

**DURAPAC**  
ENGINEERED FOR RELIABILITY

# Instruction Manual

Reciprocating Air Hydraulic Power Unit  
Model – DPA-18



**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-18 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.

- 1.8 L usable oil reservoir
- 3 position treadle for adv/hold/retract functions
- Treadle may be operated by hand or foot for greater versatility
- Release detent function enhances productivity
- Convenient carry handle included
- Recommended air pressure range 4-12 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 a particular 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 have an understanding of 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-18	S/A	3/8"-NPTF	1,800	700	1,240	160	4-12	8.2

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 @ 4-12 bar/60-175 psi to each power unit being operated.

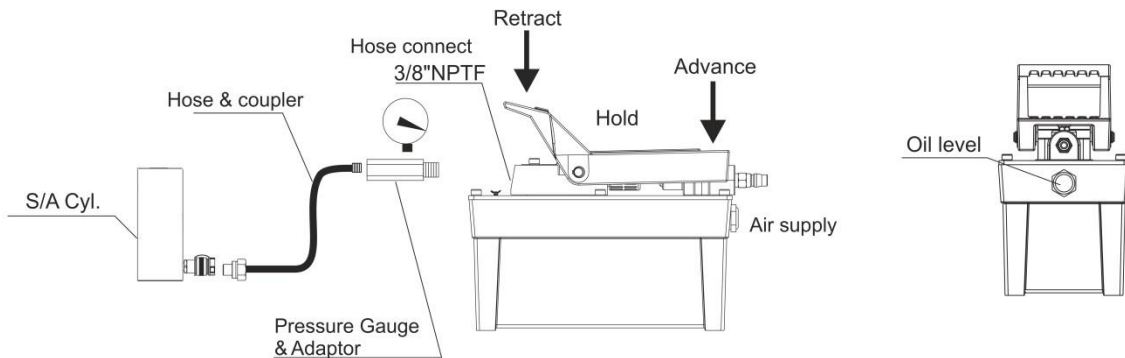


Figure 1 - DPA-18

- 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.
- 4.6 **Priming the Pump** - Press the retract end of the pedal while holding down the air intake valve with a hexagonal wrench. The air intake valve is located directly under the pedal. Allow the pump to cycle approximately 15 seconds. Remove the wrench and press the advance end of the pedal. If the cylinder extends or pressure builds, the pump has been successfully primed. If the pump does not respond, repeat the procedure, jogging the intake valve while holding the pedal in the retract position.

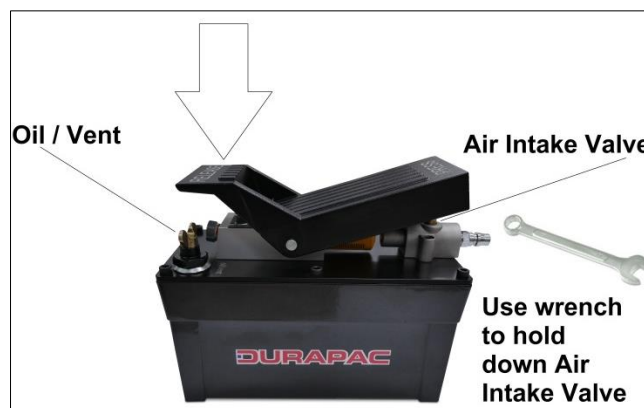


Figure 2 – Priming the Pump

## 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 Pump without an Air Regulator

- 5.1.1 To extend the cylinder, depress the “Advance” end of the pedal until desired pressure, load or position is reached.
- 5.1.2 To hold the cylinder in position, release the “Advance” end of the pedal to deactivate the power unit.
- 5.1.3 To retract the cylinder, depress the “Retract” end of the pedal.

