



巨輪興有限公司

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H型壓床 操作說明

STP15,STP-35



STP-35



STP-15

中文 : C1~C4

中文
English
Ver.16

1. 安全預防措施



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。



警告事項：不得使用油壓設備作為支撐重物使用。當液(油)壓缸作為負載頂昇設備時，僅可頂昇，不可用來支撐重物使用。當完成頂升作用後，需使用機械性工具來固定支撐。



警告事項：必須使用硬性物體來支撐重物。慎選能承受重物的鋼鐵或木塊來支撐荷載。不要在頂升或持壓使用中將液(油)壓缸當做墊塊使用。



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)。



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)。



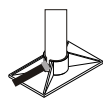
危險事項：液(油)壓設備應遠離火或熱源。高溫會軟化包裝和密封材料，導致液壓油洩漏；高溫同時也會造成油管材質與包裝變質。為確保最好狀態，不要將液(油)壓設備暴露於 65°C(150°F)高溫。在電焊場所時亦應注意防止電焊火花噴到油管。



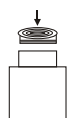
危險事項：不要用手對油管施加壓力(包括拉或舉高) 高壓下洩漏的液壓油會穿透皮膚造成嚴重傷害。當液壓油侵入皮膚請立即就診。

1. 安全預防措施

 **警告事項：**液(油)壓缸只能在已連接好的液壓油路中使用；快速接頭尚未確實連接時禁止使用或加壓，否則高壓情況下接頭的油封及鋼珠會高速噴出造成人員傷亡。

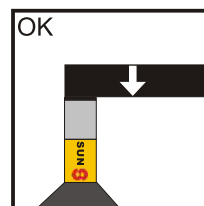
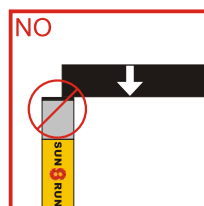
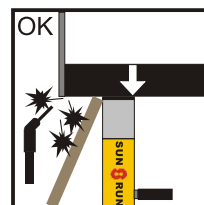
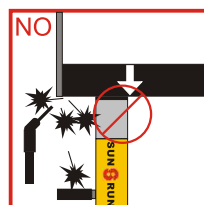
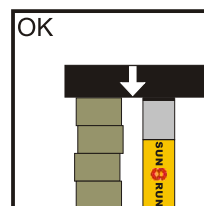
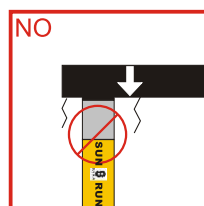
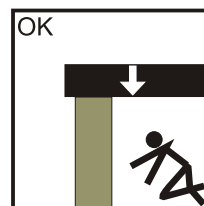
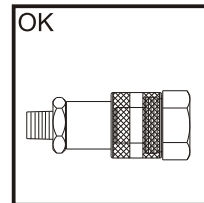
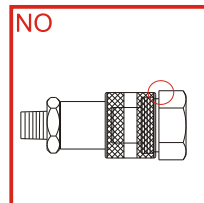
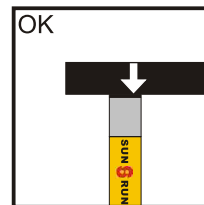
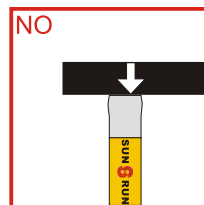
 **警告事項：**頂昇荷載前，請確保油壓裝置平穩。油壓缸必須放在平穩可支撐重物的基座上。若情況許可，可使用油壓缸基座來增加穩定性。千萬不可使用焊接或其他方法將油壓缸與所使用的基礎面(支撐座)連接一起。

