



10 TON UTILITY PRESS

OWNERS MANUAL

BENCH AND FLOOR MODEL PRESSES

10 Ton single acting manual hydraulic press

FOR YOUR OWN SAFETY AND
OPTIMUM OPERATION READ
INSTRUCTION MANUAL BEFORE
OPERATING PRESS
RETAIN THIS MANUAL FOR
FURTHER REFERENCE.



10 TON BENCH PRESS

972200

10 TON FLOOR PRESS

#972210

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SPECIFICATIONS		
Machine Specifications:	10 TON UTILITY BENCH	10 TON UTILITY FLOOR
Press Type	Manual 10 ton Bench	Manual 10 ton Floor
Cylinder Type	Single Acting	Single Acting
Max. Press Capacity	10 ton	10 ton
	2	

Ram Diameter	1 ½"	1 ½"
Ram Stroke	6"	6"
Head Travel	Left / Right of center	Left / Right of center
Travel Per Stroke	1/8" approx.	1/8" approx.
Width between uprights	16 ¾"	16 ¾"
Width between channels	3"	3"
Max. Ram to Table	16"	38"
Overall Height	36"	60"
Weight	132 lbs.	149 lbs.

1. INSTALLATION PLACEMENT:

<p>INSTALLATION OF PRESS <u>PRESS PLACEMENT SELECTION</u></p>	 CAUTION
<ol style="list-style-type: none"> 1. Location of press should be in a well lit area that will not interfere with other machines or operations. 2. Carefully unbox machine components from shipping carton. Inspect all packing as not to throw out any parts or manuals. 3. When transporting the machine please use caution. If using a sling have someone steady the machine while transporting it. 4. Install your press on a sturdy level floor surface, or work bench. The machine <u>must</u> be anchored to the floor or workbench securely. 5. After installing the press, use the kerosene or degreasing product to clean off the anti-rust oil which was applied at the factory. Then <i>wipe machined surfaces (such as ram) with a light coating of</i> 	

- **SAFETY POINTS**

BEFORE USE, ALL SAFETY POINTS MUST BE READ AND UNDERSTOOD!

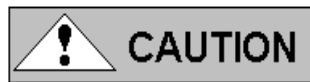
Before the PRESS is used, the instruction manual with this machine must be read and understood. This manual offers safe operation instructions. Offered below are safety instructions designed for the press and general safety instructions that apply to most machinery.



Operation of the press incorrectly, or in a dangerous fashion can result in serious injury or death.



Operation of the press incorrectly, or in a dangerous fashion can result in damage to machine or it's components and to the cutting tool.



Instructions for safe press use.

Intend use :

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. Caution is required when operating the press because it can be dangerous due to the high pressures exerted from the ram. Operation hazards such as pinching, ejection of parts are always present. Please think about the safety warnings in the instruction manual before operating the machine.

Misuse of this machine will void warranty and cause unsafe working conditions.

2. FOR SAFE OPERATION

For your own safety read the instruction manual before operating your single acting hydraulic press.



1. Keep hands out of point of operation.
2. Never hold part while pressing.
3. Always wear the eye protection.
4. Clamp work piece or brace when pressing.
5. Never place fingers in pin holes.

3. WARNING LABELS:

READ AND UNDERSTAND THESE WARNING LABELS PLACED ON THIS MACHINE BEFORE OPERATING. MAKE SURE ALL PERSONS IN THE AREA OF THE PRESS ARE AWARE OF THESE WARNINGS.

UNDER NO CIRCUMSTANCES SHOULD THESE LABELS BE REMOVED!



Establish solid footing
To prevent falls

Keep hands away
from point of
operation

Guard workpiece to
prevent projectiles
from reaching operator

WEAR EYE PROTECTION



All pins must be inserted before
applying any pressure

Keep finger out of pin holes

4. ASSEMBLY INSTRUCTIONS:

FOR DAKE MODEL UTILITY 10 TON BENCH AND FLOOR MODEL PRESSES.

