



# Instruction Manual

Roll Frame Press  
Model – HRP Series



**Note – This Roll  
Frame Press is  
shown with the  
Optional  
Shielding Frame**

**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 – Roll Frame Presses are engineered to meet Industrial Standards for Performance and Safety. The HRP Series is designed to allow the rolling frame to roll across the press bed for easy loading of large bulky items. The frame is welded for maximum strength and durability.

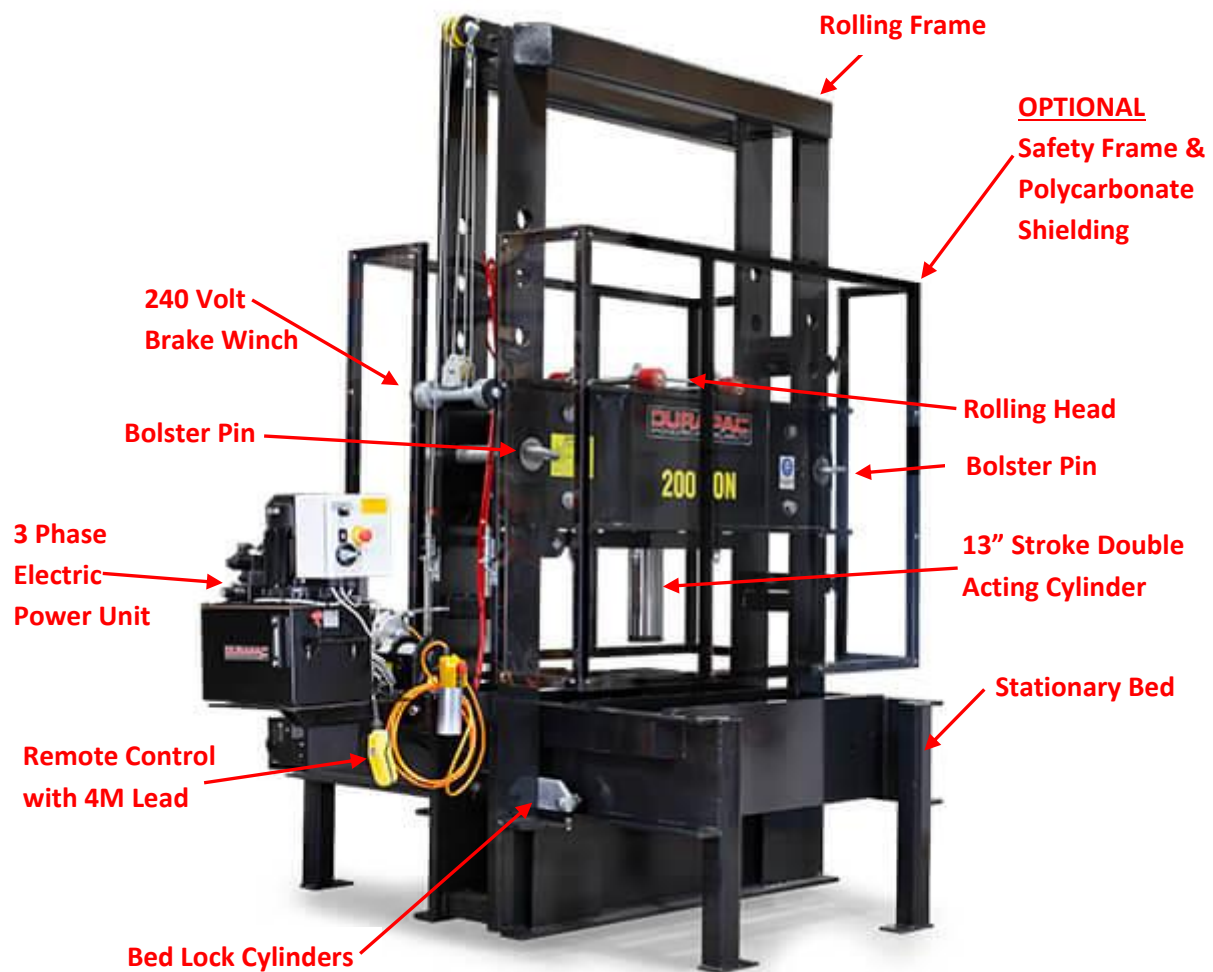
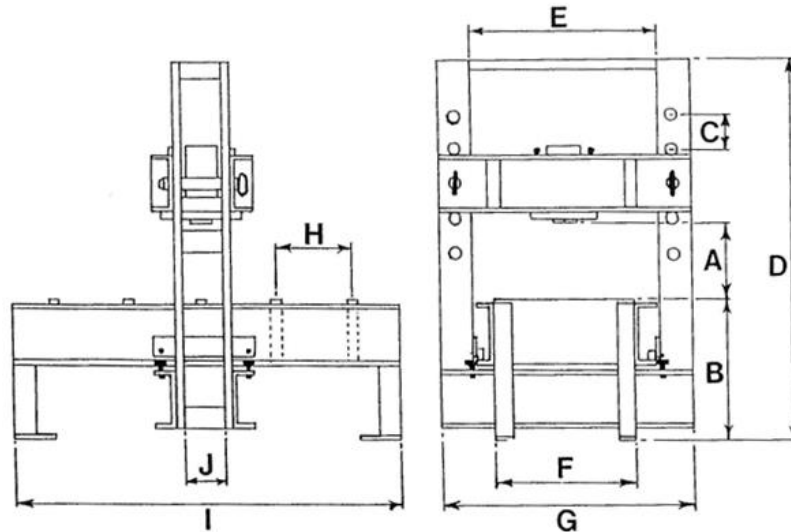


