



Horizontal Press Manual

Serial # _____

800-446-4402

www.clevelandsteeltool.com

474 E. 105th St. • Cleveland, OH 44108

Horizontal Press

Table of Contents

- 1 Company Profile, Warranty
- 2 Operator and Supervisor Information, Signal Definitions
- 3 Receiving/Unpacking/Moving
- 3 Environmental Requirements
- 4 Installation
- 4-5 Danger/Warning Panel, Maintenance
- 6 Signal Diagram

HYDRAULIC POWER SOURCES

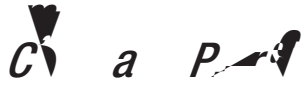
- 7 Hydraulic Accessory Tool, Porta Power

OPERATION

- 8 Operations
- 9 Operations Diagram
- 10 Set Up
- 11 Press Operations

TROUBLESHOOTING

- 12 Horizontal Press Inoperable
- 12 Rough Cylinder Operation



The Cleveland Steel Tool Company offers a full line of high quality, low maintenance hydraulic ironworking machines, associated tooling and accessories that are used in the steel fabrication industry. With proper operation, care, and maintenance, your Cleveland Steel Tool Horizontal Press will provide years of safe, trouble-free service. Please take time to study this manual carefully to fully understand Horizontal Press safety procedures, set-up, operation, care, maintenance, troubleshooting and warranty coverage prior to putting the machine into production. Any questions not answered within this manual can be directed to The Cleveland Steel Tool Company.

C E V E N

474 E. 105th St.
 Cleveland, OH 44108
 800-446-4402 ph
 216-681-7009 fx
 sales@clevelandsteeltool.com



Your Cleveland Steel Tool Horizontal Press has been serialized for quality control, product traceability and warranty enforcement. Please refer to the aluminum identification tag with the engraved serial number and electrical and power specifications when ordering parts or filing a warranty claim.

Warranty

The Cleveland Steel Tool Company will, within one (1) year of date of purchase, replace F.O.B. the factory, any goods, excluding punches, dies, and/or blades, which are defective in materials and workmanship provided that the buyer returns the defective goods, freight prepaid, to the seller, which shall be the buyer's sole and exclusive remedy for the defective goods. Hydraulic and electrical components are subject to their respective manufacturer's warranties.

The Cleveland Steel Tool Company will, within thirty (30) days of date of purchase, replace F.O.B. the factory any punches, dies, and/or blades that prove to be defective in material and workmanship.

(Proof of purchase date required)

This warranty does not apply to machines and/or components which have been altered, changed or modified in any way, or subjected to abusive and abnormal use, inadequate maintenance and lubrication, or subjected to use beyond seller recommended capacities and specifications. THIS WARRANTY IS VOID IF YOU ATTEMPT REPAIRS YOURSELF. In no event shall seller be liable for labor costs expended on such goods or consequential damages. Seller shall not be liable to the purchaser or any other person for loss, downtime, or damage directly or indirectly arising from the use of the goods or from any other cause. No officer, employee, or agent of seller is authorized to make any oral representations or warranty of fitness or to waive any of the foregoing terms of sale and none shall be binding on seller.

 **WARNING**

 **CAUTION**

This manual provides installation requirements for the Cleveland Steel Tool Horizontal Press.

All Cleveland Steel Tool hydraulic accessory tools are powered by a Cleveland Steel Tool Ironworker or a Cleveland Steel Tool Porta Power, portable hydraulic power unit.

Refer to the manual for the Cleveland Steel Tool Porta Power to operate your Cleveland Steel Tool hydraulic accessory tool. Provide operators with sufficient training and education in the basic functions of the machine prior to machine operation.

Environmental Requirements at Work Station



The work station environment for your Cleveland Steel Tool Horizontal Press must meet the following minimum requirements:

- **Ambient temperature:** 45°F - 110°F
- **Relative humidity:** No greater than 90% relative humidity.
- **Floor area:** Assure that the machinery work area provides for a stable, adequately sized and load rated floor area for material movement to and from the machinery work stations.
- **Shelter:** Protect your Ironworking machinery from water, salts and corrosive elements.
- **Lighting:** 60 Watts (500LUX or 50 footcandles) minimum.

Cleveland Steel Tool Hydraulic Accessory Tools are fully assembled and are shipped either by palletized custom wooden crate or by shrink-wrapped wooden pallet for ease of transport and receiving.

Inspect the packaging for damage and follow shipping/receiving instructions as listed on the packaging prior to receiving the tool into your facility.

When receiving your Hydraulic Accessory Tool, be prepared to safely move your machinery with a forklift rated for the following equipment weights:

Minimum Machinery Weights

Horizontal Press 1,350 lbs/612.34 kg

WARNING

Disconnect unit from power source.

Check wiring harness for loose connections or damaged control wiring.

Replace damaged control wiring as necessary. Order replacement control wiring assembly from Cleveland Steel Tool.

Check hydraulic fittings and hoses for wear or damage. Replace damaged or worn hydraulic hoses and fittings as necessary. Order replacement hydraulic components from Cleveland Steel Tool.

Check bolted connections and secure as necessary.

Check welded connections.

Check bearing surface quality.

Visually inspect die surfaces for chips or galling in the bearing surface.

Verify tooling is secure. Cleveland Steel Tool tooling is manufactured from billet steel for enhanced strength and durability. These are wearing parts that will fail over time and will require replacement. Order additional tooling through Cleveland Steel Tool. Install replacement parts according to this manual.

Clean your Horizontal Press daily. Disconnect the unit from its power source first. Do not use liquid cleaners, aerosols, abrasive pads, scouring powders or solvents such as benzene or alcohol. Clean your machine with a compressed air nozzle and soft cloth lightly moistened with a mild, water-based detergent solution. Remove filings, dirt, dust and grime from working surfaces. Ensure the surfaces are fully dry before reconnecting power.





 **DANGER**



 **WARNING**

- For Operator safety, wear personal protective equipment, clear the work zone of any tooling or debris prior



WARNING

Quality parts are dependent upon conscientious setup, operation and maintenance of your Horizontal Press. Physically review your Horizontal Press prior to any operation. Confirm all static components are tight in the assembly. Confirm all moving components are free of obstruction. Confirm all tooling and assemblies are properly seated within the assembly.

Problem

Solution

Horizontal Press Inoperable

Check accessory control switch
Check shop press male 4-pin power cable is connected to female limit switch port.

Check hand control Mil Spec male power cable is connected to female Mil Spec control port

Note: Auto Cut port will NOT power the Horizontal Press accessory.

Rough Cylinder Operation

Check Hydraulic fluid level at power source.
Check hoses for correct installation.

