



For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

MODEL T1241

20-TON HYDRAULIC PRESS

INSTRUCTIONS

(For Machines Mfd. Since 7/20)



! WARNING

Eye injury hazard! Always wear safety glasses when using this machine.



! WARNING

Crushing hazard! Always keep hands clear when using this machine.

Identification

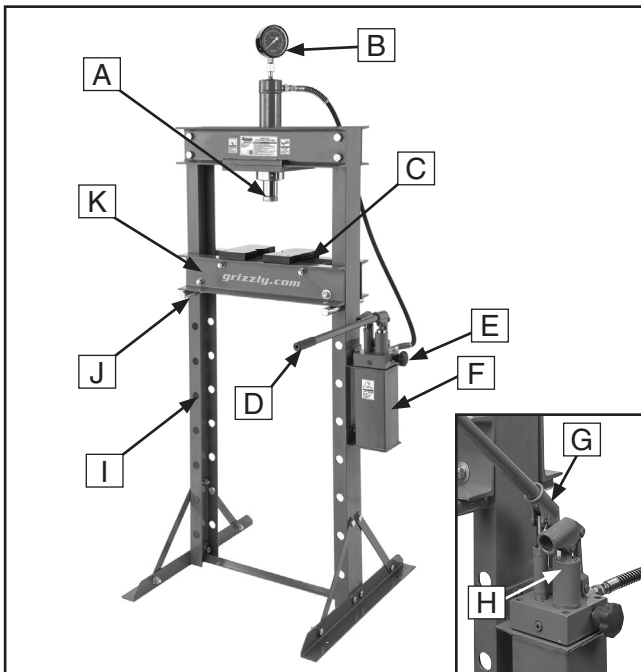


Figure 1. Model T1241 identification.

A. Hydraulic Ram. Applies pressure directly to workpiece. Hydraulic ram operates using pressure for downward ram movement.

B. Pressure Gauge. Shows pounds of force (in tons) per inch being applied to workpiece.

C. Table Plates. Support workpiece during pressing operation.

D. Pump Handle. Generates hydraulic pressure in ram when pumped up and down. Moves ram downward.

E. Tank Relief Valve. Releases pressure from hydraulic ram to release workpiece.

F. Hydraulic Fluid Reservoir. Holds hydraulic fluid for operation of hydraulic ram.

G. Micro Pump Valve. Increases hydraulic ram pressure in small increments.

H. Standard Pump Valve. Increases hydraulic ram pressure in large increments.

I. Bed Adjustment Holes. Holds support rods to position press bed at desired height.

J. Support Rods. Support press bed using holes in machine frame.

K. Press Bed. Platform for table plates supports workpiece during pressing operation.

! CAUTION

Always ensure workpiece is positioned so force is evenly distributed. Off-center workpieces can be ejected unexpectedly from force of hydraulic ram, striking operator or bystanders and causing injury.

Inventory

Open shipping crate and inventory items included inside (see **Figure 2**).

Description:	Qty
A. Sleeve Spacers (Bed)	4
B. Pressure Gauge	1
C. Bed Support Rods.....	2
D. Bed Sides.....	2
E. Columns	2
F. Hydraulic Ram Cylinder.....	1
G. Hydraulic Line.....	1
H. Hydraulic Reservoir Assembly	1
I. Table Plates.....	2
J. Ram Mounting Plate.....	1
K. Cross Beams.....	2
L. Angle Braces.....	4
M. Center Brace	1
N. Base Supports.....	2
O. Pump Handle.....	1