Figure 1 – Press Frame Components

Figure 2 - Press Frame Dimensions



Press Model	A		B	C	D	E	F	G	H	I	J
	Min.	Max.									
HRP-50	300	1,300	800	200	2,720	1,000	800	1,200	340	2,000	200
HRP-100	300	1,300	800	200	2,720	1,000	800	1,300	340	2,000	200
HRP-150	300	1,300	800	200	2,900	1,025	800	1,400	340	2,000	225
HRP-200	300	1,300	800	200	2,900	1,025	800	1,300	340	2,000	220

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 Roll Frame Presses 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 Roll Frame Press 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 press 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 Presses

- Work pieces must be well supported and aligned so when pressure is exerted; parts being pressed do not slip out or break
- To prevent accidental slippage, do not place work pieces on the press bed, or apply hydraulic force until all bolster pins are in place and all tension has been removed from the bolster lift cables
- **Do NOT** overload equipment. Overloading can cause equipment failure and possible personal injury. The presses are designed for a maximum pressure of 700 bar
- **Do NOT** stress adapters beyond their capacities. Any pushing or pulling adapters used with this press must have a maximum tonnage rating equal to, or higher than, the maximum tonnage rating of the press, or breakage can occur
- The operator of the press must use appropriate shielding for each application. Some additional safety can be provided by wrapping the piece in a protective blanket before applying pressure. Durapac can supply **optional “general purpose” shielding that may be used in many different applications. This shielding is a steel frame with polycarbonate clear sheets.** Consult Durapac for further information

### 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 pump, 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 pump 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:**

- The press is shipped fully assembled. It is fitted with a removable steel beam to secure the rolling frame assembly to the press bed. Once the roll frame press is securely mounted in its final position, remove this steel beam
- **Do NOT** adjust safety valve pressure – safety valve pressure is set at 700 bar (10,000 psi)
- Ensure the press is securely mounted on level concrete. Unstable positioning may result in injury or equipment damage

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

Press Model	Capacity		Stroke (mm)	Pump Model	Cylinder Model
	Ton	kN			
HRP-50	50	498	334	PES3024	RD-5013
HRP-100	100	933	333	PES3024	RD-10013
HRP-150	150	1,386	333	PES3024	RD-15013
HRP-200	200	1,995	330	PES3024	RD-20013

- 4.2 Refer to the attached instruction manual for the PES3024, 3 phase *either* 3.0 kW, 415 Volt, 50 Hz **OR** 3.6 kW, 440-480 Volt, 60 Hz Power Unit. Ensure a qualified electrician installs a suitable 3 phase electrical plug and confirm the rotation of the motor is as per the directional arrow on the motor shroud.
- 4.3 Check oil level in the reservoir before operating the pump.
- 4.4 Check all system fittings and connections to be sure they are tight and leak free.

