Operating instructions

Hydraulic workshop press

WPP 15 E, WPP 20 E, WPP 30 E

WPP 50 E, WPP 75 E

WPP 15 E

WPP 75 E

WPP - SERIES

Imprint

Product identification

Hydraulic workshop press	Item number
WPP 15 E	6300016
WPP 20 E	6300020
WPP 30 E	6300030
WPP 50 E	6300050
WPP 75 E	6300075

Manufacturer

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Information about the operating instructions

Genuine operating instructions

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Author: RL/FL

Copyright information

Contents

1 Introduction

You have made an excellent choice in purchasing a UNICRAFT hydraulic workshop press.

Carefully read the operating instructions prior to commissioning.

They describe correct commissioning, intended use and safe as well as efficient operation and maintenance of your hydraulic workshop press.

The operating instructions form part of the hydraulic workshop press. Keep these operating instructions at the installation location of your hydraulic workshop press.

Please also note the locally applicable accident prevention regulations and general safety regulations for the use of hydraulic workshop presses.

1.1 Copyright

The contents of these operating instructions are protected by copyright. Their application is permitted within the context of the use of the hydraulic workshop press. Any further use shall not be permitted without written consent by the manufacturer.
For the protection of our products, we shall register trademark, patent and design rights, as this is possible in individual cases. We strongly oppose any infringement of our intellectual property

1.2 Customer service

Please contact your specialist retailer if you have any questions regarding your workshop press or require any technical information. Your specialist retailer will be happy to support you with specialist advice and information.

Germany:
Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt
Germany

Repair service:

Fax: 0049 (0) 951 96555-111
Email: service@stuermer-maschinen.de
Internet: www.unicraft.de

Spare parts orders:

Fax: 0049 (0) 951 96555-119
Email: ersatzteile@stuermer-maschinen.de

1.3 Limitation of liability

All data in these operating instructions has been compiled on the basis of the state-of-the-art, valid standards and guidelines as well as our many years of expertise and experience.

The manufacturer shall not be liable for damage in the following cases:

- Non-observance of these operating instructions
- Unintended use
- Deployment of untrained staff
- Conversions at one's own responsibility
- Technical modifications
- Use of unauthorised spare parts

The actual scope of delivery may deviate from the descriptions and illustrations in this document as a result of special variants, optional extras or recent, technical modifications.

The obligations defined in the supply contract shall apply in addition to the general terms and conditions and the manufacturer's general terms and conditions as well as the statutory regulations valid at the time of the conclusion of the contract.

2 Safety

This section provides an overview of all important safety packages for personal protection as well as safe and reliable operation. The sections on individual service life phases contain additional, specifically applicable safety information.

2.1 Legend of symbols

Safety instructions

Safety instructions in these operating instructions have been highlighted with symbols. Safety instructions are indicated by signal terms that express the degree of risk involved.

DANGER!

This combination of symbol and signal term indicates a directly dangerous situation which may cause death or serious injury if not averted.

WARNING!

This combination of symbol and signal term indicates potentially hazardous situations which may cause death or serious injury if not averted.

CAUTION!

This combination of symbol and signal word indicates a potentially hazardous situation which, if not avoided, could result in property damage and environmental damage.

ATTENTION!

This combination of symbol and signal term indicates a potentially hazardous situation which may cause minor or light injuries if it is not averted.

NOTE !

This combination of symbol and signal term indicates a potentially dangerous situation which may cause material damage or harm the environment if it is not averted.

Tips and recommendations

Tips and recommendations

This symbol highlights useful tips and recommendations as well as information for efficient and reliable operation.

Observe the safety information in these operating instructions to minimise the risk of personal injury as well as material damage and prevent hazardous situations.

2.2 Operator responsibility

Operators are defined as the persons who operate the machine for commercial or profit-based purposes or provide the machine to third parties for use or application and bear the legal product responsibility in terms of the protection of users, staff or third parties during operation.

Obligations of the operator:

If the machine is used for commercial purposes, operators are subject to the legal stipulations in terms of occupational safety. For this reason, the safety instructions in these operating instructions as well as the safety, accident prevention and environmental protection regulations valid at the installation location must be complied with. In this process, the following shall apply in particular:

- Operators shall obtain information about valid occupational safety regulations and determine additional hazards as part of a risk assessment which result from the specific operating conditions at the machine's installation location. Said risk assessment shall be reflected in operating instructions for machine operation.
- During the entire machine operating time operators must check whether the operating instructions they created meet current standards and adapt the operating instructions where necessary.
- Operators shall clearly manage and specify the responsibilities for installation, operation, troubleshooting, maintenance and cleaning.
- Operators must make sure that all persons handling the machine have read and understood these operating instructions. Operators must also regularly train staff and notify of the hazards.
- Operators shall provide staff with the required protective equipment and wearing the required protective equipment shall be mandatory.

Operators shall also be responsible for maintaining the machine in a technically perfect condition. For this reason, the following shall apply:

- Operators shall make sure that the maintenance intervals described in these operating instructions are complied with.
- Operators shall regularly check that the safety equipment is fully functional and complete.

2.3 Operating staff qualification

The different tasks described in these operating instructions require different levels of skills in terms of the qualifications of operating staff working with the machine.

WARNING!

Risk from inadequately qualified persons!

Inadequately qualified persons are unable to assess the risks when handling the machine, thus putting themselves and others at risk of severe or fatal injuries.

- All work must be carried out by qualified persons only.
- Keep inadequately qualified persons away from the work area.

Exclusively persons of whom it can be expected that they reliably complete assigned tasks shall be authorised to carry out any tasks. Persons whose reactions have been impaired shall not be authorized, e.g. drug users, users under the influence of alcohol or medication.

These operating instructions specify the following personal qualifications for the different tasks:

Operating staff:

Operating staff has undergone an induction by the operator about the entrusted tasks and potential hazards resulting from improper behaviour. Operating staff shall exclusively be permitted to carry out any tasks beyond operation in normal mode if this has been specified in the operating instructions and operators have explicitly entrusted operating staff with the task.

Specialist staff:

As a result of specialist training, expertise, experience and skills in terms of the relevant standards and regulations, specialist staff is able to complete the tasks they are entrusted with and independently identify hazards and avert risks.

Manufacturer:

Certain work must be carried out by manufacturer specialist staff only. Other staff is not permitted to carry out this work. Contact our customer service to have the work carried out.

2.4 Personal protective equipment

Personal protective equipment is intended to protect the health and safety of persons at work. Staff must wear the personal protective equipment indicated in individual sections of these operating instructions when carrying out the different tasks on the machine.

The personal protective equipment is described in the following section:

Protective goggles

Protective goggles are intended to protect the eyes from flying parts.

Protective gloves

Protective gloves are intended to protect the hands from components with sharp objects as well as friction, abrasion, and deep-cut injuries.

Safety shoes

Safety shoes protect feet from pinching, falling parts and slipping on slippery surfaces.

Protective clothing

Protective clothing is tight-fitting work clothing without protruding parts, usually with a low tear resistance.

2.5 Safety identifications on the workshop press

The following safety identifications have been attached to the workshop press (Fig. 1) which must be observed.

Fig. 1: Safety identifications
1 Pinching hazard for the upper limbs I
2 Safety information: read operating instructions, wear eye protection, wear protective clothing and safety shoes

Safety identifications attached to the machine must not be removed. Damaged or missing safety identifications may cause errors, personal injury and material damage. They must be replaced immediately.

If the safety identifications are not visible and comprehensible at first glance, the machine must be stopped until new safety identifications have been attached.

3 Intended use

The hydraulic workshop press is used exclusively for pressing out and pressing in bearings, bushings, shafts and bolts, as well as for stamping, bending and punching work.

Intended use also includes compliance with all the information in these instructions.

3.1 Reasonably foreseeable misuse

Any use beyond or different from the intended use is considered misuse.

Possible misuses can be:

- Modifications to the machine or accessories.
- Maintenance work on an unsecured machine.
- Failure to observe the signs of wear and damage.
- Service work by untrained or unauthorized personnel.
- Use of accessories or spare parts not approved by the manufacturer.
- Misuse of the machine.
- Operating the workshop press if the operating instructions have not been fully read and understood.
- Deliberate or careless handling of the workshop press during operation.
- The use of an incompletely assembled machine.

Misuse of the workshop press can lead to dangerous situations.

Stürmer Maschinen GmbH accepts no liability for design and technical modifications to the workshop press.

Claims of any kind for damage due to improper use are excluded.

3.2 Residual risks

Even if all safety instructions are followed and the machine is operated in accordance with the instructions, there are still residual risks which are listed below:

- There is a risk of injury to the upper limbs (e.g. hands, fingers).
- Risk of injury to the eyes from flying parts, even with protective glasses.
- Risk of injury from contact with live components.
- Risk of injury from rebounding workpiece or parts thereof.

4 Technical data

Model	WPP 15 E	WPP 20 E	WPP 30 E
Press force	15 t	20 t	30 t
Foot width x depth [mm]	700 x 560	730 x 560	795 x 700
Total height	1616 mm	1625 mm	1800 mm
Frame height	-	1519 mm	1770 mm
Inside width	500 mm	510 mm	535 mm
Work area	985 mm	912 mm	1031 mm
Piston stroke	160 mm	186,5 mm	150 mm
Operating pressure compressed air	-	-	7.5 - 8.5 bar
Air consumption approx.	-	-	200 l/min
Max. load on prism jaw	-	5 t	7.5 t
Weight	91,5 kg	105 kg	171 kg

Model	WPP 50 E	WPP 75 E
Compression force	50 t	75 t
Foot width x depth [mm]	1030 x 800	1140 x 800
Total height	1877 mm	1925 mm
Frame height	1832 mm	1840 mm
Inside width	730 mm	800 mm
Work area	1048 mm	884 mm
Piston stroke	200 mm	250 mm
Operating pressure compressed air	7.5 - 8.5 bar	7.5 - 8.5 bar
Air consumption approx.	200 l/min	200 l/min
Max. load on prism jaw	12.5 t	18.75 t
Weight	302.5 kg	451 kg

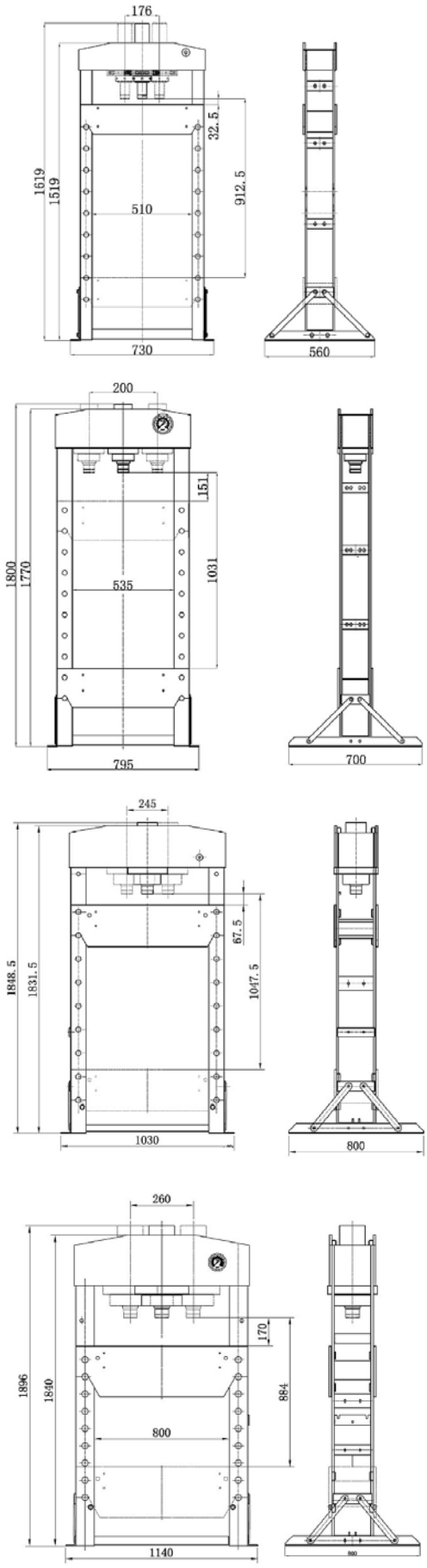

Fig. 2: Dimensions (from top to bottom): WPP 20 E, WPP 30 E, WPP 50 E, WPP 75 E

4.1 Environmental conditions

Model	WPP 15 E - 75 E
Operating temperature	-5°C to 40°C
Storage temperature	-25°C to 55°C
Transport temperatures	-25°C to 70°C (< 24 h)
Altitude range	max. 1000 m
Humidity	max. 85% relative humidity
Working environment	Non-flammable, dry and free from dust

4.2 Type plate

Fig. 3: Type plate of the WPP 75 E hydraulic workshop press

4.3 Pressure gauge

The pressure gauge used features two scales:
- Outer scale [1] shows US tons [1tn. sh.=907.18 kg]
- Inner scale [2] shows metric tons

[1 t = 1000 kg], usual throughout Europe

Fig. 4: Pressure gauge

5 Transport, packaging, storage

Delivery

Check the hydraulic workshop press for visible transport damage upon delivery. Immediately notify the haulage company or retailer if you identify damage on the hydraulic workshop press.

