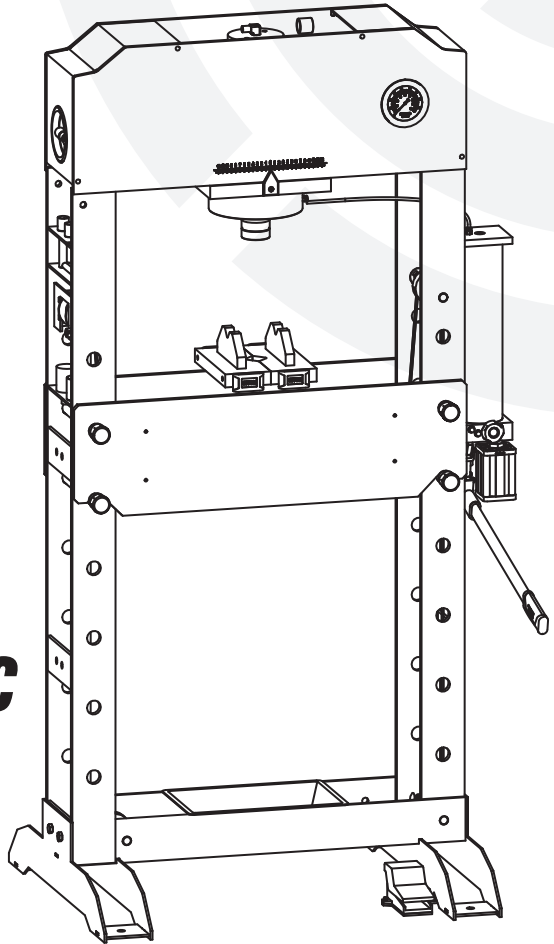


50T Hydraulic Shop Press



IMPORTANT! PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE ALL SAFETY INSTRUCTIONS AND WARNINGS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO FOLLOW THESE INSTRUCTIONS MAY CAUSE DAMAGE TO PROPERTY AND/OR PERSONAL INJURY.

PLEASE KEEP THESE INSTRUCTIONS SAFE AND AVAILABLE FOR FUTURE REFERENCE.







INTENDED USE

This hydraulic press is designed and manufactured exclusively for industrial and workshop applications to perform controlled pressing, bending, straightening, assembling, disassembling and forming operations on metal workpieces and other rigid materials, within the equipment's rated load, stroke and technical specifications.

Before attempting to operate the press, it is essential that you read this manual thoroughly and carefully follow all instructions given. In doing so you will ensure the safety of yourself and that of others around you and you can also look forward to the press giving you long and satisfactory service.

SAFETY PRECAUTIONS

The following safety symbols appear on the product.

	Read instruction manual before use		Wear safety glasses
	Wear Safety Shoes		Hazard: shattered workpiece
	Hazard: crushed hands		Wear protective gloves

- Due to the weight of the press and the lifting equipment, the help of an assistant will be required during installation. Fix the press to the floor using suitable anchor bolts.
- Before starting work, check for signs of cracked welds, loose or missing bolts, damaged screen or any other damage. Do not use if any of these conditions exist. Have repairs made only by authorised service centre.
- Before work, always ensure that hydraulic hoses and couplings are completely sound.
- NEVER tamper with the press components or modify them. The safety valve is set and sealed at the factory; do not attempt to adjust the setting.
- Use only the recommended hydraulic oil.
- The components of this press are designed to withstand the rated load. Do not substitute any other components or exceed the rated load of the press.
- Before applying pressure, ensure the workpiece is firmly secure and stable.
- ALWAYS clean up spills of hydraulic oil immediately as this can be dangerous in a workshop environment.
- Do not let any person who is unfamiliar with hydraulic presses use the press unless they are under direct supervision.
- Keep children and unauthorised personnel away from the work area.
- ALWAYS apply the load under the centre of the ram. Offset loads can damage the ram and may cause the work piece to be ejected.
- ALWAYS ensure the work piece is properly supported by the press bed.
- When using accessories such as pressing plates, be certain they are centered below the ram and are in full contact with the bed.

- Parts being pressed may shatter or be ejected from the press. Always use adequate guards and wear eye protection and protective clothing when using this press.
- Keep hands and fingers away from parts that may pinch or shift.
- NEVER use extension tubes to increase the length of the pump handle or foot pedal. Excessive effort can cause damage and/or accidents.
- Avoid use in humid, flammable and explosive environments to prevent electric shock and fire hazards.
- Failure to heed these warnings may result in damage to the equipment or serious personal injury.

