



INSTRUCTIONS AND PARTS LIST FOR Models 1-202, 1-204, 1-210, and 1-220 Air Arbor Presses

WARNING LABELS



To the left is the safety Alert symbol. When you see these safety alert symbols on your press, be alert to the potential for personal injury.
Follow recommended precautions and safe operating practices.

SETTING UP THE PRESS FOR OPERATION

1. Fasten press to bench or work surface using the mounting holes provided (Item 3).
2. Connect a 3/8" air supply to the filter-regulator (Item 38) located at the rear of the press frame. **CAUTION! Air must be moisture free! Water in the air supply may damage the press beyond repair! Air line lubrication is not required.**
3. Adjust the air regulator for proper operating pressure as follows:
 - a. 200 pound model (1-202) at 70 psi.
 - b. 400 pound model (1-204) at 90 psi.
 - c. 1000 pound model (1-210) at 85 psi.
 - d. 2000 pound model at (1-220) at 100 psi.

OPERATIONS

1. Depressing both recessed buttons (Item 23) simultaneously will cause the press to close.
2. The releasing of either recessed button will cause the press to open fully.
3. The Down Stroke Stop adjustment (Item 8) is located inside the guard (Item 10). This adjustment may be used to limit the closing of the press to any point in the stroke. Always tighten the locknut to keep the adjustment in place. **WARNING! ALWAYS REPLACE THE GUARD (Item 10). NOT DOING THIS COULD RESULT IN SERIOUS INJURY!**
4. The cylinder rod of the press has a non-rotating feature that could be damaged if care is not used when attaching tooling. Always hold the rod from rotating using a wrench on the flats above the threads when attaching tooling or tooling adapters.
5. There are openings in each side of the control enclosure for screwdriver adjustment of the press ram speed. The opening on the right side (looking from the front) controls the up speed and the other one is for the down speed. Turning the screw clockwise decreases the speed.

WARNING LABELS



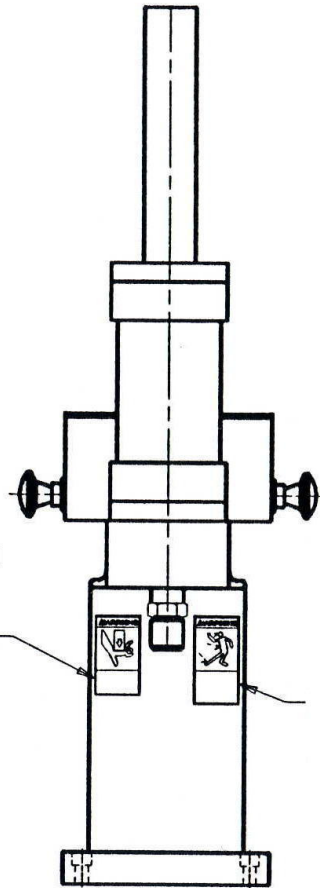
To the left is the safety Alert symbol. When you see these safety alert symbols on your press, be alert to the potential for personal injury.

Follow recommended precautions and safe operating practices.

Carefully read all safety messages in these instructions and on your press safety signs.

Keep safety labels in good condition. Replace missing or damaged safety labels. **This machine is intended to be operated by one person.** This person should be conscious of the press ram movement not only for himself but also for persons in the immediate area of the machine.

Label Placement View



LABEL #84396: Warning label, keep hand away from point of operation. Mount to flat surface of throat just below radius as shown.

LABEL #84400: Warning label, guard workplace to prevent projectiles from reaching operator. Mount to flat surface of throat just below radius as shown.

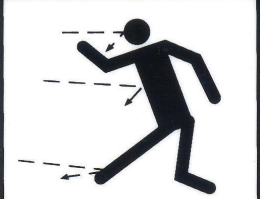
DRAWING SHOWS WARNING LABEL LOCATION
ON AIR-OPERATED ARBOR PRESSES
1-202, 1-204, 1-210 & 1-220

Label 84400

WARNING

Guard workpiece to prevent projectiles from reaching operator.

Wear eye protection.



ADVERTENCIA

Mantenga el lugar de trabajo de tal manera que los proyectiles no alcancen al operario.

Lleve puestas gafas protectoras.

Label 84396

WARNING

Keep hands away from point of operation.

Read instructions.



SAFEGUARDING THE POINT OF OPERATION

ANSI B11.2 - Hydraulic Power Presses - Safety Requirements for Construction, Care, and Use

It is important that Dake press users have a clear understanding of their responsibility involving the care and use of their Dake hydraulic press, including point-of-operation safe guards. Dake strongly recommends that Dake press users obtain a copy of the current American National Standard Institute (ANSI) B11.2 standard, for a more complete understanding of their responsibilities.

ANSI B11.2 states the following, relative to point of operation safeguarding:

“Normally, only the employer (press user) can determine the requirements of the press productions system components, including the dies and methods for feeding. Therefore, the employer is ultimately responsible to designate and provide the point-of-operation safeguarding system.”