Transport

Improper transport is accident-prone and can cause damage or malfunctions for which we do not grant any liability or guarantee.

Transport the scope of delivery secured against shifting or tilting with a sufficiently dimensioned industrial truck to the installation site.

WARNING!

Severe or fatal injuries may occur if parts of the machine tumble or fall down from the forklift truck, pallet truck or from the transport vehicle. Follow the instructions and information on the transport box.

Note the total weight of the machine. The weight of the machine is indicated in the "Technical data" of the machine. When the machine is unpacked, the weight of the machine can also be read on the rating plate.

Only use transport devices and load suspension gear that can hold the total weight of the machine.

WARNING!

The use of unstable lifting and load suspension equipment that might break under load can cause severe injuries or even death. Check that the lifting and load suspension gear has sufficient load-bearing capacity and that it is in perfect condition.

Observe the accident prevention regulations issued by your Employers Liability Insurance Association or other competent supervisory authority, responsible for your company.

Fasten the loads properly.

General risks during internal transport

WARNING: DANGER OF TIPPING

The device may be lifted unsecured by a maximum of 2cm.

Employees must be outside the danger zone, the reach of loads.

Warn employees and, if necessary, advise employees of the hazard.

Devices may only be transported by authorized and qualified persons. Act responsibly during transport and always consider the consequences. Refrain from daring and risky actions.

Gradients and descents (e.g. driveways, ramps and the like) are particularly dangerous. If such passages are unavoidable, special caution is required.

Before starting the transport check the transport route for possible danger points, unevenness and disturban-ces as well as for sufficient strength and load capacity.

Danger points, unevenness and disturbance points must be inspected before transport. The removal of danger spots, disturbances and unevenness at the time of transport by other employees leads to considerable dangers.

Careful planning of internal transport is therefore essential.

NOTE !

Take into account the weight of the machine when transporting and lifting it. Transport and hoisting equipment must be able to carry the load.

NOTE !

Protect the machine from humidity.

The hydraulic workshop press must be transported upright only. Do not stack hydraulic workshop presses on top of each other. Do not place any other objects onto workshop presses.

Secure the upright hydraulic workshop press on a pallet using bolts. Said pallet must be correctly secured in the cargo area. Any loose parts must be securely fastened to the hydraulic workshop press, secured separately or safely stored in a separate container.

Blank metal parts have been greased to protect them from humidity and dirt.

Tips and recommendations

Make sure the corrosion protection is active or replaced (if necessary) in the event of prolonged transport.

Transport using industrial trucks/pallet trucks:

The hydraulic workshop press must be positioned on an even, stable surface (e.g. a pallet) and be secured with bolts in the event of transport using a suitably dimensioned pallet truck or industrial truck.

Packaging

All packaging materials and packing aids used for the hydraulic workshop press are suitable for recycling and must always be disposed of using material-based recycling systems.

Packaging materials made of cardboard must be shredded and disposed of as part of waste paper recycling.

The foils are made of polyethylene (PE), padding is made of polystyrene (PS). Dispose of these substances at a recycling centre or hand them over to the relevant waste disposal company.

Storage

As a rule, the hydraulic workshop press must be stored in a clean condition and a dry, clean and frost-free environment.

6 Machine description

Figures in these operating instructions may deviate from the original.

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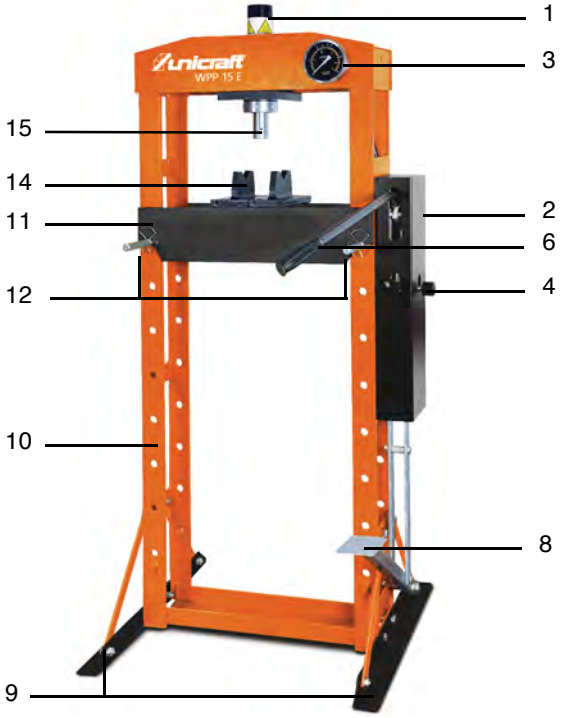
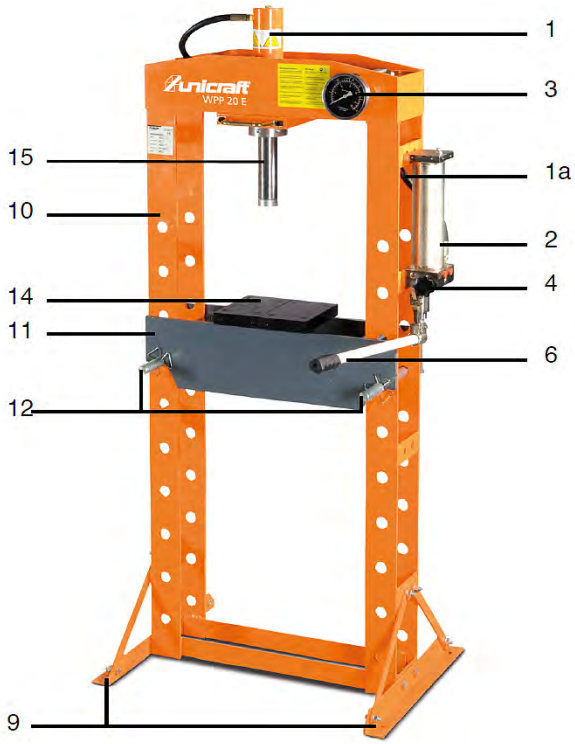
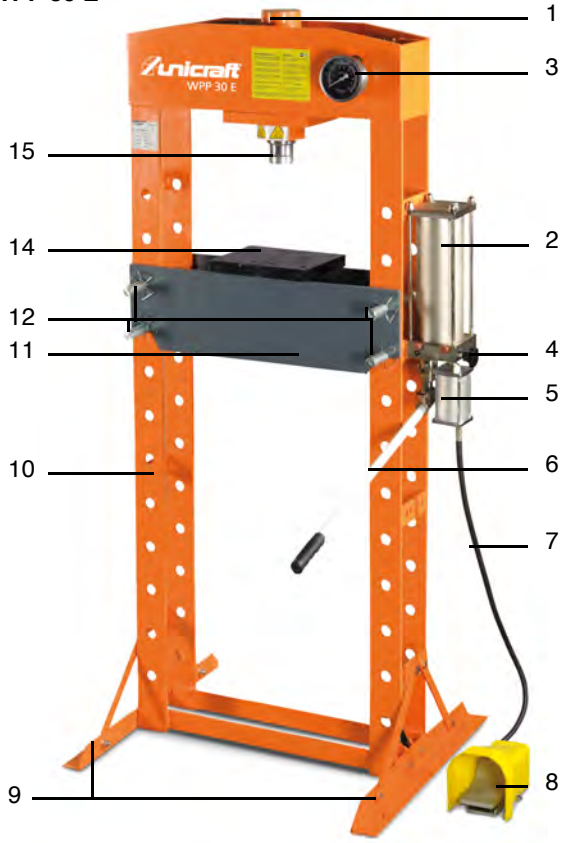


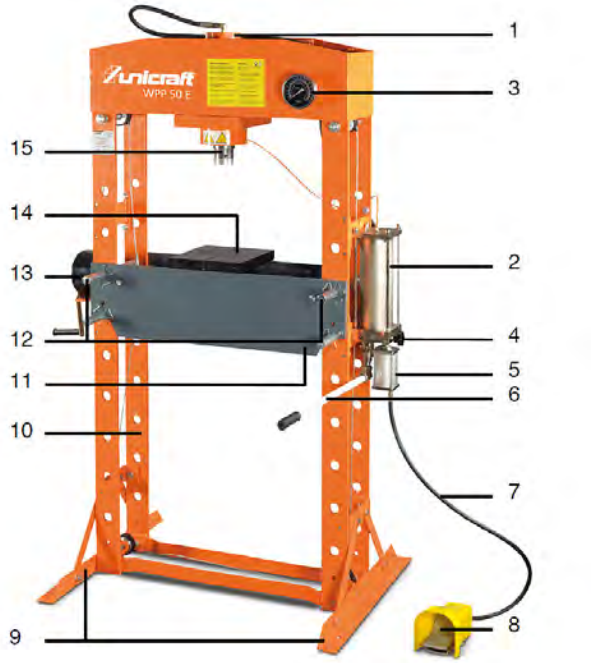
WPP 20 E



WPP 30 E



WPP 50 E



WPP 75 E

Fig. 5: WPP 15 E, 20 E, 30 E, 50 E,75 E hydraulic workshop press

1 Hydraulic cylinder

1a Connecting hose between hydraulic cylinder and manual hydraulic pump

2 Manual hydraulic pump

3 Pressure gauge

4 Switching valve to move the hydraulic cylinder up/ down

5 Pneumatic pump

6 Lever for the manual hydraulic pump

7 Air line

8 Pneumatic foot switch

9 Foot

10 Frame

11 Press table

12 Press table support bolt

13 Winch

14 Support blocks

15 Stamp

6.1 Scope of supply

- Pre-assembled hydraulic workshop press
- Support blocks
- Hydraulic pump
- Hydraulic pump lever
- Pneumatic pump
- Foot switch
- Winch
- Filling and vent plug
- Operating instructions

6.2 Accessories

- Grip guard
- Pressure barb set, suitable for WPP 15 E to WPP 75 E, with max. load 20 tons.

IMPORTANT!

Do not exceed the maximum pressure of 20 tons when using the pressure barb set.

7 Setup

The hydraulic workshop press must be set up and operated in dry, well-ventilated indoor areas only. It must be positioned securely and set up on an even, stable surface that is free from vibrations and be secured using suitable ground anchors.

Make sure there is a sufficient amount of clearance, approximately 1 m clearance on each side (see Fig. 6) and the work area is adequately lit.

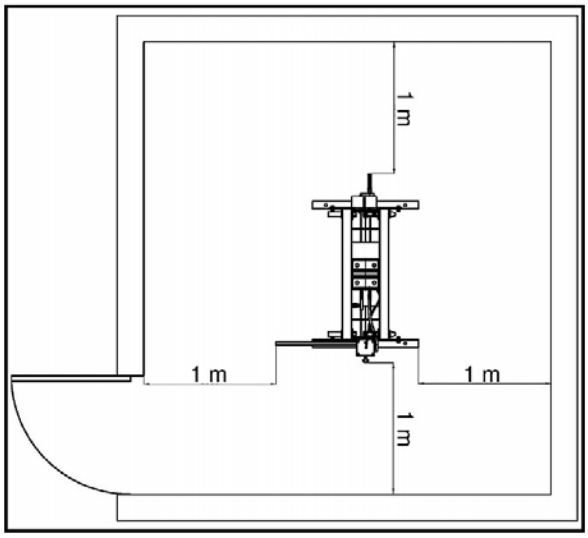


Fig. 6: Correctly set up the hydraulic workshop press

8 Installation

Wear protective gloves!

