (item 6) using (2) bolts, lockwashers and nuts (items 12, 13 and 14) as shown. Tighten bolts finger tight.
4. Slide bed frame (item 15) over both columns until it rests on the floor.
5. Insert (1) 5/8-11 x 4-1/2" bolt (item 8) thru (1) head support (item 5), thru one column, and then thru another head support. Use (2) spacers (item 11) and (1) each lockwasher and nut (items 9 and 10) as shown. Tighten finger tight.
6. Pivot both head supports upward to allow head assembly (item 16) to be installed along bottom flange of head support channel.

7. Lower both head supports simultaneously and insert bolt, spacers, lockwasher and nut (items 8, 9, 10 and 11) to attach both head supports to the opposite column.
8. Install remaining 2 bolts, lockwashers and nuts (items 8, 9 and 10) and 4 spacers (item 11) to attach both head supports to the columns.
9. Tighten all bolts and nuts.
10. Install (2) 3/8-16 x .70" (item 18) bolts into head assembly.
11. Attach pump bracket (item 7) to either column using (3) bolts, lockwashers and nuts (items 12, 13 and 14). Note that bracket can be mounted to either side of the press depending on operator preference.
12. Lift bed frame to desired position, and insert (2) locating pins (item 17). Be certain they are fully engaged in both flanges of each column.

For Presses Equipped with Hydraulics:

13. Screw ram into head assembly. By use of ram collar threads.



WARNING

**PRIOR TO APPLYING LOAD BE SURE
HYDRAULIC RAM COLLAR THREADS
ARE FULLY ENGAGED TO HEAD
ASSEMBLY.**

14. Place hand pump on pump bracket and connect hose to ram quick coupler.

OPERATION

1. Bed Frame - The bed frame (item 15) is adjustable up and down to fully take advantage of available ram travel and numerous work pieces.
2. Head Assembly - The head assembly (item 16) is adjustable right to left. To adjust, loosen both hex locking screws (item 18) and position head, always

centering load on ram plunger saddle. After head assembly is positioned hex locking screws must be securely tightened.

BED FRAME ADJUSTMENT

1. Fully retract ram and remove all items from press bed frame.

WARNING

**REMOVE ALL ITEMS FROM PRESS
BED FRAME BEFORE ATTEMPT-
ING TO ADJUST HEIGHT. BE-
WARE OF POSSIBLE FALLING BED
FRAME.**

2. Support bed frame, and remove (2) press bed pins (item 17).
3. Raise or lower bed frame to desired height, and reinstall press bed pins. Be certain pins are fully engaged in both flanges of the upright columns.

MAINTENANCE

- Periodically check the press frame to make sure all bolts are tight and inspect for cracked welds, bent, loose, or missing parts.
- If the paint becomes badly chipped, it is suggested that unit be repainted. This will prevent rusting.
- Keep the hydraulic component operating area uncluttered and free of unnecessary equipment.
- Periodically check your hydraulic connections for possible leaks. Replace or properly repair damaged or leaking hydraulic components before using.
- Change hydraulic oil in your hydraulic system every 100 working hours, or more frequently in unusually dirty or dusty areas.

