



# 50 Ton Shop Press

## MODEL H6233

### INSTRUCTION SHEET

#### Introduction

The Model H6233 50 Ton Shop Press (**Figure 1**) features 50 tons of pressure to handle forming, bending, straightening, and bearing and wheel installation.

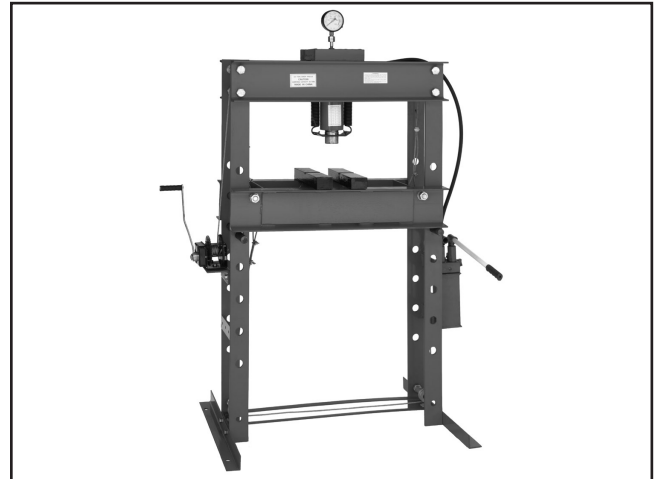
The Model H6233 was carefully packed when it left our warehouse. If you discover this shop press is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

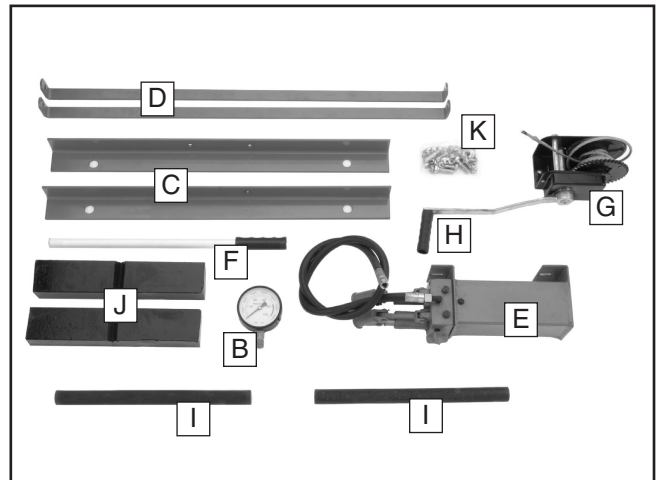
When you are completely satisfied with the condition of your shipment, you should inventory the contents.

#### Figure 2 - Main Contents.

<b>A.</b>	Press Frame (Not Shown)	1
<b>B.</b>	Hydraulic Pressure Gauge	1
<b>C.</b>	Base Supports	2
<b>D.</b>	Spreaders	2
<b>E.</b>	Hydraulic Pump	1
<b>F.</b>	Hydraulic Pump Handle	1
<b>G.</b>	Winch	1
<b>H.</b>	Crank Handle	1
<b>I.</b>	Support Rods	2
<b>J.</b>	Table Plates	2
<b>K.</b>	Bolt Bag	1
	—Hex Bolts M12-1.75 x 40	4
	—Hex Nuts M12-1.75	8
	—Lock Washers 12mm	8
	—Hex Bolts M12-1.75 x 25	4
	—Cable Clamps	2
	—Hex Nuts for Cable Clamps	4
	—U-Bolts	2
	—Hex Bolt M8-1.25 X 20	1
	—Flat Washer 8mm	1



