



FORCE 50 DA HYDRAULIC PRESS INSTRUCTIONS AND PARTS LIST



Ordering information

Please order all parts by part number and name; also mention model number as shown on plate attached to the frame of the press. Prices do not include freight and handling charges.

724 Robbins Road
Grand Haven, MI 49417
Phone: 616-842-7110 800-937-3253
Fax: 616-842-0859 800-846-3253
Web: www.dakecorp.com
E-mail: customerservice@dakecorp.com
technicalservice@dakecorp.com

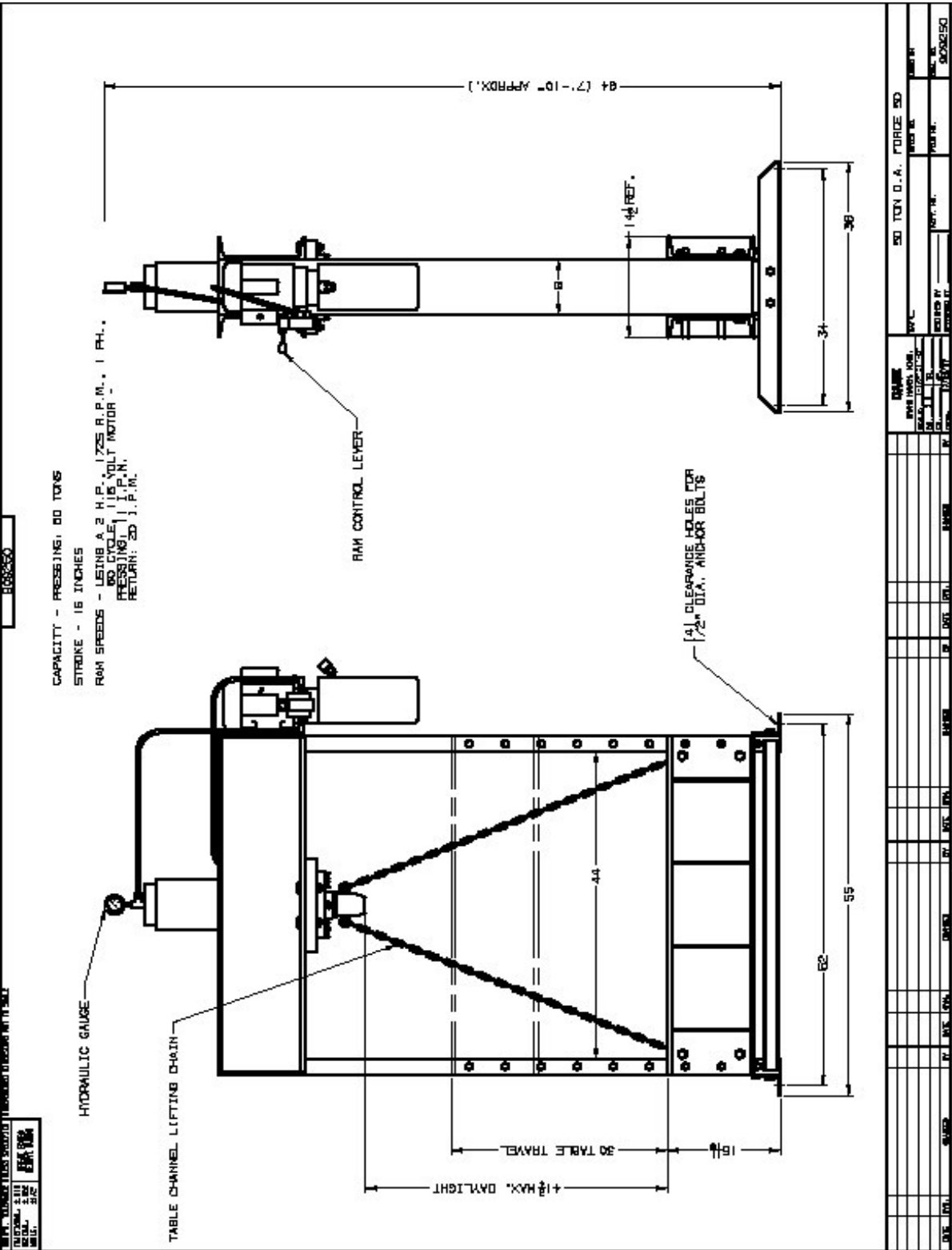
Thank you for buying Dake !!!!

