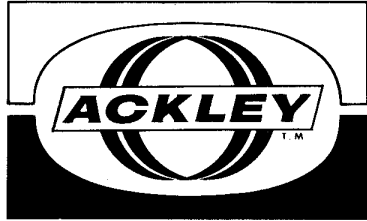


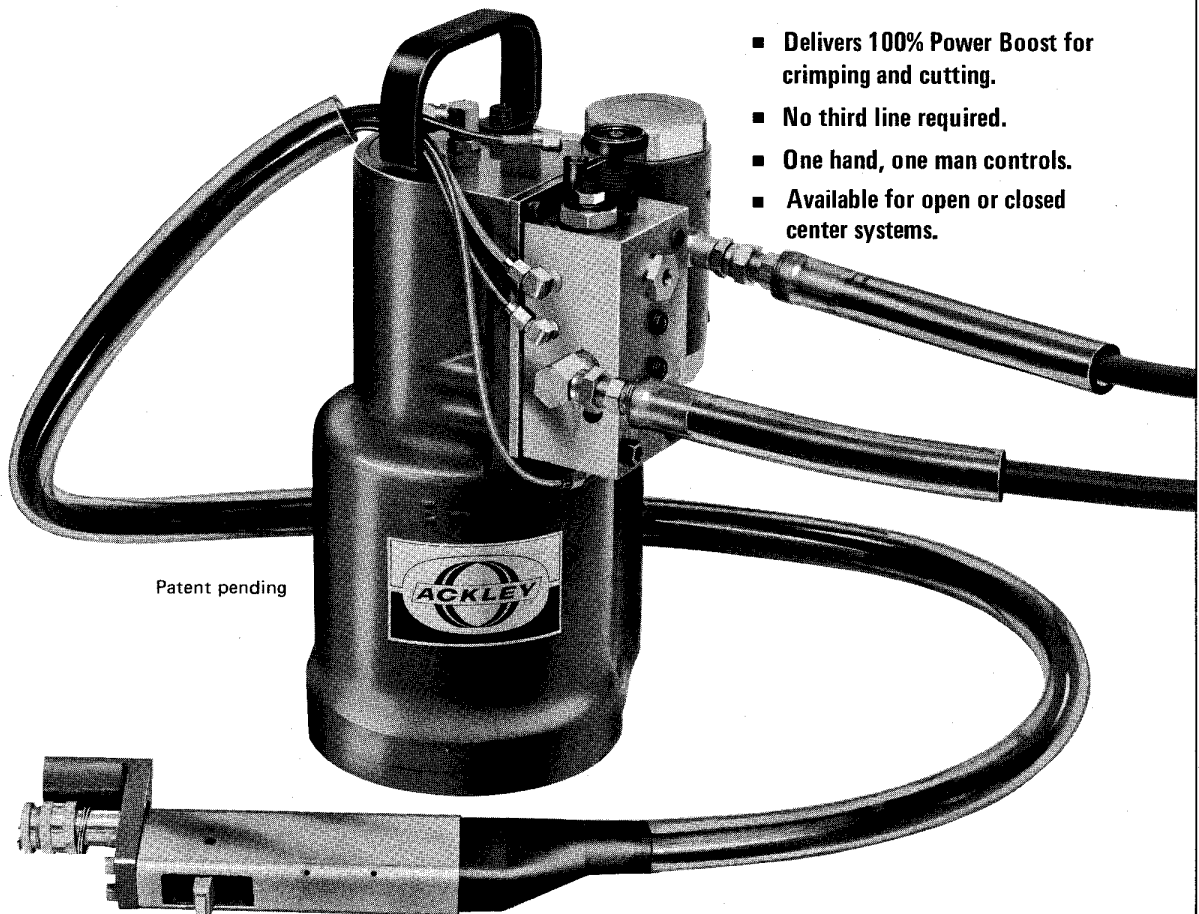
# PARTS LIST

MAINTENANCE AND OPERATING INSTRUCTIONS



## HYDRAULIC POWERED **INTENSA-PRESS™**

**MODELS 101H-OC and 