



655 Eisenhower Drive  
Owatonna, MN 55060 USA  
Phone: (507) 455-7000  
Tech. Serv.: (800) 533-6127  
Fax: (800) 955-8329  
Order Entry: (800) 533-6127  
Fax: (800) 283-8665  
International Sales: (507) 455-7223  
Fax: (507) 455-7063  
Website: otctools.com

Form No. 540099

**Parts List &  
Operating Instructions  
for:**

**5230**

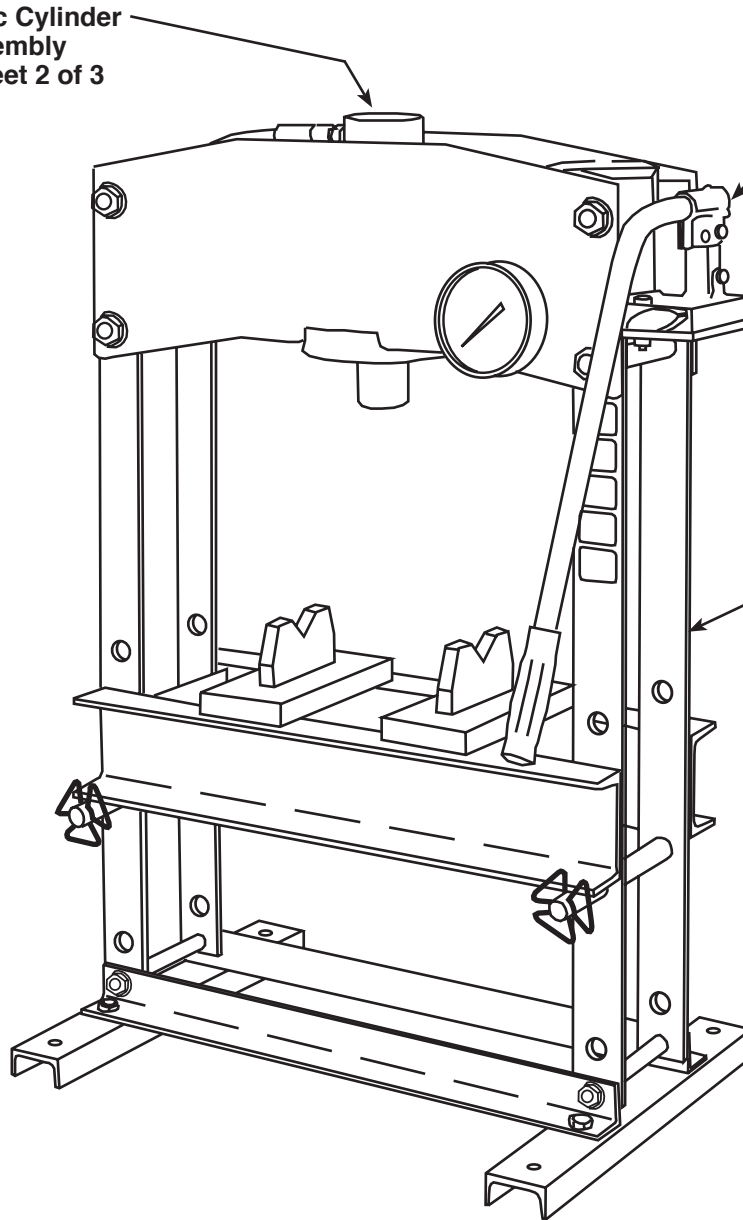
## Bench Press

Max. Capacity: 16.5 Ton

Hydraulic Cylinder  
Assembly  
See sheet 2 of 3

Hydraulic Unit  
See back, sheet 2 of 3

Press Frame  
See back, sheet 1 of 3

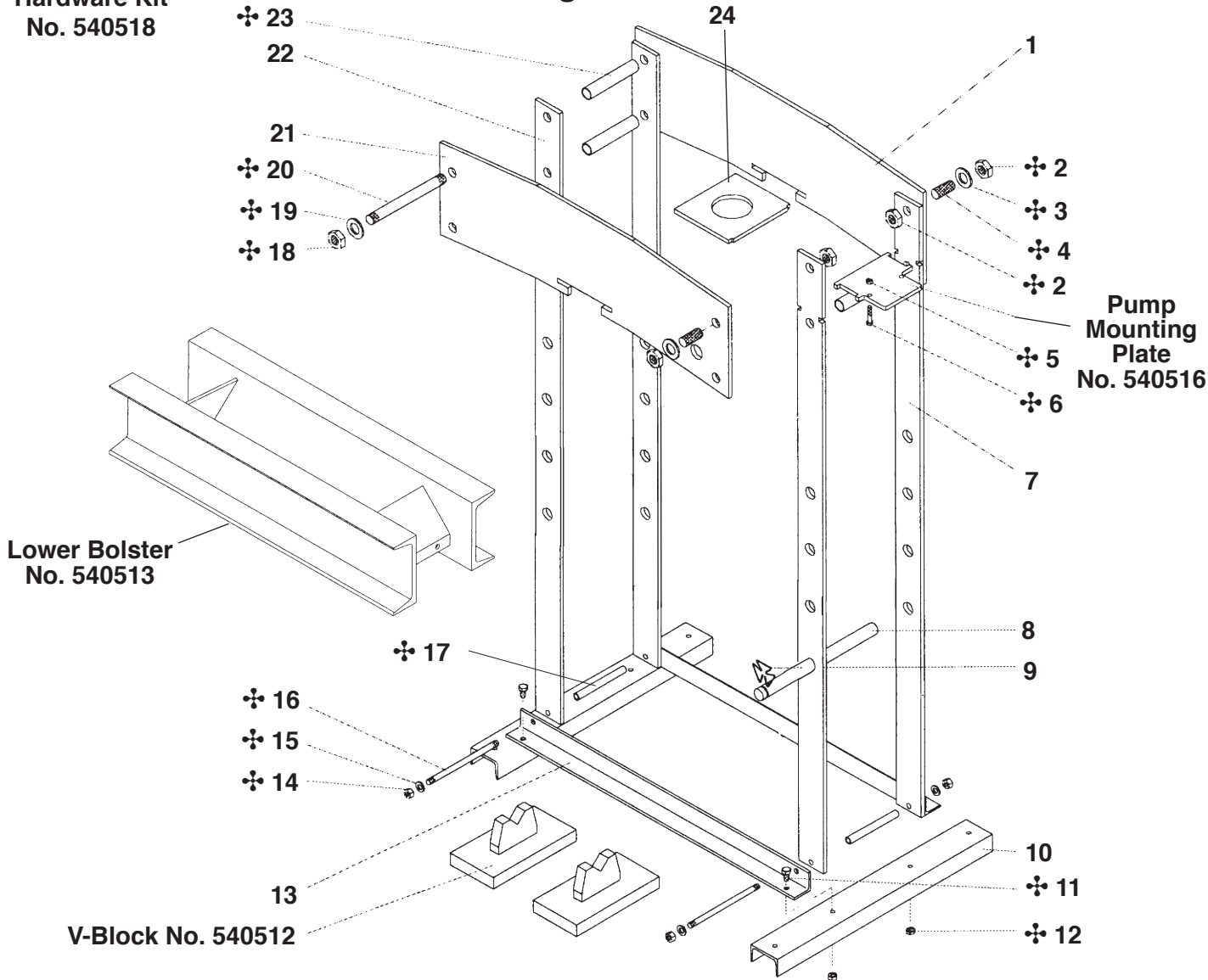


Sheet No. 1 of 3

Issue Date: Rev. C September 11, 2015

✦ = Included in  
