



# 巨輪興有限公司

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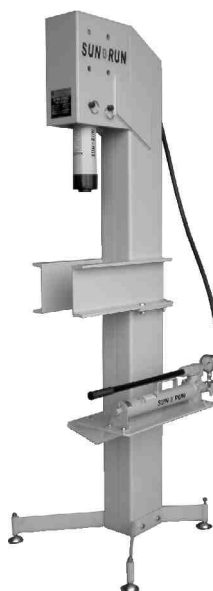
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# C型油壓床 操作說明

## SPM-256C



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中文 : C1~C3

中文  
English  
Ver.16

## 1. 安全措施



不遵守以下的注意事項和警告將引起設備損失及人員傷害。



**重要事項：**未滿18歲人員不得擅自操作。操作SUN RUN油壓設備前請先仔細閱讀並了解相關操作手冊、安全事項和警告事項。操作人員負有油壓設備週邊之人員及環境之安全責任。



**警告事項：**為確保避免人員傷害和設備作業損失，請確認所有油壓設備及週邊配件，使用最大壓力為 700 bar(10,000psi)。



**警告事項：**操作人員於使用期間為避免傷害，需全程配戴安全防護措施。



**危險事項：**為避免人員傷害，請於操作過程中手、腳遠離液(油)油壓缸和液壓設備。



**警告事項：**禁止超載使用。  
超載使用易造成設備損害及人員損傷。液(油)壓缸設計最大使用壓力為 700 bar (10,000psi)。



**警告事項：**當零件出現裂痕或損壞時，應立即以**SUN RUN**零件更換。正確標準的零件可防止人員或設備損傷。**SUN RUN**零件經特別設計可完全適用並適用產品標稱的額定荷載或壓力。



**重要事項：**液壓設備必需由合格的液壓技工進行維修。需要修理時，請聯繫就近的**SUN RUN**服務據點並使用**SUN RUN**液壓油保固方為有效。



**危險事項：**千萬不可將溢流(安全)閥的壓力值設定高於泵浦的額定壓力。超載的壓力值可能引起設備損壞及人員損傷。  
尤其千萬不可拆除溢流(安全)閥。



**警告事項：**系統操作壓力絕不可超過最低壓力元件之值最低值。系統中應加裝壓力錶藉以監測系統中的壓力並了解使用狀態。



**警告事項：**避免損壞油壓管。捲收油管時，避免油管強烈彎曲或打結。使用彎曲或打結油管易引起背壓。強烈彎曲或打結的油管亦易引起內部損壞或提早油管老化。



**千萬不要重壓油管。**劇烈的撞擊會造成油管內鋼絲網損壞。使用受損的油管可能導致油管破裂。



**重要事項：**千萬不要利用油管來提攜其他油壓設備(例如:小型油壓缸、泵浦..等)



**危險事項：**液(油)壓設備應遠離火或熱源  
高溫會軟化包裝和密封材料，導致液壓油洩漏；高溫同時也會造成油管材質與包裝變質。為確保最好狀態，不要將液(油)壓設備暴露於 65°C(150°F)高溫。在電焊場所時亦應注意防止電焊火花噴到油管。