Wear safety shoes!

Wear protective clothing!

ATTENTION!

Risk of pinching!

Risk of injury to fingers and hands caused by incorrect installation work on the workshop press.

- Keep in mind the workshop press' weight. Ensure stable supports and support equipment.

The following parts of the hydraulic workshop press are provided in disassembled condition in the cardboard box or screwed to the inside of the frame (see Fig. 7):

- Crossbeam feet
- Pump unit with foot switch (WPP 20 E: no foot switch)
- Pressure gauge
- Winch (WPP 50 E and WPP 75 E model)

These parts must be assembled or converted and secured with screws.

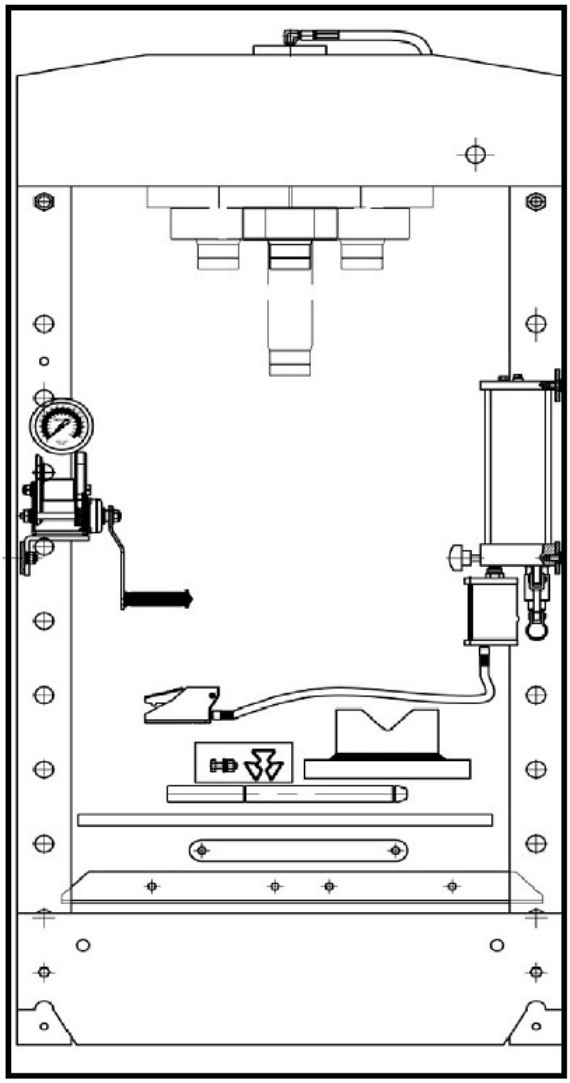


Fig. 7: WPP 75 E hydraulic workshop press (packed)

Step 1: Remove the outer and outer packaging and remove any loose parts from the packaging.

8.1 Installing crossbeam feet

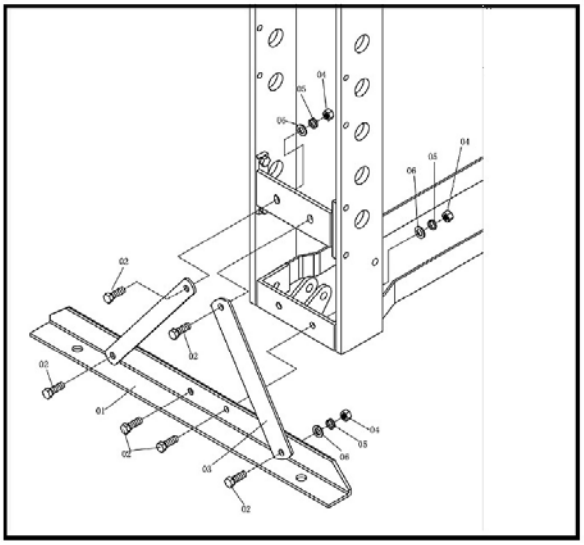


Fig. 8: Installing crossbeam feet

Step 1: secure the crossbeam feet and the two crossbeams to both sides of the frame using the screws, shims, spring washers and nuts (see Fig. 8).

8.2 Installing the pressure gauge

On delivery, a screw plug is screwed in place of the manometer, so that no oil can leak. This must be replaced with the pressure gauge.

NOTE!

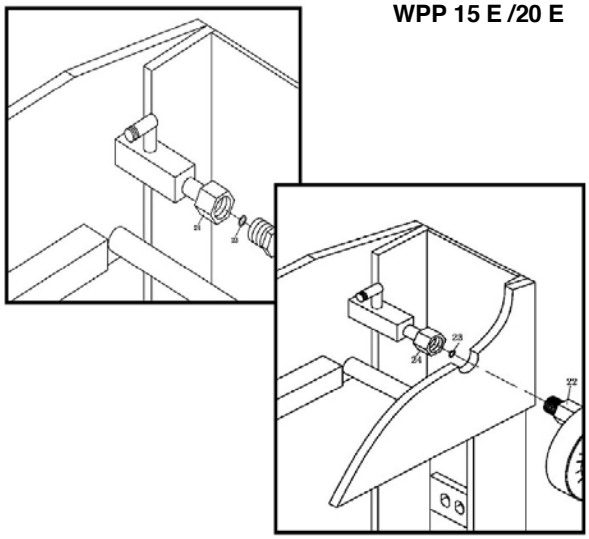
Before screwing in the manometer, make sure that you have inserted the provided sealing ring on the front of the thread.

Step 1: Remove screw plug and sealing ring.

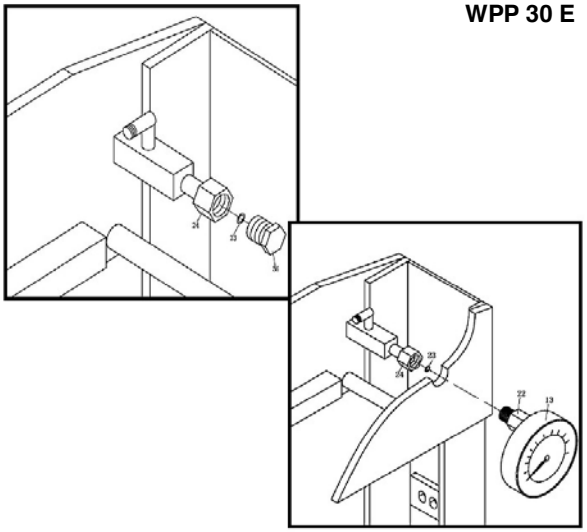
Step 2: Tighten pressure gauge and sealing ring on the distributor (see Fig. 9 and Fig. 10). The connection must be tight so that no oil can leak.

Step 3: Screw the short hose (730mm) with a straight fitting to the pressure gauge and check that the hose is not screwed twisted (see Fig. 11).

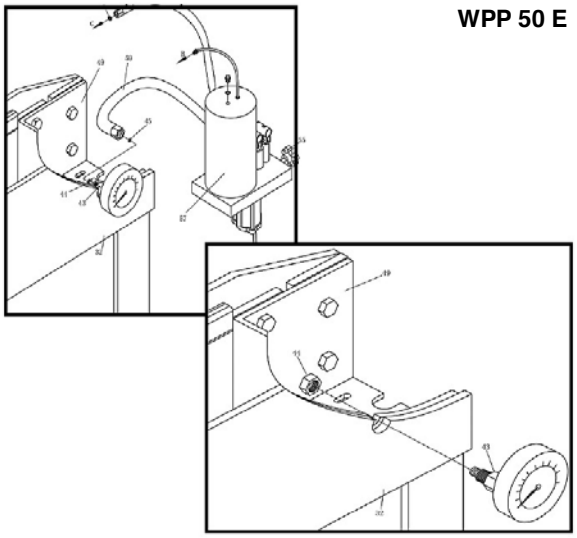
WPP 15 E /20 E



WPP 30 E



WPP 50 E



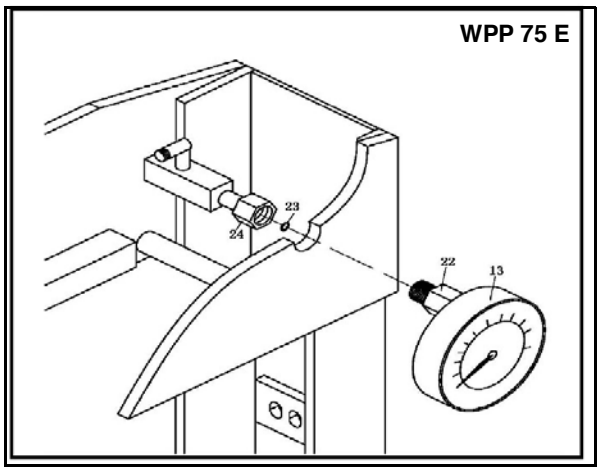


Fig. 9: Installing the pressure gauge

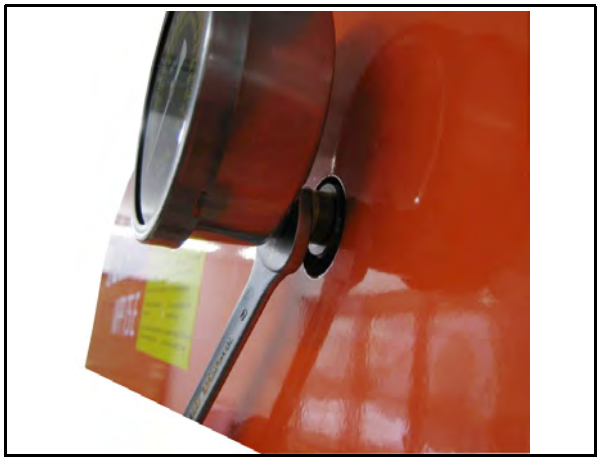


Fig. 10: Mount the pressure gauge

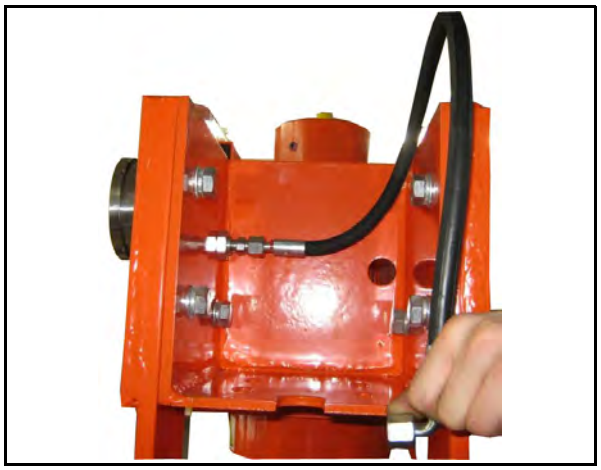
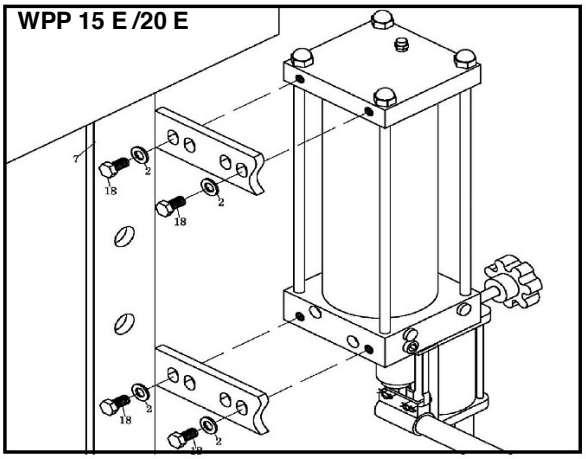
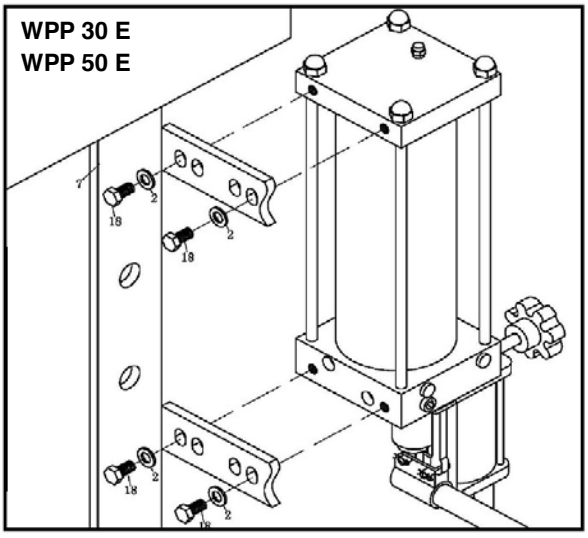
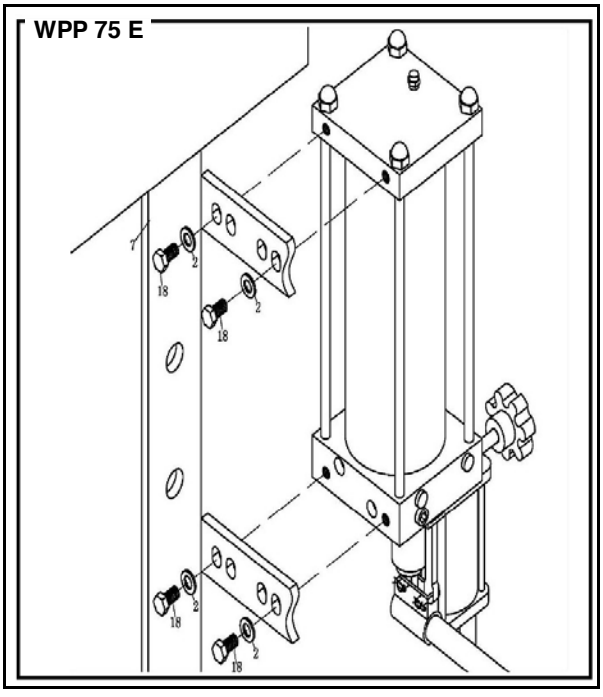


