

HYDRAULIC HORIZONTAL PRESS MACHINE

USER'S MANUAL



WARNING

Read the instructions before starting to use the machine in order to ensure the safety is guaranteed.

The press should only be used by competent and qualified personnel who have completed the orientation training, know the equipment and read this manual.

You should contact with HANSTAHL Machinery for all your inquiries.

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1)INTRODUCTION

The purpose of this manual is to provide the knowledge required for the use and maintenance of the Hydraulic Horizontal Press and create a sense of the responsibility and an understanding of the capabilities of the equipment given to the operator.

2)INTENDED USE AND WARRANTY

This Press is used for bending metal parts. Any use other than this purpose and materials is deemed illegal.

If used in this way, all responsibility, damage and loss will belong to the user.

The safety equipment used for this Press is to prevent possible occupational accident, and their removal from the unit, replacement or deactivation may cause a work accident in this case, all responsibility, damage and loss will belong to the user.

We have 1 (one) year warranty for mechanical, hydraulic and electrical materials caused by manufacturing defects. Malfunctions resulting from user error or using the Press not in accordance with the manual will be excluded from the scope of warranty.

3.SECURITY

3.1. SAFETY RULES

- Read the machine user manual carefully before operating the press.
- Pay attention to the warning signs on the press.
- Only trained operators should use this press.
- In the operator training, information should be given about risks that may arise from the use of the press and the measures to be taken.
- The user must also be trained on protection systems and safety parts and periodic checks of these parts.
- The user must never leave the press running.
- The press is designed to be used by one person at most.
- This press is built to provide not only a high degree of safety, but also a high level of efficiency.
- The manufacturer is not responsible for any damages that may arise from corrections made on the press.
- Do not use this press if you are under the influence of alcohol, drugs or medication.

3.2. PERSONAL SAFETY

- Before operating the press, the usage and maintenance manual must be read. Your eyes are the best security tool. Please carefully look at the equipment before using the press.
- Experience shows that there are many objects on the person that can cause injuries: remove your rings, watch, bracelets, button up the buttons on your arm tightly, remove your clothes such as ties, threads that can get stuck in tight places, collect your hair (under a cap or with an elastic hair pin), Wear recommended work shoes.

3.3. FORBIDDEN

- The press should not be used outside of its intended use and for different materials.
- It should not be operated without proper protective systems and its protective parts should never be removed. Parts that require adjustment and periodic maintenance must be done after power cut.
- No mechanical or electrical changes must be made on the press for whatever reason.

3.4. OTHER RISKS

Do not forget that the use of the press can always be dangerous. Absolutely security depends entirely on the user. This press is equipped with appropriate protection systems for safe operation. As long as these systems are used properly, the press will be safe and operated efficiently.

Even if the rules written in the use and maintenance manual are followed, the following risks and dangers may occur;

- Dangers that may arise from incorrect electrical connection
- Dangers can arise from incorrect installation.

3.5. WORKPLACE SAFETY

- Before starting to work, the working area must be thoroughly cleaned and the wastes in oily or similar places must be removed.
- Employees must be made aware of the condition of the ground.
- Work shoes (with steel protection zone and rubber sole) must be worn and protective equipment (protective gloves etc.) must be used.
- Only the authorized operator must be in the work place.
- In order for the operator to stay outside the dangerous area, there must be a good lighting and sufficient working place in the work area.
- The floor must be flat against the danger of slipping and there must be no obstacle parts on the floor.
- All unused tools, equipment and connection extensions must be removed. Similar materials such as cables or cords must be removed from the work area to avoid tripping hazards.

3.6. MACHINE SAFETY

Start the press when all safety systems are properly installed and suitable for use. Use only hand-powered tools. The guards must be installed while the machine is turned off.

The use of press machine is not allowed unless the following conditions are provided;

- While the press is running, never remove any part of the main body.
- When closing the press, turn it off after taking the operation to its final position.
- Make sure that the procedure between electrical fields, including testing and documentation is done safely.
- While the press connection apparatus and other parts are loaded or unloaded, the body parts of the employees should never remain between the load and the parts.
- The noise level of the press is below the critical threshold.

