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Distributors of new & used workshop Equipment

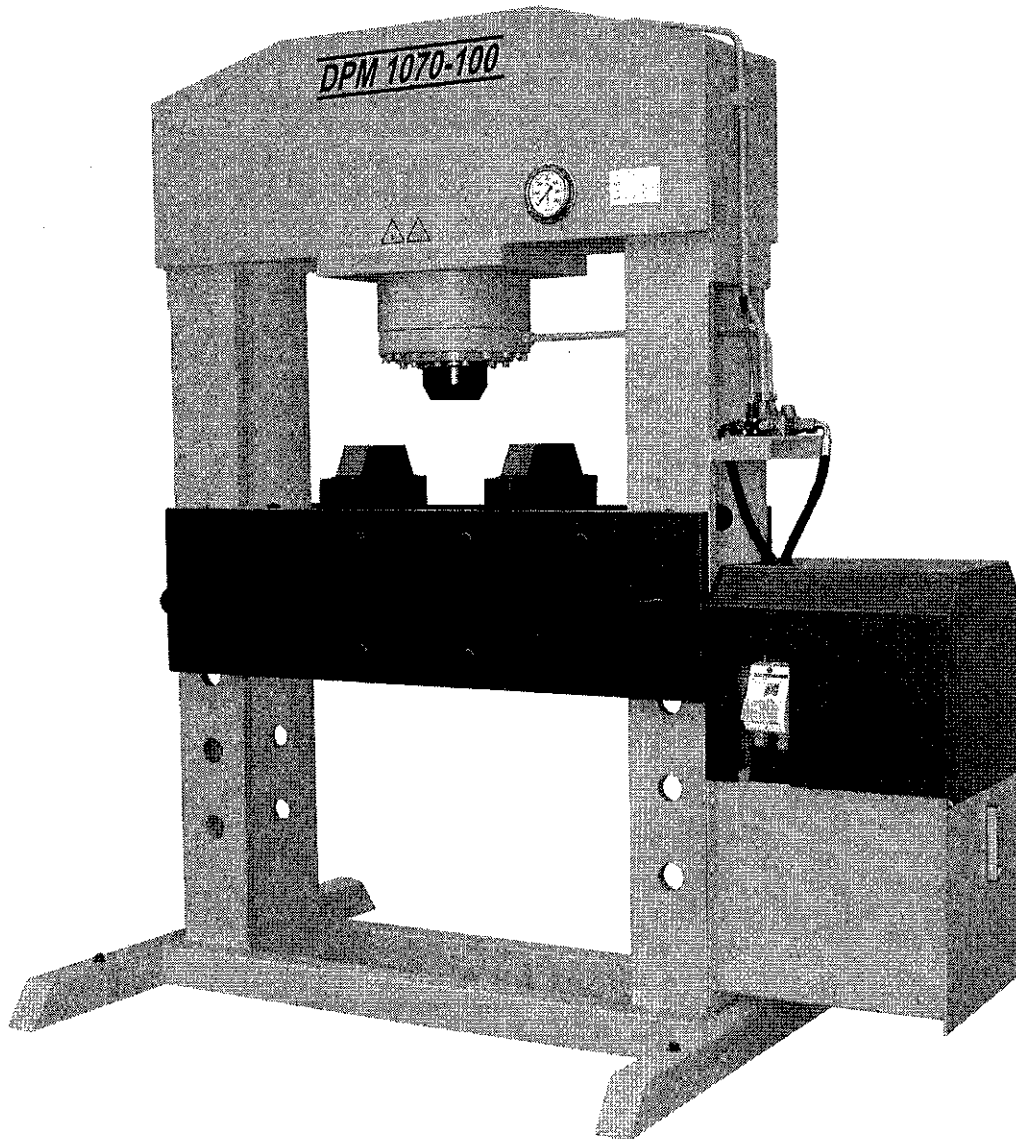
P136

PRESS HYD DPM1070x100T

**SAHINLER 100T
HYD/ELECT MANUAL**

12 APRIL 2011

USER'S MANUAL
MODEL DPM 1070-1570 / 100 ton.
Hydraulic Workshop Straightening Presses
With
Motor





CE DECLARATION

We as

confirm that the machine

DPM 1070- 100 ton.

Serial Number :
Production Year :

complies with

**EC MACHINES DIRECTIVE 2006 / 42 / EC
replaced with EC-Directives 91 / 368 / EWG and
93 / 44 / EWG and
93 / 68 / CEE
EC-Low Voltage 73 / 23 / EWG
EC - Noise Level Directives 86 / 188 / EWG
EC-Directives EMV 89 / 336 / EWG**

and the machine also harmonized with the standards

DIN EN 60204 Part 1

Name :
Position :

.....

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GENERAL NOTES

1. Introduction

Thank you for choosing this Machine. We are proud to have you in our long list of satisfied customers all over the world.

This User's Manual is absolutely for your safety and is essential for the machine to have a long production life. As long as you keep up with our Manual you will be able to run your machine smoothly and safely. Keep in mind that the machine is designed absolutely to perform maximum safety and for efficient working.

In this Manual you can find instructions and information about:

- Correct installations of the machine
- Description of the functional parts of the machine
- Set-up and start-up adjustments
- Correct standard and scheduled maintenance
- Simple safety regulations and accident prevention.

Therefore, as far as the user's safety is concerned, in this handbook the possible risks connected with machine operation are pointed out as follows:



Attention: Showing the risks of accident, if instructions are not followed.



Warning: Showing the probable damages to the machine or equipment, if the instructions are not strictly followed.



Note: It gives useful information.

It is certainly necessary that the operator should read and understand all the **Attention, Warning, Note** specified in this Manual before starting with operation of the machine and before any lubrication or maintenance intervention

On all steps of installation, operation and maintenance safety must be your first concern for the protection of yourself, other users and the service of the machine. In case of any failure please first refer to this Manual, and then if a solution cannot be found contact first of all the distributor where you purchased our product. Do not forget to refer to the drawings and the numbers for any spare part needed or to define any problem. Make sure you have the serial number and production year of the machine.

Our technical staff will make their best to help you in the most convenient way.

2. Transport

As soon as you receive the machine, check for any visible transport damages. Should there be any visible damages; report it straight away to the transporter company and your supplier.

Remove any protective crates around the machine and read the instructions on related chapters of this Manual carefully to set up the machine. If the machine is damaged while transport, **immediately take some photographs for insurance** claims.

Take precautions while loading / unloading or moving the machine to avoid any injuries. Refer also to related chapter of this Manual for the best way of handling the machine.

3. Electrical Information

All necessary connection procedure can be found on this Manual. Do not try to connect the machine before reading these procedures and fully understanding the drawings. For any unclear matters get in touch with us. Have the machine connected by a qualified electric technician. For, as we made clear in the "general conditions of guarantee", under no circumstances installing mistakes, including electrical connection mistake, can not be covered by guarantee agreement. Always turn off power before making any connections or disconnecting the machine.

4. Maintenance

Your machine is designed and produced to work efficiently and smoothly. To achieve this you should also take care while operating the machine. Regard Maintenance sections to have the longest life from your machine. Try and use original spare parts where necessary and most importantly do not overload the machine or do not make any unauthorized modifications.

5. Safety

Take all precautions possible to avoid any personal injury while using the machine. Keep in mind to protect the third party people around the machine. Refer to safety directives.