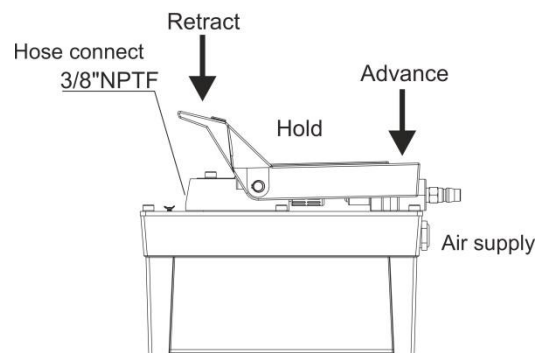


Figure 3 – Operation

### 5.2 Pump with an Air Regulator

- 5.2.1 Open the air shut-off valve or connect the air quick coupler. **Note** - Under certain circumstances the pump may need to be primed before operation. Refer to 4.7 - Priming the Pump in the Installation Section.
- 5.2.2 Slowly turn the air regulator control on the unit; **clockwise to increase** pressure, **counter-clockwise to decrease** pressure. As air enters the pump, it will begin to deliver fluid to the system.
- 5.2.3 Continue to slowly turn the air regulator control clockwise until the unit gauge reaches the maximum hydraulic pressure rating. A maximum hydraulic pressure reading should be obtained if air pressure is approximately 10 bar.
- 5.2.4 Shut off and disconnect the air supply to the pump to release all system pressure. Check fluid level when the hydraulic system is retracted.
- 5.2.5 The pump is now ready for operation.

## 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 pump fully retracted 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 top of the reservoir.
- 6.1.3 Use a small funnel to fill the reservoir to within 12.7 mm (0.5 ") from the oil/vent cap.
- 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 on a daily basis, it is recommended that an inline oiler and air dryer is installed and SAE grade oil (5W to 30W) is used. Set the unit to feed approximately one drop of oil per minute into the system.

#### **6.5 Storage**

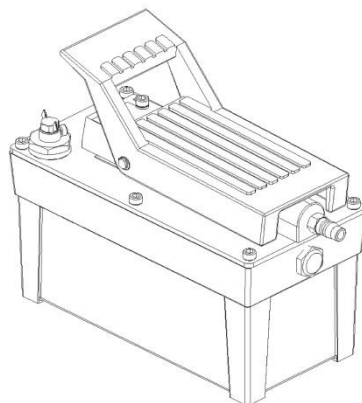
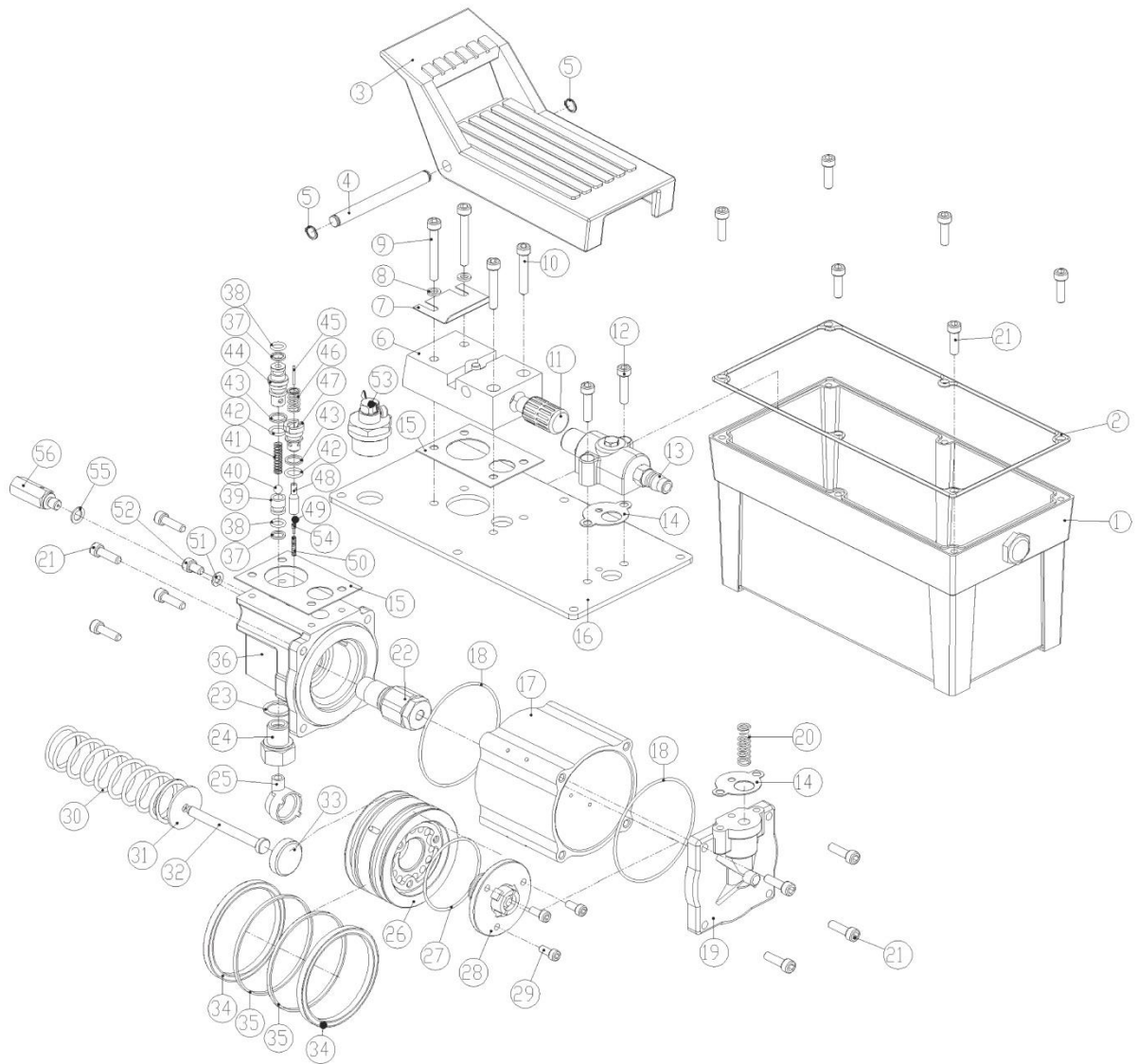
- 6.5.1 When not in use, depressurise and disconnect the hydraulic power unit from the application.
- 6.5.2 Wipe clean thoroughly and store in a clean, dry environment. Avoid temperature extremes.
- 6.5.3 For transportation or long storage, replace the air vent plug with shipping plug.
- 6.5.4 Shield 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>
	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>
	Pump not primed	<ul style="list-style-type: none"> <li>Prime pump as per 4.7 - Priming the Pump in the Installation Section</li> </ul>
<b>Application responds to pressurised fluid, but system does not maintain pressure</b>	Fluid intake filter contaminated	<ul style="list-style-type: none"> <li>Remove reservoir, clean intake filter and reinstall</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>
	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>
<b>Application does not return fluid to power unit (i.e. cylinder will not retract)</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>
	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>Excess oil spray from muffler</b>	Air lubricator is set too high	<ul style="list-style-type: none"> <li>Set at one drop per minute</li> </ul>

