KAKA INDUSTRIAL HP-50P

KAKA INDUSTRIAL HP-50P 50-Ton Hydraulic Press Instruction Manual

Model: HP-50P

1. Safety Information

Operating the KAKA INDUSTRIAL HP-50P hydraulic press requires strict adherence to safety protocols to prevent injury and equipment damage. Read and understand all instructions before operation.

General Safety Precautions

- Always wear appropriate Personal Protective Equipment (PPE), including safety glasses, gloves, and steel-toed boots.
- Ensure the press is securely anchored to a stable, level surface before use.
- Keep the work area clean, well-lit, and free of obstructions.
- Never exceed the rated 50-ton capacity of the press.
- Do not place hands or body parts between the ram and the workpiece during operation.
- Ensure all adjustments are locked in place before applying pressure.
- Regularly inspect the press for any signs of damage, wear, or leaks. Do not operate if damaged.
- Only trained and authorized personnel should operate this equipment.
- Disconnect air and hydraulic power before performing any maintenance or adjustments.

2. Product Overview

The KAKA INDUSTRIAL HP-50P is a robust 50-ton H-frame pneumatic hydraulic shop press designed for various industrial and garage applications such as bending, forming, punching, staking, and straightening. It features a durable reinforced steel construction, an adjustable workbench, and a dual-scale pressure gauge for precise control.

