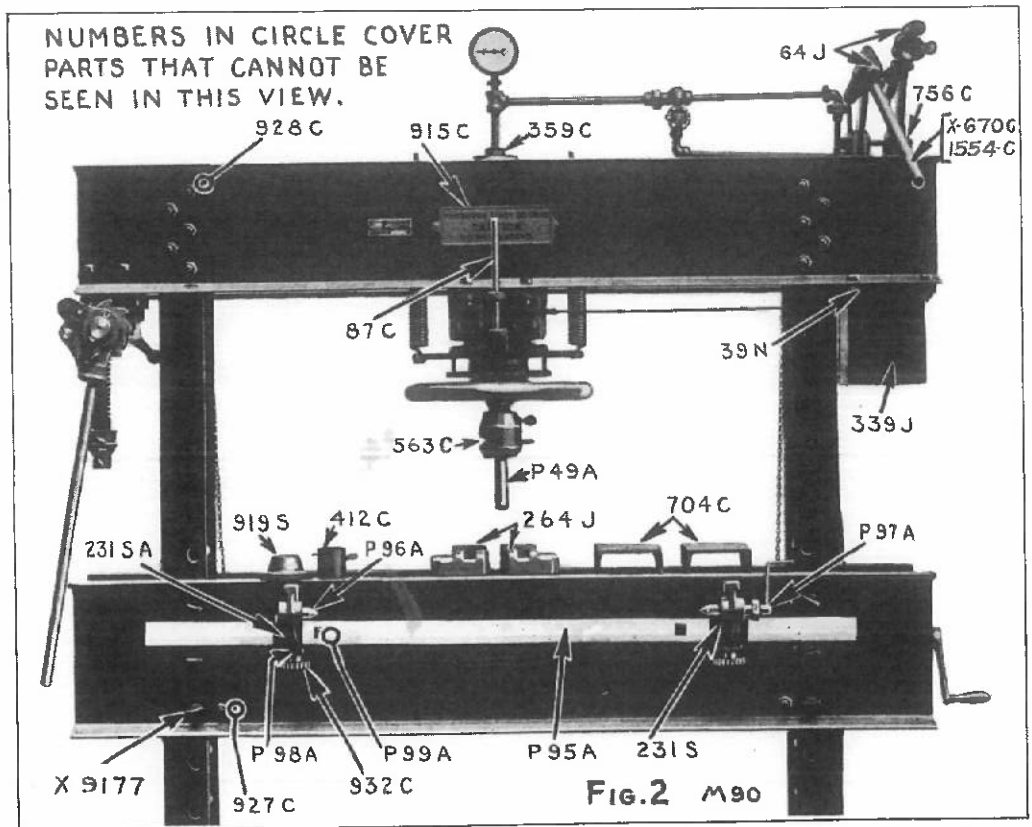
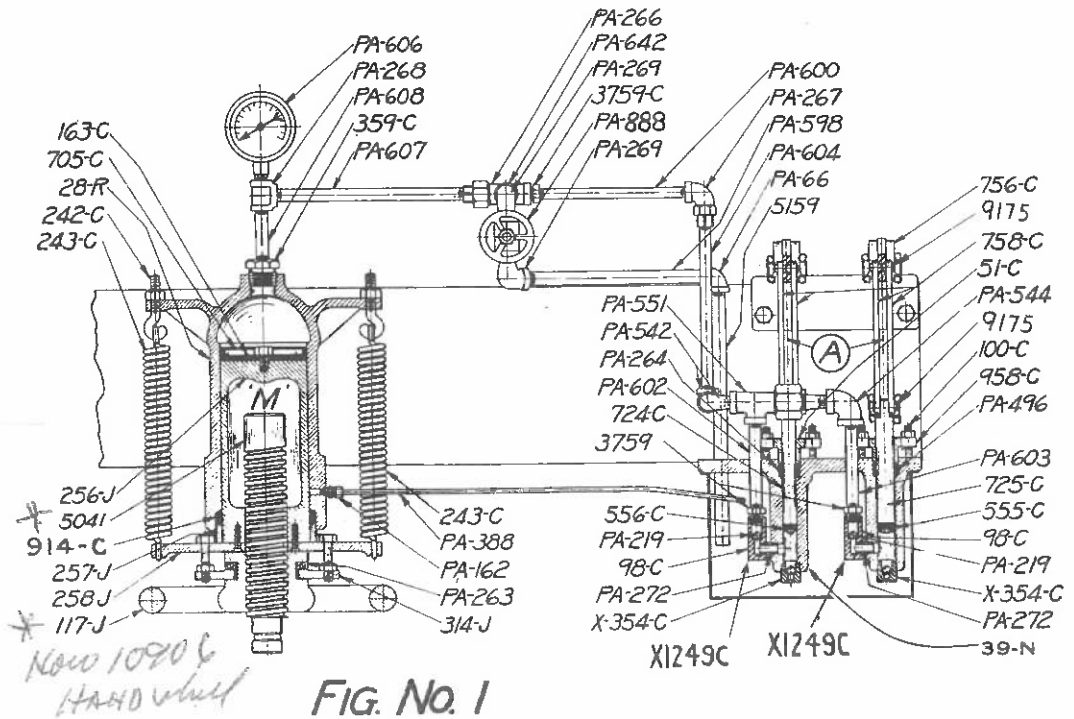


