

# Hilka

82950012

## 12 TONNE FLOOR STANDING SHOP PRESS



## ASSEMBLY & OPERATION

PLEASE RETAIN THIS LEAFLET  
FOR FUTURE REFERENCE






## Safety Advice

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-  Use protective eyewear, safety shield, heavy-duty work gloves and non-skid footwear.
-  Remove ties, watches, rings and other loose jewellery, and contain long hair.
-  Keep hands and feet away from bed area at all times.
-  Only use this press on a surface that is stable, level, dry and not slippery, and capable of sustaining the load.
-  Do not use press to compress springs or any other item that could disengage and cause a potential hazard.
-  Inspect the press before each use. DO NOT use if bent, broken, cracked, leaking or otherwise damaged, any
-  Never stand directly in front of loaded press and never leave loaded press unattended. Ensure that workpiece is center-loaded and secure.
-  DO NOT operate the press when tired or under the influence of alcohol, drugs or intoxicating medication.
-  DO NOT allow untrained persons to operate the press.

## Safety Advice

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-  DO NOT make any modifications to the press.
-  DO NOT expose the press to rain or any other kind of bad weather.
-  DO NOT use brake fluid or any other improper fluid and avoid mixing different types of oil when adding hydraulic oil. Only good quality hydraulic jack oil can be used
-  Use only authorised Hilka spare parts and use only authorised technicians for repairs.
-  The maximum load is 12 tonnes. DO NOT exceed this rated capacity. Never apply excessive force to a workpiece and always use the pressure gauge to accurately determine the applied load.

## Technical data

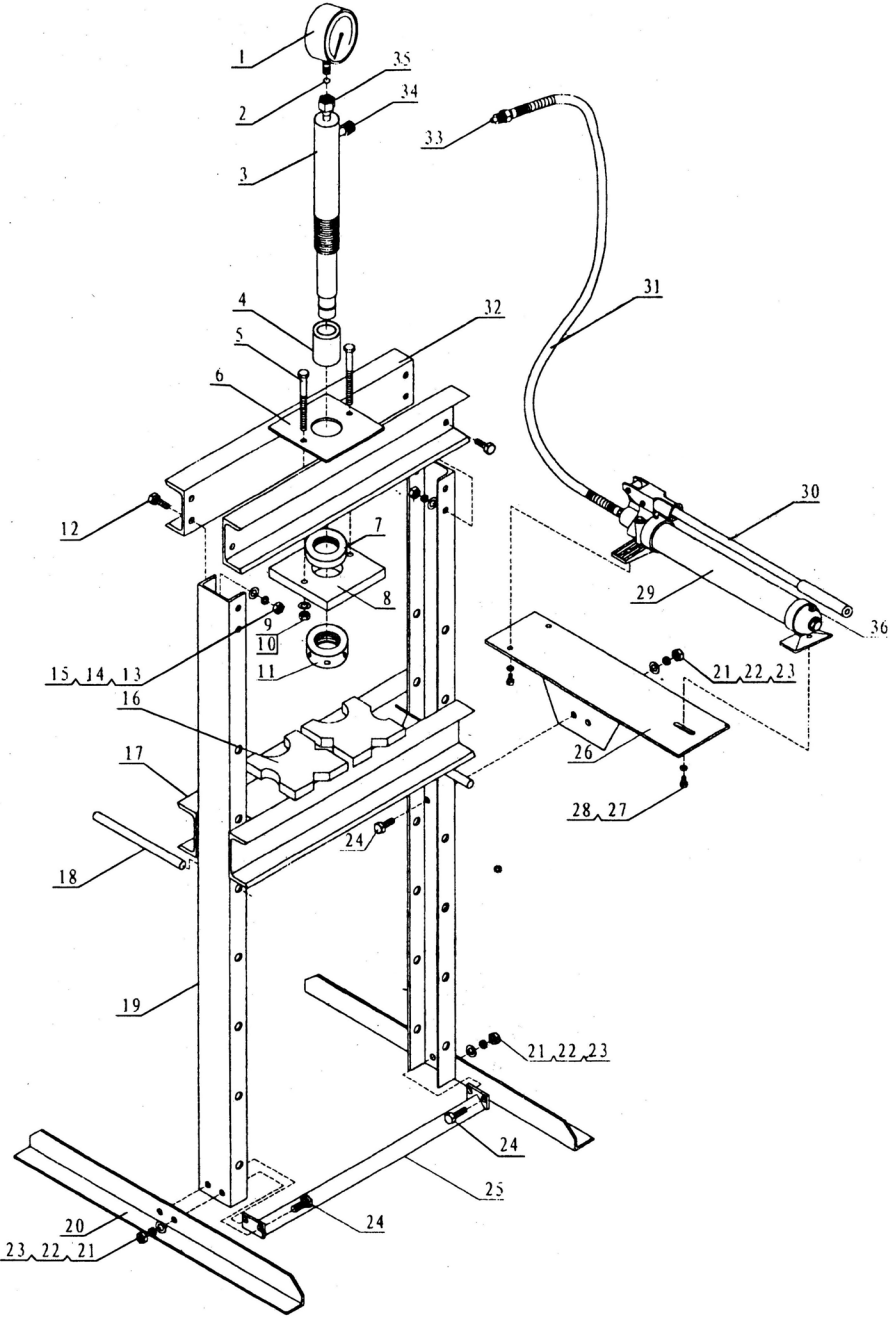
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Capacity	12 tonnes
Working range	77-917mm (2-7/8~36-1/8")
Stroke	180mm (7-1/16")
Bed width	510mm (20-1/16")

