



## FORCE 50 DA HYDRAULIC PRESS INSTRUCTIONS AND PARTS LIST

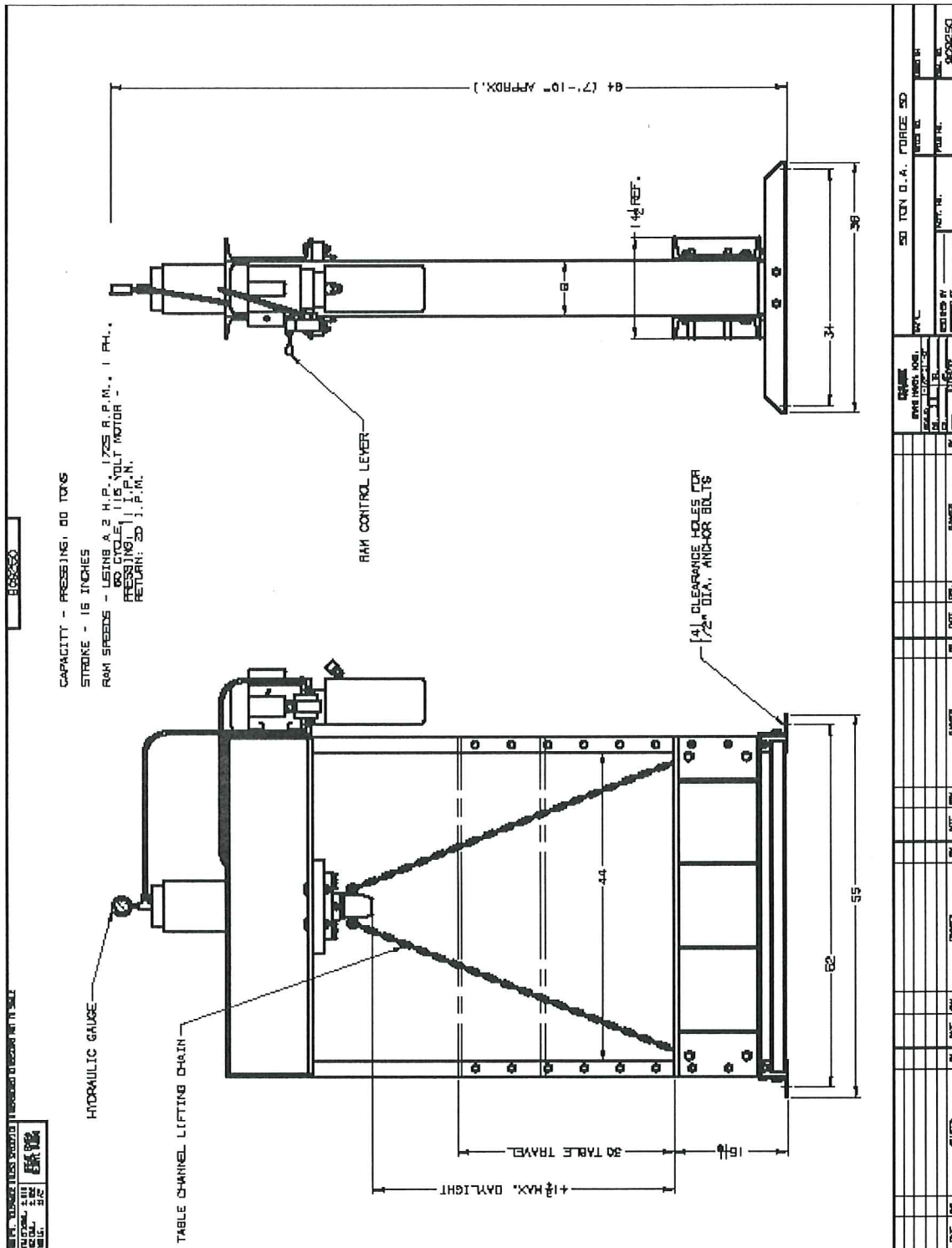


### Ordering information

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.

