

Operation and Maintenance Manual

WILSON
HYDRAULIC REPAIR GROUP
P.O. BOX 160
LEEDS, NEW YORK 12451

HYDRAULIC PRESS

TONNAGE: 25 TON

MODEL: 25R or 37R

SER. NO.: _____

CUSTOMER

Above information should accompany all orders for parts or service.

WILSON HYDRAULIC REPAIR GROUP, P.O. BOX 160, LEEDS, NEW YORK 12451

C A U T I O N

IT IS THE EMPLOYER'S RESPONSIBILITY TO EDUCATE THE PRESS OPERATOR IN SAFE WORK PROCEDURES AND TO PROVIDE PROPER SAFETY DEVICES, OR MEANS OF PROTECTION THAT MAY BE NECESSARY OR REQUIRED FOR ANY PARTICULAR USE, OPERATION, SET-UP, OR SERVICE OF THIS EQUIPMENT.

THE EMPLOYER SHALL INSURE ADEQUATE SUPERVISION THAT CORRECT OPERATING PROCEDURES ARE BEING FOLLOWED.

NEVER PLACE ANY PART OF YOUR BODY IN THE PRESSING AREA.

NEVER INSTALL TOOLING (DIES, ETC.) WITH PRESS MOTOR RUNNING.
(APPLICABLE TO MOTOR-DRIVER PRESSES).

NEVER OPERATE, INSTALL TOOLING (DIES), OR SERVICE THIS EQUIPMENT WITHOUT PROPER INSTRUCTION OR WITHOUT READING THIS OPERATION MANUAL.

NEVER OPERATE PRESS IN EXCESS OF ITS RATING.

NEVER REMOVE ANY SAFETY EQUIPMENT OR STROKE LIMITING DEVICES (AS APPLICABLE) INSTALLED BY MANUFACTURER.

WILSON HYDRAULIC REPAIR GROUP
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TEL: 518/943-0247
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MODEL 25R MANUAL

25 TON WHRG
HAND-OPERATED HYDRAULIC SHOP PRESS

F O R W A R D

THE MODEL 25R, 25 TON, WILSON HYDRAULIC REPAIR GROUP (WHRG) HAND-OPERATED, HYDRAULIC SHOP PRESS IS RUGGEDLY BUILT, AND, IT'S DESIGN AND MANUFACTURE IS OF THE HIGHEST QUALITY. IF PROPERLY CARED FOR, THIS PRESS WILL GIVE MANY YEARS OF SATISFACTORY SERVICE.

THE SUCCESSFUL PERFORMANCE OF THE PRESS DEPENDS GREATLY ON THE OBSERVANCE OF THE OPERATION AND MAINTENANCE INSTRUCTIONS CONTAINED IN THIS TECHNICAL MANUAL, WHICH IS INTENDED TO HELP THE USER TO BECOME FAMILIAR WITH THE PRESS AND ITS OPERATION. THE RESULTS OBTAINED DEPEND UPON THE PROPER INSTALLATION OF THE PRESS AND THE ADHERENCE TO THE INSTRUCTIONS OUTLINED. THE FUNCTIONS AND ADJUSTMENTS OF VARIOUS COMPONENTS ARE CAREFULLY EXPLAINED, AS WELL AS THE NECESSITY OF PROPER LUBRICATION.

WHEN THE PRESS IS THOROUGHLY UNDERSTOOD, SETUPS CAN BE MADE EASILY AND QUICKLY. IF THE USER WILL BECOME FAMILIAR WITH THIS PRESS, MAXIMUM OUTPUT IS ASSURED AND UNNECESSARY DELAYS AND CONSEQUENT LOSS OF TIME WILL BE AVOIDED.

REPLACEMENT PARTS

INCOMPLETE INFORMATION MAY CAUSE A DELAY IN SHIPMENT OF PARTS. TO ORDER REPLACEMENT PARTS, PLEASE SPECIFY:

1. PRESS MODEL, SERIAL NUMBER, TONNAGE AND DATE MANUFACTURED.
2. PART NUMBER, AND, A COMPLETE DESCRIPTION OF ITEM REQUIRED.
3. IF APPLICABLE, DRAWING NUMBER ON WHICH PART APPEARS.

ADDITIONAL OR REPLACEMENT COPIES OF THIS MANUAL CAN BE SUPPLIED AT A NOMINAL FEE.

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WILSON HYDRAULIC REPAIR GROUP, P.O. BOX 160, LEEDS, NEW YORK 12451

INSTRUCTIONS FOR ASSEMBLY AND OPERATION
OF WHRG MODEL 25R 25 TON WHRG PRESS

THE WHRG 25 TON HAND-OPERATED HYDRAULIC SHOP PRESS MODEL 25R IS COMPLETELY ASSEMBLED EXCEPT FOR PUMP HANDLE AND CAPSTAN HANDWHEEL HANDLES WHEN PRESS IS SHIPPED (DOMESTIC SHIPMENT) IN A COMMERCIAL TYPE SKID OR CRATED CONTAINER. ANY DAMAGE TO SHIPPING CONTAINER WOULD INDICATE NECESSITY FOR A THOROUGH INSPECTION OF PRESS FOR DAMAGE.