Fig. 11: Fit the hose line to the manometer

8.3 Installing the pump unit







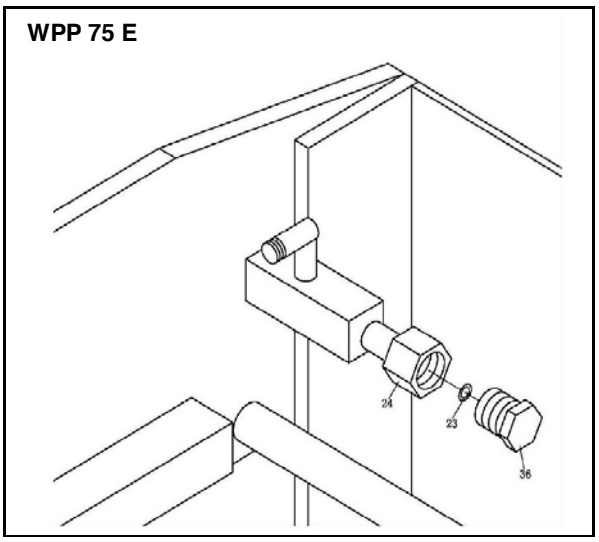


Fig. 12: Installing the pump unit

WARNING!

The hydraulic unit is heavy in design. Please assemble these with the help of a second person or with a lifting device.

Step 1: Unscrew the pump unit from the inside of the frame and turn it outwards.

Step 2: Fix the pump unit with the screws and washers on the outside of the frame (see Fig. 12).

Connect the hose to the manometer

DANGER!

Make sure that the hoses are screwed tight and not squeezed or twisted.

Step 1: Short hose line (730mm) with straight screw connection to the manometer and the 90 ° bend to the left (view from front side) screwing of the hydraulic pump unit. (see Fig. 13).

Step 2: Screw the long hose (1250 mm) with the straight screw connection to the hydraulic cylinder and the 90 ° bend on the right (view from the front) to the hydraulic pump unit (see Fig. 14).

Step 3: Screw the compressed air connection from the foot switch into the pneumatic pump. Connect the footswitch to the quick coupling with a suitable compressed air line (see Fig. 15).

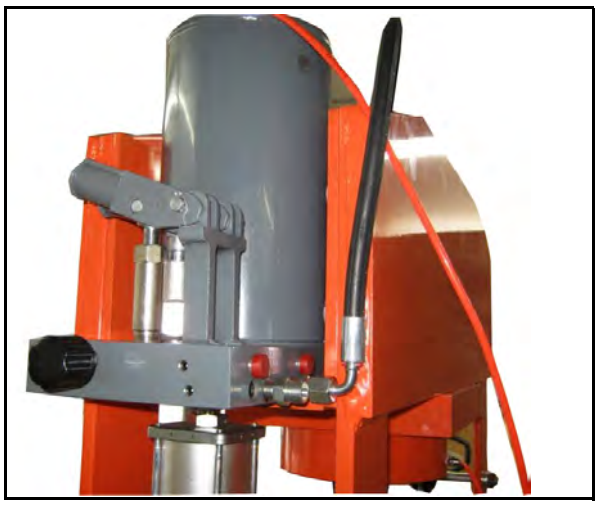


Fig. 13: Mount the short hose

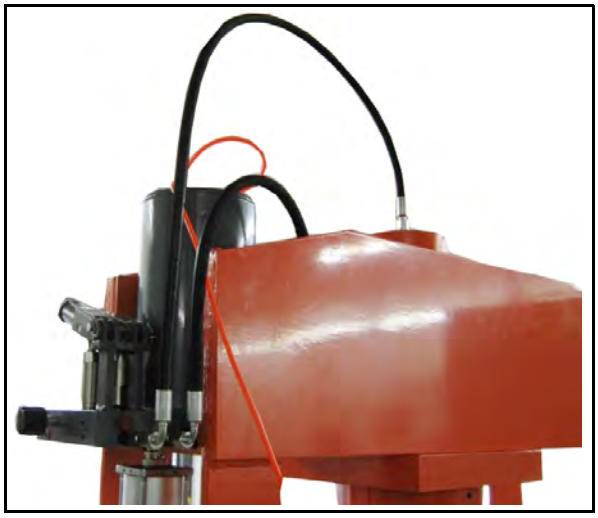


Fig. 14: Mount the long hose

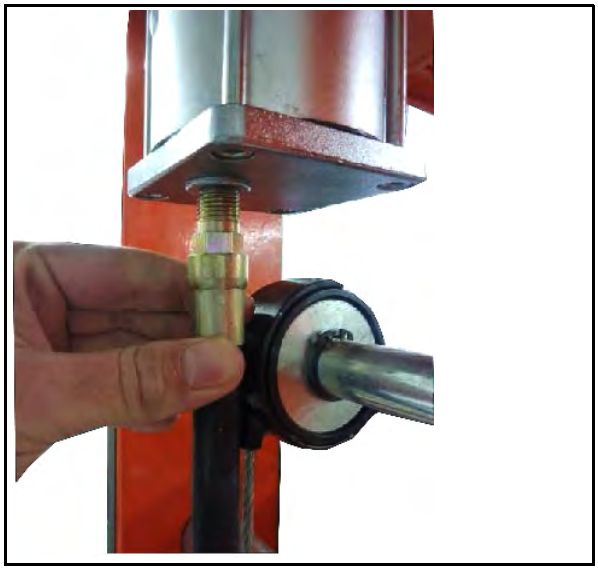


Fig. 15: Mount compressed air connection

8.4 Installing the winch

WPP 50 E and WPP 75 E models:

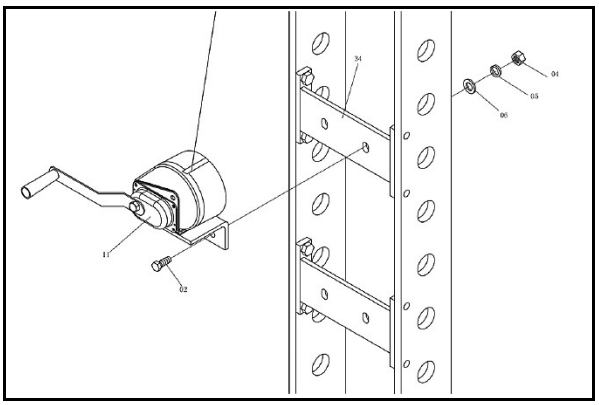


Fig. 16: Installing the winch

Step 1: Unscrew the winch from the inside of the frame and turn it outwards.

Step 2: Fasten the winch with the screws, washers and nuts on the outside of the frame (see Fig. 16).

Step 3: Check the function and tightness of the connections.

DANGER!

Before first use, the workshop press must be firmly anchored to the place of destination.

9 Before first use

Step 1: Bleed the hydraulic system by turning the diverter valve counterclockwise. Pump with the pump lever several times to remove the air from the hydraulic system. Then close the diverter valve again.

Step 2: Check all lines and connections for leaks. Check all machine parts for undamaged condition and proper function.

10 Commissioning

WARNING!

Risk of death!

Non-observance of these instructions causes a risk of death.

- Do not work on the hydraulic workshop press under the influence of alcohol, drugs or medication and/or if you are very tired or suffer from conditions impairing your concentration.
- The hydraulic workshop press must be operated by one person only. Additional persons must keep out of the work area during operation.

ATTENTION!

Risk of crushing!

Incorrectly working on the hydraulic workshop press causes a risk of injury to fingers and hands.

- Securely position the workpiece for processing on the support blocks and/or secure it to the support blocks.
- Do not reach into the operating range of the hydraulic workshop press during operation.
- Do not reach into the press and keep away from moving parts!

Wear protective goggles!

Wear safety shoes!

Wear protective clothing!

Wear ear protection!

Wearing safety gloves!

NOTE !

Carry out the following before operating the hydraulic workshop press for the first time.

- Check all screw connections on the installed, hydraulic workshop press and retighten if necessary.
- Fill the pump with hydraulic oil or top it up and seal the filler neck using the yellow, plastic vent plug.
- Remove any air from the hydraulic system.

10.1 Adjusting the table height

ATTENTION!

Risk of crushing!

Pinching may result from the press table not having been fully supported on the support bolts.

- Check the table is fully supported on the support bolts before adjusting the table height.
- Make sure the securing bolts have been installed correctly!

Adjust the correct table working height using the adjustment bolts to safely work on the hydraulic workshop press.

Step 1: Lift the press table on one side and keep it in this position.

Step 2: Pull the support bolt from the frame bore on the side the table was lifted.

Step 3: Lift the press table to the desired height or slightly above the corresponding frame bore.

Step 4: Insert the support bolt into the corresponding frame bore.

Step 5: Lower the press table onto the support bolt.

Step 6: Also carry out these steps on the second side so the table is positioned horizontally.

10.2 Setting up the work area

The work area must have been set up properly to be able to safely process the workpiece.

Step 1: position the support blocks on the press table.

Step 2: press the four pins in the support blocks down on each side so they are fully inserted in the press table.

This prevents the support blocks from slipping or tilting during processing.

10.3 Adjusting the horizontal working position

Step 1: Align the workpiece so that it is horizontal to the hydraulic cylinder.

As a result, it cannot tilt during hydraulic cylinder processing.

IMPORTANT!

Make sure the workpiece has been centred under the piston!

10.4 Aligning hydraulic cylinders

The hydraulic cylinder can be manually moved to the desired position over the workpiece. For this purpose, it can be moved towards the left or right.

IMPORTANT!

Make sure the workpiece has been centred under the piston!

10.5 Building up pump pressure

NOTE !

Monitor both the working area and the pressure gauge during pressing to exclude potential damage to the press or workpiece caused by overloads.

Step 1: insert the lever into the dedicated bush.

Step 2: move the switching valve to the right-hand position to access the hydraulic cylinder for filling.

Step 3: move the lever up and down until the stamp comes into contact with the workpiece. Fill the hydraulic cylinder with oil.

Step 4: continue to pump until the required pump pressure has built up.

IMPORTANT!

- Do not exceed the press capacity!
- Do not use extensions for the pressure lever

The pump pressure can also be built up using the pneumatic pump (if available).

For this purpose, operate the pneumatic foot switch and proceed as described for the lever until the required pressure has been built up.