INSTRUCTIONS AND PARTS LIST ON No. 6-A PRESS



NOTE—Defective parts must be returned prepaid when making claim for credit. Always give catalog number and Serial Number of Machine when ordering parts. Prices on parts are subject to change without notice. No invoice rendered for less than .50.

INSPECTION OF SHIPMENT

Before accepting shipment, make sure machine was not damaged in transit. If damaged,

have Agent note on Freight Bill and file with Transportation Co.

UNPACKING

Remove the crate carefully. The following loose fittings are with Press No. 6-A :

- | | |
|------------------------|---------------------------------------|
| 1 Pressure gauge | 2 Channel blocks for table |
| 1 Depth gauge pin | 2 V-blocks for table |
| 1 Release valve handle | 1 Handle for table winch |
| 1 Screw nose cap | 1 Pump handle extension |
| 1 V-nose extension pin | 2 Thumb screws |
| 1 V-nose for screw | 1 Collar for pressing off axle gears. |

With Press No. 26-A the following additional fittings are included :

- | | |
|-------------------------|--------------------------------|
| 1 Extension handle | 1 Extension pin holder |
| 1 Pinion shaft assembly | 1 Pull back (or return) handle |
| 1 Rack | 1 Spacer |

With Press No. 26A-49 the following additional fittings are included :

- 1 Extension bar with spacers and bolts.
- 2 Test center heads (wired to front corner posts).

ASSEMBLY

Remove the plug in the pipe tee PA-268 (Fig. No. 1) over the cylinder and insert the pressure gauge PA-606 (Fig. No. 1). Use a wrench to do this, as turning the gauge by hand may break the glass. The handle of valve PA-888 may now be attached and the guide pin 87-C (Fig. No. 2) put in place as shown.

Next attach the pump handles (64-J Fig. No. 2) at the right hand end of the upper channels to the bracket on the rear channel. Then remove the $\frac{3}{4}$ " pipe plug from the pump casting above the oil tank and put in about five (5) quarts of light engine oil SAE No. 20 and replace the plug.

On presses No. 26-A it is also necessary to install the Rack and Pinion Attachment. The Rack P-83-A (Fig. 3) is first put in place by putting it in the bearing from the bottom with the teeth towards the center of the press. The leaf spring 7002 (Fig. 3) that holds the rack is taped in place at the factory for shipping. When installing the rack remove the tape taking care not to lose the

spring. Then insert the pinion and shaft (Fig. 3) that are assembled with the ratchet wheel and handle socket. This is inserted from the front of the press; next place the spacer 937-C (Fig. 3) over the pinion shaft and mount the return handle 454-S (Fig. 3). Before tightening the set screw in the return handle make certain that it enters the spot hole in the pinion shaft.

On presses No. 26-A-49 it is also necessary to install the Test Centers. This is done by placing the long bar P-95-A (Fig. No. 2) on the front table channel. The pipe spacers P-99-A (Fig. No. 2) should be placed between the bar and table channel making certain the bolts holding the bar to the channel are set squarely and installed so the nuts are on the inside of the table channel. The adjustable center head should be on the right hand side.

Prime the pumps by giving each pump ten (10) to fifteen (15) strokes with the release valve PA-888 (Fig. No. 1) open to expel the air in the piping.

