

MULTIPRESS®

HYDRAULIC EQUIPMENT

service manual



NOTICE

MULTIPRESS supplies service bulletins, parts lists and parts for presses with serial numbers below 30,000; only as a convenience to our customers.

Any press with a serial number below 30,000 was not manufactured by *MULTIPRESS*.

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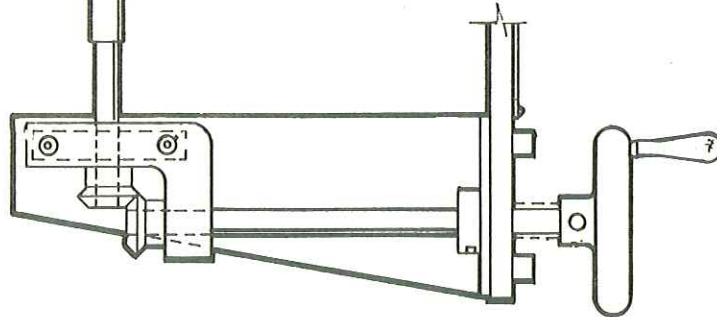
INCHING CONTROL ASSEMBLY

FOR

WR, WS, & WT BENCH MODEL PRESSES

AND

FH THRU FZ FLOOR MODEL PRESSES



MULTIPRESS®

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GENERAL

This manual is intended for reference when servicing and repairing MULTIPRESS® press equipment.

The following models are covered in this manual:

WR, WS & WT bench model presses, with handwheel inching.

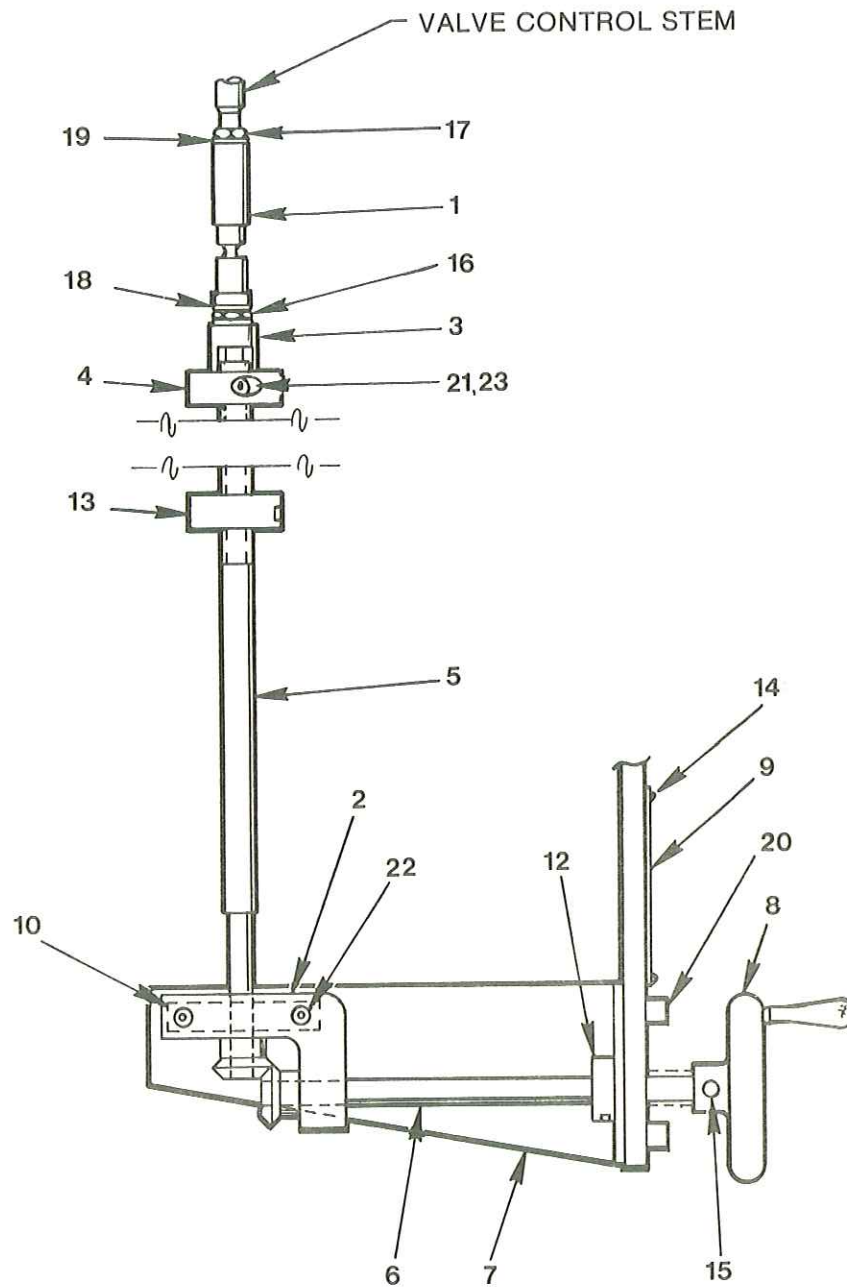
FH, FL, FN, FQ, FX, FY & FZ floor model presses equipped with C201 thru C592 control valves with hand-wheel inching, or C90 series control valves with selector lever inching.

