



INSTRUCTIONS AND PARTS LIST FOR MODEL FORCE 10DA and FORCE 25DA (Double Acting, Electrically-Operated Hydraulic Press)

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

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.

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

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. There fore, 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 ever production operation performed on a press production system.

A complete and current copy of the ANSI B11.2 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

Press set-up

Installation Instructions

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

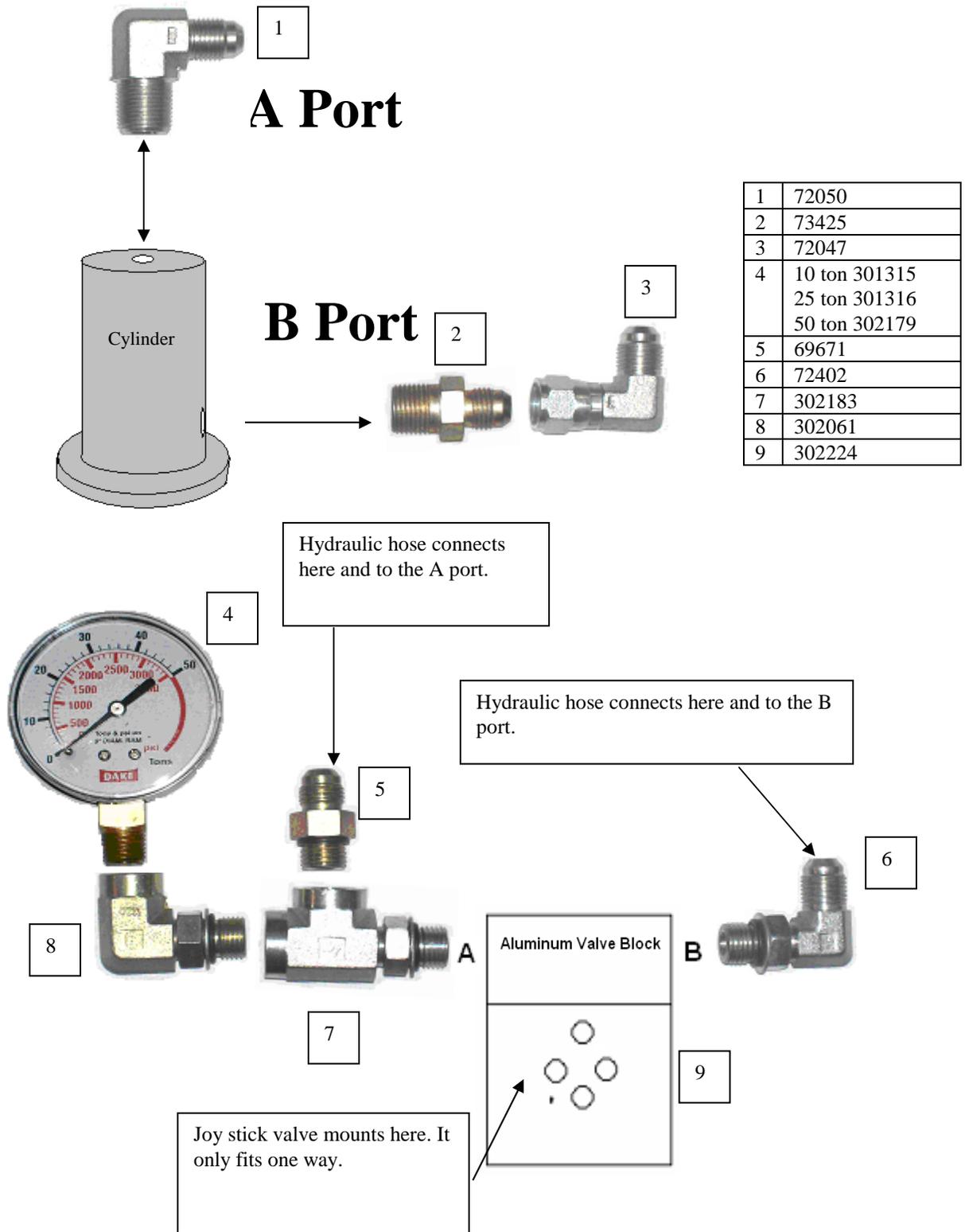
NOTE: FOR EASE OF ASSEMBLY LEAVE THE PRESS FRAME MOUNTED ON THE SHIPPING SKID

- 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.**

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



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

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

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, 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

