

0: Uncrating/Unboxing

The Titan 25T base unit is delivered fully assembled on a singular skid. An in depth description of what is inside is provided here. Please use this as a reference for the rest of the assembly.

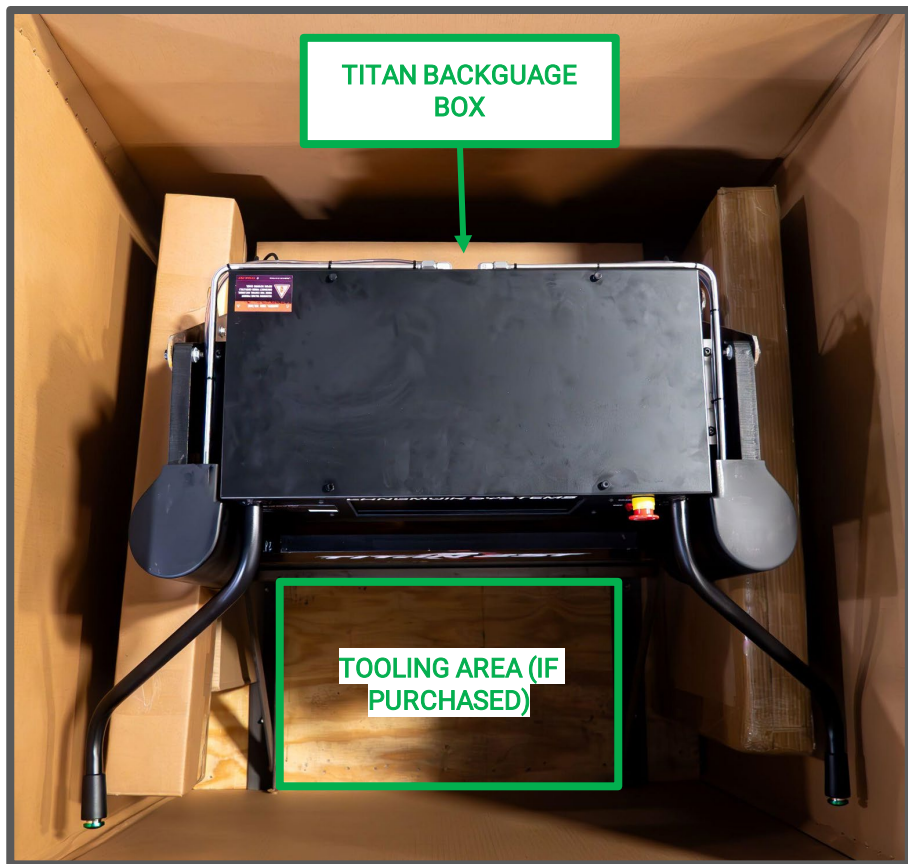


Main Box

- (1) Fully assembled Titan 25T
- (1) Foot Pedal
- (1) Power Cord
- (1) Tooling Sub Box
- (1) Punch Clamp Box

1: Add-on Unboxing

At the time of purchase, if any Titan add-ons were selected, they will be shipped nested within the Titan 25T boxing.



NOTE: THE FOLLOWING ITEMS ARE CONSIDERED ADDITIONAL ACCESSORIES AVAILABLE FOR PURCHASE IN OUR ONLINE STORE. IF YOU DID NOT PURCHASE ANY ADD-ONS WHEN ORDERING YOUR TITAN 25T, YOUR PALLET WILL NOT INCLUDE ADDITIONAL BOXING ASIDE FROM THE FOOT PEDAL AND POWER CORD.

Backguage Add-on Box

- (1) METAL TUBE WELDMENTS SUB BOX
- (1) LINEAR BEARING AND LEAD SCREW SUB BOX
- (1) DRAG CHAIN
- (1) MISC PARTS SUB BOX
- (1) BACKGUAGE ELECTRONICS BOX
- (1) MISC HARDWARE BOX

Material Support Tray Add-on Box

- (1) LINEAR BEARING AND RAIL ASSEMBLY
- (2) SUPPORT BRACKET WELDMENTS
- (2) MISC PARTS SUB BOX

Press Brake Stand Add-on Boxes (2)

- (1) LH CAST SIDE SUPPORT
- (1) RH CAST SIDE SUPPORT
- (1) MATERIAL STORAGE TRAY
- (1) ADJUSTABLE CASTER BOX
- (1) PRESS BRAKE STAND FOOT SUB BOX
- (2) STAND DIAGONAL BRACE