Refer to your basic Multipress manual for operation of inching control.

When ordering parts for inching controls it is important to include your press model number and serial number along with the part number(s) of the part(s) being ordered to assure that the correct part(s) are provided for your press.

WR, WS, & WT PRESSES			FH PRESSES		FL, FN, FQ & FX PRESSES			FY & FZ
MANUAL VALVES	MANUAL OR ELECTRIC VALVES		MANUAL OR ELECTRIC VALVES		MANUAL OR ELECTRIC VALVES			MANUAL OR ELECTRIC VALVES
SINGLE CYCLE	AUTOMATIC AND SINGLE CYCLE		SINGLE CYCLE	AUTOMATIC AND SINGLE CYCLE	SINGLE CYCLE	AUTOMATIC AND SINGLE CYCLE		SINGLE CYCLE
C201	C404	C409	C592	C304	C592	C94	C97	C592EPR
C202	C464	C469		C309		C95	C98	
C261	C304	C309		C404		C96	C99	
	C364	C369		C409				

HANDWHEEL INCHING CONTROL (WR, WS, & WT SERIES PRESSES)

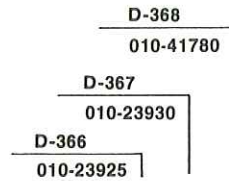


INCHING CONTROL FOR
MANUAL AND AUTOMATIC VALVES

FIGURE 1

HANDWHEEL INCHING CONTROL

(WR, WS, & WT SERIES PRESSES)



Item	Part No.	Description	WR	WS	WT
1	010-03790	Swivel Joint	1	1	1
2	010-23924	Inching Control Bracket	1	1	1
3	030-25430	Positive Stop	1	1	1
4	030-23571	Upper Stop Collar	1	1	1
5	030-25847	Inching Control Rod	1		
	030-23447	Inching Control Rod		1	1
6	030-23380	Gear Control Shaft		1	
	030-23572	Gear Control Shaft			1
	030-49003	Gear Control Shaft	1		
7	030-23762	Mounting Bracket			1
	030-49004	Mounting Bracket	1	1	
8	030-23382	Handwheel	1	1	1
9	030-25519	Instruction Plate	1	1	1
10	030-25851	Bolt Anchor Plate	1	1	1
11		Not Used			
12	210-05000	Collar	1	1	1
13	210-15001	Collar	1	1	1
14	320-10203	Drive Screw #2x3/16	4	4	4
15	325-12160	Rollpin 3/16 x 1	1	1	1
16	335-18100	Hex Jam Nut 7/16 - 14	1	1	1
17	335-19100	Hex Jam Nut 1/2 - 20	1	1	1
18	348-10028	Lockwasher 7/16	2	2	2
19	348-10032	Lockwasher 1/2	1	1	1
20	358-14100	S.H.C. Screw 5/16 - 18 x 5/8			3
	358-14120	S.H.C. Screw 5/16 - 18 x 3/4	3	3	
21	358-14180	S.H.C. Screw 5/16 - 18 x 1 1/4	1	1	1
22	358-14240	S.H.C. Screw 5/16 - 18 x 2	2	2	2
23	345-11020	Washer 5/16 Flat	1	1	1

HANDWHEEL INCHING CONTROL

(FH SERIES PRESS WITH C300 SERIES CONTROL VALVES)