10.6 Retracting hydraulic cylinders

Tips and recommendations

The manufacturer has already configured the retracting speed of the hydraulic cylinder. Modifications are required or permitted following maintenance work or repairs only. For this reason, the adjusting screw has been covered.

Step 1: move the rotary button of the switching valve to the left-hand position.

The hydraulic oil automatically returns from the cylinder back into the pump oil tank.

10.7 Mount pressure pin set

Tips and recommendations

The mandrel set includes a chuck, mandrels of various diameters, and a hex key to loosen and tighten the hexagon socket screw on the plunger of the press.

Fig. 17: Mount pressure pin set

Step 1: Unscrew the piston head with the enclosed Allen key.

Step 2: Insert the mandrel chuck into the piston chuck and tighten with the hexagon socket wrench.

Step 3: Insert the mandrel into the mandrel chuck.

10.8 Processing the workpiece

IMPORTANT!

- Make sure the securing bolts have been installed correctly!
- Make sure the workpiece has been centred under the piston!
- Do not exceed the press capacity!
- Do not use extensions for the pressure lever
- Do not reach into the press and keep away from moving parts!

Step 1: Lock the support blocks on the press table.

Step 2: Place the workpiece on the support blocks and / or fixate on it.

Step 3: Turn the control valve of the hydraulic pump clockwise until it is completely closed.

Step 4: Operate the hand pump or the foot pump. The pump starts to work and the hydraulic cylinder is lowered.

Step 5: When the hydraulic cylinder is over the workpiece, loosen the hand pump or the foot pump.

Step 6: Align the workpiece and the hydraulic cylinder.

Step 7: Operate the foot pump or hand pump to press the punch onto the workpiece. Observe the display of the manometer.

Step 8: After machining the workpiece, turn the control valve counterclockwise. The hydraulic cylinder returns to its original position / rest position.

Step 9: Remove the workpiece.

11 Maintenance and repairs

11.1 Cleaning maintenance

Keep the hydraulic workshop press clean.

IMPORTANT!

- Do not use solvent to clean plastic parts or painted surfaces. This may cause the surface to disintegrate and cause consequential damage.

Wear protective gloves!

NOTE!

Do not use sharp cleaning tools for any cleaning. This may cause damage or destroy the machine.

Clean all plastic parts and painted surfaces with a soft, moist close and some neutral cleaning agent.

Remove any excess lubricant or escaped oil using a clean and lint-free cloth.

We recommend to have specialist staff clean and check the hydraulic workshop press at minimum once a year.

11.2 Maintenance and repairs

Maintenance and repairs must be carried out by specialist staff only.

If the hydraulic workshop press is not operating correctly, contact a specialist retailer or our customer service. The contact details are listed in section 1.2 Customer service.

All protective and safety equipment must be immediately reinstalled after having completed repair and maintenance work.

An authorised person must check the hydraulic pipes and connections once a year. In the event of increased usage periods, frequent or increased pressure pulses or severe external influences the machine must be checked once every six months.

The hydraulic pipes must be replaced after an operating period of six years. In the event of increased usage periods and stricter requirements pipes must be replaced every two years.

11.2.1 Change the oil

Drain oil:

Step 1: Open the fitting on the retracted hydraulic cylinder.

Step 2: Pump out the hydraulic oil and collect in a suitable container at the end of the pipe.

NOTE!

The extracted oil must be disposed of separately. Information about this is provided by the lubricant manufacturer.

Refill oil:

Step 1: Retract the piston so that it is in the rest position.

Step 2: Add new oil through the filler hole.

Step 3: Bleed the hydraulic system by turning the diverter valve counterclockwise. Pump with the pump lever several times to remove the air from the hydraulic system. Then close the diverter valve again.

11.2.2 Visual inspection

Maintenance intervals and operating hours	Maintenance point
Daily	Visual inspection of the hydraulic workshop press for dirt, clean if necessary
Weekly	Visual inspection of the hydraulic workshop press, in particular the press table and support bolts: if necessary, replace damaged components or request repairs
Weekly	Visual inspection of the hydraulic workshop press, in particular the functions of the hydraulic components and checking for oil leaks (pump, hoses, cylinders, pressure gauge, etc.): If necessary, replace damaged components
200 operating hours	Functional inspection of the entire hydraulic workshop press to verify the machine completes all steps and operates correctly and safely: If necessary, request repairs
Annually	Have the hydraulic pipes and connections checked by an authorised person. In the event of increased usage periods, frequent or increased pressure pulses or severe external influences the machine must be checked once every six months. If necessary, have damaged pipes replaced.

11.2.3 Maintenance tasks

Maintenance intervals and operating hours	Maintenance task
200 operating hours	Lubricate the hydraulic workshop press.
300 operating hours	Change the hydraulic oil.
When necessary	Top up hydraulic oil.
6 years	Have hydraulic lines replaced. Every two years in the event of increased usage periods.

11.2.4Recommended processing materials

Processing material	Specification	Manufacturer/type (non-binding recommendation)	Quantity
Hydraulic oil	ISO 32 Viscosity from 22 to 25 mm²/s	OMV HYDRAL 32	
Grease	SO XM 2	OMV SIGNUM M 283	As required

11.2.5 Lubrication

Machine component	Lubrication point	Lubrication medium
Manual hydraulic pump	Stamp Shaft on the switching valve	Grease: For lubrication, the grease should be applied to the listed components by means of a greased brush. Excess grease should be removed with a dry and lint-free cloth

12 Disposal, reusing used machines

In your own interest and to protect the environment make sure that all machine components are exclusively disposed of in as intended and permitted.

12.1 Decommissioning

Disused machines must be decommissioned immediately to prevent misuse at a later point and putting the environment or persons at risk.

Step 1: Remove all environmentally hazardous processing materials from the used machine.

Step 2: If necessary, disassemble the machine into assemblies and components that are easy to handle and suitable for recycling.

Step 3: The machine components and processing materials must be disposed of using the intended disposal methods.

12.2 Disposing of lubricants

Lubricant manufacturers provide disposal information for the lubricants used. If necessary, request product-specific data sheets.

13 Spare parts

DANGER!

Risk of injury caused by the use of incorrect spare parts!

The use of incorrect or faulty spare parts may cause risks for operating staff and damage as well as malfunctions.

- Exclusively genuine spare parts made by the manufacturer or spare parts authorised by the manufacturer shall be used.
- Always contact the manufacturer if you are unsure.

Tips and recommendations

The manufacturer warranty shall be rendered void in the event of a use of unauthorised spare parts.

13.1 Spare parts orders

Spare parts are available from authorised retailers.

The following key data is required for queries or spare parts orders:

- Device type
- Item number
- Spare parts drawing number
- Position number
- Year of manufacture
- Quantity
- Desired shipping type (post, freight, sea, air, express)
- Shipping address

Spare parts orders without the aforementioned data cannot be taken into account. The supplier shall determine the shipping type if no relevant data was provided.

Data on the machine type, item number and year of manufacture is listed on the type plate attached to the workshop press.

Example

The pressure gauge for the workshop press WPP 75 E must be ordered. The pressure gauge has the number 50 in the spare parts drawing 5.

By ordering spare parts, send a copy of the spare parts drawing (5) with the marked part (pressure gauge) and marked positon number (50) to the dealer or spare parts department and provide the following information:

- Machine type: **Workshop press WPP 75 E**
- Item number: **630 0075**
- Drawing number: **5**
- Position number: **50**

13.2 Spare parts drawings

The following drawings are intended to identify the required spare parts in the event of service. If applicable, submit a copy of the parts drawing including the highlighted components to your authorised retailer.