Hardware Kit  
No. 540518

Figure 1



Frame No. 540517

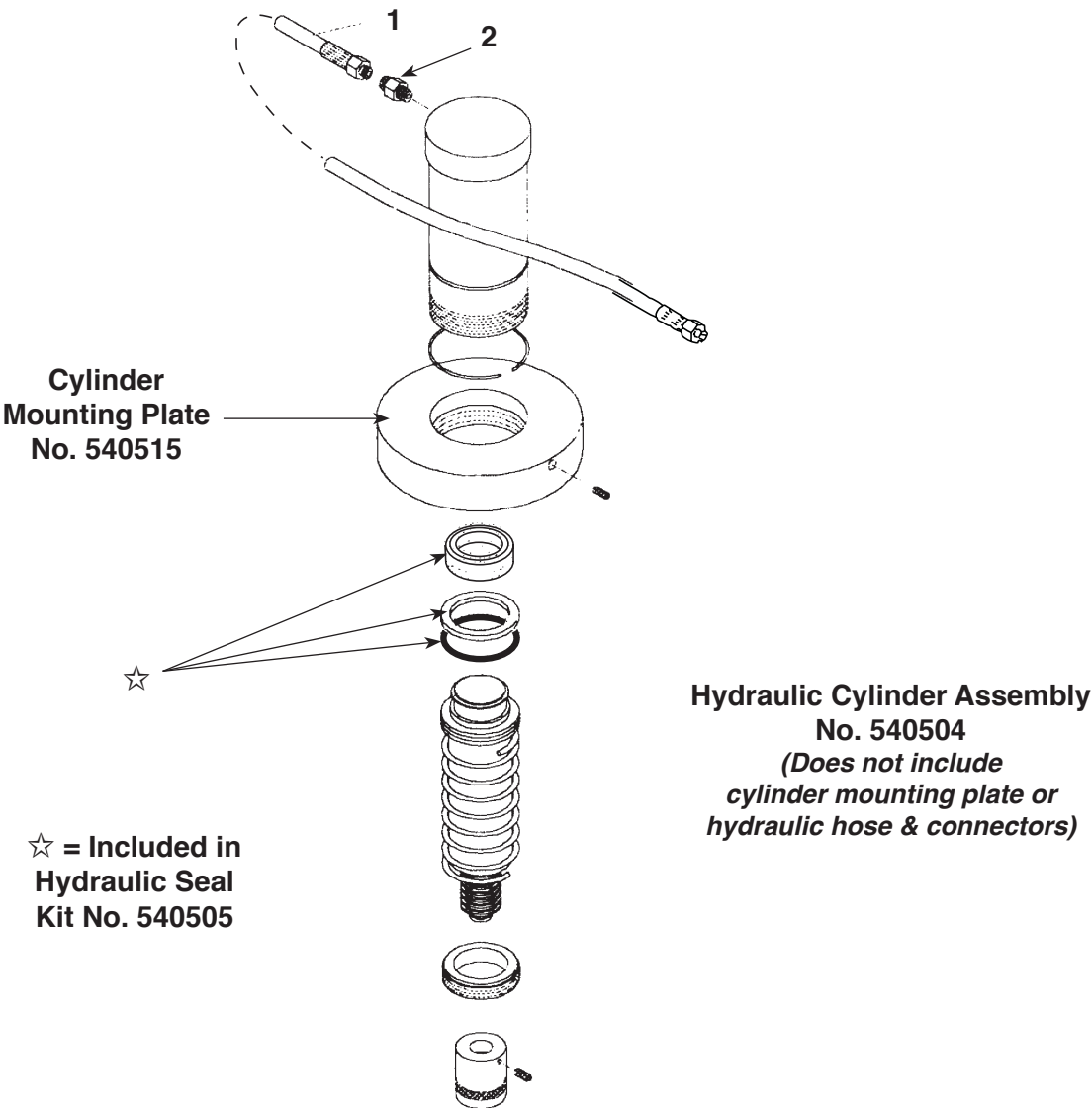
Item No.	Qty.	Description
1	1	Upper Bolster (Rear)
✦ 2	2	Nut
✦ 3	2	Washer
✦ 4	2	Threaded Rod
✦ 5	2	Nut
✦ 6	2	Screw
7	2	Upright
10	2	Foot
✦ 11	4	Screw
✦ 12	4	Nut
13	2	Cross Brace
✦ 14	4	Nut
✦ 15	4	Washer
✦ 16	2	Threaded Rod
✦ 17	2	Bushing