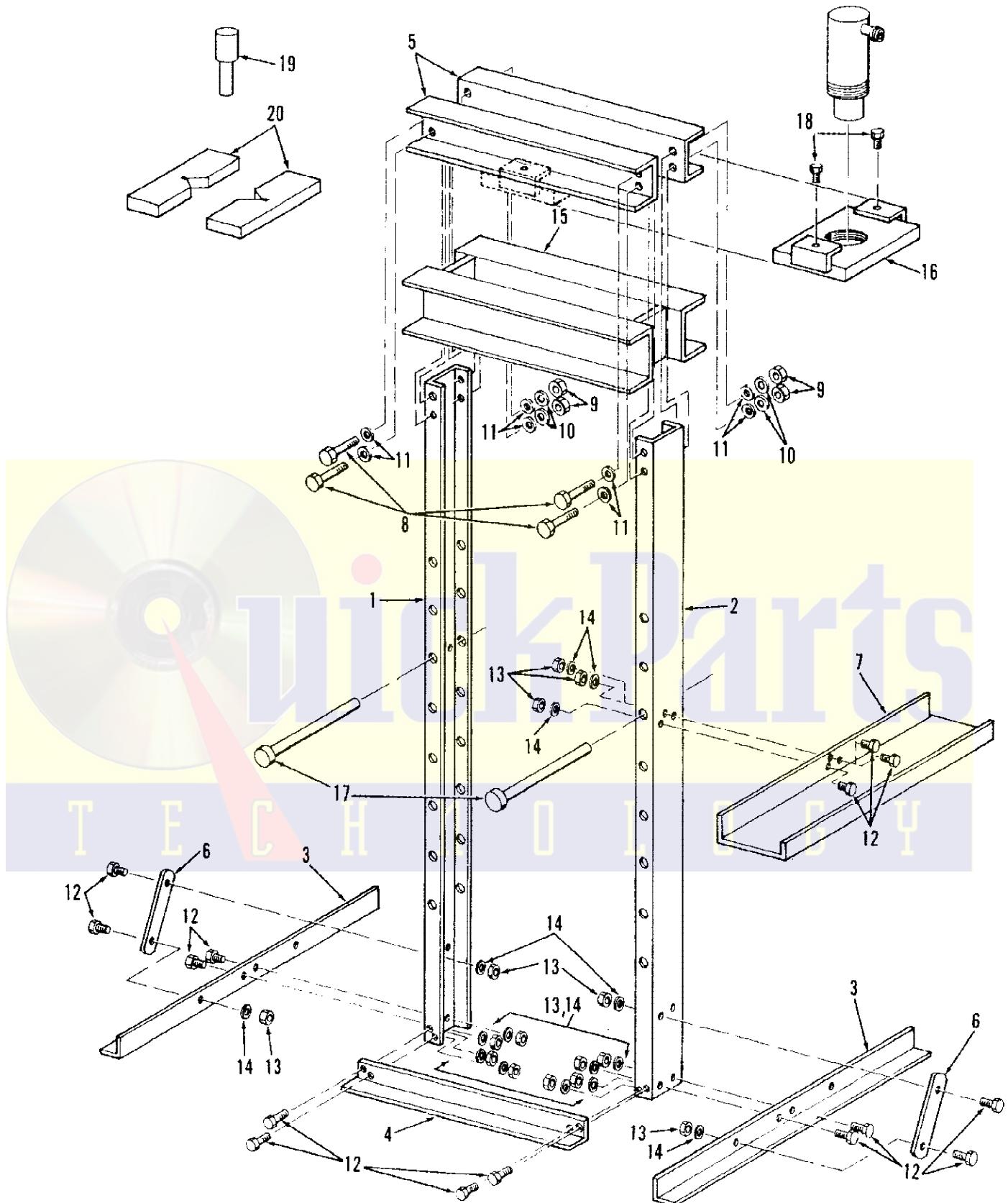
SHOP PRESSES

12 TON MODEL B67619
25 TON MODEL B67621

Item No.	Part Code	Description	Qty. Req'd.
12 Ton 25 Ton			
1	H31887 H31920	Left Column	1
2	H31888 H31921	Right Column	1
3	H31889 H31889	Base - Leg	2
4	H31890 H31890	Column Support	1
5	H31891 H31922	Head Support	2
6	H31892 H31892	Frame Support	2
7	H31893 H31893	Pump Bracket	1
8	H68716 —	HCS 5/8-11 x 4.5	4
8	— H68730	HCS 5/8-11 x 6.5	4
9	H68717 H68717	Hex Nut, 5/8-11	4
10	H68718 H68718	Lockwasher, 5/8	4
11	H68719 H68719	Spacer	8

Item No.	Part Code	Description	Qty. Req'd.
12 Ton 25 Ton			
12	H68720 H68720	HCS 3/8-16 UNC x 1.0	15
13	H68721 H68721	Hex Nut, 3/8-16	15
14	H68722 H68722	Lockwasher, 3/8	15
15	H31894 H31923	Bed Frame	1
16	H68724 H68732	Head Assembly	1
17	H68725 H68725	Press Bed Pin	2
18	H68726 H68726	HCS 3/8-16 UNC x .70	2
19	H68466 —	Bearing Punch	1
20	H68465 —	Arbor Plate	2
21	H86847 H86849	Product Decal	1
22	H31840 H31840	Warning Decal	2

*Not shown.



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