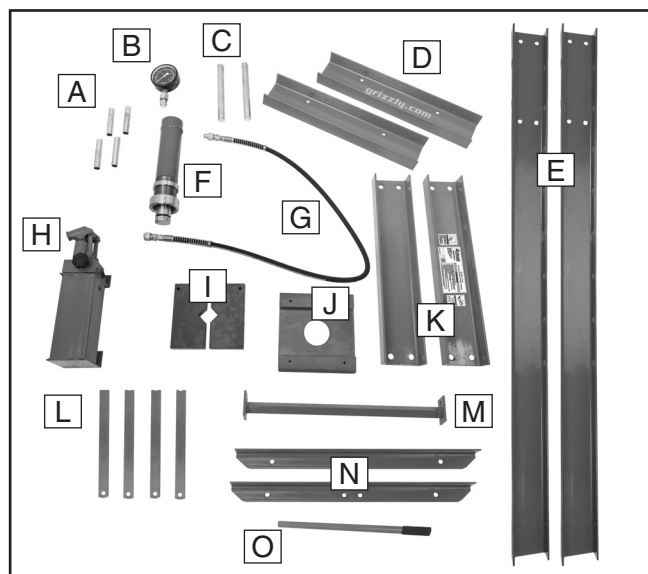


Figure 2. Inventory items.

P. Hardware Bag (not shown)	
—Hex Bolts M16-2 x 35 (Cross Beam)	8
—Hex Nuts M16-2 (Cross Beam).....	8
—Flat Washers 16mm (Cross Beam).....	8
—Lock Washers 16mm (Cross Beam).....	8
—Hex Bolts M12-1.75 x 30 (Base).....	4
—Hex Nuts M12-1.75 (Base)	4
—Flat Washers 12mm (Base)	4
—Lock Washers 12mm (Base).....	4
—Hex Bolts M10-1.5 x 25 (Base)	8
—Hex Nuts M10-1.5 (Base).....	8
—Flat Washers 10mm (Base)	8
—Lock Washers 10mm (Base)	8

—Hex Bolts M10-1.5 x 25 (Tank).....	2
—Hex Nuts M10-1.5 (Tank)	2
—Flat Washers 10mm (Tank).....	2
—Lock Washers 10mm (Tank).....	2
—Hex Bolts M10-1.5 x 130 (Bed)	4
—Hex Nuts M10-1.5 (Bed)	4
—Flat Washers 10mm (Bed).....	4
—Lock Washers 10mm (Bed)	4
—Hex Bolts M8-1.25 x 16 (Ram Plate).....	4

Needed For Setup

Description	Qty
Additional People	1
Open-End Wrench 13mm.....	1
Open-End Wrenches 17, 19, 21mm.....	2 Ea.
Phillips Head Screwdriver #2.....	1
Mallet.....	1
Thread-Sealant Tape.....	As Needed
Mounting Hardware.....	As Needed

Assembly

1. Lay columns on the ground and connect base supports and center brace, as shown in **Figure 3**, using (4) M12-1.75 x 30 hex bolts, 12mm flat washers, 12mm lock washers, and M12-1.75 hex nuts.
2. Attach (2) angle braces to each base support using (8) M10-1.5 x 25 hex bolts, 10mm flat washers, 10mm lock washers, and M10-1.5 hex nuts, as shown in **Figure 3**.

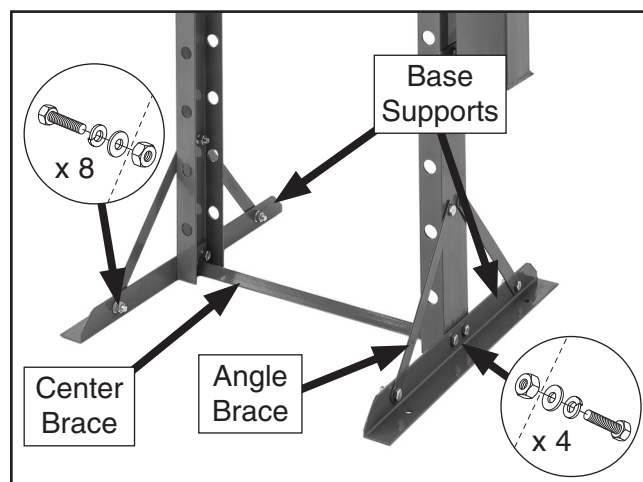
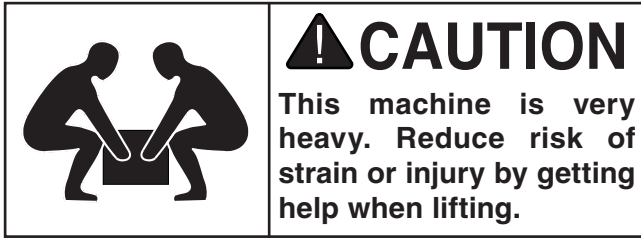


Figure 3. Center strut and angle braces attached to base supports and columns.





