



Operating Instructions and Parts Manual

Arbor Press – ½-, 1-, 2-, 3-, 5-Ton

Model No. AP0-M, AP1-M, AP2-M, AP3-M, AP5-M



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The specifications in this manual are given as general information and are not binding. JET reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.



Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This arbor press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of an arbor press, do not use until proper training and knowledge have been obtained.
5. Do not use this arbor press for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this arbor press. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Do not operate this arbor press while tired or under the influence of drugs, alcohol or any medication.
8. Make sure this arbor press is firmly secured to the floor or bench before use.
9. Check damaged parts. Before further use of the arbor press, a part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
10. Provide for adequate space surrounding work area and non-glare, overhead lighting.
11. Keep the floor around the arbor press clean and free of scrap material, oil and grease.
12. Keep visitors a safe distance from the work area. **Keep children away.**
13. Make your workshop child proof with padlocks, master switches or by removing starter keys.
14. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
15. Maintain a balanced stance at all times so that you do not fall into the arbor press. Do not overreach or use excessive force to perform any machine operation.
16. Use recommended accessories; improper accessories may be hazardous.
17. Make sure the work piece is securely attached or clamped to the table.
18. Remove loose items and unnecessary work pieces from the area before starting the machine.
19. Do not overload the arbor press by using extension (cheater) bars.
20. Use steel collars to support parts when pressing on bearings to prevent damage to the bearings.

Familiarize yourself with the following safety notices used in this manual:



This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.



This means that if precautions are not heeded, it may result in serious, or even fatal, injury.

Introduction

The arbor press is designed for riveting, swaging, bending, punching, and flattening. The arbor press can be used to press on or remove close-fitting bearings and bushings. It is suited for the production environment as well as machine shops, automobile repair shops, and home workshops.

The anvil has four slots that are available for a variety of pressing operations.

Specifications

| | | | | | |
|---------------------------|-------------|-----------|----------------|------------|------------|
| Stock# | 333605 | 333610 | 333620 | 333630 | 333650 |
| Model# | AP0-M | AP1-M | AP2-M | AP3-M | AP5-M |
| Pressure (ton) | 1/2 Ton | 1 Ton | 2 Ton | 3 Ton | 5Ton |
| Capacity over Table (in.) | 4-3/4 | 5 | 7-1/2 | 11-1/2 | 17 |
| Diameter of Work (in.) | 6-5/8 | 8 | 10-3/4 | 11-3/8 | 17 |
| Anvil Diameter (in.) | 3-1/2 | 3-1/2 | 6-11/16 | 6-11/16 | 9-3/4 |
| Size of Ram (in.) | 3/4 x 7-7/8 | 1 x 9-1/8 | 1-1/4 x 13 | 1-1/2 x 18 | 2 x 27-1/2 |
| Ram Bore (in.) | 3/8 | 1/2 | 1/2 | 1/2 | 1/2 |
| Ram Travel (in.) | 4.72 | 5.9 | 9.05 | 12.6 | 18.1 |
| Base Size (in.) | 4 x 9-1/2 | 5 x 9-1/2 | 6-3/8 x 15-3/4 | 8-1/2 x 18 | 9-7/8 x 26 |
| Overall Dimensions: | | | | | |
| Length (in.) | 9-5/16 | 9-1/2 | 15-3/4 | 18-1/8 | 27 |
| Width (in.) | 6-5/8 | 7-1/2 | 10 | 10-1/4 | 13 |
| Height (in.) | 10-3/8 | 12 | 17-1/2 | 22-1/2 | 31-1/2 |
| Net Weight (lb.) | 17-1/2 | 25-1/2 | 67-1/2 | 108 | 262 |
| Shipping Weight (lb.) | 19 | 26-1/2 | 69-1/2 | 116 | 296-1/2 |

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Arbor Press Features

The arbor press (see Exploded view on page 8) consists of a cast iron base, an anvil, a pressing handle with lock knob, and a rack-type ram.

The removable anvil has four cutouts that can be used for pressing off or pressing on bearings or bushings of various sizes.

Set-up and Operation

Note: Numbers in parentheses below correspond to item numbers in the exploded view on page 8.