TECHNICAL SPECIFICATION

Item	HDHYPO50
Capacity	50 TON
Bed Opening	220mm
Work Range	0~970mm
Stroke Length	200mm
Inside Bed Dimensions L x W	220x710mm
Dimensions L x W x H	920x800x1985mm
Net Weight	323kg
Pneumatic Press	110-150 PSI

ASSEMBLY INSTRUCTIONS

Use the exploded drawing as your guide to assemble. Lay all parts and assemblies out in front of you before beginning. The following procedure is recommended:

- Use bolts (20), washers (19), lock washers (18) and nuts (17) to attach the base sections (16) (31), connect the hydraulic hose (36) to the pump (34) and then insert the handle into the grip.
- Use bolts (26) and lock washers (27) to install the switch (28) on the base section (31).
- Connect the air pipe (32) to the switch (28).
- Tighten all bolts and screws.

EXPLODED PARTS DIAGRAM

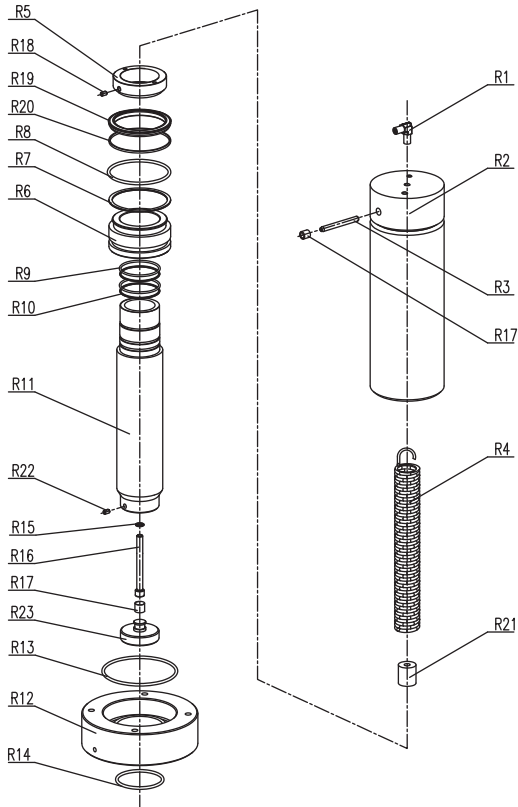
SHOP PRESS PARTS LIST

No.	Description	QTY
1	Bolt M12x120	4
2	Spring	4
3	Bolt M8x12	2
4	Spring washer 8	3
5	Screw parts	1
6	Roller square steel	2
7	Bearing	4
8	Ring 15	4
9	Punch set	1
10	Handle	1
11	Pointer	1
12	Bolt M6x10	1
13	Butterfly washer	4
14	Bed frame	1
15	Bed frame pin	4
16	Base section	1
17	Nut M12	4
18	Lock washer 12	8
19	Washer 12	8
20	Bolt M12x35	4
21	Roller shaft	2
22	Split washer 20	12
23	Roller cover 1	3
24	Roller	3
25	Roller cover 2	3
26	Bolt M5x12	2
27	Lock washer 5	2
28	Switch	1
29	Magnetic mat	1
30	Tool tray	1
31	Base section	1

No.	Description	QTY
32	Air pipe	1
33	Handle	1
34	Pump	1
35	O-ring 5x1.8	4
36	Hydraulic hose	1
37	Plastic pipe	1
38	Washer 10	4
39	Lock washer 10	4
40	Bolt M10x30	4
41	Press block	2
42	Steel rope	1
43	Bolt M12x40	4
44	Ram fixup assembly	1
45	Roller shaft	1
46	Plastic cover plate1	1
47	Bolt M8x20	1
48	Washer 8	1
49	Long roller	2
50	Hydraulic hose	1
51	T-connector	1
52	T-connector	1
53	Pressure gauge connection 1	1
54	Pressure gauge connection 2	1
55	Rectangular sealing ring	2
56	Pressure gauge	1
57	Plastic pipe end	1
58	Cylinder parts	1
59	Plastic pin	8
60	Plastic cover plate 2	1
61	Frame	1