3. With help from an assistant, secure cross beams to top of columns (see **Figure 4**) with (8) M16-2 x 35 hex bolts, 16mm flat washers, 16mm lock washers, and M16-2 hex nuts. When installing second cross beam, position ram mounting plate over bottom edges of cross beams, as shown in **Step 4**.

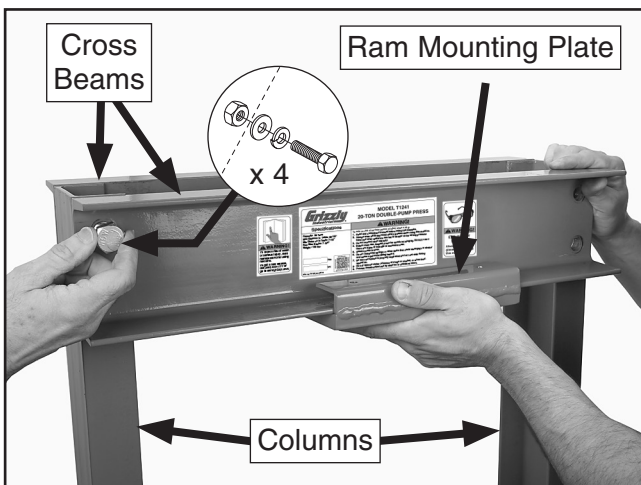


Figure 4. Securing cross beams to columns with ram mounting plate positioned on bottom edge.

4. Secure ram mounting plate in center of cross beams using (4) M8-1.25 x 16 hex bolts through pre-drilled holes in mounting holes (see **Figure 5**).

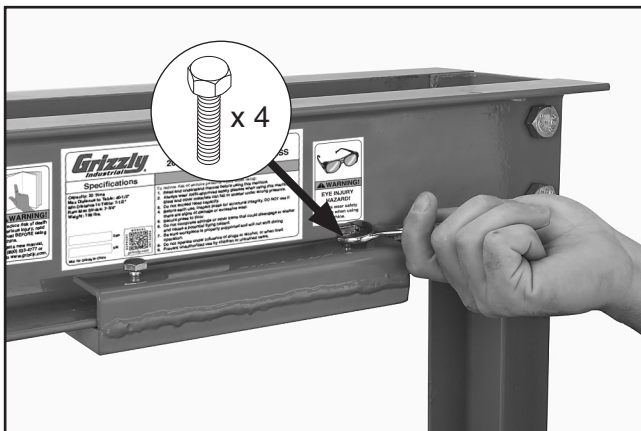


Figure 5. Securing ram mounting plate to cross beams.

5. From above, insert hydraulic ram cylinder through hole in ram mounting plate and thread ram collar into position, as shown in **Figure 6**.

Note: Ram collar can be tightened by inserting a Phillips head screwdriver into collar holes and lightly tapping across shaft of screwdriver with a mallet to rotate until tight.

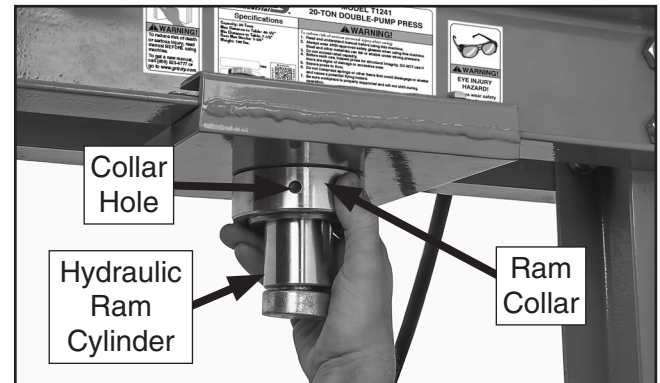


Figure 6. Securing hydraulic ram to mounting plate with ram collar.