UNCRATE PRESS AND COMPLETE ASSEMBLY. PRESS MUST BE PLACED IN AN UPRIGHT POSITION BY USE OF A CRANE OR HEAVY DUTY LIFTING DEVICE (PIVOTING PRESS ON BASE SUPPORTS WHICH ARE SECURED ONLY ON ONE SIDE FOR SHIPPING PURPOSES).

SECURE SECOND SET OF LOCKING BOLTS TO EACH BASE MOUNTING BRACKET AND BASE. INSTALL PUMP HANDLE IN SOCKET 25R-60 AND TIGHTEN SET SCREW 25R-64. PLACE THE TWO (2) CAPSTAN HANDWHEEL HANDLES IN THE HUB SO THAT BOTH HANDLES ARE CENTERED BY THE SPRING LOADED DETENT BALLS INCORPORATED IN THE HUB.

REMOVE BREATHER CAP 25R-70 AND FILL OIL RESERVOIR WITH FOUR (4) QUARTS OF HYDRAULIC OIL, TEXACO RANDO HD-B, OR EQUIVALENT.

MOVE CONTROL LEVER 25R-44 TO FRONT POSITION AND OPERATE RAM UP AND DOWN THROUGH 2-3 COMPLETE STROKES BY MEANS OF THE CAPSTAN HANDWHEEL ASSEMBLY. THIS WILL CHARGE THE HYDRAULIC CYLINDER WITH OIL AND ELIMINATE AIR FROM THE CIRCUIT. PRESS IS NOW READY FOR OPERATION.

PLACE TABLE PLATES AT DESIRED WORK POSITION SO THAT THE PLATES REST ON THE ALLOY STEEL PINS 25R-5000. CAUTION: MAKE CERTAIN THAT THE TABLE LIFTING CABLE IS SLACK AND NOT SUBJECT TO ANY TENSION DURING THE PRESS OPERATION.

CLOSE CONTROL LEVER BY MOVING SAME TO REAR OF PRESS. THE CAPSTAN HANDWHEEL IS THEN USED TO OPERATE THE RAM DOWN TO CONTACT THE WORK ON IDLE STROKE. IF RAM CONTACTS POSITIVE RESISTANCE, OPERATION OF THE HAND PUMP SHOULD RESULT IN IMMEDIATE PRESSURE APPLICATION AND PRESSURE INDICATION ON THE GAUGE 25R-67.

WHENEVER POSSIBLE, THE RAM SHOULD BE OPERATED IN THE UPPER PORTION OF ITS RATED 7-1/2" STROKE RANGE. HOWEVER, IF RAM AT ANY TIME EXCEEDS THE RATED STROKE LENGTH, "BUILT-IN" SAFETY BY-PASS PLUNGER 25R-38 WILL BE DEPRESSED BY PISTON 25R-55 AND VALVE 25R-19 WILL BE OPENED - THUS RELIEVING PRESSURE ON THE PISTON AND PREVENTING DAMAGE TO CYLINDER HEAD 25R-4 DUE TO OVER EXTENSION OF THE RAM. THIS MECHANICALLY ACTUATED BY-PASS WILL REMAIN OPEN UNTIL THE RAM IS RETURNED TO A POSITION WITHIN RATED STROKE RANGE.

THE "BUILT-IN" 3-TON CAPACITY MECHANICAL ARBOR PRESS FEATURE CONSISTING GENERALLY OF THE RACK CUT RAM 25R-40, ENGAGING PINION 25R-51, SHAFT 25R-72 AND CAPSTAN HANDWHEEL ASSEMBLY, MAY BE MADE OPERATIVE AT ANY TIME BY MOVEMENT OF THE CONTROL LEVER TO FRONT OR OPEN POSITION.

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C A U T I O N - IF HYDRAULIC PRESSURE IS TO BE EXERTED AGAINST WORK THAT MAY BREAK OR OTHERWISE ESCAPE FROM BENEATH RAM UNDER HIGH PRESSURE, THE TWO CAPSTAN HANDWHEEL HANDLES SHOULD BE REMOVED FROM HUB TO MINIMIZE INERTIA OF THE ARBOR PRESS FEATURE - THUS MINIMIZING POSSIBLE DAMAGE DUE TO SUDDEN PRESSURE RELEASE AND SLIGHT DOWNWARD MOVEMENT OF THE RAM.