101H-CC**



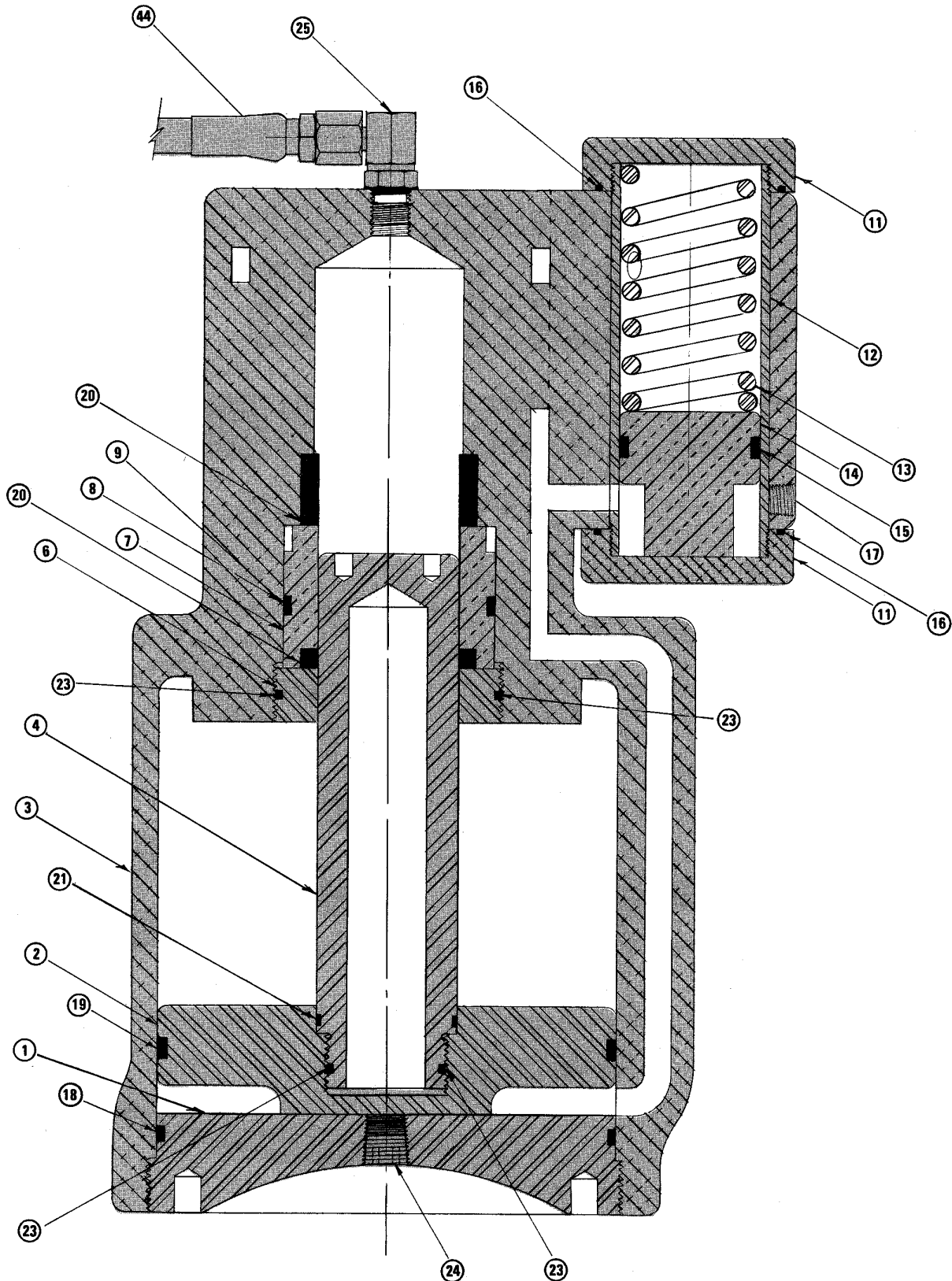
- Delivers 100% Power Boost for crimping and cutting.
- No third line required.
- One hand, one man controls.
- Available for open or closed center systems.