GENERAL WARRANTY TERMS

- *Your machine is covered by manufacturer's guarantee for a period of **12 months** from the date of purchase against manufacture defects. The warranty period does not exceed 18 months from the date of delivery from the manufacturer's factory.*
- *Warranty covers only manufacture defective parts and / or components that are reported as "defective" by a Technician and must be reported to us in writing by fax or email.*
- *The manufacturer is responsible for the supply of free of charge spares only and cannot be held responsible for loss of work.*
- *Shipping and customs fees for the spare part must be paid by the end-user.*
- *If a technician travel is necessary we will not charge for labor and workmanship costs but the customer must pay traveling and accommodation charges.*
- *A Warranty claim does not relieve the Customer from payment obligations.*
- *The Customer can not ask or demand any reimbursement of damage nor the Customer will have the right to extend or delay payment obligations nor the cancellation of order and the refunding of damages as the guarantee is given for the defective parts of the machine and not for the job.*



Note: *All warranty claims must be applied with the Model, Serial Number and the Manufacture Year of the machine.*

General Safety Terms

This Hydraulic Press is manufactured with safety standards of CE. Misuse, abuse or overload can cause the following hazards on the machine:

- *Personal injury of the user or the third persons*
- *Damage on the machine or on the forming material*

All the persons to operate the machine must thoroughly read and understand this manual for their and other people's safety.

Operating Safety

The following points must always be considered while operating with the machine such as: forming, bending, punching, joining.

Danger of Explosion

***NEVER** press any type of inflammables, pressure or vacuum cans, spray boxes on the machine do not press heavy and hard materials on the machine such as thick columns, thick steel rolls or bars, cement, stone or marble on the machine.*

Important Note

While the machine is rest for longer periods such as adjustment, waiting, maintenance there can be oil leakage. Wipe any leakage with a cloth and bind them if needed.

Any modification on the machine is strictly forbidden without the written permission of the manufacturer, for further safety reasons.

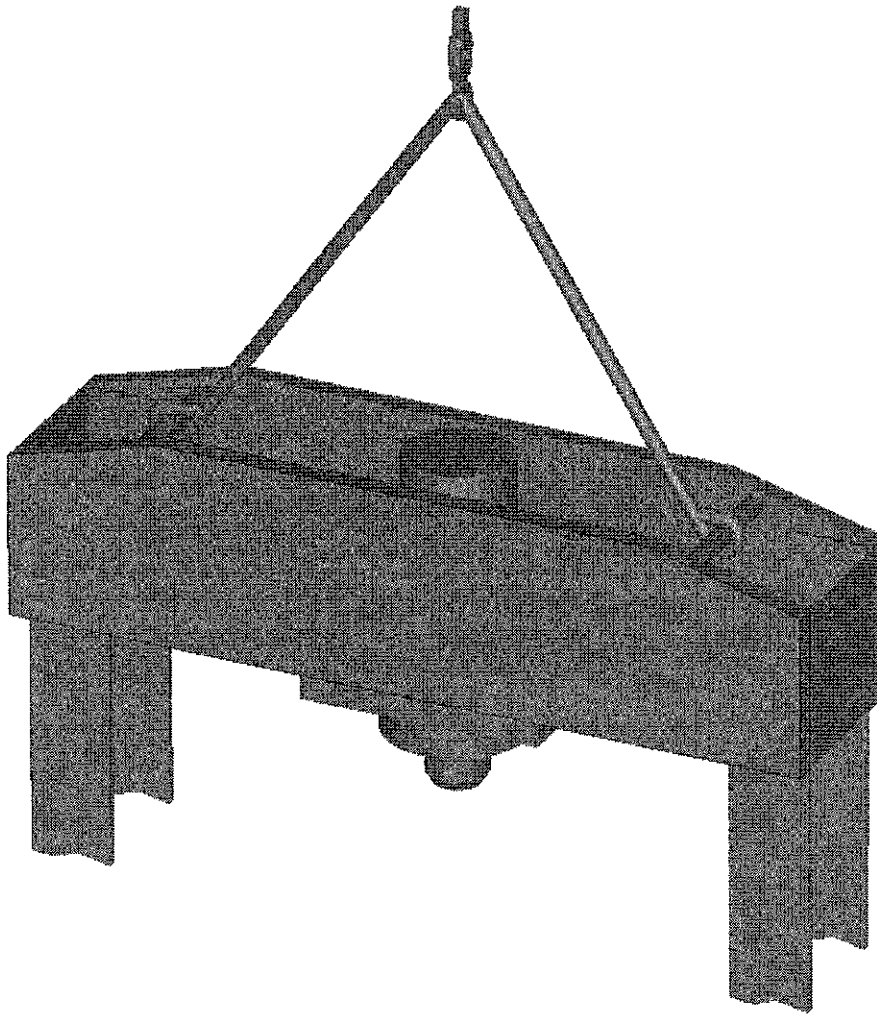
All operation, maintenance and repair must be carried out according to this manual for safety.

TRANSPORT AND LIFTING OF THE MACHINE

The machine weight is approximately 1500 kg. Use necessary cranes and lift as shown. Please take extra care during lifting and moving. Use a steel rope with hooks capable of carrying 4 ton. If necessary consult with specialized companies for lifting.

Approximate Weight:

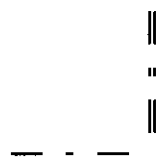
DPM 1070 / 100 ton 1500 kg.



OPENING THE PACKAGE

If any visible damage exist on the machine when you receive the machine immediately informs the dealer or manufacturer. Also never forget to state the visible damage on transport documents.

The packing material is completely safe and do not consist any environmentally dangerous articles. However they must be kept out reach of children as some nylon products in packing may cause suffocation if used as a toy etc.



TECHNICAL PROPERTIES

Hydraulic Workshop Straightening Presses With Motor			
Model		DPM 1070 / 100 ton	DPM 1570 / 100 ton
Press Power	kN	1000	1000
Max. pressure	bar	263	263
Stroke	mm	300	300
Piston diameter	mm	Ø220x160	Ø220x160
Motor Power	kW	5,5	5,5
Advance Speed	mm/sec	8	8
Working Speed	mm/sec	5	5
Return Speed	mm/sec	10	10
Table Width	mm	1070	1570
Dimensions L x W x H	mm	2160x1000x2250	2660x1000x2250
Weight	kg	1500	2200

STANDARD SPECIFICATIONS

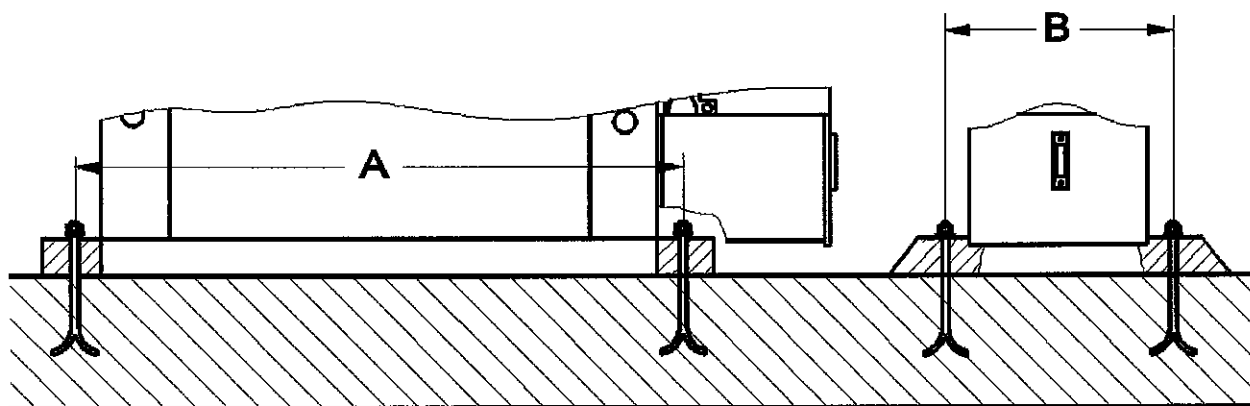
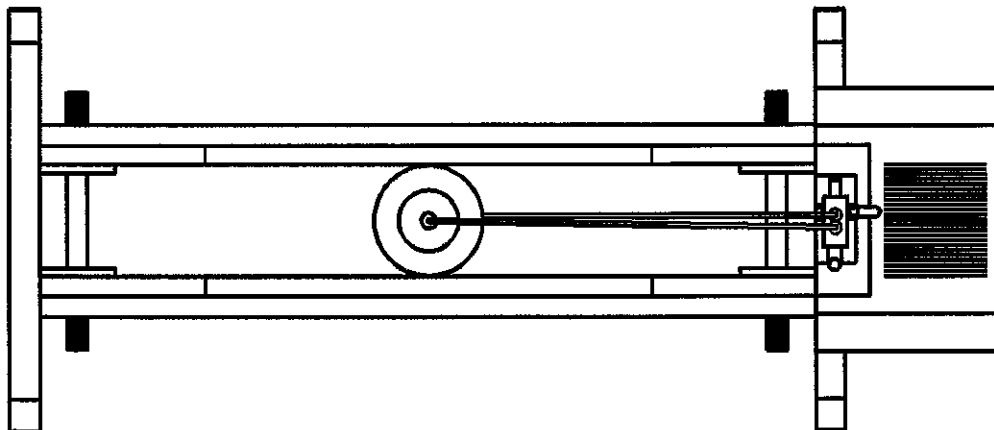
- *Steel welded frame*
- *Safety valve against overloading*
- *Adjustable table height*
- *Fast approach, slow work speed with special joystick control*
- *V – Blocks standard*
- *Easy to operate*
- *Stop at any position*
- *Pressure manometer*
- *Suitable for CE regulations*
- *User manual book*