Titan Lift Plate Add-on Package

- (2) TITAN LIFT PLATES
- (2) HARDWARE SUB BAG

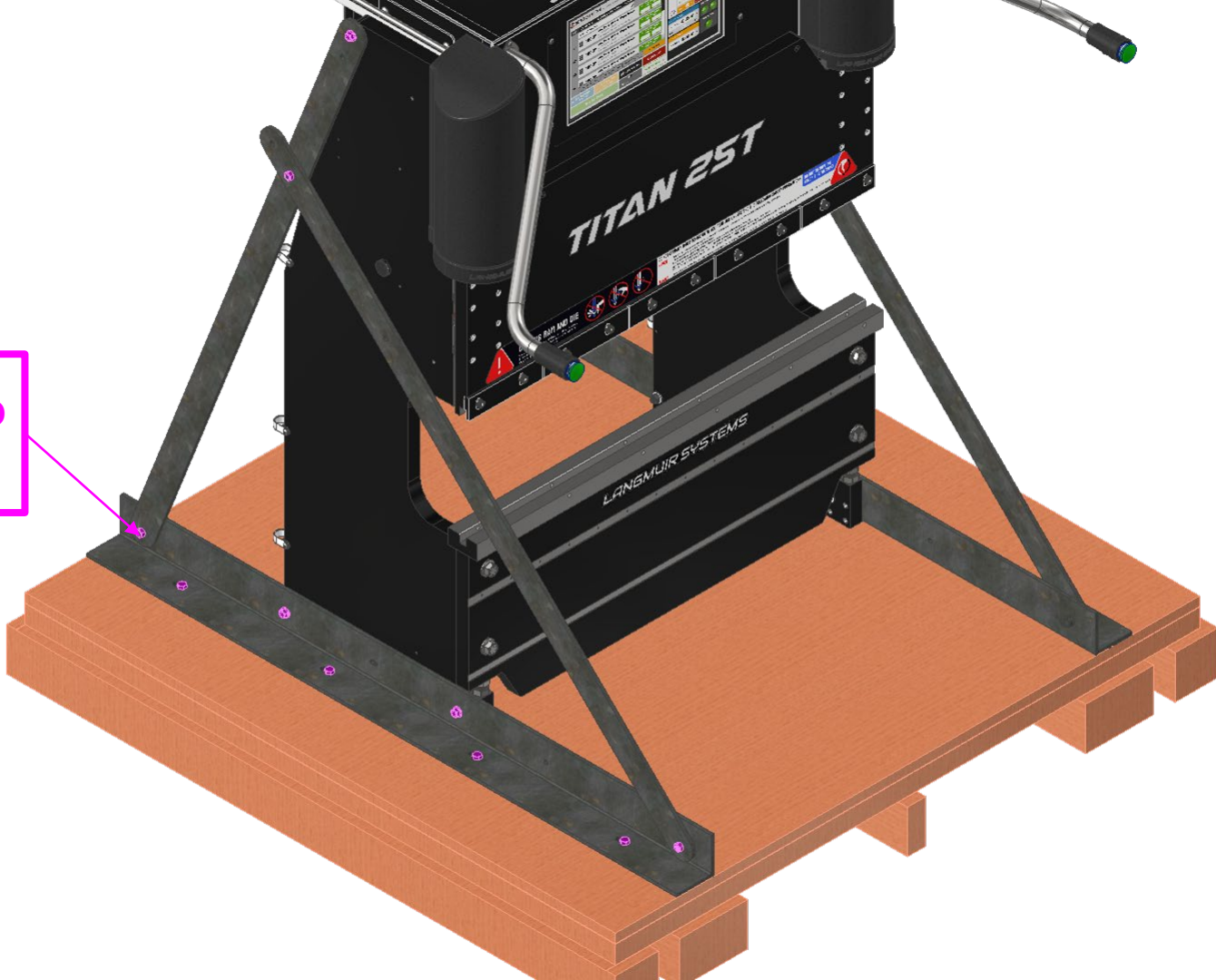
Leveling Foot Kit Add-on Box

- (4) LEVELING FEET
- (4) LEVELING FOOT MOUNT
- (1) HARDWARE BAG

2. Removing the Shipping Support Arms

The first step in removing Titan from the pallet is to remove the support arms and angle iron from the unit.

**BOLTS TO
REMOVE**



Materials

Parts

- None

Hardware

- None

Tools

- (2) ½" Box End Wrenches
- (1) 9/16" Socket Wrench
- (1) Pry Bar (Optional)

Instructions:

NOTE: Titan 25T arrives bolted to a metal bracing to ensure safe shipping. This bracing must be removed prior to moving and operating the Titan 25T. Failure to remove the metal structure prior to operation can damage the Titan 25T.

IMPORTANT: PRIOR TO BEGINNING THIS STEP, ENSURE THE TITAN PALLET IS PLACED IN AN OPEN AREA THAT IS EASILY ACCESSIBLE BY FORKLIFT OR SHOP CRANE FROM ALL SIDES OF THE PALLET. SPACE REQUIREMENT WILL VARY BASED ON MAKE AND MODEL OF LIFTING EQUIPMENT.

A1. Using two ½" Box End Wrenches, loosen and remove all bolts highlighted in magenta on the shipping bracing from both sides. Then, using a 9/16" Socket Wrench, remove the nuts securing the angle iron to the Titan 25T Pallet. Remove bracing from the pallet.

NOTE: If removal of the bolts that attach the angle iron to the bottom of the Titan 25T proves to be a challenge, using a pry bar to slightly elevate the Titan off pallet will remove vertical loading on the bolts for easy removal.

3: Preparing to Lift The Titan 25T

The second step to remove the Titan 25T from its pallet is to prepare the designated lift points.

Materials

Parts

- (2) Titan Lift Plate

Hardware

- (4) 5/16-18 x 1 ¾ Hex Head Flange Bolt
- (4) 5/16-18 Flange Nut

Tools

- None

Instructions

WARNING SYMBOL: TITAN 25T LIFT POINTS

WARNING: Titan 25T has built-in, designated lift points for safe lifting of the unit. Failure to utilize the designated lift points can result in permanent damage to the Titan 25T and a serious risk to your safety that may result in injury or death. Do NOT under any circumstances attempt to lift the Titan 25T from any point other than the designated lift points.