4. MAINTENANCE RULES

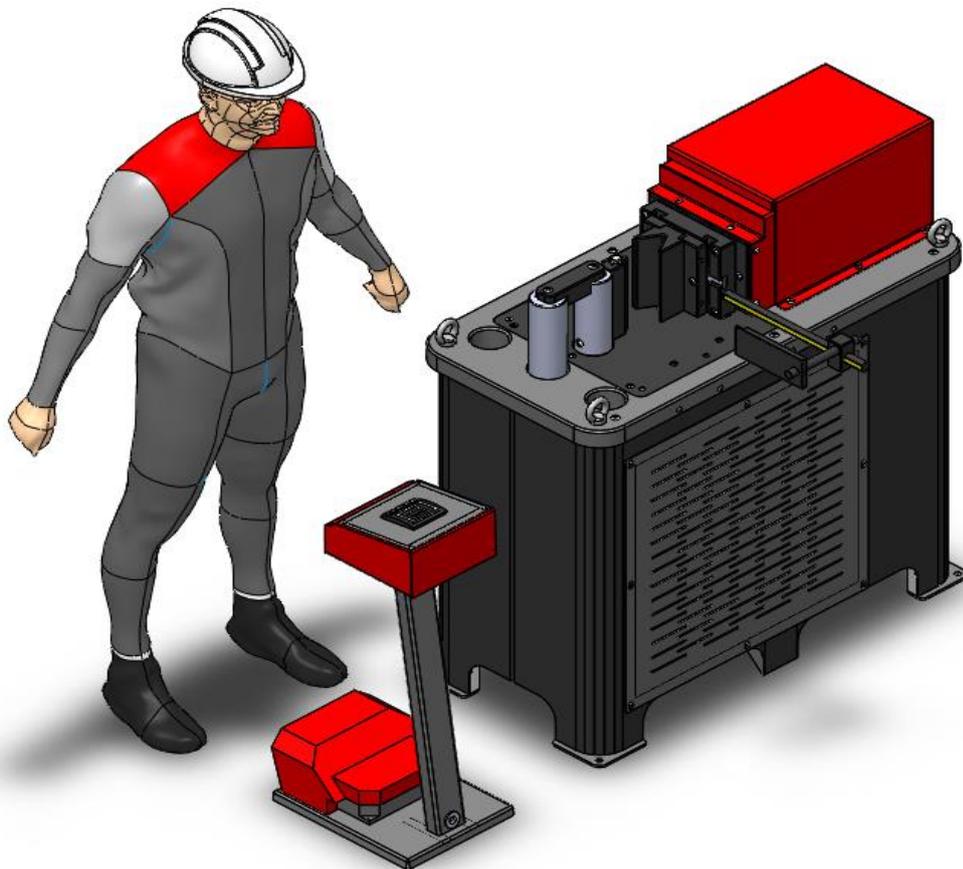
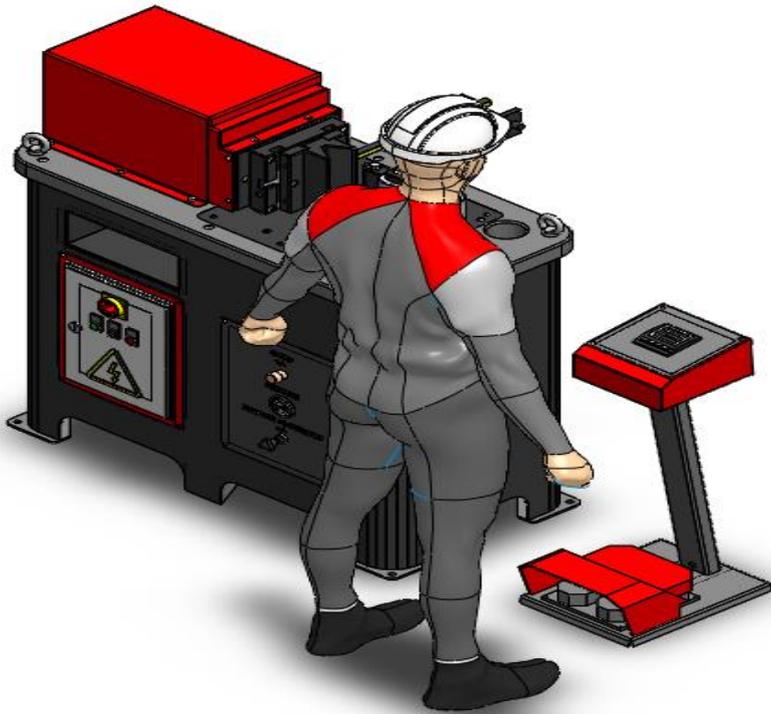
- Make sure that there is no electrical connection during maintenance. Check this out personally.
- Turn off the press by pressing the emergency stop button to make arrangements or to install any part.
- Stop the press completely before cleaning or removing the protective parts required for maintenance.
- The general cleaning of the press and floor is an important factor for safety.
- Perform the cleaning and maintenance operations regularly.
- Make sure that the working procedure is applied correctly for each press insulation.