Important information

- *Leave enough work area around the machine.*
- *Place the machine on a flat concrete base and check the parallelism carefully.*
- *Do not use chemical cleaner the machine.*

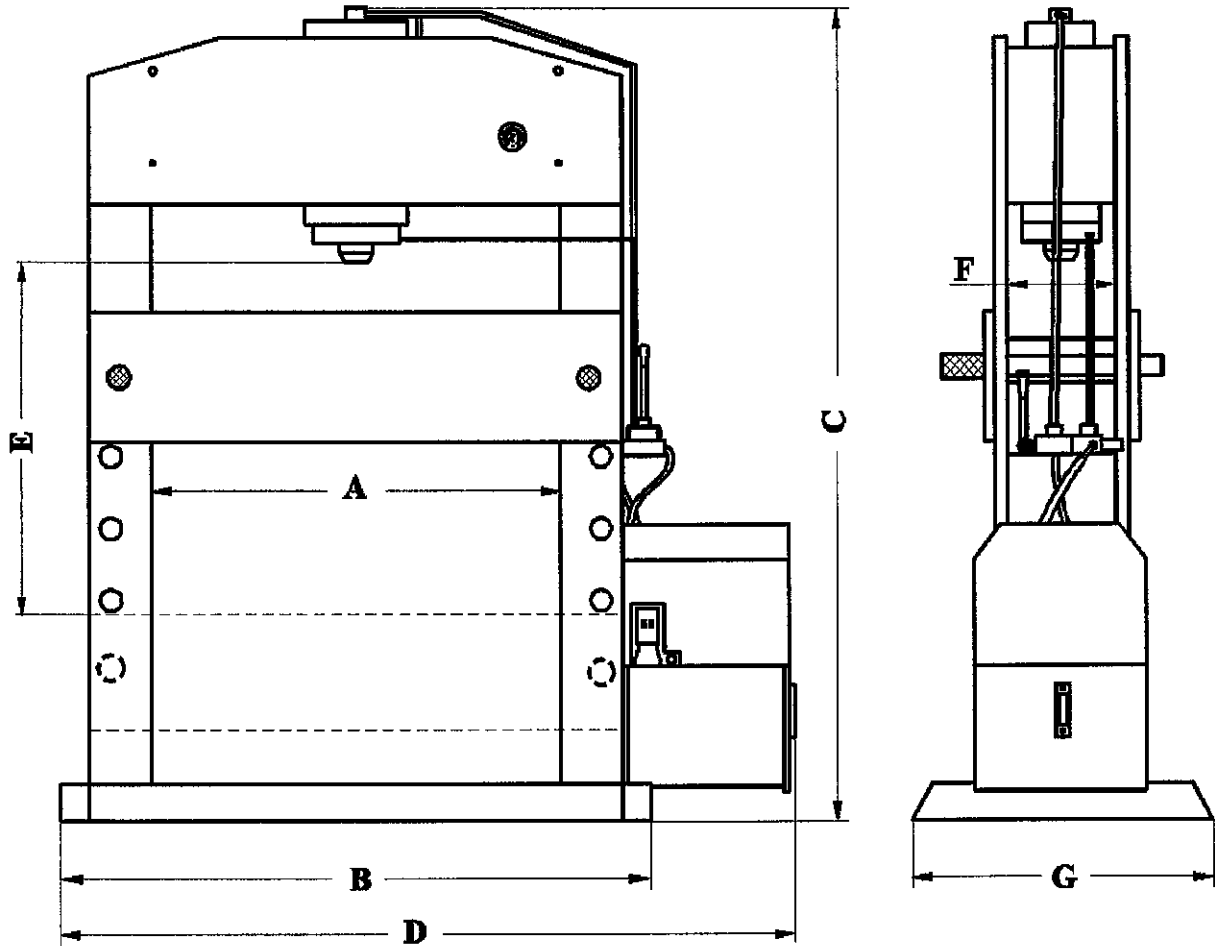
Foundation Plan:

On attached pages you can find foundation plan of the machine. For operation the machine must be bolted to the ground. For bolting refer to front page.



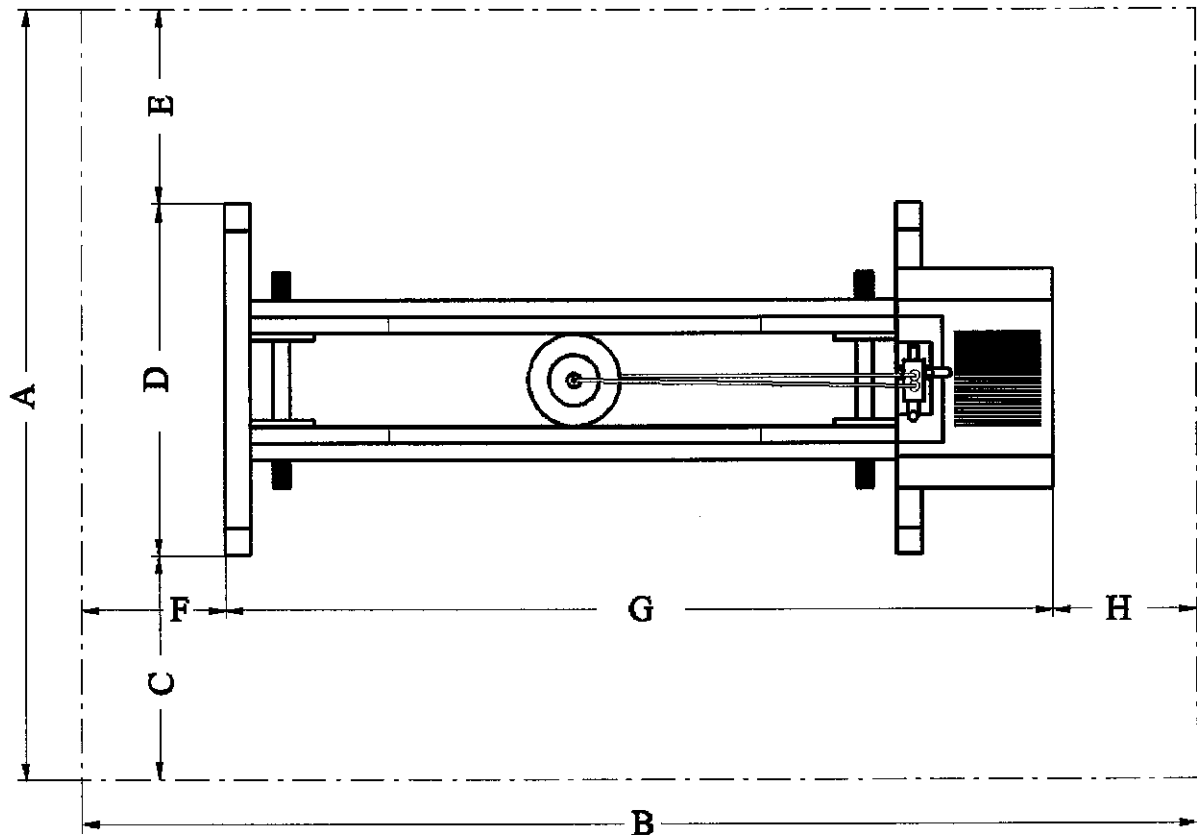
MODEL	A	B
DPM 1070 / 100 t	1550	860
DPM 1570 / 100 t	2050	860

