



HORIZONTAL PRESS HP20T

INSTALLATION MANUAL



ORIGINAL INSTRUCTIONS - HP20T

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OPERATOR AND SUPERVISOR INFORMATION

This is one of four manuals supplied with your machine.

- Installation Manual
- Safety Instructions Manual
- Operations Manual
- Maintenance Manual

Each of the four machine manuals describe 'best practices' in handling, installing, operating and maintaining your machine. The contents of each manual is subject to change without notice due to improvements in the machinery or changes in National or International standards.

All rights reserved. Reproduction of this manual in any form, in whole or in part, is not permitted without the written consent of Edwards Manufacturing Company.

Understand the contents of each manual thoroughly. Keep all manuals close to the machine to allow for easy reference when necessary.

Provide operators with sufficient training and education in the basic functions of the machine prior to machine operation.

Do not allow for operation of the machine by unqualified personnel. Edwards Manufacturing Company is not liable for accidents arising from unskilled, untrained operation.

Do not modify or change the machine without written authorization from Edwards Manufacturing Company. Unauthorized modification to a machine may result in serious operator injury, machine damage and will void your machine warranty.

This machine is manufactured for use by able bodied and able minded operators only. Never operate machinery when tired or under the influence of drugs or alcohol.

Do not resell, relocate or export to a destination other than to the original point of sale. Edwards has designed this machine to meet the standards of the original receiving country and is not liable for meeting any governing body or performance standards beyond those of the original receiving country.

SIGNAL WORD DEFINITION



Indicates a hazardous situation that, if not avoided, will result in death or serious injury.



Indicates a hazardous situation that, if not avoided, could result in death or serious injury.



Indicates a hazardous situation that, if not avoided, could result in mild or moderate injury.



Indicates information considered important, but not hazard related.

SIGNAL WORD PANEL ON MACHINE



Critical machine safety information is identified on signal word labels. Labels are attached adjacent to the potentially hazardous locations of the machine. Reference the Safety Instruction Manual for additional information regarding the potentially hazardous condition identified on the label.

Review ALL labels on the machinery, reference the operational precautions and safe operations sections within this manual before any operation activity is initiated.

Failure to read and understand the signal word labels affixed to the machinery may result in operator death or injury.

HORIZONTAL PRESS INSTALLATION

This manual provides installation requirements for the Edwards Horizontal Press.

All Edwards Hydraulic Accessory Tools are powered by an Edwards Ironworker outfitted with a Hydraulic Accessory Pack or an Edwards Porta Power, portable hydraulic power unit.

Refer to Safety, Installation, Operations and Maintenance manuals for the Edwards power-plant you are using to operate your Edwards Hydraulic Accessory Tool.

Environmental Requirements at Work Station

NOTICE

The work station environment for your Edwards Horizontal Press must meet the following minimum requirements:

- **Ambient temperature:** 7.2°C - 43.3°C [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:** 500LUX (50 footcandles) minimum.

Receiving the Horizontal Press

WARNING

Edwards 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 fork-lift rated for the following equipment weights:

Minimum Machinery Weights

Horizontal Press 612.34kg/1350lb

Utilize best practices for fork-lift operation. Handle material as close to the drive surface as possible with the widest spread and deepest penetration of forks effective to service the pallet. Forks should be adjusted and locked into the safety detent closest to the maximum available fork spread.

Unpacking/Moving the Horizontal Press

Your Edwards Horizontal Press includes surface and remotely mounted electrical cabling and hydraulic lines. Exercise caution when removing the factory supplied packaging. Do not cut electrical wires or hydraulic hoses.

1. Carefully remove packaging.
2. Carefully remove the lagbolts and washers attaching the HP20T to the shipping pallet.
3. Locate the fork-lift areas at the bottom of the machinery
4. Carefully insert forks through the fork lift assembly. Confirm that forks penetrate through the assembly and allow for clamps to restrain Horizontal Press from sliding off forks. Install clamps (not included) to forks so that the press is stable while moving and lift the press from the pallet.
5. Locate your HP20T Horizontal Press directly adjacent to the Edwards Ironworker or Porta Power. Ensure that power controls of the Ironworker or Porta Power are within arms-reach of the Horizontal Press.

Installing the Horizontal Press

WARNING

1. The HP20T Horizontal Press is designed to mount on a dedicated, weight rated flooring system. **DO NOT MOUNT ON CASTERS.** The floor rating should be a minimum multiplier of 2.5 times the weight of the Press plus the weight of any tooling being used within the Press, plus the material being pressed.

(HP20T weight (1350 lb.) + Tooling weight + Material weight) x 2.5 = Dedicated, weight rated floor system

2. Locate leveling pads installed on the bottom of the machine. Unscrew pads to allow for a minimum of 1" working space and the installation of anchoring hardware (not provided). With a level placed on the work surface, check the machinery for level. Adjust machine for level by rotating pads clockwise or counterclockwise and mark drill locations within leveling pad surface. Drill for and install four 1/2" wedge anchor bolts to secure HPM2 to floor. Lower machine onto anchor bolts, install washers, and tighten nuts to complete floor installation.