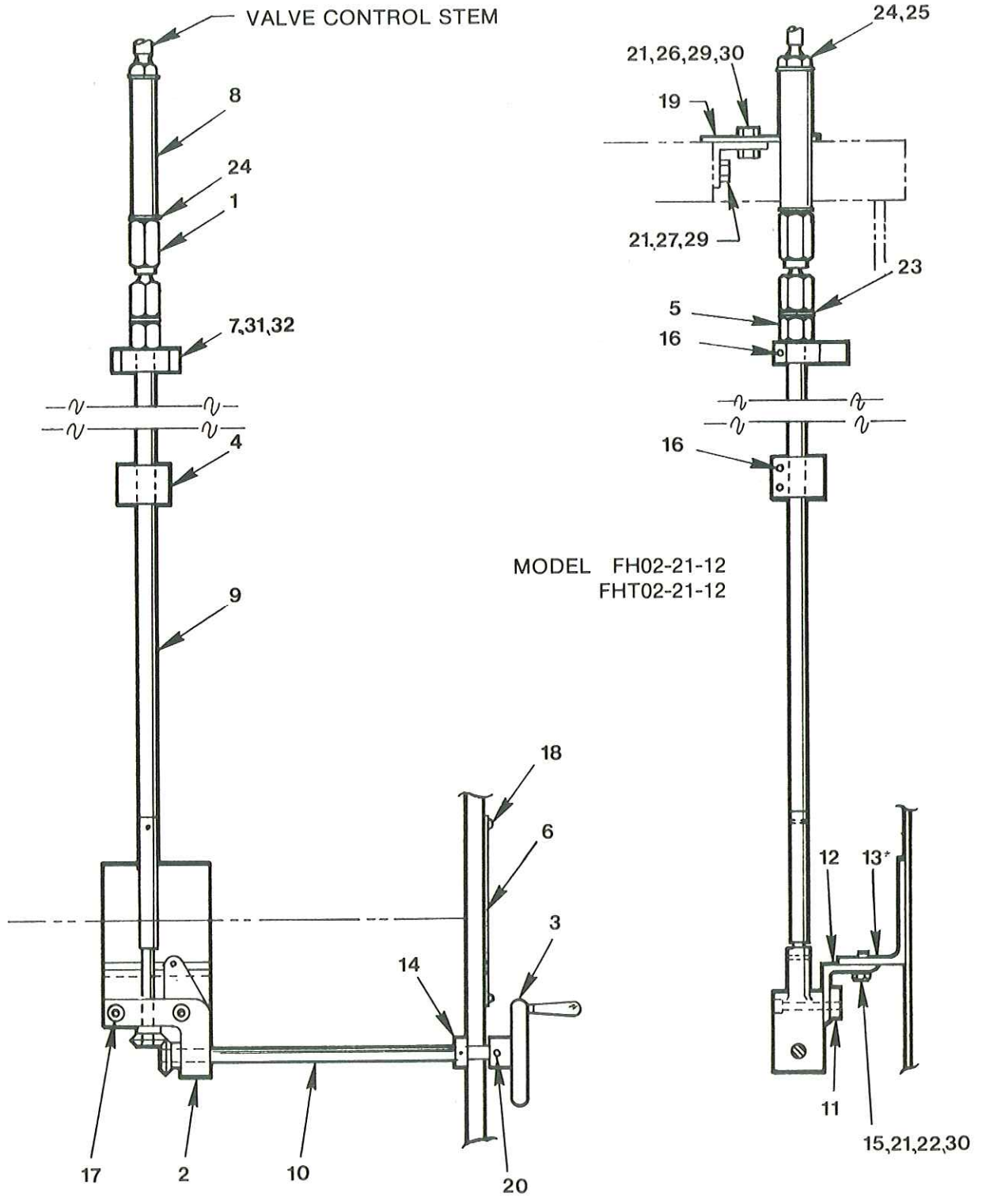


FIGURE 2

*FIELD CONVERSION ONLY

HANDWHEEL INCHING CONTROL

(FH THRU FZ SERIES PRESSES WITH C592 CONTROL VALVE)

