

## ENGINEERING DATA

### PRESSURE DROP

Dake 26-series 4-way valve, 5-series elec-draulic, and 6-series air-draulic - with intregal and release valve.

Approx. one ton per minute for 1st five minutes  
Approx. half ton per minute for next ten minutes  
Approx. quarter ton per minute for next fifteen minutes  
Pressure drop during holding cycle.

Note: This is a conservative rating based on tests of two valve in two different presses (actual tests are approx. one half of above figures)

Shop Instruction -

1/2 ton/min - First 5 min.  
1/4 ton/min - Next 10 min.  
1/8 ton/min - Next 15 min.

H-Frame hand operated presses (no 4-way valve)

Less than one half of the above

Standard Laboratory Presses - Hand operated - approx. 4,000 lbs. in 5 minutes.

PRESSURE VARIATION - 3/4" Dake relief valve Model #36-543 with 4 gallon/min pump. The pressure variation is approximately 2% of full scale range. Oil cooler should be used unless idle time is much greater than the time oil is passing through relief valve.

### DRAWING SPEEDS (MAX.)

Steel	55 ft.per min.
Brass	150 ft.per min.
Aluminum	100 ft.per min.
Stainless	35 ft.per min.
Zinc	75 ft.per min.
Chrome Nickel	20 ft.per min.

TIME REQUIRED - to raise to full tonnage 5-050 press requires .07 min. or 4.2 sec. to raise from zero to full tonnage.