Item No.	Qty.	Description
✦ 18	6	Nut
✦ 19	6	Washer
✦ 20	3	Threaded Rod
21	1	Upper Bolster (Front)
22	2	Upright
✦ 23	3	Bushing
24	1	Cylinder Mounting Plate

Bolster Pins No. 540511

Item No.	Qty.	Description
8	1	Axle
9	1	Clip

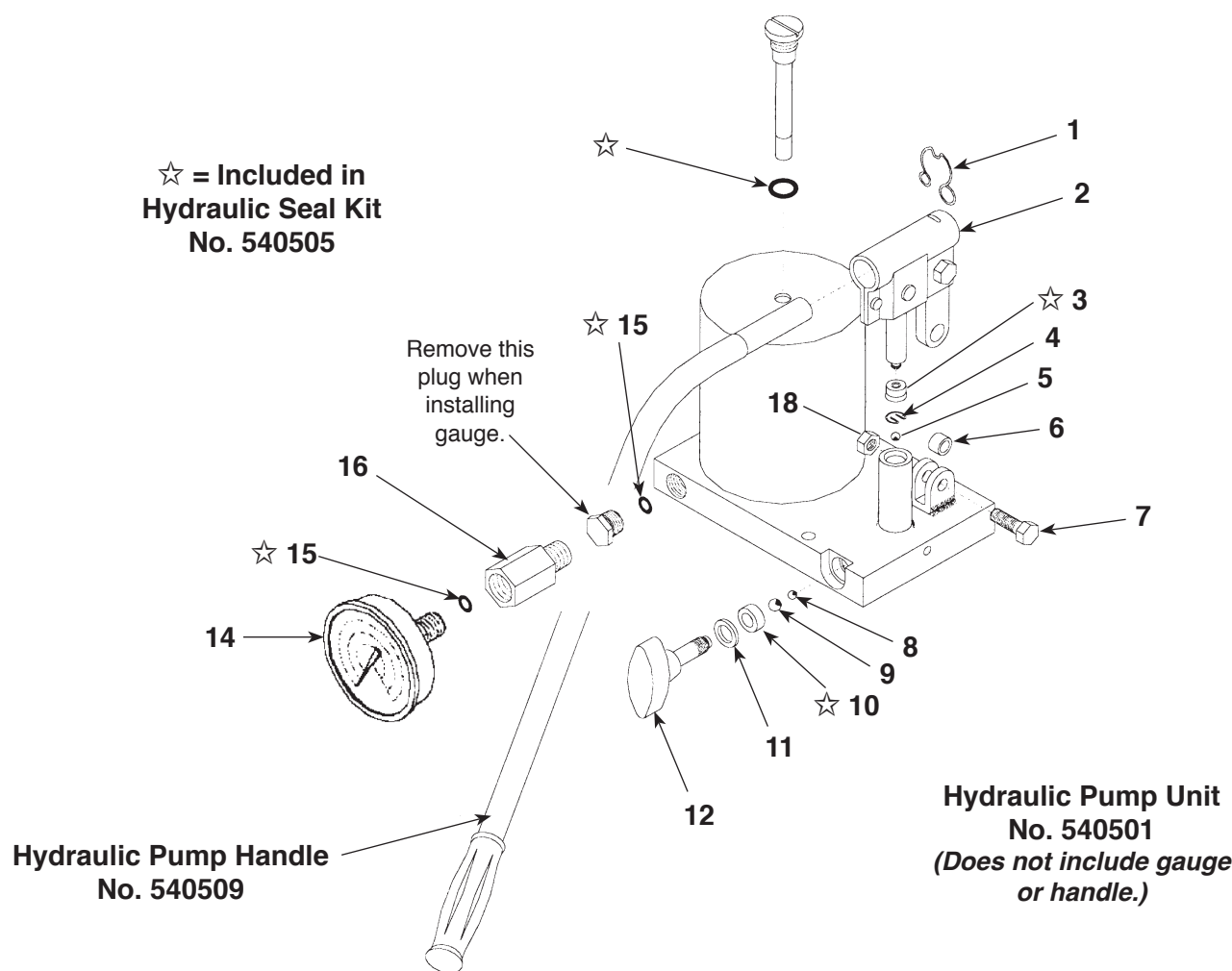
Figure 2



Hydraulic Cylinder Hose No. 540508

Item No.	Qty.	Description
1	1	Hose
2	2	Connector

Figure 3



Hydraulic Pump Release Screw  
No. 540506

Item No.	Qty.	Description
8	1	Ball
9	1	Ball
10	1	Seal
11	1	Washer
12	1	Knob

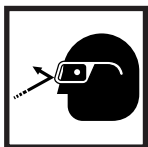
Hydraulic Pump Handle Hardware  
No. 540510

Item No.	Qty.	Description
1	1	Spring
2	1	Handle Socket
3	1	Seal
4	1	Spring
5	1	Ball
6	1	Bushing
7	1	Screw
18	1	Nut

Hydraulic Pump Pressure Gauge  
No. 540507

Item No.	Qty.	Description
14	1	Pressure Gauge
15	2	O-ring
16	1	Connector

## Safety Precautions



**CAUTION:** To prevent personal injury or equipment damage,

- The owner of the press is responsible for the press being installed and operated according to federal (OSHA), state, and local safety standards.
- Wear eye protection that meets ANSI Z87.1 and OSHA standards.
- Read, understand, and follow all safety precautions and operating instructions included with the press. Safety-related decals must be installed, maintained, and replaced if they become unreadable.
- Keep hands out of the work area during a pressing operation.
- Work pieces must be well supported and aligned so ram force is straight, and parts being pressed cannot slip out or break.
- Locate the press in an isolated area or shield the press to minimize danger to others.