TO SERVICE PRESS:

IF PRESS REFUSES TO HOLD HYDRAULIC PRESSURE AND INDICATING POINTER ON GAUGE SHOWS PRESSURE DROP, CHECK FIRST TO SEE IF PUMP HANDLE MOVES UPWARD AS PRESSURE DROPS. IF IT DOES, THE TROUBLE IS PROBABLY A RESULT OF FOREIGN MATTER WHICH MAY BE HOLDING PUMP EXHAUST BALL 25R-8 OFF IT'S SEAT.

IF PUMP HANDLE IS PULLED DOWN (AND RAM NOSE IS AGAINST WORK) BUT NOT PRESSURE DEVELOPS, THE BALL VALVE 25R-8 (INTAKE VALVE FOR PUMP) MAY NOT BE SEATING PROPERLY. THE HOLLOW PIPE PLUG 25R-6, WHICH MAKES THE SEAT FOR BALL 25R-8, HAS A HEX SOCKET TO FIT AN ALLEN TYPE WRENCH.

PUMP BODY CAN BE REMOVED FROM CYLINDER BODY BY REMOVING PUMP PLUNGER LINKS AND TAKING OUT THE FOUR (4) CAP SCREWS THAT HOLD THE PUMP CASTING. PLEASE NOTE WHEN DOING THIS, THERE IS A RUBBER "O" RING AT THE TOP END OF THE PUMP CASTING TO SEAL AGAINST THE BOTTOM OF THE OIL TANK. ALSO, THERE IS AN "O" RING 25R-7 WHICH SEALS PUMP BODY TO CYLINDER WALL. BE SURE THESE ARE BOTH IN POSITION IN THEIR RESPECTIVE GROOVES WHEN REPLACING PUMP. SOMETIMES A LITTLE DAUB OF HEAVY GREASE ON THE RING HELPS TO HOLD IT WHILE POSITIONING.

YOU WILL NOTE THAT A STEEL LOCK RING 25R-10 HOLDS EXHAUST VALVE SPRING 25R-9 IN PLACE AGAINST BALL 25R-8. THIS LOCK RING HAS A HOLE IN THE CENTER THROUGH WHICH A PUNCH MADE OF SOFT STEEL CAN BE INSERTED AGAINST BALL 25R-8. TAP LIGHTLY WITH A HAMMER TO RESEAT THIS BALL.

PUMP PACKING RINGS 4064.75 SHOULD BE COMPRESSED BY PACKING GLAND NUT 25R-62 ONLY ENOUGH TO KEEP OIL FROM DRIPPING. THERE WILL BE A COATING OF OIL ON THE PLUNGER WHICH IS NECESSARY FOR PROPER LUBRICATION. IF OIL SHOULD STREAM DOWN RAM 25R-4, AND LEAK OUT AN UNDUE AMOUNT THROUGH BOTTOM OF THE HEAD, THE PACKING RING 25R-11 MAY BE WORN OR INOPERATIVE. THE PISTON HOLD DOWN NUT 25R-20 MAY BE LOOSE OR THE "O" RING PACKING 25R-50 MAY NOT PROVIDE A SEAL BETWEEN THE PISTON AND THE RAM.

IF SERVICE REQUIRES THE REMOVAL OF THE RAM, LOOSEN NUT 25R-37 ON THE CONTROL ROD. UNSCREW THE CONTROL ROD 25R-29 (TURNING IN COUNTER-CLOCKWISE DIRECTION) UNTIL IT IS DIS-ENGAGED FROM 25R-36.

TO SERVICE PRESS - C O N T I N U E D

REMOVE CYLINDER HEAD BOLTS 25R-35 AND CYLINDER HEAD SHOULD SEPARATE FROM THE CYLINDER. PLACE A DEEP PAN ON THE PRESS TABLE AND PISTON CAN BE PULLED DOWN AND REMOVED. NOTE: THE CONSTRUCTION OF THE PACKING RING 25R-11. IT IS COMPOSED OF ONE LARGE NEOPRENE CENTER RING AND FOUR (4) THIN RINGS (2 ON EACH SIDE) WHICH ARE REPLACED IN THE GROOVE LIKE PISTON RINGS, AFTER THE NEOPRENE RING IS IN PLACE TO PREVENT "O" RING EXTRUSION. ALSO, NOTE THAT THESE NON-EXTRUSION RINGS ARE RATHER DELICATE TO HANDLE, AND, WHEN REPLACING THE RAM-PISTON ASSEMBLY IN THE CYLINDER, PLEASE USE CAUTION AND MAKE SURE THAT THEY ARE BACK IN THE PISTON GROOVE. ENTER THE PISTON IN THE CYLINDER HOUSING AND TAP ON THE LOWER END WITH A FIBER Mallet OR BLOCK OF CLEAN HARD WOOD.