## 5.0 Operation



**IMPORTANT:**

- It is mandatory that the operator has a full understanding of all instructions, safety regulations, cautions and warnings, before starting to operate any of this high force tool equipment
- To reduce the risk of personal injury and/or property damage, hydraulic connections must be securely fastened before building pressure in the system. Release all system pressure before loosening any hydraulic connection in the system
- Remove all weight from the bolster before raising or lowering
- Always monitor pressure, load or position using suitable equipment. Pressure may be monitored by means of a manifold and gauge. Correct application position can only be determined by the operator of the equipment
- **Do NOT** operate the press while the cables are under tension
- When using your press, set the bed height to a minimum distance to carry out the procedure. Place appropriate supports under the job ie. press plates or V blocks.

Ensure the load cap or tooling is centrally located

### 5.1 Operating the Electric Power Unit and Hand Pump

Refer to the pump/power unit instruction manuals for information on installation and operation.

### 5.2 Adjusting the Bolster Position

**⚠ CAUTION:** Never check the alignment of the bolster pin holes by inserting fingers or any part of your body into the holes. This could act as a guillotine and cause serious injury

- 5.2.1 While holding and applying twisting motion to the bolster pin (closest to the electric power unit) jog the electric brake winch to tension the bolster cable.
- 5.2.2 As the bolster weight is transferred from the pin to the cable the bolster pin can be removed.
- 5.2.3 Once the first bolster pin is removed, remove the second bolster pin.
- 5.2.4 Once both bolster pins are fully removed, continue to jog the electric brake winch remote pendant switch to adjust to the desired position.
- 5.2.5 Once both pins are fully inserted, remove any tension on the electric brake winch cable.

### 5.3 Inserting Bolster Pins

- 5.3.1 Always insert the bolster pin furthest away from the electric pump first.
- 5.3.2 Jog the electric brake winch until the holes in the rolling frame and bolster are aligned.
- 5.3.3 Insert the pin using a slight twisting motion.
- 5.3.4 Once the pin is fully inserted, proceed to install the bolster pin nearest the electric pump.
- 5.3.5 In this case, the electric brake winch will be jogged downwards to align the rolling frame and bolster holes.

### 5.4 Positioning the Hydraulic Cylinder

**⚠** Items not aligned with the centre of the cylinder are unstable under pressure/load and can be ejected out of the press, causing serious personal injury or equipment damage

- 5.4.1 Loosen the lock nuts under the bolster. Do not fully remove them
- 5.4.2 Holding the cylinder mounting block, push the cylinder assembly left or right to the desired location.
- 5.4.3 Tighten the lock nuts to ensure cylinder can no longer move left or right.

## 5.5 Positioning the Press Frame



Figure 3 – Press Frame Lock

- 5.5.1 Gradually open the release valve on the rolling frame-mounted hand pump. The two cylinders on the rolling frame will retract and the press bed will rest on the rollers.
- 5.5.2 Move the rolling press frame by pushing it to the desired position along the stationary bed length.
- 5.5.3 Close the release valve and stroke the rolling frame-mounted hand pump until the bed no longer rests on the rollers.

## 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 pump, 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 or tools 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 Use a small funnel to fill the reservoir to within 20 mm (3/4") of the opening.
- 6.1.3 Bleed air from system if necessary.
- 6.1.4 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 pump reservoir.
- 6.2.3 Extend and retract the cylinder several times without putting a load on the system. Air will be released into the pump 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 Storage

- 6.4.1 When not in use, depressurise and disconnect the hydraulic press from the application.
- 6.4.2 Wipe clean thoroughly and store in a clean, dry environment. Avoid temperature extremes.
- 6.4.3 For transportation or long storage, replace the air vent plug with shipping plug.
- 6.4.4 Shield press with a protective cover.