1. Fill the reservoir with 2 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!!!!

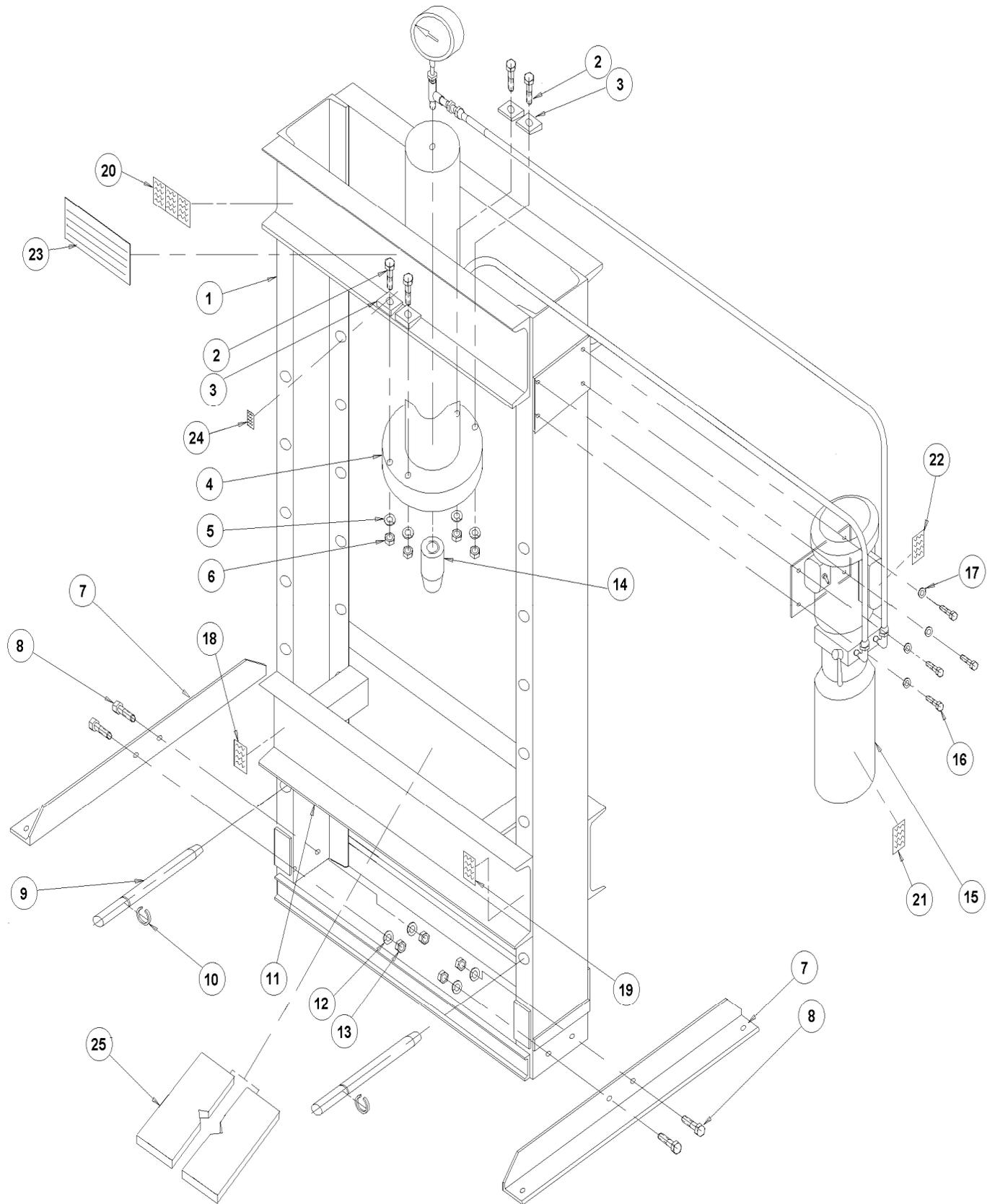
This press is not intended for stripping operations! Personal injury or machine damage can result.