We hope you enjoy many years of using your new Dake hydraulic press. We hope you find these instructions helpful, if you have any questions please give us a call, or just stop by for a factory tour.

724 Robbins Road
Grand Haven, MI 49417

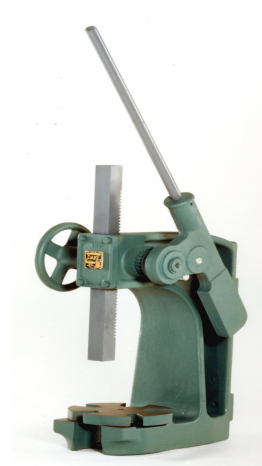
Phone: 616-842-7110 800-937-3253

Dimensional drawing of 50 ton press



MACHINE SPECIFICATIONS

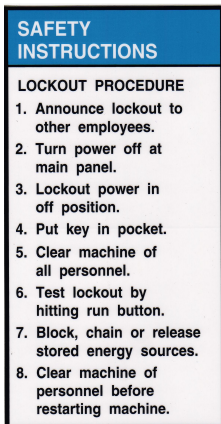
Tons	50
Stroke	16 inches
Pressing speed	11 Inches per minute
Return speed	20 Inches per minute
Daylight	41 3/4
Table travel	30 Inches
Between channels	44 Inches
Motor 1725 R.P.M	2 horse power / 60 cycle / 115/220 Volt
Weight	1200 lbs.
Approx. height	7' 10" / 94"



Optional side mounted arbor

Options

1. Remote relief valve part number 301949. This will make the tonnage adjustable from 290 – 3537 p.s.i.
2. Check valve makes the press hold pressure part number 302071
3. Side mounted arbor part number 02007. This press will mount on the left side of the 50 DA press.



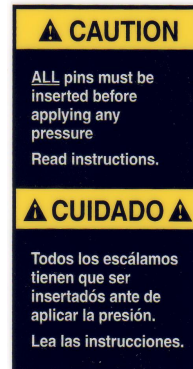
Part Number 76462



Part Number 84395



Part Number 84399



Part Number 84487



Part Number 300168

10 TON PRESS SHOWN

1. LABEL #500158
WARNING LABEL -
LEFT SIDE -
ESTABLISH SOLID
FOOTING TO
PREVENT FALLS.

2. LABEL #500159
WARNING LABEL -
RIGHT SIDE -
KEEP HAND AWAY
FROM POINT OF
OPERATION.

3. LABEL #500160
WARNING LABEL -
GUARD WORKPLACE
TO PREVENT
INJURY FROM
FALLING DEBRIS.

4. LABEL #500161
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

5. LABEL #500162
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

6. LABEL #500163
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

7. LABEL #500164
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

8. LABEL #500165
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

9. LABEL #500166
WARNING LABEL -
MOUNT CENTERED ON
CHANNEL AS SHOWN.

10. LABEL #500167
CAUTION LABEL -
ALL PINS MUST BE
INSERTED BEFORE
APPLYING ANY
PRESSURE. READ
INSTRUCTIONS.
MOUNT CENTERED ON
CHANNEL AS SHOWN.

This machine is not designed for stripping operations. Personal injury or machine damage can result.

Press set-up

Installation Instructions

Your new Dake Press has been packaged in a manner to prevent damage to any critical components; some assembly will be required. All parts in the accessory box are critical to the function of your press. Some presses may be pre assembled.