**7.0 Troubleshooting**

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
<b>Cylinder moves but does not maintain pressure</b>	Leaking connection	<ul style="list-style-type: none"> <li>• Clean, reseal with thread sealant and tighten connection</li> </ul>
	Leaking cylinder seals	<ul style="list-style-type: none"> <li>• Replace worn seals</li> <li>• Check for excessive contamination or wear</li> <li>• Replace contaminated fluid as necessary</li> </ul>
	Pump/valve malfunctioning	<ul style="list-style-type: none"> <li>• Check pump or valve operating instructions</li> </ul>
<b>Cylinder leaks hydraulic fluid</b>	Worn or damaged seals	<ul style="list-style-type: none"> <li>• Replace worn seals</li> <li>• Check for excessive contamination or wear</li> <li>• Replace contaminated fluid as necessary</li> </ul>
	Loose connections	<ul style="list-style-type: none"> <li>• Clean, reseal with thread sealant and tighten connection</li> </ul>
<b>Cylinder will not retract or retracts slower than normal</b>	Closed pump release valve	<ul style="list-style-type: none"> <li>• Open pump release valve</li> </ul>
	Loose couplers	<ul style="list-style-type: none"> <li>• Tighten couplers</li> </ul>
	Blocked hydraulic lines	<ul style="list-style-type: none"> <li>• Clean and flush</li> </ul>
	Weak or broken retraction springs	<ul style="list-style-type: none"> <li>• Send to service centre for repair</li> </ul>
	Internally damaged cylinder	<ul style="list-style-type: none"> <li>• Send to service centre for repair</li> </ul>
	Pump reservoir too full	<ul style="list-style-type: none"> <li>• Drain hydraulic fluid to correct level</li> </ul>
<b>Erratic Action</b>	Air in the system or pump cavitation	<ul style="list-style-type: none"> <li>• Add fluid, bleed air and check for leaks as described in the Maintenance Section</li> </ul>
	External leakage	<ul style="list-style-type: none"> <li>• Replace worn packings</li> <li>• Check for excessive contamination fluid as necessary</li> </ul>
	Sticking or binding cylinder	<ul style="list-style-type: none"> <li>• Check for dirt or leaks</li> <li>• Check for bent, misaligned, worn parts or defective packings</li> </ul>
<b>Cylinder does not move</b>	Loose couplers	<ul style="list-style-type: none"> <li>• Tighten couplers</li> </ul>
	Faulty coupler	<ul style="list-style-type: none"> <li>• Verify that female coupler is not locked up (ball wedged into seat)</li> <li>• Replace both male and female couplers</li> </ul>
	Improper valve position	<ul style="list-style-type: none"> <li>• Close release valve or shift to new position</li> </ul>
	Low or no hydraulic fluid in pump reservoir	<ul style="list-style-type: none"> <li>• Fill and bleed the system as described in the Maintenance Section</li> </ul>

Problem	Cause	Solution
	Air-locked pump	<ul style="list-style-type: none"> <li>• Prime pump as described in 6.2 – Bleeding Air from the System in the Maintenance Section</li> </ul>
	Pump not operating	<ul style="list-style-type: none"> <li>• Check the Operation Section for the pump’s operating instructions</li> </ul>
	Load is above the capacity of the system	<ul style="list-style-type: none"> <li>• Use the correct equipment</li> </ul>
<b>Cylinder extends only partially</b>	Low or no hydraulic fluid in pump reservoir	<ul style="list-style-type: none"> <li>• Fill and bleed the system as described in the Maintenance Section</li> </ul>
	Load is above the capacity of the system	<ul style="list-style-type: none"> <li>• Use the correct equipment</li> </ul>
	Sticking or binding cylinder	<ul style="list-style-type: none"> <li>• Check for dirt or leaks</li> <li>• Check for bent, misaligned, worn parts or defective packings</li> </ul>
<b>Cylinder moves slower than normal</b>	Loose couplers	<ul style="list-style-type: none"> <li>• Tighten couplers</li> </ul>
	Restricted hydraulic line or fitting	<ul style="list-style-type: none"> <li>• Clean and replace if damaged</li> </ul>
	Pump not operating correctly	<ul style="list-style-type: none"> <li>• Check the Operation Section for the pump’s operation instructions</li> </ul>
	Leaking cylinder seals	<ul style="list-style-type: none"> <li>• Replace worn seals</li> <li>• Check for excessive contamination or wear</li> <li>• Replace contaminated fluid as necessary</li> </ul>