HOW TO OPERATE

Raise or lower the winch-operated table to suit the work. Insert table pins X-9177 (Fig. No. 2). Place the work under the screw and spin the ball-bearing hand wheel until the screw nose rests on the work. Close the release valve PA-888 and operate the

pump until the desired pressure is obtained. When finished open release valve PA-888 and the plunger will immediately return to its highest position. Then spin hand wheel to return the screw to its highest position.

CAUTION

Before using the press, always put the protecting cap 412-C (Fig. No. 2) on end of plunger screw so as not to burr its end.

The table chains are intended for raising and lowering table only. Do not apply pressure on work until table pins have been inserted.

The screw (operated by the hand wheel) is

provided with a stop. Do not force the screw beyond the stop.

When operating the pump, do not drive the hydraulic plunger below the six-inch (6-in.) limit indicated by the depth gauge located in front of the upper channel. Otherwise, the packing may become damaged.

INDEX TO INSTRUCTION CHART (Fig. 1)

A. If the plunger M does not move when the handle A is pumped:

1. Is there sufficient oil in the oil tank?
2. Is valve PA-888 closed (it is sometimes necessary to pump the handle A 10 or 15

times to remove the air that is in the cylinder and the piping)?

3. Remove the oil box by taking out the several cap screws and bolts to inspect valves 98-C and X-354-C. Be sure to have the screen on the bottom of valve X-354-C clean.

4. Inspect valve PA-888 by removing the cap and examining the seat to see that it is not pitted or leaking.

B. Pressure will not hold and handle "A" raises:

1. Inspect valve 98-C as this valve, if leaking, will cause handle A to raise after pressure is applied on the plunger M.

C. Pressure will not hold but handle A does not raise:

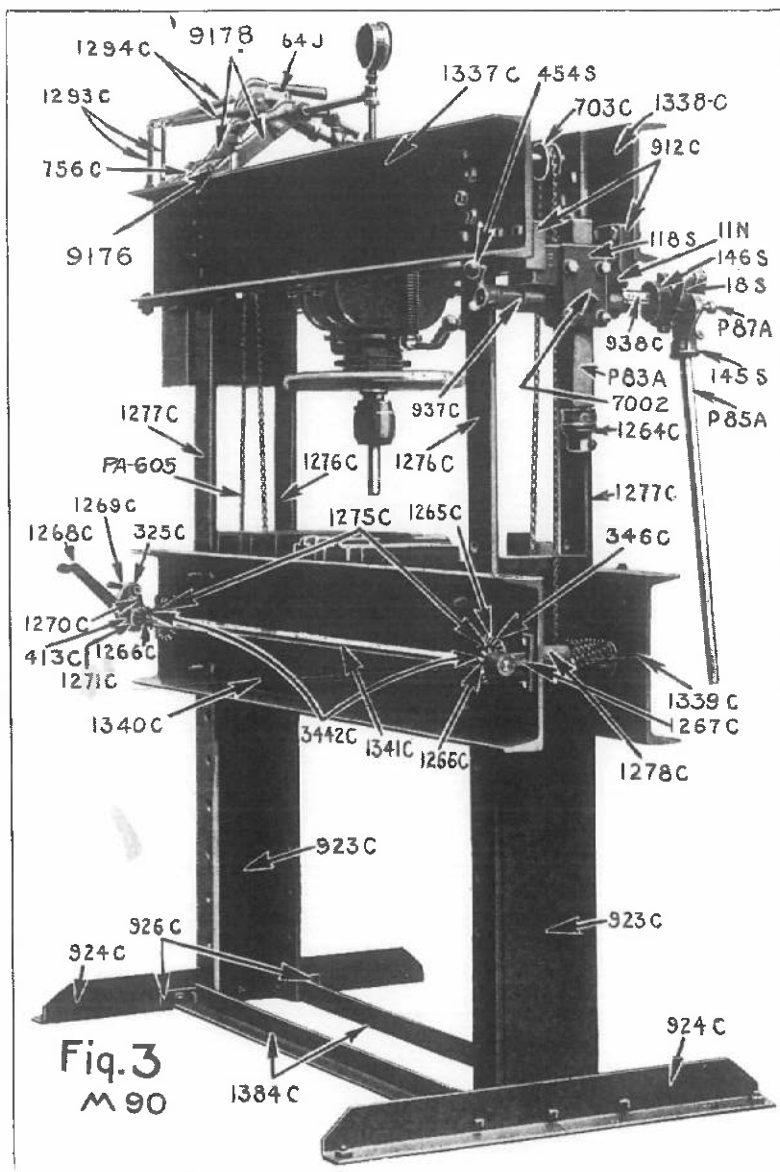
1. Inspect valve PA-888 for leakage.

