



Operation and Maintenance Manual

XLP-Series 25 ton Workshop Presses

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To reduce the risk of injury, user must read and understand this document before use.

ABOUT US

Enerpac is a global market leader in high pressure hydraulic tools, controlled force products, portable machining, on-site services and solutions for precise positioning of heavy loads. As a leading innovator with over a 100 year legacy, Enerpac has helped move and maintain some of the largest structures on earth. When safety and precision matter, elite professionals in industries such as aerospace, infrastructure, manufacturing, mining, oil & gas and power generation rely on Enerpac for quality tools, services and solutions. For additional information, visit www.enerpac.com.



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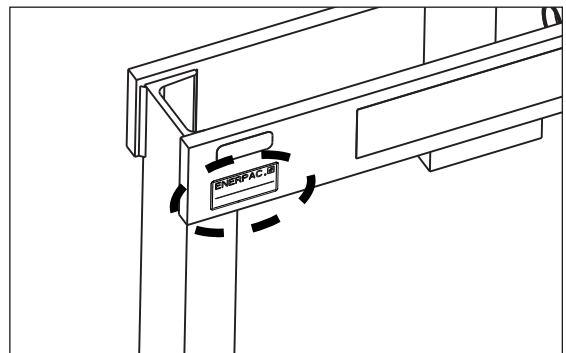
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WARRANTY

Refer to the Enerpac Global Warranty document for terms and conditions of the product warranty. Such warranty information can be found at www.enerpac.com.

NAMEPLATE

Refer to the nameplate decal for the press model number. Decal appearance and text may vary depending on location of product manufacture.



AVAILABLE LANGUAGES

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1. Safety

Read all instructions carefully. Follow all recommended safety precautions to avoid personal injury as well as damage to the product and / or damage to other property. Enerpac cannot be responsible for any damage or injury from unsafe use, lack of maintenance, or incorrect operation. Do not remove warning labels, tags, or decals. In the event that any questions or concerns arise, contact Enerpac or a local Enerpac distributor for clarification.

Save these instructions for future use.

If you have never been trained on high-pressure hydraulic safety, consult your distributor or service center for information about Enerpac hydraulic safety courses.

This manual follows a system of safety alert symbols, signals, words, and safety messages to warn the user of specific hazards. Failure to comply with these warnings could result in death or serious personal injury, as well as damage to the equipment or other property.



The Safety Alert Symbol appears throughout this manual. It is used to alert you to potential physical injury hazards. Pay close attention to Safety Alert Symbols and obey all safety messages that follow this symbol to avoid the possibility of death or serious injury.

Safety Alert Symbols are used in conjunction with certain Signal Words that call attention to safety messages or property damage messages and designate a degree or level of hazard seriousness. The Signal Words used in this manual are WARNING, CAUTION, and NOTICE.

WARNING Indicates a hazardous situation that, if not avoided, could result in death or serious personal injury.

CAUTION Indicates a hazardous situation that, if not avoided, could result in minor or moderate personal injury.

NOTICE Indicates information considered important, but not hazard related (e.g. messages related to property damage). Please note that the Safety Alert Symbol will not be used with the signal word.

1.1 Hydraulic Press Safety Precautions

WARNING

Failure to observe and comply with the following precautions could result in death or serious personal injury. Property damage could also occur.

- Ensure force application point on workpiece is centered under the press cylinder and that the entire cylinder saddle is in contact with the workpiece.
- Avoid side loading the press cylinder and workpiece as significant damage or physical injury could occur.
- Where possible, use a safety screen for safety purposes.
- Ensure the material placed on the press bed is rated for press capacity.
- Verify hydraulic components (pump, cylinder, hoses, and accessories) remain in good working condition.
- Use only accessories (such as press plates and V-Blocks) of adequate design and sufficient rating to safely secure the workpiece during application. Use of Enerpac V-Blocks (Model VB-25 - optional accessory) is strongly recommended.
- Do not use the press for pulling applications. The XLP-Series Hydraulic Press is designed *only* for pressing applications.
- Do not position or hold workpieces when load is being applied or while workpieces are under load.
- Keep all body parts away from the press cylinder and workpieces while press is in use.
- Ensure that press frame is secured to the floor, workbench or other solid surface.
- Ensure area around the press is safe and secure before operating press.
- Ensure proper personal protective equipment (PPE) is in place when using the press.
- Be certain that the operator has read and understood all operating instructions provided with the press, pump and all accessories.
- Be sure the operator has completed appropriate safety training, specific to the work surroundings. The operator should be thoroughly familiar with the controls and the proper use of the press.

