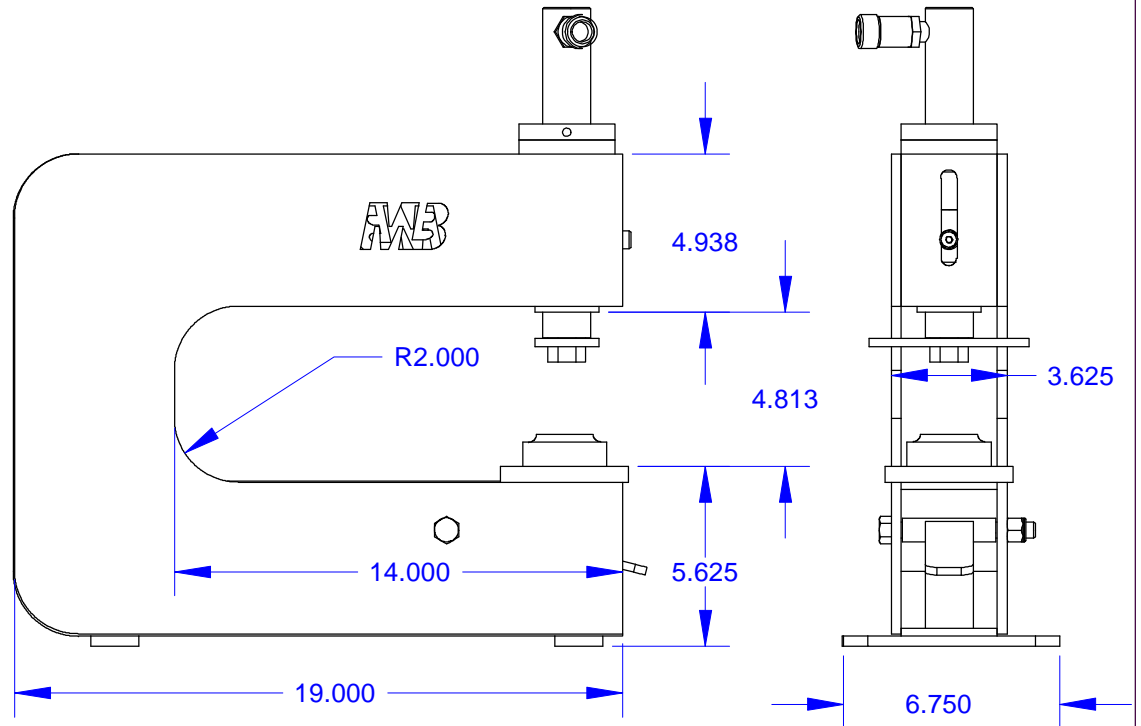
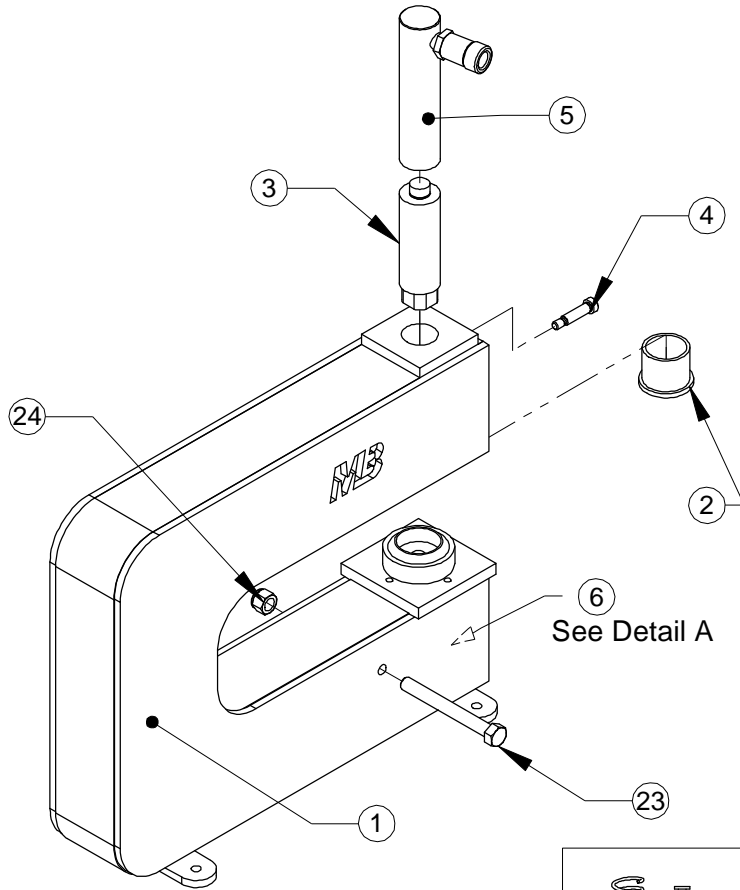
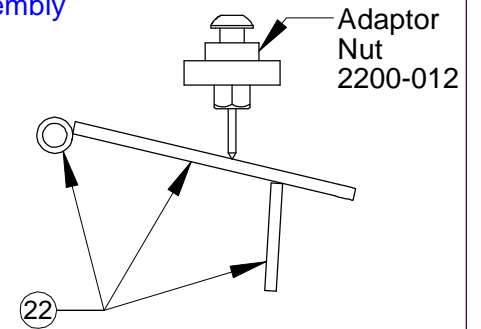