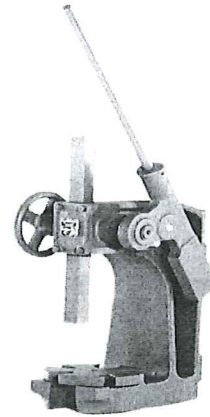
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Grand Haven, MI 49417  
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### Dimensional drawing of 50 ton press



## 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.

**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 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.

Part Number 76462

**⚠ DANGER**

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

**⚠ PELIGRO ⚠**

Alta tensión.  
Puede provocar lesiones severas o la muerte.  
Para reparaciones, emplee personal autorizado solamente.  
Use cierre eléctrico.

Part Number 84395

**⚠ WARNING**

Keep fingers out of pin holes.

**⚠ PELIGRO ATENCION ⚠**

No ponga los dedos en los agujeritos.

Part Number 84399

**⚠ CAUTION**

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

**⚠ CUIDADO ⚠**

Todos los escálamos tienen que ser insertados ante de aplicar la presión.  
Lea las instrucciones.

Part Number 84487

**⚠ WARNING**

Establish solid footing to prevent falls.

Keep hand away from point of operation.  
Read instructions.

Guard workpiece to prevent projectiles from reaching operator.  
Wear eye protection.

Part Number 300168



**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.

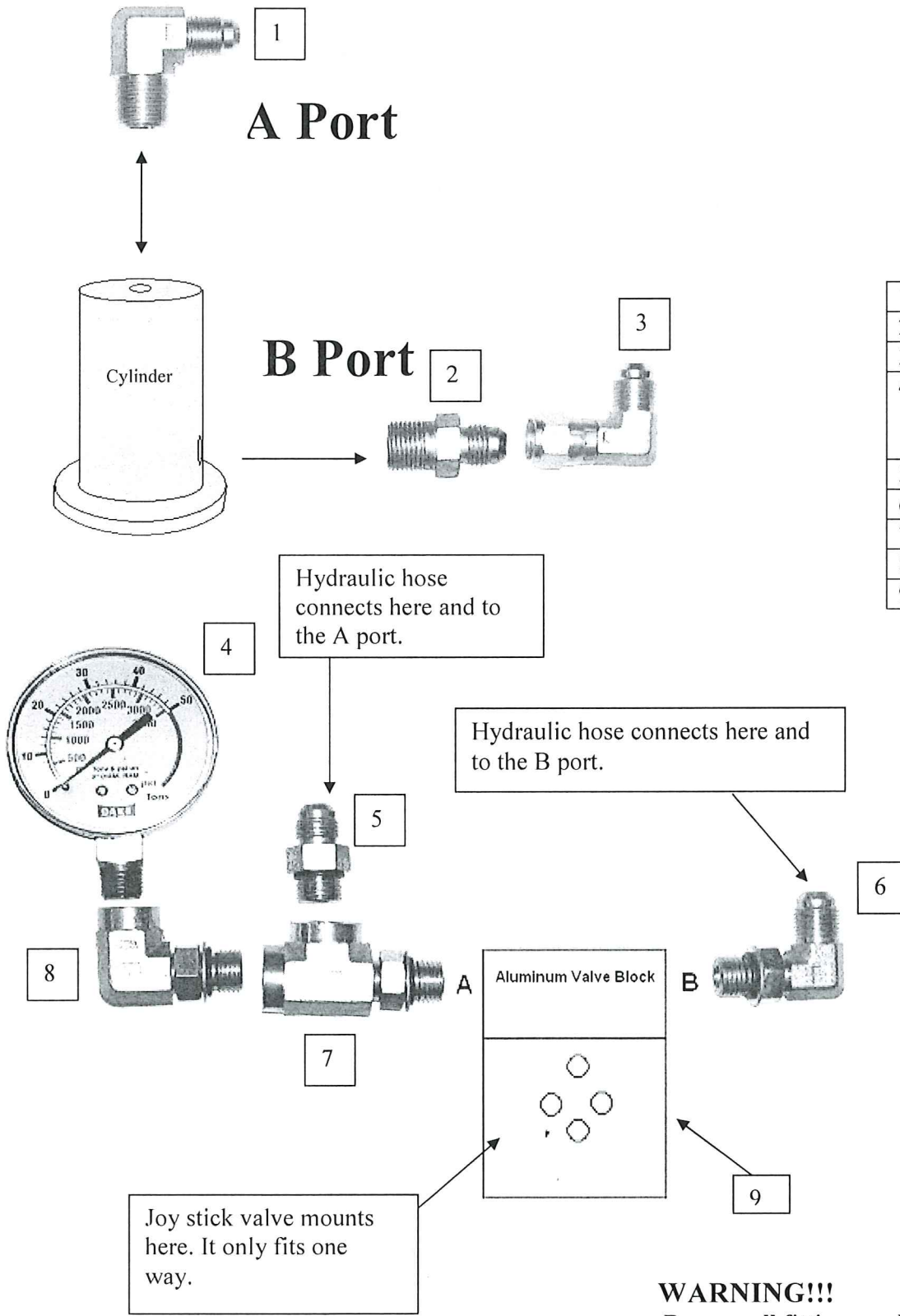
**NOTE: FOR EASE OF ASSEMBLY LEAVE THE PRESS FRAME MOUNTED ON THE SHIPPING SKID**