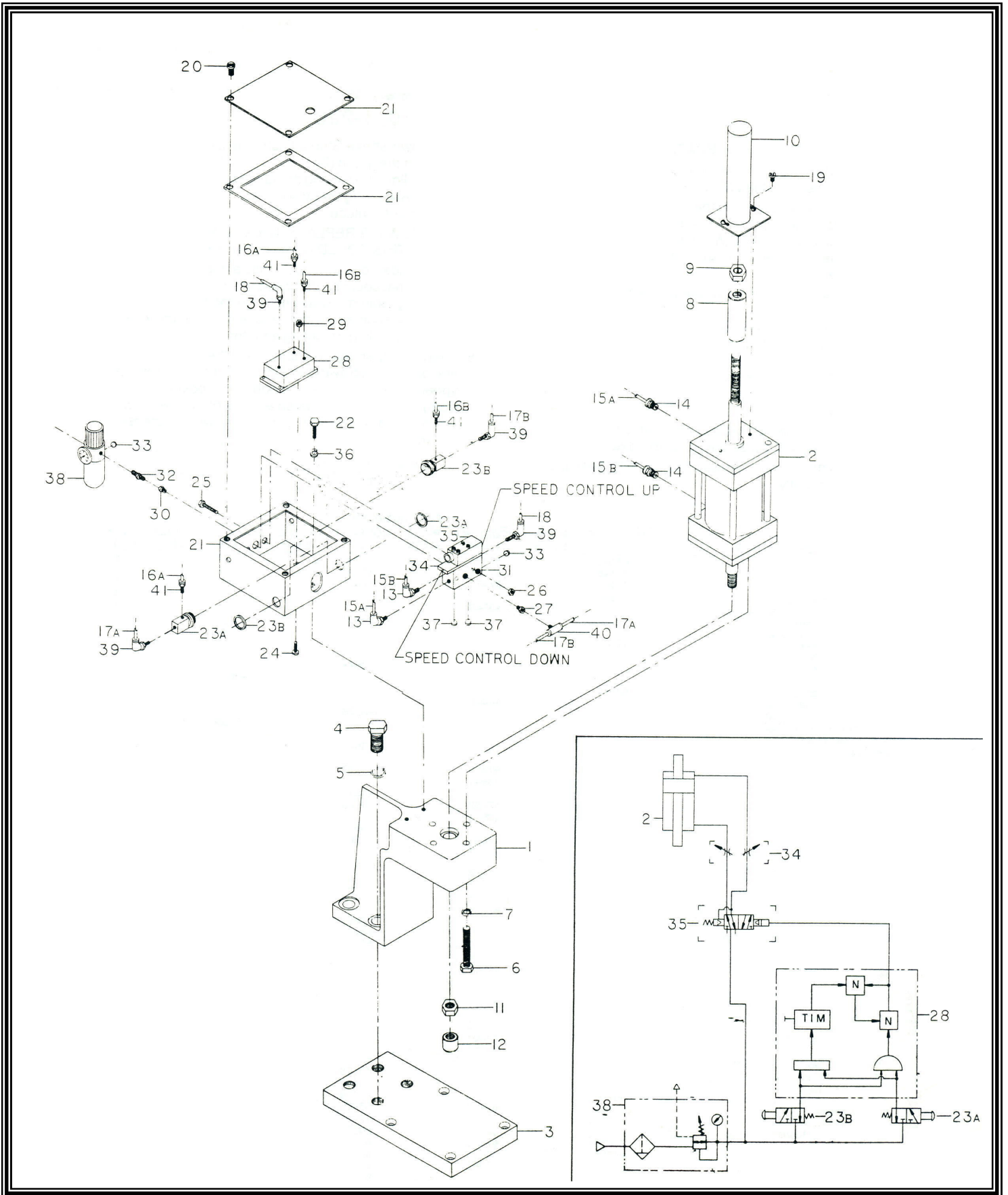
The standard also discusses additional responsibilities of the employer. Some of the key responsibilities are:

- The employer is responsible for the safety, use, and care of the hydraulic power press production system.
- The employer is responsible to consider the sources of hazards for all tasks to be implemented on the hydraulic power press production system.
- The employer is required to eliminate or control identified hazards in the scope of their work activity.
- The employer is responsible for the training of personnel, caring for, inspecting, maintaining, and operating hydraulic press production systems to ensure their competence.
- The employer is responsible to provide and ensure that point-of-operation safeguarding is used, checked, maintained, and where applicable, adjusted on every production operation performed on a press production system.