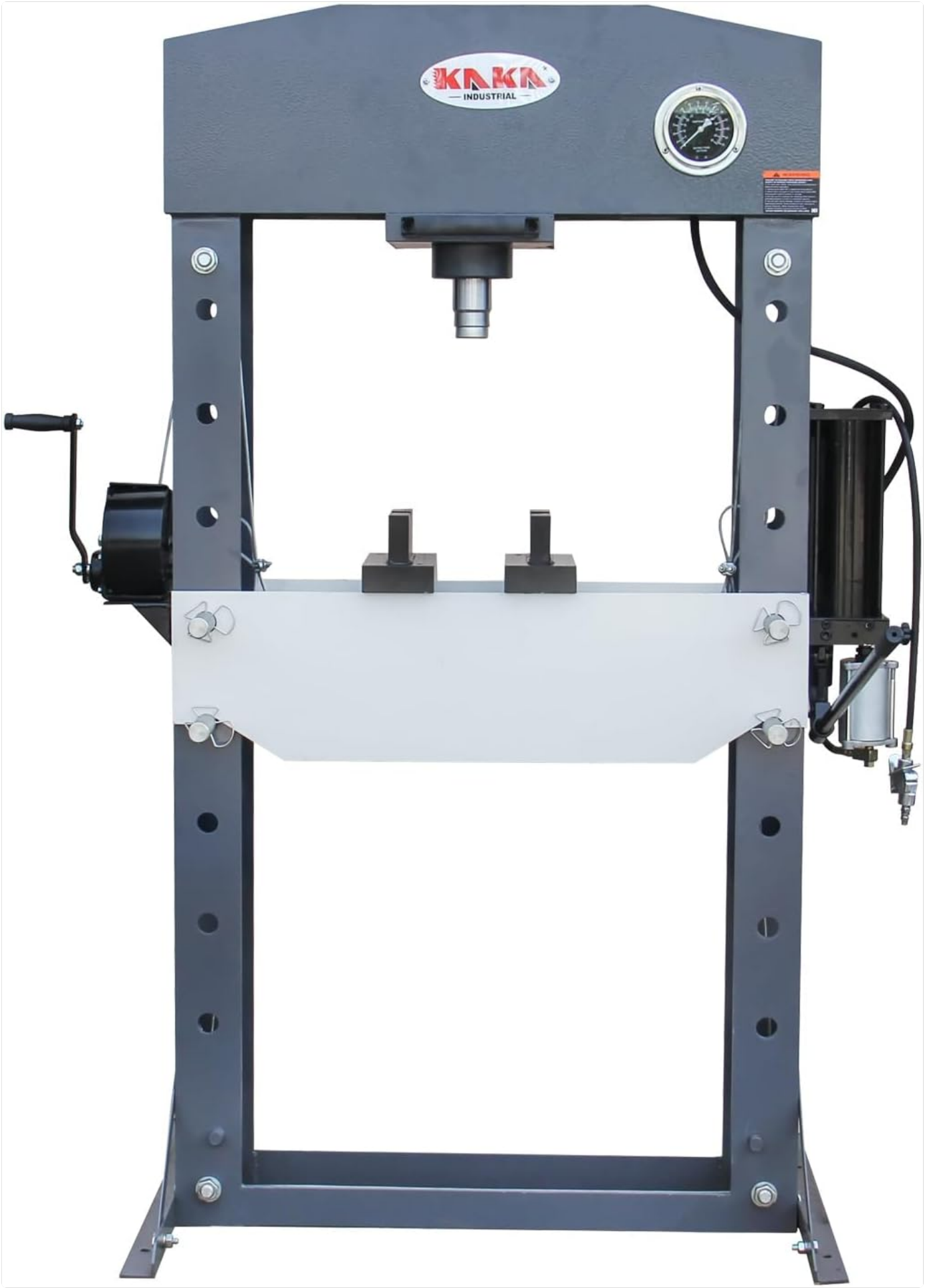


Figure 2.1: Front view of the KAKA INDUSTRIAL HP-50P 50-Ton Hydraulic Press.