IF AN AIR CUSHION FORMS, AS YOU PUSH THE RAM UPWARDS, PULL DOWN ON THE CONTROL ROD 25R-29 WHICH IN TURN HOLDS VALVE 25R-13 OPEN, THUS RELIEVING THE AIR PRESSURE ABOVE THE PISTON. REPLACE THE CYLINDER HEAD AND RECONNECT THE CONTROL ROD 25R-29, AND, TIGHTEN LOCK NUT 25R-37. **C A U T I O N:** WHEN ADJUSTING THIS ROD FOR LENGTH, BE SURE THAT WHEN CONTROL KNOB 25R-45 IS IN THE FULL CLOSED (TO THE REAR) POSITION, THE TRIPPING ARM 25R-28 DOES NOT REST ON PIN 25R-21. (A 1/32" TO 1/16" CLEARANCE SHOULD BE CORRECT).

TO REMOVE THE TANK COVER, FIRST REMOVE COTTER PINS 25R-49. A STEADY UPWARD PULL ON THE BREATHER CAP 25R-70 WILL THEN REMOVE THE COVER ASSEMBLY. THE "O" RING SEAL, 25R-34 MAY CAUSE SOME RESISTANCE. YOU WILL NOTE THAT THE LOADING AND UNLOADING VALVE IN THE TOP OF THE CYLINDER IS BUILT IN A CAGE 25R-12, WHICH IN TURN IS SCREWED INTO THE TOP OF THE CYLINDER USING "O" RING 25R-24 TO SEAL AGAINST PRESSURE. WITH THE COVER OF THE TANK REMOVED, THE ACTION OF THIS VALVE MAY BE OBSERVED WITH SOMEONE OPERATING THE PRESS.

THE OPERATION OF THE VALVE IS AS FOLLOWS: WHEN THE RAM AND PISTON ARE PULLED DOWN TO THE WORK OR THE PRESS TABLE BY MEANS OF THE CAPSTAN HANDWHEEL, THE VALVE 25R-13 OPENS AND ALLOWS OIL FROM THE TANK TO FLOW THROUGH, THUS LOADING THE CYLINDER AUTOMATICALLY. AS THE END OF THE RAM TOUCHES THE TABLE OR WORK, VALVE 25R-13 AUTOMATICALLY CLOSES, THUS TRAPPING THE CYLINDER FULL OF OIL. THE FIRST STROKE OF THE HAND PUMP SHOULD NO START TO BUILD UP PRESSURE.

NOTE: THE CYLINDER WILL LOAD AUTOMATICALLY WITH THE CONTROL KNOB IN THE OPEN OR CLOSED POSITION. HOWEVER, TO BUILD UP HYDRAULIC PRESSURE, THE KNOB MUST BE THE BACK OR CLOSED POSITION. AS STATED IN THE OPERATING INSTRUCTIONS, WITH THE KNOB IN THE FORWARD OR OPEN POSITION, VALVE 25R-13 IS HELD OPEN AND OIL MOVES FREELY IN AND OUT OF THE CYLINDER, THUS PERMITTING THE FREE USE OF THE RACK AND PINION PRESS FEATURE WHICH IS OFTEN SO USEFUL ON LIGHT TYPE WORK.