**Figure 1.** Model H6233.



**Figure 2.** Inventory parts.

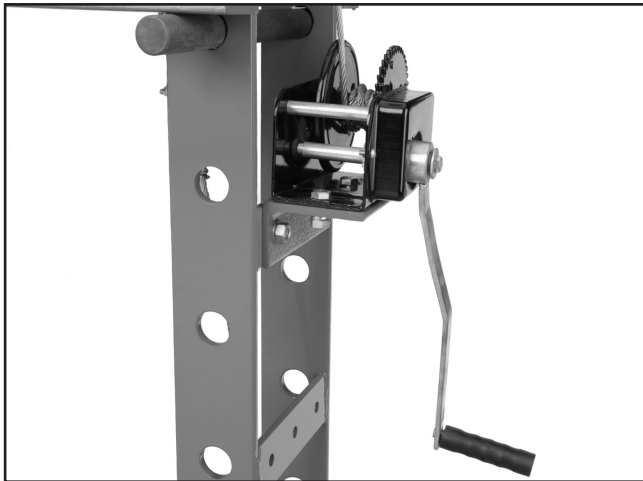
	<h3>⚠ WARNING</h3> <p>Always use ANSI approved safety glasses when operating machinery.</p>
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<h3>⚠ WARNING</h3> <p>This Shop Press is not a toy. DO NOT allow children to use this press. Serious injury may occur if this press is used incorrectly.</p>
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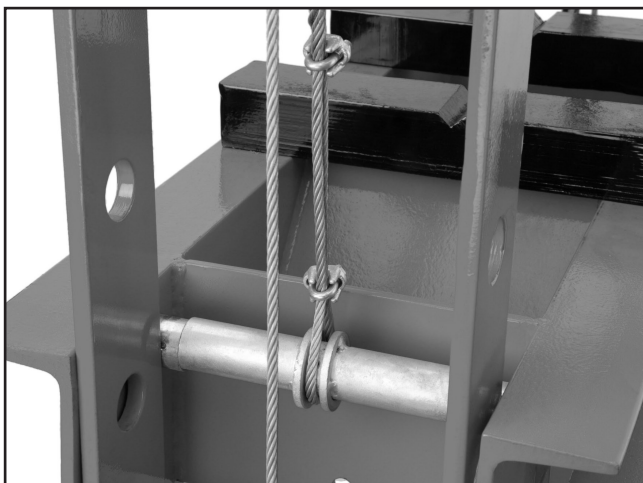
# ASSEMBLY

1. Get assistance to tilt the press upright, and have the assistant hold it in place.
2. Place the spreaders between the uprights and thread M12-1.75 x 40 hex bolts through the holes in the spreaders, the uprights and the base supports. Secure the hex bolts with 12mm lock washers and hex nuts.
3. Thread M12-1.75 x 25 hex bolts through the winch support bracket and the crossbar in the upright with the pulley at the top. Secure with lock washers and hex nuts. Attach the handle with a M8-1.25 X 20 hex bolt and 8mm flat washer (**Figure 3**).



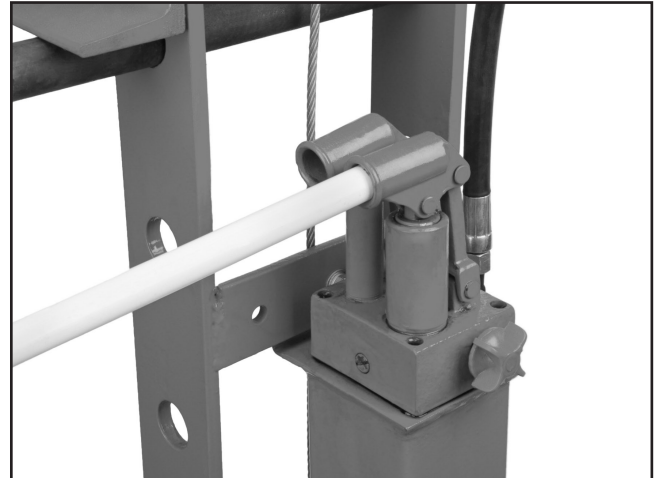
**Figure 3.** Winch installation.

