

**DURAPAC**  
ENGINEERED FOR RELIABILITY

# Instruction Manual

Reciprocating Air Hydraulic Power Unit  
Model – DPA-16



**Maximum Operating Pressure – 700 bar**



This is a safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid injury or death

## 1.0 Product Information

DURAPAC – Reciprocating Air Hydraulic Power Units are engineered to meet Industrial Standards for Performance and Safety. The DPA-16 model's unique hydraulic circuit allows the quick displacement of hydraulic fluid under no load conditions and easy pumping in loaded conditions. These air actuated power units supply compressed hydraulic fluid to compatible applications i.e. cylinder, presses, spreaders, compactors and crimping machines, anywhere that 700 bar of fluid pressure is needed.

- 1.6 L usable oil reservoir
- 3 position treadle for adv/hold/retract functions
- Release detent function enhances productivity
- Recommended air pressure range 3-8 bar

Special skill, knowledge and training may be required for a specific task and the product may not be suitable for all jobs. The user must ultimately make the decision regarding suitability of the product for any given task and assume the responsibility of safety for all in the work area. Contact a Durapac representative if you are unsure of your power unit's suitability for an application.

## 2.0 Receiving Instructions

It is recommended prior to use that an inspection be done by qualified personnel and that any missing or damaged parts, decals, warning/safety labels or signs are replaced with Durapac authorised replacement parts only. Any power unit that appears to be damaged in any way, is worn, leaking or operates abnormally should be removed from service immediately until such time as repairs can be made. Any power unit that has been or suspected to have been subject to a shock load should be removed from service immediately until inspected by a Durapac authorised service centre. Owners and operators of this equipment should be aware that the use and subsequent repair of this equipment may require specialised training and knowledge.

## 3.0 Safety

Save these instructions. For your safety, read and understand the information contained within. The owner and operator should understand this product and safe operating procedures before attempting to use this product. Instructions and safety information should be conveyed in the operator's native language before use of this product is authorised. Make certain that the operator thoroughly understands the inherent dangers associated with the use and misuse of the product. If any doubt exists as to the safe and proper use of this product as outlined in this factory authorised manual, remove from service immediately.



### **DANGER:**

- To avoid personal injury, keep hands and feet away from work area during operation
- **Do NOT** handle pressurised hoses. Escaping oil under pressure can penetrate the skin causing serious injury. If oil is injected under the skin, see a doctor immediately

- Stay clear of loads supported by hydraulics. A cylinder, when used as a load lifting device, should never be used as a load holding device. After the load has been raised or lowered, it must always be supported mechanically

**WARNING:**

- The system operating pressure must not exceed the pressure rating of the lowest rated component in the system. Install pressure gauges in the system to monitor operating pressure. It is your window to what is happening in the system
- Always wear appropriate personal protective equipment (PPE) when operating hydraulic equipment. The operator must take precaution against injury due to failure of the tool or work piece(s)
- **Do NOT** hold or stand directly in line with any hydraulic connections while pressurising
- **Do NOT** attempt to disconnect hydraulic connections under pressure. Release all line pressure before disconnecting hoses
- All personnel must be clear before lowering load or depressurising the system
- **Do NOT** attempt to lift a load weighing more than the capacity of the cylinder

**IMPORTANT:**

- If at any stage, the safety related decals become hard to read, these must be replaced
- Minimum age of the operator must be 18 years. The operator must have read and understood all instructions, safety issues, cautions and warnings before starting to operate the equipment. The operator is responsible for this activity towards other persons
- **Do NOT** lift hydraulic equipment by the hoses or couplers. Use the carrying handle or other means of safe transport
- Hydraulic equipment must only be serviced by a qualified hydraulic technician. For repair service, contact the Durapac authorised service centre in your area. To protect your warranty, use only high-quality hydraulic oil

**CAUTION:**

- **KEEP HYDRAULIC EQUIPMENT AWAY FROM FLAMES AND HEAT.** Hydraulic fluid can ignite and burn. Excessive heat will soften packings and seals, resulting in fluid leaks. Heat also weakens hose materials and packings. For optimum performance do not expose equipment to temperatures of 65°C (150°F) or higher. Protect all equipment from weld spatter
- No alteration should be made to this device

### 3.1 Hydraulic Power Units

- **Do** use a gauge or other load measuring instrument to verify load
- **Do NOT** exceed the rated capacity of the power unit or any equipment in the system. Burst hazard exists if connection pressure exceeds rated pressure
- **Do NOT** operate the system with bent or damaged couplers or damaged threads