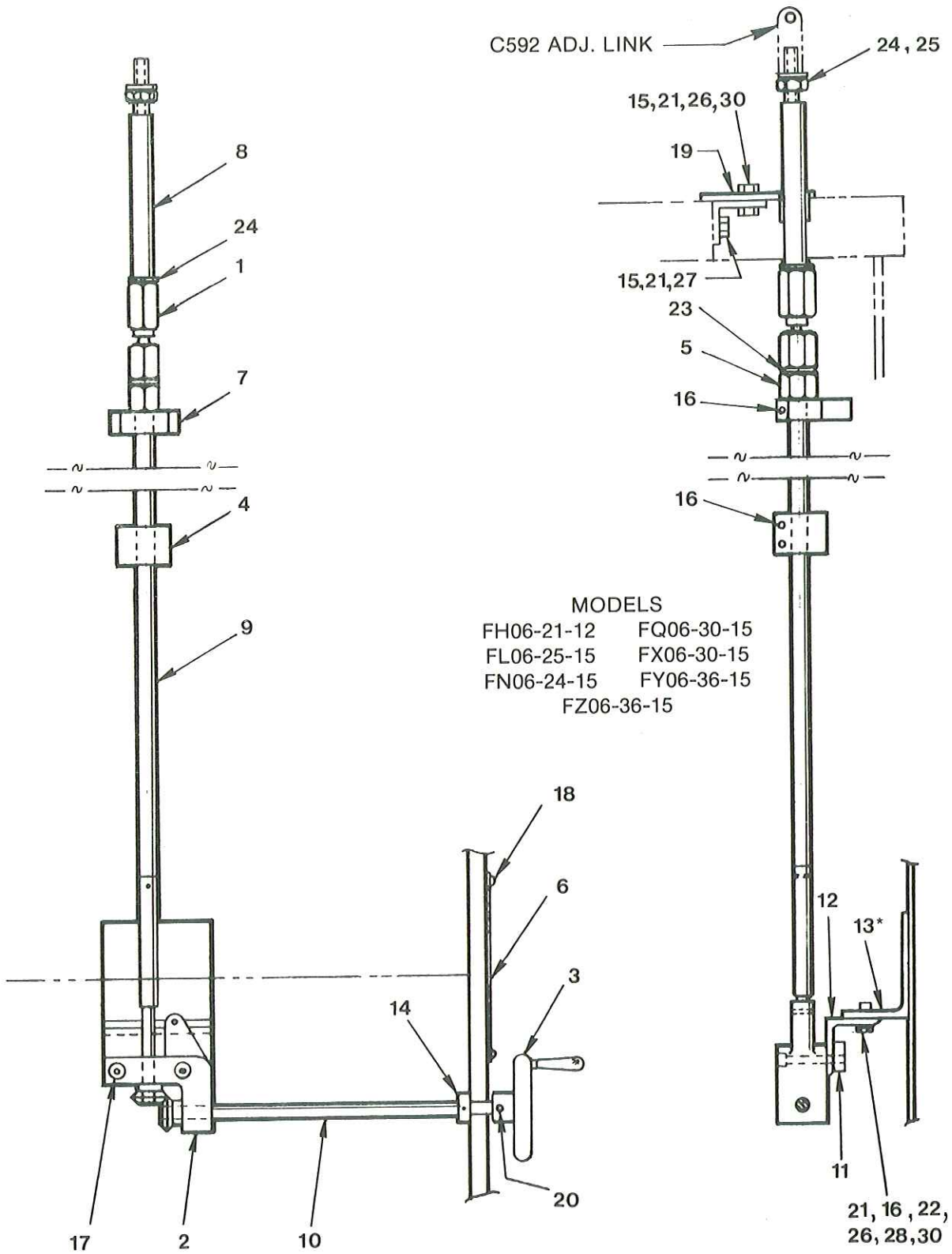


FIGURE 3

*FIELD CONVERSION ONLY

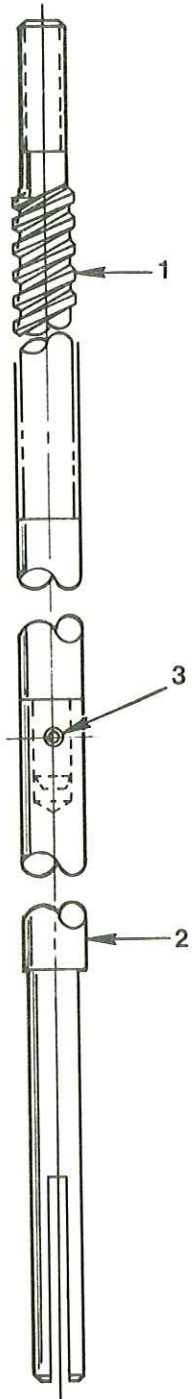
PARTS LIST FOR FIGURES 2&3

Item	Part No.	Description	Model No. Valve									
			FH 12	FH 20	FH 20	FL 35	FN 50	FQ 75	FX 100	FY 150	FZ 200	
1	010-03790	Swivel Joint	1	1	1	1	1	1	1	1	1	1
2	010-23924	Inching Control Bracket	1	1	1	1	1	1	1			
3	030-23382	Handwheel	1	1								
	030-49001	Handwheel			1	1	1	1	1	1	1	1
4	030-48036	Bottom Stop Collar	1	1	1	1	1	1	1	1	1	1
5	030-25430	Positive Stop	1	1	1	1	1	1	1	1	1	1
6	030-25519	Instruction Plate	1	1	1	1	1	1	1	1	1	1
7	030-47199	Upper Stop Collar		1	1	1	1	1	1	1	1	1
	030-69558	Upper Stop Collar	1									
8	030-48123	Inching Adapter		1								
	030-48126	Inching Adapter			1							
	030-48127	Inching Adapter				1						
	030-48128	Inching Adapter					1					
	030-49240	Inching Adapter						1				
	030-49243	Inching Adapter							1			
	030-72525	Inching Adapter								1	1	
9	010-24371	Inching Control Rod	1	1	1							
	010-24372	Inching Control Rod				1						
	010-24384	Inching Control Rod						1				
	010-26274	Inching Control Rod							1			
	010-27634	Inching Control Rod					1					
	010-47522	Inching Control Rod									1	1
10	030-47201	Gear Control Shaft	1	1	1							
	030-47212	Gear Control Shaft				1						
	030-47213	Gear Control Shaft					1					
	032-49241	Gear Control Shaft						1				
	030-49244	Gear Control Shaft							1			
	030-72524	Gear Control Shaft								1	1	
11	030-25851	Anchor Bolt Plate	1	1	1	1	1	1	1	1	1	1
12	030-47202	Gear Assembly Bracket	1	1	1	1	1	1	1	1	1	1
13*	030-48132	Angle	1	1	1	1	1	1	1	1	1	1
14	210-05000	Collar	1	1	1	1	1	1	1	1	1	1
15	306-14160	Hex Hd. Cap Screw 5/16-18 x 1		2	4	4	4	4	4	4		
16	358-14160	Socket Hd. Cap Screw 5/16-18 x 1	3	3	3	3	3	3	3	3	5	5