EXPLODED PARTS DIAGRAM

RAM PARTS LIST



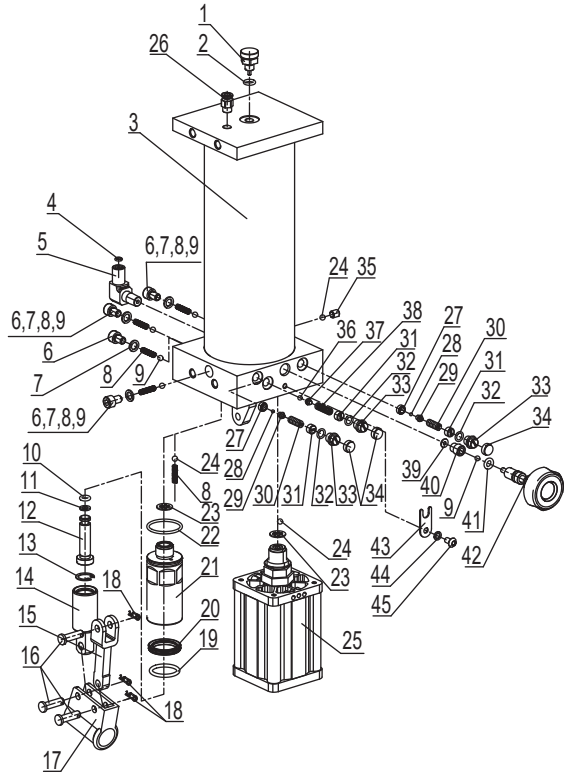
No.	Description	QTY
R1	Connector	1
R2	Cylinder	1
R3	Pin 10x70	1
R4	O-ring	1
R5	Nut	1
R6	Piston head	1
R7	Ring	1
R8	O-ring 90.5x5.3	1
R9	Ring	2
R10	O-ring 60.5x2.5	2
R11	Ram	1
R12	Guide sleeve	1

No.	Description	QTY
R13	O-ring 120x5.3	1
R14	O-ring 74.5x5.3	1
R15	Washer	1
R16	Bolt M10x80	1
R17	Bolt	2
R18	Bolt M10x10	1
R19	Y-ring	1
R20	Back ring	1
R21	Spring nut	1
R22	Bolt M8x12	1
R23	Toe	1

EXPLODED PARTS DIAGRAM

PUMP PARTS LIST

No.	Description	QTY
1	Air bleed screw	1
2	O-ring 8.5x2.65	1
3	Hydraulic pump unit	1
4	O-ring 5x1.8	1
5	Angle coupling	1
6	Bolt M8x10	4
7	Copper pad	4
8	Steel ball spring	5
9	Steel ball	5
10	O-ring 6.5x3	1
11	Ring 12x7x1.5	1
12	Small Pump	1
13	Retaining ring 20	1
14	Big pump	1
15	Connecting rod	1
16	Pin	3
17	Hand-held	1
18	Torsional spring latch	3
19	O-ring 27.5x3.55	1
20	Y-ring 35.5x28x5.5	1
21	Pump body	1
22	O-ring 35x2.65	1
23	Copper washer	2



No.	Description	QTY
24	Steel ball	3
25	Air pump	1
26	Hose end	1
27	Guide sleeve	2
28	Steel ball	2
29	High-pressure spring seat	2
30	Spring	2
31	Pressure adjusting screw	3
32	O-ring 8x1.8	3
33	Sealing screw	3
34	Safety valve cap	3

No.	Description	QTY
35	Screw M8x8	1
36	Steel ball	1
37	Low-pressure spring seat	1
38	Low-pressure spring	1
39	Copper washer	1
40	Oil return valve nut	1
41	O-ring 7x3	1
42	Oil Return Valve	1
43	Limit block	1
44	Spring washer 6	1
45	Bolt M6x10	1

OPERATING INSTRUCTIONS

Manual Operating

- Adjust the worktable height - Pull out the latches on both sides of the worktable, move the worktable up and down to a height suitable for the workpiece, ensure the latches are fully inserted into the column holes and locked securely.
- Placing the workpiece - Place the workpiece in the centre of the worktable to ensure uniform force on the workpiece without inclination or deviation.
- Pressurisation operation - Push the manual operating lever slowly to drive the hydraulic cylinder, making the pressure head contact the workpiece slowly.
- Observe the pressure gauge and gradually increase the pressure to the required pressure for operation; it is strictly forbidden to push the operating lever hard or apply instant high pressure.
- After meeting the operation requirements, stop the operation and maintain the pressure until the operation is completed (e.g., bearing press-fitting in place).
- Pressure relief and reset - Open the pressure relief valve slowly to release the cylinder pressure gradually and the piston rod will reset automatically under the action of the spring.
- After the pressure head is completely away from the workpiece, take out the workpiece to finish the operation.

