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**Hydraulic Press Assembly
Operation Manual
Order No. 19286-1000**



- Description
- Operation
- Maintenance

Safety Warnings and Information

	<p>Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.</p> <p style="text-align: center;"><u>Keep this manual available when using this tool.</u></p> <p>Replacement manuals are available for download at no charge at www.molex.com.</p>
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<h3 style="color: red; margin: 0;">SAFETY ALERT SYMBOL</h3> <p>This symbol is used to call your attention to hazards or unsafe practices which could result in an injury or property damage. The signal word, defined below, indicates the severity of the hazard. The message after the signal word provides information for preventing or avoiding the hazard.</p>	
 <b style="color: red;">DANGER	<p><b style="color: red;">DANGER: Indicates an imminently hazardous situation which, if not avoided, could result in death or serious injury.</p>
 <b style="color: red;">WARNING	<p><b style="color: red;">WARNING: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.</p>
 <b style="color: red;">CAUTION	<p><b style="color: red;">CAUTION: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. <b style="color: red;">CAUTION may also be used to alert against unsafe practices associated with events that could lead to personal injury.</p>

	<p> <b style="color: red;">WARNING</p> <p>Always wear proper eye protection when Operating or servicing this equipment.</p> <p>Failure to wear eye protection could result in serious eye injury from flying debris.</p>		<p> <b style="color: red;">WARNING</p> <p>Heavy Object To avoid muscle strain or back injury, use lifting aids and proper lifting techniques when removing or replacing. Failure to observe these precautions may result in injury or property damage.</p>
	<p> <b style="color: red;">WARNING</p> <p>Never wear clothing or jewelry that is loose or That could potentially hang into the equipment and get caught.</p> <p>Failure to observe this warning could result in Severe Injury or death.</p>		<p> <b style="color: red;">WARNING</p> <p>Never install or service this machine while connected to any electrical power source. Disconnect power by unplugging this tool from its power source.</p> <p>Failure to observe this warning could result In severe injury or death.</p>
	<p> <b style="color: red;">WARNING</p> <p>Never operate, service, install, or adjust this machine without proper instruction and without first reading and understanding the instructions in this manual and all applicable tool and/or wire processing machine manuals.</p>		<p> <b style="color: red;">WARNING</p> <p>Always wear proper ear protection when Operating or servicing this applicator. Failure to observe these precautions may result in Injury or property damage.</p>

	<p>WARNING</p> <p>Never use this tool without guards or safety devices that are intended to prevent hands from remaining in the die space.</p> <p>Failure to observe this warning could result in severe injury or death.</p>		<p>WARNING</p> <p>Do not use compressed air to clean this equipment. The forces created by compressed air can force debris into the tool.</p> <p>Failure to observe these precautions may result in injury or property damage.</p>
<p>Air Hydraulic Pump</p>	<p>WARNING</p> <p>Hand/Foot Operated Maximum Capacity: 10,000 PSI</p> <p>Before operating the hydraulic pump, all hose connections must be tightened with proper tools.</p> <p>Do not over-tighten. Connections need only be tightened securely and leak-free. Over-tightening may cause premature thread failure or may cause high-pressure fittings to split at pressures lower than their rated capacities</p> <p>Should a hydraulic hose ever rupture, burst, or need to be disconnected, immediately shut off the pump and shift the control valve twice to release all pressure.</p> <p>Never attempt to grasp a leaking hose under pressure with your hands. The force of escaping hydraulic fluid could cause serious injury.</p> <p>Do not subject the hose to potential hazard such as fire, extreme heat or cold, sharp surfaces, or heavy impact.</p> <p>Do not allow the hose to kink, twist, curl, or bend so tightly that the oil flow within the hose is blocked or reduced. Periodically inspect the hose for wear because any of these conditions can damage the hose and possibly result in personal injury.</p> <p>Do not use the hose to move attached equipment. Stress may damage hose and possibly cause personal injury.</p> <p>Hose material and coupler seals must be compatible with the hydraulic fluid used. Hoses must not encounter corrosive materials such as creosote-impregnated objects and some paints. Consult the manufacturer before painting a hose.</p> <p>Never paint the couplers. Hose deterioration due to corrosive materials may result in possible personal injury</p>	<p>Pump</p>	<p>WARNING</p> <p>Do not exceed the PSI hydraulic rating noted on the pump nameplate or tamper with the internal high-pressure relief valve.</p> <p>Creating pressure beyond rated capacities may result in personal injury.</p> <p>Before replenishing the oil level, retract the system to prevent overfilling the pump reservoir.</p> <p>An overfill may cause personal injury due to excess reservoir pressure created when cylinders are retracted.</p>
		<p>Cylinder</p>	<p>WARNING</p> <p>Do not exceed rated capacities of the cylinders. Excess pressure may result in personal injury.</p> <p>Do not set poorly balanced or off-center loads on a cylinder. The load may tip and cause personal injury.</p>
		<p>Air Supply</p>	<p>WARNING</p> <p>Shut off and disconnect the air supply when the pump is not in use or before breaking any connection in the system.</p>



WARNING

MOLEX CANNOT BE RESPONSIBLE FOR DAMAGE OR INJURY RESULTING FROM UNSAFE PRODUCT USE, LACK OF MAINTENANCE, OR INCORRECT PRODUCT AND SYSTEM APPLICATION.