D. Oil leaks around plunger "M":

1. Adjust packing by tightening gland 257-J with the four cap screws.

E. Oil leaks around the pump plungers:

1. Adjust the packing by tightening the glands 958-C and 51-C.



PARTS LIST FOR No. 6-A PRESS

Part No.	Req. No.	Description	Part No.	Req. No.	Description
11-N	1	Bearing	PA-600	1	Extra Heavy Pipe (horiz.) ¼" x 11" ..
18-S	1	Pawl	PA-602	1	Extra Heavy Pipe (vert.) ¼" x 6"
28-R	1	Cylinder 5" Bore	PA-603	1	Extra Heavy Pipe (vert.) ¼" x 6 ¾" ..
39-N	1	Pump Cylinder Plate ¾" x 1" Dia. Hole	PA-604	1	Extra Heavy Pipe (vert.) ¼" x 9 ¼" ..
P-49-A	1	V-Nose Extension 1" Dia. x 6"	PA-605	2	Lifting Chains No. 113—9'-7" Long ...
51-C	1	Packing Gland ¾" Hole	PA-606	1	Pressure Gauge 70 Ton 5" Ram
PA-62	1	Pipe Plug ¾"	PA-607	1	Extra Heavy Pipe (horiz.) ¾" x 11 ½" ..
64-J	2	Handle Socket	PA-608	1	Extra Heavy Pipe Nipple ¾" x 3 ½" ..
PA-66	1	Standard Ell ¾"	PA-642	1	Extra Heavy Nipple ¾" x 2 ½"
P-83-A	1	Rack 1 ½" x 1 ¾" x 14-13/16"	X-670-C	1	Handle Unit (with Pin)
P-85-A	1	Lever ¾" Dia. x 26"	PA-698	1	Spec. Washer ½" O.D. x ¼" I.D. x 3/64" Th.
P-87-A	1	Special Pawl Locking Screw	703-C	2	Sheave Wheel
87-C	1	Guide ½" Dia. x 9"	704-C	2	Raising Block 5"—9" x 14"
P-95-A	1	Parallel Bar	705-C	1	Cup Washer 5" Dia. x ¾" x 3/16"
P-96-A	1	Dead Center	724-C	1	Plunger ¾" Dia. x 7"
P-97-A	1	Live Center	725-C	1	Plunger 1" Dia. x 7"
P-98-A	2	Clamp Plate ¾" x 1 ½" x 4"	731-C	2	Hook No. 49
98-C	2	Check Valve Body 1" x 1" x 2 ½"	756-C	1	Fulcrum Bracket
P-99-A	2	Spacers ¾" x 1 ¾" Pipe	9178	2	Beam ½" x 1 ½" x 10-5/16"
100-C	4	Packing Gland Stud ¾" Dia. x 2 ½" ..	758-C	4	Link 5/16" x 1" x 8 ¾"
117-J	1	Hand Wheel 14 ½" Dia.	910-C	2	Special Flat Head Bolt ½" x 1 ½"
118-S	1	Bearing Cover	911-C	2	Special Flat Head Bolt ½" x 2 ¾"
145-S	1	Handle Socket	912-C	2	Spacing Block
A-146-S	1	Ratchet Gear	915-C	1	Caution Plate
PA-155	1	Pipe Plug ¾"	919-S	1	Differential Shaft Remover
PA-162	1	¼" Ball Fastener ½" Pipe Thread	923-C	2	Right and Left Hand End Channel 7"—9.8" x 41"
163-C	1	Follower Plate 2-35/64" Dia.	924-C	2	Base Angles 3 ½" x 2 ½" x ¼" x 36"
PA-208	2	Taper Pins	926-C	4	Angle Bracket 3 ½" x 2 ½" x ¼" x 2"
PA-219	2	Steel Ball 7/16" Dia.	927-C	4	Table Channel Spacer ¾" x 8-7/16" Pipe
231-S	1	Live Center Bracket	928-C	4	Top Channel Spacer ¾" x 7" Pipe
231-SA	1	Dead Center Bracket	X-9177	6	Table Pins ¾" Dia. x 12 ¾" Lg.
242-C	2	Spring Adjusting Screw ½" Dia. x 5-1/16"	932-C	2	Hand Nut (½" Tap)