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
9	302224

## 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!!!!**

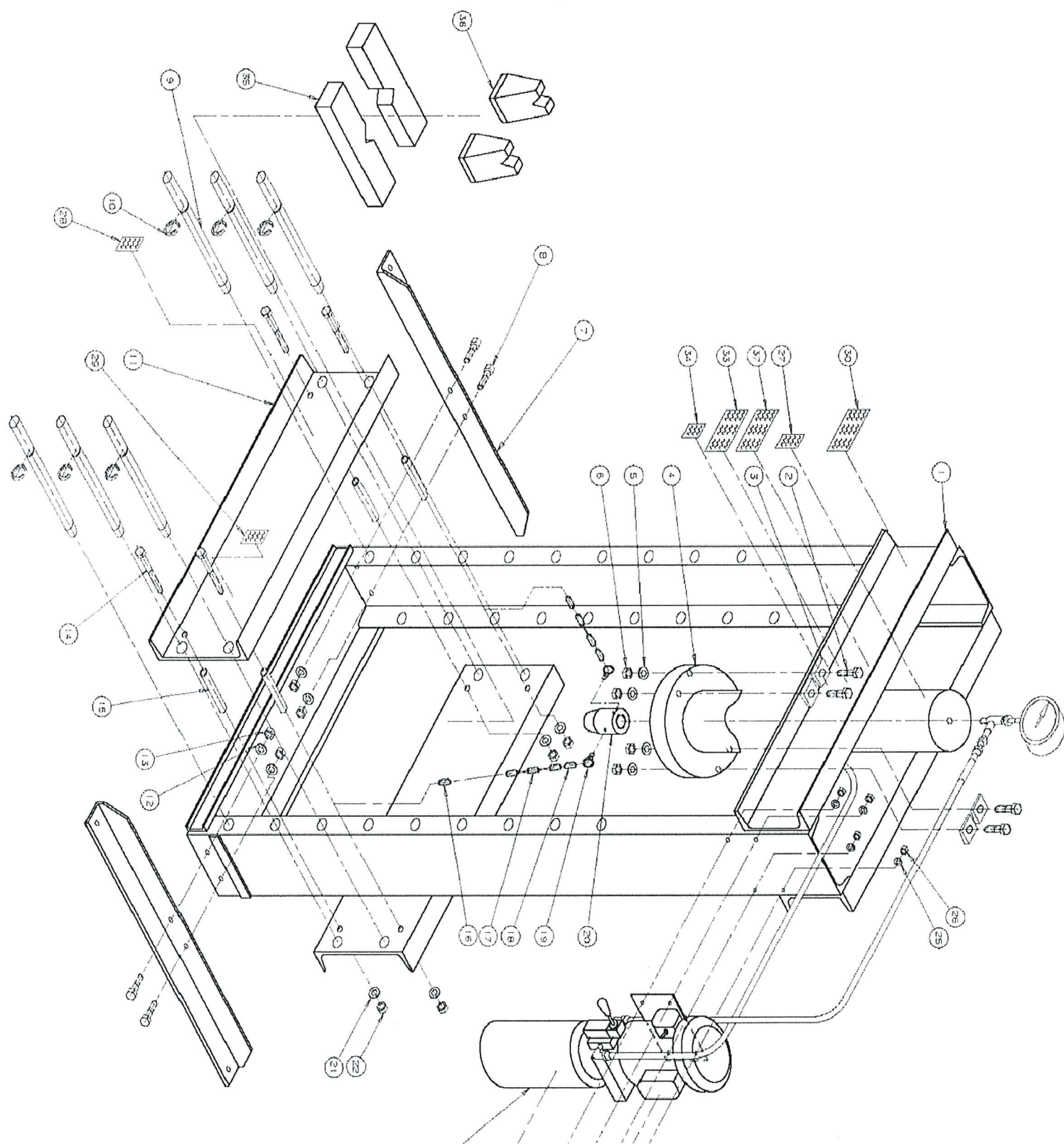
**Only use Hydraulic oil in this machine DTE 24 hydraulic oil is recommended.**