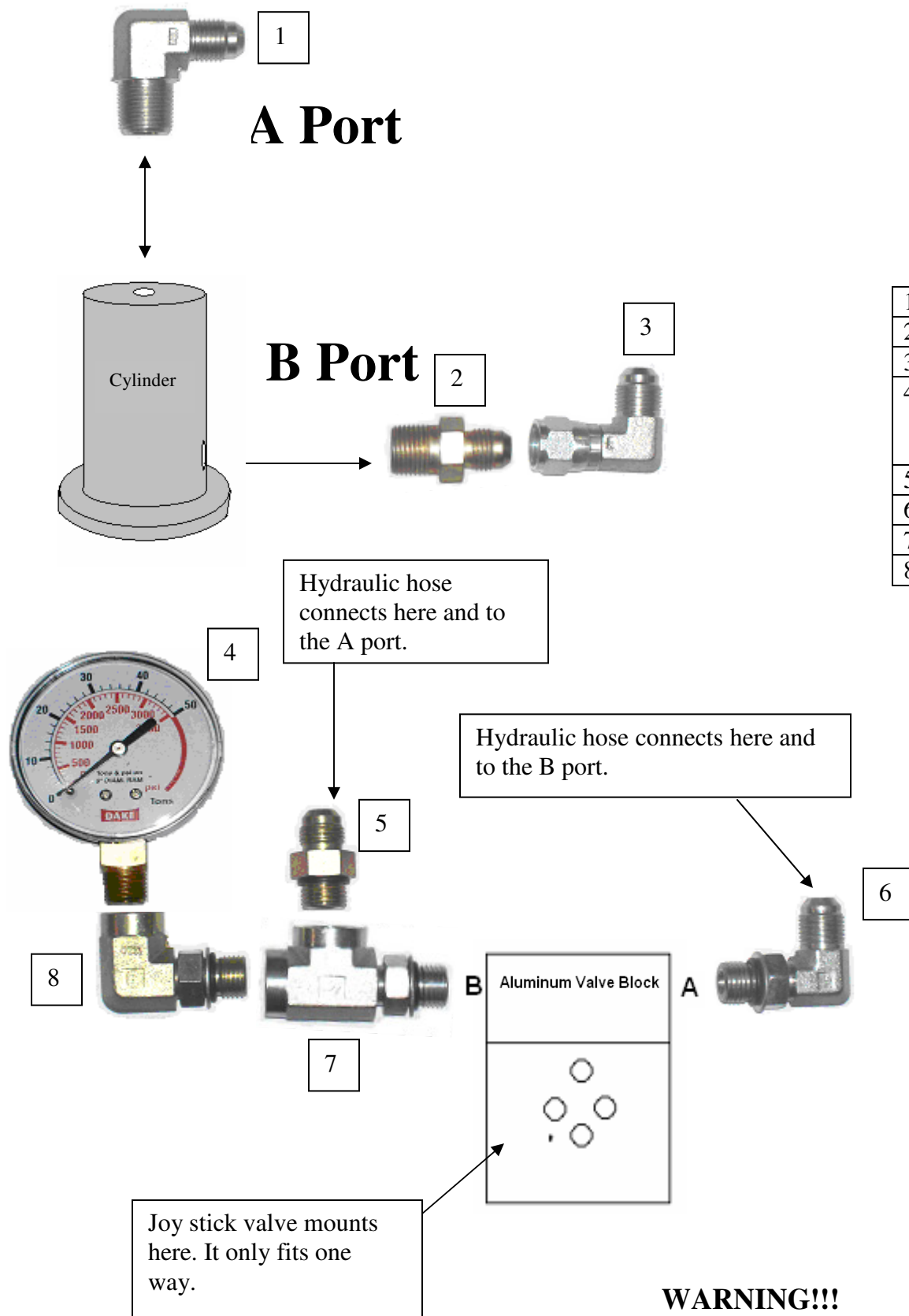
NOTE: FOR EASE OF ASSEMBLY LEAVE THE PRESS FRAME MOUNTED ON THE SHIPPING SKID

1. Remove plastic from the machine.
2. Open the box and you will see a pumping unit, with the press still laying on its side. Locate the four holes on the side of the press facing up.
3. Place the pumping unit on the side of the press with the mounting bracket facing down, making sure the holes all line up.
4. There are four bolts, washers and nuts in a bag, in the box. Put the bolts in the holes using the washers and nuts. Make sure all nuts and bolts are tight.
5. With the press lying on its side fill the reservoir with DTE 24 Mobile oil or equivalent.
6. Look at picture on the next page to install all the fittings.

WARNING!!!!

Be sure all bolts and fittings are tight before operating this pumping unit, personal injury could result.

How to install the fittings on your new hydraulic press



1	72050
2	73425
3	72047
4	10 ton 301315 25 ton 301316 50 ton 302179
5	69671
6	72402
7	302183
8	302061

WARNING!!!

Be sure all fittings and bolts are tight.
Do not over tighten fittings or bolts.

Wiring Instructions

WARNING!!!!

A licensed qualified electrician that follows all state and local laws must wire and install the electrics on this machine.

