

Fault Description: The usual symptoms of a Double Acting Press Ram with air in the hydraulic system are as follows.

- No resistance in the pump stroke while advancing or retracting the ram [pump handle feels light].
- Most of the down stroke of the pump handle taken up but no advance or retract movement of the Ram.
- Ram advances or retracts erratically while being pumped in either direction.

Bleeding Procedure

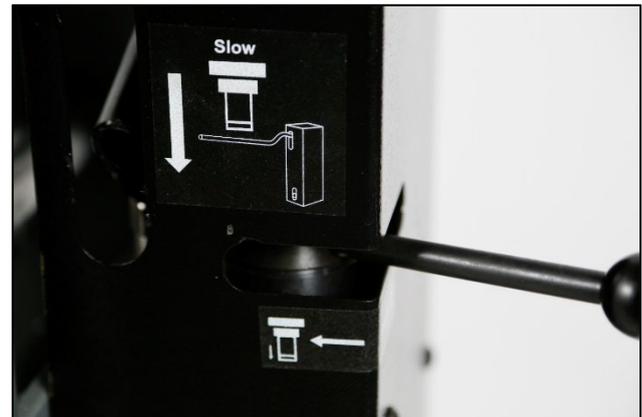
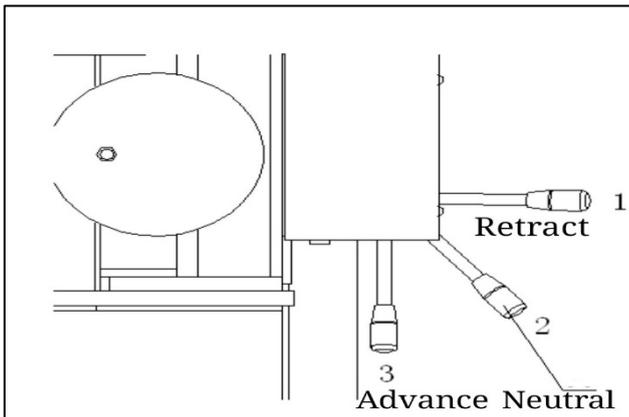
1. Remove the Breather/Filler and if required, refill with *32 Grade Hydraulic until the oil is within 3cm of the filler hole then replace the Filler Bung/Breather and open the Breather air vent screw.



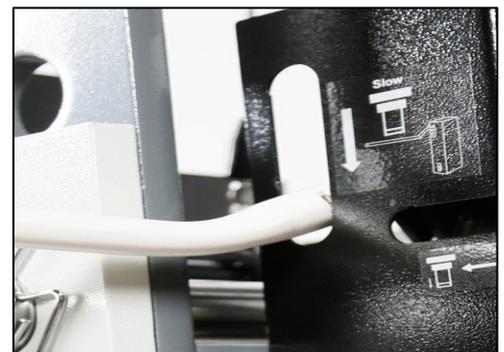
Advance/Retract/Neutral position selector positions as follows.

1	When the handle lever (I) is in position 1, the ram piston is retracting.
2	When the lever (I) is in position 2, the ram piston has stopped moving.
3	When the handle lever (I) is in position 3, the ram piston is extending.

2. Start with the direction selector control valve in the Neutral [2] position as shown below.



3. Insert the Pump Handle into the socket [slow manual pump] and pump the handle no less than twenty cycles.



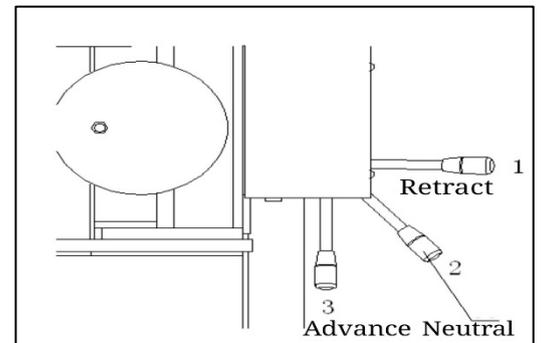
4. Insert the Pump Handle into the socket [Quick manual pump] and pump the handle no less than twenty cycles.



5. Connect the air supply hose to the air foot valve controller.



6. Turn the selector valve lever to Neutral position 2, then depress the air foot valve, keeping the air motor working no less than two minutes (120secs).



7. Turn the selector valve lever to Advance position 3, pump the ram to full extension and check if the ram is working properly then turn the selector valve lever to Retract position 1, and pump the ram to full retraction then check if the ram is working properly; If the ram is working properly air bleeding is completed.
8. Should any of the symptoms described in the instruction's introduction remain, please repeat the bleeding processes 1 to 7 or alternatively contact your TQB Brands Distributor.

At this point both the Pump and Press Ram should be free of air and the Jack ready for operation

** The Borum range of Presses use grade 32 Grade Hydraulic Oil for the correct operation and compatibility with the seals used in their construction.*