Hydraulic Power



Your Edwards Horizontal Press is factory assembled and tested for optimum performance when powered by Edwards Manufacturing Company rated hydraulic power supplies.

The Horizontal Press is powered by either an Edwards Ironworker with the factory installed Hydraulic Accessory Control Package or an Edwards Porta-Power, 5hp, 3000psi, portable power unit.

ALTERNATE POWER SOURCES ARE NOT RECOMMENDED AND MAY COMPROMISE MACHINE OPERATION, MACHINE HYDRAULIC WARRANTY AND OPERATOR SAFETY.

Follow electrical connection installation instructions for power supply as set forth within the Installation Manual of the Edwards Ironworker or Porta-Power.

Powering with an Edwards Ironworker

Power selection controls are located adjacent to the starter on the feed side of the machine. Hydraulic quick connections and accessory controls are located on the drop-off side or end cap of the machine.

With the Ironworker power off, install Horizontal Press hoses, power and control:

- Install the Horizontal Press male and female accessory hydraulic hoses to the ironworker male and female quick-connect hydraulic fittings. Both fittings have a detent ball setting that must be aligned to couple and uncouple hoses.
- Remove the safety cap at the push button port. Attach the Horizontal Press hand control male mil. spec. control cable to the female mil. spec. accessory control port at your Ironworkers Hydraulic Accessory package. Attach the yellow limit switch cable to the limit switch port of the ironworker. Attach the yellow Auxiliary cable to the Aux Light port on the ironworker.

With all Ironworker and Horizontal Press stations clear of hands, tools, tooling, material or debris, power up the Ironworker by depressing the green button on the starter box.

With the power on, your Ironworker machine will return to a neutral position.

Turn the 3-position switch on the front of the machine case to the Accessory position. This operation disables the Ironworker and switches control to the accessory hand control.

Test the Horizontal Press operation by depressing the OUT control button. Once depressed, the cylinder will extend. Releasing pressure on the OUT control button will stop the cylinder. Test the Horizontal Press operation by depressing the IN control button. Once depressed, the cylinder will be retracted back into the cylinder enclosure. Releasing pressure on the IN control button will stop the cylinder.

Test the digital encoder and limit switches by rotating the scale hand crank.

Depress the red e-stop button to kill power at the Ironworker. To reset power, twist the e-stop button and push start button at the Ironworker.

When disconnecting your Horizontal press, simply reverse procedure. **Replace the safety cap at the push button port to restore power to your Ironworker.**

Powering with an Edwards Porta-Power

Your Edwards Porta-Power 5hp / 3000psi / Portable Power Unit will power all your Edwards Hydraulic Accessories.

Follow electrical connection installation instructions as set forth within these sections of the Installation Manual:

With the Edwards Porta-Power off, install accessory hoses, power and control:

- Install the male and female Horizontal Press hydraulic hoses to the Porta-Power male and female quick connect hydraulic fittings adjacent to the starterbox. Both fittings have a detent ball setting that must be aligned to couple and uncouple hoses.
- Remove the safety cap at the push button port. Attach the Horizontal Press hand control, male mil. spec. control cable to the female mil. spec. accessory push button port on the Porta-Power case. Attach the yellow limit switch cable to the limit switch port of the ironworker. Attach the yellow Auxiliary cable to the Aux Light port on the ironworker. Attach the Horizontal Press hand control, male mil. spec. control cable to the female mil. spec. accessory push button port on the Porta-Power case.

With all Ironworker and Horizontal Press stations clear of hands, tools, tooling, material or debris, power up the Porta-Power by depressing the green button on the starter box.

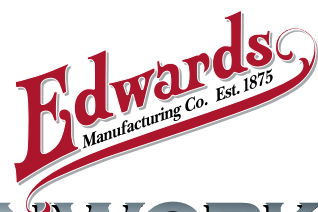
With the power on, your Horizontal Press is in a neutral position.

Test the Horizontal Press operation by depressing the OUT control button. Once depressed, the cylinder will extend. Releasing pressure on the OUT control button will stop the cylinder. Test the Horizontal Press operation by depressing the IN control button. Once depressed, the cylinder will be retracted back into the cylinder enclosure. Releasing pressure on the IN control button will stop the cylinder.

Test the digital encoder and limit switches by rotating the scale crank.

Depress the red e-stop button on the hand control to kill power at the Porta Power. To reset power, twist the e-stop button and push start button at Porta Power.

When disconnecting your Horizontal press, simply reverse procedure. **Replace the safety cap at the push button port to restore power to your Porta Power.**



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