# Parts Guide

Item	Description	Qty	Item	Description	Qty
1	Pressure gauge	1	19	Post	2
2	Nylon washer	1	20	Base section	2
3	Ram assy	1	21	Lock washer	10
4	Hex socket screw	1	22	Spring washer	10
5	Bolt M10	2	23	Nut	10
6	Upper plate	1	24	Hydraulic hose assy	1
7	Upper round nut	1	25	Lower cross member	1
8	Under plate	1	26	Pump setting plate	1
9	Punch pin	1	27	Lock washer	3
10	Upper beam	2	28	Bolt	3
11	Under round nut	1	29	Pump assy	1
12	Bolt	14	30	Hose fitting	1
13	Washer	14	31	Clip pin	4
14	Lock washer	14	32	Bolt	8
15	Nut	14	33	Support	2
16	Block assy	2	34	Connection nut	1
17	Press bed frame	1	35	Gauge connection nut	1
18	Bed frame pin	2	36	Oil filler nut	1
			37	Support bar	4

# Parts Guide



# Assembly

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1. Unpack and lay all parts and assemblies out before beginning.
2. Attach one base section (20) to left post and lower cross member (25) using bolts (12), washers (13), lock washers (14) and nuts (15,)
3. Attach another right post and the lower cross member.
4. Put the press frame in an upright position, attach the two upper cross beams (10) to left and right posts (19) using bolts (12), washers (13), lock washers (14) and nuts (15).
5. Put the upper plate (6) onto the upper crossbeam, insert the bolt (5) into the hole in the upper plate, then insert the ram into the hole in the upper plate.
6. Screw the upper round nut (7) onto the ram until end, then put the under plate (8) onto the ram through the bolt (5)
7. Secure the upper plate and under plate by tightening the washers (21), lock washers (22) and nuts (23) to the bolt (5).
8. Insert bed frame pin (18) into the holes in the posts, then insert the press bed frame (17) into press frame and onto bed frame pin.
9. Attach the setting plate (26) to the right post using bolts (12), washers (13), lock washers (14) and nuts (15), then secure the pump assemblies using the bolt (27) and washers (28). and then insert the handle (30) to the handle bracket.
10. Connect the hydraulic hose fitting (33) to the connection nut (34) and assemble the pressure gauge (1) to the pressure gauge connection nut (35) which is on the top of ram (3).
11. Tighten all bolts, nuts and screws.

# Operation

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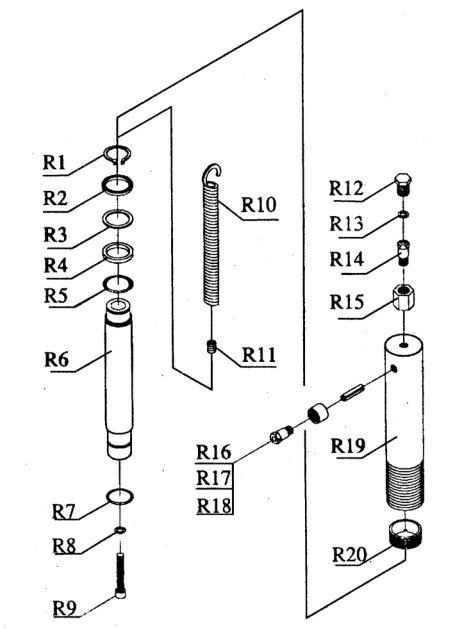
1. Before first use, purge away air from the hydraulic system. Open the release valve by turning anti-clockwise. Pump several full strokes to eliminate any air in the system.
2. Place the heel block (16) on press bed frame (17), then insert workpiece onto the heel block.
3. Close the release valve by turning it clockwise until it is firmly closed.
4. Pump the handle until serrated saddle nears workpiece.
5. Align workpiece and ram to ensure center-loading.
6. Pump the handle to apply load onto workpiece.
7. When work is done, stop pumping the handle, slowly and carefully remove load from workpiece by turning the release valve counterclockwise in small increments.
8. Once ram has fully retracted, remove workpiece from bed frame.

# Maintenance

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1. Clean the outside of the press with dry, clean and soft cloth and periodically lubricate the joints and all moving parts with a light oil as needed.
2. When not in use, store the press in a dry location with ram and piston fully retracted.
3. When press efficiency drops, purge the hydraulic system to eliminate any air in the system (see operation guide)
4. Check the hydraulic oil: remove the oil filler nut on the pump and if required fill with high quality hydraulic jack oil as necessary, then replace the oil filler nut. Purge away air from the hydraulic system
5. Check to ensure that all bolts, screws and nuts are firmly tightened.

# Parts Guide - Hydraulic Ram



Item	Description
1	Retaining ring
2	Sealing ring
3	Ring
4	O-ring
5	Circlip
6	Piston
7	Circlip
8	Sealing washer
9	Bolt M10
10	Spring

Item	Description
11	Screw
12	Screw
13	Nylon ring
14	Gauge coupler
15	Gauge connection nut
16	Pin
17	Connection nut
18	Coupler
19	Ram
20	Ring for ram

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