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.

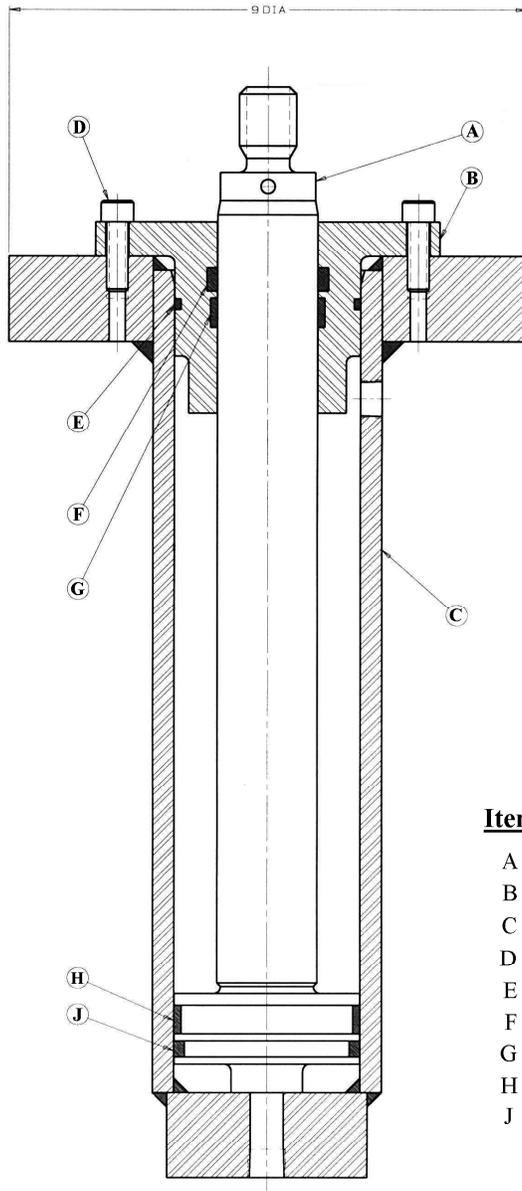
PROBLEM & SOLUTIONS

Ram moves in the neutral position	4-way valve is off center	Re-adjust the 4-way valve by centering the valve stem. See Page 5
Ram runs jerky while moving up and down	Air in the system	Self-bleeding system. Continue to run ram up & down aprox. 15 times.
Machine will not build desired pressure	Relief valve needs to be reset	Remove octagon cap from back of manifold and adjust set screw to correct pressure. WARNING – Do not exceed 2413 PSI.
Pins are shearing or bending	Relief valve needs to be reset	Remove octagon cap from back of manifold and adjust set screw to correct pressure. WARNING – Do not exceed 2413 PSI.
Oil leaks around the ram	Cylinder seals need replacing	Replace cylinder seals
Oil leaks around holes other than the ram	Bolts need to be tightened.	Tighten bolts around the ram.
Ram will not extend the full 10 inches.	Oil level is too low.	Re-fill the reservoir with oil.
Hydraulic gauge will not read pressure	Hydraulic gauge is bad	Replace the hydraulic gauge.
Motor will not start	No power to it.	Double check the electrical cord.
Motor overheats and shuts down	Duty cycle time is exceeded	Check the duty cycle time on the motor. (Has no cooling fan. 15-20 minutes)
	Extension cord is being used.	Extension cord will lower the Amps and will cause overheating of the motor. Remove cord.