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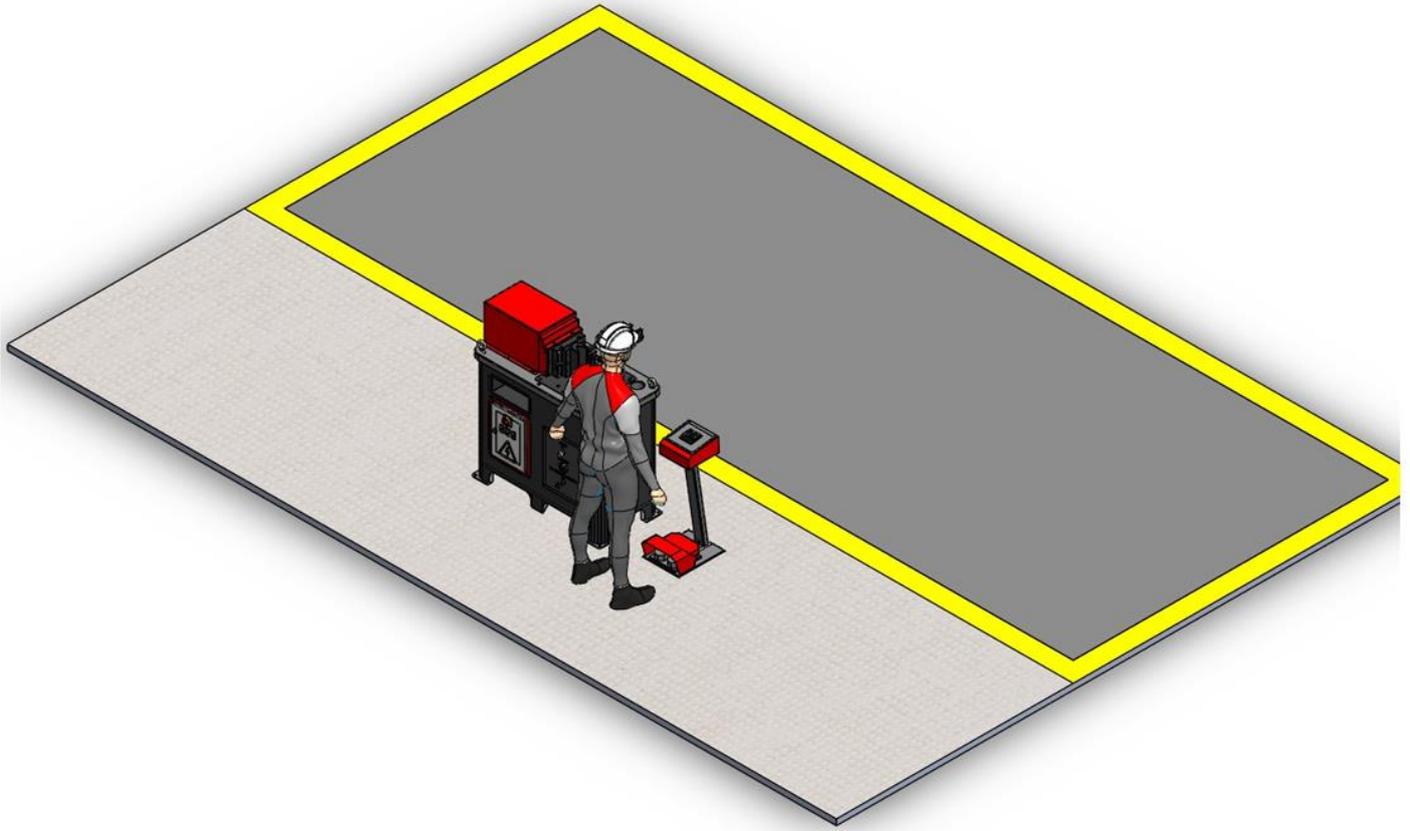
NO	MAINTENANCE INSTRUCTIONS	G Ü N L Ü K	H A F T A L L I K	1 5 G Ü N L Ü K	A Y L I K	3 A Y L I K	6 A Y L I K	Y I L L I K
1	Check the screws, nuts, buttons and signs, otherwise complete them.					x		
2	Clean the outer surface and inner parts of the hydraulic press. Protect the press against rusting.	x						
3	Clean the hydraulic oil pump surface, oil tank and hoses and check for oil leakage. Check the manometer.						x	
4	Check the hydraulic oil.							x
5	Clean and lubricate moving parts, guide, slide, column and horizontal bars.				x			