17	358-14280	Socket Hd. Cap Screw 5/16-18 x 2 1/2	2	2	2	2	2	2	2	2	2	2
18	320-10203	Drive Screw #2 x 3/16 LG	4	4	4	4	4	4	4	4		
19	030-48681	Shipper Rod Guide Bar		1	1	1	1	1	1			
	030-13161	Shipper Rod Guide Bar									2	2
20	325-12160	Rollpin 3/16 x 1	1	1								
	325-12280	Rollpin 3/16 x 1 3/4			1	1	1	1	1	1	1	1
21	346-11020	Std. Lockwasher 5/16	2	4	4	4	4	4	4	4		
22	348-10020	Shakeproof Lockwasher 5/16	2	2	2	2	2	2	2	2	2	2
23	348-10028	Shakeproof Lockwasher 7/16	1	1	1	1	1	1	1	1	1	1
24	348-10032	Shakeproof Lockwasher 1/2	2	2	2	2	2	2	2	2	2	2
25	335-19100	Hex Jam Nut 1/2-20	1	1								
	335-20100	Hex Jam Nut 1/2-13			1	1	1	1	1	1	1	1
26	335-14100	Hex Jam Nut 5/16-18	2	4	4	4	4	4	4	4	2	2
27	030-69350	Angle		1	1	1	1	1	1			
28	358-14180	Screw S.H.C. 5/16-18 x 1 1/4	2	2	2	2	2	2	2			
29	306-14180	Screw H.H.C. 5/16-18 x 1 1/4		4								
30	344-10020	Washer-Std. 5/16 Flat	2	4	4	4	4	4	4	4	2	2
31	030-69274	Spacer-Inching Upper Collar	2									
32	316-12080	Screw-F.H.S.C. 1/4-20 Unc x 1/2	2									
33	030-13163	Retainer-Shipper Rod Guide									2	2
34	358-20420	Screw-S.H.C. 1/2-13 x 5 1/2									4	4

*FIELD CONVERSION ONLY

HANDWHEEL INCHING CONTROL ROD

(USED WITH 300 & 500 SERIES CONTROL VALVES)



Item	Part No.	Description	010-24371	010-24372	010-27634	010-24384	010-26274	010-47522
			FH	FL	FN	FQ	FX	FY/FZ
1	032-47200	Shipper Rod Upper Half	1	1	1	1	1	1
	032-47352	Shipper Rod Lower Half	1					
2	032-47353	Shipper Rod Lower Half		1				
	032-49239	Shipper Rod Lower Half				1		
	032-48039	Shipper Rod Lower Half					1	
	032-69158	Shipper Rod Lower Half			1			
	032-72505	Shipper Rod Lower Half						1
3	325-12100	Rollpin 3/16 x 5/8	1	1	1	1	1	1

FIGURE 4

SELECTOR LEVER ASSEMBLY (USED WITH 90 SERIES CONTROL VALVES)