TO SERVICE PRESS - C O N T I N U E D

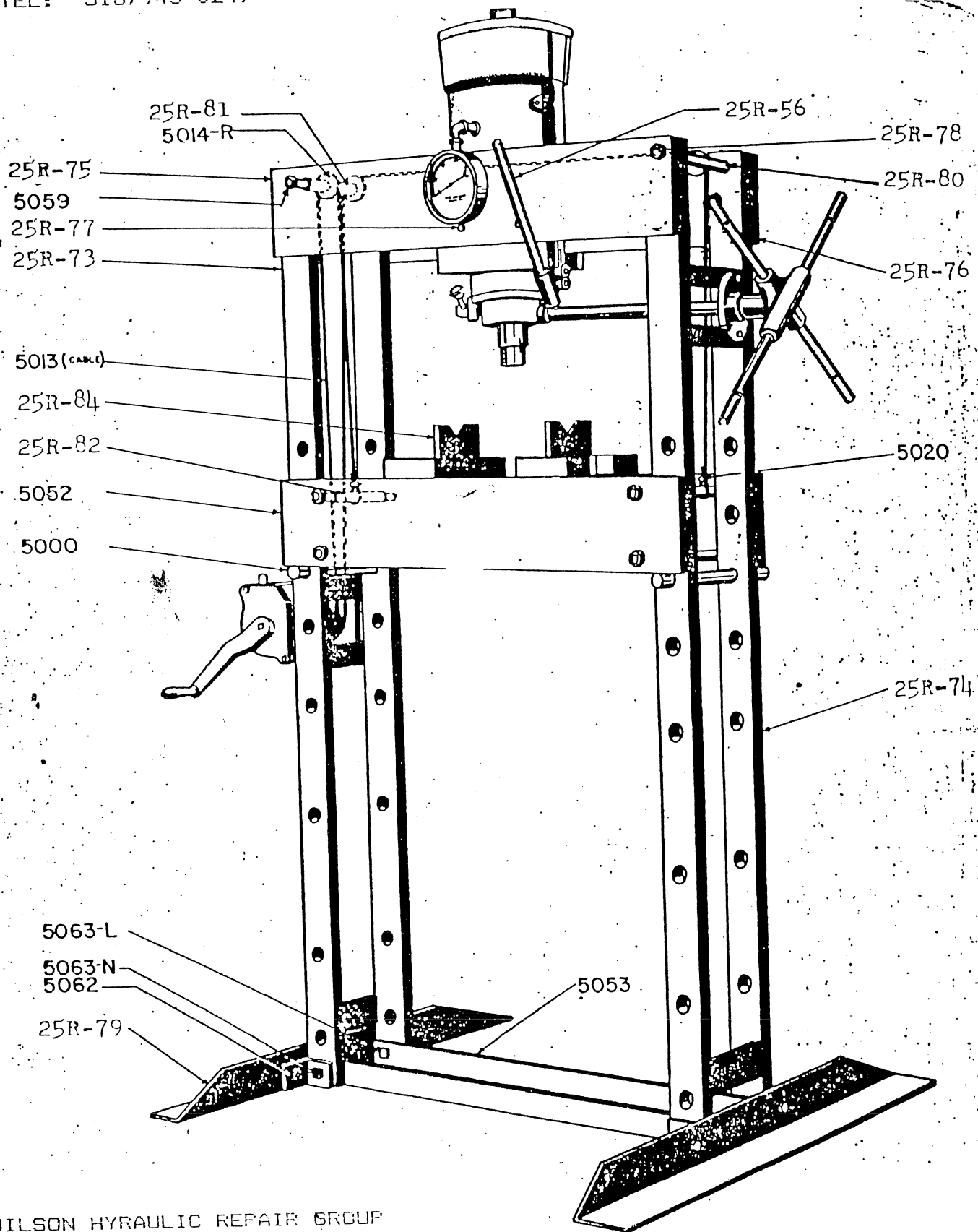
IN SERVICING THE CONTROL VALVE ASSEMBLY (25R-12), YOU WILL NOTE IN THE CENTER OF THE LARGE VALVE STEM A SMALL PIN (25R-21), A SMALL BALL VALVE (25R-19), A SPRING (25R-18), AND, A PLUG WITH A HOLE THROUGH THE CENTER (25R-17).

WHEN OIL IN THE CYLINDER IS UNDER HIGH PRESSURE, THE LARGE VALVE 25R-13 WILL NOT OPEN UNTIL THE TRIPPING ARM 25R-38 FIRST PULLS DOWN THE TRIPPING PIN 25R-21 AND BALL 25R-19, THUS RELIEVING THE PRESSURE IN THE CYLINDER. AS THE ARM 25R-28 IS FURTHER PULLED DOWN, IT CONTACTS THE STEM OF THE LARGE VALVE 25R-13 WHICH NOW OPENS EASILY SINCE THE PRESSURE HAS DROPPED TO ZERO.

IF FOREIGN MATTER SHOULD GATHER UNDER THE SEAT OF VALVE 25R-13, IT MAY NORMALLY BE REMOVED BY GRASPING THE TOP OF THE VALVE STEM, AND ROTATING THE VALVE BACK AND FORTH ON ITS SEAT A FEW TIMES. THE SMALL VALVE 25R-19 CAN BE RE-SEATED BY REMOVING THE PLUG 25R-17, AND, SPRING 25R-18, AND, TAPPING THE BALL SLIGHTLY WITH A SMALL PIECE OF BRASS OR MILD STEEL ROD.