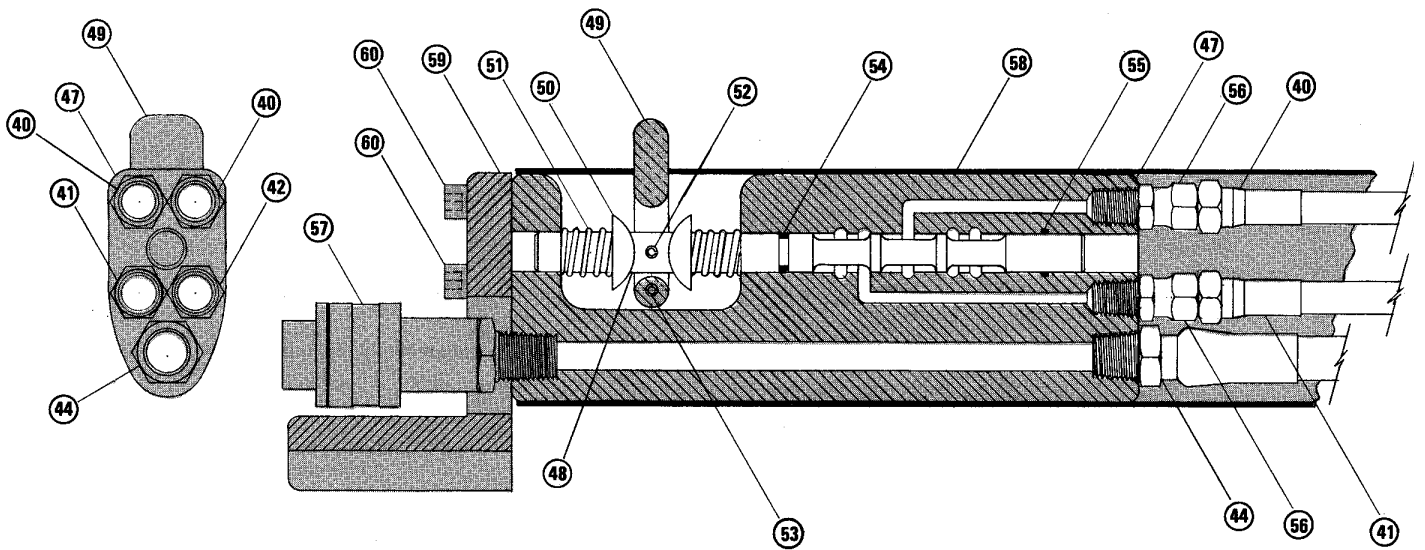
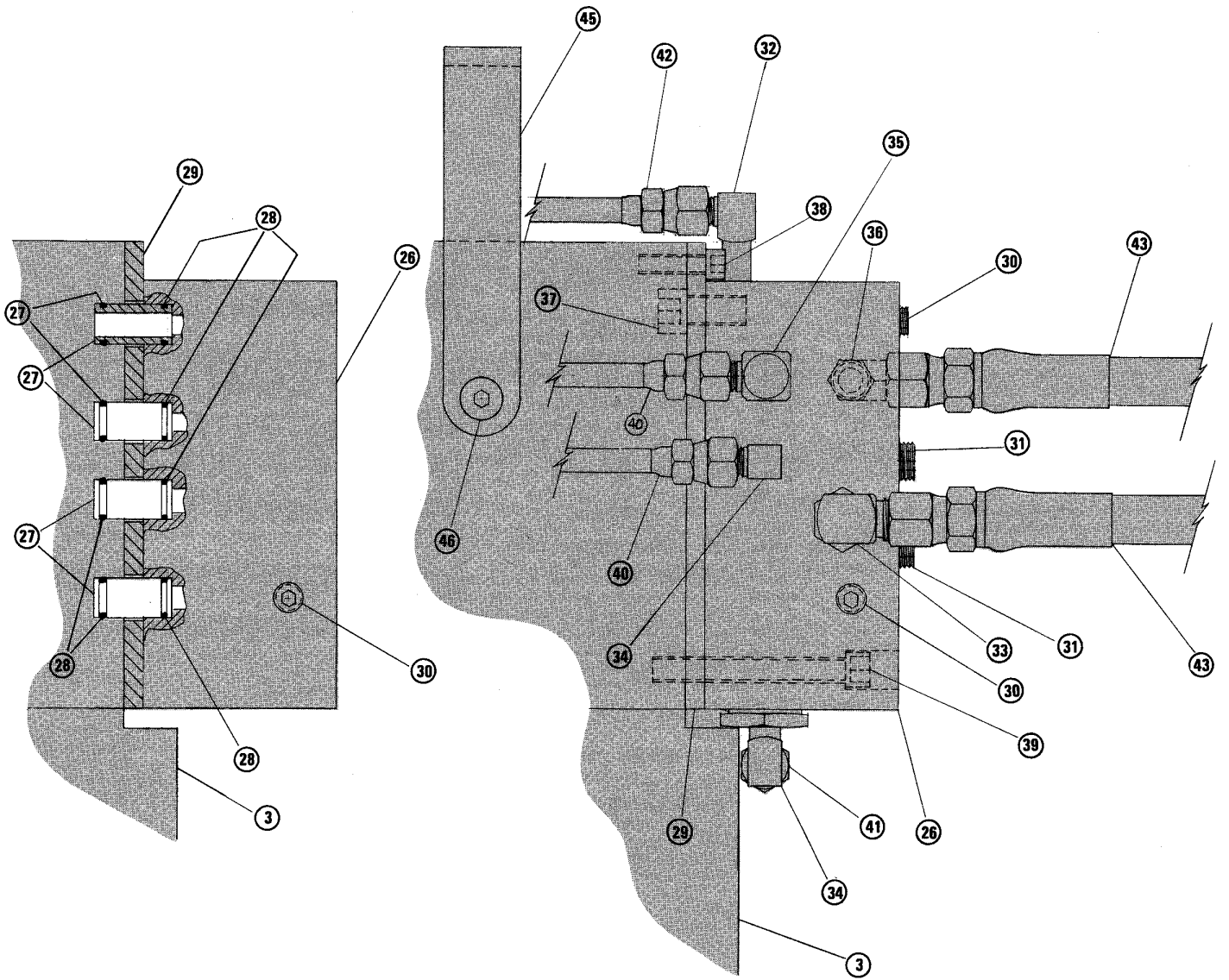
**IMPORTANT!** READ INSTRUCTIONS BEFORE ATTEMPTING TO OPERATE.