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2200-H	HD Hyd. Press Frame	1
2	2200-501	1-1/2" Bronze Bearing	1
3	2200-H02	Hydraulic Shaft	1
4	2200-527	SHSS 3/8 x 1-1/4"	1
5	2200-510	5 Ton 3-1/4 Stroke Hydraulic Piston	1
6	2200-015A	Scrap Ejector Assembly	1



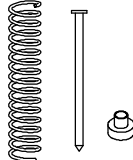
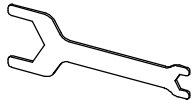
Detail A  
Scrap Ejector Assembly

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
20	1/2-20 x 1"	SBHCS Drilled Thru	1
21	Ejector Pin	Ejector Pin	1
22	2200-015	Ejector Lever	1
23	1/2-13 x 4-1/2"	HHCS	1
24	1/2-13	Nylock Half Nut	1

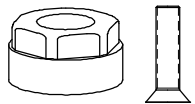


Included

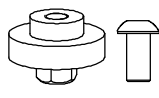
#2200-034  
Wrench



#2200-SLC  
Spring Loaded Center Assm



#2200-011  
Upper Adaptor Nut  
w/ 1/2-20 x 2" FHCS

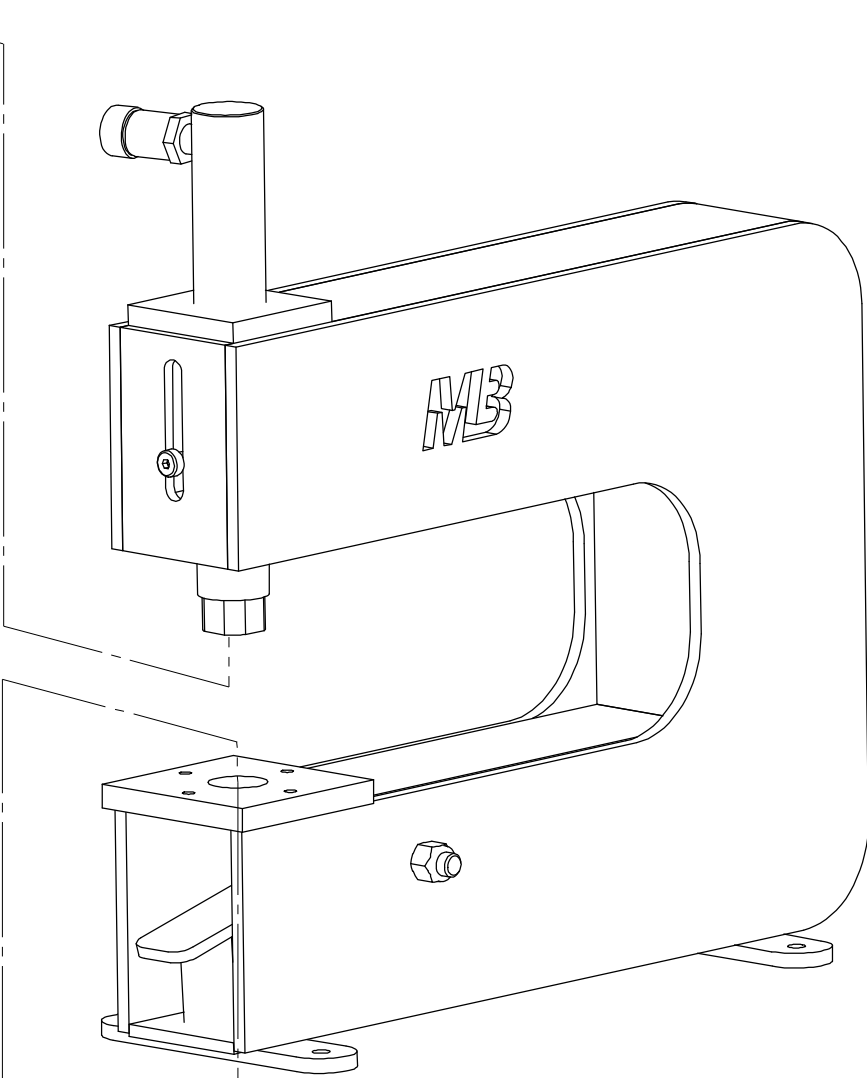
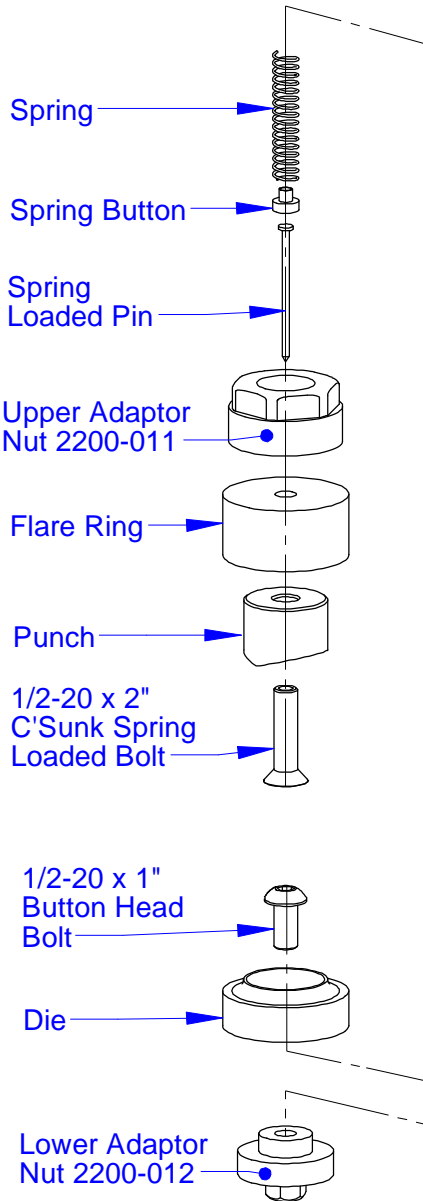