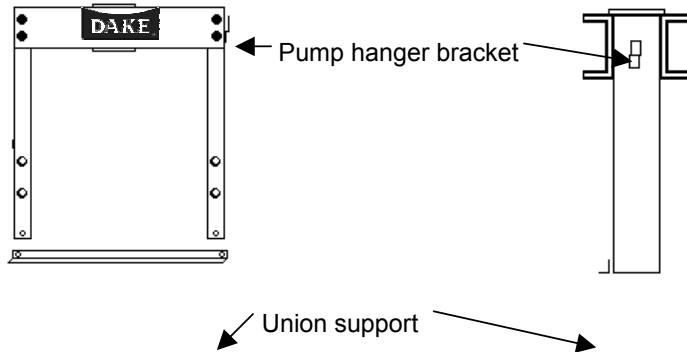
Your new Dake Press has been packaged in a manner to prevent damage to any critical components, some assembly will be required. All parts in the accessory box are critical to the function of your press. Please review the list of materials to insure you have all components required. Please refer to the parts list and exploded diagrams on pages 10-13 of this owners manual.

Your press head frame, uprights and head traverse ram plate has been pre-assembled at the factory. You will be required to install the worktable, ram, pumping unit and base angles. Follow the simple instructions below for quick assembly. Assembly may be made easier if the frame is laid down flat with the front facing upward.

STEP 1: Bench model:

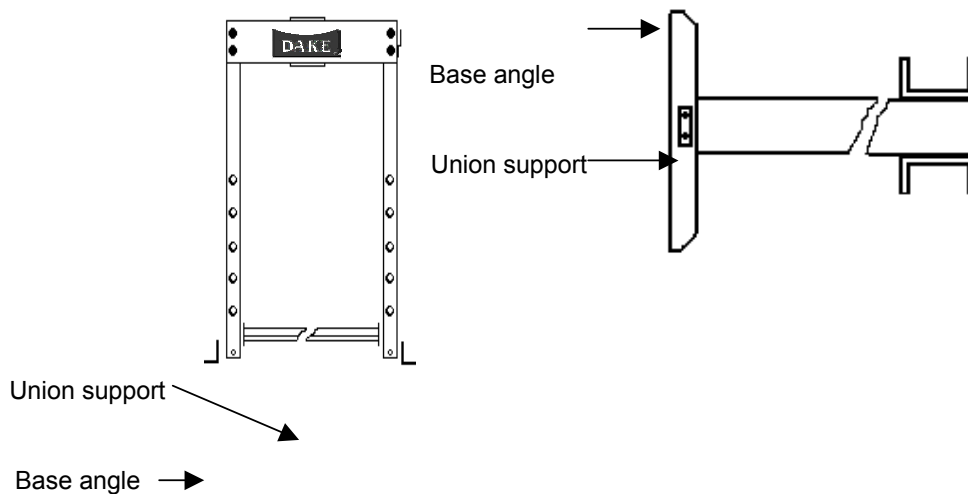
Using (2) M8 x 20mm bolts, nuts and washers install the union support to the bottom from of the upright channels. (Pump hanger bracket on the right hand side of the upright.) Angle is to face outward see drawing below on right.

Hand tighten.



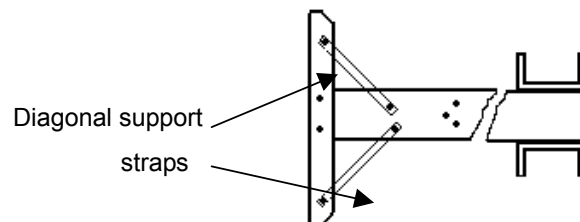
STEP 1. Floor model:

Install the union support to the inside of the upright channels and base angles, using the 4 of the M8 x 25mm bolts, nuts and washers provided. Place union support in-between the channels, and install the 2 base angles to the frame through the union support and install nuts. Base angles face outward (See drawing below) Hand tighten.



STEP 2. Floor model: (Bench model skip this step)

Install the diagonal support straps. Using 4 M8 x 25mm bolts, nuts and washers. Install the support straps to the inside of the base angles then to the frame as shown. Finger tighten.