# HYDRAULIC POWERED INTENSA-PRESS

## MODELS 101H-OC and 101H-CC





# MODELS 101H-OC and 101H-CC

Illus. No. (do not use for ordering)	Part No. (use for ordering)	Quantity Required	Part Name For Ordering
1	1503	1	Cylinder End Plate
2	1504	1	Low Pressure Piston
3	1514	1	Low Pressure Cylinder
4	1500	1	High Pressure Piston
6	1506	1	Seal Nut
7	1501	1	Piston Bearing
8	473	1	O-Ring
9	1367	2	Back-up Rings
11	1507	2	Accumulator End Cap
12	1508	1	Accumulator Cylinder
13	1523	1	Accumulator Spring
14	1509	1	Accumulator Piston
15	1368	1	T-Seal
16	665	2	O-Ring
17	995	2	Pipe Plug
18	1365	1	End Cap O-Ring
19	1371	1	T-Seal
20	1370	4	Polypack Seal
21	1363	1	Piston O-Ring
23	634	4	Nylon Lock Cap
24	1212	1	Pipe Plug
25	1533	1	90° Elbow
26	1562	1	Porting Block O.C. Assembly
26	1561	1	Porting Block C.C. Assembly
27	1505	4	Oil Tubes
28	18	8	Oil Tube O-Ring
29	18	1	Mounting Plate
30	955	2	Pipe Plug
31	1545	4	Pipe Plug
32	1538	1	90° Elbow
33	1532	1	90° Elbow
34	1539	2	90° Elbow
35	1540	1	90° Elbow
36	1531	1	90° Elbow
37	1525	1	Button Hd. Cap Screw
38	769	2	Socket Hd. Cap Screw
39	1524	2	Socket Hd. Cap Screw
40	1576	2	Hose Assembly
41	1574	1	Hose Assembly, No. 1 Pilot
42	1575	1	Hose Assembly, No. 2 Pilot
43	1577	2	Pigtail Hose Assembly
44	1573	1	Hose Assembly, High Pressure
45	1512	1	Handle
46	1559	2	Shoulder Bolt
47	1515	1	Trigger Housing
48	1516	1	2-Way Valve Spool
49	1517	1	Trigger
50	1518	2	Spring Pad
51	1550	2	Valve Spring
52	757	1	Roll Pin
53	1534	1	Roll Pin
54	1362	1	O-Ring
55	18	1	O-Ring
56	1537	4	Swivel Connectors
57	1527	1	Coupler
58			Heat Shrink Tubing
59	1519	1	Hotstick Adapter
60	1521	4	Socket Hd. Cap Screw

## Seal Kit

Includes all normal wear items

No. 1177 . . . 101H Seal Kit

Includes O-Rings, Back-up Rings, T-Seals and Polypack Seals.

## Repair Kit

(Not available.)

**DO NOT EXCEED 8 gpm — 2,000 psi**

### DESIGN CHANGES:

All Ackley tools and allied equipment are subject to design improvements, specifications and price changes at any time with no obligation to units already sold and/or outlined herein.