4. Feed the cable through the pulley and loop it around the shaft in the table (**Figure 4**).



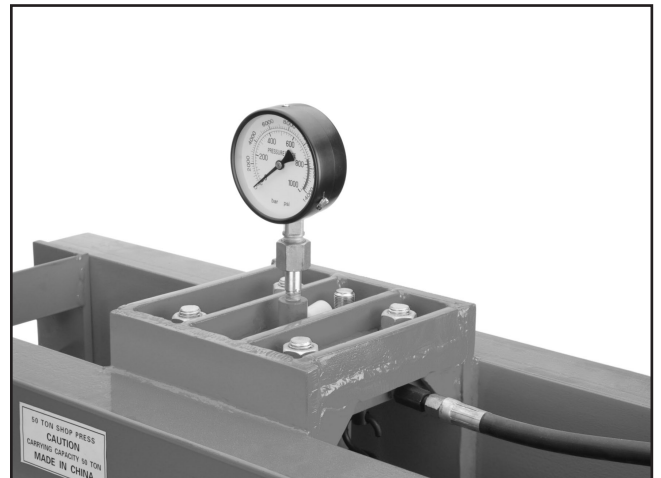
**Figure 4.** Cable connection.

5. Hold the end of the cable against the hanging part of cable and place a U-bolt around the cables. Place the cable clamp over the U-bolt and thread the hex nuts onto the ends of the U-bolt and tighten. Install the second cable clamp a few inches from the first.
6. Align the hydraulic pump with the holes in the crosspiece in the upright and secure it with M12-1.75 x 25 hex bolts, lock washers, and hex nuts (**Figure 5**).



**Figure 5.** Pump installation.

7. Coat the threads on the end of the hose with hydraulic sealant and thread it into the side of the pressure head assembly.



**Figure 6.** Hose and pressure gauge.

8. Coat the threads of the pressure gauge with hydraulic sealant and install the gauge into the top of the pressure head assembly.

# OPERATIONS

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## WARNING

**DO NOT compress springs or other objects that could be ejected from the press. DO NOT compress objects that could shatter.**



1. Raise the table so the workpiece will be close to the pressure head.
2. Place the support rods through the uprights and lower the table onto the support rods.
3. Place the table plates on the table and center the workpiece on the table plates. *Note—Place round stock in the V-grooves of the table plates.*

## WARNING

**Always center the workpiece on the table plates and center the pressure head on the workpiece to prevent injury by ejection of the workpiece.**

4. Turn the pressure release valve clockwise to tighten.
5. Place the pump handle in the right handle socket and pump until the pressure head is pushing on the workpiece. *Note—The left handle socket is for small adjustments and the right socket is for large adjustments.*
6. Place the pump handle in the left socket and pump until the desired pressure is reached.
7. Turn the pressure release valve counter-clockwise to allow the pressure head to move up and remove the work piece.



# MAINTENANCE

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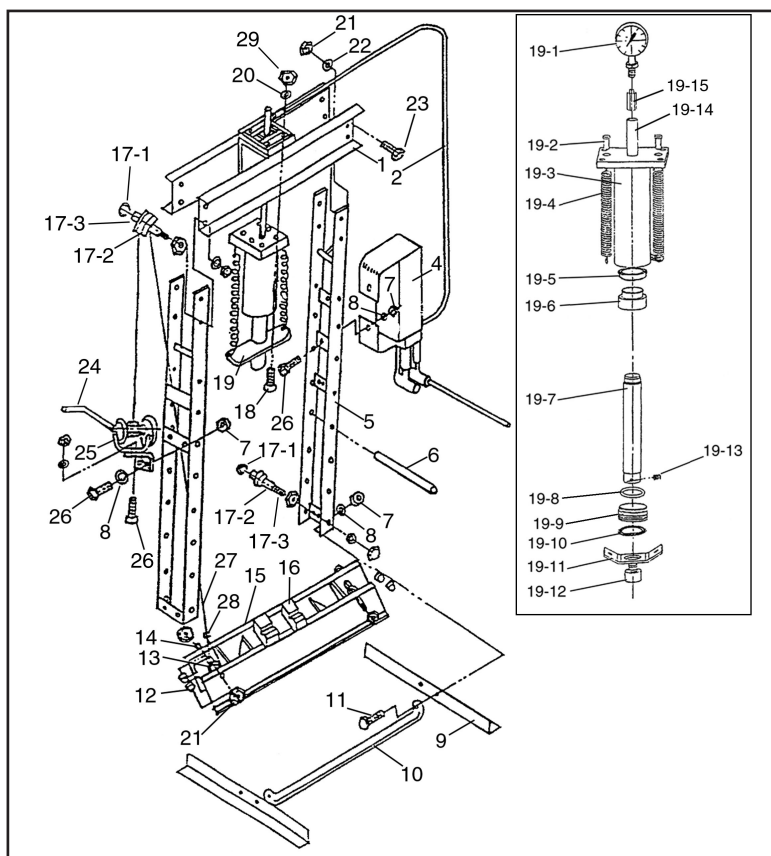
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1. Wipe all dirt and dust off the press
2. Apply light oil to the surface of the ram.
3. Check hoses, pressure head, and support rods for cracks or damage. Replace if necessary.
4. Remove the plug between the handle sockets to check hydraulic jack oil level. Add if necessary, replace the plug, then pump the handle several times with the pressure release valve open to bleed the air out of the system.