**危險事項：**不要用手對油管施加壓力(包括拉或舉高) 高壓下洩漏的液壓油會穿透皮膚造成嚴重傷害。當液壓油侵入皮膚請立即就診。

施工件需明顯且穩固地被支撐，須預防零件因壓力而破裂飛噴。  
勿超荷使用各配件。超荷使用配件或壓床易造成工件或機台損毀。

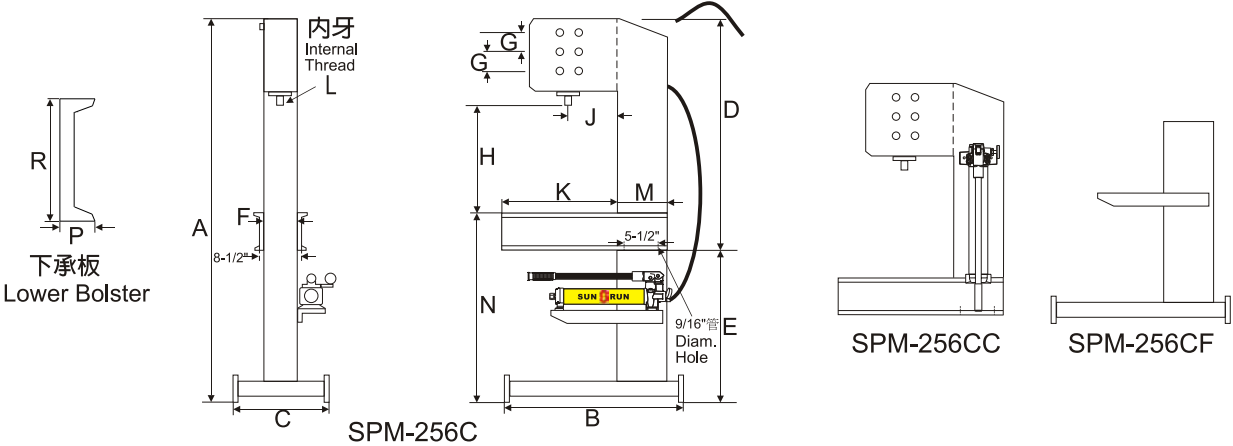
壓床管理者務必使壓床各部位牌示(含警告)明顯可見。

為因應壓床使用多功能性，操作使用時應搭配使用多功能性的保護罩防止施工工件產生意外。  
例如施壓前先將工件以包裝方式保護，防止施壓後工件破裂噴出或滑動。

2. 規範

2.1倘若您所使用壓床搭配泵浦，請確認所有接頭是否完全密合連接並檢查是否合於下列規範：

2.2液壓油: Aw46



H-Frame Press Dimensions (mm)																
外型尺寸																
A	B	C	D	E	F	G	H(Cyl. Retracted)	J	K	L	M	N	P	R	底座 Floor Space	
1972	622	610	1057	914	152	127	260, 387, 514	165	318	(in) 1-1/2~16	203	1092	51	178	610*622	

Model No. 壓床型號	Cylinder Model 油壓缸型號	Cap. (tons) 能力	Type of Cylinder Used 油壓缸型式	Stroke 揚程	Speed(in./stroke) 速度		Pump type 泵浦	Weight (kg) 重量
					Advance 前進	Pressing 擠壓		
SPM-256C	RSC-256	25	Single-Acting	158mm	0.129	0.03	Hand	109

標準液壓手動泵浦 (詳見型錄SPH系列)  
Equipped with Hydraulic Manual Pump (reference SPH series)

Model Number  型 號	Usable Oil Capacity  有效油量 (cm <sup>3</sup> )	Pressure Rating  輸出壓力		Oil Displacement per Stroke  輸出油量		Piston Stroke  行程  (mm)
		1 <sup>st</sup> stage	2 <sup>nd</sup> stage	1 <sup>st</sup> stage	2 <sup>nd</sup> stage	
		(bar)		(cm <sup>3</sup> )		
SPH-1200	1200	14	700	12.5	2.8	19



選配液壓電動泵浦 (詳見型錄SPE-3000系列)  
Opt Hydraulic Electric Pump(reference SPE-3000 series)

Model Number 型號	Motor 馬達	Pressure Rating (Psi)/(bar) 輸出壓力		Output flow rate (L/min) 輸出油量	
		1 <sup>st</sup> stage	2 <sup>nd</sup> stage	1 <sup>st</sup> stage	2 <sup>nd</sup> stage
SPE-3000	0.5hp	200(14)	10,000(700)	4	0.4



### 3.操作

- 3.1 使用時請確認平台使用高度，將平台升到適當高度後將插銷置入。  
再將物件平穩放置，如有搖晃情形請重新放置，務必平穩放置以防物件飛出發生危險。
- 3.2 工作過程時需注意物件變化，防止施壓過程工件承壓破裂，造成傷害。當按鈕放鬆時壓床自動停止動作，即不再產生施壓能力。操作過程操作人員應注意實施1.安全措施要項，避免危險。  
無論操作與否操作者四肢及軀體均應避免位於物件或壓台下方，防止物件或壓台突然掉落，造成危險。
- 3.4 工作完成後請將油壓缸主軸縮回最高(原點)。