Key Components

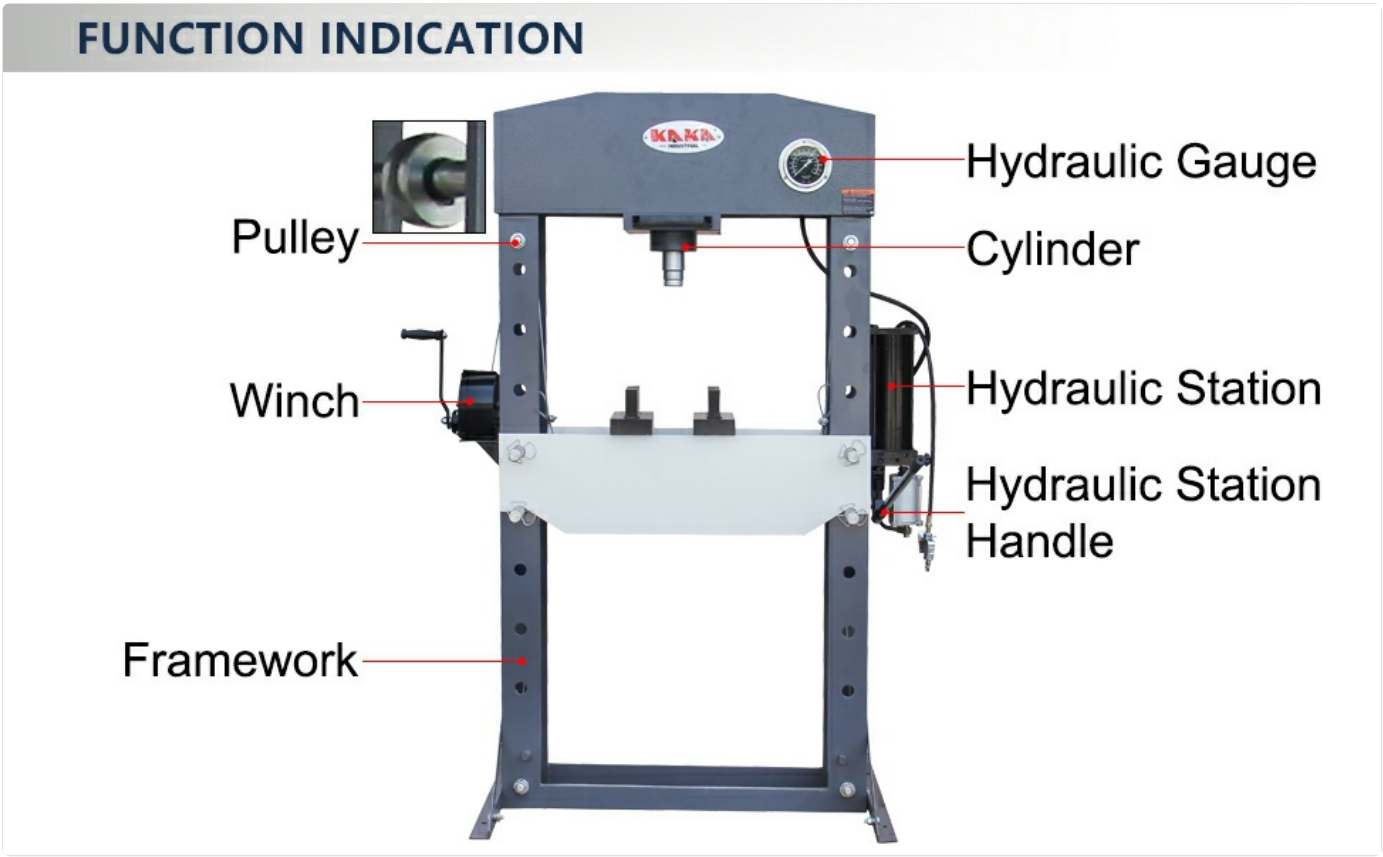


Figure 2.2: Component identification for the HP-50P Hydraulic Press.

- **Framework:** The main H-frame structure providing stability and support.
- **Cylinder:** The hydraulic cylinder housing the ram.
- **Ram:** The movable component that applies force to the workpiece.
- **Hydraulic Gauge:** Displays the applied pressure in tons.
- **Hydraulic Station:** Contains the hydraulic pump and reservoir.
- **Hydraulic Station Handle:** Used to manually operate the hydraulic pump.
- **Pneumatic Pump:** Air-powered pump for efficient operation.
- **Winch and Pulley System:** Facilitates easy adjustment of the workbench height.
- **Adjustable Workbench:** The platform where workpieces are placed, adjustable to 8 different positions.
- **V-Blocks:** Included accessories for supporting various workpiece shapes.

3. Specifications

Detailed specifications for the KAKA INDUSTRIAL HP-50P 50-Ton Hydraulic Press.

Feature	Specification
Model Number	HP-50P
Capacity	50 Tons
Stroke	8.66 inches
Ram Diameter	6.3 inches
Max Table Distance	25.98 inches

Feature	Specification
Workbench Adjustment Holes	8 (spaced 5.31 inches apart)
Pump Type	Hydraulic + Pneumatic
Hydraulic Reservoir Capacity	3 Liters
Item Weight	578 pounds
Product Dimensions	55 x 30 x 81 inches
Color	Gray

4. Setup and Assembly

The KAKA INDUSTRIAL HP-50P hydraulic press is a heavy piece of equipment. Proper setup is crucial for safe and effective operation.

Unpacking and Placement

- Upon delivery, ensure someone is present to receive and sign for the shipment.
- If delivered to a residential location, a liftgate service is strongly recommended due to the weight of the unit.
- Carefully unpack the press, inspecting for any shipping damage. Report any damage immediately.
- Choose a permanent, level, and stable location for the press. The floor must be capable of supporting the press's weight (578 lbs) plus the maximum workpiece weight and applied force.
- Securely anchor the press to the floor using appropriate hardware (not included) to prevent tipping or movement during operation.

Assembly and Initial Checks

1. **Attach Winch and Pulley System:** Mount the winch system to the side of the press frame as shown in Figure 4.1. Ensure all fasteners are tightened securely.



Figure 4.1: Winch and pulley system for workbench adjustment.

2. **Install Workbench:** Position the adjustable workbench at the desired height using the winch and pulley system. Insert the support pins through the frame holes and the workbench. Ensure both pins are fully engaged and secured.
3. **Place V-Blocks:** Position the V-blocks on the workbench as needed for your specific application.



Figure 4.2: Included V-blocks for workpiece support.

4. **Connect Air Supply (for Pneumatic Pump):** Connect a suitable air compressor to the pneumatic pump inlet. Ensure the air supply pressure is within the recommended range (refer to the pump's specific requirements, typically 90-120 PSI).
5. **Check Hydraulic Fluid Level:** Verify that the hydraulic fluid reservoir is filled to the appropriate level. If low, add high-quality hydraulic oil (ISO VG 32 or equivalent) as specified by the manufacturer.
6. **Bleed Air from System:** Before first use, it may be necessary to bleed any trapped air from the hydraulic system. Consult the pump's specific instructions for this procedure.