- **Do NOT** subject the power unit and its components to shock loads
- Use only Durapac approved accessories and components
- **Do NOT** connect to an application which can return more oil to the reservoir than the power unit reservoir can hold
- **Do NOT** connect the power unit to a hydraulic system that is powered by another pump

### 3.2 Hydraulic Hoses & Fluid Transmission Lines

- Avoid short runs of straight-line tubing. Straight line runs do not provide for expansion and contraction due to pressure and/or temperature changes
- Reduce stress in tube lines. Long tubing runs should be supported by brackets or clips. Before operating the power unit, connections should be tightened securely and leak-free. Over tightening can cause premature thread failure or high-pressure fittings to burst
- Should a hydraulic hose ever rupture, burst or need to be disconnected, immediately shut off the power unit and release all pressure. Never attempt to grasp a leaking pressurised hose with your hands. The force of escaping hydraulic fluid can inflict injury
- **Do NOT** subject the hose to potential hazard such as fire, sharp objects, extreme heat or cold or heavy impact
- **Do NOT** allow the hose to kink, twist, curl, crush, cut or bend so tightly that the fluid flow within the hose is blocked or reduced. Periodically inspect the hose for wear
- Hose material and coupler seals must be compatible with the hydraulic fluid used. Hoses also must not come in contact with corrosive materials such as battery acid, creosote-impregnated objects and wet paint. Never paint a coupler or hose

**FAILURE TO HEED THESE WARNINGS MAY RESULT IN PERSONAL INJURY AS WELL AS PROPERTY DAMAGE.**

## 4.0 Installation



### **IMPORTANT:**

- Always secure threaded port connections with high grade, non-hardening pipe thread sealant. Teflon tape can be used if only one layer of tape is used and it is applied carefully, two threads back, to prevent the tape from being introduced into hydraulic system, which could cause jamming of precision-fit parts
- To extend the life of your power unit, the air compressor should have a filter, regulator and lubricator system that will provide clean, lubricated air to the power unit. Contact a Durapac representative for the necessary accessories

- 4.1 Familiarise yourself with the specifications and illustrations in this owner’s manual. Know your power unit, its limitations and how it operates before attempting to use. Refer to the specification chart below or if in doubt, contact a Durapac representative.

Model Number	Used with Cylinder	Oil Port Thread	Usable Oil Capacity (cc)	Pressure Rating (bar)	Output Flow Rate (cm <sup>3</sup> /min)		Air Pressure Range (bar)	Weight (kg)
					No load	Load		
DPA-16	S/A	3/8"-NPTF	1,600	700	1,000	150	3-8	6.6

- 4.2 **Air Connection** - Remove plastic cap, connect suitable air supply to air input port. Air input port is designed to fit the popular 1/4" NPT air nipple (not included). Ensure that your air source can dedicate 7.8 cfm @ 3-8 bar/45-116 psi to each power unit being operated.
- 4.3 Check all system fittings and connections to be sure they are tight and leak free.
- 4.4 Check oil level in reservoir before operating the power unit.
- 4.5 **Remove air from the power unit** – Air can accumulate in the hydraulic system during the initial setup or after prolonged use, causing the cylinder to respond slowly or in an unstable manner. Should removal of air from power unit be required, please follow the steps in 6.2 – Bleeding Air from the System in the Maintenance Section.

## 5.0 Operation



**IMPORTANT:**

- Always monitor pressure, load or position using suitable equipment. Pressure may be monitored by means of an optional manifold and gauge. Load may be monitored by means of a load cell and digital indicator. Correct application position can only be determined by the operator of the equipment
  - **Do NOT** operate a power unit that is disconnected from the application. If operated in this condition, the hose and connections will become pressurised. This increases the chance of a burst hazard. Damage may also occur to the power unit and its components
- 5.1 To extend the cylinder, depress on the foot pedal marked "Pump" (horizontal portion) until desired pressure, load or position is reached.
- 5.2 To hold the cylinder in position, release the foot pedal to deactivate the power unit.
- 5.3 To retract the cylinder, depress the release valve by stepping on the foot pedal marked "Release" (raised, stirrup shaped portion).

## 6.0 Maintenance



**IMPORTANT:**


- Check oil level regularly

- Use only good quality hydraulic fluid. **Do NOT** use brake fluid, transmission fluid, turbine oil, motor oil, alcohol, glycerine etc. Use of anything other than good quality hydraulic oil will void warranty and damage the power unit, hose, and application. We recommend Durapac Hydraulic Oil or equivalent
- Equipment must only be serviced by a qualified hydraulic technician. For repair service, contact your local Durapac authorised service centre
- Damage to hydraulic hoses may not be detected during visual inspections. For this reason, Durapac recommends that hydraulic hoses be replaced on a regular basis
- Tighten connections as needed. Use non-hardening pipe thread compound when servicing connections

Dirt, sand, etc. will quickly ruin any hydraulic system. Ensure that couplings are clean and free of foreign matter. After each use, clean couplings and attach dust caps.