110 Volt

WARNING!!!!!!

This machine must have a designated 30 amp drop for 110 volts.

1. For 110 volts this machine is ready to plug in. The machine can be wired 220 volt single phase. Always follow the wiring diagram provided in the motor cover when converting to 220 volt single phase. A cord and plug that is rated for the specified voltage and amperage must be used. This rating is located on the motor.

WARNING!!!!

It is the responsibility of the installer to make sure the motor is wired correctly for the voltage needed. Damage to motor could result.

220 Volt single phases 17.2 amps

WARNING!!!!

A licensed qualified electrician that follows all state and local laws must wire and install the electrics on this machine.

WARNING!!!!!!

This Machine new is shipped out as a 110 volt machine. If the wiring must be changed to suit 220 volts single phase.

1. The leads on the motor must be changed to fit 220 volts 17.2 Amps, follow the diagram on the motor.
2. Install plug and wire that fits the rating on the motor, this plug and wire must be rated for the voltage and amperage listed on the motor.

Operation

WARNING!!!!!!

If a 110 volt power supply will be used. A designated 30 amp drop must be supplied; this press will not operate correctly without the 30 amps.

1. Fill the reservoir with 3 gallons of Mobil DTE 24 hydraulic fluid or its equivalent AW 32.
2. Turn the on / off power switch (toggle switch) to the "on" position (up).
3. Move the control lever down, this will advance the ram in the downward position.
4. Release the control lever and the ram will stop moving.
5. Move the control lever handle to the up position and the ram will move up.

6. When the press is new be sure to move the ram up and down to work out any air that may be in the system.

Lubrication

Keep all working parts of the press well oiled for easier operation. Also, keep a light film of oil over the entire surface of the ram to prevent rust.

WARNING!!!!

This press is not intended for stripping operations! Personal injury or machine damage can result.

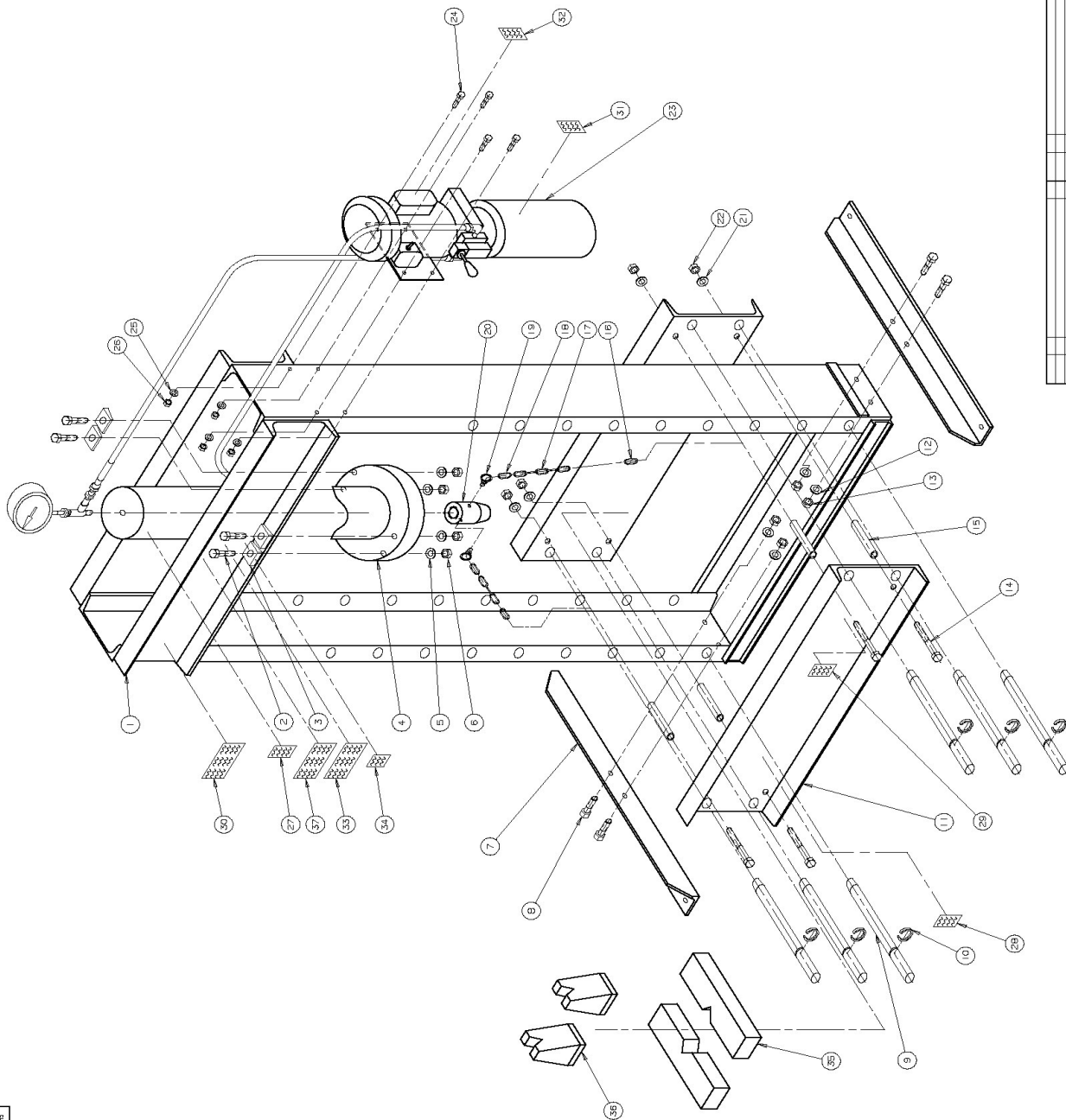
WARNING!!!!

