

*TRACK PIN PRESS TPP 63*

Documentation commissioner:  
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**BAHCO**

*Thank you for the faith you have shown in us by choosing a BAHCO product. BAHCO stands for products of high quality and it is our hope that you will be able to use this product for many years.*

*To avoid functional disturbances, we recommend that you read these instructions thoroughly before using the product.*

### **Technical data**

Max. working pressure:	70 MPa (700 bar, 10150 psi)
Max capacity:	625 kN (63,7 ton, 70.3 sh.ton)
Stroke:	60 mm (2.36 in)
Stroke volume:	0.54 liter (32.7 cu.in)
Total weight with box:	94 kg (207.3 lbs)
Weight assembled:	~66 kg (~145.5 lbs)
Hydraulic oil	ISO VG10

### **Overloading**

Overloading may damage the equipment and cause personal injury. A ram can support maximum load on the piston stop ring/glands. However, avoid loading a ram when it is fully extended as this causes unfavourable stresses.

### **Hoses**

Do not let hoses become twisted or sharply bent. If hydraulic pressure is applied to a distorted hose it can cause an unfavourable rise in pressure that may damage the equipment.

If hoses are badly bent or twisted it may lead to internal rupture and excessive wear.

Do not let sharp or heavy objects rest on the hose or run over it. Never lift or carry hydraulic components by the hose or connections

**NOTE!** A hose rupture can cause hydraulic oil to leak under high pressure and cause serious injection damage. Therefore, always check the hose before use, and replace in time.

### **Temperature**

Avoid exposing hydraulic equipment to temperatures higher than 50°C. Heat can destroy gaskets and hoses. Do not use under -20°C.

## **Bleeding the hydraulic system**

Air can collect in the hydraulic system when hoses or tools are connected and this can lead to problems in operation. To bleed the system run the tool or ram through 3-4 cycles (pumping to full extension then releasing) without any load. At the same time make sure that the tool or ram is kept lower than the pump so that air can travel back to the oil reservoir in the pump. Then bleed the pump oil reservoir. Top up the pump with oil if necessary.

## **Maintenance**

Hydraulic equipment must be serviced and maintained regularly to keep it in good working condition. For safety reasons it is important that hydraulic products are serviced and maintained by experienced personnel. If in any doubt, contact your dealer for information about the nearest authorised service agent.

Always use original BAHCO spare parts. Lubricate moving parts as necessary with a high quality grease. Always use high quality hydraulic oil with good low temperature properties.

## **Storage**

When hydraulic equipment is not in use:

Clean the equipment, make sure the hydraulic system is not pressurized and store it somewhere clean and free from damp. Make sure the equipment is not subject to extremes of temperature.

Apply grease on details after use and before storage to minimize the risk of corrosion.

## Usage

### **WARNING!**

**NEVER** stand in front of or behind the press in line with the rods when the cylinder is pressurized. If any part comes loose, they can be pushed out with high force and cause serious damage. See fig. 1.

**NEVER** use a rod that is bent, see fig. 2.

If a rod starts to bend under pressure, immediately stop the operation. Relieve the system of pressure and check that all parts are mounted as they should.

BAHCO Track Pin Press is assembled in situ. For an exploded view of the components, see fig. 3.

BAHCO Track Pin Press can be used for a number of different track sizes. It is important that the correct centering sleeve is used together with the correct press mandrel for the respective belt chain, see table 1.

For removal and installation of tracks, see the workshop manual for each type of machine.

## Installation

### **Tools needed:**

Open end spanner/wrench, key width 19 and 55 mm.

Circlip pliers for SgA 55.

1. Attach the centering sleeves to the counterhold and fixing yoke. Lock with included circlips, see fig. 4 and fig. 5.
2. Screw the pulling rods into the counterhold yoke. Make sure the rods are fully screwed in, see fig. 6. Place the counterhold yoke against the track chain as shown in fig. 7. It is important that the centering sleeve is centered over the end bolt.
3. Place the fixing yoke with the centering sleeve centered over the end bolt of the track chain and tighten the fixing yoke with the nuts, fig. 8. Important! The fixing yoke must be parallel with the counterhold yoke. Check measure according to fig. 9.
4. Place the cylinder yoke at the end of the rods as shown in fig. 10. Screw the cylinder into the cylinder yoke, fig. 11.
5. Make sure that the handle (fig. 12) or the quick coupling (fig. 13) does not align with any of the rods. If this happens, turn the cylinder back counter clockwise from the stop until the positioning enables the cylinder to move along the rods without the handle or quick coupling hitting the rods, fig. 14.