1.2 Additional Safety Precautions

⚠ WARNING

Failure to observe and comply with the following precautions could result in death or serious personal injury. Property damage could also occur.

- Always wear and/or use appropriate personal protective equipment (PPE) such as hard hat, hearing protection, safety shoes and gloves (at a minimum rigger type gloves).
- Ensure that protective clothing will not interfere with safe operation of the tool or restrict the ability to communicate with co-workers.
- The operator must be of at least the minimum age required by applicable local regulations, laws and the facility standard operating procedures.
- Be sure your workplace is safe. Follow the instructions in your workplace's standard operating procedures and be sure to observe all communicated safety precautions.
- Be sure appropriate guards (user-supplied) are securely in position and free from damage.
- Maximum allowable hydraulic system operating pressure is 10,000 psi [700 bar]. Do not exceed this pressure setting.
- Always be sure that pump is stopped and all pressure is fully relieved (0 psi/bar) before disconnecting or connecting the hydraulic hose. The sudden and uncontrolled release of pressurized hydraulic oil could occur if hose is disconnected while under pressure.
- Never attempt to connect or disconnect hoses while the pump is on and/or the system is pressurized.
- Before use, be certain that all hose couplers are fully connected. There should be no threads visible between the male and female coupler halves.
- Never apply more hydraulic pressure to any tool, hose, fitting or accessory than the maximum allowable pressure as stated in the manufacturer's specifications. The system operating pressure must not exceed the pressure rating of the lowest rated component in the system.
- Do not abuse or overstress hoses in any way. Do not bend hoses excessively.
- Take every precaution to prevent oil leaks from occurring. High pressure oil leaks can penetrate the skin, resulting in serious injury.

NOTICE

Failure to observe and comply with the following precautions could result in property damage and/or void the product warranty.

- Never carry the pump by its hose.
- If oil leakage is present from hydraulic cylinder, replace seals as required before placing the press back into service.
- If the press becomes damaged in any way, have it repaired and checked for proper operation before placing it back into service.
- Always follow the inspection and maintenance instructions contained in this manual. Perform maintenance and inspection activities at the specified time intervals.
- Always use Enerpac pumps and hoses.
- Always use Enerpac replacement parts.