5. SAFETY SIGNS USED AND THEIR MEANS

	<p>DANGER</p>	<p>Indicates that if the instructions for use are not followed, death/ Serious injury or serious damage to the product may occur.</p>
	<p>ELECTRIC SHOCK</p>	<p>The sign indicates electrical hazards that can result in personal injury or death.</p>
	<p>CRUSHING HAZARD (HAND/ FINGER)</p>	<p>The sign determines the risk of accidents with moving parts, jamming and injuring personnel.</p>
	<p>DANGER OF BEING UNDER LOAD</p>	<p>The sign indicates the risk of injury as a result of the load falling on personnel.</p>
	<p>IMPORTANT NOTE</p>	<p>Warning sign about important points and issues</p>
	<p>USER MANUEL</p>	<p>Indicates that the user manual should be read before the operation.</p>
	<p>UNAUTHORIZED PERSONS DANGER OF ENTERING THE WORK AREA</p>	<p>Indicates that people should not enter dangerous areas</p>

6. LAYOUT VE OPERATOR POSITION





7. PACKING AND SHIPPING INFORMATION

- The press machine has been packaged in the most appropriate way in order to protect against possible damages during the shipment processes stated below. In the packaging of the press, protection measures have been taken against the risk of tipping during transportation, impact, moisture and rusting.
- Accessories are shipped with the press on the same pallet and in separate packages to prevent damage during transportation.
- The press should be stored in closed areas.
- The press is mounted on a wooden pallet. When unpacking, it should be opened carefully so as not to damage the press.
- While lifting, carrying and lowering, the carrying lug on the press and wooden pallets made for forklift transportation are used. Loading, unloading from the vehicle and transporting it to the installation site is done by crane or forklift according to the most suitable transportation method and the user company possibilities. If every opportunity is available, it is recommended that this transport is carried out by crane.

- Perform the centering balancing by determining the weight to be lifted. During the maneuver, the control element must be at least 1m away from the forklift or the load. The controller must confirm with the forklift operator that the movement of the forklift is under control. As the controller's instruction, the forklift operator must stop his forklift. If any person is closer than 1m to the forklift, the forklift operator must stop.
- Always drive the forklift from below during load handling. Forklift forks should be as close to the ground as possible. Under no circumstances should personnel get on the load or on the forklift.
- Make sure that the forklift forks are securely fastened. Seat belts should be used while moving up or down the ramp.
- Perform the centering balancing by determining the weight to be lifted.
- During the maneuver, the control element must be at least 1m away from the forklift or the load.
- Control should be done by stopping on the hook, not with the limit limiter switch. After the operation is completed, the lift should be brought to the parking position.
- After loading on the vehicle, the packaging must be secured using a strap. For possible damage and missing parts, HANSTAHL Ltd. Şti must be notified in writing within 7 days.