6. Attach hydraulic reservoir assembly to right side of press column (see **Figure 7**) with (2) M10-1.5 x 25 hex bolts, 10mm flat washers, and 10mm lock washers, and M10-1.5 hex nuts.

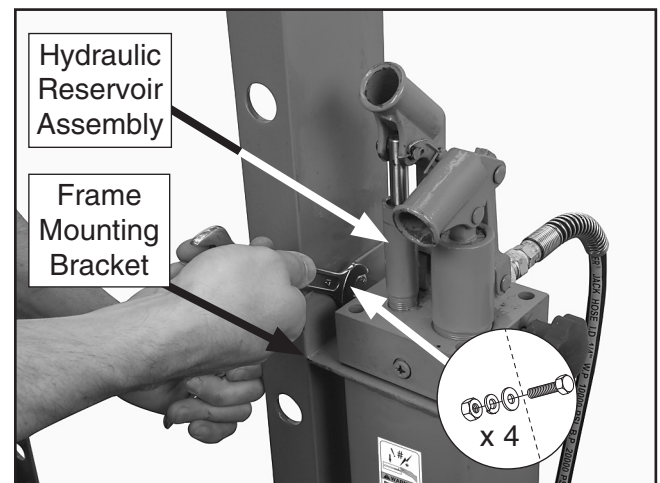


Figure 7. Mounting hydraulic reservoir assembly.



7. Connect hydraulic line to top end of hydraulic ram cylinder and hydraulic tank (see **Figure 8**).
8. Attach pressure gauge to the top of hydraulic ram (see **Figure 8**).

Note: Use thread tape on pressure gauge threads to ensure a proper seal during operation.

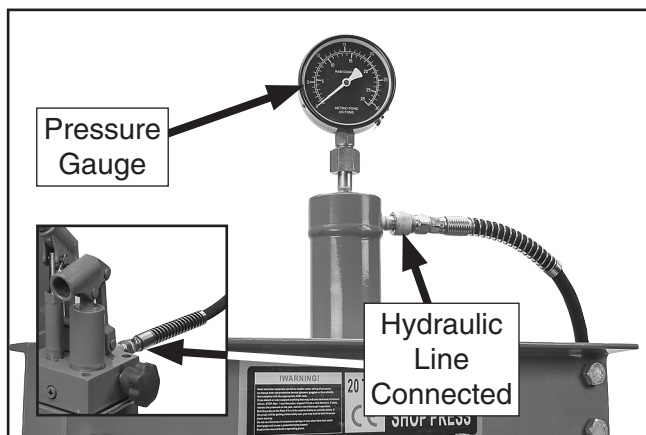


Figure 8. Pressure gauge and hydraulic line connected to hydraulic ram.

9. Assemble bed with (4) sleeve spacers between bed sides and secure together with (4) M10-1.5 x 130 hex bolts, 10mm lock washers, 10mm flat washers, and M10-1.5 hex nuts, as shown in **Figure 9**.

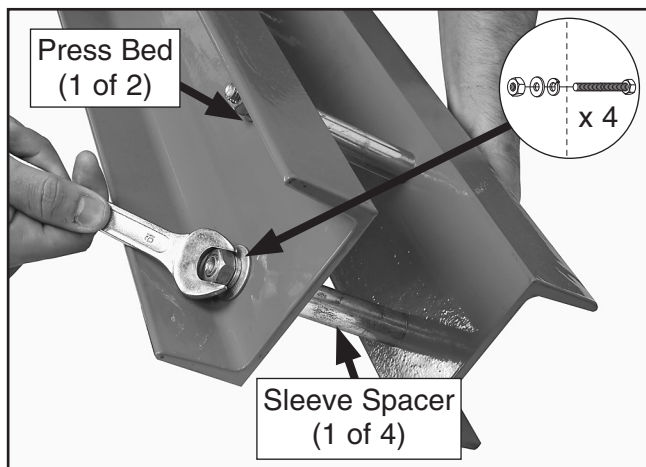


Figure 9. Assembling press bed.