⚠WARNING Do not use the arbor press without first securing the arbor press to the workbench and anchoring the workbench to the floor.

Mount the arbor press to the workbench or stand and secure with bolts using the holes in the base (1). Also, secure the workbench or stand to the floor.

Changing Ram Position

The ram has a flat surface on one end and a hole on the other end. The hole is used to accept the punch inserts. Change-out the ram as follows:

- A. Remove the handle by loosening the knob (17). Then remove one cap (5) from the handle assembly. Remove handle (6) from the pinion (16).
- B. Remove the pinion retainer (14) by backing off the Set Screw (13). Now slide the pinion retainer (14) off of the pinion (16).
- C. Pull up on the ram (4) enough to provide slack to remove the pinion (16) from the arbor press.
- D. Pull the ram (4) out the top of the arbor press body. Turn the ram (4) end-for-end.

Tip: If ram does not freely come out of arbor press body, loosen the two hex nuts (11) on side of arbor press body and the two hex nuts (11) on the front plate (12).

- E. Repeat steps A – D in reverse.

Maintenance

- A. Periodically lubricate the arbor press with a light machine oil.
- B. Wipe off or vacuum the accumulated debris and dust after using the arbor press.
- C. Periodically check the ram for side-to-side and front-to-back play. If the play is excessive, loosen the hex nuts (11) and adjust (tighten) the screws (10 on side, 9 in front) just enough to eliminate the excess play. Tighten them equally to assure even contact with the ram (4).
- D. Once the play is eliminated, hold the screw (10 or 9) in position and tighten the hex nut (11). Check to make sure the amount of play is acceptable.

Parts Lists

Model AP0-M – 1/2-ton Arbor Press

| Index | Part No. | Description | Qty |
|-------|------------|----------------------|-----|
| 1 | AP0-01G | Base | 1 |
| 2 | AP0-06G | Anvil | 1 |
| 3 | AP0-16 | Spring Pin 6x16 | 1 |
| 4 | AP0-02 | Ram | 1 |
| 5 | AP0-5-1 | Cap | 2 |
| 6 | AP0-6-1 | Handle | 1 |
| 7 | TS-1482051 | Bolt, Hex M6x25 | 4 |
| 8 | TS-1550041 | Washer M6 | 4 |
| 9 | TS-1482051 | Bolt, Hex M6x25 | 2 |
| 10 | TS-1482061 | Bolt, Hex M6x30 | 2 |
| 11 | TS-1540041 | Nut, Hex M6 | 4 |
| 12 | AP0-12G | Plate | 1 |
| 13 | TS-1523011 | SHSS M6x6 | 1 |
| 14 | AP0-10 | Pinion Retainer | 1 |
| 15 | TS-1482021 | Bolt, Hex M6x12 | 1 |
| 16 | AP0-03 | Pinion | 1 |
| 17 | AP0-05 | Knob | 1 |
| 18 | TS-2361061 | Lock Washer M6 | 4 |
| | AP0-19 | ID Label (not shown) | 1 |

Model AP1-M – 1-ton Arbor Press

| Index | Part No. | Description | Qty |
|-------|------------|----------------------|-----|
| 1 | AP1-01G | Base | 1 |
| 2 | AP1-06G | Anvil | 1 |
| 3 | AP0-16 | Spring Pin 6x16 | 1 |
| 4 | AP1-02 | Ram | 1 |
| 5 | AP1-5-1 | Cap | 2 |
| 6 | AP1-6-1 | Handle | 1 |
| 7 | TS-1482051 | Bolt, Hex M6x25 | 4 |
| 8 | TS-1550041 | Washer M6 | 4 |
| 9 | TS-1482051 | Bolt, Hex M6x25 | 2 |
| 10 | TS-1482061 | Bolt, Hex M6x30 | 2 |
| 11 | TS-1540041 | Nut, Hex M6 | 4 |
| 12 | AP1-12G | Plate | 1 |
| 13 | TS-1523011 | SHSS M6x6 | 1 |
| 14 | AP1-10 | Pinion Retainer | 1 |
| 15 | TS-1482021 | Bolt, Hex M6x12 | 1 |
| 16 | AP1-03 | Pinion | 1 |
| 17 | AP1-05 | Knob | 1 |
| 18 | TS-2361061 | Lock Washer M6 | 4 |
| | AP1-19 | ID Label (not shown) | 1 |

