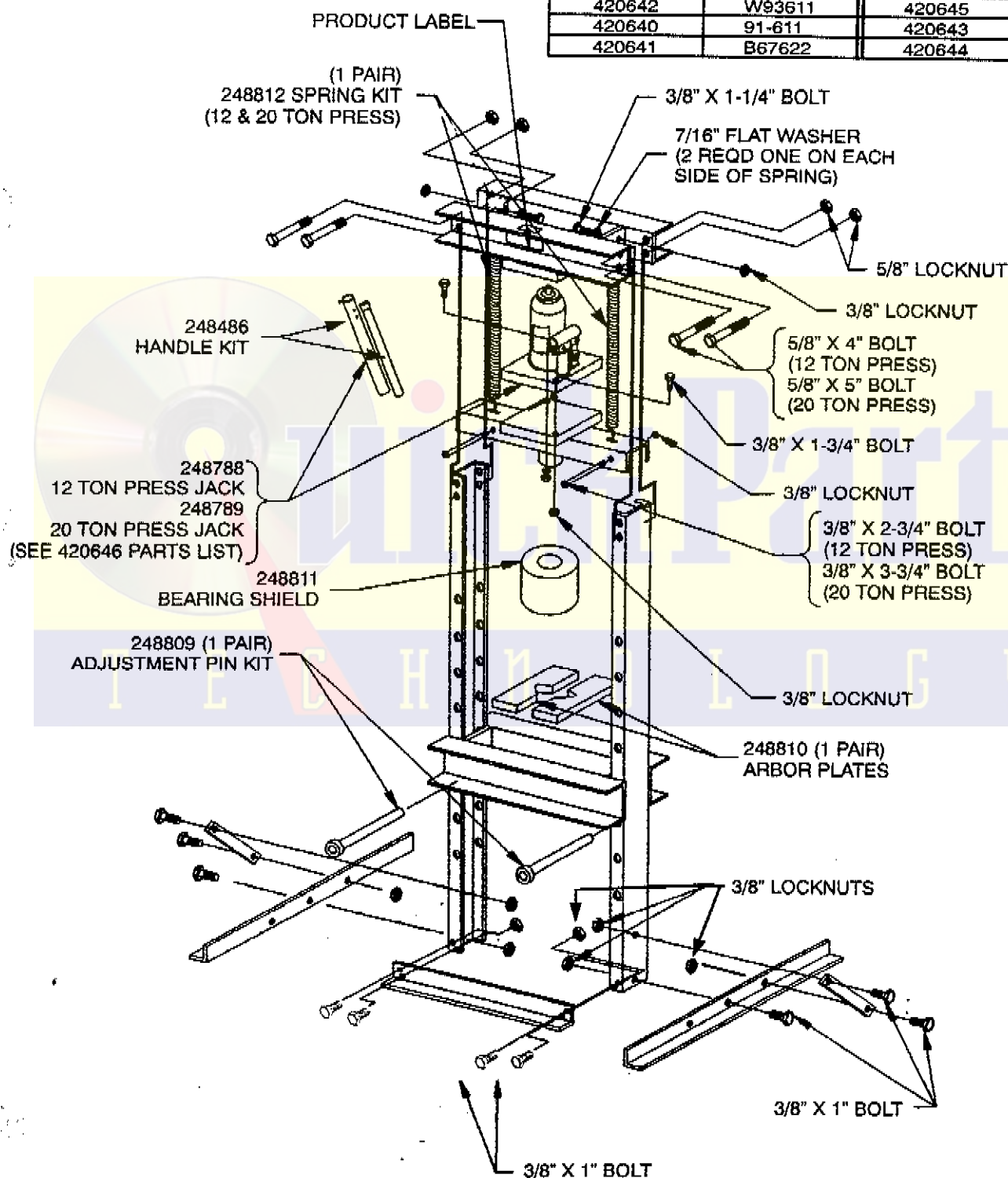


**LINCOLN, NAPA,
BLACKHAWK**

**MODELS: W93611, W93612
91-611, 91-612
B67622, B67624**

12 AND 20 TON SHOP PRESS

PRODUCT LABEL	MODEL (12 TON)	PRODUCT LABEL	MODEL (20 TON)
420642	W93611	420645	W93612
420640	91-611	420643	91-612
420641	B67622	420644	B67624



ASSEMBLY INSTRUCTIONS

12 TON AND 20 TON SHOP PRESS

TO ASSEMBLE SIDE RAILS
PLACE UPPER CHANNELS
AND BED ON FLOOR. RAILS
MAY HAVE TO BE TAPPED
BETWEEN CHANNELS.