NOTE: THE FOLLOWING STEPS OUTLINE LIFTING PROCEDURES UTILIZING THE TITAN LIFT PLATE KIT. IF YOU DID NOT PURCHASE THE TITAN LIFT PLATE KIT, YOU WILL NEED TO SOURCE GRADE 8, 5/16-18 BOLTS WITH ENOUGH LENGTH TO ATTACH LIFTING CHAIN OR STRAPPING. IT IS RECOMMENDED TO UTILIZE OVERSIZED WASHERS AS A BACKSTOP ON THE SOURCED BOLTS TO PREVENT THE CHAIN OR STRAPPING FROM SLIPPING OVER THE BOLT HEAD DURING LIFTING OF THE UNIT.

A1. The Titan 25T comes equipped with two hydraulic cylinder fairings that cover one of the designated lift points. To gain access to the lift point, remove the fairings from their magnetic connectors by pulling them vertically off of the Titan 25T. Set aside for reinstallation at a later time.

A2. Install and orient the Titan Lift Plates with the provided fasteners as shown.

NOTE: FAILURE TO ORIENT THE TITAN LIFT PLATE CORRECTLY WILL CAUSE THE UNIT TO LEAN FORWARD SIGNIFICANTLY WHEN LIFTING AND CREATE UNSAFE LIFTING CONDITIONS CAPABLE OF DAMAGING THE TITAN.

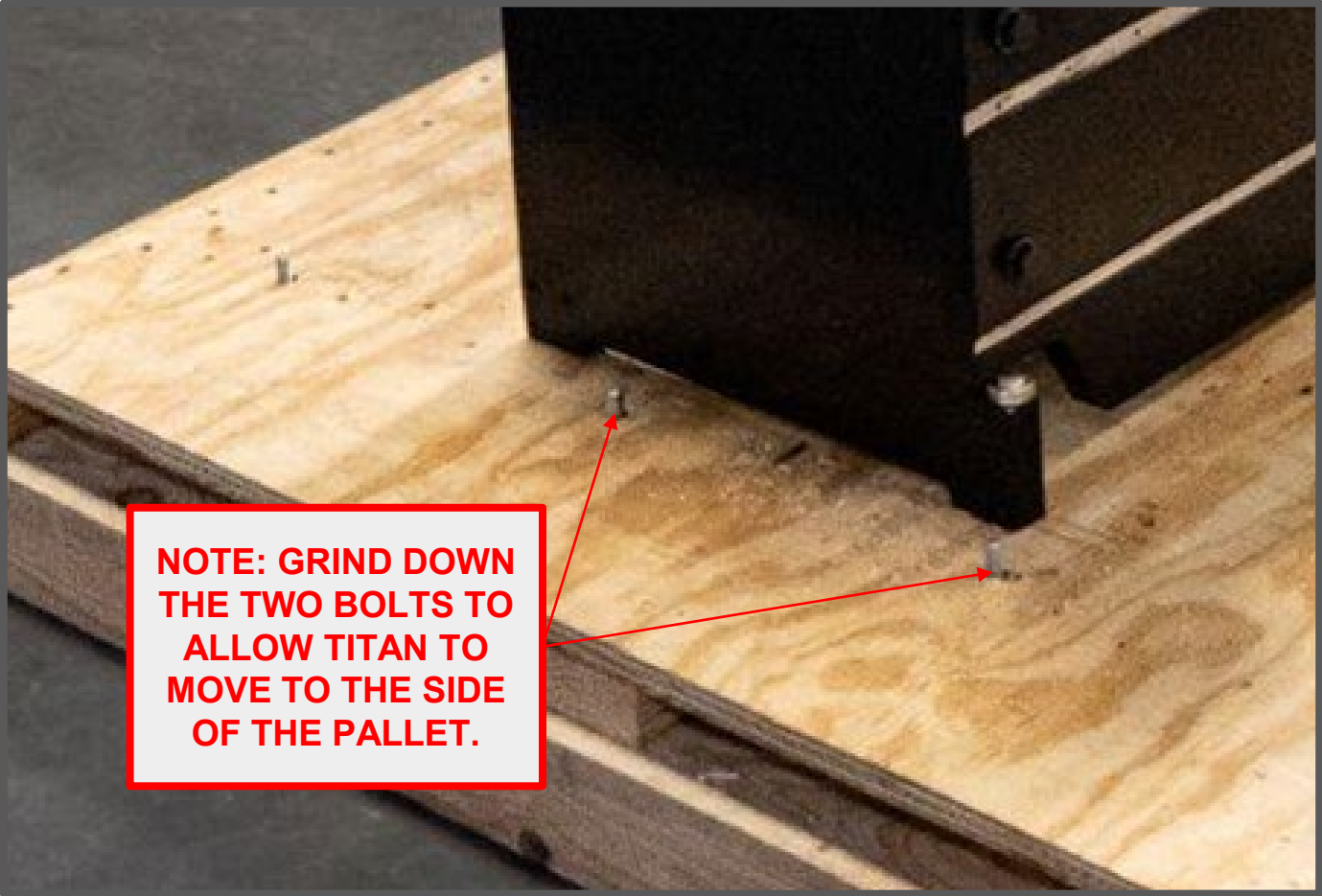
INFO SYMBOL : LIFTING EQUIPMENT

- Do you own or have access to a forklift to lift the Titan 25T?
See the forklift lifting section → [LINK MANUAL TO SKIP TO SLIDE 21]
- Do you own or have access to a shop crane rated for 1000 lbs to lift the Titan 25T? See the Shop Crane/Engine Hoist Section → [LINK MANUAL TO SKIP TO SLIDE 10]