# Instruction Manual

30 Series Auto, 2 Speed Electric Power Unit  
Model – PES3024



**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 – 30 Series Auto 2 Speed Power Units are engineered to meet Industrial Standards for Performance and Safety. The PES3024 features a two-speed pump with a 4-way solenoid valve and remote pendant to actuate advance/hold/retract functions on double acting cylinders and tools and is ideal for operating medium to large tonnage cylinders and systems.

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 blocked 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 protective gear 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 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

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	kW	Voltage (3 Ph.)	Hz	Amps	Usable Oil Capacity (L)	Max. Pressure Rating (bar)	Flow Rate (Lpm)		Solenoid Remote Pendant Function 4 mtr	Used with Cylinder	Approx. Dry Weight (kg)
							100 bar	700 bar			
PES3024	3.0	415	50	6.4	20	700	10.5	2.1	Adv/Hold/Retract	D/A	77
PES3024-440V	3.6	440-480	60	6.3	20	700	12.5	2.5	Adv/Hold/Retract	D/A	77

- 4.2 Remove the manifold plug and then connect oil output port to suitable fittings and application/cylinder. Check all system fittings and connections to be sure they are tight and leak free.
- 4.3 Check oil level in reservoir before operating the power unit.
- 4.4 Ensure a **clockwise motor rotation** when motor is viewed from the fan end.
- 4.5 Remove air from the system – Position the cylinder/nut splitter/spreader so that the piston rod is pointed down and the cylinder is lower than the power unit. Advance and retract the cylinder several times, avoiding pressure build-up. Air removal is complete when the cylinder motion is smooth.



## 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. 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 Starting the Power unit

- 5.1.1 Turn the motor power ON/OFF button to the ON position.
- 5.1.2 Switch the RUN/STOP switch to the RUN position to start the electric motor.

### 5.2 Lifting

- 5.2.1 To advance the cylinder, press the ↑ arrow on the remote pendant. Fluid will flow from the “A” port of the subplate.
- 5.2.2 To stop advancing the cylinder, release the ↑ arrow on the remote pendant.

### 5.3 Lowering

To retract the cylinder, press the ↓ arrow on the remote pendant. Fluid will flow from “B” port of the subplate.

### 5.4 Pressure Adjustment

The directional control valve subplate is fitted with an adjustable pressure relief valve. The operator can dial in the maximum desired pressure required for the application at hand. The pressure adjusting range is from 0-700 bar.

## 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 Storage

- 6.4.1 When not in use, depressurise and disconnect the power unit from the application.
- 6.4.2 Wipe clean thoroughly and store in a clean, dry environment. Avoid temperature extremes.
- 6.4.3 For transportation or long storage, replace the air vent plug with shipping plug.
- 6.4.4 Shield power unit with a protective cover.