10. Insert bed support rods through holes in each column to support press bed at desired height (see **Figure 10**). Lift bed into place and rest it on support rods

⚠ CAUTION

ALWAYS make sure support rods are supporting bed evenly! Failure to support press bed evenly could lead to bed accidentally dropping during setup or operation, which may result in crushing injury.

11. Place table plates on press bed, and insert pump handle into left or right receiver on top of hydraulic tank (see **Figure 10**).

Note: Left receiver is used for smaller incremental ram movement, and right receiver is used for larger incremental ram movement.

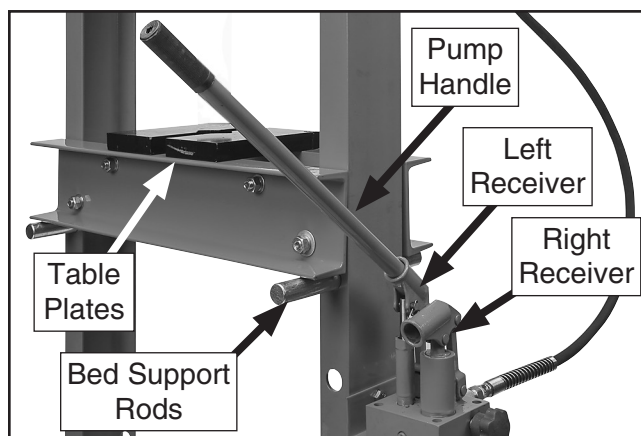


Figure 10. Table plates and handle positions.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... $\frac{3}{8}$ "

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

If the machine will be installed in a commercial or workplace setting, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

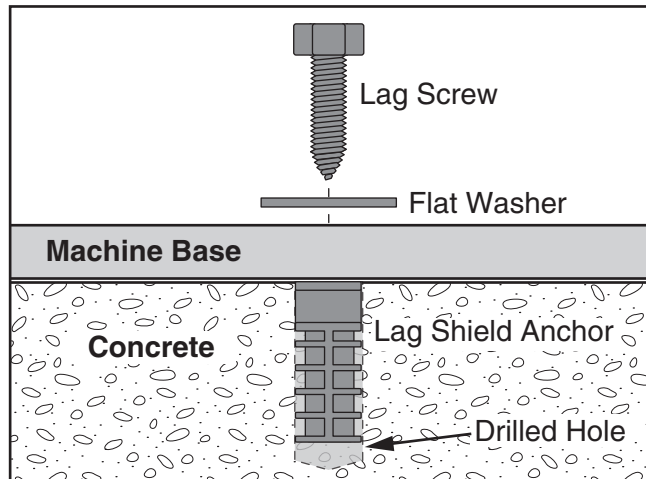


Figure 11. Popular method for anchoring machinery to a concrete floor.

Operating Press

1. Fully rotate tank relief valve (see **Figure 12**) clockwise to close it.



Figure 12. Rotating hydraulic system relief valve location.

2. Raise press bed to desired height, insert support rods, as shown in **Figure 13**, into holes in machine frame, then lower bed onto support rods.

**CAUTION**

ALWAYS make sure support rods are supporting bed evenly! Failure to support press bed evenly could lead to bed accidentally dropping during setup or operation, which may result in crushing injury.

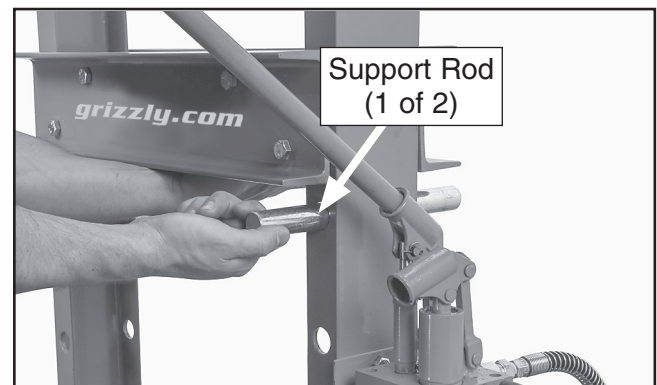


Figure 13. Inserting support rod.