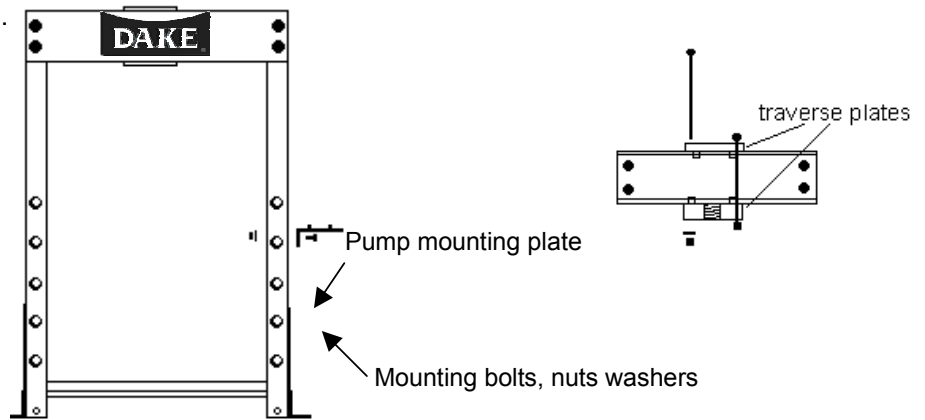
STEP 3:

Carefully stand the unit upright. Making sure all components are square to each other, tighten all nuts and bolts securely.

STEP 4: Floor model: (Bench model skip this step)

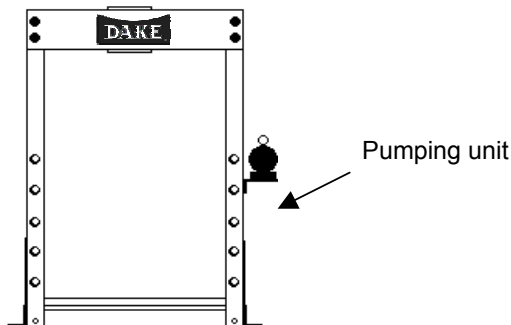
Install pump mounting plate on the side of the upright channel using the 3 M10 x 25mm bolts, nuts and washers.

Mount Head ram traverse plates. The side with two bars welded to them go inside the frame, with the thick threaded plate on the bottom. Using two 10mm x 120 mm bolts, washers and nuts snug only enough To allow plate to travel



STEP 5: Floor model: (Bench model skip this step)

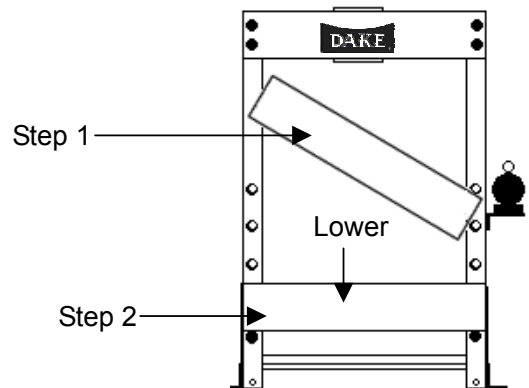
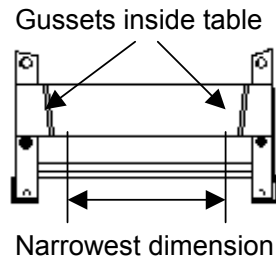
Install the pumping unit to the mounting plate using 2 M10 x 25mm bolts, nuts and washers. Make sure pump is centered on this mounting plate.