Maintenance is required when wear or leakage is noticed. Periodically inspect all components to detect any problem that may require service and maintenance.

### 6.1 Adding Hydraulic Fluid


 **WARNING:** Always add oil with cylinders fully retracted (or extended, if pull cylinders) or the system will contain more oil than the reservoir can hold

- 6.1.1 Depressurise and disconnect hydraulic hose from application/cylinder.
- 6.1.2 With the power unit in its upright, horizontal position, remove the air vent plug located on the top plate of the reservoir.
- 6.1.3 Use a small funnel to fill the reservoir to within 19mm (3/4") of the opening.
- 6.1.4 Bleed air from system if necessary.
- 6.1.5 Wipe up any spilled fluid and reinstall the air vent plug/reservoir cap.

### 6.2 Bleeding Air from the System

- 6.2.1 Repeat Steps 6.1.1 to 6.1.3 (above), if required.
- 6.2.2 Invert cylinder and place at a lower level than the power unit reservoir.
- 6.2.3 Extend and retract the cylinder several times without putting a load on the system. Air will be released into the power unit reservoir.
- 6.2.4 Recheck oil level after removing air.

### 6.3 Changing Hydraulic Fluid

 For best results, change fluid once a year or every 300 hours of use

- 6.3.1 Repeat Steps 6.1.1 to 6.1.2 (above).
- 6.3.2 Pour used fluid into a sealable container.
- 6.3.3 Repeat Steps 6.1.3 to 6.1.5 (above).
- 6.3.4 Dispose of fluid in accordance with local regulations.

## 6.4 Lubrication

When power unit is operated daily, it is recommended that an inline oiler and air dryer is installed and SAE grade oil (5W to 30W) is used.

## 6.5 Storage

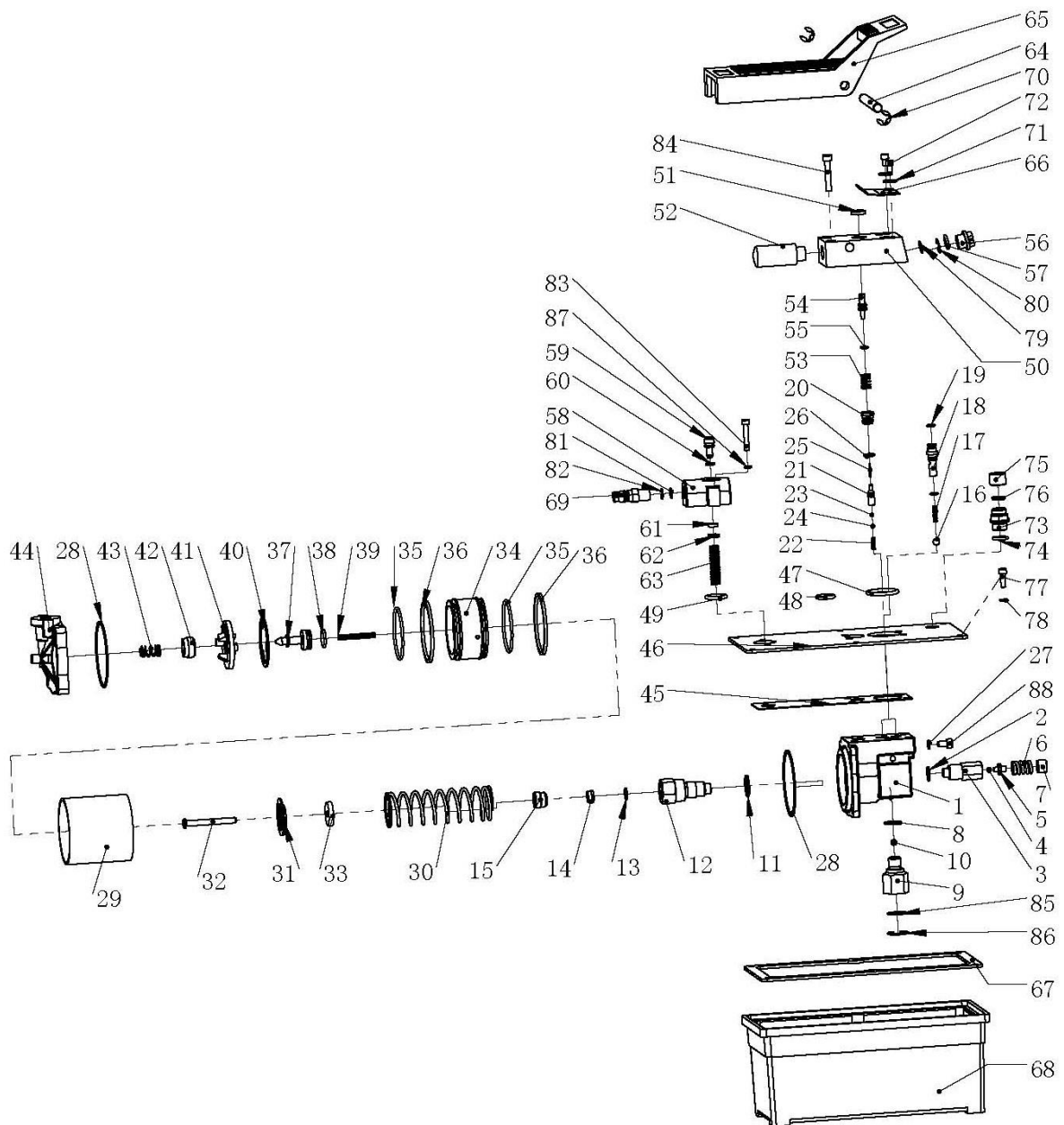
- 6.5.1 When not in use, depressurise and disconnect the hydraulic power unit from the application.
- 6.5.2 Wipe clean thoroughly and store in a clean, dry environment. Avoid temperature extremes.
- 6.5.3 Close the air vent for transportation or long storage.
- 6.5.4 Shield power unit with a protective cover.

