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.
Dimensional drawing of 50 ton press
MACHINE SPECIFICATIONS

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tons</td>
<td>50</td>
</tr>
<tr>
<td>Stroke</td>
<td>16 inches</td>
</tr>
<tr>
<td>Pressing speed</td>
<td>11 Inches per minute</td>
</tr>
<tr>
<td>Return speed</td>
<td>20 Inches per minute</td>
</tr>
<tr>
<td>Daylight</td>
<td>41 3/4</td>
</tr>
<tr>
<td>Table travel</td>
<td>30 Inches</td>
</tr>
<tr>
<td>Between channels</td>
<td>44 Inches</td>
</tr>
<tr>
<td>Motor</td>
<td>2 horse power / 60 cycle / 115/220 Volt</td>
</tr>
<tr>
<td>Weight</td>
<td>1200 lbs.</td>
</tr>
<tr>
<td>Approx. height</td>
<td>7' 10&quot; / 94&quot;</td>
</tr>
</tbody>
</table>

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.

SAFETY INSTRUCTIONS

LOCKOUT PROCEDURE
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 personnel.
6. Test lockout by hitting run button.
7. Block, chain or release stored energy sources.
8. Clear machine of personnel before restarting machine.

Part Number 76462

Part Number 84395

Part Number 84399

Part Number 84487

Part Number 300168

11/25/2014
Below is a drawing showing the location of all safety labels on this press.
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

A Port

Cylinder

B Port

Hydraulic hose connects here and to the A port.

Hydraulic hose connects here and to the B port.

Joy stick valve mounts here. It only fits one way.

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

11/25/2014
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.

11/25/2014
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.
## FORCE 50 DA HYDRAULIC PRESS

### PARTS LIST

<table>
<thead>
<tr>
<th>Item #</th>
<th>Qty</th>
<th>Description</th>
<th>Part #</th>
<th>Item #</th>
<th>Qty</th>
<th>Description</th>
<th>Part #</th>
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<tr>
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<td>1</td>
<td>Frame 50 Ton</td>
<td>706943</td>
<td>24</td>
<td>4</td>
<td>Hex Cap Screw 5/16&quot;-18 NCx1/2&quot;lg</td>
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<td>4</td>
<td>Hex Cap Screw 1/2&quot;-13x3 1/4&quot; lg</td>
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<td>T-Ring Seal</td>
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</tr>
</tbody>
</table>
MACH'G. TOLERANCE UNLESS SPECIFIED

FRACTIONAL: ± 0.010
DECIMAL: ± 0.002
ANGLE: ± 1/8"

BREAK EDGES
REMOVE BURRS

DATE   SYM.   CHANGES           BY
10/01/08   A   SW. LAYOUT REV. & NOTES ADDED   HDD
12/18/14   C   SWAPPED T5 & T8 AND CCW & CW - PER B. PACE   SK

UNDERSCORED DIMENSIONS NOT TO SCALE

---

MOTOR LEADS

LOW VOLTAGE

T1  T3  T5  T2  T4  T8

L1  L2

SWITCH

ON  OFF

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

---

MOTOR LEADS

HIGH VOLTAGE

T1  T2  T3  T5  T4  T8

L1  L2

SWITCH

ON  OFF

---

DAKE
GRAND HAVEN, MICH.

POWER IN

110 VOLTS
1 PHASE
50/60 HZ
26.2 AMP

L1(HOT)

SWITCH TOP

L2(N)

GROUND SCREW

---

POWER IN

208 - 230 V
1 PHASE
50/60 HZ
13.1 AMP

L1(HOT)

SWITCH TOP

L2(N)

GROUND SCREW

---

ELECTRICAL CONTROL / WIRING
SEQUENCE OF OPERATION

IDLE - HANDLE NEUTRAL, PRESSURE IN CYLINDER LOCKS.
PRESSING - HANDLE POS. #1, CLOSE AND/OR THROTTLE FOR RAM MOVEMENT AND/OR PRESSURE.
RETURN - HANDLE POS. #2, OPEN AND/OR THROTTLE FOR RAM MOVEMENT AND/OR DECOMPRESSION.

THROTTLING ACTION

RANGE: 400 - 6000 P.S.I.
SET - 3550 PSI

H.P. 3450 R.P.M.

1.8 GPM

3 GALLON RESERVOIR
RECOMMENDED OIL VISCOSITY 150-225 SSU @ 100° F.

4 2 HOSE OSR165F6FF54" DAKE
3 1 GAUGE - 50 TON CDS-1P-350-A DAKE
2 1 WORKHEAD - 50 TON 716647 DAKE
1 1 POWER UNIT 301856 DAKE

COMPONENT LIST:

DAKE

HYDRAULIC DIAGRAM

11/25/2014