STEP 6:

With press standing upright and all bolts tightened install the worktable. Insert two table pins in the two lowest holes. Take the worktable and tilt it at a sharp angle and insert it in the uprights. (NOTE: The gussets welded to the table are at slight angles. The narrowest dimension of these gussets go down. See drawing) (Step 1) Once worktable is in the

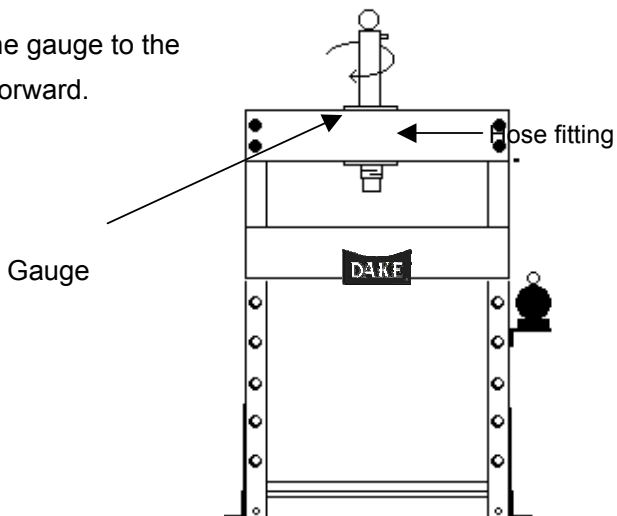
uprights turn it level and lower down and set it on the table pins. (Step 2) Take care when doing this, a helper would be advised.



STEP 7:

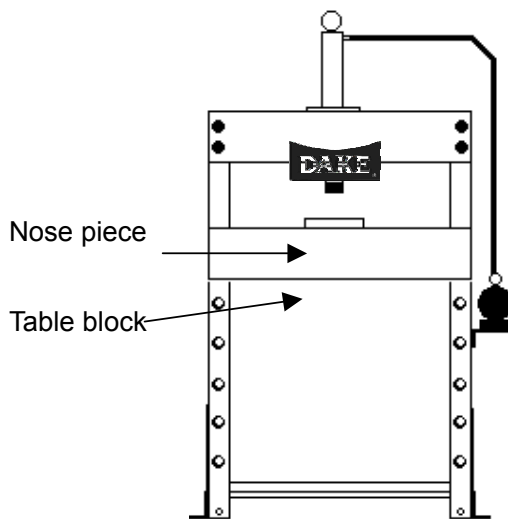
Locate the cylinder and remove the plastic protective cap on the end of the ram. (If applicable) Carefully screw the cylinder from the top into the head traverse ram plate. Screw this in as tight as possible while keeping the cylinders hydraulic hose fitting facing to the left. (Cylinder may not be totally tight while keeping the fitting facing this way, but it will not effect the presses operation.)

Using Teflon tape install the gauge to the top of the cylinder facing forward.



STEP 8:

On the bench model hang the pumping unit in its holder bracket on the side of the frame. Remove the plastic protective cap from the end of the hydraulic hose. Screw the hydraulic hose onto the cylinder hose fitting. The fitting has a knurled collar that you can tighten by hand. (Do not use a wrench because damage may occur to the fitting) The hose has a check valve that prevents oil from escaping so if hose is ever removed air will not get in the system. Install a nose piece and use table blocks when operating this machine.



NOTE:

System is filled with oil and may take a few pumps to fill all lines. Close the pump valve and pump to check for piston action, and for leaks. If air appears to be in the system, open the valve handle and pump vigorously about a dozen times. Close valve and try again.

STEP 9:

Chose location placement as described on page 2. Mount the press securely. You are now ready to use the press.

5. OPERATION (PROCEDURE)

Always use the supplied nose pieces. The flat nose piece will be good for most pressing and flattening operations. The step style nose piece will work well for pressing bearing, bushing and parts that have a hole that the nose piece will fit into. This nose piece will help support or hold the piece during pressing operations.

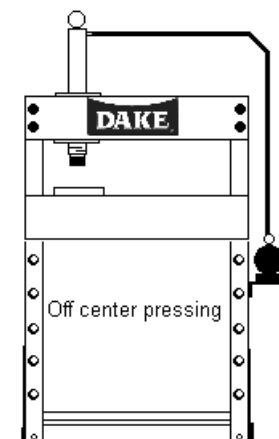
There are two table plates that should always be used as a backing plate during pressing operations. You will find notches in these table plates to allow you to use the press as a straightening press for axles, shafts, etc and most round stock.