ITEM	DESCRIPTION	QTY	FORCE 10DA Part No.	FORCE 25DA Part No.	REMARKS
1	Frame, 10-Ton	1	86517	86684	
2	1/2" - 13NC x 2 3/4"	4	43355	43355	LG. Hex Cap Screw
3	1/2" Channel Washer	4	43657	43657	
4	Workhead Assembly	1	716514	716640	
5	1/2" Lock Washer	4	43647	43647	
6	1/2" - 13 Hex Nut	4	43916	43916	
7	Base Angle	2	85189	978	
8	1/2" - 13NC LG.	4	43349	43347	Hex Cap Screw
9	Table Pin	2	86520	85407	
10	Retaining Ring	2	43975	76818	
11	Table Channel	1	86692	86682	
12	1/2" Lock Washer	4	43647	43644	
13	1/2" - 13 Hex Nut	4	43916	43916	
14	Nose Piece	1	86691	86683	
15	Hydraulic Power Unit	1	300266PU	300265PU	does not include Gauge, Fittings, Hoses and Valve
15	Hydraulic Power Unit	1	300266	300265	includes Gauge, Fittings, Hoses and Valve
16	5/16" - 18NC x 1/2"	4	43313	43313	LG. Hex Cap Screw
17	5/16" Flat Washer	4	43632	43631	
18	Warning Label	1	84487	84487	(See Page 10)
19	Warning Label	1	84399	84399	(See Page 10)
20	3-IN-1 Warning Label	1	300168	300168	(See Page 10)
21	Safety Instructions	1	76462	76462	(See Page 10)
22	Warning Label	1	84395	84395	(See Page 10)
23	DAKE Name Plate	1	86533	86534	(See Page 10)
24	Made In USA Plate	1	76936	76936	(See Page 10)
25	Table Plates	2	85427	85508	
26	Conversion Label	1	79955	79964	CONVERSION CHART LABEL
PARTS NOT ILLUSTRATED					
Breather Vent	1	300267	300267	Reservoir fill port	
Eyebolt	2	N/A	300284		
Triangular Snap Hooks	4	N/A	300285		
Coil Chain	2	N/A	78477		
Gauge	1	301315	301316	Reads in tons / psi	
Gauge	1	301315	300268	Reads in bar / psi	
Valve kit	1	300266KIT	300265KIT	Valve, gauge, fittings and hoses	
Optional check valve	1	302071	302071		
Optional relief valve	1	301949	301949	290-3625 psi or 20-250 bar	
Optional relief valve	1	302197	302197	43.5-435 psi or 3-30 bar	
Bolts	4	43401	43401	Mounting bolts for valve only	
Bolts	4	23155	23155	Mounting bolts for valve and relief valve or check valve	
Bolts	4	302221	302221	Mounting bolts for valve, check valve and relief valve.	