 避免荷載不直接作用在油壓缸的主軸中心上。偏心荷載易導致油壓缸和主軸受損。此外，重物亦可能因傾斜而滑落，引發潛在危險。

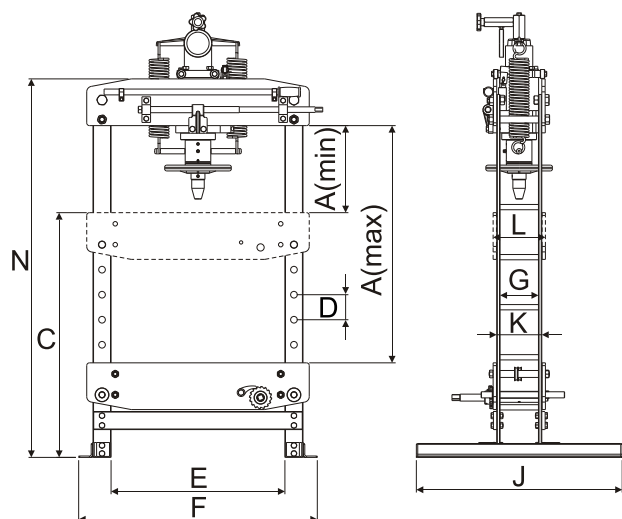
 將荷載平均的分布在墊塊表面。傾斜墊塊可消除偏荷載。當無使用螺牙連接其他附件時，一定要使用墊塊以保護主軸。

 **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。

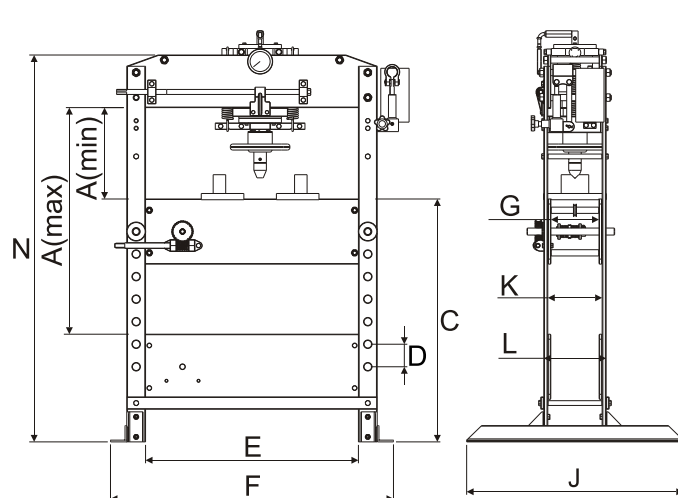
 **重要事項：**液壓設備必需由合格的液壓技工進行維修。需要修理時，請聯繫就近的**SUN RUN**服務據點並使用**SUN RUN**液壓油保固方為有效。



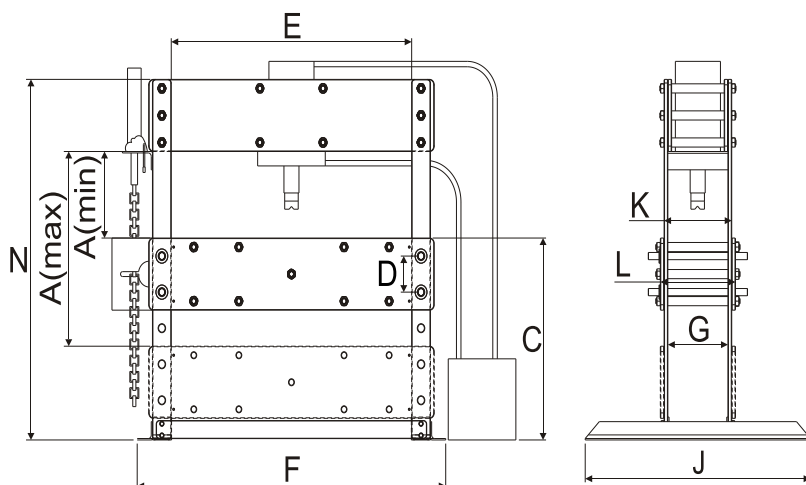
2. 規範



STP-15 / STP-15A



STP-35 / STP-35A / STP-35E



STP-100E / STP-60E

Model Number	Cylinder Capacity	Screw Stroke	Ram Stroke	Operting Pressure	Press Modal Pump	Output Flow Rate	Dimensions(mm)												Wt.
型 號	能 力 ton(kN)	輔助高 (mm)	揚程 (mm)	使用壓力 (kgf/cm ²)	幫浦 樣式 ²⁾	輸出油量	外型尺寸												重量 (kg)
							A (max)	A (min)	C	D	E	F	G	J	K	L	N		
STP-15	15(148)	90	108	300	H	5c.c./once	1000	310	880	90	625	858	138	740	162	188	1510	168	
STP-35	35(335)	125	172	360	H	6c.c./once	1085	335	970	90	850	1130	192	865	217	249	1695	220	
STP-35AH ¹⁾					A & H	750c.c./min												222	
STP-35EH ¹⁾				E & H	8750c.c./min	250													
STP-60E ¹⁾	60(523)	—	310	70 210	E	8750c.c./min 3000c.c./min	1050	250	1350	100	1050	1380	268	1000	306	338	1900	670	
STP-100E ¹⁾	100(1010)	—	300	70 210	E	8750c.c./min 3000c.c./min	1080	480	1120	200	1600	2050	400	1500	450	500	2000	1500	