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

# FORCE 50 DA HYDRAULIC PRESS

## PARTS LIST

Item #	Qty	Description	Part #		Item #	Qty.	Description	Part #
1	1	Frame 50 Ton	706943		24	4	Hex Cap Screw 5/16"-18 NCx1/2"lg	43313
2	4	Hex Cap Screw 1/2"-13x3 1/4" lg	43356		25	4	Lock Washer 5/16"	43644
3	4	Channel Washer 1/2"	43657		26	4	Hex Nut 5/16"-18	43911
4	1	Work head Assembly	716547				Hose Kit / Valve	301856KIT
5	4	Lock Washer 1/2"	43647		28	1	Label All pins warning	84487
6	4	Hex Nut 1/2"-13	43916		29	1	Label Fingers out of	84399
7	2	Base Angle	566		30	1	Label Ganged warning	300168
8	4	Hex Cap Screw 1/2"-13NC X 1 1/2" lg	43349		31	1	Label Lockout procedure	76462
9	6	Table Pin	569		32	1	Label Voltage danger	84395
10	6	Retaining Ring	43980		33	1		
11	2	Table Channel	706945		34	1	Label Made in USA	76936
12	4	Lock Washer 1/2"	43647		35	2	Table Plate	702
13	4	Hex Nut 1/2"-13	43916		36	2	V-Block	336
14	4	5/8-11 x 10 1/2" long	79983		37	1	Dake Name Plate	81002
15	4	Table Spacer	86488		A	1	Piston	87135
16	2	Shackle	301884		B	1	Piston guide	87136
17	2	Chain	301881		C	1	Cylinder	87134
18	4	Spring Snap	301882		D	1	Soc. Hd. Cap screw	43485
19	2	Eye Bolt	301880		E	1	Seal	37044
20	1	Nose Piece	87138		F	1	T-Ring	37048
21	4	Lock Washer 5/8"	43648		G	1	Wear Ring	37045
22	4	Hex Nut 5/8"x11	43917		H	1	Wear Ring	37046
23	1	Hydraulic Power Unit	301856PU		J	1	T-Ring Seal	17942