6. Screw the center spindle (fig. 15) into the cylinder until the tip projects about 20 mm from the piston, fig. 16.
7. When pressing out the end bolt - place the mandrel against the end bolt. When installing the end bolt - place the new end bolt against the hole in the track chain link, see fig. 17. Forward the cylinder until the center spindle clamps against the press mandrel or end bolt, fig. 18.
8. Screw the nuts to the cylinder yoke to lock the cylinder in place, fig. 19. Important! The cylinder yoke must be parallel with the fixing yoke. Check measure according to fig. 20.
9. Connect a pump to the cylinder. Ensure that the ends of the quick couplings are clean from dirt and particles before pairing, otherwise contamination may end up inside the pump and cylinder, causing damage and wear that may cause leakage. To prevent dirt from entering the dust caps, connect the male and the female dust cups according to fig. 21 and fig. 22.

## **Stepwise pressing of end bolt.**

1. Pump until the piston reaches its full stroke, fig 23.
2. Open the pump release valve and allow the piston to return to its original position, fig 24.
3. Screw the center spindle in until it is again clamped against the press pin or the new end bolt, fig 25.
4. Close the pump relief valve, pump until the piston reaches its full stroke, Fig. 26.

Repeat until the end bolt is fully extruded or pressed in place.

**NOTE!** Do not screw in the center spindle longer than it is edge-to-edge with the cylinder, fig. 27. If the center spindle does not reach the point, move the cylinder with yoke, fig. 28 and lock in place with the nuts.

Fig. 1

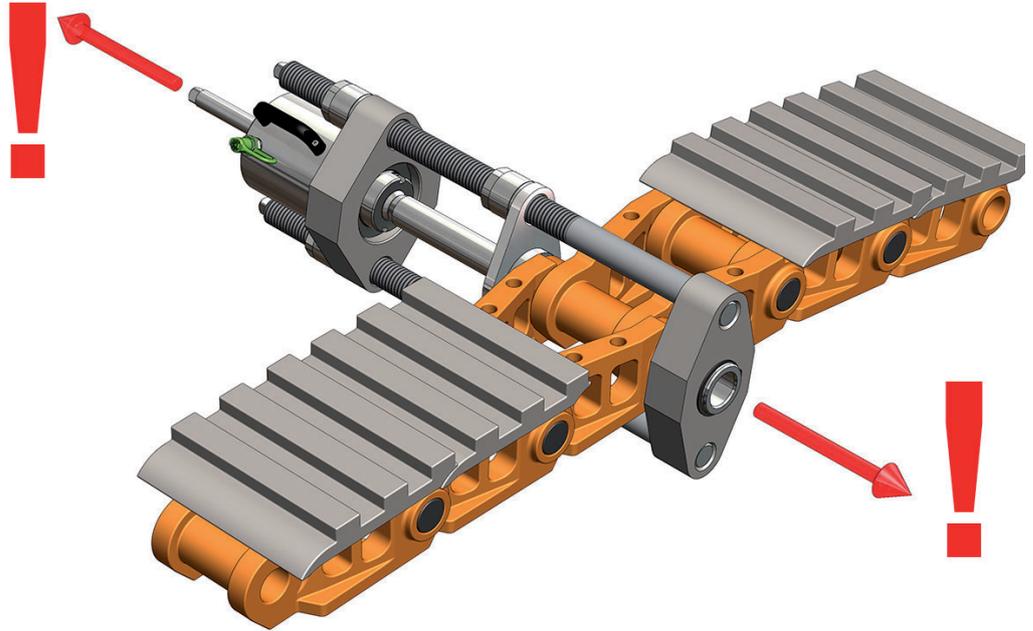
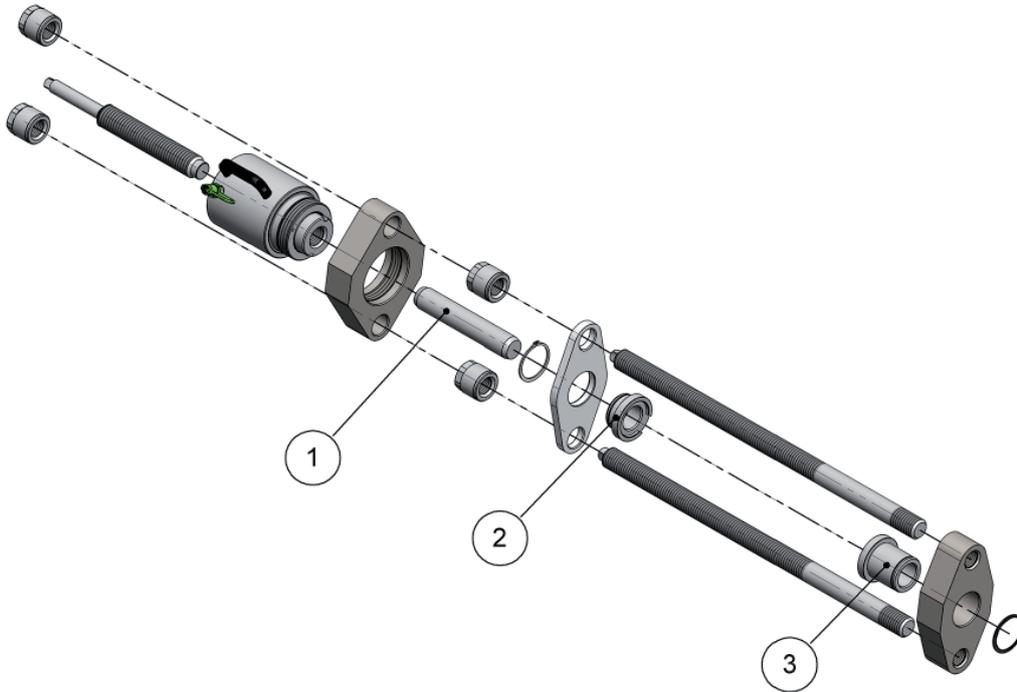