2. Compliance

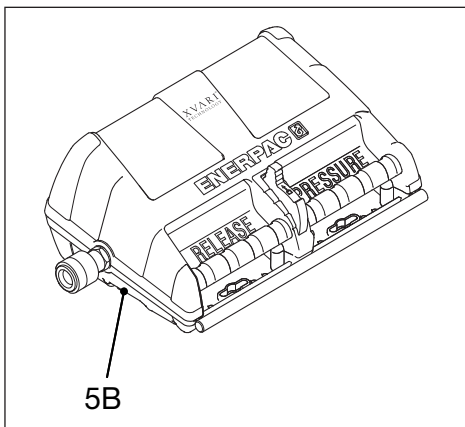
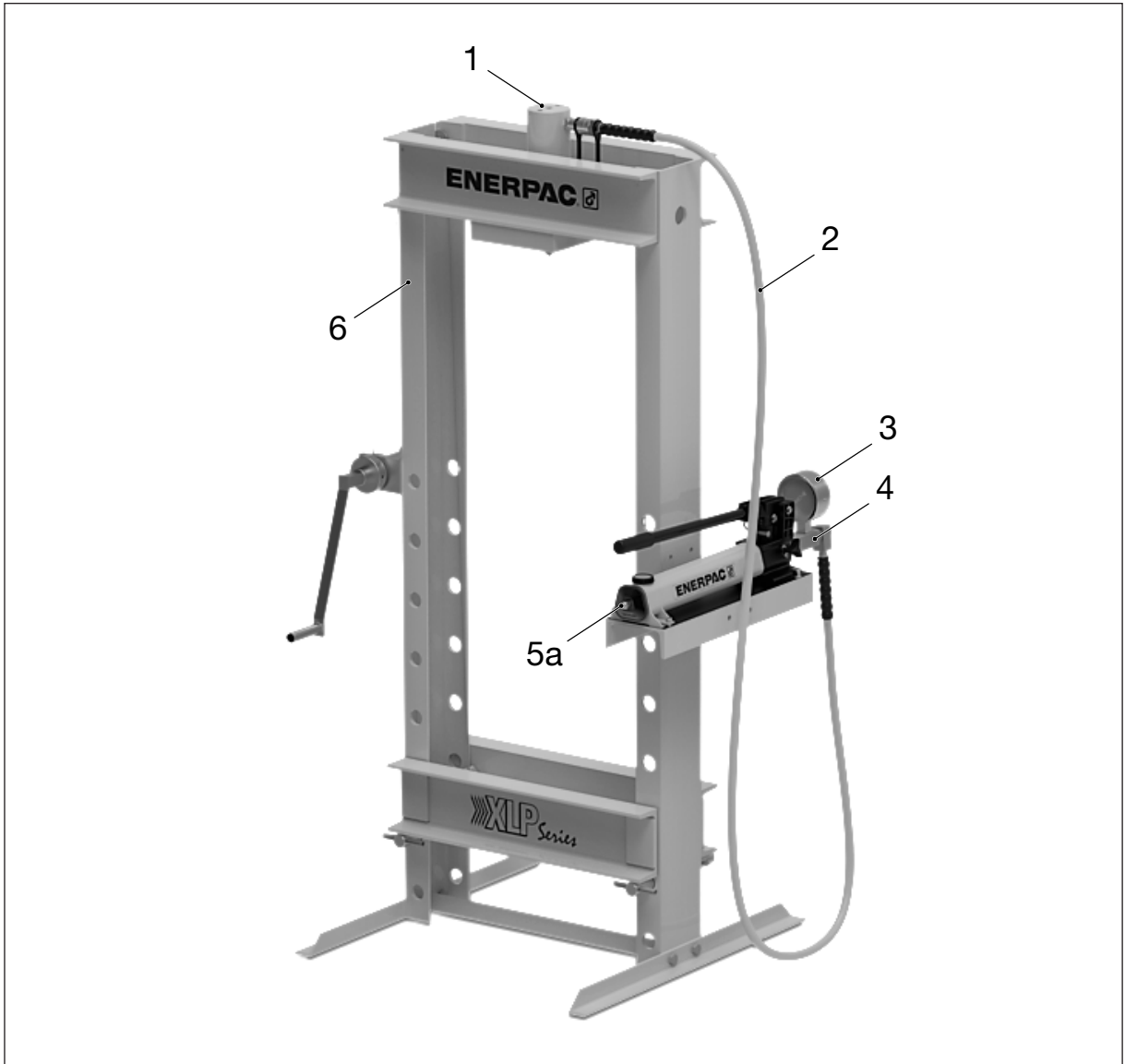
2.1 Conformance to National and International Standards



Enerpac declares that the product(s) have been tested and conforms to applicable standards and the product(s) are compatible to all EU and UK Requirements.