Main Dimension of the Machine



Model	A	B	C	D	E	F	G
DPM 1070 / 100 T	1070	1630	2280	2160	820	240	1000
DPM 1570 / 100 T	1570	1630	2280	2160	820	240	1000

Working Area:



MODEL	A	B	C	D	E	F	G	H
DPM 1070 / 100 t.	3000	2960	800	1400	800	400	2160	400
DPM 1570 / 100 t.	3000	2960	800	1400	800	400	2160	400

SAFETY DIRECTIVES

EXPLANATION FOR OPERATOR

Operator under age of 16 years to operate the machine is strictly forbidden (EC-Directive). The operator of the machine should carefully read this manual and understand the danger he might be in if he misuses or abuses the machine. If any part of this manual is unreadable or illegible please contact to the dealer and manufacturer

The owner of the machine should be responsible for operating the machine with qualified personnel.

PERSONAL PROTECTION

Gloves and safety glasses and safety cap are recommended during operator.



Attention:

- *No material should be fed if the machine is running.*
- *The user must be careful for third persons entering the operation area of the machine.*

General Safety Instructions

Following instructions are meant for the operator of the machine and it is the End-User's responsibility to make sure the operator reads and understands the following and the User's Manual for safe operation.

- *Read the User's manual before operating the machine.*
- *Always inform electric faults to electric technicians.*
- *Keep your working dress or long hair or necklace etc away from moving parts.*
- *Work with necessary safety clothes if necessary (safety shoes, glasses , earplugs etc).*
- *Control the Safety features before working and ensure they are working properly.*
- *See and understand Safety Labels on the machine.*
- *Perform periodic maintenance.*
- **DO NOT** *overload the machine.*
- *If you see abnormal behavior of the machine, stop the machine and inform your supervisor immediately.*
- *Be careful of other people around the machine during operation.*
- *Never modify electric unit.*
- *Never remove any mechanic or electronic safety features from the machine.*
- *Be extremely careful during transport or re-placement of the machine and follow transport instructions in the manual to safety handle the machine.*



Attention: Before the first use of the machine always check this list carefully for a safe start.

1. Check for visible oil leak
2. Control of the buttons and check the joystick

IMPORTANT POINTS

- The machine must be used by qualified and technical personnel at all times.
- All modifications and changes on the machine without the written confirmation of manufacturer is forbidden and if such a case occurs all responsibilities of the manufacturer will be out of consideration.
- Any such modification is also breach of CE directives
- The machine can be stored and used in closed areas however beware not to put it near any explosive, flammable or in any dangerous articles.
- In case any use of non-original spares or accessories and in case of injuries then, the manufacturer will not responsible of such claims.
- Beware of third persons entering the operation area of the machine.
- Beware of any obstacles entering the operation area of the machine.
- In long term stand-by's turn the main button to position 0 (zero)

Electrical Connections

Danger

All electric connections must be carried out by a qualified electric technician and any electrical fault must be immediately reported to a qualified electric technician.

This rating is for standard machine and can vary from country to country so please check the machine ID Plate found on the machine to see exact rating for specific countries.

Controlling the Direction of Rotation of Motors

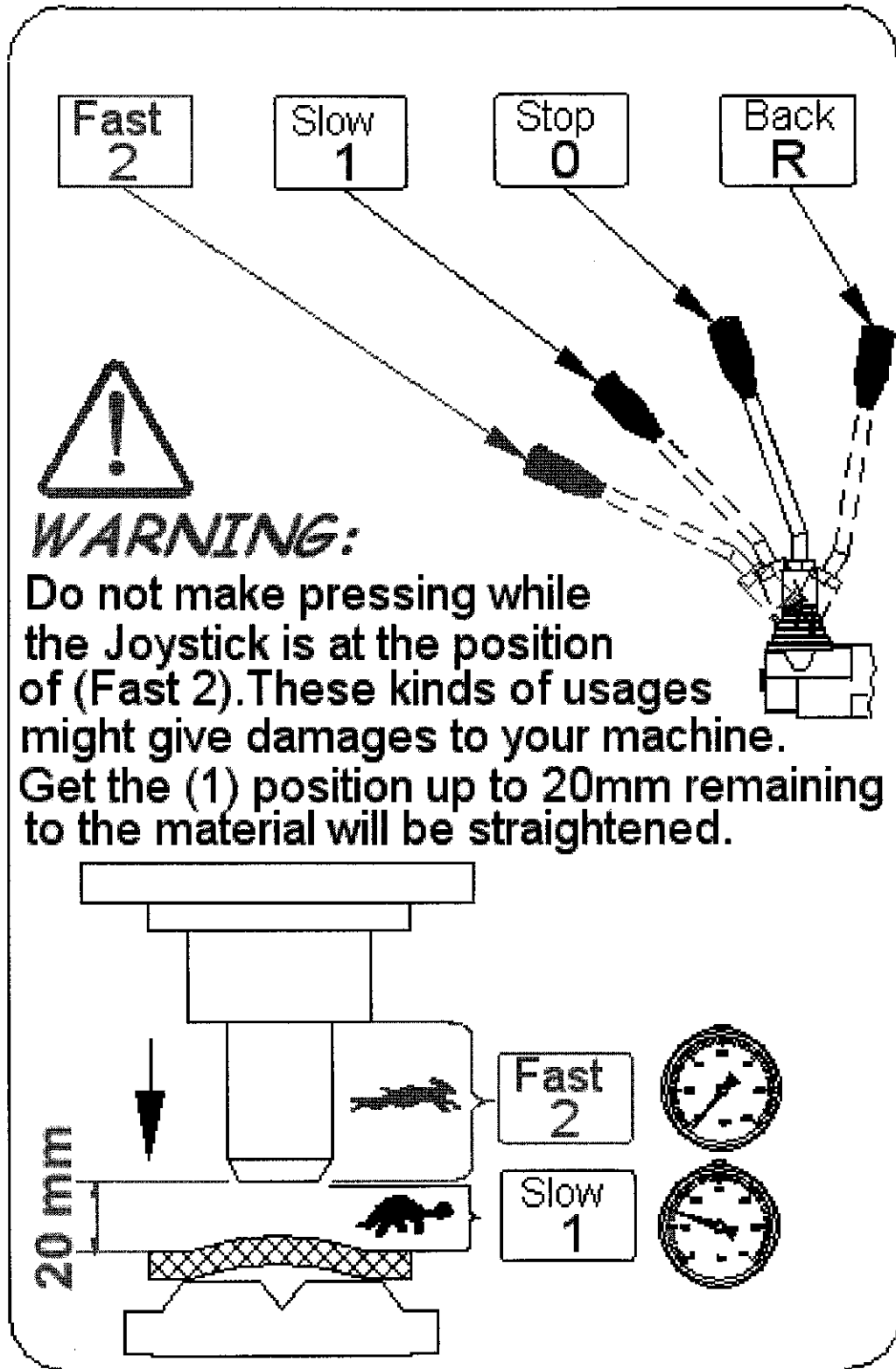
When you first start the machine you must control the Direction of Rotation of Motors.

There is an arrow pointing the running direction of the motor on the motor housing. If this is not clearly visible then test if the machine operates normally that is the Ram moves up and down normally. Try it for 10 seconds approximately and if you don't see any movement that means Direction of Rotation of Motor is not correct and the pump is not working so immediately stop the machine disconnect the electrics and reverse the phase cables and try again.


Warning

Don't work the machine with wrong Direction of Rotation for more that 1 minute as this will burn out the pump.