Fig. 2



**Fig. 3**



POS.			Bolt size					
1	2	3	A	B	C	D	E	F
			p					
				p				
					p			
						p		
							p	
								p

Table 1 [mm]

Fig. 4



Fig. 5



Fig. 6

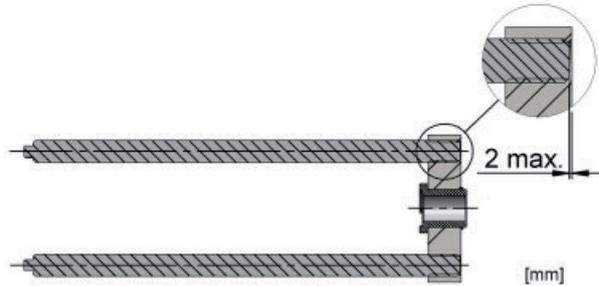


Fig. Abbildung 7

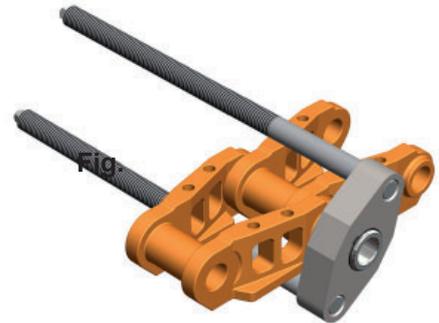


Fig. 8

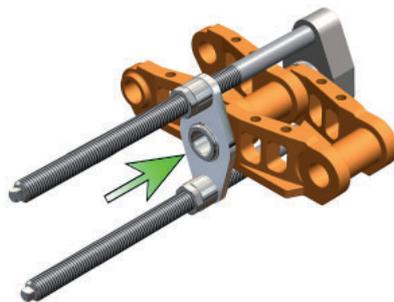


Fig. 9

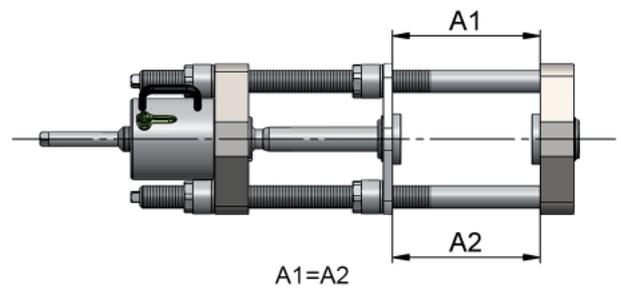


Fig. 10

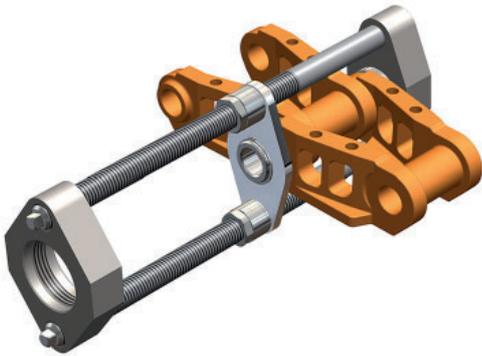


Fig. 11

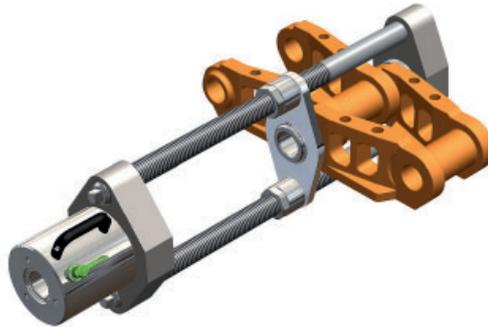


Fig. 12



Fig.13

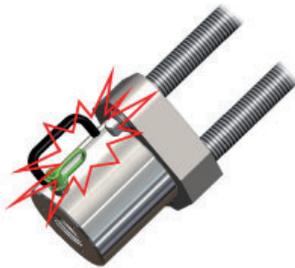


Fig. 14

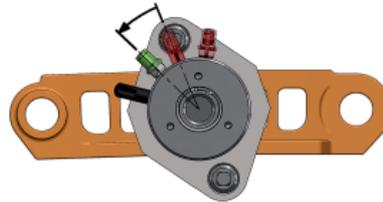


Fig. 15

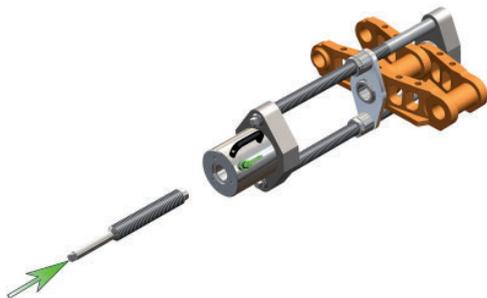
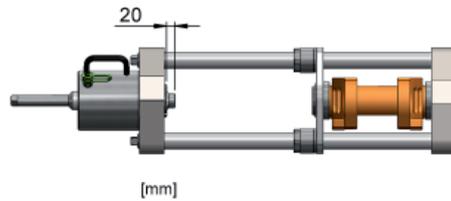
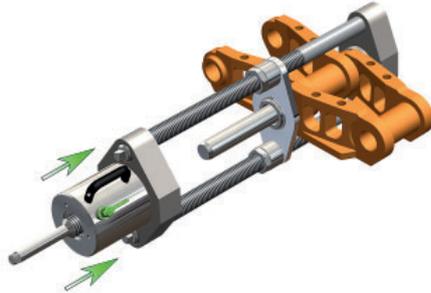