Only use Hydraulic oil in this machine DTE 24 hydraulic oil is recommended.

Do not use transmission fluid in this press, the warranty will be void and this fluid will damage the seals.

MAKE 1. TOLERANCE UNLESS SPECIFIED UNLESS INDICATED NOT TO SCALE

DATE: 3/29/2010
 DRAWN BY: J. D. D.
 CHECKED BY: J. D. D.
 APPROVED BY: J. D. D.



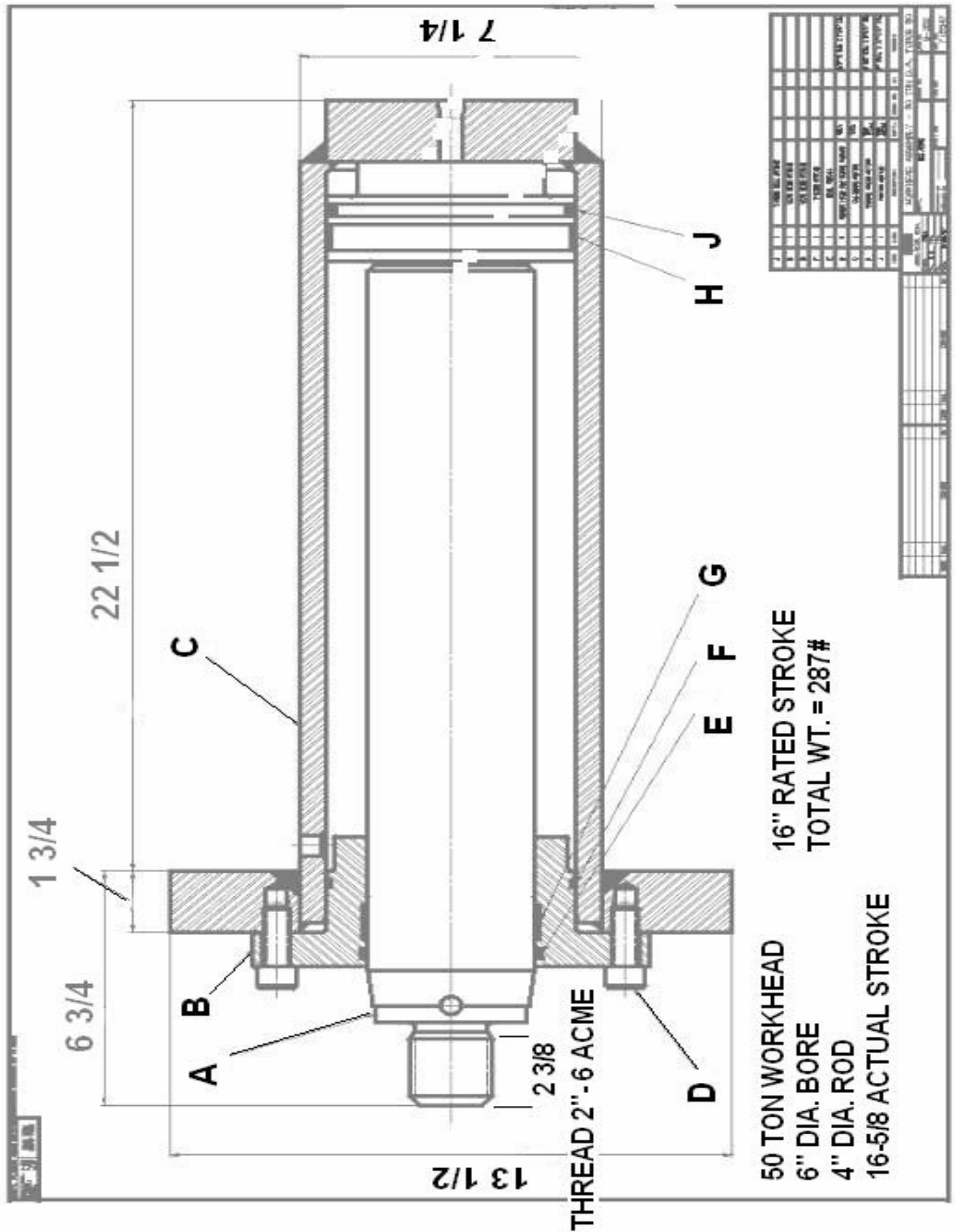
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31	2	TABLE PLATE	81003	
30	3	TABLE PLATE	7002	
29	4	TABLE PLATE	7003	
28	5	TABLE PLATE	7004	
27	6	TABLE PLATE	7005	
26	7	TABLE PLATE	7006	
25	8	TABLE PLATE	7007	
24	9	TABLE PLATE	7008	
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15	18	TABLE PLATE	7017	
14	19	TABLE PLATE	7018	
13	20	TABLE PLATE	7019	
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11	22	TABLE PLATE	7021	
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6	27	TABLE PLATE	7026	
5	28	TABLE PLATE	7027	
4	29	TABLE PLATE	7028	
3	30	TABLE PLATE	7029	
2	31	TABLE PLATE	7030	
1	32	TABLE PLATE	7031	