NOTE: IF YOU BOUGHT AND ARE PLANNING TO INSTALL THE TITAN 25T ON TO THE PRESS BRAKE SUPPORT STAND ADD-ON, YOUR SHOP HOIST/Crane MUST BE CAPABLE OF LIFTING THE TITAN 25T UNIT ~30 INCHES FROM THE FLOOR.

4: Maneuvering the Titan on the Pallet

Before lifting with an Engine Hoist/Shop Crane, the Titan must be maneuvered so that the Hoist can be properly positioned.



**NOTE: GRIND DOWN
THE TWO BOLTS TO
ALLOW TITAN TO
MOVE TO THE SIDE
OF THE PALLET.**

Materials

Parts

- None

Hardware

- None

Tools

- Angle Grinder or Bolt Cutter

Instructions:

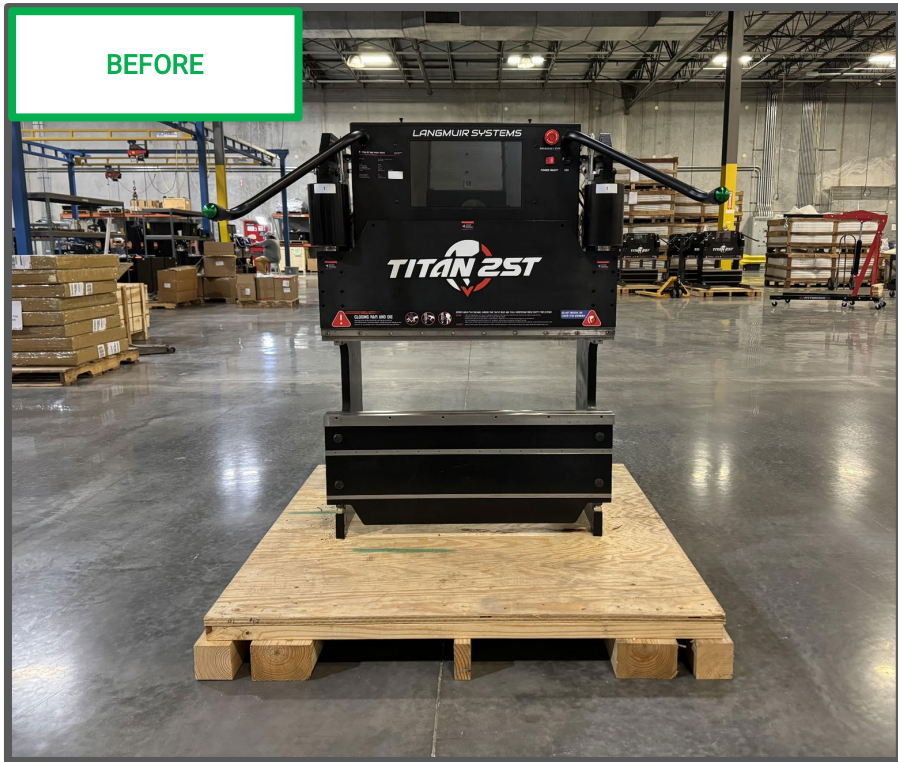
INFO SYMBOL: The Titan 25T can be secured to the pallet with lag bolts from the top or hex bolts from the bottom. If your Titan is secured to the pallet with hex bolts from the bottom, they will need to be removed to allow free movement of Titan across the pallet.

WARNING SYMBOL: PERSONAL PROTECTIVE EQUIPMENT

WARNING: The process of maneuvering the TITAN 25T presents various risks from material ejection, crush hazard, and pinch points. It is recommended that for all steps outlined in maneuvering the Titan 25T that eye protection, steel toe boots, and safety gloves be worn. If at any point the Titan 25T begins to tip or fall, be prepared to back away from the unit. Do NOT under any circumstances place appendages under the Titan 25T as this could lead to serious or fatal injury.

A1. Using an angle grinder, grind down the two studs protruding from the pallet shown.