Copies of the EU Declaration as well as the UK Self-Declaration are enclosed with each shipment

3. Features & Components

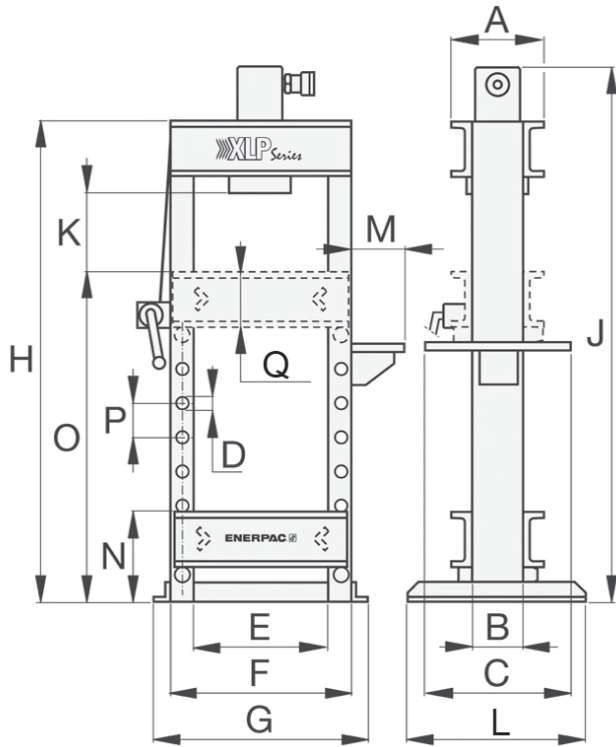


Key:

- 1. Hydraulic Cylinder
- 2. Hydraulic Hose
- 3. Hydraulic Pressure Gauge
- 4. Gauge Adapter
- 5A. Hydraulic Pump, Hand Operated
(Models XLP256P392 and XLP256P392U only)
- 5B. Hydraulic Pump, Air Operated
(Models XLP256XA11G and XLP256XA11GU only)
- 6. Frame

4. Product Data

4.1 Dimensions



Press Model Number	XLP256P392 XLP256P392U	XLP256XA11G XLP256XA11GU	
Rapid Advance mm/sec [in/sec]	{3,4 [0.13]}**	10,0 [0.39]	
Pressing mm/sec [in/sec]	{0,7 [0.03]}**	1,3 [0.05]	
Dimensions mm [in]	A	270 [10.63]	270 [10.63]
	B	140 [5.51]	140 [5.51]
	C	510 [20.08]	N/A
	D	32 [1.26]	32 [1.26]
	E	510 [20.08]	510 [20.08]
	F	630 [24.80]	630 [24.80]
	G	710 [27.95]	710 [27.95]
	H	1620 [63.78]	1620 [63.78]
	J	1705 [67.143]	1705 [67.143]
	K	357-1211 [14.06-47.68]	357-1211 [14.06-47.68]
	L	770 [30.31]	770 [30.31]
	M	140 [5.51]	N/A
	N	218 [8.58]	218 [8.58]
O	1072 [42.20]	1072 [42.20]	
P	122 [4.80]	122 [4.80]	
Q	140 [5.51]	140 [5.51]	
Weight kg [lb]	156 [364]	170 [375]	

** {...} = advance speed in mm[in] per handpump stroke.

4.2 Specifications

Press Model Number	Press Capacity		Maximum Daylight mm[in]		Power Source			Cylinder		
					Pump Type		Valve Type	Pump Model No.	Stroke mm[in]	Model No.
	Tons	kN	Vertical	Horizontal	Man.	Air	Man.			
XLP256P392	25	232	1211 [47.68]	510 [20.08]	●		●	P392	158/6.25	RC256
XLP256P392U	25	232	1211 [47.68]	510 [20.08]	●		●	P392	158/6.25	RC256
XLP256XA11G	25	232	1211 [47.68]	510 [20.08]		●	●	XA11G	158/6.25	RC256
XLP256XA11GU	25	232	1211 [47.68]	510 [20.08]		●	●	XA11G	158/6.25	RC256

5. Installation

5.1 Assembling the Press Frame

Assemble press legs to press using press leg fasteners supplied.

Assemble winch handle to the winch using hardware supplied

5.2 Mounting the Press Frame

⚠ WARNING Mount the press securely. Unstable positioning may cause the press to tip, resulting in serious personal injury or equipment damage.

If the press is to be mounted to the floor or some other foundation, lower press bed to lowest set of holes before drilling and bolting down. This will ensure that the press does not twist and that the bed will line up with all sets of holes in the legs.