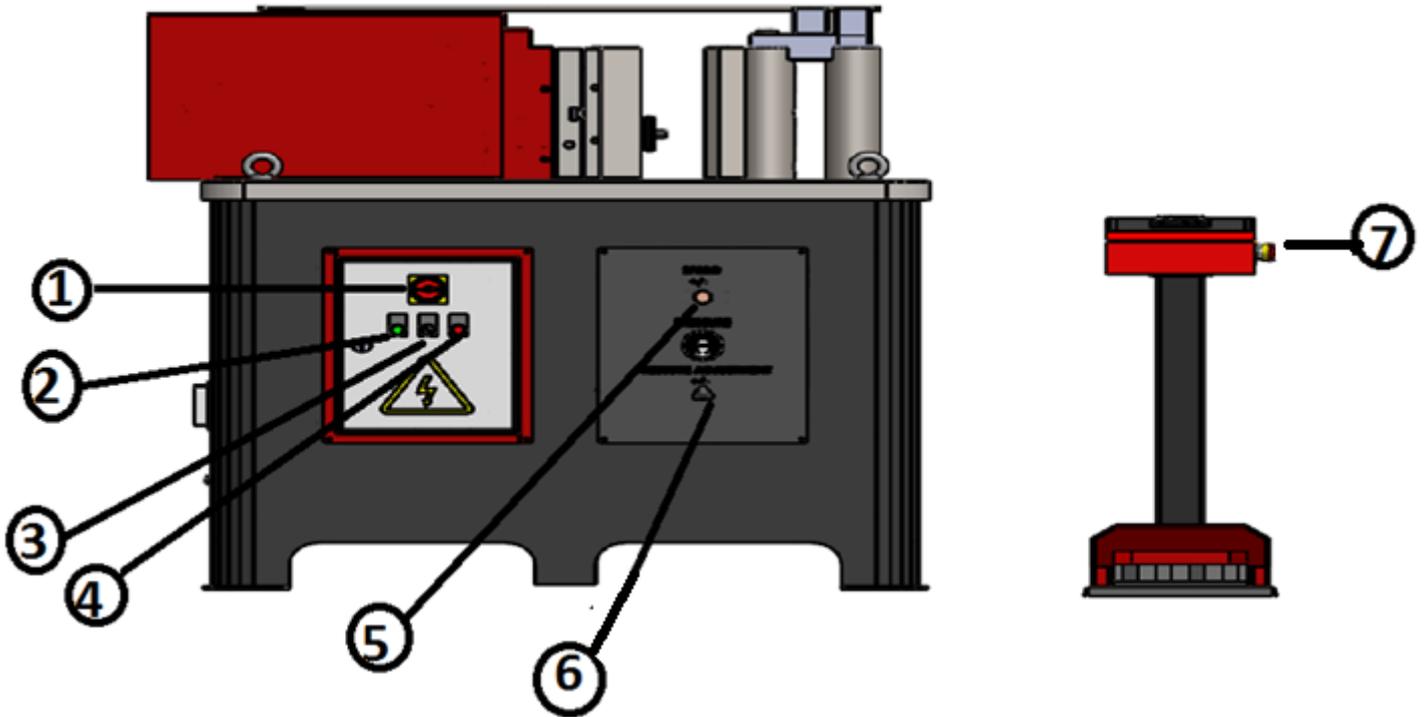
8. ASSEMBLY

Correct placement of the press in the place where it will be installed and ensuring appropriate environmental conditions are important for working life and high operation.

The following conditions must be met for the environment in which the press will operate;

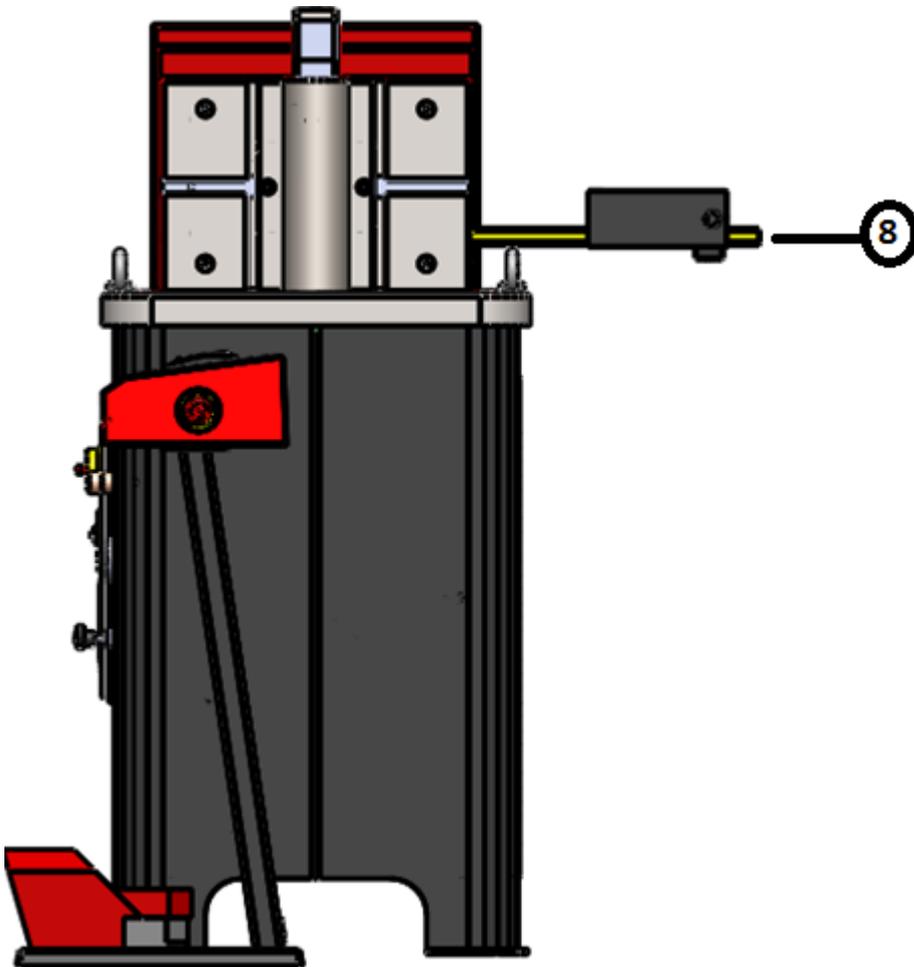
- Ambient temperature should be between 5°C and + 40°C.
- It should be protected from rain, mud and moisture.
- It should be protected from direct sunlight.
- The environment should be properly lit for the job to be done.
- Make sure that the place where the press will work is on a flat ground.
- Balance the feet on which the press is on the ground with respect to the floor.
- Perform the general cleaning of the place where you will place it.
- Provide the required electrical voltage.