A complete and current copy of the ANSI B.11.2 standard can be obtained by contacting the following:

American National Standards Institute
1430 Broadway
New York, NY 10018

AMT – The Association For Manufacturing Technology
7901 Westpark Drive
McLean, VA 22102



Item	Part Name	Model 1-202	Model 1-204	Model 1-210	Model 1-220	Qty
1	Main Frame	67463	67472	67728	67733	1
2	Air Cylinder	67446	67473	67730	67735	1
3	Mounting Plate	67461	67474	67731	67734	1
4	3/8"-16 x 1" Hex Cap Screw	43328	-	-	-	4
	1/2"-13 x 1-1/4" Hex Cap Screw	-	43348	-	-	4
	3/4"-10 x 3/4" Hex Cap Screw	-	-	43372	-	4
	1"-8 x 1/2" Hex Cap Screw	-	-	-	43383	4
5	3/8" Lock Washer	43645	-	-	-	4
	1/2" Lock Washer	-	43647	-	-	4
	3/4" Lock Washer	-	-	43649	-	4
	1" Lock Washer	-	-	-	43650	4
6	5/16"-18 x 2"	43320	-	-	-	4
	3/8"-16 x 2-3/4" Hex Cap Screw	-	43336	-	-	4
	3/8"-15 x 3-1/4" Hex Cap Screw	-	-	43339	-	4
	1/2"-13 x 4-1/2" Hex Cap Screw	-	-	-	43359	4
7	5/16" Lock Washer	43644	-	-	-	4
	3/8" Lock Washer	-	43645	43645	-	4
	1/2" Lock Washer	-	-	-	43647	4
8	Stroke Control	67464	67464	67732	67732	1
9	1/2"-20 Hex, Jam Nut	43941	43941	-	-	1
	3/4"-16 Hex, Jam Nut	-	-	43946	43946	1
10	Stroke Control Guard	67462	67462	67729	67729	1
11	1/2"-20 Hex, Jam Nut	43941	43941	-	-	1
	3/4"-16 Hex, Jam Nut	-	-	43946	43946	1
12	Nose Piece	68391	68391	68392	68392	1
13	1/4" Male Elbow Conn. – Brass	60467	60467	-	-	2
	3/8" Male Elbow Conn. – Brass	-	-	60470	60470	2
14	1/4" Male Tube Conn. – Brass	50790	50790	50790	50790	2
15	1/4" Tube Line (Top of air cylinder to subplate)	67764	67764	-	-	1
	1/4" Tube Line (Bottom of cylinder to subplate)	67765	67765	-	-	1
	3/8" Tube Line (Top of air cylinder to subplate)	-	-	67762	67762	1
	3/8" Tube Line (Bottom of cylinder to subplate)	-	-	68486	68486	1
16	1/8" Tube Line (R.H. air valve to element)	68487	68487	68487	68487	1
	1/8" Tube Line (L.H. air valve to element)	68488	68488	68488	68488	1
17	1/8" Tube Line (R.H. air valve to tee)	68489	68489	68489	68489	1
	1/8" Tube Line (L.H. air valve to tee)	68490	68490	68490	68490	1
18	1/8" Tube Line (Subplate to element)	68491	68491	68491	68491	1
19	#10-24 x 1/4" Phillips Hd. Machine Screw	60477	60477	60477	60477	2
20	#10-32 x 1/2" Slotted Machine Screw	43858	43858	43858	43858	4
21	Control Enclosure	68390	68390	68390	68390	1
22	1/4"-20 x 1/2" Hex Cap Screw					2
23	Control Button	67467	67467	67467	57467	2
24	10#-32 x 3/4" Slotted Machine Screw					4
25	1/4"-20 x 1-3/4" Hex Cap Screw	43865	43862	43864	43864	2
26	1/4"-20 Hex Nut	-	-	43946	43946	2
27	3/8" x 1/8" Hex Bushing – Brass	60478	60478	60478	60478	1
28	Logic Element	67453	67453	67453	67453	1
29	#10-32 Hex Nut	43907	43907	43907	43907	4
30	3/8" x 1/4" Hex Bushing – Brass	50790	50790	50790	50790	1
31	Manifold Subplate	67470	67470	67470	67470	1

Item	Part Name	Model 1-202	Model 1-204	Model 1-210	Model 1-220	Qty
32	1/4" Pipe Nipple – Brass	44511	44511	44511	44511	1
33	1/8" Pipe Plug – Brass	60469	60469	60469	60469	2
34	Stack Speed Control	62031	62031	62031	62031	1
35	4-Way Air Valve	67468	67468	67468	67468	1
36	1/4" Lock Washer	43643	43643	-	-	2
37	1/4" Pipe Plug – Brass	33771	33771	33771	33771	2
38	Filter – Regulator	62552	62552	62552	62552	1
39	1/8" Male Elbow Conn. – Brass	60463	60463	60463	60463	4
40	1/8" Male Branch Tee – Brass	60468	60468	60468	60468	1
41	1/8" Male Tube Conn. – Brass	60464	60464	60464	60464	4



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