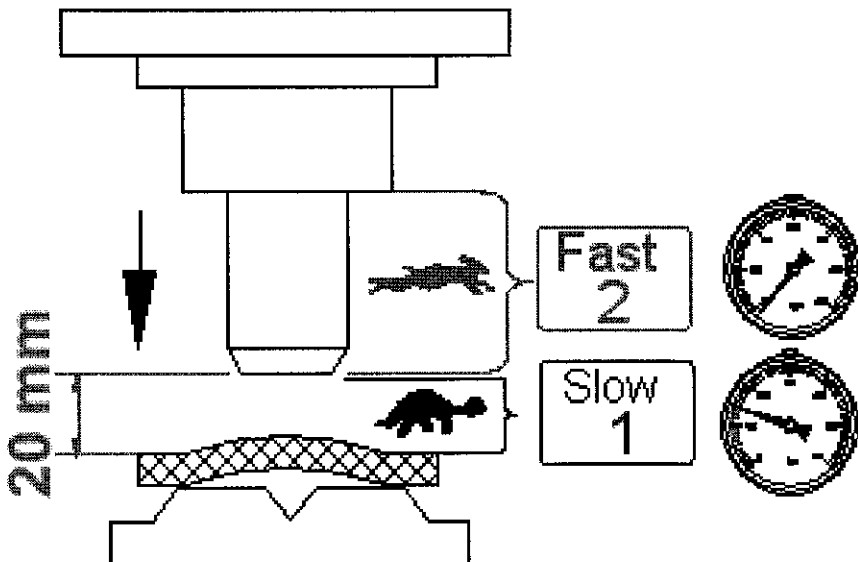
USING THE JOYSTICK



Fast 2 Slow 1 Stop 0 Back R



WARNING:
Do not make pressing while the Joystick is at the position of (Fast 2). These kinds of usages might give damages to your machine. Get the (1) position up to 20mm remaining to the material will be straightened.



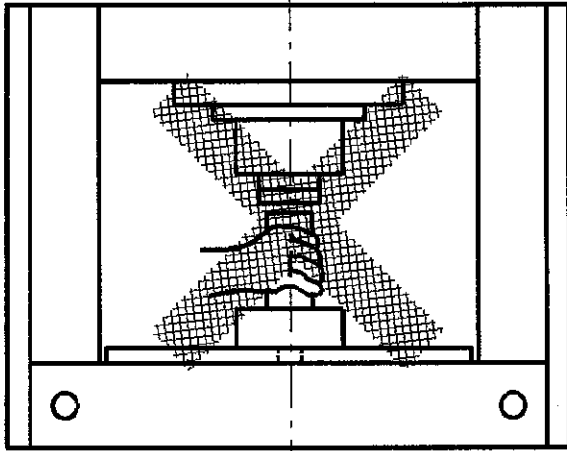
20 mm

Fast 2

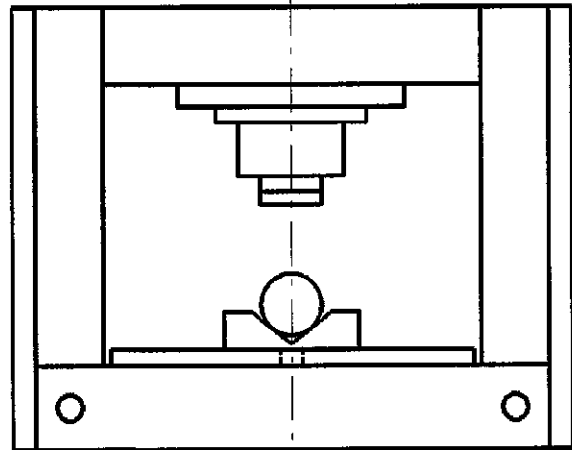
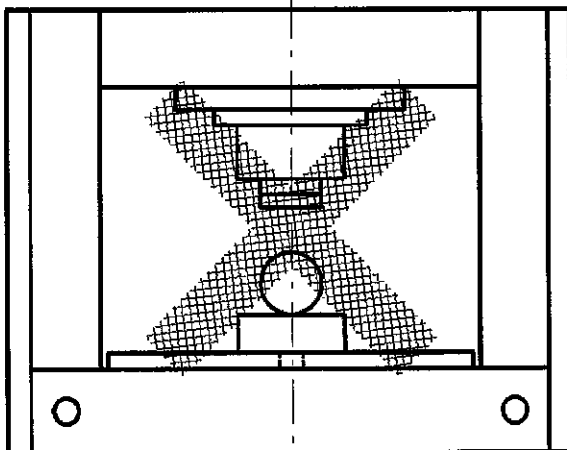
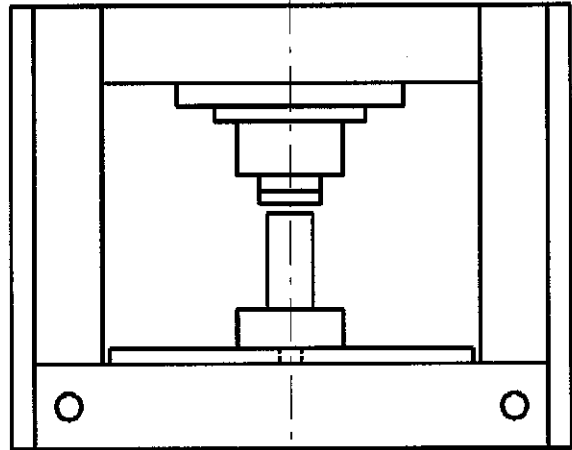
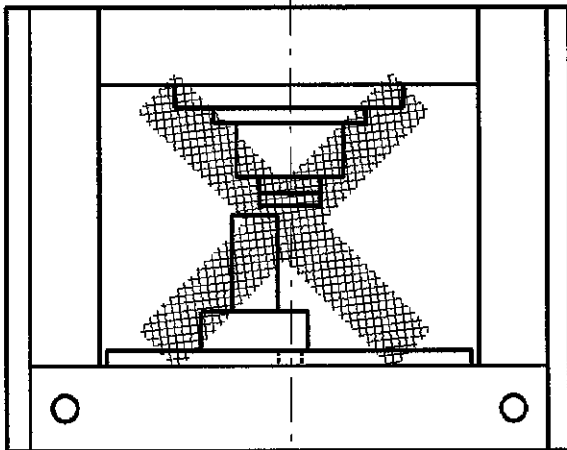
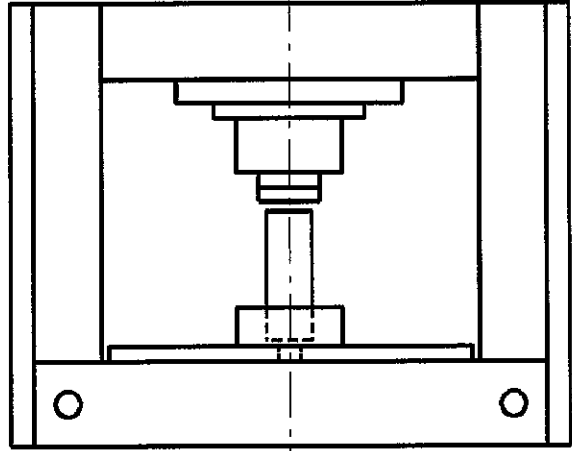
Slow 1

Using the Machine:

FALSE

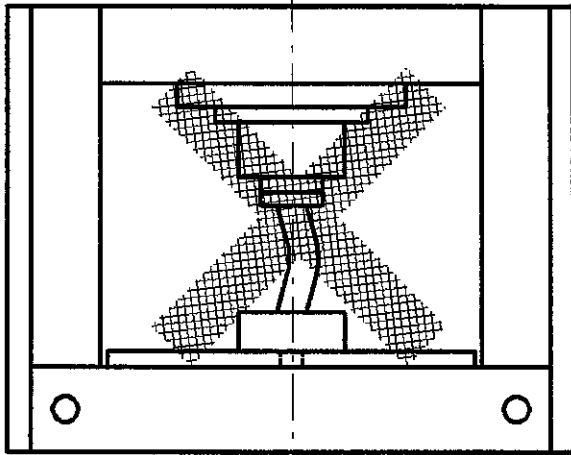


TRUE

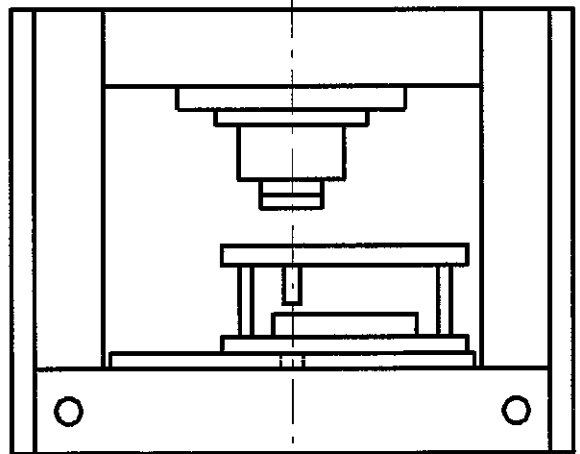
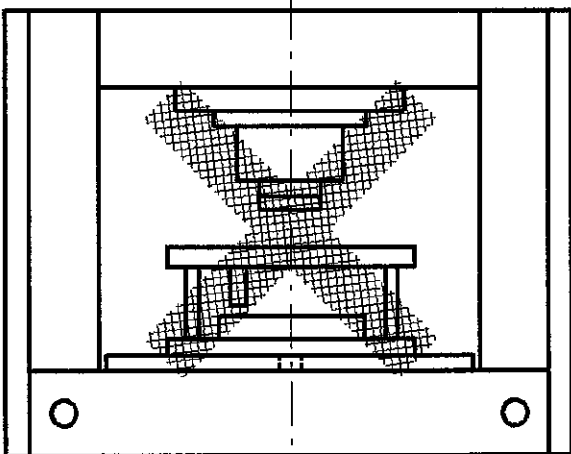
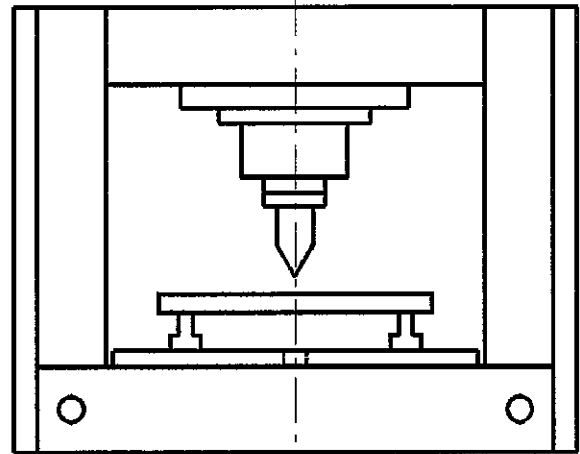
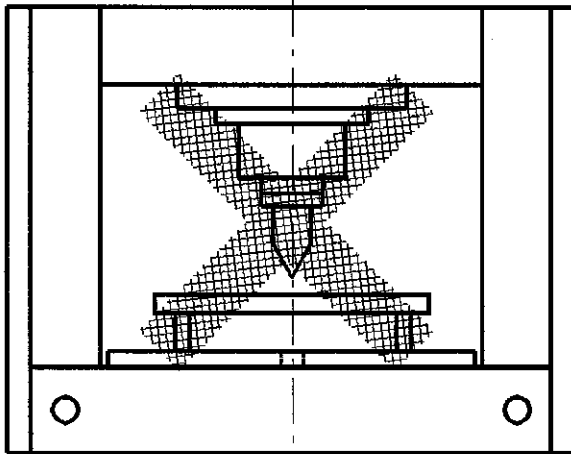
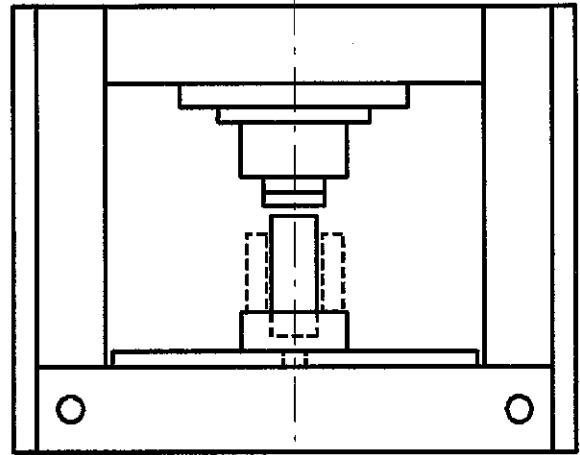


Using the Machine:

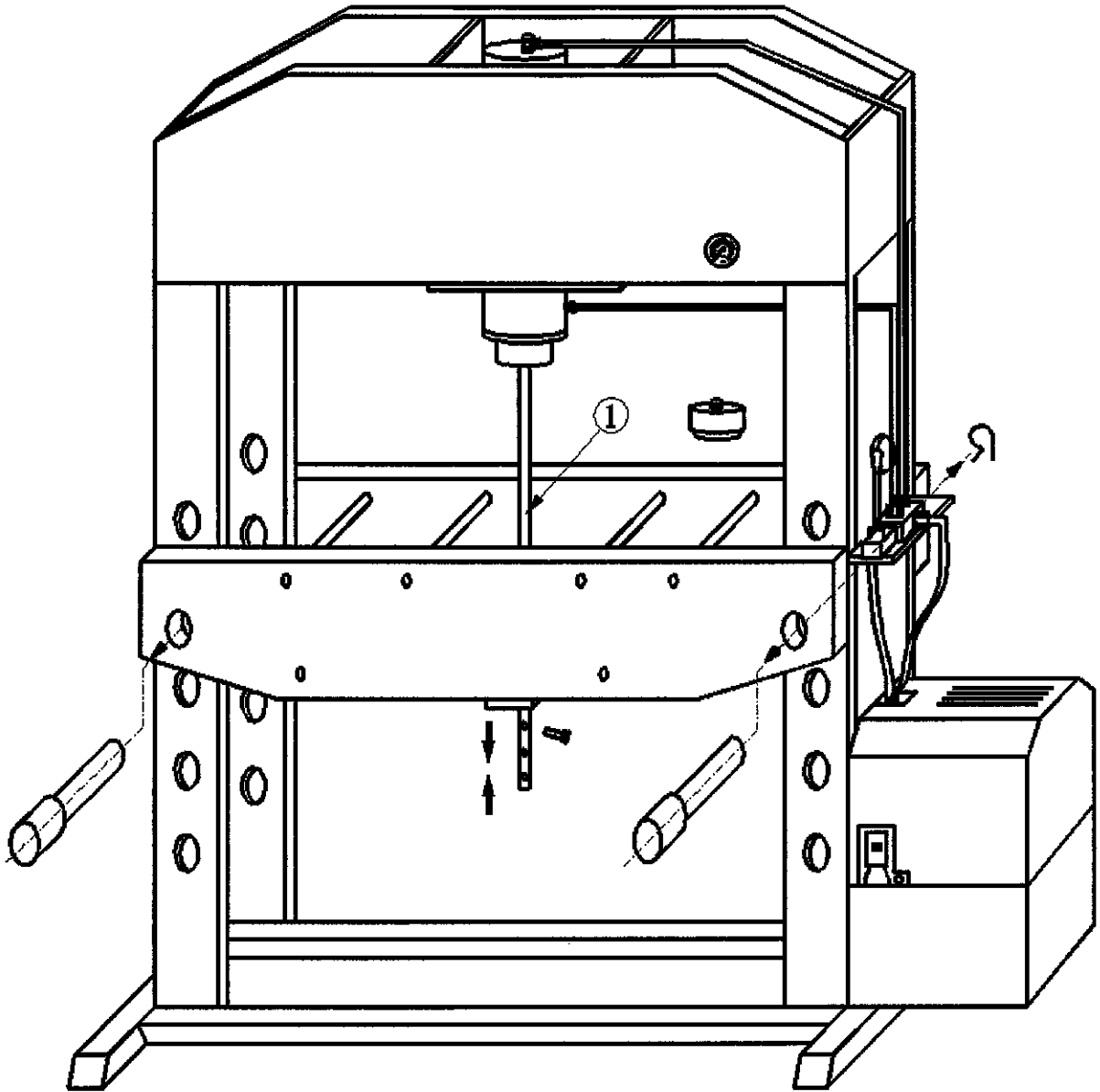
FALSE



TRUE



DPM Lifting Equipment.