### IMPORTANT:

Ackley Manufacturing Co. cannot assume responsibility where parts are removed or replaced by other than themselves or designated Ackley Official Tool Repair Service Depots.

### CAUTION:

Be sure to follow the important instructions for removing, dismantling and re-assembling these tools as given on page 6 of this folder.

### HOW TO ORDER PARTS

Always include the following:

1. Model number	4. Quantity you require
2. Part number	5. Type of hydraulic circuit (open or closed system)
3. Part name	

## ACKLEY WARRANTY

Parts and equipment are guaranteed against defects in materials and workmanship for a period of 12 months from date of purchase. (Exception: cutting parts and parts not produced by Ackley Manufacturing, such as impact mechanisms, alternator and regulator, hose, cut-off attachment. These items hold the warranty of their manufacturer.) This warranty is void if maximum gpm and psi are exceeded.

Ackley will replace, in their plant, parts found defective and guaranteed by this warranty. Shipping charges are prepaid by customer.

There is no other warranty expressed or implied.

## INTENSA-PRESS OPERATING INSTRUCTIONS

Be sure to hook up both pressure and return line to system before beginning prefill or operation.

### FILLING THE INTENSA-PRESS (automatically precharging the unit)

By Federal Law this unit must be shipped without hydraulic oil. The following instructions will tell how to fill the unit with oil and purge it of air.

1. Obtain a bucket to catch hydraulic oil or provide a means to return it directly to the system reservoir.
2. Connect unit to a warmed up 4 - 8 gpm hydraulic system. Input or pressure is the lower fitting on the left, when looking at the face of Porting Block (26), also marked "P" (33). Return is the upper fitting on the right marked "Tank Out" (36).
3. Leave the complete High Pressure (male & female) Parker Hannifin 3000-2 Coupler (57) on Trigger Housing (47). Remove the plastic plug on the end. This will allow oil to flow freely out of the Coupler during filling process.
4. Turn on system pressure to Intensa-Press.
5. Pull Trigger (49) back and wait until hydraulic system operates over its by-pass.
6. With the Trigger still in back position, open black Precharge Valve (NI) on the top of the Press. (Air is now being forced out of the press by the incoming oil.)
7. As oil begins to flow out of the Trigger Housing via the High Pressure Fitting (57), (a) operate the Trigger from the neutral (centered) position to back position several times. (b) Open and close the black Precharge Valve (NI) several times.
8. After oil begins to flow free of air, allow another gallon of oil to flow.
9. Close Precharge Valve.
10. Remove male half of high pressure Coupler (57). Release Trigger to neutral. Your 101H Intensa-Press is now ready to be hooked up to a high pressure gauge or tool.

### TROUBLE SHOOTING

These four conditions indicate that there is still air in the Intensa-Press. Go through filling process again.

- a. Head creeps when Trigger is in neutral position.
- b. Intensa-Press fails to operate the Head at all.
- c. Jerking motion of Head Piston in advance or retract.
- d. Incomplete closure of the Head indicates that the Intensa-Press has not been completely filled. Go through filling process again.

### TO PRECHARGE YOUR INTENSA-PRESS (Necessary after replacement of Hand Valve, High Pressure Hose or Control Hose.)

1. Remove Head, Gauge, or male half of the High Pressure Coupler (57).
2. Hook up Intensa-Press to power system and apply pressure.
3. Open black Precharge Valve on top of Porting Block (26) on the Intensa-Press.

4. Pull back on Trigger.
5. Hold for several seconds.
6. Do not release Trigger before closing black Precharge Valve.

### OPERATING THE 101H PRESS (ON CRIMPING HEADS REQUIRING MORE THAN 11.0 CUBIC INCHES OF OIL)

1. Activate pressure at power source.
2. Pull Trigger on the Intensa-Press Handle into retract position.
3. Open black Precharge Knob (NI) on top of Porting Block (26) of the Intensa-Press. (This will allow your power source pressure and oil to pass through the press into the Crimping Head and move the Crimping Head, allowing the Crimping Head Dies to come flush with the Sleeve.)
4. When the Crimping Head Dies come flush with the Sleeve, close the Precharge Valve (NI) and release the Trigger back to neutral. **Note:** The Dies will very slowly begin retracting.
5. Use the Intensa-Press as it would normally be used. Do not retract Dies more than 1/2" from the Sleeve during crimping process. When the crimping job is complete the oil in Crimping Head must be returned to the main system.
6. Let the Dies "creep" into the retract position as far as they will on their own (with Trigger in the retract position). When the oil begins passing over the power source high pressure relief (this will occur in open center systems) let the Trigger return to neutral.
7. Push the Trigger into advance position briefly (not more than one second). Then pull it into the retract position and hold 3 - 4 seconds. Repeat this process until the Crimping Head Dies have returned to the full retract position.
8. Disconnect the large Crimping Head from Trigger Housing.
9. Intensa-Press is now ready for its normal usage.