1) STP-35AH : Air pressure 7~10kgf/cm² STP-35EH : 0.5HP*110/ 220V*1PH STP-60E : 3HP*220V*3PH STP-100E : 5HP*220V*3PH
STP-35AH : 使用空壓 7~10kgf/cm² STP-35EH : 0.5HP*110/220V*1PH STP-60E : 3HP*220V*3PH STP-100E : 5HP*220V*3PH

2) H: by manual A: by air E: by electric H / 手動 A / 氣動 E / 電動

2.操作

將壓床拆封後使壓床穩固直立於平坦地面。對照零件表依下列步驟完成組裝：

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：

氣動泵浦：7~10kgf/cm² (圖1)

電動泵浦：

STP-35E: 0.5HP-110/220V-1PH

STP-60E: 3HP-220V-3PH

STP-100E: 5HP-220V-3PH

*電動泵浦請再確認銘牌上詳細規格



圖1

2. 工作檯面位置：

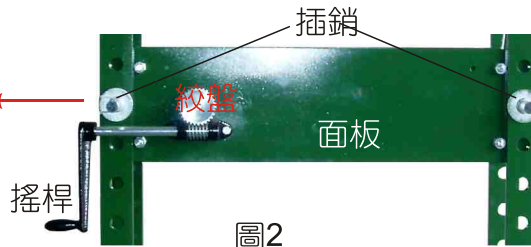


圖2



圖2-1
STP-15

2.1 下面板(圖2):

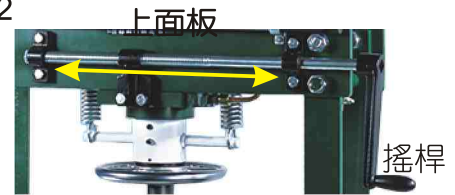
- 利用搖桿先將鋼索稍稍拉緊，使插銷上面板的重量得以轉移。先緩慢取出一邊插銷直到完全脫離插銷孔。
- 利用搖桿將面板稍稍舉起直到另一邊插銷完全取出。
- 轉動搖桿利用絞盤使工作檯面上升或下降。定位後再將插銷重新完全插入。

- ★當下降STP-15的下面板時，使用者的手不可離開搖桿並且腳不可站立於面板下方如(圖 2-1)。
- 假若使用者手離開搖桿將會造成下面板急遽掉落。
- ★無論上升或下降面板重新安裝插銷時，需完全由前至後插入孔內。
- ★當面板位置已定位且插銷也已完全插入插銷孔內，稍微轉動搖桿並放鬆鋼索。
- 因為當面板承壓時緊繃的繩索易造成斷裂或金屬疲乏。
- ★為防止鋼索斷裂，千萬不可於面板承壓時上升或下降移動。
- ★每三個月至少檢查全鋼索一次。當發現鋼索有磨損、斷痕或其他損傷時需立即更換鋼索。
- 鋼索需能輕鬆縮放自如，若有其他異狀需立即處理。

2.操作(續頁)

2.2 上面板 (圖2-2):
轉動搖桿使主軸可左右移動。

圖2-2



2.3 泵浦 (圖2-3):