**8.0 Parts Breakdown**



## 9.0 Parts List

Item	Description	Part No.	Qty	Item	Description	Part No.	Qty
1	Oil tank	ZAM2339	1	30	Spring	ZAM2365	1
2	Reservoir spacer*	ZAM2340	1	31	Washer	ZAM2366	1
3	Peddle	ZAM2341	1	32	Rod	ZAM2367	1
4	Plug	ZAM2342	1	33	Washer	ZAM1221	1
5	C type ring	ZAM2343	2	34	Seal*	ZAM2368	2
6	Outlet block	ZAM2344	1	35	Wear ring*	ZAM2369	2
7	Block	ZAM2345	1	36	Body	ZAM2370	1
8	Washer	ZAM2346	2	37	Back-up ring*	ZAM1162	2
9	Bolt	ZAM2347	2	38	O-ring*	ZAM1183	2
10	Bolt	ZAM1894	2	39	Outlet bush	ZAM2371	1
11	Silencer	ZAM2348	1	40	Steel ball*	ZAM1273	1
12	Bolt	ZAM2117	2	41	Spring	ZAM2372	1
13	Switch gear	ZAM2349	1	42	O-ring*	ZAM2373	2
14	Spacer*	ZAM2350	2	43	Back-up ring*	ZAM1834	2
15	Spacer*	ZAM2351	2	44	Outlet shaft	ZAM2374	1
16	Base plate	ZAM2352	1	45	Fixing plug	ZAM2375	1
17	Cylinder	ZAM2353	1	46	Spring	ZAM2376	1
18	O-ring*	ZAM2354	2	47	Pressure relief	ZAM2377	1
19	Motor cover	ZAM2355	1	48	Return shaft	ZAM2378	1
20	Spring	ZAM2356	1	49	Steel ball	ZAM1212	1
21	Bolt	ZAM1840	14	50	Spring	ZAM2379	1
22	Pump assembly	ZAM2357	1	51	Cu washer*	ZAM2380	1
23	Cu washer	ZAM2358	1	52	Bolt	ZAM2381	1
24	Oil path block	ZAM2359	1	53	Vent assembly	ZAM2382	1
25	Filter net	ZAM2360	1	54	Ball pedestal	ZAM2383	1
26	Piston	ZAM2361	1	55	Cu washer	ZAM1766	1
27	O-ring*	ZAM2362	1	56	Relief valve	ZAM2384	1
28	Piston plate	ZAM2363	1		Repair kit	ZAM2385	1
29	Bolt	ZAM2364	3				

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