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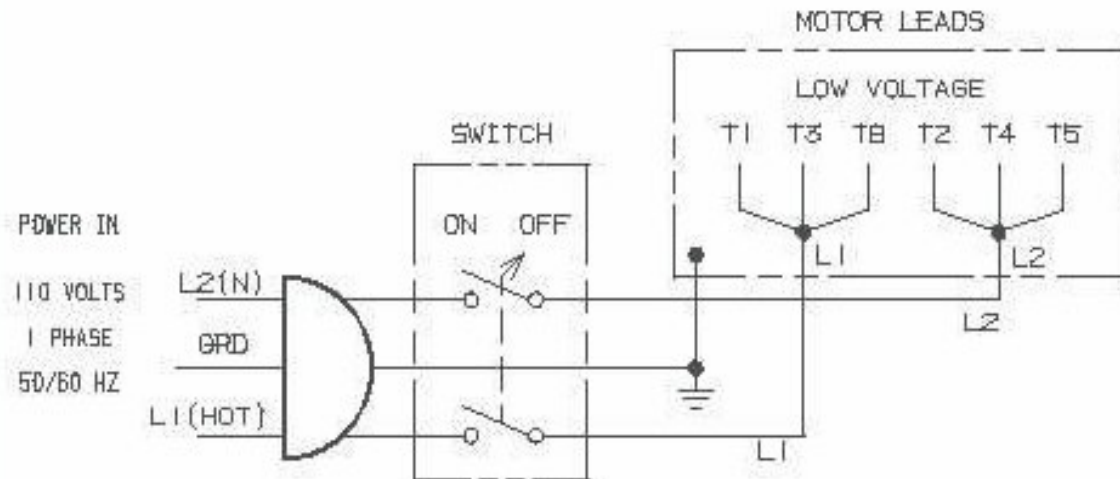
FORCE 50 DA HYDRAULIC PRESS