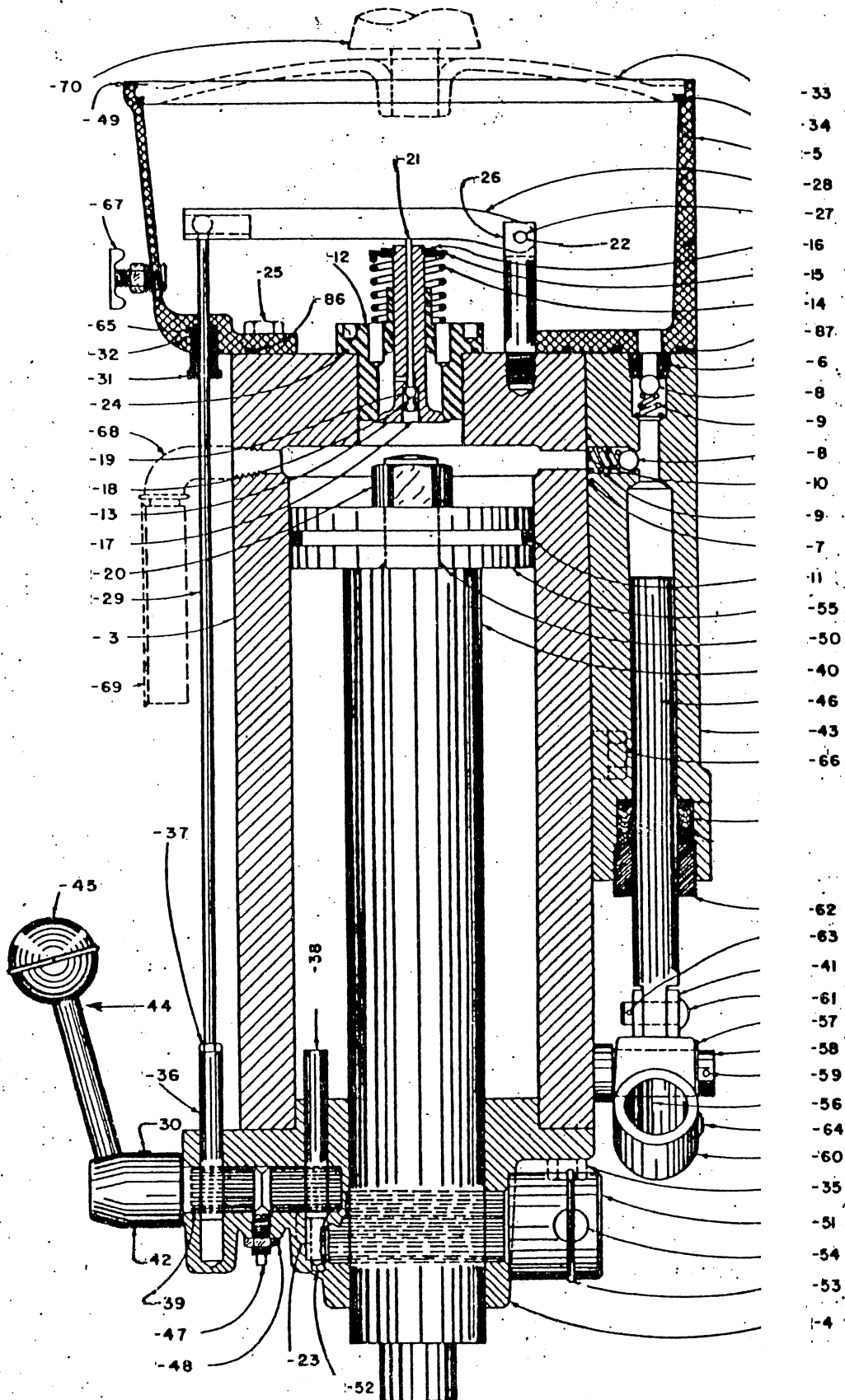
IF THE VALVE CAGE IS TO BE REMOVED FROM THE TOP OF THE CYLINDER FOR SERVICE, FIRST REMOVE THE COTTER PIN 25R-27 AND HINGE PIN 25R-22. THE ARM 25R-28 CAN NOW BE SLIPPED OFF THE BALL WHICH IS ON THE UPPER END OF THE CONTROL ROD 25R-29. THE VALVE CAGE CAN NOW BE UNSCREWED FROM THE TOP OF THE CYLINDER.