9. HOW PRESS WORKS



1. Main Switch
2. Hydraulic Start
3. Manuel- Automatic Switch
4. Hydraulic Stop
5. Speed Valve
6. Pressure Valve
7. Emergency Stop Button





8) Manuel Backgauge

HOW TO OPEN THE PRESS;

- Turn the No.1 power switch.
- Pressing the green START button. No.2 turns on the unit and also the START button.
- The material is bent at the desired height by applying pressure to the material with the head that moves freely by means of the pedal.

10. CONTROL SYSTEMS

Control systems are designed and manufactured in a way that prevents the occurrence of dangerous situations. Special attention must be paid to the following;

- The machine should not start unexpectedly,
- Machine parameters should not change in an uncontrolled way if the changes cause dangerous situations,
- When the stop command is given, the machine should not be prevented from stopping,
- No moving part of the machine or part held by the machine must fall or be ejected,
- Automatic or manual stopping of moving parts should not be prevented, whatever happens,
- The protective devices must be fully effective or give a stop command,
- Parts for control systems must be applied consistently to a whole subgroup of machines.

11. POWER SUPPLY FAILURE

The return of energy or fluctuations in the supply after any interruption in the power supply that feeds the machines should not cause a dangerous situation.

Special attention must be paid to the following;

- Machines should not start unexpectedly.
- The parameters of the machines should not change in an uncontrolled way when such a change could lead to a dangerous situation.
- Stopping the machine should not be prevented if the command has already been given.
- Whatever happens, moving parts should not be prevented from being stopped automatically or manually.
- The protective devices must remain fully effective or give a stop command.

12. STOPPING

12.1. NORMAL STOPPING

The machines are equipped with a control device that can stop the machine in complete safety. Each workstation is fitted with a control device that will shut down all or part of the functions of the machinery, depending on the hazards present. Thus, the machine is made safe.

Once the machines or their dangerous functions are stopped, the power supply to the respective actuators must be cut off.



12.2. OPERATIONAL STOPPING

When a stop command is required that does not de-energize the actuators for operational reasons, the stop state must be monitored and maintained.

12.3. EMERGENCY STOPPING

When the active state of the emergency stop device expires following a stop command, this command must be made to perpetuate the activation of the emergency stop device until this operation is specifically overridden. It must not be possible to activate the device without triggering a stop command. Disengagement of the device must only be possible with an appropriate action, and disengagement of the device must not restart the machine, but allow a start.

The emergency stop function must be available and working at all times, regardless of the operating mode.

Emergency stop devices are a supplementary element for other protective measures and cannot replace these measures.

13. RISK OF BREAKAGE DURING OPERATION

Various parts of the machines and their connections are resistant to the stresses they are exposed to during use. If there is still a risk of breakage or disintegration despite the precautions taken, the relevant parts should be installed, positioned and/or protected in a way that prevents any broken parts from remaining inside and causing dangerous consequences.

Fluid-bearing flexible and rigid pipes, especially those under high pressure are resistant to foreseeable internal and external stresses and are tightly fastened and/or protected so that there is no risk during a break.

In cases where the materials to be processed are automatically fed into the tool, the following conditions must be met in order to avoid a risk to persons:

- When the workpiece comes into contact with the tool, the tool must have achieved normal working conditions.
- When the tool is started and/or stopped, the feed movement must be coordinated with the movement of the tool.