PARTS LIST

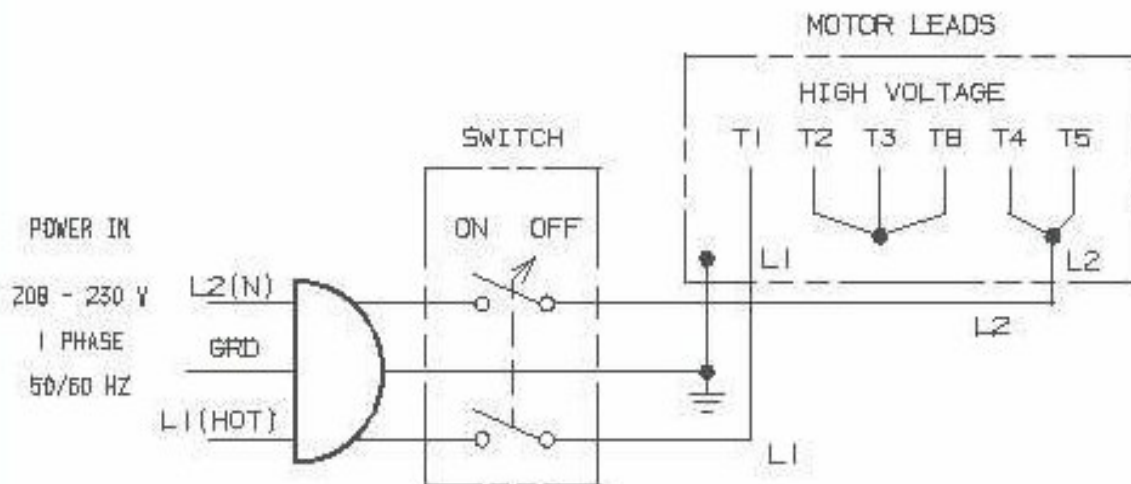
Item #	Qty	Description	Part #		Item #	Qty.	Description	Part #
1	1	Frame 50 Ton	87137		20	1	Nose Piece	87138
2	4	Hex Cap Screw 1/2"-13x3 1/4" lg	43356		21	4	Lock Washer 5/8"	43648
3	4	Channel Washer 1/2"	43657		22	4	Hex Nut 5/8"x11	43917
4	1	Work head Assembly	716547		23	1	Hydraulic Power Unit	301856
5	4	Lock Washer 1/2"	43647		24	4	Hex Cap Screw 5/16"-18 NCx1/2"lg	43313
6	4	Hex Nut 1/2"-13	43916		25	4	Lock Washer 5/16"	43644
7	2	Base Angle	566		26	4	Hex Nut 5/16"-18	43911
8	4	Hex Cap Screw 1/2"-13NC X 1 1/2" lg	43349		27	1	Label	301879
9	6	Table Pin	569		28	1	Label	84487
10	6	Retaining Ring	43980		29	1	Label	84399
11	2	Table Channel	706945		30	1	Label	300168
12	4	Lock Washer 1/2"	43647		31	1	Label	76462
13	4	Hex Nut 1/2"-13	43916		32	1	Label	84395
14	4	Table Bolts	79983		33	1	Name Plate	301856
15	4	Table Spacer	86488		34	1	Label	76936
16	2	Shackle	301884		35	2	Table Plate	702
17	2	Chain	301881		36	2	V-Block	336
18	4	Spring Snap	301882		37	1	Dake Name Plate	81002
19	2	Eye Bolt	301880					



MACH'G. TOLERANCE UNLESS SPECIFIED		DATE	SYN.	CHANGES	BY
FRACTIONAL: $\pm .010$	BREAK EDGES REMOVE BURRS				
DECIMAL: $\pm .002$					
ANGLE: $\pm 1/2^\circ$					
UNDERScoreD DIMENSIONS NOT TO SCALE					



CCW ROTATION FACING LEAD END AS SHOWN.
INTERCHANGE LEADS T5 & T8 FOR CW.



DAKE		ELECTRICAL CONTROL / WIRING			
GRAND HAVEN, MICH.		NAT'L.		STOCK NO.	USED ON
SCALE: <u>NA</u>					909250
DR. <u>ROD</u>	TR. <u></u>			FILE NO.	DRW. NO.
CH. <u></u>	AP. <u></u>	DESIGNED BY <u></u>			87175
DATE: 1/25/78 11:02A		APPROVED BY <u></u>			