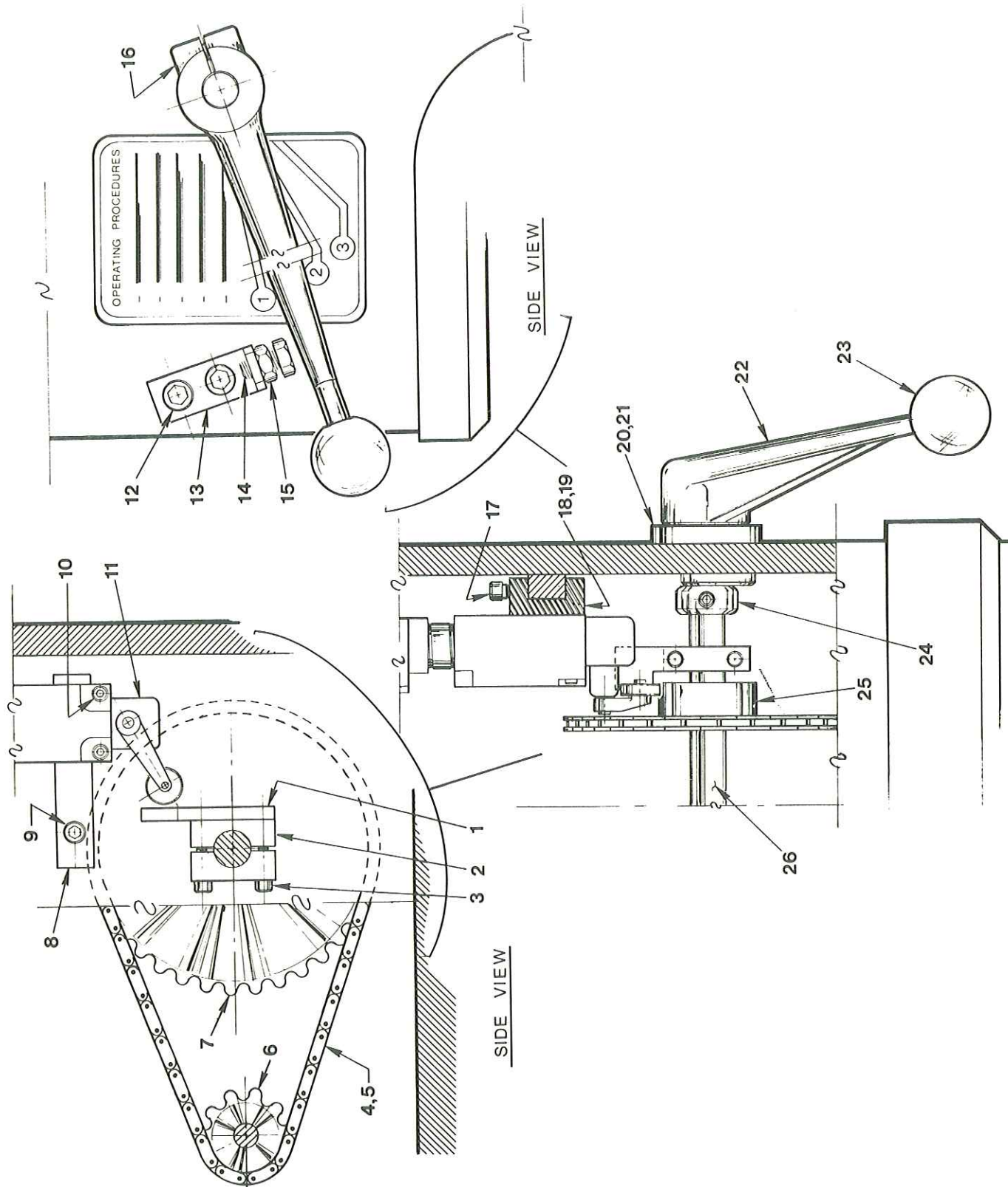


FIGURE 5

SELECTOR LEVER ASSEMBLY

(USED WITH 90 SERIES CONTROL VALVES)

Item	Part No.	Description	MODELS			
			DO1,	DO2,	DO3	
			FH	FL/FN	FQ	FX
1	030-90081	Cam-Emergency Reverse	1	1	1	1
2	030-90082	Clamp-Cam	1	1	1	1
3	358-12200	Screw-S.H.C. 1/4-20 x 1 1/2	2	2	2	2
4	218-10048	Chain-Roller	1	1	1	1
5	218-20048	Link-Offset Chain	1	1	1	1
6	219-30012	Sprocket	1	1	1	1
7	219-30036	Sprocket	1	1	1	1
8	030-90787	Bar-Mounting	1	1	1	1
9	358-12080	Screw-S.H.C. 1/4-20 x 1/2	2	2	2	2
10	358-10220	Screw-S.H.C. 10-24 x 1 3/4	1	1	1	1
11	114-20023	Switch-Limit	1	1	1	1
12	358-14140	Screw-S.H.C. 5/16-18 x 7/8	2	2	2	2
13	030-23223	Stop	1	1	1	1
14	306-16180	Screw-H.H.C. 3/8-16 x 1 1/4	1	1	1	1
15	333-16000	Nut-Hex. 3/8-16	1	1	1	1
16	358-16120	Screw-S.H.C. 3/8-16 x 3/4	1	1	1	1
17	359-09080	Screw-S.H.C. 10-32 x 1/2	1	1	1	1
18	030-90760	Plate-Mounting	1	1	1	1
19	358-09120	Screw-S.H.C. 10-32 x 3/4	1	1	1	1
20	030-13124	Eccentric	1	1	1	1
21	311-12060	Screw-S.S. 1/4-20 x 3/8	1	1	1	1
22	030-14372	Handle-Selector	1			1
	030-13121	Handle-Selector		1	1	
23	221-44603	Knob	1	1	1	1
24	210-07500	Collar	1	1	1	1
25	211-10005	Key-Woodruff #5	1	1	1	1
26	030-13797	Shaft-Selector Handle	1			
	030-13939	Shaft-Selector Handle		1		
	030-16658	Shaft-Selector Handle			1	
	020-48436	Shaft-Selector Handle				1

SHIPPER ROD ASSEMBLY (USED WITH 90 SERIES CONTROL VALVES)