A. 檢查泵浦所有接頭是否密合且洩壓閥是否旋緊。



手動式



氣動式

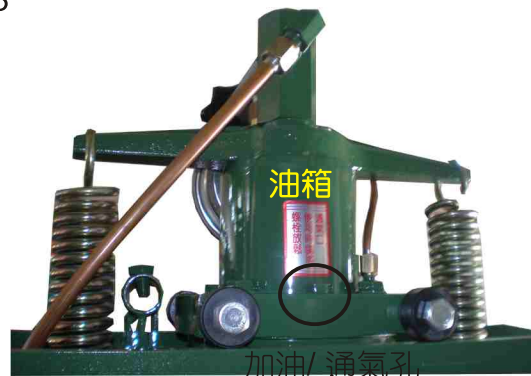


電動式



洩壓閥

圖2-3



B. 工作前請先檢查油位是否正確；加油/通氣蓋是否已更為為鑽孔螺栓。
★油位每三個月至少檢查一次並注入液壓油R32達油箱90%。

2.4 操作過程：

假如面板已昇至最高，但工件仍無法和主軸接觸(工作)
請轉動方向盤(如圖2-4) 延伸主軸長度。

★ 延伸主軸長度非正確舉，因為極力建議使用高硬度墊板(或V型墊塊)
縮短主軸與工件間距離。

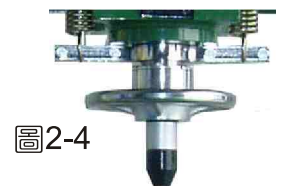


圖2-4

步驟 2.1~2.3皆執行後，使用者可先使用手動方式操作，較為快速及達省力效果。
當工作略感吃力時，可改用氣動或電動泵浦系統增加工作效率。

★當工作完成，請將主軸縮回原點。

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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OPERATING INSTRUCTIONS

H FRAME PRESSES

STP15,STP-35



STP-35



STP-15

English : E1~E4

中文
English
Ver.16

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.



WARNING: 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: USE ONLY RIGID PIECES TO HOLD LOAD. Carefully select steel or wood blocks that are capable of supporting the load. Never use a hydraulic cylinder as a shim or spacer in any lifting or pressing application.



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).



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.



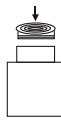
DANGER: Do not handle pressurized hoses. Escaping oil under pressure can penetrate the skin causing serious injury. If oil is injected under the skin, see a doctor immediately.

1. SAFETY PRECAUTIONS

 **WARNING:** Never pressurize uncoupled couplers. Only use hydraulic equipment in a coupled system.

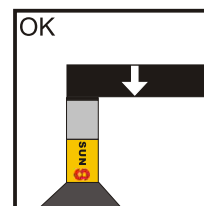
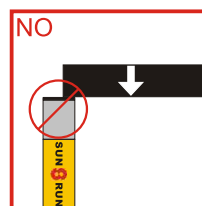
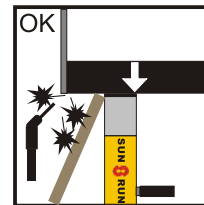
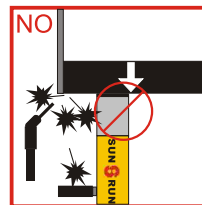
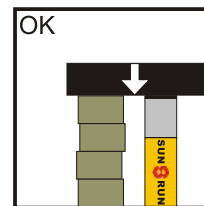
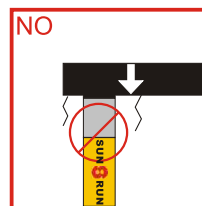
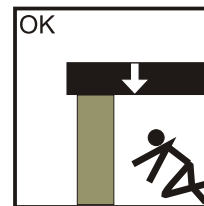
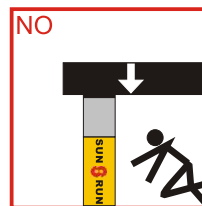
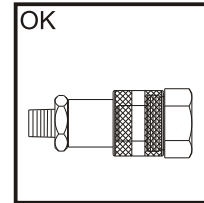
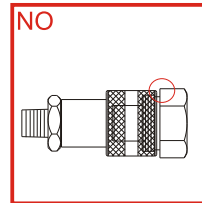
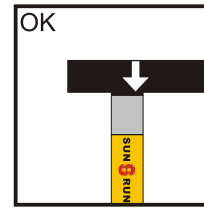
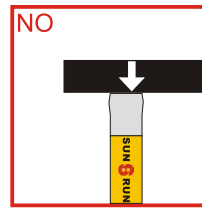
 **WARNING: BE SURE SETUP IS STABLE BEFORE LIFTING LOAD.** Cylinders should be placed on a flat surface that can support the load. Where applicable, use a cylinder base for added stability. Do not weld or otherwise modify the cylinder to attach a base or other support.

 **Avoid** situations where loads are not directly centered on the cylinder plunger. Off-center loads produce considerable strain on cylinder and plungers. In addition, the load may slip or fall, causing potentially dangerous results.