**7.0 Troubleshooting**

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
<b>Application does not extend, move or respond to pressurised fluid</b>	Overload condition	<ul style="list-style-type: none"> <li>• Remedy overload condition</li> </ul>
	Loose couplers	<ul style="list-style-type: none"> <li>• Tighten couplers</li> </ul>
	Faulty couplers	<ul style="list-style-type: none"> <li>• Replace couplers</li> </ul>
	Malfunctioning power unit	<ul style="list-style-type: none"> <li>• Contact a Durapac authorised service centre</li> <li>• Repair or replace as necessary</li> </ul>
<b>Application responds to pressurised fluid, but system does not maintain pressure</b>	Inadequate air supply	<ul style="list-style-type: none"> <li>• Ensure air source can dedicate 7.8 cfm @ 4-12 bar/60-175 psi</li> </ul>
	Overload condition	<ul style="list-style-type: none"> <li>• Remedy overload condition</li> </ul>
	Malfunctioning power unit or valve	<ul style="list-style-type: none"> <li>• Contact a Durapac authorised service centre</li> <li>• Repair or replace as necessary</li> </ul>
<b>Application responds slower than normal</b>	Leaking application/connection	<ul style="list-style-type: none"> <li>• Replace application/connection</li> </ul>
	Loose connection or coupler	<ul style="list-style-type: none"> <li>• Tighten connection or coupler</li> </ul>
<b>Application does not return fluid to power unit (i.e. cylinder will not retract)</b>	Restricted hydraulic line or fitting	<ul style="list-style-type: none"> <li>• Clean and replace if damaged</li> </ul>
	Leaking application/connection	<ul style="list-style-type: none"> <li>• Replace application/connection</li> </ul>
	Malfunctioning coupler/damaged application	<ul style="list-style-type: none"> <li>• Secure load by other means</li> <li>• Depressurise power unit and hose</li> <li>• Remove coupler and/or application</li> <li>• Repair or replace as necessary</li> </ul>
<b>Application does not fully extend (cylinder or spreader)</b>	Overfilled reservoir	<ul style="list-style-type: none"> <li>• Secure load by other means</li> <li>• Depressurise power unit and hose</li> <li>• Remove application</li> <li>• Drain fluid to proper level</li> </ul>
	Low fluid level in power unit	<ul style="list-style-type: none"> <li>• Secure load by other means</li> <li>• Depressurise power unit and hose</li> <li>• Remove application</li> <li>• Fill fluid to proper level</li> </ul>
<b>Poor performance</b>	Low fluid level in power unit	<ul style="list-style-type: none"> <li>• Ensure proper fluid level</li> </ul>



**8.0 Parts Breakdown**



Note: Not all components of the power unit are replacement items but are illustrated as a convenient reference of location and position in the assembly sequence.