243-C	2	Pull Back Spring 1 ½" Dia. x 10" No. 4	937-C	1	Spacer
256-J	1	Ram 5" Dia. x 10 ¼" Dia.	938-C	1	Pinion Shaft 1 ¾" Dia. x 17-9/16"
257-J	1	Packing Gland	958-C	1	Packing Gland 1" Hole
258-J	1	Pull Back Yoke	1264-C	1	Arbor Socket
PA-263	1	Ball Retainer	1265-C	2	Bevel Gear 6 Pitch 4" P.D.—24 Teeth
264-J	2	Low V-Block	1266-C	2	Bevel Pinion 6 Pitch 2" P.D.—12 Teeth
PA-264	1	Pump Packing	1267-C	1	Gear Bearing
PA-266	1	Combination Tee and Union ¾"	1268-C	1	Crank 6 ¼" Centers
PA-267	1	Union Ell ¾"	1269-C	1	Holding Pawl
PA-268	1	Extra Heavy Tee ¾"	1270-C	1	Gear and Pawl Bearing
PA-269	2	Extra Heavy Street Ell ¾"	1271-C	1	Ratchet—20 Teeth
PA-888	1	Needle Valve ¾"—No. 1040	1275-C	2	Bevel Gear Shaft ¾" x 10 ¾"
PA-272	2	Extra Heavy Close Nipple ¾"	1276-C	2	Right Front and Left Rear Corner Posts ¾" x 3 ½" x 6'-0"
314-J	2	Ball Retaining Collar	1277-C	2	Left Front and Right Rear Corner Posts ¾" x 3 ½" x 6'-0"
325-C	1	Shoulder Stud ¾" Dia. x 1-13/16"	1278-C	2	Chain Drum
339-J	1	Tank 8 ¾" x 6 ½" x 7" No. 22 Ga. ...	1293-C	2	Eye Bolt ½" x 6 ¾"
346-C	6	Pin for Bevel Gear and Drum ¼" x 1-11/16"	1294-C	2	Coil Spring 13/16" Dia. x 6 ½" No. 12
X-354-C	2	Foot Check Valve Unit	1337-C	1	Rear Top Channel 10"—25" x 66" ...
369-C	1	Special Pipe Plug 1 ¾" Hex. x 1 ½" ...	1338-C	1	Top Front Channel 10"—25" x 66" ...
PA-863	1	Copper Tube ¼" O.D. 24 ½" Lg.	1339-C	1	Front Table Channel 12"—25" x 68 ½"
409-C	1	Screw Key 5/16" x 5/16" x 2"	1340-C	1	Rear Table Channel 12"—25" x 68 ½"
410-C	1	Pin for Screw Key 3/16" Dia. x 1" ...	1341-C	1	Table Adjusting Shaft ¾" x 68 ½"
412-C	1	Screw Cap 1 ¾", Bore 2 ½" Dia. x 2 ¾"	1384-C	2	Base Tie Bar 2" x 2" x ¼" x 51 ½" ..
413-C	1	Pin ¼" x 2"	1554-C	1	Handle ¾" Dia. x 26" long
454-S	1	Rack Adjusting Handle	3442	2	Pin ¼" x 1-7/16"
914-C	1	Cylinder Packing	3759	3	Reducing Bushing ¾" to ¼"
PA-496	1	Pump Packing	5041	1	Screw 2 ¾" Dia. x 13 ½" long
PA-542	2	Extra Heavy Street Ell ¼"	5159	1	Standard Pipe (vert.) ¾" x 14 ½"
PA-544	1	Extra Heavy Ell ¼"	7002	1	Leaf Spring
PA-551	1	Heavy Union Tee ¼"	9175	4	Pin ½" Dia. x 1 ½" Lg.
555-C	1	Plunger Cup Washer 1" Dia. x ¾"	9176	2	Pin ½" Dia. x 2-5/16" Lg.
556-C	1	Plunger Cup Washer ¾" Dia. x 5/16" ...			All Bolts, Nuts, Rivets and Washers
563-C	1	V-Nose 1 ¾" Bore			(Must be ordered by size and thread)
PA-598	1	Standard Pipe (horiz.) ¾" x 13 ½" ...			
X-1249-C	2	Check Valve Units			

Parts No's. 1293-C Eye Bolt and No. 1294-C Coi Spring not Standard Equipment, may be purchased as Extras.