3. Place table plates on press bed (see **Figure 14**), and place workpiece onto blocks.

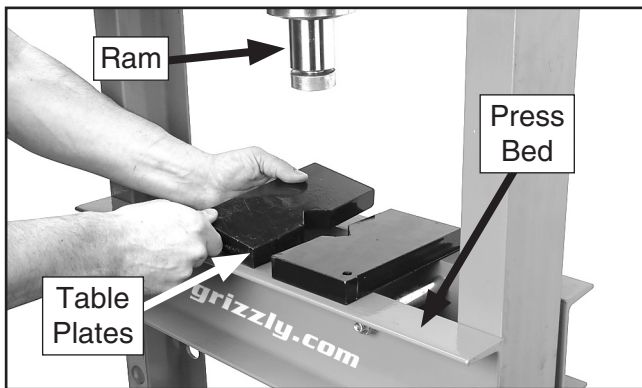


Figure 14. Positioning table plates on press bed.

CAUTION

Always ensure workpiece is positioned so force is evenly distributed. Off-center workpieces can be ejected unexpectedly from force of hydraulic ram, striking operator or bystanders and causing impact injury.

4. Pump handle to lower ram or increase downward pressure. Refer to pressure gauge for actual workpiece pressure (see **Figure 15**). Ram should lower smoothly.

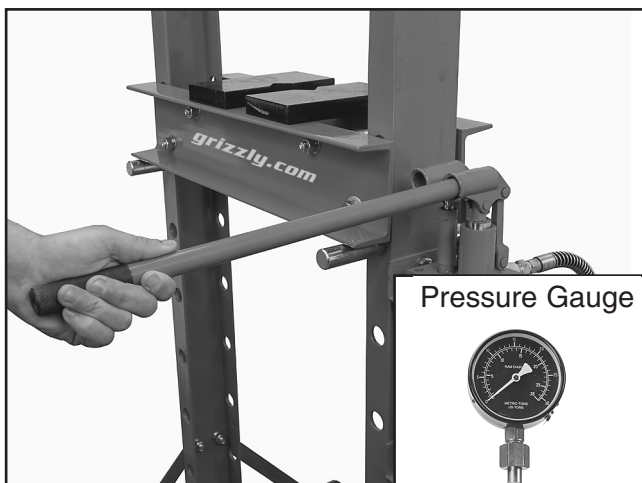


Figure 15. Pumping handle to increase pressure, which is indicated on pressure gauge.

5. Rotate tank relief valve (see **Figure 16**) counterclockwise to release pressure on ram, then remove workpiece.

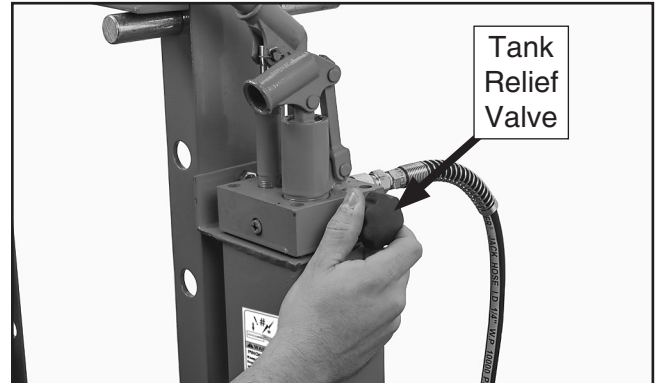


Figure 16. Rotating tank relief valve.