**9.0 Parts List**

Item	Description	Part No.	Qty	Item	Description	Part No.	Qty
1	Piston pump body	ZCZ1001	1	46	Reservoir cover	ZCZ1046	1
2	Relief valve	ZCZ1002	1	47	Oil outlet o-ring*	ZCZ1047	1
3	Relief valve body	ZCZ1003	1	48	Air vent o-ring*	ZCZ1048	1
4	Relief valve one-way valve*	ZCZ1004	1	49	Air inlet o-ring*	ZCZ1049	1
5	Relief valve ball holder	ZCZ1005	1	50	Oil outlet valve block	ZCZ1050	1
6	Relief valve spring*	ZCZ1006	1	51	Anti-dust ring	ZCZ1051	1
7	Adjustment plug	ZCZ1007	1	52	Muffler	ZCZ1052	1
8	Copper washer	ZCZ1008	1	53	Oil drain spring*	ZCZ1053	1
9	Suction filter	ZCZ1009	1	54	Oil drain switch	ZCZ1054	1
10	Suction filter one-way valve*	ZCZ1010	1	55	Oil drain pressure bar o-ring*	ZCZ1055	1
11	Copper washer	ZCZ1011	1	56	Oil port end cap	ZCZ1056	1
12	Piston body	ZCZ1012	1	57	Oil port end cap o-ring	ZCZ1057	1
13	Piston seal washer*	ZCZ1013	1	58	Air inlet valve body	ZCZ1058	1
14	Piston seal washer*	ZCZ1014	1	59	Air inlet switch	ZCZ1059	1
15	Front cover	ZCZ1015	1	60	Air inlet switch o-ring*	ZCZ1060	1
16	Oil outlet one-way valve*	ZCZ1016	1	61	Washer*	ZCZ1061	1
17	Spring*	ZCZ1017	1	62	Air inlet seal washer cap	ZCZ1062	1
18	Pressure stem	ZCZ1018	1	63	Air inlet spring*	ZCZ1063	1
19	HP nozzle o-ring*	ZCZ1019	2	64	Pin	ZCZ1064	1
20	Oil drain valve	ZCZ1020	1	65	Foot pedal	ZCZ1065	1
21	Oil drain valve spool	ZCZ1021	1	66	Return spring	ZCZ1066	1
22	Oil drain valve spring*	ZCZ1022	1	67	Reservoir seal washer*	ZCZ1067	1
23	Oil drain one way valve*	ZCZ1023	1	68	Reservoir	ZCZ1068	1
24	Oil drain ball holder*	ZCZ1024	1	69	Air inlet connector	ZCZ1069	1
25	Oil drain thimble*	ZCZ1025	1	70	Snap ring	ZCZ1070	2
26	Oil drain valve o-ring*	ZCZ1026	1	71	Washer	ZCZ1071	2
27	Copper washer	ZCZ1027	1	72	Bolt	ZCZ1072	2
28	Air cylinder seal ring*	ZCZ1028	2	73	Breathing valve	ZCZ1073	1
29	Cylinder bore	ZCZ1029	1	74	O-ring	ZCZ1074	1
30	Piston return spring*	ZCZ1030	1	75	Breathing cap	ZCZ1075	1
31	Piston stop plate	ZCZ1031	1	76	Seal	ZCZ1076	1
32	Pump piston	ZCZ1032	1	77	Bolt	ZCZ1077	1
33	Washer*	ZCZ1033	1	78	Nylon washer	ZCZ1078	1
34	Large piston	ZCZ1034	1	79	Oil return filter*	ZCZ1079	1
35	Large piston o-ring*	ZCZ1035	2	80	Snap ring	ZCZ1080	1
36	Large piston seal*	ZCZ1036	2	81	Air inlet filter	ZCZ1081	1
37	Small piston	ZCZ1037	1	82	Snap ring	ZCZ1082	1
38	Small piston o-ring*	ZCZ1038	1	83	Bolt	ZCZ1083	1
39	Small piston return spring*	ZCZ1039	1	84	Bolt	ZCZ1084	1
40	Large piston seal washer*	ZCZ1040	1	85	Filter	ZCZ1085	1
41	Large piston cover	ZCZ1041	1	86	Snap ring	ZCZ1086	1
42	Small piston seal washer*	ZCZ1042	1	87	Spring washer	ZCZ1087	1
43	Cylinder head spring*	ZCZ1043	1	88	Bolt	ZCZ1088	1
44	Back cover	ZCZ1044	1	*	Repair kit	ZCZ1089	1
45	Pump cover seal washer*	ZCZ1045	1		Oil Drain Assembly Kit	ZCZ1000	1

Items marked with a \* are contained within a standard Repair Kit.  
Serial, model and part numbers need to be quoted when ordering parts.