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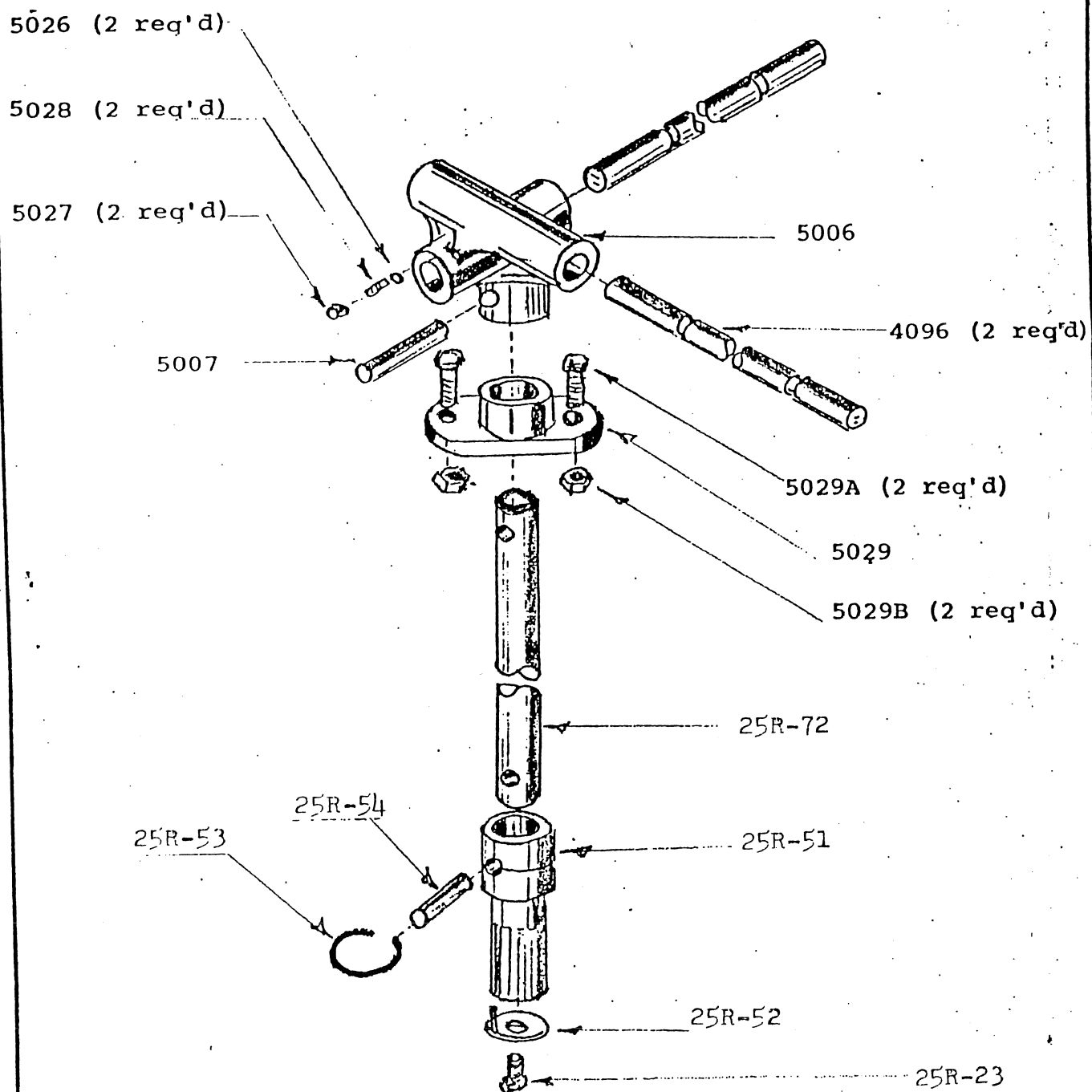
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WHRG MODEL 25R: HYDRAULIC CYLINDER & PUMP ASSEMBLY

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PARTS LIST
FOR
WHRG MODEL 25R, 25 TON HAND-OPERATED
HYDRAULIC SHOP PRESS

<u>PART NO.</u>	<u>AMT.</u> <u>REQ'D.</u>	<u>ITEM/DESCRIPTION</u>
25R-03	1	CYLINDER CASTING, MACHINED
25R-04	1	HEAD CASTING, MACHINED
25R-05	1	OIL RESERVOIR
25R-06	1	SEAT BUSHING, PUMP INTAKE
25R-07	1	"O" RING, PUMP
25R-08	2	BALLS, PUMP
25R-09	2	SPRING, PUMP
25R-10	1	RETAINING RING, PUMP
25R-11	2	PISTON T-SEALS
25R-12	1	BODY, RELEASE VALVE
25R-13	1	RELEASE VALVE
25R-14	1	SPRING, RELEASE VALVE
25R-15	1	WASHER, RELEASE VALVE
25R-16	1	RETAINING RING, RELEASE VALVE
25R-17	1	SET SCREW, RELEASE VALVE
25R-18	1	SPRING, CRACKING BALL
25R-19	1	BALL, CRACKING
25R-20	1	LOCK NUT, PISTON
25R-21	1	PIN, CRACKING BALL
25R-22	1	COTTER PIN, PIVOT SCREW
25R-23	1	CAP SCREW, PINION
25R-24	1	"O" RING, RELEASE VALVE
25R-25	4	CAP SCREW, OIL RESERVOIR
25R-26	1	PIVOT SCREW, RELEASE VALVE
25R-27	1	PIN, PIVOT SCREW
25R-28	1	LEVER, PRESSURE RELEASE
25R-29	1	PUSH ROD, PRESSURE RELEASE
25R-30	1	PIN
25R-31	1	BUSHING, PUSH ROD SEAL
25R-32	1	"O" RING, PUSH ROD SEAL
25R-33	1	COVER, OIL RESERVOIR
25R-34	1	RING SEAL, RESERVOIR COVER
25R-35	4	CAP SCREWS, HEAD ASSEMBLY
25R-36	1	RACK, EXT. PRESSURE RELEASE
25R-37	1	LOCK NUT, PRESSURE RELEASE
25R-38	1	RACK, INTERNAL, PRESSURE RELEASE
25R-39	1	PINION, PRESSURE RELEASE
25R-40	1	RAM, RACK CUT
25R-41	2	DRAG LINKS, PUMP
25R-42	1	LINK, PINION, HANDLE
25R-43	1	PUMP, CASTING
25R-44	1	STUD, HANDLE

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PARTS LIST
FOR
WHRG MODEL 25R, 25 TON HAND-OPERATED
HYDRAULIC SHOP PRESS