# 出廠證明暨保固書

產品名稱：

型 號：

序 號：

出廠日期：        /        /

保固期間：        /        /        ~        /        /

該產品經公司嚴格品質管制,並測試合格出廠,本產品自驗收合格日起保固一年,如非人為使用不當或天然不可抗拒之災害,本公司免費維修,如非以上之原因本公司將酌收材料成本負責維修。

公司：巨輪興有限公司

負責人：蘇明益

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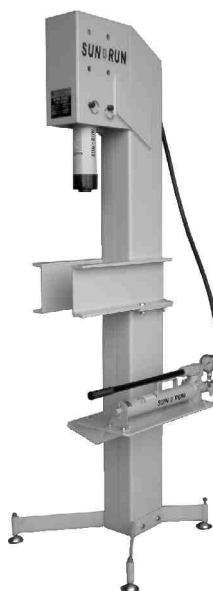
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# OPERATING INSTRUCTIONS

## C FRAME PRESSES

### SPM-256C



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English : E1~E3

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## 1. SAFETY PRECAUTIONS



Fail to comply with the following cautions and warnings could cause equipment damage and personal injury.



**IMPORTANT :** 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 SUN RUN equipment. The operator is responsible for this activity towards other persons.



**WARNING :** To avoid personal injury and possible equipment damage, make sure all hydraulic components withstand the maximum pressure of 700 bar(10,000psi).



**WARNING:** Always wear safety glasses. The operator must take precaution against injury due to failure the tool or workpiece.



**DANGER:** To avoid personal injury keep hands and feet away from cylinder and workpiece during operation.



**WARNING :** Do not overload equipment. Overloading cause equipment failure and possible personal injury. The cylinders are designed for a max. Pressure of 700 bar (10,000psi).



**WARNING:** Immediately replace worn or damaged parts with genuine SUN RUN parts. SUN RUN parts are designed to fit properly and withstand rated loads.



**IMPORTANT:** Hydraulic equipment must only be serviced by a qualified hydraulic technician. For repair service, contact the SUN RUN Service Center in your area. To protect your warranty, use only SUN RUN oil.



**DANGER: NEVER** set the relief valve to a higher pressure than the maximum rated pressure of the pump. Higher settings may result in equipment damage and/ or personal injury. Do not remove relief valve.



**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.



**CAUTION:** Avoid sharp bends and kinks that will cause severe back-up pressure in hoses. Bends and kinks lead to premature hose failure.



**DO NOT** drop heavy objects on hose. A sharp impact may cause internal damage to hose wire strands. Applying pressure to a damaged hose may cause it to rupture.



**IMPORTANT:** Do not lift hydraulic equipment by the hoses or couplers. Use the carrying handle or other means of safe transport.



**CAUTION :** KEEP HYDRAULIC EQUIPMENT AWAY FROM FLAMES AND HEAT. 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 hoses and cylinders from weld spatter.



**DANGER:** Do not handle pressurized hoses. Escaping oil under pressure can penetrate the skin causing serious injury. If oil is injected under the skin, see a doctor immediately.

Work pieces must be well supported and aligned so when pressure is exerted, parts being pressed do not slip out or break. 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 owner of the press must replace all safety-related decals if they become too hard to read.

It is impossible for the manufacturer to provide practical "all-purpose" shielding because this is a general purpose press that can be used in many different applications. The owner of the press must supply shielding that is practical and necessary for each application. Some safety is provided by wrapping the piece in a protective blanket before applying pressure.