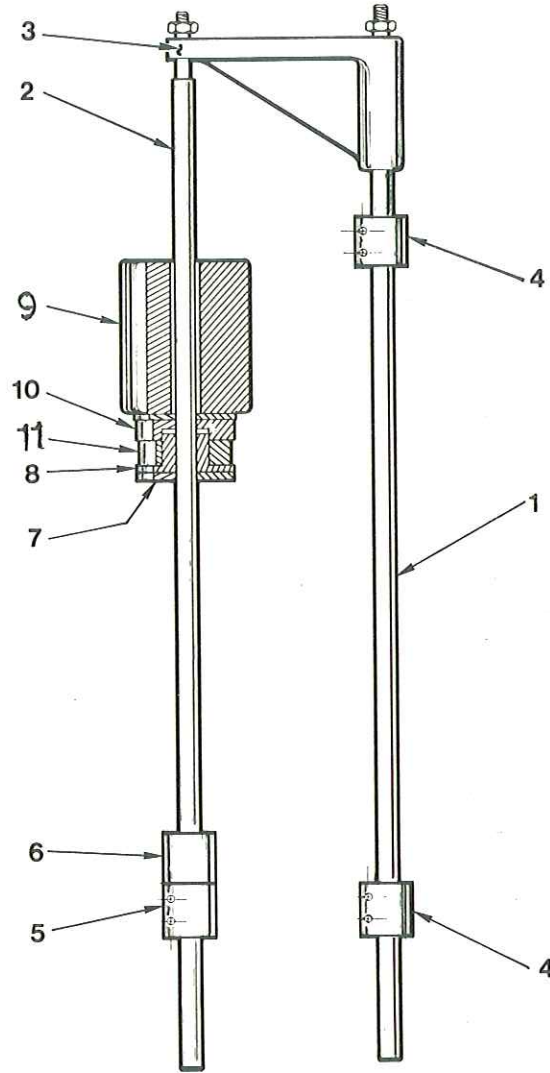


FIGURE 6

Item	Part No.	Description	Quantity			
			FH	FL/FN	FQ	FX
1	030-13798	Rod-Shipper	1			
	030-13151	Rod-Shipper		1		
	030-16662	Rod-Shipper			1	
	030-47097	Rod-Shipper				1
2	*030-13798	Rod-Shipper	1			
	*030-13151	Rod-Shipper		1		
	*030-16662	Rod-Shipper			1	
	*030-47097	Rod-Shipper				1
3	*030-13166	Arm-Safety	1	1	1	1
4	030-11587	Collar	2	2	2	2
5	*030-11587	Collar	1	1	1	1
6	*030-20674	Spacer	1	1	1	1
7	*030-14823	Washer-Bumper	2	2	2	2
8	*030-13169	Retainer-Bumper	1	1	1	1
9	*030-13799	Weight-Shipper Rod	1	1	1	1
10	*030-13168	Plate-Bumper	1	1	1	1
11	*030-13170	Bumper	1	1	1	1