BEFORE



AFTER



Materials

Parts

- None

Hardware

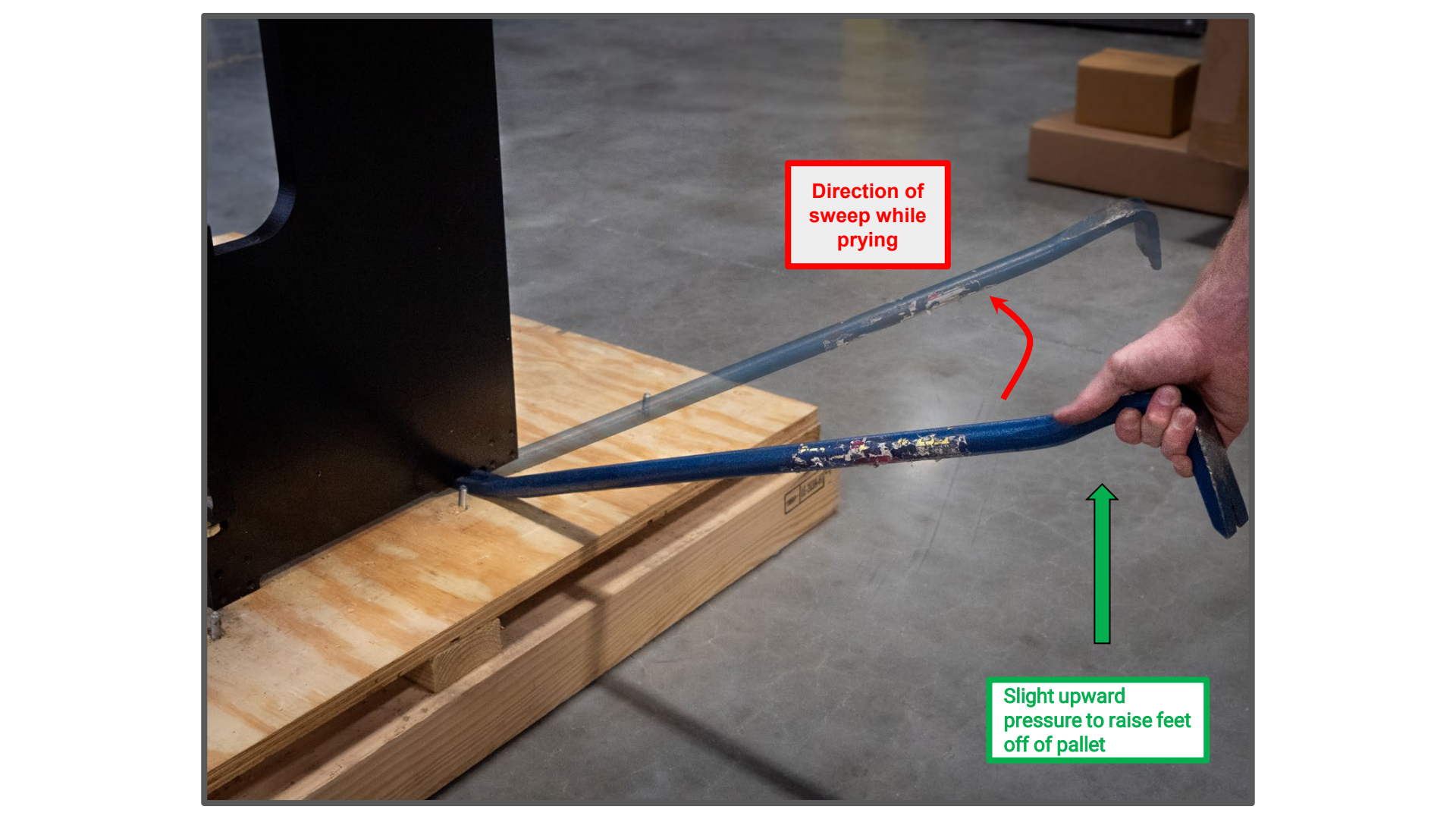
- None

Tools

- None

Instructions:

NOTE: The Titan 25T must be moved to one side of the pallet as shown before it can be lifted with the shop hoist.



Direction of
sweep while
prying

Slight upward
pressure to raise feet
off of pallet

Materials

Parts

Hardware

Tools

- Pry Bar (24in+ Recommended)

Instructions

B1. Locate a pry bar to assist with maneuvering the Titan 25T. We recommend a length of 2 ft minimum for easy maneuverability.

B2. Position the end of the pry bar such that it sits in the relief between the feet of one of the uprights as shown.