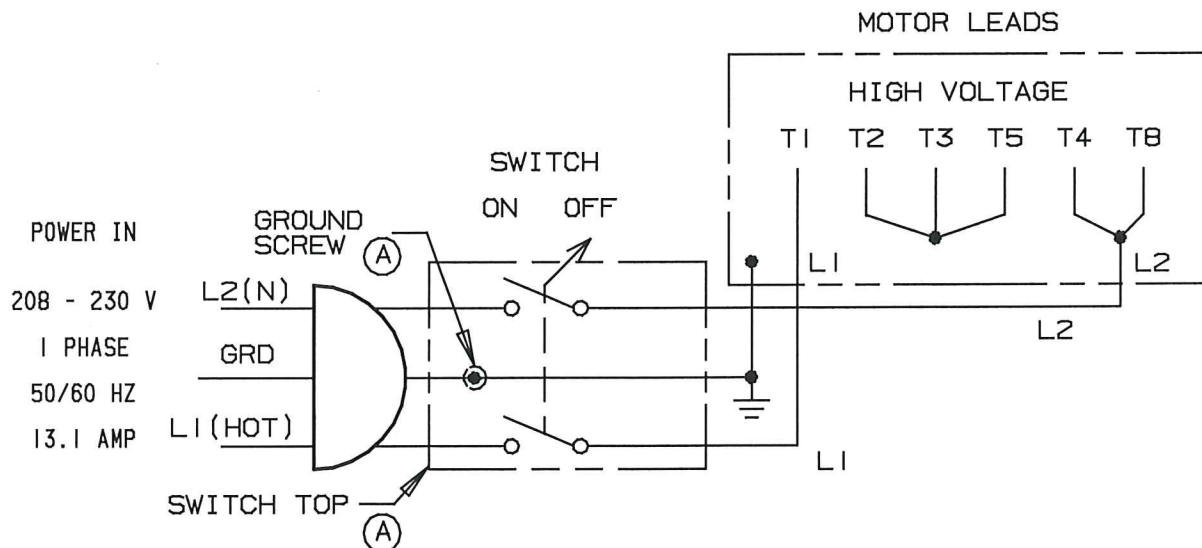
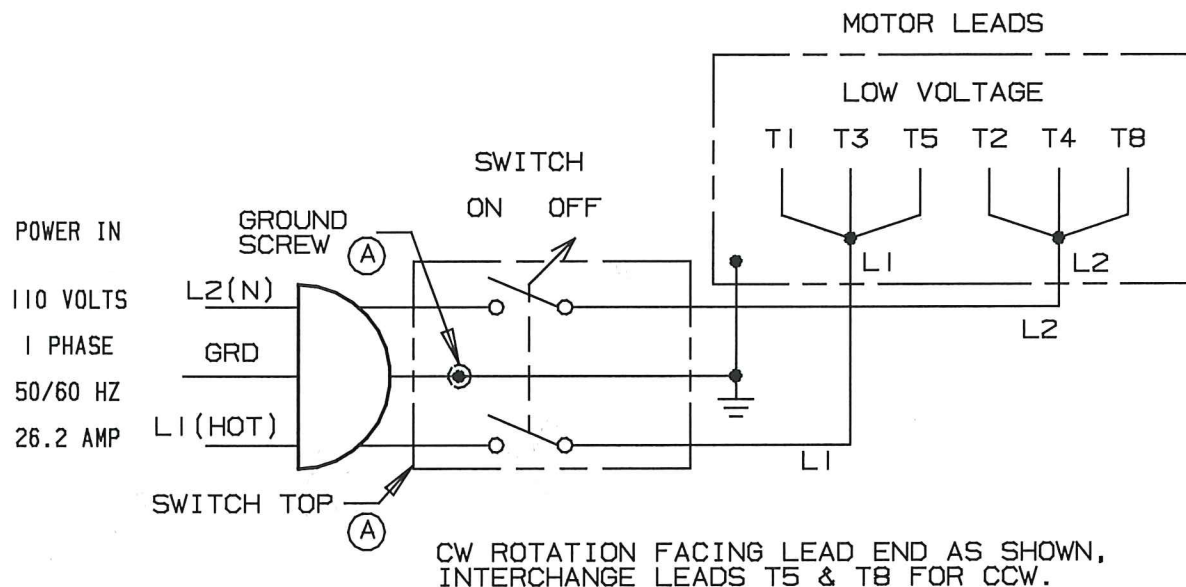




MACH'G. TOLERANCE UNLESS SPECIFIED		DATE	SYM.	CHANGES	BY
FRACTIONAL: ±.010	BREAK EDGES REMOVE BURRS	10/01/08	A	SW. LAYOUT REV. & NOTES ADDED	HDD
DECIMAL: ±.002		12/18/14		SWAPPED T5 & T8 AND CCW & CW - PER B. PACE	SK
ANGLE: ±1/2°					
UNDERScoreD DIMENSIONS NOT TO SCALE					

87

87175



DAKE		ELECTRICAL CONTROL / WIRING			
GRAND HAVEN, MICH.		MAT'L.		STOCK NO.	USED ON
SCALE: NA					909250
DR. HDD	TR.	DESIGNED BY		PATT. NO.	FILE NO.
CH.	AP.	APPROVED BY			DRW. NO.
DATE: 1/23/08 11:02A					87175