WPP 15 E

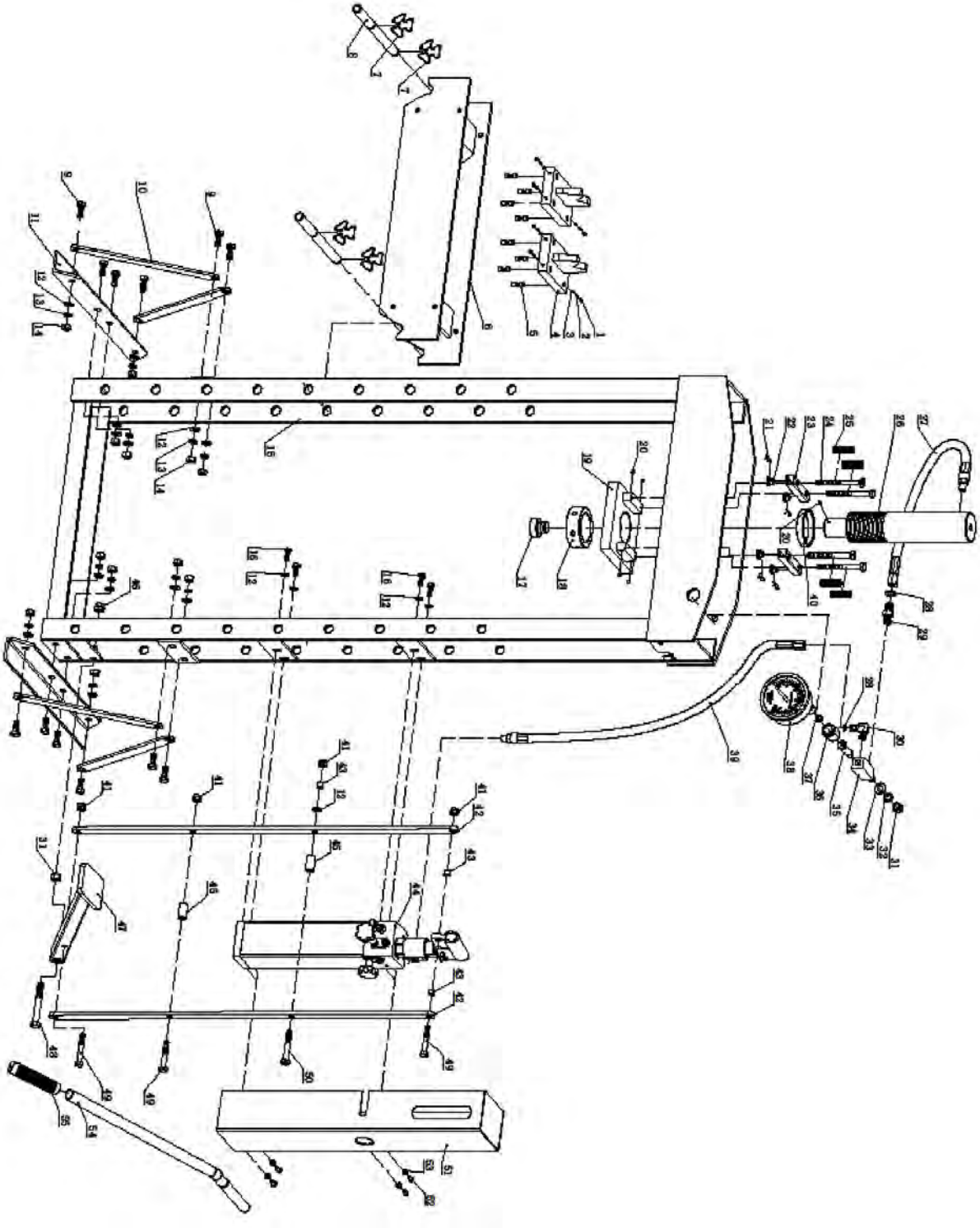


Fig. 18: Spare parts drawing 1 WPP 15 E

WPP 20 E

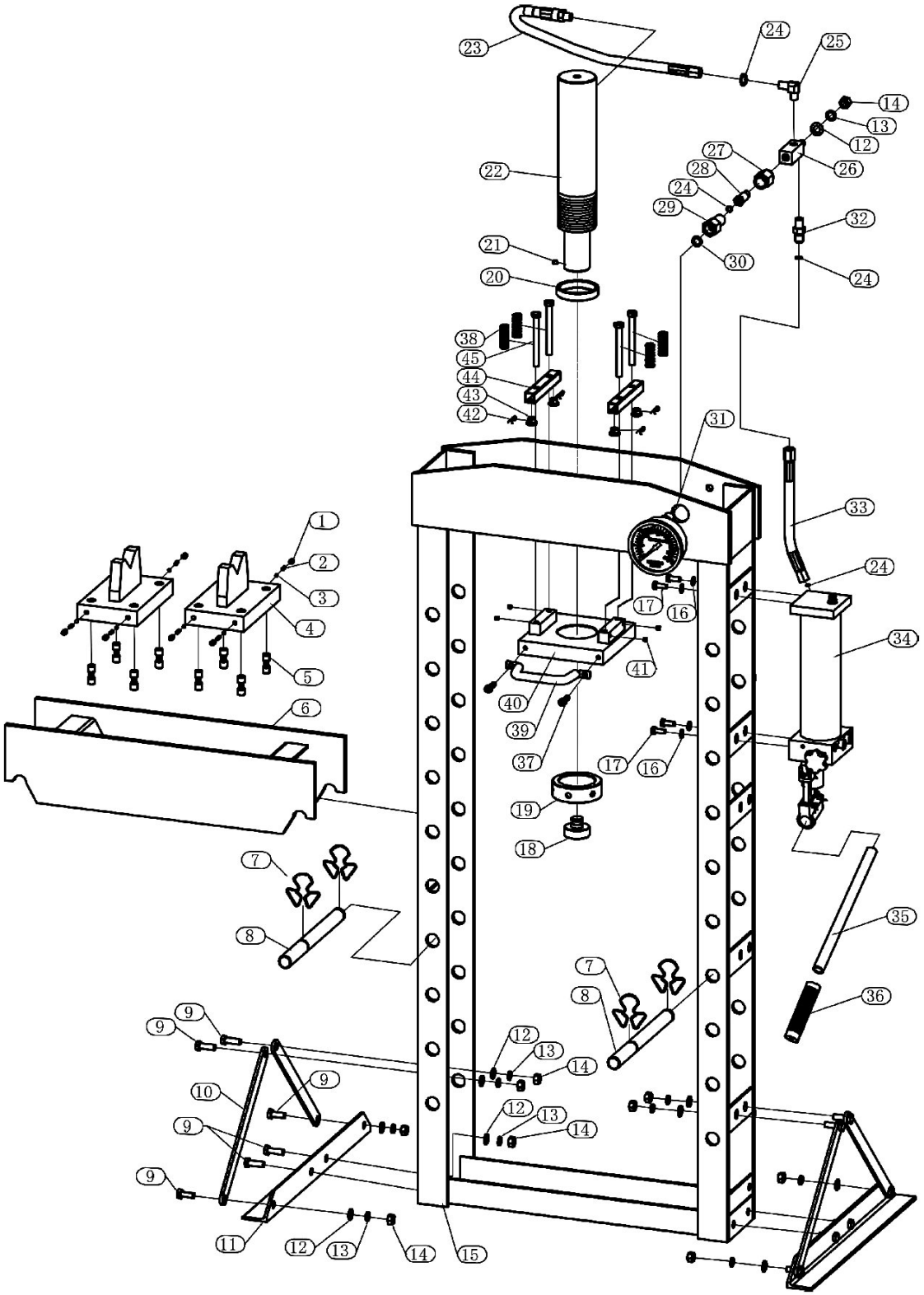


Fig. 19: Spare parts drawing 2 WPP 20 E

WPP 30 E

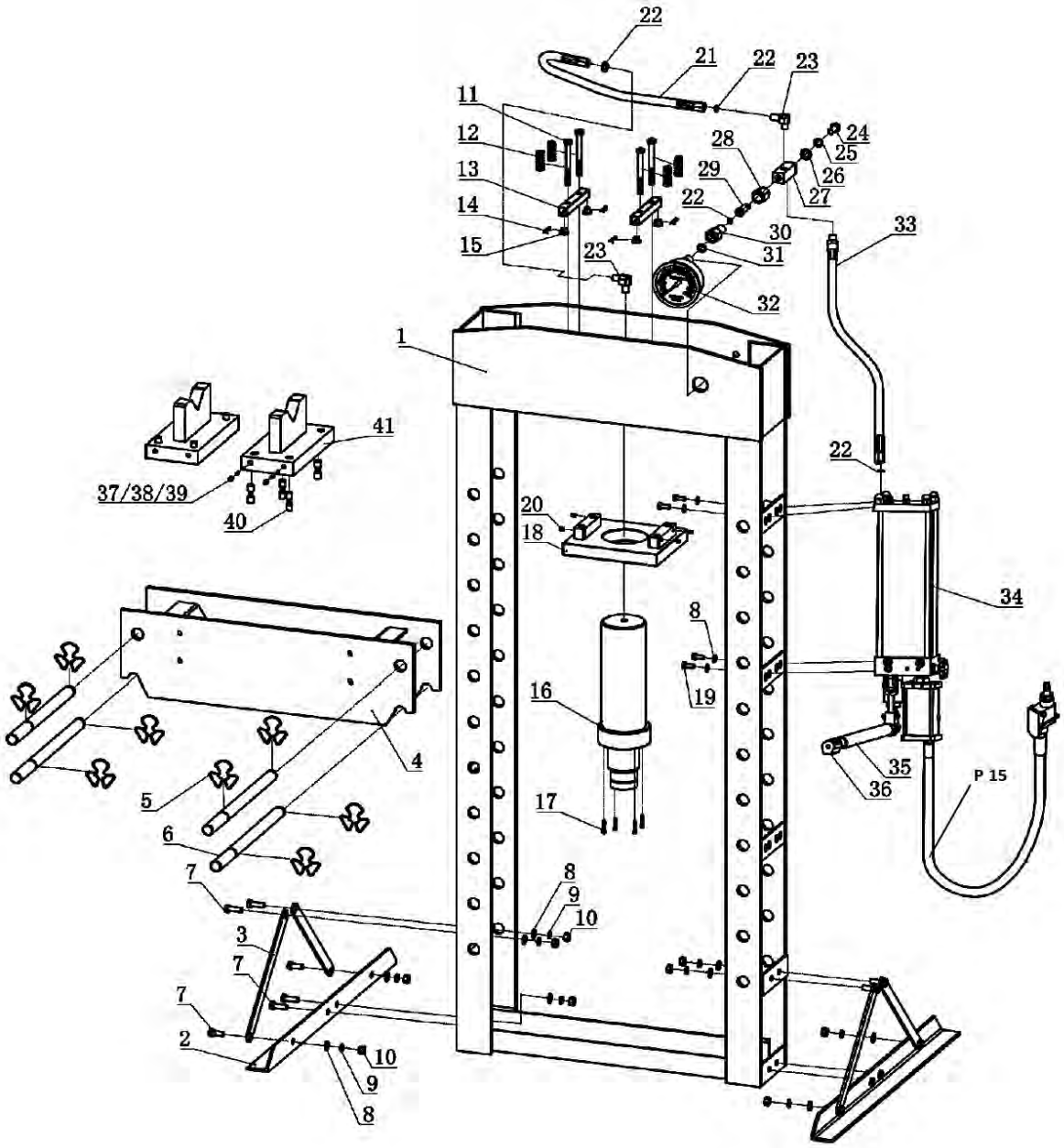


Fig. 20: Spare parts drawing 3 WPP 30 E

WPP 50 E

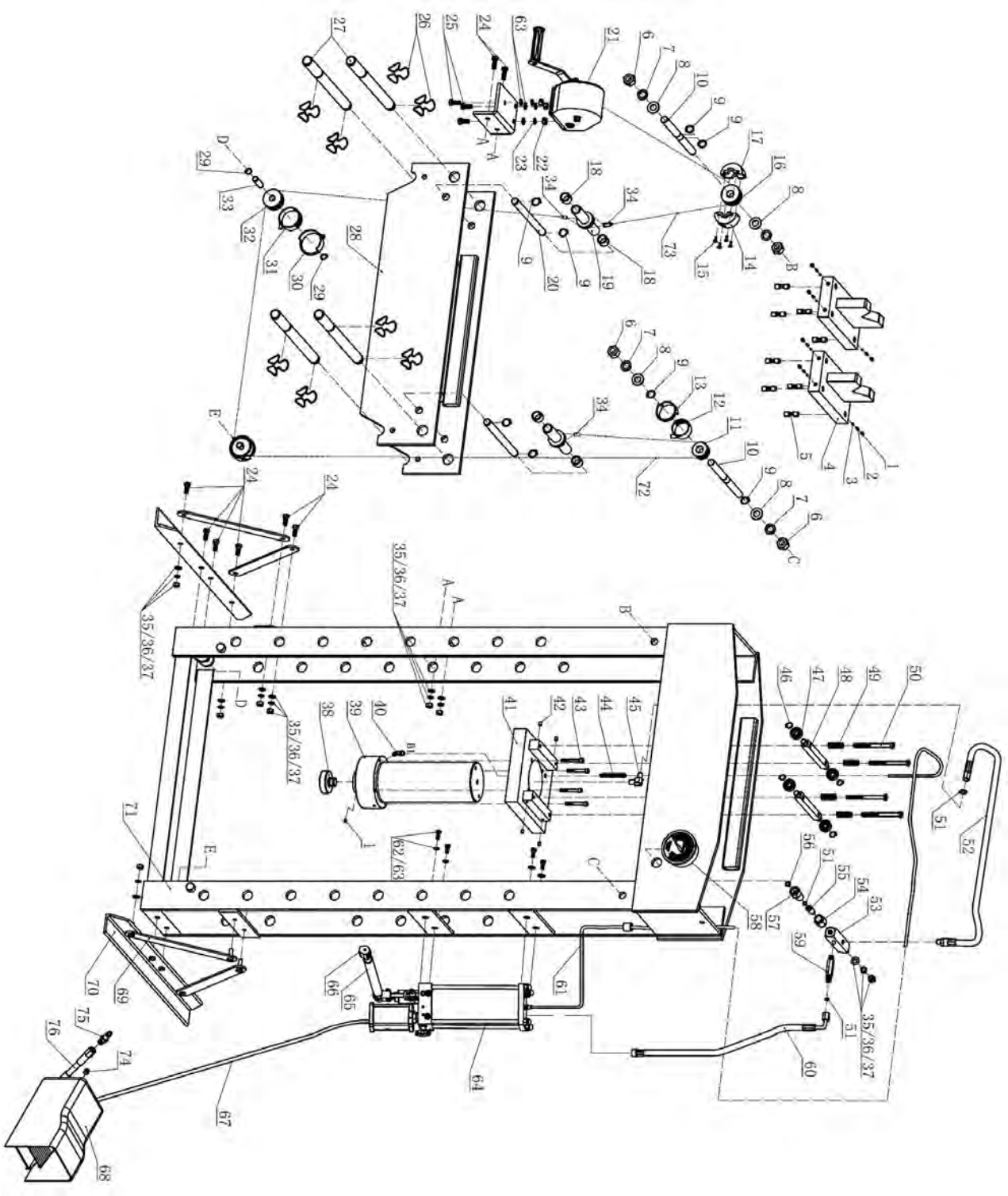


Fig. 21: Spare parts drawing 4 WPP 50 E

WPP 75 E

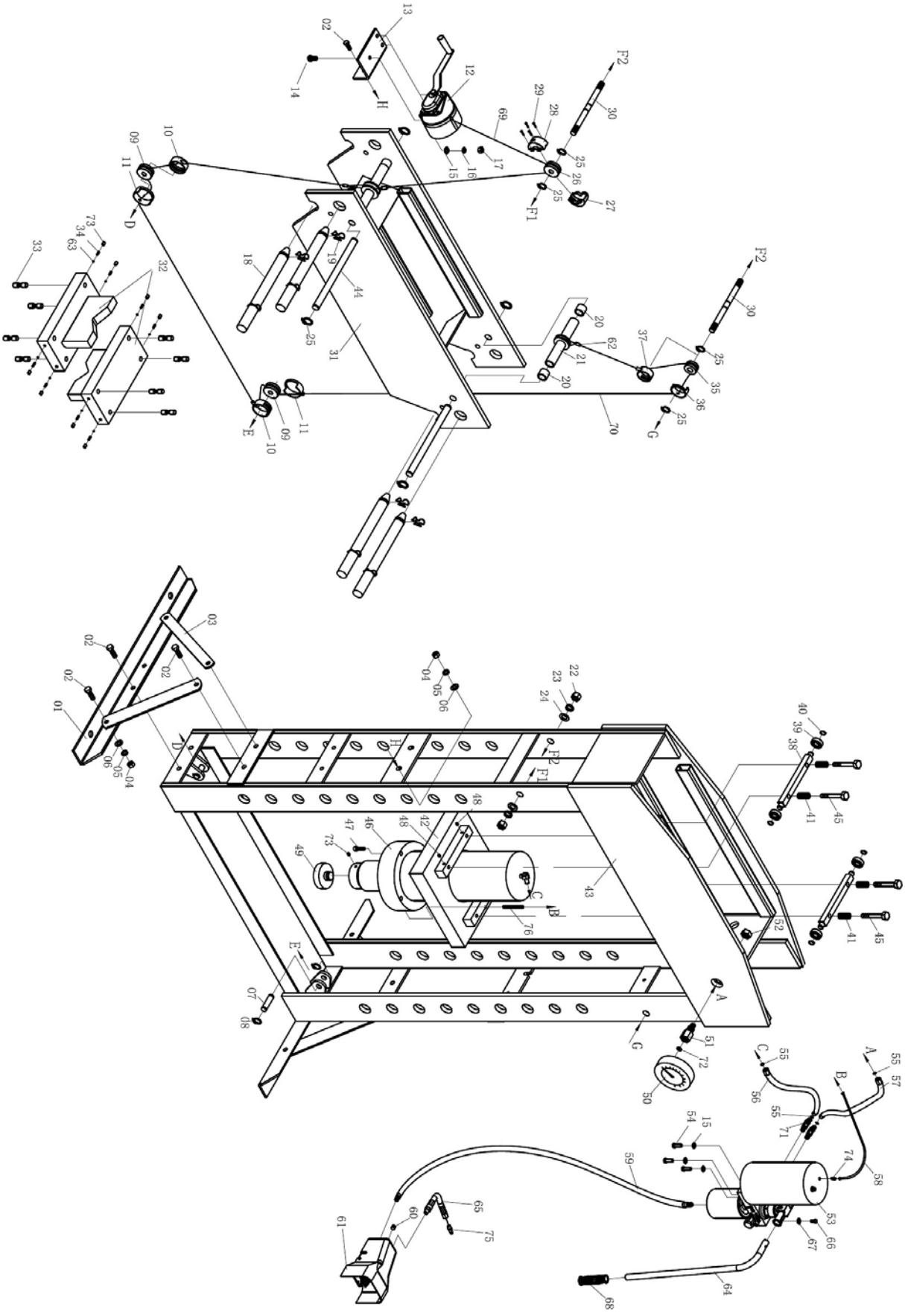