#2200-012  
Lower Adaptor Nut  
w/ 1/2-20 x 1" Button Bolt

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6/17/2010		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±.015 ONE PLACE DECIMAL ±.015 TWO PLACE DECIMAL ±.010 THREE PLACE DECIMAL ±.005 ANGULAR ±1°		NAME	DATE
5/18/2011			DRAWN	RAJ	07/18/08
			CHECKED		
			ENG APPR.		
			MFG APPR.		
			Q.A.		
		QUANTITY	COMMENTS		
		MATERIAL YYYY			
		FINISH			
NEXT ASSY	USED ON				
APPLICATION		DO NOT SCALE DRAWING			

<b>M3 MITTLER BROS. MACHINE &amp; TOOL</b>		
TITLE: Hydraulic Bench Press Assembly		
SIZE <b>A</b>	DWG. NO. 2200-H	REV A
SCALE: 1:6	WEIGHT: 66.577	SHEET 1 OF 2



**ASSEMBLY:**

- Remove 1/2" - 20 Bolt and Bearing from Punch & Flare Tool - set bolt / bearing aside.
- Install Button Head Bolt through Female Die.
- Install Lower Adaptor Nut #2200-012 through hole in Lower Platen Tooling Plate
- Thread Button Head Bolt into Lower Adaptor Nut - **DO NOT Tighten.**
- Install Ejector Pin through Button Head Bolt - See Drawing
- Install 1/2"-20 Countersunk Bolt through Punch and Male Flare Ring.
- Install and Tighten 1/2"-20 Bolt into Upper Adaptor Nut #2200-011.
- Install Spring Load Pin through center of Bolt - See Drawing.
- Place a dab of grease on bottom of Spring Button to assist in Spring Button to Spring Loaded Pin Alignment.
- Place Spring Button on Bolt head.
- Install Spring over tab on Spring Button.
- Carefully Install Spring Loaded Assembly into Upper Ram Cavity while Threading Upper Adaptor Nut onto Ram.
- Tighten Upper Adaptor Nut using Wrench #2200-034.
- Lower Upper Ram / Punch / Male Flare Ring Assembly.
- Align Female Die with Punch by moving Female Die.
- Lower Assembly onto Lower Tooling Plate.
- Tighten Lower Adaptor Nut using Wrench #2200-034.

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	<b>MB MITTLER BROS. MACHINE &amp; TOOL</b>
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±.015 ONE PLACE DECIMAL ±.015 TWO PLACE DECIMAL ±.010 THREE PLACE DECIMAL ±.005 ANGULAR ±1°		DRAWN	BAB	
		QUANTITY		CHECKED		TITLE:
		MATERIAL YYYY		ENG APPR.		Punch & Flare Assembly
		FINISH		MFG APPR.		
NEXT ASSY	USED ON			Q.A.		SIZE DWG. NO. REV
APPLICATION		DO NOT SCALE DRAWING		COMMENTS		<b>A</b> 2200-H
						SCALE: 1:4 WEIGHT: 66.577 SHEET 2 OF 2

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