5.3 Hydraulic Cylinder Installation

⚠ CAUTION Check all hydraulic hoses to be sure that fittings and couplers are tight and leak free. Check hose positions to be sure the hoses are located to avoid damage during press operations. Tighten all connections fully, but not excessively.

1. Models with hand pumps
 - a. Connect the gauge adaptor (GA2) to the outlet port of the pump.
 - b. Attach the gauge into the 1/2" NPTF port of the gage adaptor (GA2).
 - c. Attach the swivel coupler (XSC1) into the 3/8" NPTF port of the gage adaptor (GA2).
 - d. Connect the threaded end of the hose to the swivel coupler.
2. Models with air pumps
 - a. Connect the swivel coupler to the outlet port on the side of the pump.
 - b. Connect the threaded end of the hose to the swivel coupler.
3. Connect the hydraulic hose with the coupler end to the cylinder.

Notes:

- Threaded NPT and NPTF connections: Apply PTFE tape to male threads and tighten each item to 1.5 to 3 turns past finger tight (minimum of 40 ft-lbs [54.2 Nm]).
- Pressure gauge and adapter: Orient as desired by first torquing to this minimum torque specification and then continuing to tighten until desired orientation is achieved.
- Tighten cylinder coupler halves by hand only. Be certain they are fully tightened (no gap or threads visible between coupler halves).

6. Operation

6.1 System Set-Up

⚠ WARNING Check all press set-ups and load fixtures for safe operation.

Center the work piece and all parts of the set-up on the line of force. If spacers are used in the set-up, they should be constructed in one solid piece or tack welded together for stability.

⚠ WARNING Before operating the press, make sure all bed support pins are fully inserted and retaining rings are installed on ends of the bolster pins before pressurizing the cylinder or loading the press.

6.2 Removing Air From The Hydraulic System

NOTICE Air removal will go faster if hose(s) are bled of air before connecting them to cylinder port(s).

Advance and retract the cylinder several times, avoiding pressure build-up. Air is fully removed from the system when the cylinder advances and retracts smoothly.

6.3 Hand Pumps

1. Close release valve finger tight
2. Operate the pump handle to build pressure. Pressure will be maintained until the release valve is opened
3. Open release valve to release pressure.

6.4 Air Powered Pumps

Depress the pressure side of the treadle to activate the throttle and advance the cylinder to desired stroke. To retract the cylinder depress release.

6.5 Repositioning the Cylinder

(see figure 1)

1. Loosen, DO NOT REMOVE , the wing nut (D) located under the lower cylinder support bracket
2. Slide the cylinder mounting block assembly (A) to the desired position on the press frame
3. Tighten wing nut (D) securely when cylinder is in the desired location

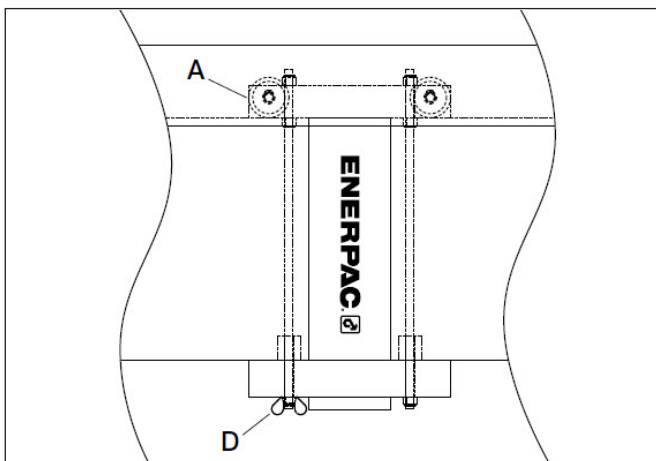


Figure 1: Repositioning the cylinder

6.6 Bed Adjustment (Raising and Lowering)

⚠ WARNING Remove all items from the press bed/ bolster before raising or lowering bed/bolster.

⚠ WARNING Keep hands away from the press bed/ bolster and frame when raising/lowering bed/bolster.