LOOSEN AND RE-TIGHTEN UPPER AND
LOWER BOLTS TO CORRECT FRAME TILT
AND WOBBLE.

TAP TOGETHER TO
ENGAGE DIMPLES.

TO INSTALL JACK

SPRING PULldown
EYEBOLT

3/8" X 1-1/4" BOLT

7/16" FLAT WASHER
(ONE ON EACH SIDE
OF SPRING)

5/8" LOCKNUT

3/8" LOCKNUT

5/8" X 4" BOLT
(12 TON PRESS)
5/8" X 5" BOLT
(20 TON PRESS)

3/8" X 1-3/4" BOLT

3/8" LOCKNUT

3/8" X 2-3/4" BOLT
(12 TON PRESS)
3/8" X 3-3/4" BOLT
(20 TON PRESS)

3/8" LOCKNUT

3/8" LOCKNUTS

3/8" X 1" BOLT

3/8" X 1" BOLT

AIR RATCHET SPEEDS
ASSEMBLY OF LOCKNUTS

SHOP PRESS

OWNER/OPERATOR MANUAL

OWNER/OPERATOR RESPONSIBILITIES

IT IS THE RESPONSIBILITY OF THE OWNER AND/OR OPERATOR TO PROPERLY USE AND MAINTAIN THIS EQUIPMENT AND THE LEGIBILITY OF ALL WARNING AND INSTRUCTION LABELS. CAREFULLY READ AND UNDERSTAND THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL BEFORE OPERATING THIS EQUIPMENT.

SPECIFICATIONS

See product labels for model number and capacity rating.

WARNING

FAILURE TO HEED THE FOLLOWING WARNINGS MAY RESULT IN PERSONAL INJURY OR PROPERTY DAMAGE.

1. Wear safety glasses or protective face shield.
2. Install safety shield around work unit whenever possible.
3. Align and support all work to provide a straight ram pressure against a solid base.
4. Do not overload.
5. Use only manufacturer approved accessories.
6. Do not modify press.

INSPECTION

Visually inspect for damaged, loose, or missing parts. If press is worn or damaged, remove from service. Contact an authorized service center for damage assessment or repairs.

OPERATION

Before operating the press, it may be necessary to purge air from the jack hydraulic circuits. Purging is required if the jacks ram fails to extend when pumped or it appears to require excessive number of pump strokes because of air trapped in the jacks hydraulic cylinder. See instructions on "Purging Air" under "Troubleshooting".

Support the press bed and move the bed/pins to the highest position that will allow you to position your part on the press bed. This will lessen the number of pump strokes needed to contact the part. The pins must be fully inserted to distribute the load equally. Make sure the arbor plates are stable and safety shields are in place.

Crack open the filler/vent screw (1-2 turns) before operating the jack. The jack may not retract fully if the vent is closed. Operate the jack slowly particularly when heavy loads are encountered.

MAINTENANCE

Periodically check all the press frame and base bolts to make sure they are tight. Apply light jack oil to the ram if it appears dry and retraction is not smooth. If this does not correct the problem, internal ram seals may have to be replaced.

TROUBLESHOOTING

PURGING AIR:

With the ram fully retracted, open (1-2 turns) the filler/vent screw on the side of the oil reservoir and close (clockwise) the release valve in the base of the jack. Pump the jack to maximum extension. Continue to pump the jack (slowly) for several more strokes. Open the release valve to fully retract the ram. The jack should now be ready for normal operation. Repeat if necessary.

RAM DOESN'T EXTEND FULLY:
Check jack oil level. Level should be slightly below the filler hole. Add clean jack oil if needed.

WILL NOT HOLD LOAD:

A. Release valve leaking. Tighten valve.

B. Oil not clean/hydraulic circuit dirty. Try rapid pumping and/or fast retraction of ram to flush oil thru hydraulic circuits. If this doesn't correct problem, drain, flush, and replace oil. Use clean jack oil.

SERVICE

If troubleshooting procedures do not correct problem, contact your nearest authorized service center for repairs and/or replacement parts.