*If you need additional help with this procedure, call our service department at: (570) 546-9663.*



# PARTS



REF	PART #	DESCRIPTION
1	PH6233001	HEADER
2	PH6233002	HYDRAULIC HOSE
4	PH6233004	PUMP ASSEMBLY
5	PH6233005	UPRIGHT
6	PH6233006	SUPPORT ROD
7	PN09M	HEX NUT M12-1.75
8	PLW05M	LOCK WASHER 12MM
9	PH6233009	BASE SUPPORT
10	PH6233010	SPREADER
11	PB101M	HEX BOLT M12-1.75 X 40
12	PH6233012	SLEEVE
13	PH6233013	SLEEVE
14	PH6233014	SHAFT
15	PH6233015	TABLE
16	PH6233016	TABLE PLATE
17	PH6233017	LOWER PULLEY ASSY
17-1	PR11M	EXT RETAINING RING 25MM
17-2	PH6233017-2	PULLEY
17-3	PH6233017-3	PULLEY SHAFT
18	PH6233018	HEX BOLT M20-2.5 X 70
19	PH6233019	PRESSURE HEAD ASSY
19-1	PH6233019-1	PRESSURE GAUGE
19-2	PH6233019-2	EXTENSION SPRING BOLT
19-3	PH6233019-3	CYLINDER ASSEMBLY

REF	PART #	DESCRIPTION
19-4	PH6233019-4	EXTENSION SPRING
19-5	PH6233019-5	PISTON SEAL RING
19-6	PH6233019-6	PISTON HEAD
19-7	PH6233019-7	PISTON ROD
19-8	PH6233019-8	O-RING 8 X 70
19-9	PH6233019-9	GUIDE SLEEVE
19-10	PH6233019-10	O-RING 63 X 5
19-11	PH6233019-11	SPRING PLATE
19-12	PH6233019-12	PRESSURE HEAD
19-13	PSS16M	SET SCREW M8-1.25 X 10
19-14	PH6233019-14	EXTENSION TUBE
19-15	PH6233019-15	HYDRAULIC CONNECTOR
20	PLW07M	LOCK WASHER 20MM
21	PH6233021	HEX NUT M24-3
22	PH6233022	LOCK WASHER 24MM
23	PH6233023	HEX BOLT M24-3 X 55
24	PH6233024	WINCH HANDLE
24-1	PB09M	HEX BOLT M8-1.25 X 20
24-2	PW01M	FLAT WASHER 8MM
25	PH6233025	WINCH
26	PB25M	HEX BOLT M12-1.75 X 25
27	PH6233027	STEEL CABLE 6MM
28	PH6233028	CABLE CLAMP
29	PH6233029	HEX NUT M20-2.5