1. The winch has a self-locking feature and can be stopped in any position.
2. Remove retaining pins from the bed/bolster pins.
3. Turn the winch to raise the bed/bolster until the bed/ bolster pins become loose and can be removed from the press.
4. The bed/bolster can be raised/lower to the desired height.
5. When desired height is reached, install the 2 bed/ bolster pins back into the press and reinstall the retaining pins.
6. Slowly turn the winch so the bed/bolster moves down and sits on the pins.

⚠ WARNING Before operating the press, make sure all bed/ bolster support pins are fully inserted, retaining pins are installed and the bed/bolster is sitting on the bed/bolster support pins.

⚠ WARNING The bed/bolster support pins must be installed before operating the press. The winch cable is only used to raise/lower the bed/bolster, it is not designed to support the bed/bolster while pressurizing the cylinder or loading the press.

7. Storage

7.1 Recommended Storage

Enerpac tools should be stored in a cool, dry place. Tools should always be cleaned, serviced and lubricated prior to storage. Ensure that tools are stored in their designated packing cases.

8. Maintenance

8.1 Hydraulic System

1. Keep all hydraulic components free of dirt, grease, chips, and unnecessary equipment
2. Periodically check hydraulic system for damaged components, loose connections, or leaks. Replace or repair damaged or leaking components immediately
3. Change hydraulic oil in your system every 50 hours of operation
4. Use only Enerpac hydraulic oil. Use of fluids other than Enerpac hydraulic oil may cause damage to your system and may void your Enerpac warranty
5. For complete hydraulic component instructions, refer to the instructions enclosed with your pump and cylinder.

8.2 Press Frame

1. Keep work area and press bed free of dirt, chips, and unnecessary tools and fixtures
2. Periodically check frame parts are undamaged. Replace or repair damaged parts immediately
3. If the paint becomes badly chipped, the unit should be repainted to prevent rusting and to keep frame appearance neat.

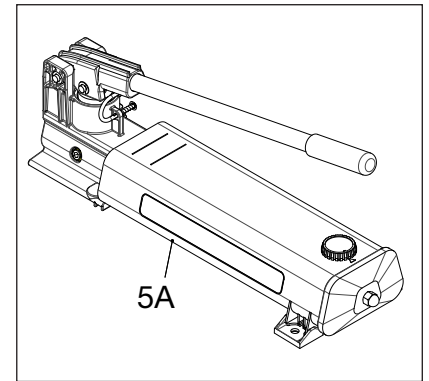
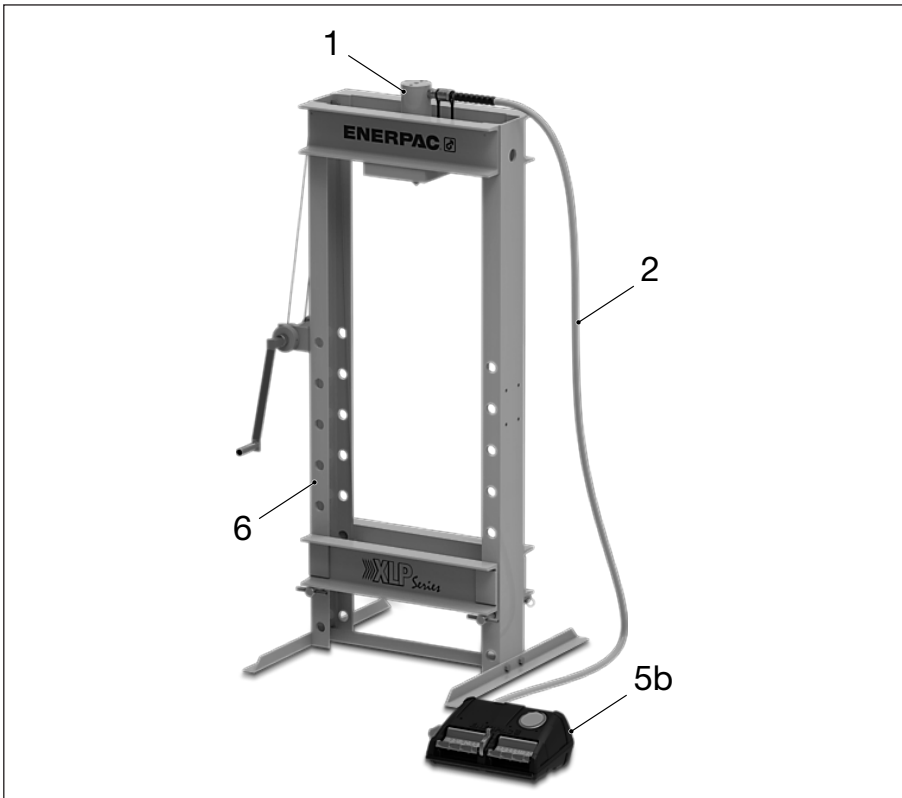
9. Troubleshooting