CAUTION

Failure to observe these precautions may result in injury or property damage.



CAUTION

Never perform any service or maintenance other than as described in this manual.

Never modify, alter or misuse the equipment

Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

Failure to observe this precaution may result in injury and property damage.

Tooling Technical Assistance

Molex offers tooling technical assistance for customers who may need some guidance for tooling adjustments. This support can be obtained by calling either of the two numbers listed below and asking for the Molex Tooling Group.
Call Toll Free 1-800-786-6539 (US) 1-630-969-4550 (Global).

This assistance is limited to the operation and set-up of a customer's Molex Press Assembly. Questions with regard to Molex connector products or how to identify the proper tooling and/ or tooling documentation should be directed to your local Molex personnel or Customer Service Representative.

When calling for service on the tool a copy of the *Tooling Manual* and Specific *Applicator Tooling Specification Sheet* should be present and a person that is familiar with the applicator should be present. Be sure the following information is supplied:

1. Customer name
2. Customer address
3. Person to contact such as (name, title, e-mail, and telephone number)
4. Press order number (Lease number also if applicable)
5. Serial number (Lease number also if applicable)
6. Molex Connector product order number
7. Urgency of request
8. Nature of problem

Molex Application Tooling Group

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Lisle, IL 60532, USA

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Visit our Web site at <http://www.molex.com>

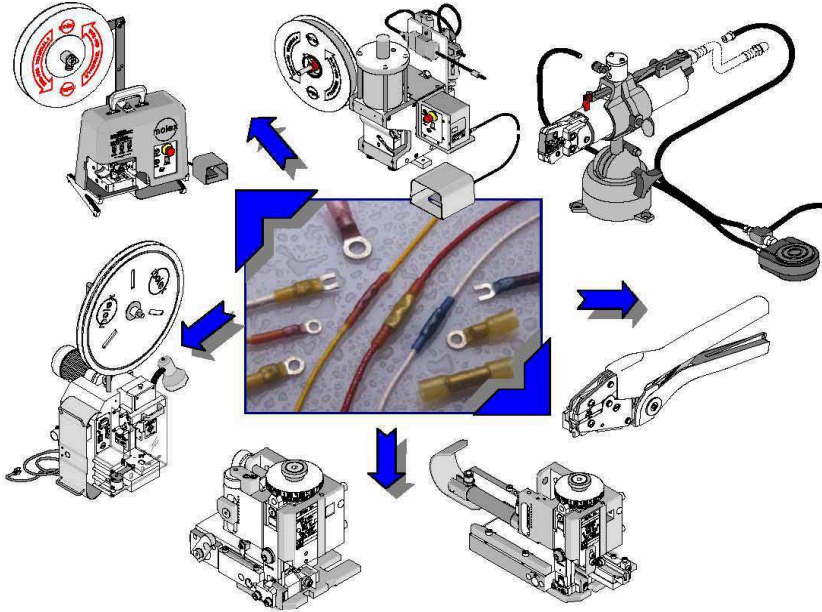
5.4 Troubleshooting

Symptom	Cause	Solution
Pump reciprocates but no oil delivery. (Ram will not extend)	▪ Low oil level.	Replenish oil reservoir.
	▪ Pump not primed.	Depress air intake valve and hydraulic release valve simultaneously.
	▪ Check oil filter for contamination.	Invert pump. Fill intake filter with oil. Depress pedal end marked "pump."
Low oil delivery. (Ram extends slowly)	▪ Reservoir not vented	Remove filter and clean.
	▪ Inadequate air supply: 1. Check air input supply. 2. Contamination, check airside of pump. Thoroughly inspect the slot in the air cylinder tub.	1. Should be 20 CFM minimum. 2. Clean and reassemble.
	▪ Hydraulic failure: 1. Check the oil filter for contamination. 2. Air in hydraulic system.	1. Clean and reinstall. 2. Bleed the system as described in "Preventative Maintenance" Section.
Pump will not build to maximum Pressure. (No visible leakage)	▪ Check the air supply.	100 PSI is required to obtain maximum pressure.
Pump builds pressure but will not hold system pressure.	▪ Check hydraulic connections.	Refit as needed.

For more information use the Crimping Testing and Inspection Handbook for Industrial (Closed Barrel products).

There is no charge for this book, which can be found on the Molex Website (www.molex.com) or contact you local Molex sales engineer.

Industrial Crimp Quality Handbook



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**INDUSTRIAL CRIMP QUALITY
HANDBOOK**
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