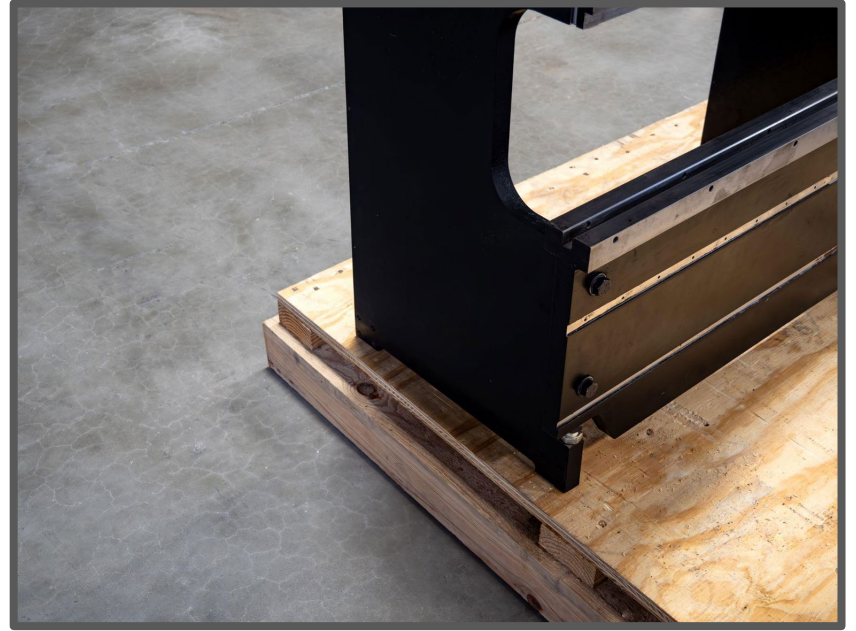
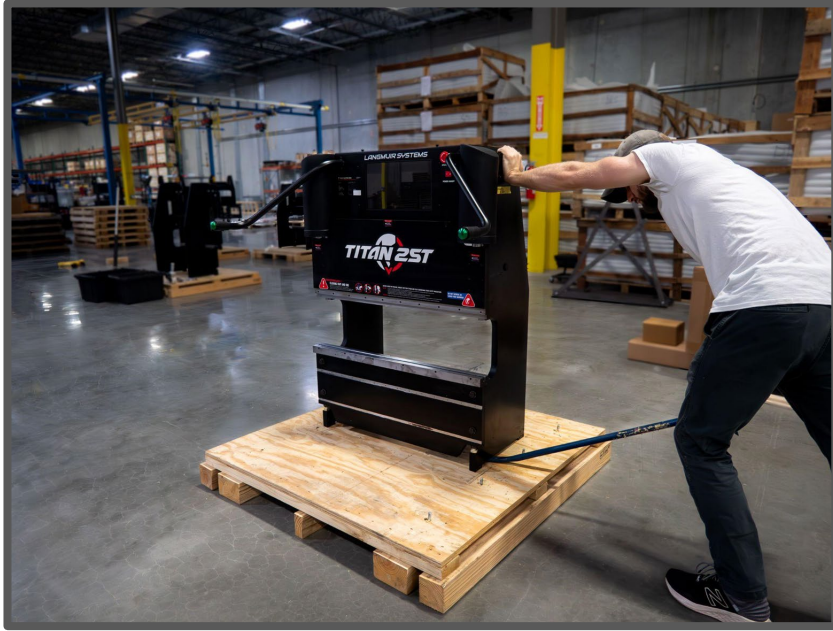
WARNING SYMBOL: FALLING/TIPPING HAZARD

WARNING: TITAN 25T CAN BE EASILY TIPPED IF NECESSARY CAUTION IS NOT TAKEN DURING PRYING. GO SLOW AND PRY IN SMALL INCREMENTS.

B3. With the pry bar positioned as shown, begin by prying Titan slightly off the pallet (~0.125") until both feet are raised up.

B4. Next, sweep the pry bar to the right such that Titan moves in an arced path. If done correctly, the foot closest to the pry bar should now be closer to the far end of the pallet and Titan will be sitting at an angle on the pallet.

B5. On the same side of the unit, position the pry bar next to the opposite foot and repeat the process outlined in steps B2-B4, but sweep the pry bar in the opposite direction.



Materials

Parts

Hardware

Tools

- Pry Bar (24in+ Recommended)

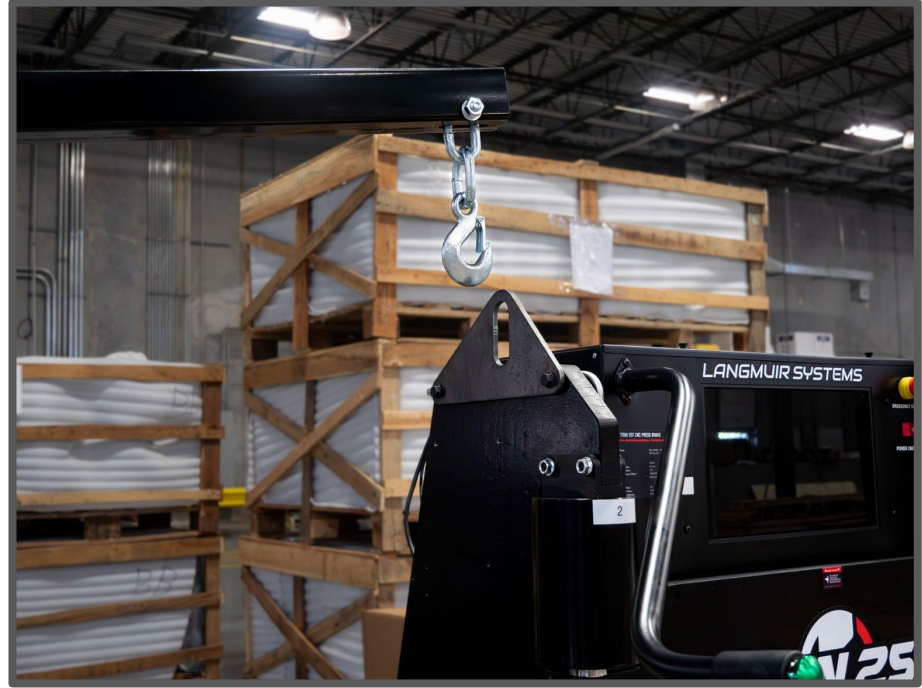
Instructions

NOTE: Providing slight forward pressure to the top of the unit as shown will provide some forward momentum to aide in walking the Titan Unit.

B6. Continue to pry and walk the Titan until the upright closest to the pallet's perimeter is within 1.5" - 2" from the edge.

5: Lifting with a Shop Crane/Engine Hoist

The next step is to utilize your shop crane to access the final lift point.