When using your press always use the highest table setting to minimize the stroke distance of the ram. **Note:** Only use supplied table pins. Do not weld or pin table. Once a part is put in the press and is clamped or braced securely, close the pumping unit release valve handle. (Clockwise). Pump the handle to lower the ram. Pump until pressing operation is completed. If you need to maintain pressure leave the valve on the pumping unit closed. When operation is complete, turn the valve counter-clockwise to release pressure and raise the ram. Once the ram has been raise just above the work close valve again and repeat operation on the next part. There is no need to raise the ram all the way to the top each time. If pressing application requires a certain tonnage, press until the gauge reads the appropriate tonnage then stop. Release pressure and repeat operation.

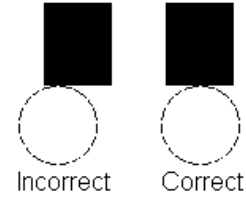
NOTE: Never pump the ram down fully and dead head the ram in the cylinder. Only build pressure when using the table plates or a part is being pressed. Failure to do this may cause ram seal damage and leaking.

If the application requires off center pressing, loosen the head ram traverse plate bolts and slide head left or right to the area where pressing is required. You may now proceed with the operation. When head is returned to the center position snug these bolts up to prevent unexpected movement.




Always make sure you are pressing with the whole ram. Center ram over the work, do not press with only the edge

of the nose piece. This can cause injury by ejecting the part, or damage to the ram.



6. MAINTENANCE OF MACHINE

MAINTENANCE!	 CAUTION
<ol style="list-style-type: none"> 1. On a regular basis wipe the enter press. Keep ram free from debris and abrasive materials (Frequency depends on environment the machine is in) 2. A light oil applied to the ram will help to keep the surface clean. 3. If the hydraulic hose or table pins are worn or cut, or damaged in any way, have it replaced immediately. 4. If oil is ever needed, remove plug from the top of the pumping unit and add hydraulic jack oil. Bleed the system by pumping the handle repeatedly about a dozen time with the relief valve open. Close valve and check that air has been bled. 	

7. TROUBLE SHOOTING:

Problem	Solution
Oil leaking around ram.	Put ram under full pressure for 24 hours. If problem continues contact Dake
Ram is jerky or sluggish	With release valve open repeatedly pump the handle to bleed air from lines.

Ram does not return fully Open and close release valve several times. If continues contact Dake.

Pump will not pump Make sure valve is fully closed. Contact Dake.

Leaking by gauge Place Teflon tape to threads and reinstall.

Leaking by hoses Check all fitting, make sure they are tight. Look for hole or abrasions.

Will not reach max. tonnage Check that the valve is closed fully. Bleed system, Contact Dake.

Will not hold pressure Some bleed off will occur over time. Check valve is closed fully.