*Items used with Speed Control Option

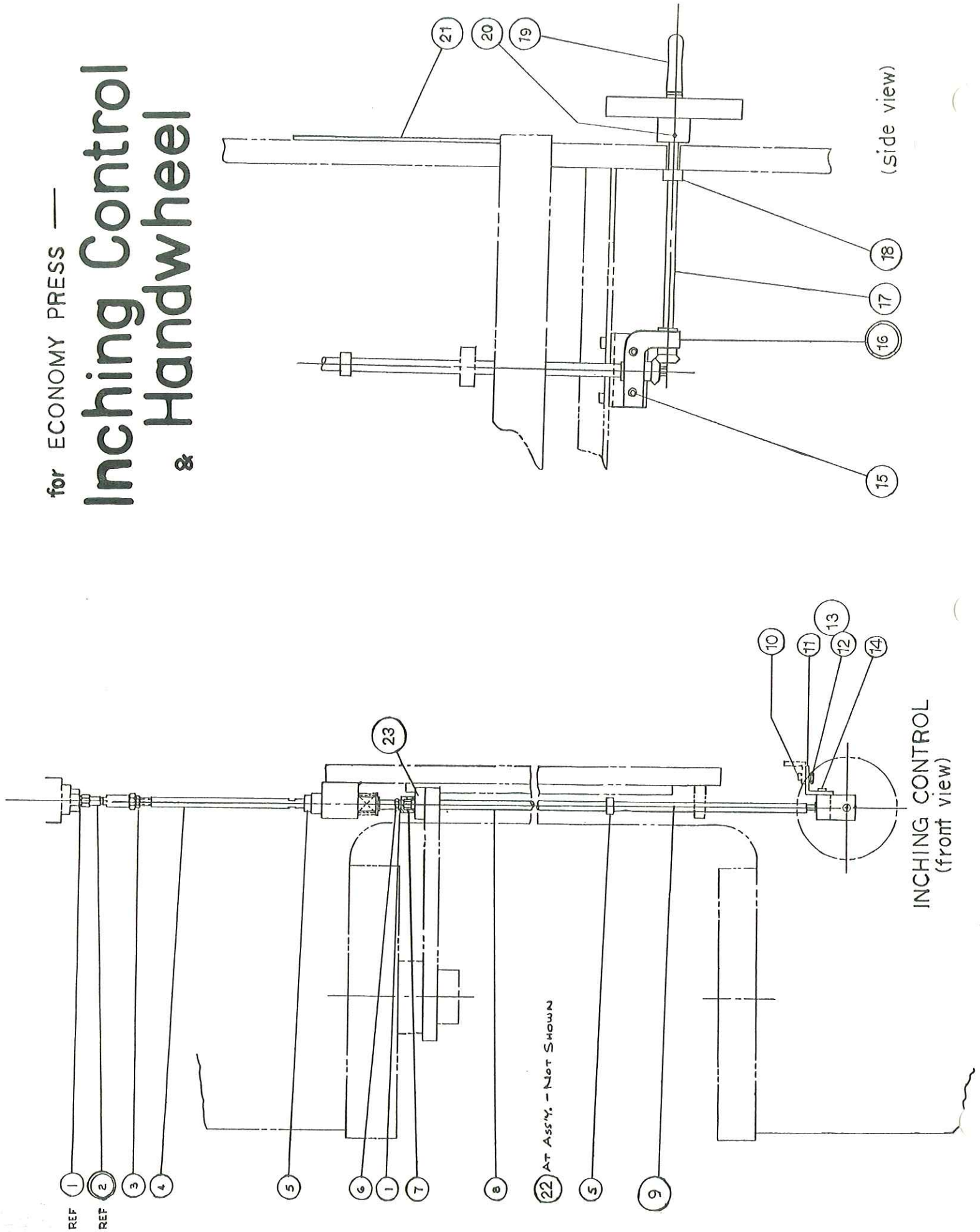
HANDWHEEL INCHING

(For FW Economy Presses)

Item	Part #	Description	FW4H-15 S12-48997	FW4L-35 S22-10032	FW4N-50 S22-10172
1	348-10028	Washer, 7/16"	1	2	1
2	010-03790	Swivel Joint	1	1	1
3	335-19100	Nut—1/2-200NF Jam	—	1	1
4	030-59154	Adapter—Inching	—	—	1
	030-53470	Adapter—Inching	—	1	—
	030-53621	Adapter—Inching	1	—	—
5	210-15001	Collar-Stop, 5/8" I.D.	1	3	2
6	335-18100	Nut-Jam, 7/16-14	—	—	1
7	030-25430	Stop-Positive	1	1	1
8	030-47200	Shipper Rod—Upper	—	—	1
	030-53468	Shipper Rod—Upper	—	1	—
	030-53484	Shipper Rod—Upper	1	—	—
9	030-47352	Shipper Rod—Lower	—	—	1
	030-48039	Shipper Rod—Lower	—	1	—
	030-53485	Shipper Rod—Lower	1	—	—
10	358-14180	Screw—5/16-18 x 1 1/4	1	2	2
11	030-47202	Bracket	1	1	1
12	346-10020	Washer-Lock, 5/16	—	2	2
13	333-14000	Nut—5/16-18	—	2	2
14	030-25851	Plate-Bolt Anchor	1	1	1
15	358-14240	Screw—5/16-18 x 2	—	2	2
	358-14280	Screw—5/16-18 x 2 1/2	1	—	—
16	010-23924	Control Gear Assembly	1	1	1
17	030-53554	Shaft—Gear Control	—	—	1
	030-53469	Shaft—Gear Control	—	1	—
	030-53457	Shaft—Gear Control	1	—	—
18	210-05000	Collar—1/2" I.D.	1	1	1
19	030-49001	Handwheel	1	1	1
20	325-12160	Rollpin—3/16 x 1	1	1	1
21	030-25519	Inching Control Plate	1	1	1
22	325-12100	Rollpin—3/16 x 5/8	1	1	1
23	030-23571	Collar—Upper Stop	1	1	—
24	358-14160	Screw—5/16-18 x 1	(Item 10)	1	—
25	348-10028	Lockwasher—7/16"	1	2	—
26	348-10032	Lockwasher—1/2"	2	1	—
27	030-48681	Bar—Upper Shipper Rod Guide	1	—	—
28	030-53622	Angle—Upper Guide Mounting	1	—	—
29	358-14100	Screw—5/16-18 x 5/8	4	—	—
30	335-20100	Nut-Jam, 1/2-13	1	—	—
31	358-14200	Screw—5/16-18 x 1 1/2	2	—	—
32	345-11020	Washer—5/16" Flat	7	—	—
33	335-14100	Nut—5/16"-18 Jam	2	—	—

for ECONOMY PRESS —

Inching Control & Handwheel





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