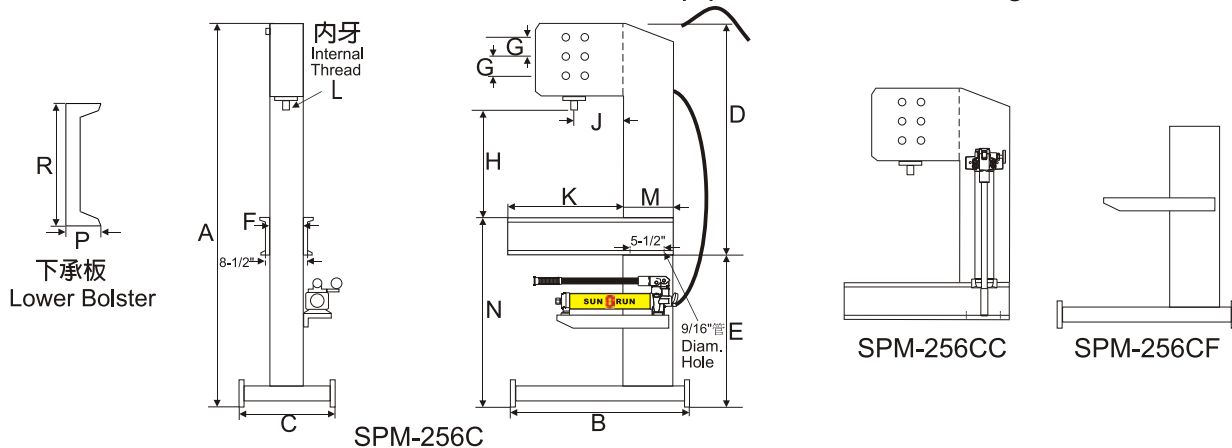
## 2. SPECIFICATION

### Bolster Adjustment:

A winch and cable assembly support the bolster when the support pins are not in place.

The following rules must be observed to prevent personal injury:

1. Keep hands, feet, etc. Out from under the bolster. Accidental slippage can result in personal injury.
2. To prevent slippage, all bolster support pins must be in place, and all cables slack, before placing a work piece on the press bed or starting a pressing operation.
3. To prevent cable breakage, never raise or lower the bolster while it holds a load.
4. When raising or lowering the bolster, remove the work the work piece. Insert a support pin all the way through the front and back uprights in the highest hole under the bolster that will not interfere with the new bolster position. Remove your hands from the support pins after the pins are in place to avoid personal injury should the bolster fall.
5. Inspect the entire length of the lifting cables at least every three months. Replace any cable that appears frayed, worn, or crushed. The cables must run on the pulleys easily, and the pulleys must be free to turn. Careful cable maintenance will help prevent cable breakage.



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SPE-3000	0.5hp	200(14)	10,000(700)	4	0.4



### 3. OPERATING

Assemble the gauge and hose to the pump using the hydraulic hose, gauge, adapters, and couplers that have been supplied.

**IMPORTANT:**

Use a high grade of non-hardening pipe sealer to seal hydraulic connections. Teflon tape can be used if only ONE layer of type is used. Leave the first exposed (no tape). Apply carefully to prevent the tape from being pinched by the coupler and broken off inside the system. Any loose piece of tape could travel through the system and possibly obstruct the flow of oil.

1.Thread ram into ram mounting plate.

IMPORTANT: The threads of the ram must be flush with the bottom of the mounting plate (full thread engagement).

2.Place the ram assembly on the lower bolster.

IMPORTANT: The pipe plug on the ram must face the pump side of the press frame.

3. By operating the winch mechanism, raise the ram assembly to the upper bolster. Block the ram assembly if additional height is needed so the ram will reach the upper bolster when the lower bolster is raised.

4. After the ram assembly has been secured to the upper bolster, lower the bolster assembly onto the bolster pins.

5.Bleed the hydraulic system by slowly operating the pump handle until an air-free stream of hydraulic oil flows from the hose.

6. Straighten the press and wrench tighten all hex nuts and cap screws.

**IMPORTANT:**

1.Retract the ram when it isn't being used to prevent damage to the finished surface of the piston rod.

2.When refiling the pump reservoir, use only high-grade hydraulic oil. Never use brake fluids or other substitutes.