Fig. 22: Spare parts drawing 5 WPP 75 E

Spare parts Drawings Hydraulic cylinder:

WPP 20

WPP 30 E

WPP 15 E

Pump
WPP 50 E

WPP 50 E
WPP 75 E

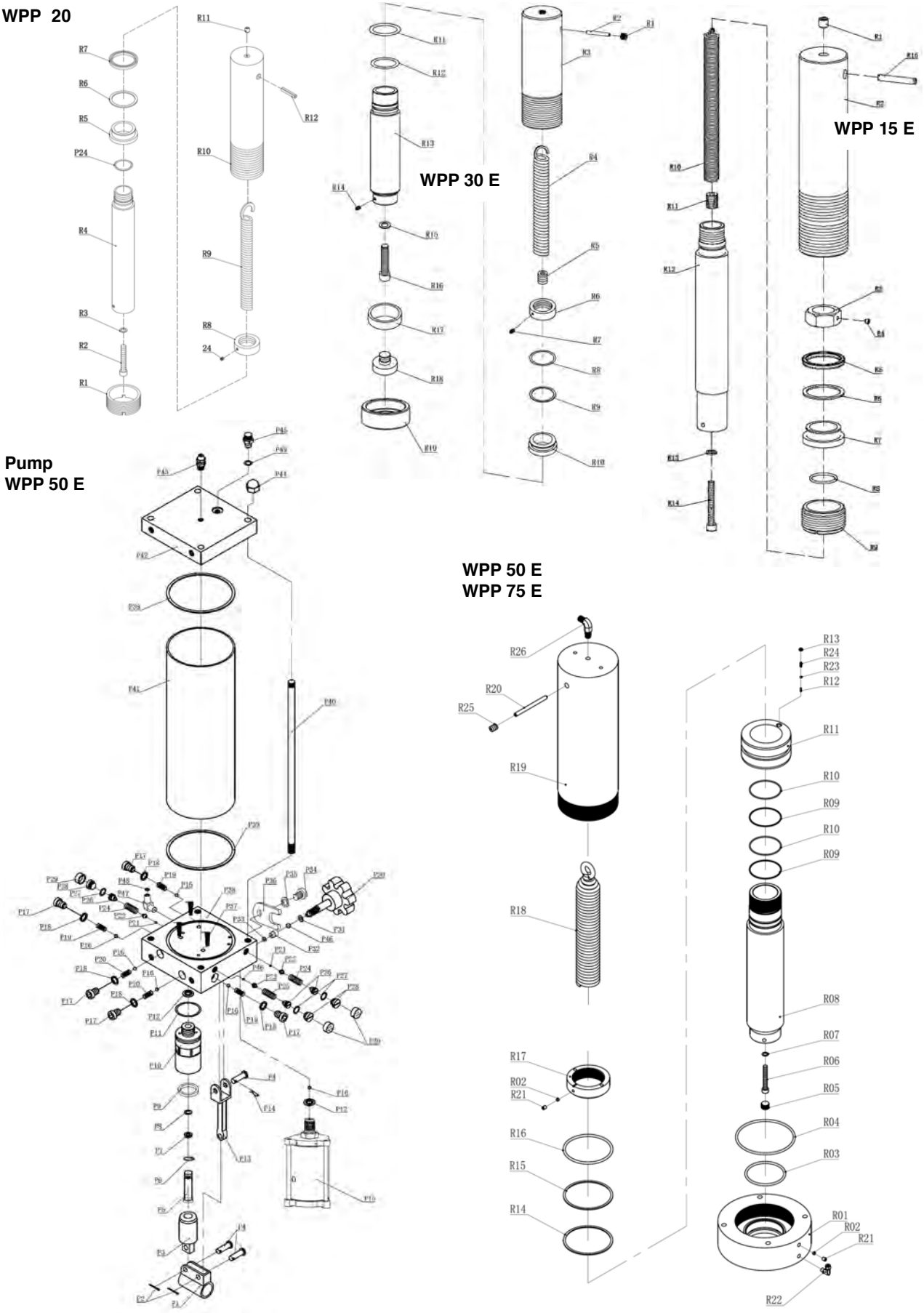
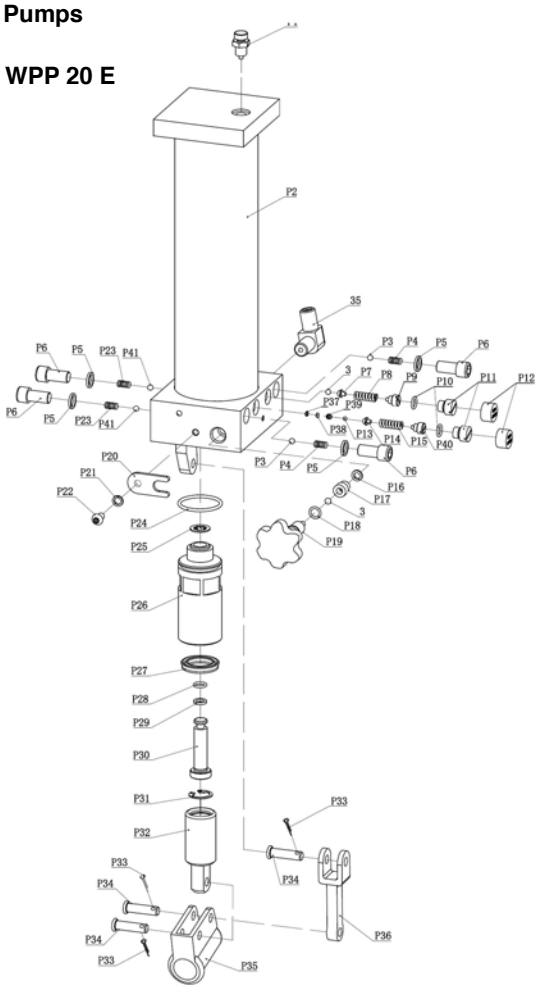


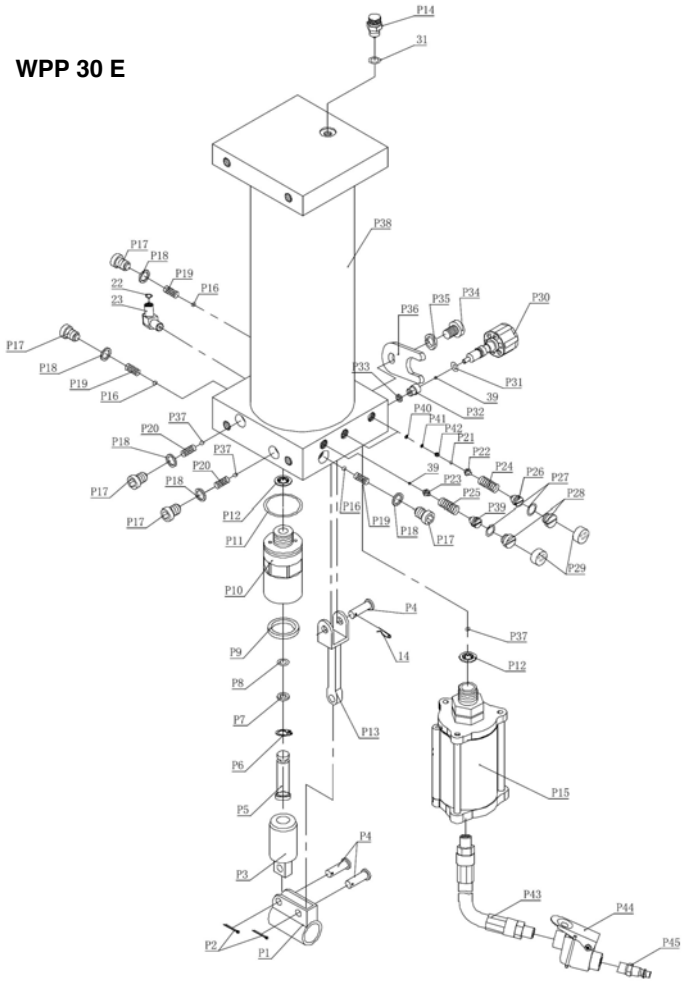
Fig. 23: Cylinders of the WPP 20 E hydraulic workshop press (top left), WPP 30 E (top center), WPP 15 E (top right), WPP 50 E and WPP 75 E (bottom right). Pump Drawing for the WPP 50 E (bottom left)