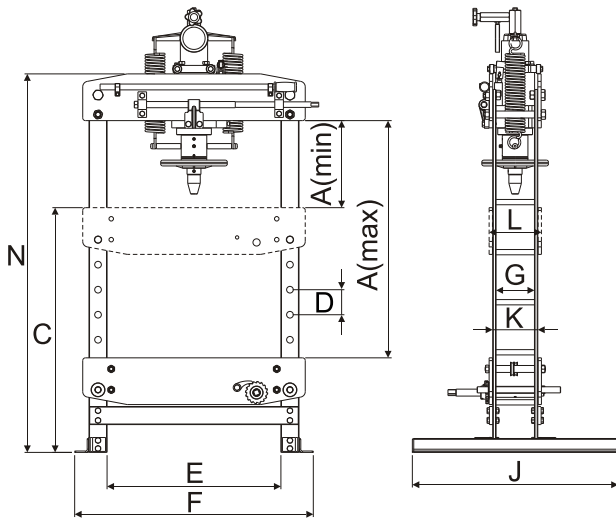
 Distribute the load evenly across the entire saddle surface. Always use a saddle to protect the plunger.

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

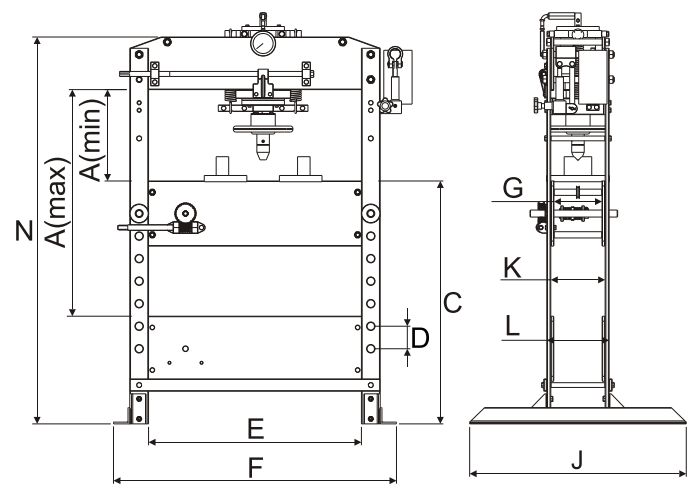
 **IMPORTANT:** Hydraulic equipment must only be serviced by a qualified hydraulic technician. For repair service, contact the SUN RUN Service Center in your area. To protect your warranty, use only SUN RUN oil.



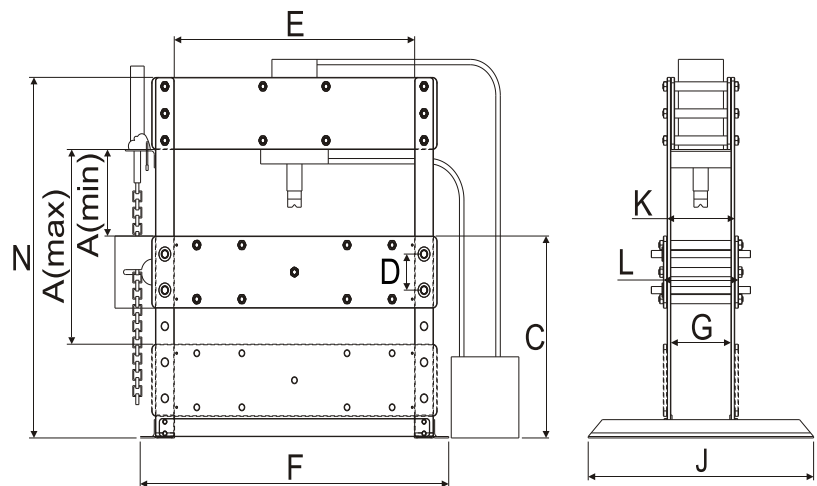
2. Dimensions



STP-15 / STP-15A



STP-35 / STP-35A / STP-35E



STP-100E / STP-60E

Model Number	Cylinder Capacity	Screw Stroke	Ram Stroke	Operting Pressure	Press Modal Pump 2)	Output Flow Rate	Dimensions(mm)												Wt.
							A (max)	A (min)	C	D	E	F	G	J	K	L	N	重量 (kg)	
STP-15	15(148)	90	108	300	H	5c.c./once	1000	310	880	90	625	858	138	740	162	188	1510	168	
STP-35	35(335)	125	172	360	H	6c.c./once	1085	335	970	90	850	1130	192	865	217	249	1695	220	
STP-35AH 1)					A & H	750c.c./min												222	
STP-35EH 1)					E & H	8750c.c./min												250	
STP-60E 1)	60(523)	—	310	70 210	E	8750c.c./min 3000c.c./min	1050	250	1350	100	1050	1380	268	1000	306	338	1900	670	
STP-100E 1)	100(1010)	—	300	70 210	E	8750c.c./min 3000c.c./min	1080	480	1120	200	1600	2050	400	1500	450	500	2000	1500	