- 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 ways. The owner of the press must provide shielding that is practical and necessary for each application. Some protection is provided by wrapping the piece in a protective blanket before applying pressure. (Protective blankets are offered in the OTC catalog.)



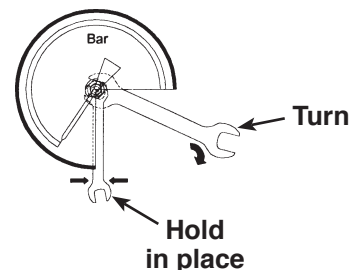
This press can exert an extremely high force at a moderate hydraulic pump pressure. If you have any questions concerning an application, or how much force is exerted at a given pressure, please contact OTC Technical Services.

## Assembly Instructions

1. Assemble the legs to the press using the hardware provided.
2. Install the pressure gauge to the press as follows:

Remove the plug from the pump gauge port. With the o-ring in place inside the connector, gently tighten the gauge as shown in illustration at right.

3. Install the pump handle into the handle socket and push in until the clip retains the handle.



## Operating Instructions

1. Attach the press securely to a flat, hard surface.
2. Place the bolster at the correct height firmly onto the bolster pins.
3. Bleed air from the hydraulic system by turning the release valve knob counterclockwise (CCW), and pumping the handle of the pump several times. Close the release valve by turning the knob clockwise (CW).
4. Position the center of the cylinder piston on the center of the workpiece. Continue to pump the pump handle until the pressing job is complete.
5. Turn the release valve knob counterclockwise (CCW) to retract the cylinder piston.

## Maintenance

Keep the press clean and lubricated. Keep the cylinder piston retracted when not in use. Add or replace the pump's oil when needed. Use only approved hydraulic fluid, and fill to the correct amount.