**7.0 Troubleshooting**

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
<b>Motor will not start</b>	Inadequate or faulty electrical supply	<ul style="list-style-type: none"> <li>• Check the condition of the power unit’s power cord.</li> <li>• Check the condition of extension cords</li> <li>• Check for tripped circuit breaker. Be sure breaker is of adequate size</li> <li>• Contact a qualified electrician for any necessary repairs</li> </ul>
<b>Noisy operation</b>	Air trapped in system	<ul style="list-style-type: none"> <li>• Check all points where air may leak into the system</li> <li>• Refer to 6.2 – Bleeding Air from the System</li> </ul>
	Power unit reservoir too full	<ul style="list-style-type: none"> <li>• Drain fluid to correct level</li> </ul>
	Low fluid level in power unit reservoir	<ul style="list-style-type: none"> <li>• Refer to 6.1 – Adding Hydraulic Fluid</li> <li>• Fill and bleed the system</li> </ul>
<b>Power unit oil is over-heating</b>	Oil viscosity is too high	<ul style="list-style-type: none"> <li>• Refer to 6.3 – Changing Hydraulic Fluid</li> <li>• Refill with a good quality hydraulic oil</li> </ul>
	Low fluid level in power unit reservoir	<ul style="list-style-type: none"> <li>• Refer to 6.1 – Adding Hydraulic Fluid</li> <li>• Fill and bleed the system</li> </ul>
<b>Power unit runs but will not power unit oil</b>	Power unit is not primed	<ul style="list-style-type: none"> <li>• Run power unit a few minutes tipping from side to side</li> </ul>
	Externally adjustable relief valve is not correctly set	<ul style="list-style-type: none"> <li>• Reset the relief valve to appropriate level</li> </ul>
	Damaged o-ring	<ul style="list-style-type: none"> <li>• Send to a Durapac authorised service centre for repair</li> </ul>
	Defective control valve	<ul style="list-style-type: none"> <li>• Send to a Durapac authorised service centre for repair</li> </ul>
<b>Power unit does not reach rated capacity</b>	Low fluid level in reservoir	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then fill and bleed the system</li> </ul>
	Leaking system components	<ul style="list-style-type: none"> <li>• Repair or replace as necessary</li> </ul>
<b>Poor performance</b>	Fluid level in power unit is low	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then fill and bleed the system</li> </ul>
<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 for repair</li> </ul>

Problem	Cause	Solution
Application does not fully extend (cylinder or tools)	Reservoir overfilled	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then drain fluid to proper level</li> </ul>
	Low fluid level in power unit reservoir	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then fill and bleed the system</li> </ul>
	Load above capacity of system	<ul style="list-style-type: none"> <li>• Use correct equipment</li> </ul>
Application responds slower than normal	Loose connection or coupler	<ul style="list-style-type: none"> <li>• Tighten couplers</li> </ul>
	Restricted hydraulic line or fitting	<ul style="list-style-type: none"> <li>• Clean and replace if damaged</li> </ul>
	Power unit not operating correctly	<ul style="list-style-type: none"> <li>• Check power unit's operating instructions</li> <li>• Repair or replace as necessary</li> </ul>
	Low fluid level in power unit reservoir	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then fill and bleed the system</li> </ul>
Application responds to pressurised fluid, but system does not maintain pressure	Leaky connection	<ul style="list-style-type: none"> <li>• Clean, reseal with thread sealant, and tighten connection</li> </ul>
	Leaking cylinder seals	<ul style="list-style-type: none"> <li>• Replace worn seals. Look for excessive contamination or wear. Replace contaminated fluid</li> </ul>
	Power unit or valve not operating correctly	<ul style="list-style-type: none"> <li>• Contact a Durapac authorised service centre for repair</li> </ul>
	Overload condition	<ul style="list-style-type: none"> <li>• Remedy overload condition</li> </ul>
Application does not return fluid to power unit (i.e. cylinder will not retract)	Closed release valve	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Open release valve</li> </ul>
	Loose couplers	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Tighten couplers</li> </ul>
	Blocked hydraulic lines	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Clean and flush lines</li> </ul>
	Weak or broken retraction springs	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Contact a Durapac authorised service centre for repair</li> </ul>
	Internally damaged cylinder	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Contact a Durapac authorised service centre for repair</li> </ul>
	Power unit reservoir too full	<ul style="list-style-type: none"> <li>• <b>Secure load by other means.</b></li> <li>• Depressurise power unit and hose, remove application, then drain fluid to proper level</li> </ul>