MAINTENANCE AND REPAIRS

Maintenance Plan

What	When
Cleaning	Weekly
Hydraulic Oil Control and Filling	Weekly
Hydraulic Oil Change	Yearly
Hydraulic System Control	Yearly

Cleaning

You should clean the machine once a week for a more efficient working.

- Power Off the machine and disconnect it from electric plug
- Make sure that while cleaning no one can turn on the machine for your personal safety
- Clean all shiny areas such as the piston
- Do NOT use petroleum based solvents or corrosive chemicals
- Grease or lubricate necessary parts

Hydraulic System Maintenance

Hydraulic Oil can be harmful for the human skin. Avoid contact as much as possible. After finishing with maintenance clean your contact areas carefully.

Protect the Environment: recycle the used oil in the machine after removing it from the machine. Almost all material based oils are recyclable and are collected by Recycling Companies. Check with your local companies to recycle.

If there is any oil leak around the machine fill it with sand or sawdust to avoid any slippery surfaces which can be dangerous for other people. In general the Hydraulic System needs little maintenance and following points should be noted:

- Check the Oil level weekly from the Oil Gauge found on the hydraulic tank of the machine
- If the level is low fill with Shell Tellus Nr. 46 or equivalent.
- Once in 6 mounts control the Hydraulic filters inside the hydraulic tank and clean or replace if necessary
- Change the hydraulic oil at lease once a year. Fill with Shell Tellus Nr.46 or equivalent (ISO VG 46, DIN 51 519)
- Always close the tank cap tightly
- Control the bolts, seals, valves and Cylinder Seals for any visible damage once a week and replace them if necessary.

Hydraulic System Control

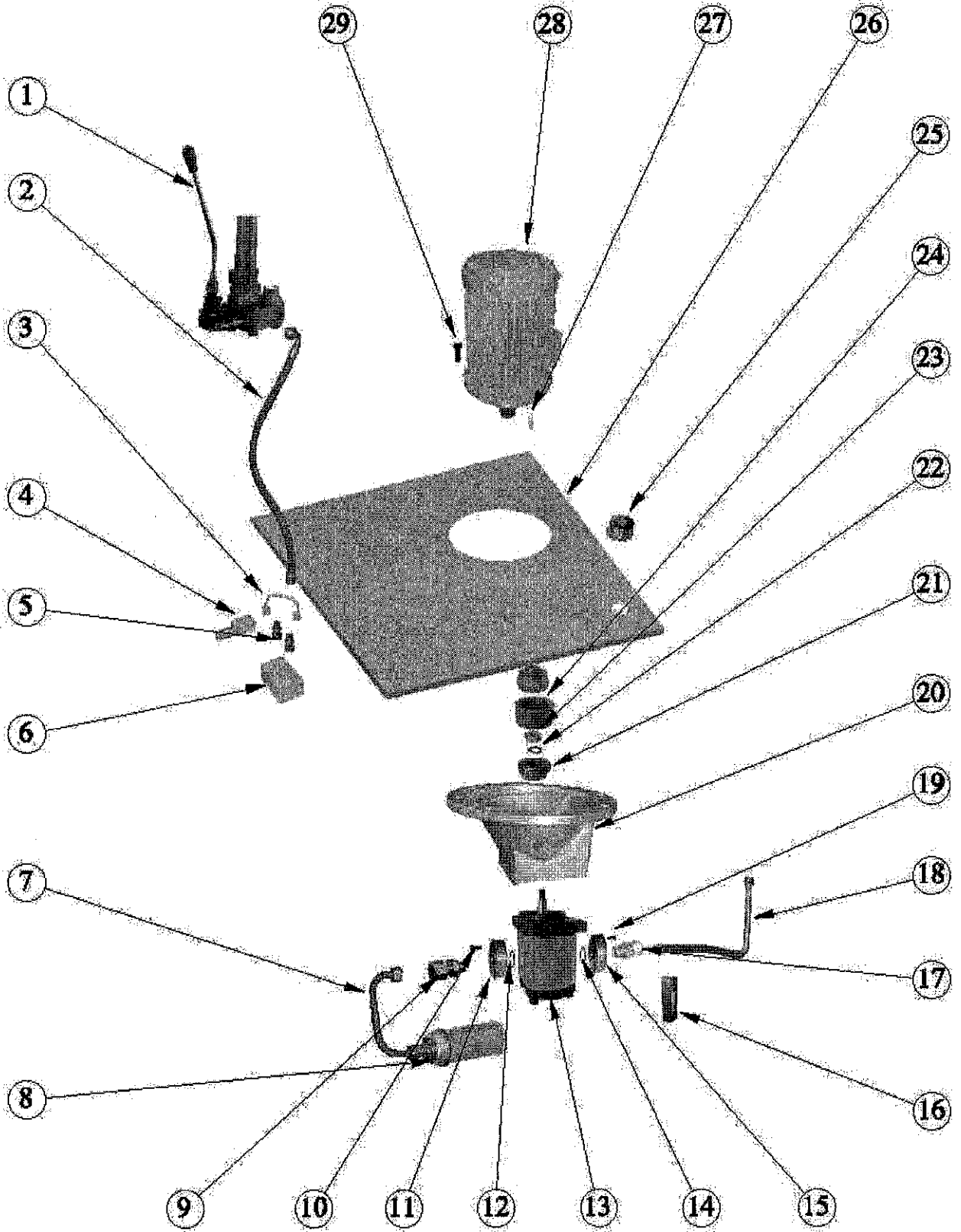
A complete check of hydraulic system once a year is strongly recommended for working safety. The control must be completed by a qualified hydraulic technician.

Control the following items:

- See if there are any visible damage on the hydraulic system and the pipes and the filters.
- Is working pressures normal?
- Control the piston seal and dust seals.
- Control the filters and replace or clean if necessary.
- Control the oil level and refill if necessary