Materials

Parts

- (1) Titan Lift Plate (Optional Purchase)

Hardware

- (2) 5/16 x 1 ¾ Hex Head Flange Bolts
- (2) 5/16 Flange Nuts

Tools

- Shop Crane/Engine Hoist
- Pry Bar

Instructions

NOTE: IF YOU HAVE NOT ALREADY ATTACHED THE TITAN LIFT PLATES TO THE DESIGNATED LIFT POINTS, DO SO NOW.

INFO: If you did not purchase the Titan Lift Plate Kit, substitute lifting equipment should provide a hook point that is positioned approximately 3.5” back from the screen side of the electronics enclosure.

WARNING SYMBOL: LIFTING EQUIPMENT

WARNING: Ensure that your shop crane/hoist is rated for AND adjusted to support a 1000 lb load. Failure to use and adjust properly rated lifting equipment can result in serious injury or death.

A1. With the Lift Plate or Substitute lifting equipment in place, position the hook of your shop crane so that the hook can be attached to the lift plate as shown.

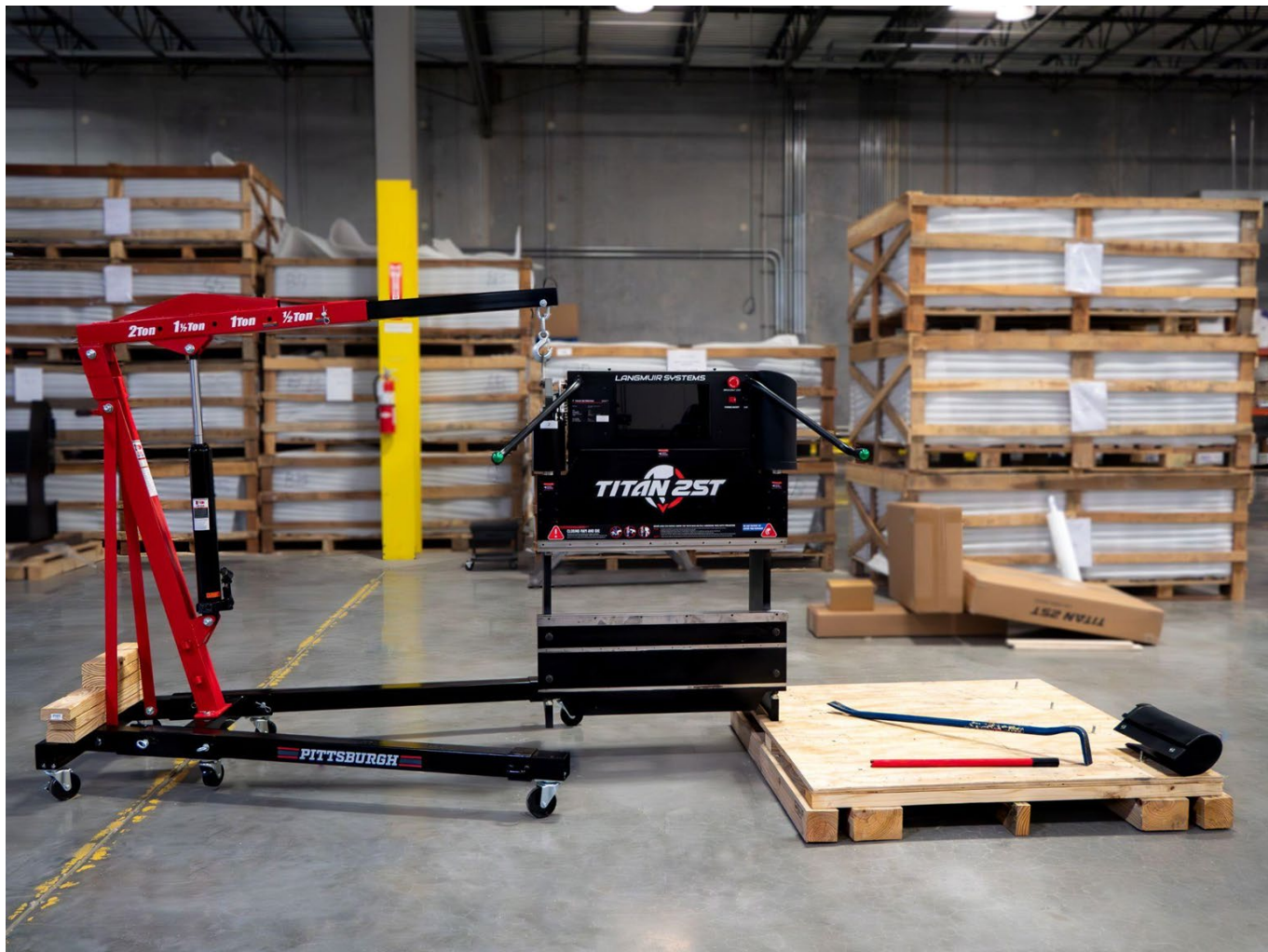
A2. Lift the side of the Titan approximately 0.125" off the pallet. The majority of Titan's weight will still be supported by the pallet on the other side of the unit.

A3. Next, using the same pry bar method to walk the Titan 25T to the edge of the pallet in the maneuvering step, begin walking Titan off of the pallet. You will need to pry and then move the shop hoist backwards to walk the Titan off of the pallet.

