

Piranha P1165 P1188

Piranha II Ironworker Instruction and Parts Manual

MODELS P1165 AND P1188

Introduction

This manual provides essential instructions and detailed information for the safe and efficient operation, maintenance, and repair of Piranha II Ironworker models P1165 and P1188. It is crucial to read and understand all sections before attempting to install, operate, or service the machine.

This document contains 22 printed pages, revised in 1996, including diagrams.

Safety Precautions

Always prioritize safety when working with industrial machinery. Failure to follow safety guidelines can result in serious injury or death. Ensure all operators are trained and familiar with the machine's operation and safety features.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and hearing protection.
- Ensure the machine is properly grounded and all electrical connections are secure.
- Never operate the machine with guards removed or bypassed.
- Keep hands and clothing clear of moving parts.
- Disconnect power before performing any maintenance or adjustments.
- Refer to local safety regulations and standards.

Installation

Proper installation is critical for the performance and safety of your Piranha II Ironworker. Follow these steps carefully:

1. **Site Preparation:** Ensure the installation area is level, stable, and capable of supporting the machine's weight. Provide adequate space for operation and maintenance.
2. **Unpacking:** Carefully uncrate the machine, inspecting for any shipping damage. Report any damage

immediately.

3. **Positioning:** Use appropriate lifting equipment to position the ironworker in its designated location.
4. **Anchoring:** Securely anchor the machine to the floor using recommended fasteners to prevent movement during operation.
5. **Electrical Connection:** Connect the machine to the appropriate power supply as specified in the machine's electrical requirements. Ensure connections are made by a qualified electrician.
6. **Hydraulic System:** Check hydraulic fluid levels and ensure all connections are tight.

Operating Instructions

This section details the procedures for operating the Piranha II Ironworker safely and effectively.

- **Pre-Operation Checks:** Before each use, inspect the machine for any loose parts, leaks, or damage. Verify all safety guards are in place.
- **Tooling Setup:** Select and install the appropriate punch and die for the material and desired operation. Refer to the *Punch and Die Clearance Chart* for correct clearances.
- **Material Handling:** Position the workpiece securely. Ensure it is properly supported and aligned with the tooling.
- **Operation:** Engage the machine's controls to perform punching, shearing, or bending operations. Always maintain a safe distance from the working area.
- **Punch Tonnage Chart:** Consult the Punch Tonnage Chart to ensure the machine's capacity is not exceeded for the material thickness and type being processed.

Maintenance

Regular maintenance is essential to ensure the longevity and optimal performance of your Piranha II Ironworker.

Adhere to the following schedule and procedures:

- **Daily Checks:** Inspect for hydraulic leaks, check fluid levels, and clean debris from the work area.
- **Lubrication:** Follow the lubrication schedule provided in this manual. Use only recommended lubricants for all moving parts, pins, and bushings.
- **Tooling Inspection:** Regularly inspect punches and dies for wear or damage. Replace worn tooling promptly to maintain cut quality and prevent machine damage.
- **Hydraulic System:** Periodically check and replace hydraulic filters. Monitor hydraulic fluid for contamination.
- **Electrical System:** Inspect electrical connections and wiring for signs of wear or damage.
- **Service Record Chart:** Utilize the provided Service Record Chart to log all maintenance activities, including dates, tasks performed, and parts replaced.

Troubleshooting

This section provides guidance for identifying and resolving common issues that may arise during the operation of your Piranha II Ironworker.

Problem	Possible Cause	Solution
Machine does not start	No power, emergency stop engaged, faulty switch	Check power supply, reset emergency stop, inspect switches

Problem	Possible Cause	Solution
Loss of hydraulic power	Low hydraulic fluid, clogged filter, pump malfunction	Check fluid level, replace filter, inspect pump
Poor cut quality	Worn tooling, incorrect clearance, dull blades	Replace tooling, adjust clearance, sharpen blades

For issues not covered here, or if troubleshooting steps do not resolve the problem, contact qualified service personnel.

Specifications

This section provides key technical and dimensional data for the Piranha II Ironworker models P1165 and P1188.