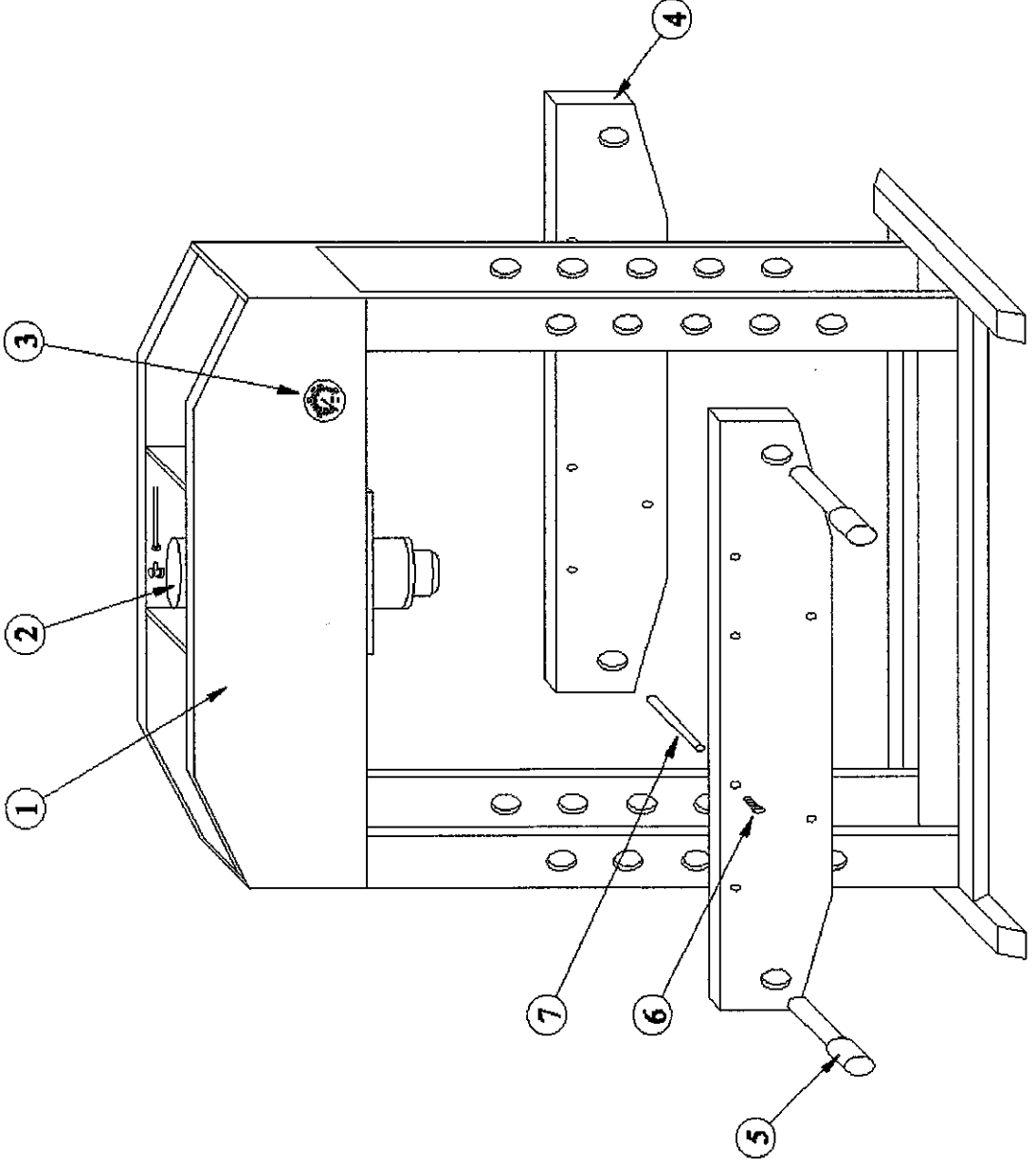
HYDRAULIC SYSTEM



Hydraulic System Part List

1. *Head arm control*
2. *Pressure pipe*
- 3.
4. *Emergency ventile block*
5. *Block bolts*
6. *Distributer block*
7. *Absorb pipe*
8. *Absorb filter*
9. *Block pressure bolt*
10. *Connecting bolt*
11. *Connecting teil*
12. *O – Ring*
13. *Hydraulic pump*
14. *O – Ring*
15. *Connecting teil*
16. *Oil temperature read – out*
17. *Pressure bolt*
18. *Pump pressure bolt*
19. *Connecting bolt*
20. *Pump flange*
21. *Coupling*
22. *O – Ring*
23. *Plastic coupling*
24. *Motor coupling*
25. *Oil tank cover*
26. *Basket*
27. *Motor shaft key*
28. *Motor*
29. *Flange bolt*

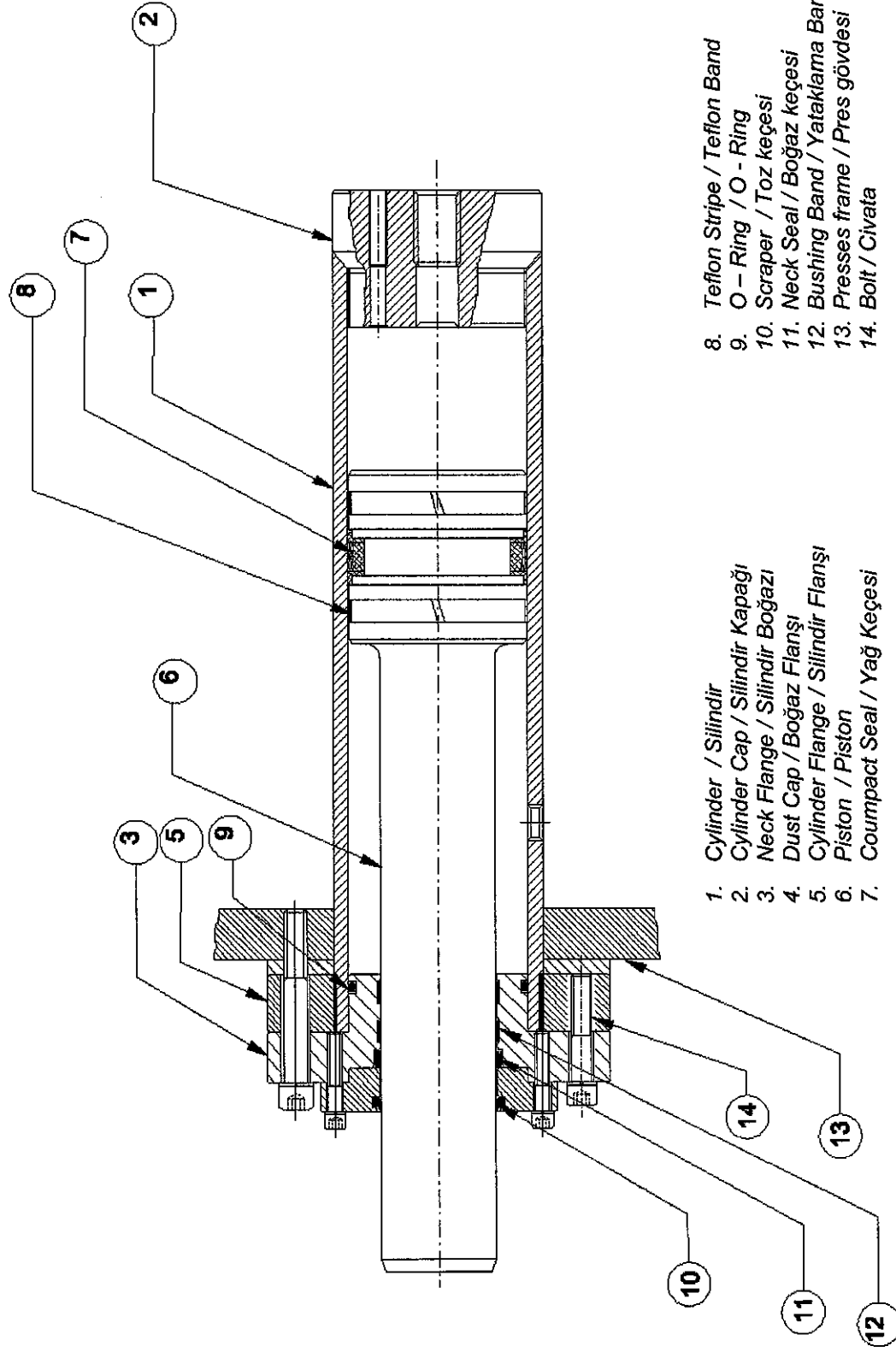
Spare Part List: / Yedek Parça Listesi



1. Mail frame
2. Cylinder
3. Manometer
4. Plate
5. Plate fixing shaft
6. Bolt
7. Plate shaft

1. Makine Gövdesi
2. Silindir
3. Manometre
4. Pleyt
5. Pleyt sabitleme milleri
6. Cıvata
7. Pleyt milleri

DPM PART LIST FOR PISTON



1. Cylinder / Silindir
2. Cylinder Cap / Silindir Kapağı
3. Neck Flange / Silindir Boğazı
4. Dust Cap / Boğaz Flanşı
5. Cylinder Flange / Silindir Flanşı
6. Piston / Piston
7. Compact Seal / Yağ Keçesi

8. Teflon Stripe / Teflon Band
9. O - Ring / O - Ring
10. Scraper / Toz keçesi
11. Neck Seal / Boğaz keçesi
12. Bushing Band / Yataklama Bandı
13. Presses frame / Pres gövdesi
14. Bolt / Civata