Model AP2-M – 2-ton Arbor Press

| Index | Part No. | Description | Qty |
|-------|------------|-----------------|-----|
| 1 | AP2-01G | Base | 1 |
| 2 | AP2-06G | Anvil | 1 |
| 3 | AP2-16 | Spring Pin 6x25 | 1 |
| 4 | AP2-02 | Ram | 1 |
| 5 | AP2-5-1 | Cap | 2 |
| 6 | AP2-6-1 | Handle | 1 |
| 7 | TS-1490051 | Bolt, Hex M8x30 | 4 |
| 8 | TS-1550061 | Washer M8 | 4 |

| | | | |
|----|------------|----------------------|---|
| 9 | TS-1490051 | Bolt, Hex M8x30 | 2 |
| 10 | TS-1490051 | Bolt, Hex M8x30 | 2 |
| 11 | TS-1540061 | Nut, Hex M8 | 4 |
| 12 | AP2-12G | Plate | 1 |
| 13 | TS-1523011 | SHSS M6x6 | 1 |
| 14 | AP2-10 | Pinion Retainer | 1 |
| 15 | TS-1490021 | Bolt, Hex M8x16 | 1 |
| 16 | AP2-03 | Pinion | 1 |
| 17 | AP2-05 | Knob | 1 |
| 18 | TS-2361081 | Lock Washer M8 | 4 |
| | AP2-19 | ID Label (not shown) | 1 |

Model AP3-M – 3-ton Arbor Press

| Index | Part No. | Description | Qty |
|-------|------------|----------------------|-----|
| 1 | AP3-01G | Base | 1 |
| 2 | AP3-06G | Anvil | 1 |
| 3 | AP2-16 | Spring Pin 6x25 | 1 |
| 4 | AP3-02 | Ram | 1 |
| 5 | AP3-5-1 | Cap | 2 |
| 6 | AP3-6-1 | Handle | 1 |
| 7 | TS-1490051 | Bolt, Hex M8x30 | 4 |
| 8 | TS-1550061 | Washer M8 | 4 |
| 9 | TS-1490051 | Bolt, Hex M8x30 | 2 |
| 10 | TS-1490051 | Bolt, Hex M8x30 | 2 |
| 11 | TS-1540061 | Nut, Hex M8 | 4 |
| 12 | AP3-12G | Plate | 1 |
| 13 | TS-1524011 | SHSS M8x8 | 1 |
| 14 | AP3-10 | Pinion Retainer | 1 |
| 15 | TS-1490031 | Bolt, Hex M8x20 | 1 |
| 16 | AP3-03 | Pinion | 1 |
| 17 | AP3-05 | Knob | 1 |
| 18 | TS-2361081 | Lock Washer M8 | 4 |
| | AP3-19 | ID Label (not shown) | 1 |

Model AP5-M – 5-ton Arbor Press

| Index | Part No. | Description | Qty |
|-------|------------|----------------------|-----|
| 1 | AP5-01G | Base | 1 |
| 2 | AP5-06G | Anvil | 1 |
| 3 | AP5-16 | Spring Pin 6x24 | 1 |
| 4 | AP5-02 | Ram | 1 |
| 5 | AP5-5-1 | Cap | 2 |
| 6 | AP5-6-1 | Handle | 1 |
| 7 | TS-1491061 | Bolt, Hex M10x40 | 4 |
| 8 | TS-1550071 | Washer M10 | 4 |
| 9 | TS-1491061 | Bolt, Hex M10x40 | 2 |
| 10 | TS-2210501 | Bolt, Hex M10x50 | 2 |
| 11 | TS-1540071 | Nut, Hex M10 | 4 |
| 12 | AP5-12G | Plate | 1 |
| 13 | TS-1524031 | SHSS M8x12 | 1 |
| 14 | AP5-10 | Pinion Retainer | 1 |
| 16 | AP5-03 | Pinion | 1 |
| 18 | TS-2361101 | Lock Washer M10 | 4 |
| | AP5-19 | ID Label (not shown) | 1 |

Exploded View