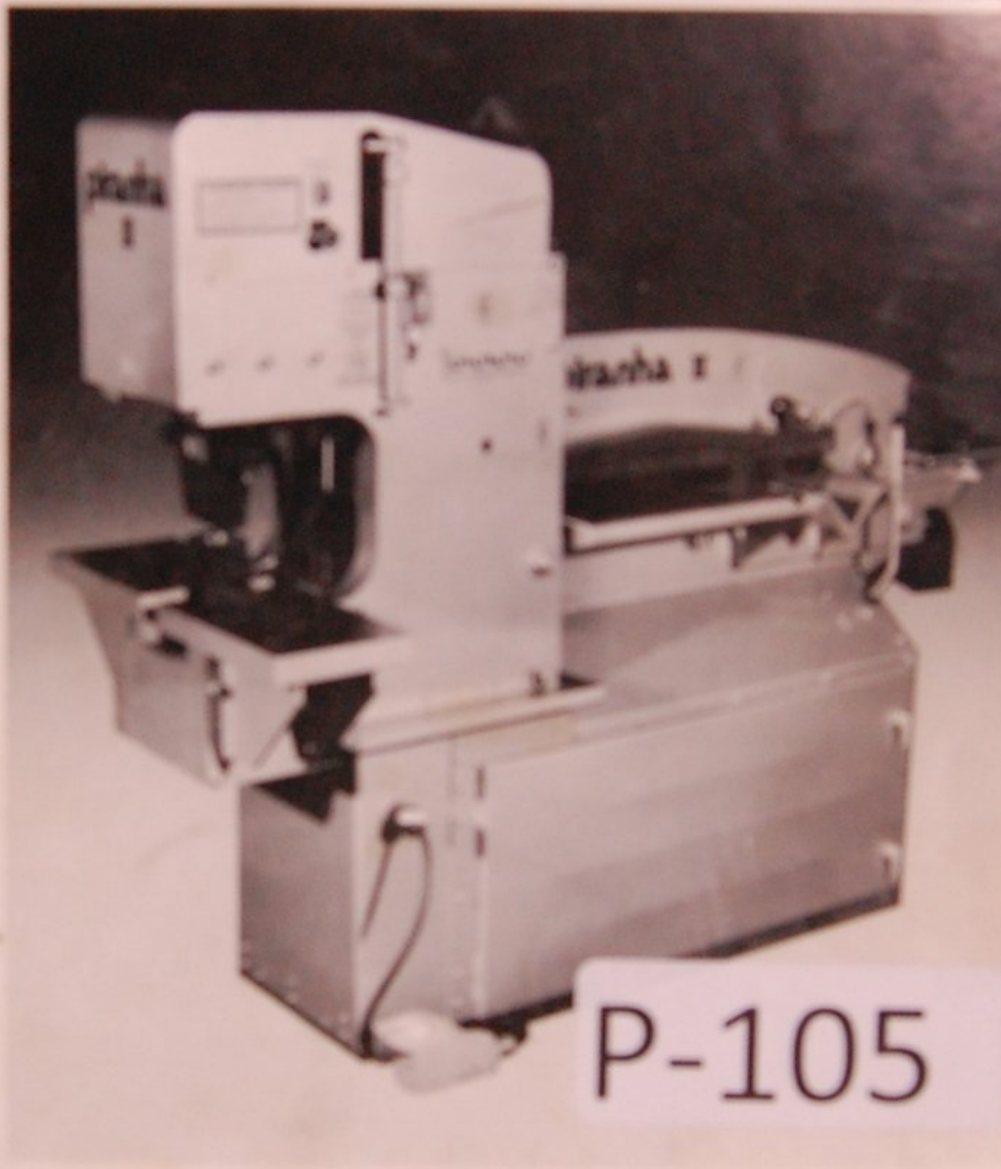
- **Models Covered:** P1165, P1188
- **Functional Diagram:** Refer to the detailed functional diagram within this manual for component identification.
- **Dimensional Data:** Specific dimensions are provided to assist with installation and space planning.
- **Punch Tonnage Chart:** Detailed chart outlining maximum punching capacities for various materials and thicknesses.
- **Punch and Die Clearance Chart:** Guidelines for selecting appropriate clearances based on material type and thickness.
- **Item Weight:** Approximately 13 ounces (for the manual itself).
- **Publication Date:** January 1, 1996

Parts and Diagrams

This section includes detailed illustrations and a comprehensive list of repair parts for the Piranha II Ironworker.

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INSTRUCTIONS
AND
REPAIR PARTS
MANUAL

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PIRANHA
IRONWORKER
Model No. P1165
and P1188



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Image: Cover of the Piranha II Ironworker Instruction and Parts Manual. This image represents the physical manual itself, which contains all the detailed diagrams and parts illustrations for the P1165 and P1188 models.

- **Repair Parts Illustrations:** Exploded views and diagrams to assist in identifying and ordering replacement parts.
- **Tool List:** A complete list of standard and optional tools required for maintenance and operation.

- **P11 65/88 Bending Attachments and Optional Tooling:** Information on available attachments and tooling to expand the machine's capabilities.

Warranty

Refer to the specific warranty information provided with your Piranha II Ironworker at the time of purchase. This manual includes a general forward and warranty statement. For detailed terms and conditions, please consult your original purchase documentation or contact Piranha customer support.

Support and Ordering Instructions

For assistance with your Piranha II Ironworker, or to order replacement parts, please follow these guidelines:

- **Ordering Instructions:** When ordering parts, always provide the machine model number (P1165 or P1188), the part number as identified in the Repair Parts Illustrations, and a clear description of the part.
- **Technical Support:** Contact Piranha customer service for technical assistance or service inquiries.