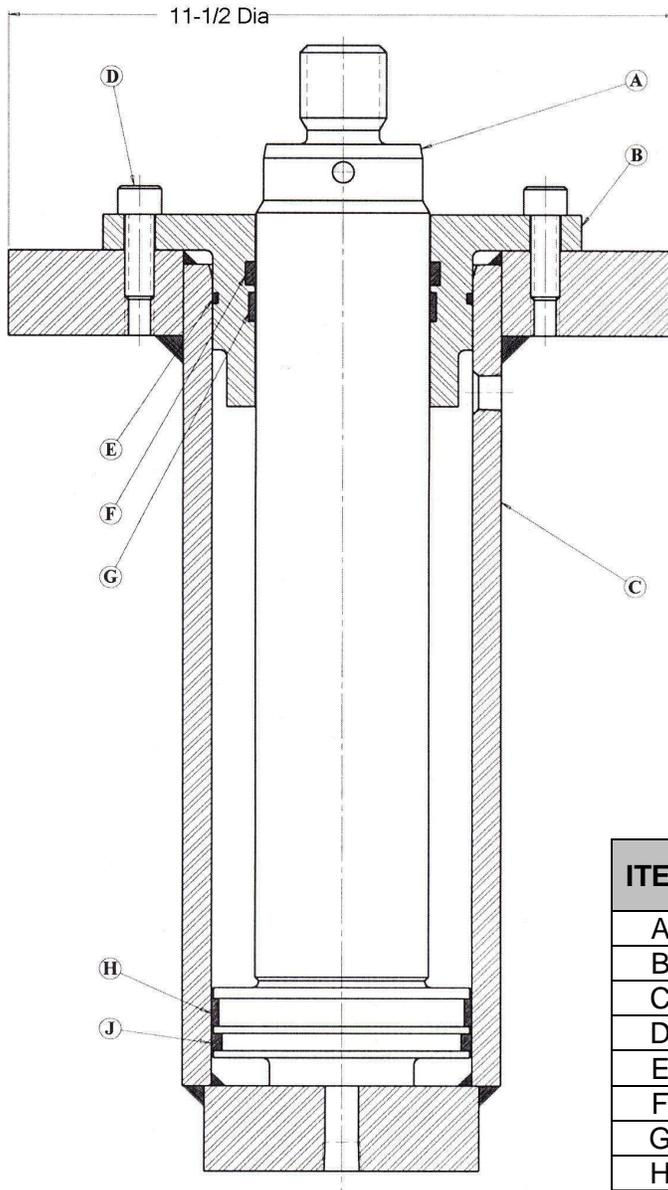
Force 10DA Workhead



10 ton workhead
 3-1/4" Dia. Bore
 1-3/4" Dia. Rod
 10-1/4" Actual Stroke
 10" Rated Stroke
 Total Wt. = 66#

<u>Item</u>	<u>Description</u>	<u>Part No.</u>
A	Piston	86690
B	Cylinder Flange	86689
C	Cylinder	86688
D	Socket Head Cap Screw	43450
E	O-Ring	78483
F	Seal	78484
G	Wear Ring	78485
H	Wear Ring	78486
J	O-ring seal	78487