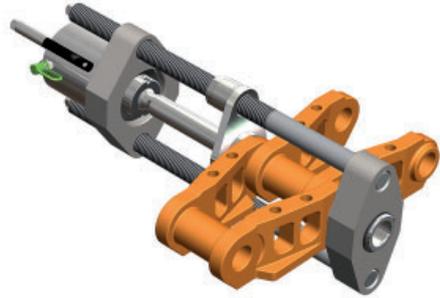
Fig. 16



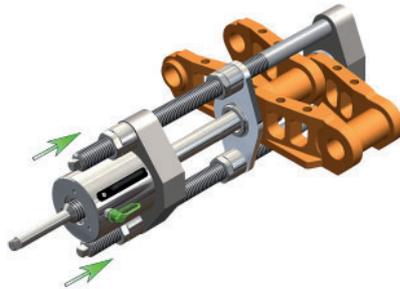
**Fig. 17**



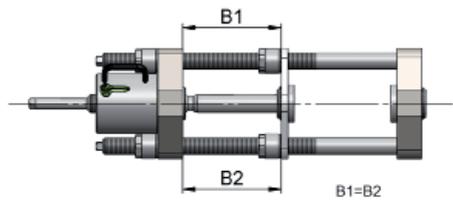
**Fig. 18**



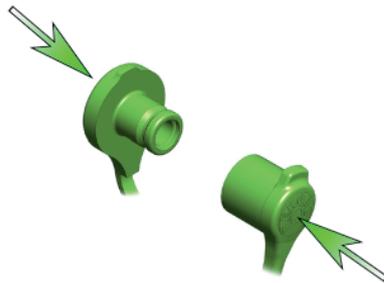
**Fig. 19**



**Fig. 20**



**Fig. 21**



**Fig. 22**



Fig. 23

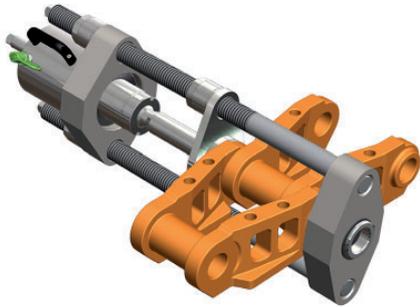


Fig. 24

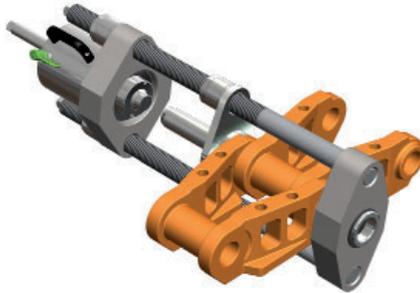


Fig. 25

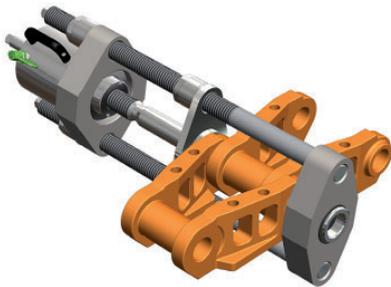


Fig. 26

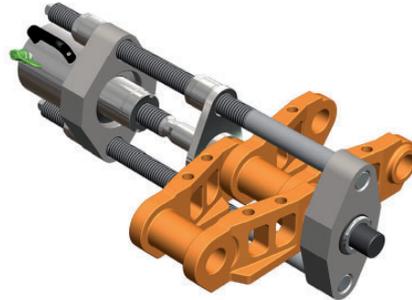


Fig. 27

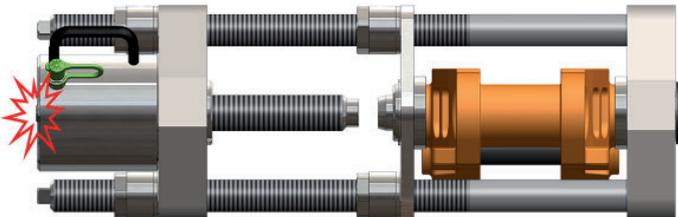
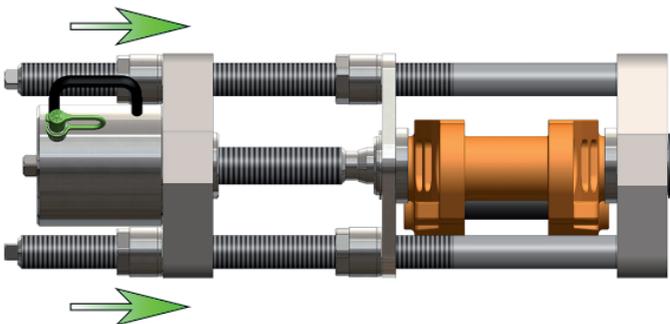


Fig. 28



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