5. Operating Instructions

Follow these steps for safe and effective operation of your KAKA INDUSTRIAL HP-50P hydraulic press.

Adjusting Workbench Height

1. Ensure the ram is fully retracted.
2. Remove the support pins from the workbench.
3. Use the winch handle to raise or lower the workbench to the desired height. The workbench has 8 adjustment holes spaced 5.31 inches apart.
4. Once at the desired height, re-insert the support pins through the frame and workbench holes, ensuring they are fully seated and secured.

Applying Pressure

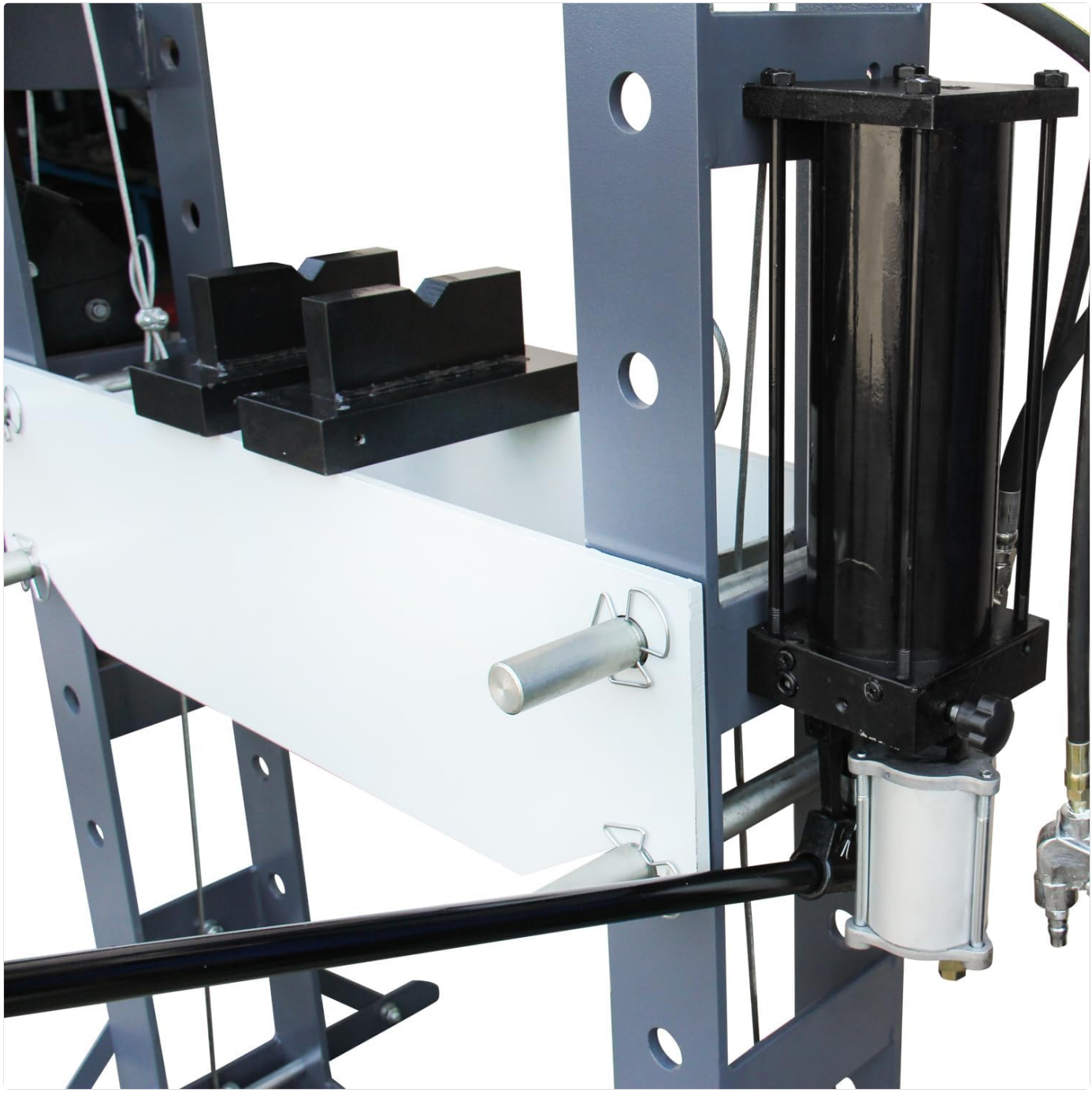


Figure 5.1: Hydraulic cylinder and pneumatic pump assembly.