Force 25DA Workhead

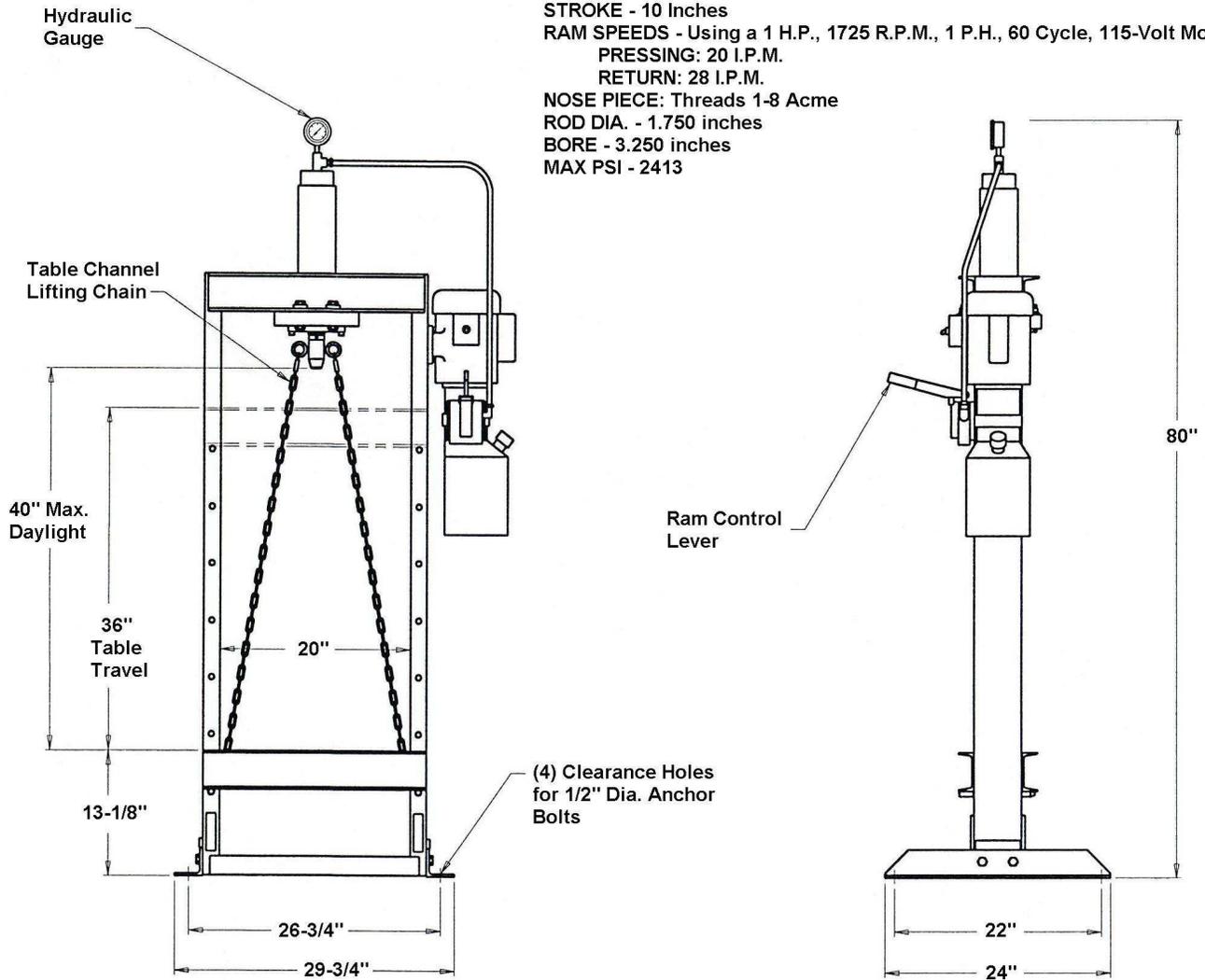


25 ton Workhead
 4-1/2" Dia. Bore
 3" Dia. Rod
 10-1/4" Actual Stroke
 10" Rated Stroke
 Total Wt. = 127#

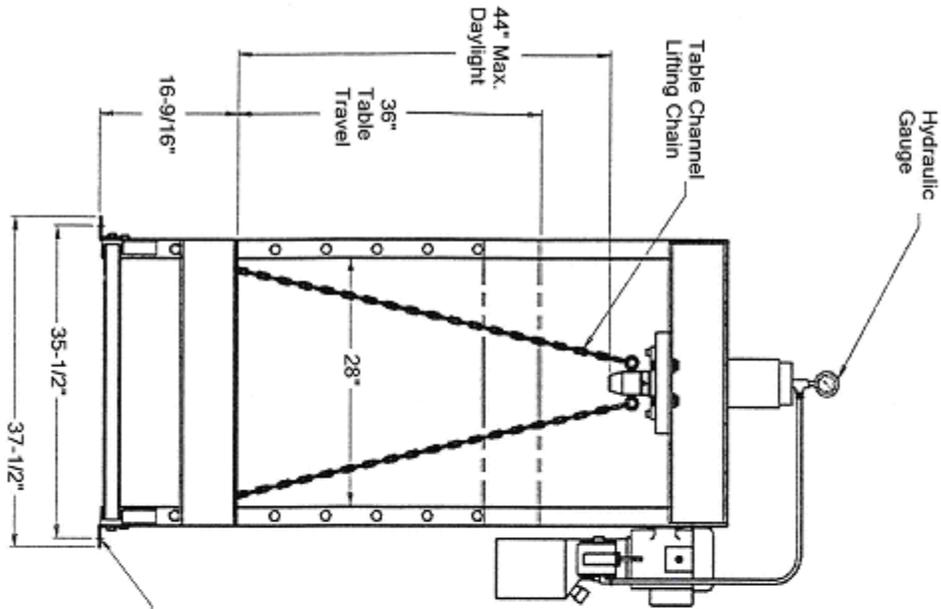
ITEM	DESCRIPTION	PART NO.
A	Piston	86463
B	Cylinder Flange	86462
C	Cylinder	86461
D	Socket Head Cap Screw	43471
E	O-Ring	79881
F	Seal	79880
G	Wear Ring	78486
H	Wear Ring	79840
J	O-Ring	79882
Complete Workhead Assembly		716640
Cylinder Repair Kit (Includes items E, F, G, H, J)		716698