Pumps

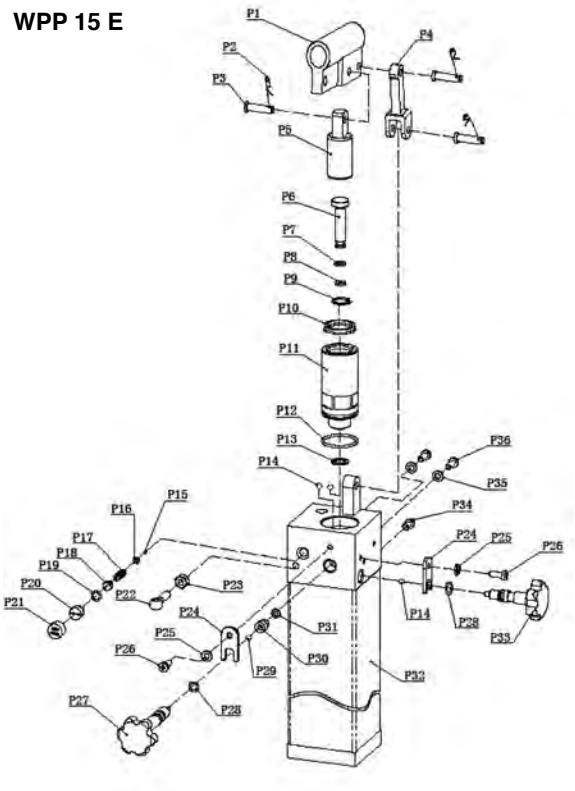
WPP 20 E



WPP 30 E



WPP 15 E



WPP 75 E

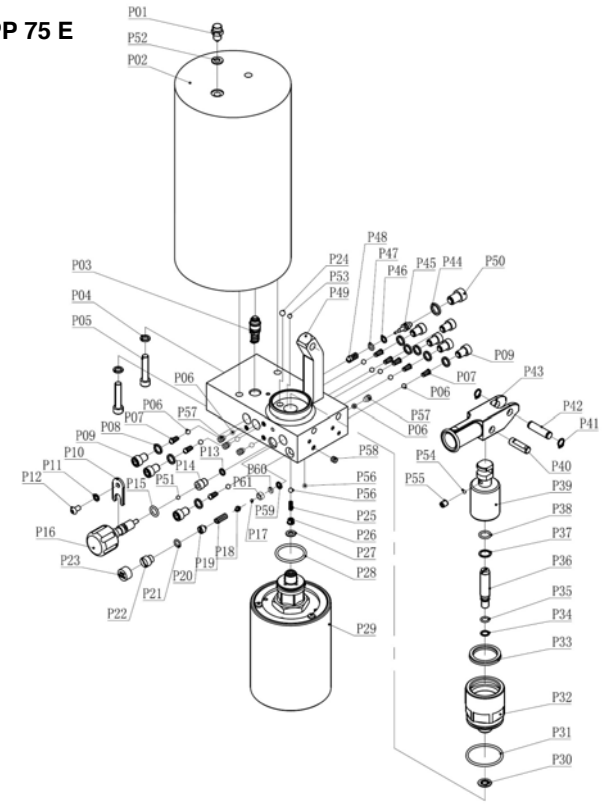


Fig. 24: Cylinder of hydraulic workshop press WPP 15 E (top left), WPP 30 E (top right); drawing pump bottom WPP 15 E (bottom left) and WPP 75 E (bottom right)

14 Hydraulics circuit diagrams

WPP 15 E

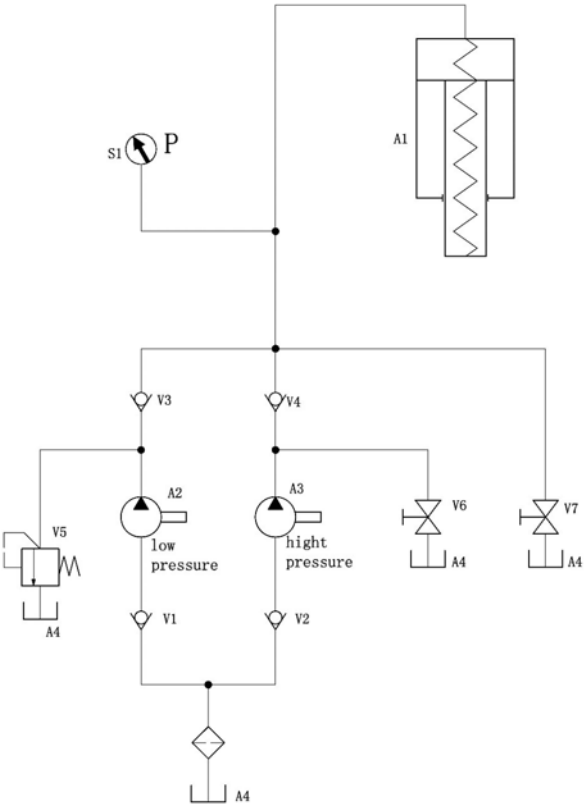


Fig. 25: Hydraulics circuit diagram WPP 15 E

WPP 20 E

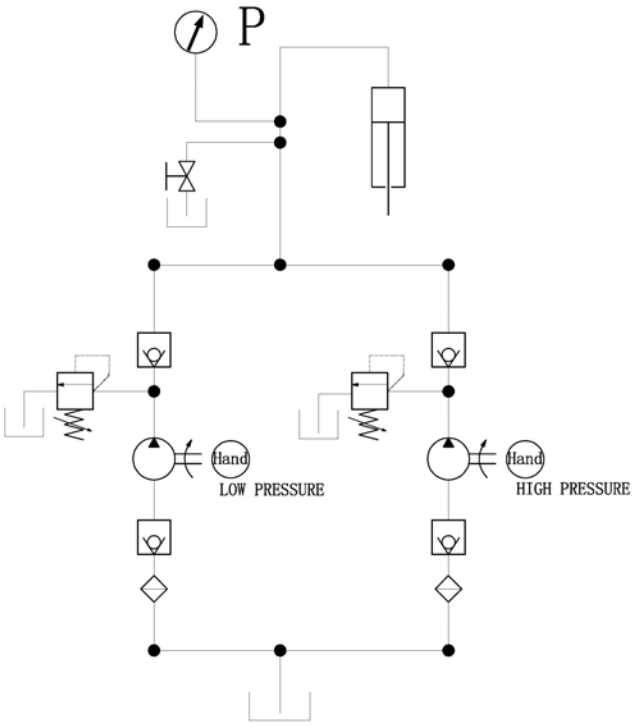


Fig. 26: Hydraulics circuit diagram WPP 20 E

WPP 30 E and 50 E

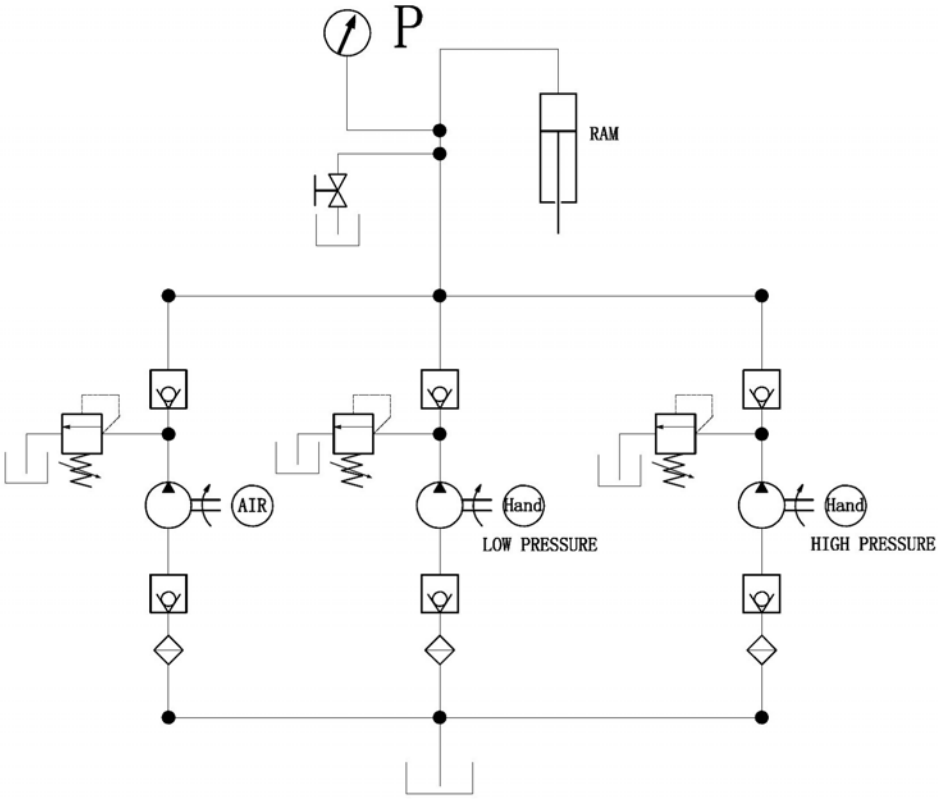


Fig. 27: Hydraulics circuit diagram WPP 30 E, WPP 50 E

WPP 75 E

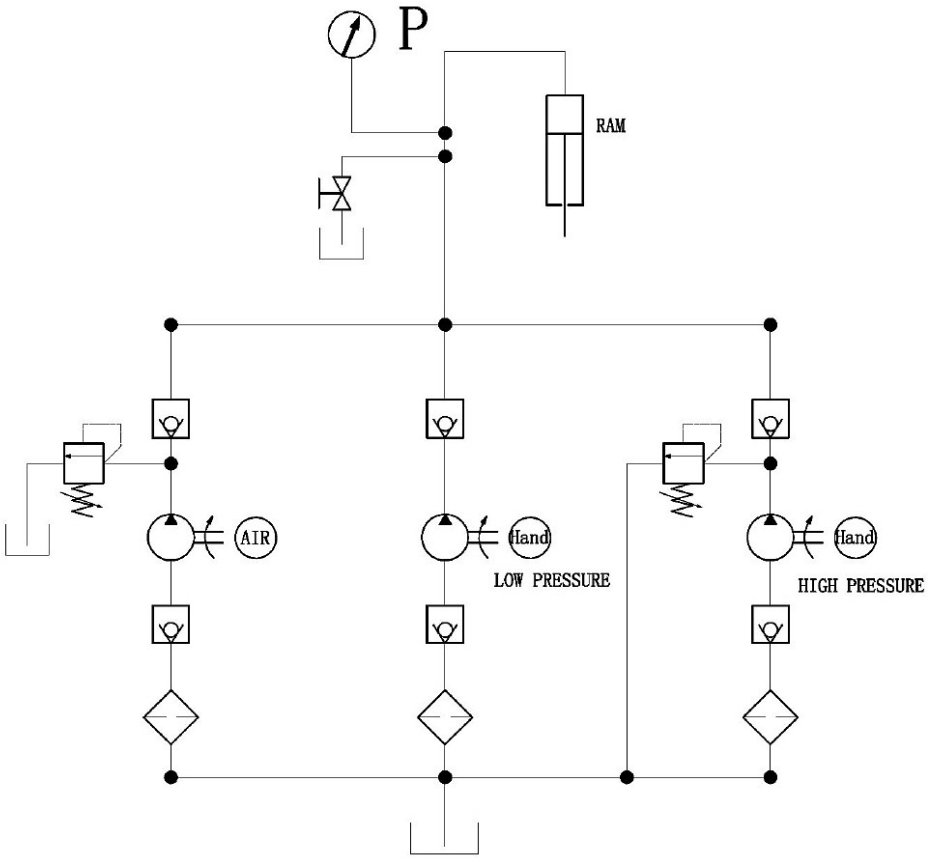


Fig. 28: Hydraulics circuit diagram WPP 75 E

15 EC Declaration of Conformity

As per machine directive 2006/42/EC, Annex II 1.A

Manufacturer/seller: Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt
Germany

hereby declares that the following product

Product group: Unicraft® Werkstatttechnik

Machine type: Hydraulic workshop press

Machine designation*:

- ☐ WPP 15 E 6300016
- ☐ WPP 20 E 6300020
- ☐ WPP 30 E 6300030
- ☐ WPP 50 E 6300050
- ☐ WPP 75 E 6300075

Serial number*: _____

Year of manufacture*: 20___

* Fill in these fields appended to the tasks on the type plate

complies with all relevant provisions of the aforementioned Directive, including any amendments thereto in force at the date of the declaration.

The following, harmonised standards have been applied:

DIN EN ISO 16092-1:2019-08	Werkzeugmaschinen-Sicherheit - Pressen - Teil 1: Allgemeine Sicherheitsanforderungen
DIN EN ISO 16092-3:2019-08	Werkzeugmaschinen-Sicherheit - Pressen - Teil 3: Sicherheits-anforderungen für hydraulische Pressen

Responsible for documentation: Kilian Stürmer, Stürmer Maschinen GmbH,
Dr.-Robert-Pfleger-Str. 26, D-96103 Hallstadt

Hallstadt, 16.01.2023

_____
Kilian Stürmer
General Manager

CE

16 Maintenance Schedule

	Maintenance Schedule							WPP			
Daily	40 h	200 h	200 h	300 h	If necessary	Yearly	6 Years				
Visual inspection press clean if necessary	Visual inspection, press table and bearing bolts	Grease the Workshop Press	Function test Prese repair if necessary	Change hydraulic oil	Vent the hydraulic system Add hydraulic oil	Check hydraulic hose and connections	Change the hydraulic hose	Date	Operating hours	Employee	Signature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