The information in the Troubleshooting Guide is intended as an aid to help diagnose and correct various possible problems that may occur. For repair service, contact your nearest Enerpac Authorized Service Center.

Troubleshooting Guide		
Problem	Possible Cause	Action
Cylinder plunger does not advance, advances slowly or in spurts.	1. Oil level in pump is low	1. Add oil according to the pump instructions
	2. Pump release valve open	2. Close pump release valve
	3. Loose hydraulic coupler	3. Check that all couplers are fully tightened
	4. Load is too heavy	4. Do not attempt to exert more than rated tonnage
	5. Air trapped in the system	5. Remove air according to the instructions section 6.2
	6. Cylinder plunger binding.	6. Check for damage to cylinder. Have cylinder serviced by a qualified hydraulic technician.
Cylinder advances, but does not hold pressure.	1. Leaking connection	1. Check that all connections are tight and leak free
	2. Leaking cylinder seals	2. Locate leak(s) and have equipment serviced by a qualified hydraulic technician
	3. Internal leakage in pump.	3. Have pump serviced by a qualified hydraulic technician.
Single-acting systems:		
Cylinder does not retract, retracts part way or retracts more slowly than normal.	1. Release valve closed	1. Open pump release valve
	2. Cylinder retraction spring broken or other cylinder damage	2. Have cylinder serviced by a qualified hydraulic technician
	3. Cylinder attachments are too heavy for a single-acting cylinder	3. Remove attachments, check cylinder for damage.
	4. Coupler not connected fully.	4. Tighten cylinder coupler halves by hand only. Be certain they are fully tightened (no gap or threads visible between coupler halves)

10. Parts List

10.1 Exploded View, XLP-Series 25 ton



10.2 Parts Table, XLP-Series 25 ton (Refer to diagram in Section 10.1)

Item	Description	Qty.	Part Numbers			
			XLP256P392	XLP256P392U	XLP256XA11G	XLP256XA11GU
1	Cylinder	1	RC256	RC256	RC256	RC256
2	Hose, Hydraulic	1	HC7210	HC7210	HC7210	HC7210
3	Gauge, Pressure*	1	GF20B	GF20P	---	---
4	Adapter, Gauge*	1	GA2, XSC1	GA2, XSC1	---	---
5A	Hyd. Pump, Hand Operated	1	P392	P392	---	---
5B	Hyd. Pump, Air Operated	1	---	---	XA11G	XA11G
6	Frame	1	SPR54015S	SPR54015S	SPR54015S	SPR54015S
7	Decal, Product Type*	2	▲	▲	▲	▲
8	Decal, Caution Warning*	2	▲	▲	▲	▲
9	Decal, Capacity*	2	▲	▲	▲	▲
10	Decal, Enerpac*	2	▲	▲	▲	▲
11	Decal, Caution*	2	▲	▲	▲	▲
---	Enerpac V-Block Kit*	-	VB25 ■	VB25 ■	VB25 ■	VB25 ■

▲ Indicates items included and available only as part of Label Kit, XLP25LK * not shown

■ Optional accessory. Two V-blocks are included in each Kit. Order as required