FORCE 10DA - Specifications

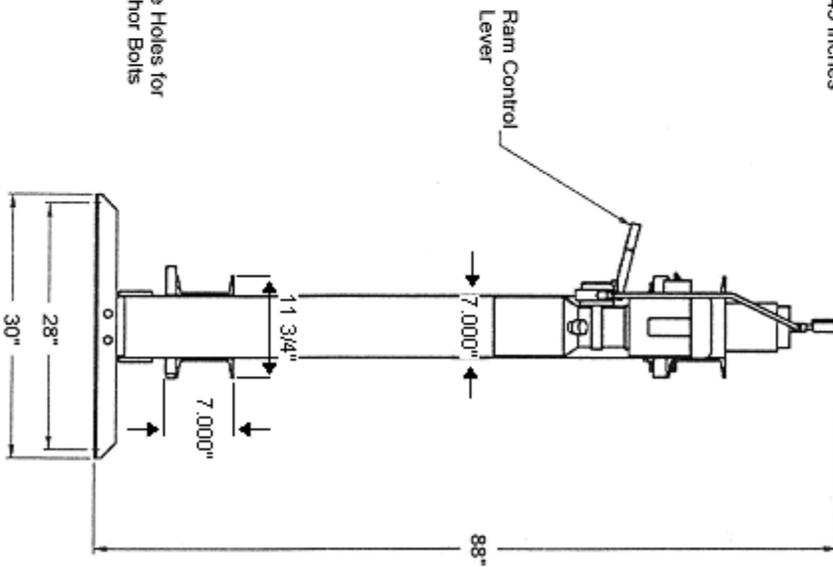
CAPACITY - PRESSING: 10-Tons
STROKE - 10 Inches
RAM SPEEDS - Using a 1 H.P., 1725 R.P.M., 1 P.H., 60 Cycle, 115-Volt Moto
PRESSING: 20 I.P.M.
RETURN: 28 I.P.M.
NOSE PIECE: Threads 1-8 Acme
ROD DIA. - 1.750 inches
BORE - 3.250 inches
MAX PSI - 2413



FORCE 25DA - Specifications



CAPACITY - PRESSING: 25-Tons
 STROKE - 10 inches
 RAM SPEEDS - Using a 1 H.P., 3450 R.P.M., 1 P.H., 60 Cycle, 115-Volt Motor
 PRESSING: 20 I.P.M.
 RETURN: 20 I.P.M.
 NOSE PIECE: Threads 1-1/2 - 6 ACME
 ROD DIA. - 2.750 inches
 BORE - 4.400 inches
 MAX PSI - 3145 inches



Safety



This is the safety alert symbol; follow recommended precautions and safe operating practices. When you see this symbol on your press be alert to the potential for personal injury.

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.

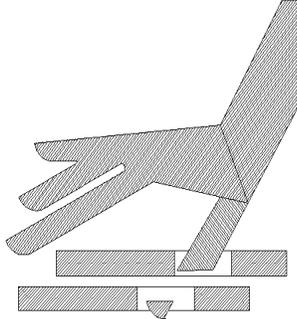
Part No: 76462

SAFETY INSTRUCTIONS
LOCKOUT PROCEDURE <ol style="list-style-type: none">1. Announce lockout to other employees.2. Turn power off at main panel.3. Lockout power in off position.4. Put key in pocket.5. Clear machine of all personnel.6. Test lockout by hitting run button.7. Block, chain or release stored energy sources.8. Clear machine of personnel before restarting machine.

⚠ DANGER

High voltage. Can cause severe injury or death. Service by authorized personnel only. Use lockout.

Part No: 84395

⚠ WARNING

Keep fingers out of pin holes.

Part No: 84399

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

Please contact factory for current prices.

⚠ CAUTION
ALL pins must be inserted before applying any pressure. Read instructions.

Part No: 84487



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