1. Place the workpiece securely on the V-blocks or directly on the workbench. Ensure it is centered under the ram.
2. Close the release valve on the hydraulic pump (usually by turning a knob or lever clockwise).
3. **For Manual Operation:** Pump the hydraulic station handle to extend the ram and apply pressure.
4. **For Pneumatic Operation:** Open the air valve to the pneumatic pump. The ram will extend and apply pressure automatically.
5. Monitor the dual-scale pressure gauge to ensure you do not exceed the desired or maximum 50-ton capacity.



Figure 5.2: Dual-scale pressure gauge for accurate readings.

6. Once the desired operation is complete, slowly open the release valve (turn counter-clockwise) to retract the ram.
7. Remove the workpiece.

6. Maintenance

Regular maintenance ensures the longevity and safe operation of your hydraulic press.

- **Daily:** Clean the press after each use. Inspect for any visible damage, loose fasteners, or hydraulic fluid leaks.
- **Weekly:** Check the hydraulic fluid level. Top up with recommended hydraulic oil (ISO VG 32 or equivalent) if necessary. Inspect all hoses and connections for wear or damage.
- **Monthly:** Lubricate all moving parts, including the ram, pump mechanism, and winch system, with appropriate grease or oil. Check the air filter on the pneumatic pump and clean or replace if needed.
- **Annually:** Consider a complete hydraulic fluid change. Inspect the structural integrity of the H-frame for any signs of fatigue or deformation.
- Always ensure the press is disconnected from air and hydraulic power before performing any maintenance.

7. Troubleshooting

This section provides solutions to common issues encountered during the operation of the HP-50P hydraulic press.

Problem	Possible Cause	Solution
Ram does not extend or extends slowly.	Low hydraulic fluid level. Release valve open. Air in hydraulic system. Insufficient air pressure (for pneumatic operation).	Check and refill hydraulic fluid. Ensure release valve is fully closed. Bleed air from the system. Check air compressor and connections.
Ram retracts slowly or not at all.	Release valve not fully open. Obstruction in the system.	Ensure release valve is fully open. Inspect for any blockages or damage.
Loss of pressure during operation.	Internal leak in hydraulic system. Release valve not fully closed. Worn seals.	Inspect for external leaks. If internal, contact qualified service personnel. Ensure release valve is tightly closed. Contact service for seal replacement.

Problem	Possible Cause	Solution
Unusual noises from pump.	Low hydraulic fluid. Air in hydraulic system. Worn pump components.	Check and refill hydraulic fluid. Bleed air from the system. Contact qualified service personnel.

For issues not listed or if troubleshooting steps do not resolve the problem, contact KAKA INDUSTRIAL customer support.

8. Warranty and Support

KAKA INDUSTRIAL is committed to providing quality products and customer satisfaction.

Warranty Information

Specific warranty details for the HP-50P hydraulic press are typically provided at the time of purchase or can be found on the official KAKA INDUSTRIAL website. Please retain your proof of purchase for warranty claims.

Customer Support

For technical assistance, parts, or service inquiries, please contact KAKA INDUSTRIAL customer support. You can typically find contact information on the manufacturer's website or through your point of purchase.

KAKA INDUSTRIAL LLC also offers a 30-day easy returns policy. For more details, please refer to the return policy provided at the time of purchase or on the seller's platform.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page's manual context to help answer it.

Name

Anonymous

Email

you@example.com

After a successful submission, we securely hash the supplied account or form email before sending it to Microsoft Advertising for conversion attribution. Privacy details.

Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question