Set up and Operation of the Dake Power Hammer

Once you remove the power hammer from the packaging you will need to install the shaping dies to be used and the wheels.

WARNING !!!
Unplug the power hammer from the electrical source before changing the dies.

A. Remove the 6 bolts from the adjustable bottom sleeve.
B. Remove the adjustable bottom sleeve from the side plates.
C. Insert die holder with the desired die attached into the slider. Make sure the die holder is bottomed into the slider.
D. Tighten the two hex socket set screws to secure the upper die holder.
Set up and Operation of the Dake Power Hammer

E. Rotate the adjusting screw handle to move the bottom adjustment rod down.

F. Insert the die holder with the desired die attached into the adjustable bottom sleeve. Make sure the die holder is bottomed into the adjustable bottom sleeve.

G. Snug up the two hex socket set screws on the adjustable bottom sleeve to hold the die holder firmly but still allow it to move up by turning the adjusting screw handle.
Set up and Operation of the Dake Power Hammer

I. Insert adjustable bottom sleeve (B) and attach six bolts through the side plates and into the adjustable bottom sleeve.
Set up and Operation of the Dake Power Hammer

J. Make sure the lock screw on the adjustment bottom sleeve is loose.

K. Rotate adjusting screw handle to move the lower die to the upper die.

**WARNING !!!!
**For safe operation and possible die damage always adjust the gap between the upper die half and the work piece to a minimum of \( \frac{1}{4} \)” before starting motor.

\( \frac{1}{4} \)” minimum gap before starting motor
Set up and Operation of the Dake Power Hammer

L. Check the two set screws on the die holder to see if they are tight. These hold the lower die firmly in place.

M. The upper and lower dies need to be lined up. If they do not line up, loosen the bolts holding the dies to the die holders and align the dies. Don’t forget to retighten these bolts.
Set up and Operation of the Dake Power Hammer

**WARNING !!!**
Before turning on power to your Dake power hammer be sure to review all safety stickers and warnings.

N. With the motor turned on, the upper die holder will begin to oscillate. Rotate the adjusting screw handle to move the lower die up until just before it touches the upper die. This is a good initial setting to try shaping with.

O. With the die gap set to your desired setting, tighten the lock screw on the adjustable bottom sleeve to lock in the gap setting. Repeat steps N and O for any future gap adjustments, up or down.
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<tr>
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<th>Part description</th>
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<td>Caster Swivel, Total Locking 300 lbs.</td>
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You are now ready to start shaping metal

Everyone has their own technique when it comes to shaping and you will need to find your own. So, practice, think, practice and think some more before practicing again. We have found that like forming by hand, it is easier to get the desired shape using the Dake power hammer by using several steps to “sneak up” on the final shape, versus trying to get the shape in one step.

A good source of information on how to use a power hammer type machine like this, is reading any of the several books on sheet metal shaping currently available.

Have fun and be safe!!!!!

Dake

Maintenance

You need to maintain your Dake power hammer as you would any other piece of shop equipment. More use requires more maintenance. This should include, but not limited to checking and greasing bearings and bushings regularly. Check for any loose components, lines and connections and replace as needed.
Safety stickers that are located on the Dake power Hammer

WARNING!!!!
Review all safety stickers before operating this machine.

Part number 301889
Part number 85425
Part number 300168
Part number 84395

Part number 76462