Pneumatic Operating

- Air source connection and inspection - Connect the air compressor air pipe, confirm that the air source pressure is stably maintained at 110-115 PSI and turn on the air source switch.
- Adjust the worktable height - Same as the manual press, adjust and lock the worktable height to fit the workpiece size.
- Place the workpiece - Place the workpiece stably in the centre of the worktable, aligning the force center with the pressure head.
- Pneumatic pressurisation operation - Operate the pneumatic control valve to make the pressure head move down slowly to contact the workpiece.
- Observe the pressure gauge, control the pressure to the required value for operation and maintain the pressure until the operation is completed.
- The pressure head stroke can be precisely controlled through the control valve to achieve accurate press-fitting.
- Pressure relief and reset - Switch the control valve to the pressure relief position, the cylinder will release pressure automatically and the piston rod will reset.
- After the pressure head is completely away from the workpiece, turn off the air source and take out the workpiece.

Maintenance and Storage

Regular Maintenance

- Clean the equipment: Wipe off oil stains and metal debris on the press surface with a dry cloth to keep the equipment clean.
- Inspect the status: Check whether the latches, springs, oil pipes and air pipes are intact, loose or damaged.
- Reset and return: Fully reset the piston rod, lower the worktable to the lowest position and turn off the air source (for pneumatic type).
- Lubrication maintenance: Apply lubricating oil to the columns, worktable latches and piston rods to ensure smooth lifting and lowering.
- Hydraulic oil maintenance: Check the hydraulic oil level and status monthly, fill up when insufficient and replace when contaminated.
- Replace hydraulic oil completely every 1-2 years: Drain the old oil, clean the oil tank and inject new hydraulic oil.
- Special maintenance for pneumatic type - Drain the accumulated water in the pneumatic pump and filter monthly to prevent rust.
- Check the tightness of air pipes and joints and replace aged air pipes in a timely manner.
- Fill lubricating oil into pneumatic valves and cylinders regularly to ensure the smooth operation of the pneumatic system.
- Structure and component inspection: Check whether the frame welds are cracked or deformed and whether the columns are worn and repair in a timely manner.
- Check the accuracy of the pressure gauge; calibrate or replace it if the display is abnormal.
- Check the elasticity of the reset spring; replace it immediately if it fails.
- Anti-rust treatment: Apply anti-rust oil to the rust-prone parts of the equipment (columns, latches), especially before long-term storage.

Storage Requirements

- For long-term storage, clean and lubricate the equipment, then place it in a dry, ventilated and rainproof indoor environment.
- Cover the equipment with a dust cover to avoid erosion by dust and moisture.
- For the pneumatic type, discharge the residual gas in the air pipe; for the manual type, close the pressure relief valve and fully reset the piston rod.
- Inspect the equipment status once a month during storage to prevent rust and component damage

EC DECLARATION OF CONFORMITY

1. **Product models:** HDHYP050

2. **Name and address of the manufacturer or his authorised representative:**



SGS Engineering (UK) Ltd
Unit 1 West Side Park, Raynesway, Derby, DE21 7AZ
Telephone: +44 (0)1332 576 850

3. **This declaration of conformity is issued under the sole responsibility of the manufacturer.**

4. **Object of the declaration:**

Equipment: 50 TON HYDRAULIC SHOP PRESS

Brand name: SGS

5. **The object of the declaration described above is in conformity with the relevant statutory requirements:**

Machinery Directive 2006/42/EC

6. **References to the relevant designated standards used or references to the other technical specifications in relation to which conformity is declared:**

Standard(s):

EN ISO 12100:2010 Safety of machinery

EN 1494:2000+A1:2008 Mobile or movable jacks and associated lifting equipment

7. **The person authorized to compile the technical file:**

Name: Neil Sansom

Address: SGS Engineering (UK) Ltd, Unit 1 West Side Park, Raynesway, Derby, DE21 7AZ

Signed for and on behalf of:

Authorised Representative

A handwritten signature in black ink, appearing to read 'Neil Sansom', written over a horizontal line.

Neil Sansom, CEO

Date: 03/25/2026