A4. Continue to walk the Titan 25T until the feet still on the pallet approach the edge of the plywood surface.

WARNING SYMBOL: FALLING/TIPPING HAZARD

WARNING: Be extremely careful as Titan approaches the edge of the pallet and ensure enough buffer is provided to prevent Titan from falling off of the pallet.



Materials

Parts

Hardware

Tools

- Shop Crane/Engine Hoist

Instructions

B1. Titan 25T should be positioned similar to the image provided above once fully walked to one side of the pallet.



Materials

Parts

- (1) Titan Lift Plate (Optional Purchase)

Hardware

- (2) 5/16 x 1 ¾ Hex Head Flange Bolts
- (2) 5/16 Serrated Lock Nuts

Tools

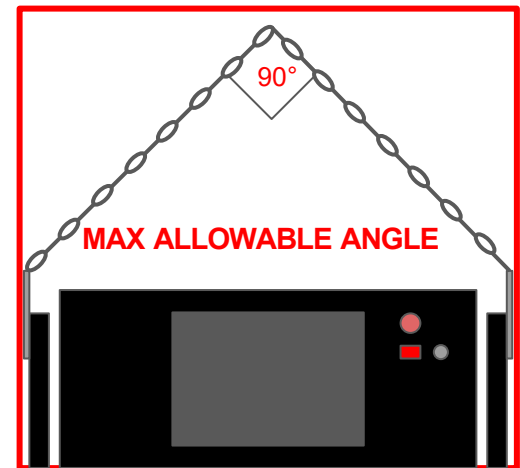
- Shop Crane/Engine Hoist
- Blocking Material

Instructions

C1. Using blocking material, fill the void under the Titan 25T that is suspended in air as shown. Blocking material should be approximately 5 ¾" tall to maintain a surface even with the top of the pallet.

C2. Slowly lower the suspended Titan 25T until the full weight of the unit is distributed between the blocking material and the pallet.

C3. Remove the Shop Crane/Hoist from the hook point.



Materials

Parts

Hardware

- 9/32 Trade Size Lifting Chain
- (Optional) Chain Shackles

Tools

- (1) Shop Crane/Engine Hoist

Instructions

D1. Span the lifting chain between the slots found on the Titan Lift Plates.

NOTE 1: YOUR CHAIN MAY VARY IN LENGTH SO LONG AS THE HOOK POINT DOES NOT EXCEED A 90 DEGREE ANGLE AS SHOWN. AN ANGLE GREATER THAN 90 DEGREES CAN PUT DAMAGING LOADS INTO THE TITAN FRAME.

NOTE 2: IF YOU REQUIRE MORE LIFT HEIGHT (SUCH AS TO LOAD TITAN ONTO THE STAND), A SPREADER BAR WITH SUFFICIENT LOAD CAPACITY MAY BE USED.

D2. Reposition your shop crane such that the hook point rest at the midpoint of your chain span as shown and connect the chain to the hook.

D3. Lift your Titan 25T fully off of the pallet.

WARNING SYMBOL: CRUSH HAZARD

WARNING: Do NOT under any circumstances place any appendage or part of your body beneath the TITAN 25T while it is suspended in air. Failure to adhere to safe lifting practices can result in fatal injury or death.



Materials

Parts

- None

Hardware

- None

Tools

- (1) Shop Crane/Engine Hoist

Instructions

FLAG SYMBOL: IF YOU PURCHASED THE TITAN 25T SUPPORT STAND ADD-ON, SEE THE PRESS BRAKE STAND ASSEMBLY GUIDE →

E1. With Titan off the pallet, you may position the unit in your shop where desirable.

6: Lifting with a Forklift

The next step is to prepare and lift the Titan 25T with a forklift.



Materials

Parts

- (2) Titan Lift Plate (Optional Purchase)

Hardware

- 9/32 Trade Size Lifting Chain (4ft Length)
- (Optional) Chain Shackles

Tools

Instructions

FLAG SYMBOL: IF YOU ARE LIFTING WITH A FORKLIFT, PROCEED TO THE NEXT STEP. OTHERWISE, SKIP IT →

NOTE: THE SPAN OF CHAIN NECESSARY FOR LIFTING TITAN MAY VARY BASED ON THE SPECIFICATIONS OF YOUR FORKLIFT AND FORKS.

A1. Span the lifting chain between the slots found on the Titan Lift Plates or between the 5/16-18 Bolts with oversized washer.

A2. Prior to lifting, ensure the chain is in line with the slot features of the Titan Lift Plate or ~3.5" back from the screen side of the electronic enclosure as shown.

A3. Begin lifting Titan 25T off of the pallet.

WARNING SYMBOL: CRUSH HAZARD

WARNING: Do NOT under any circumstances place any appendage or part of your body beneath the TITAN 25T while it is suspended in air. Failure to adhere to safe lifting practices can result in fatal injury or death.



Materials

Parts

Hardware

- 9/32 Trade Size Lifting Chain (4ft Length)
- (Optional) Chain Shackles

Tools

Instructions

FLAG SYMBOL: IF YOU PURCHASED THE TITAN 25T SUPPORT STAND ADD-ON, SEE THE PRESS BRAKE STAND ASSEMBLY GUIDE →

B1. With Titan off of the pallet, you may position the unit in your shop where desirable.