Maintenance

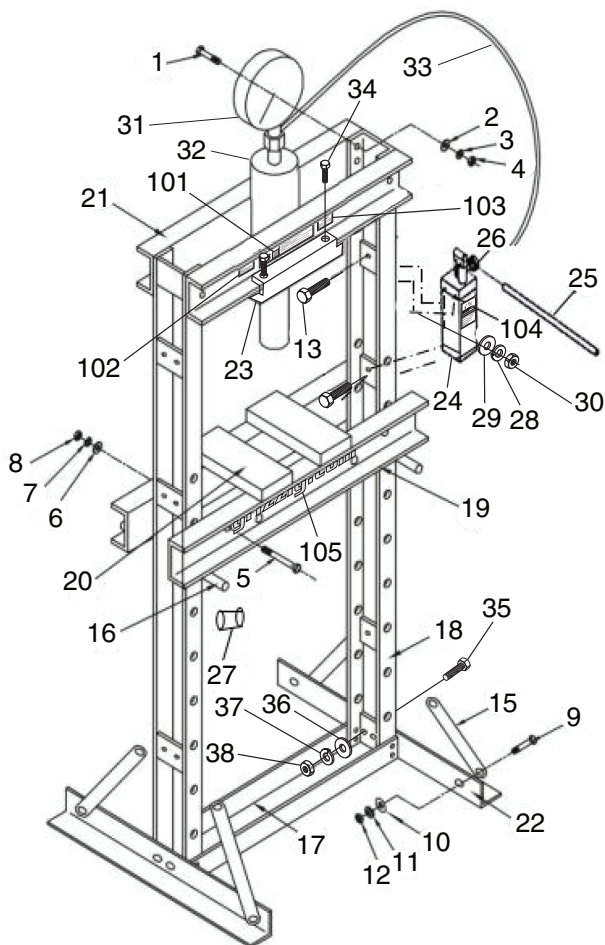
The T1241 20-Ton Press features a fully-sealed hydraulic unit. Periodically check press for loose mounting bolts or any unsafe conditions. Thoroughly clean press components on an as-needed basis for best operation.

To clean/maintain press:

1. Wipe all dirt and dust off press components.
2. Apply light oil to surface of ram.
3. Check hydraulic ram and press bed support rods for cracks or damage. Replace if necessary.

Parts Breakdown & List

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



REF	PART #	DESCRIPTION
1	PT1241001	HEX BOLT M16-2 X 35
2	PT1241002	FLAT WASHER 16MM
3	PT1241003	LOCK WASHER 16MM
4	PT1241004	HEX NUT M16-2
5	PT1241005	HEX BOLT M10-1.5 X 140
6	PT1241006	FLAT WASHER 10MM
7	PT1241007	LOCK WASHER 10MM
8	PT1241008	HEX NUT M10-1.5
9	PT1241009	HEX BOLT M10-1.5 X 25
10	PT1241010	FLAT WASHER 10MM
11	PT1241011	LOCK WASHER 10MM
12	PT1241012	HEX NUT M10-1.5
13	PT1241013	HEX BOLT M10-1.5 X 25
15	PT1241015	ANGLE BRACE
16	PT1241016	SUPPORT ROD 1"
17	PT1241017	CENTER STRUTS
18	PT1241018	COLUMN
19	PT1241019	PRESS BED
20	PT1241020	PRESS BLOCK
21	PT1241021	CROSS BEAM V1
22	PT1241022	BASE SUPPORT

REF	PART #	DESCRIPTION
23	PT1241023	RAM MOUNTING PLATE V1
24	PT1241024	HYDRAULIC RESERVOIR
25	PT1241025	HANDLE 7/8" DIA X 19.5" L
26	PT1241026	KNOB BOLT M10-1.0 X 15, 7-LOBE, D35
27	PT1241027	SLEEVE SPACERS
28	PT1241028	FLAT WASHER 10MM
29	PT1241029	LOCK WASHER 10MM
30	PT1241030	HEX NUT M10-1.5
31	PT1241031	PRESSURE GAUGE
32	PT1241032	HYDRAULIC RAM
33	PT1241033	HYDRAULIC LINE 1/4" ID X 60" L
34	PT1241034	HEX BOLT M8-1.25 X 16
35	PT1241035	HEX BOLT M12-1.75 X 30
36	PT1241036	FLAT WASHER 12MM
37	PT1241037	LOCK WASHER 12MM
38	PT1241038	HEX NUT M12-1.75
101	PT1241101	MACHINE ID LABEL
102	PT1241102	READ MANUAL LABEL
103	PT1241103	EYE INJURY HAZARD LABEL
104	PT1241104	PINCH HAZARD LABEL
105	PT1241105	GRIZZLY.COM LABEL





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