### OUTPUT PRESSURE SETTING

1. Connect high pressure (12,000 psi min.) gauge to High Pressure Coupler (57).
2. To raise the output pressure, turn Allen screw (NI) on top of the Porting Block **clockwise**, while Trigger (49) is in forward position.
3. To lower the output pressure, pull Trigger (49) to retract position and turn Allen screw (NI) on top of the Porting Block counter clockwise, one turn. Then push Trigger (49) forward to pressurize Gauge. Keep doing this until you are at or below your desired pressure. If a lower than desired output pressure is reached, follow above directions for raising output pressure.

### SERVICE INSTRUCTIONS

Oil must be removed from this unit for shipping purposes and disassembly.

#### OIL REMOVAL

1. To remove oil from the Upper Cylinder (10) the unit may be stopped at the end of a pressure stroke with the High Pressure Hose (44) end open or invert the unit with the High Pressure Fitting (25) removed from top of Press.

2. Remove the 3/8" Pipe Plug (24) from base of unit to drain the Low Pressure Cylinder(2).

### REMOVAL OF PORTING BLOCK

1. To remove the Porting Block (26), tag hoses to identify for return to proper fitting.
2. Remove two large Allen head cap screws (39) from bottom of block and smaller cap screw from the upper right hand corner(38). Upper left hand corner cap screw (38) must be removed in stages as the Porting Block is pulled from the press.
3. Pry Porting Block evenly from press to prevent damage to the four connecting oil tubes (27).

At this time the Porting Block has no servicable parts and must be serviced by installation of a new Block.

### TO DISSASSEMBLE THE PRESS

1. Drain oil as described above. Plug high pressure outlet for fitting (25).
2. Invert unit in a large vise or otherwise anchor to prevent turning.
3. Use dowels and a long bar or special spanner wrench to unscrew bottom plate (1) from Press.
4. Use a puller or compressed air carefully applied to the middle oil tube hole to remove the piston.
5. A special wrench, Ackley No. 1444, is required to loosen the inner seal nut (6).
6. Remove Piston Bearing (7) and four Seals (20).
7. Both End Caps (11) may be removed from the Accumulator to remove its Spring and Piston Assembly.

Inspect for scored Cylinders and Pistons and check for damage to Oil Seals, O-Rings and Back-up Rings. Replace as necessary.

### TO REASSEMBLE

1. Lubricate and install: a. Three Piston Seals (20) open end toward top of Press. b. Piston Bearing (7) with Seals (8 & 9) flat end toward top. c. One more Seal (20) in counterbore on top of Bearing (7) open end also pointing toward top of Press.
2. Replace Seal Nut (6) and tighten.
3. Lubricate High Pressure Piston Seals (19) and Cylinder Walls thoroughly.
4. Install Piston Assembly. Use 5/16" cap-screws in puller holes provided.
5. Use rubber hammer to seat Piston below threads in Cylinder.
6. Install Low-Pressure End Plate (1). Tighten and install 3/8" NPT Drain Plug (24). **STAND UNIT UPRIGHT ON BENCH.**
7. Install Accumulator Piston Assembly, stem end down. Use a piston ring compressor or hose clamp to start Piston Seal (15) in bore.
8. Drop in Spring (13) and tighten both End Caps with O-Rings (16) in place.
9. Lubricate four Oil Tube O-Rings and install in Block or Press. Position Block for assembly.
10. Install four Capscrews (38 & 39) and tighten evenly (one turn each in rotation) until Block is securely fastened to the Press.
11. Reconnect four small Hoses to proper fittings and large Pressure Line to fitting on top of Press.
12. Unit is now ready to connect the Pressure Hose to the lower left Port marked "P" (33) and return Hose to upper right hand Port marked "TANK OUT" (36), connect to hydraulic system to charge and test.



## ACKLEY MANUFACTURING CO.

SUBSIDIARY OF THE STANLEY WORKS

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