<u>PART NO.</u>	<u>AMT.</u> <u>REQ'D.</u>	<u>ITEM/DESCRIPTION</u>
25R-45	1	BALL, HANDLE
25R-46	1	PISTON PUMP
25R-47	1	SCREW, LOCATING, PINION
25R-48	1	NUT, LOCATING SCREW, PINION
25R-49	2	COTTER PINS, COVER
25R-50	1	"O" RING, RAM SEAL
25R-51	1	PINION, RAM
25R-52	1	WASHER, PINION
25R-53	1	SNAP RING (PINION PIN RETAINER)
25R-54	1	DOWEL PIN TO PINION
25R-55	1	PISTON
25R-56	1	PUMP HANDLE
25R-57	1	WASHER
25R-58	1	FULCRUM PIN
25R-59	1	COTTER PIN TO PUMP HANDLE HOUSING
25R-60	1	HOUSING, PUMP HANDLE
25R-61	1	PIN, DRAG LINK TO PISTON
25R-62	1	GLAND NUT
25R-63	1	COTTER PIN, PLUNGER SHAFT
25R-64	1	SET SCREW, PUMP HANDLE HOUSING
25R-65	1	STRING PACKING TO PUSH ROD SEAL BUSHING
25R-66	4	SOC. HD. CAP SCREWS TO PUMP HOUSING
4064.75	1/SET	PUMP PACKING SEALS
25R-67	1	DRAIN COCK TO OIL RESERVOIR
25R-68A	1	ELBOW (GAUGE MOUNTING)
25R-68B	1	SHORT NIPPLE (GAUGE MOUNTING)
25R-69	1	PRESSURE GAUGE (0-25 TONS) NOTE: SPECIALLY RED-LINED CAUTION
25R-70	1	BREATHER CAP TO OIL RESERVOIR
25R-71	1	SPRING, PUMP JACK
25R-72	1	SHAFT, CAPSTAN HANDWHEEL
25R-73	1	SIDE FRAME, LEFT ASSEMBLY
25R-74	1	SIDE FRAME, RIGHT ASSEMBLY
25R-75	1	TOP CROSS PLATE, FRONT
25R-76	1	TOP CROSS PLATE, BACK (REAR)
25R-77	4	CAP SCREWS, CYLINDER RETAINER
25R-78	10	STUDS, FRAME
25R-79	2	BASE FOOTERS
25R-80	4	SPACER, PRESS FRAME
25R-81	2	SPACERS (PULLEY DIVIDERS)
25R-82	4	SPACERS, TABLE PLATE (IF APPLICABLE)

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PARTS LIST
FOR
WHRG MODEL 25R, 25 TON HAND-OPERATED
HYDRAULIC SHOP PRESS

<u>PART NO.</u>	<u>AMT.</u> <u>REQ'D</u>	<u>ITEM/DESCRIPTION</u>
25R-83	2	MATCHES SET OF MOVEABLE "V" BLOCKS OR, WHEN INVERTED - FLAT PRESSING PLATES WHICH ARE STEPPED TO FIT BETWEEN THE OPENING OF THE VERTICAL TABLE PLATES. *NOTE: NOT STANDARD. *MUST BE SEPARATELY ORDERED.
25R-86	1	"O" RING
25R-87	1	"O" RING
4029	1	FLAT RAM NOSE
4096	2	HANDWHEELS, SPIKE
25R-5000	2	SPECIAL ALLOY TABLE PINS
5006	1	HANDWHEEL HUB
5007	1	PIN (HUB TO SHAFT)
5013	1	CABLE
5014R	1	PULLEY
5020	4	CABLE CLAMPS
5026	2	STEEL DETENT BALLS IN HUB
5027	2	PIPE PLUGS IN HUB
5028	2	SPRING FOR DETENT IN HUB
5029	1	BEARING, PINION SHAFT
5029A	2	CAP SCREWS TO ABOVE BEARING
5029B	2	NUTS (AS REQUIRED)
5052	2	TABLE PLATES
5053	2	TIE BARS
5059	12	HEX NUT FASTENERS
5062	4	ANGLE BRACKETS
5063-L	4	MACHINED BOLTS FOR BASE BRACKETS
5063-N	4	HEX NUT FASTENERS FOR ABOVE
5063-S	4	MACHINED BOLTS FOR BASE/BACKET MOUNTING

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WILSON HYDRAULIC REPAIR GROUP

RECOMMENDED SPARE PARTS LISTING
FOR MODEL 25R, 25 TON WHRG HYDRAULIC PRESS

<u>QUANTITY</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	25R-7	O-RING, PUMP
1	25R-24	O-RING, PUMP
1	25R-32	O-RING, PUSH ROD SEAL
1	25R-86	O-RING, RESERVOIR COVER
1	25R-87	O-RING, PUMP
1	25R-65	STRING PACKING
2/S	25R-11	G.T. SEALS
2	25R-8	BALL CHECK
1	25R-50	O-RING, RAM SEAL
1	4064.75	PUMP PACKING