1) STP-35AH : Air pressure 7~10kgf/cm² STP-35EH : 0.5HP*110/ 220V*1PH STP-60E : 3HP*220V*3PH STP-100E : 5HP*220V*3PH

2) H:by manual A:by air E:by electric

3. OPERATE

Remove banding from the press and shipping pallet, and remove all cartons. Stand the press upright. Refer to the part list, and follow these instructions during the assembly of hydraulic components and accessories.

1. If your hydraulic presses is with pump ,please check any connect of pump to hydraulic presses and inspect as below:

Air pressure range : 7~10kgf/cm² (fig1)

Electric Pump :

STP-35E: 0.5HP-110/220V-1PH

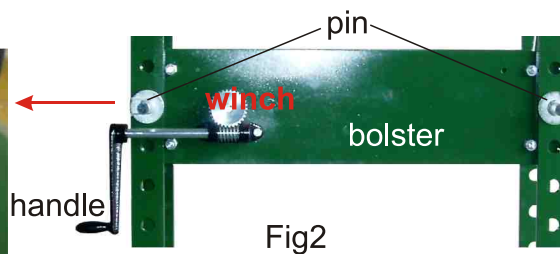
STP-60E: 3HP-220V-3PH

STP-100E: 5HP-220V-3PH

*Electric Pump please check again from nameplate.



- 2.Positioning the work bed:



- 2.1 Low bolster(fig2):

- Put a small amount of tension on the cable by cranking the winch up, taking weight off the pins. This frees the pins in the end of the bolster next to the winch (or right side of the press). Pull the loose pins out.
- Raise the other end of the bolster by pulling slightly on the handle until the other two pins are free.
- Crank the winch for either up or down movement of the work bed. Reassemble the pins.

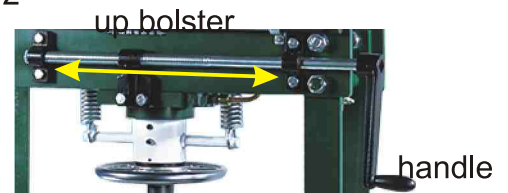
- ★ **As put down STP-15's low bolster, user hand can't leave the winch handle and user foot can't stand under the bolster (Fig2-1).** If user hand leave the handle will cause bolster to fall down sharply.
- ★ No matter raising or lowering the bolster, must assemble pin from front to back hole completely.
- ★ When bolster position is ready and support pins are inserted completely then turn a little the winch handle to **release cable**. That because nervous cable maybe broken or make metal fatigue as bolster pressured.
- ★ To prevent cable breakage, never raise or lower the bolster while it holds a load.
- ★ 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.

2. OPERATE(CONTINUE)

2.2 Up bolster (fig2-2):

Use handle to move plunger to right or left.

fig2-2



2.3 Pump (fig2-3):

A. To inspect all connect with pump and screw release valve.



Manual



Air pump



Electric pump



release valve



Oil tank

oil/ vent cap

fig2-3



oil/ vent cap

B. Inspect oil level and change drilled bolt to be oil/ vent cap before working.

★ Inspect the oil at least every three months and fill hydraulic oil R32 till 90% of oil tank.

2.4 Process :

If bolster is at highest position ,but object still can't touch plunger, please use wheel (as fig2-4) to extend plunger.

★ Extended plunger is unsuccessful at high pressure, so we sharply suggest to use other strenuous plate (or V-Blocks) to reduce distance both of plunger and object .

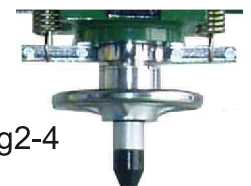


fig2-4

After step2.1~2.3 user can use manual type at first , it will be faster and easy to work.

As you fell strenuous to work, you can choose air pump or electric pump type to increase working efficiency.

★ As finish working, should return the plunger completely.