8. PARTS LIST

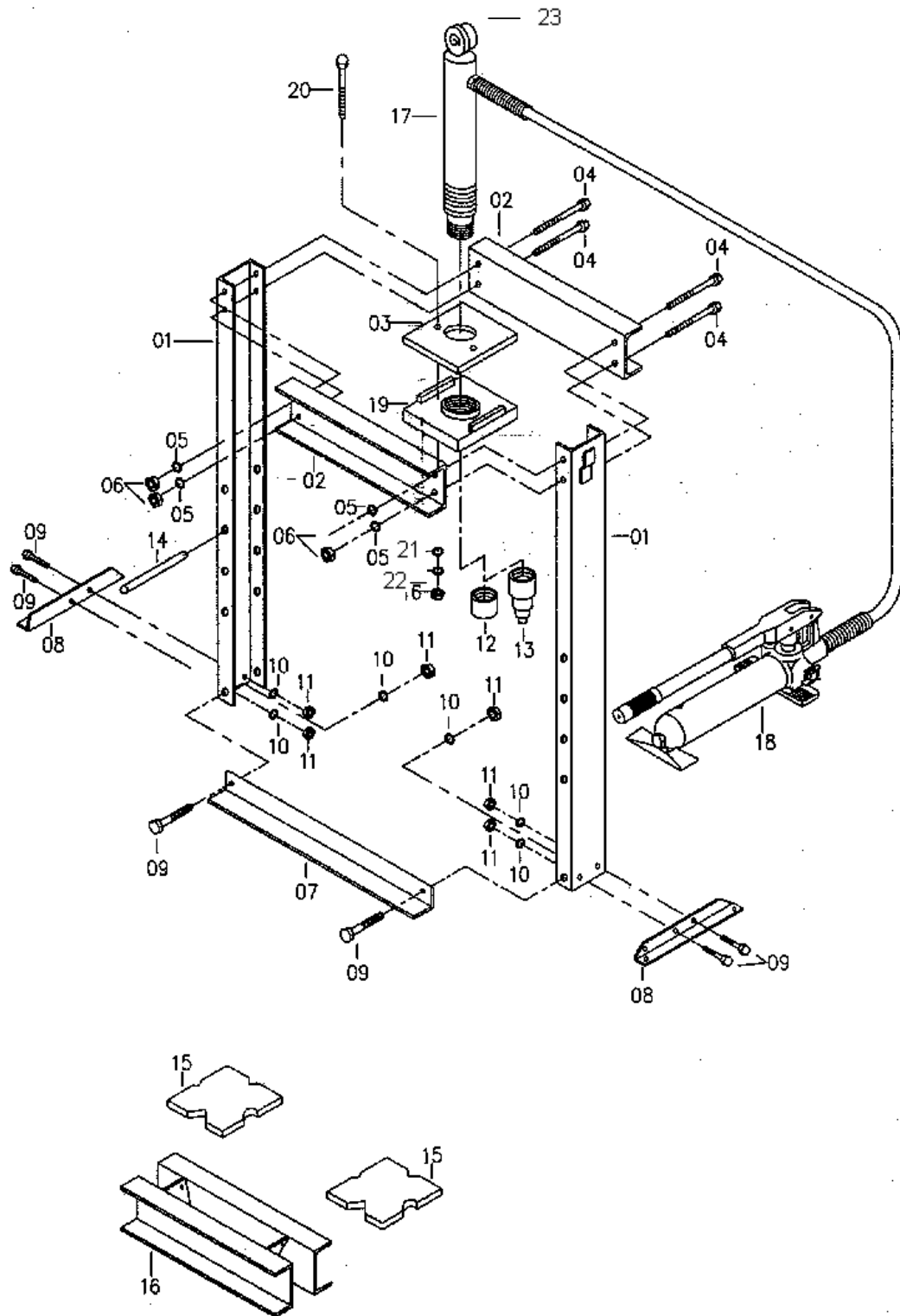
10 TON BENCH UTILITY PRESS PARTS LIST

Ref #	Dake Part #	Description	Qty.
1	301139	Frame upright channel	2
2	301138	Head frame channel	2
3 / 19	301137 / 301133	Head ram traverse plates	1 upper & lower
4	301136	Bolt M12 x 110mm	6
5	301135	Lock washer 12mm	6
6	301134	Nut M12 x 4	6
7	301132	Union support	1
8	301131	Base angle	2

9	301130	Bolt M8 x 20	6
10	301129	Lock washer 8mm	6
11	301128	Nut M8	6
12	301127	Flat nose piece	1
13	301126	Step nose piece	1
14	301125	Table pin	2
15	301124	Table plate	2
16	301123	Work table	1
17	301122	Ram / Cylinder	1
18	301121	Pumping unit	1
20	301150	Bolt M10 x 120	2
21	301149	Lock washer 10mm	2
22	301141	Nut 10mm	2
23	301120	Gauge	1

Spare seals should be stored in safe location out of direct sunlight if future is required.

10 TON BENCH UTILITY PRESS



10 TON FLOOR UTILITY PRESS PARTS LIST

Ref #	Dake Part #	Description	Qty.
1	301154	Frame upright channel	2
2	301153	Head frame channel	2
3 / 4	301152 / 301151	Head ram traverse plates	1 upper & lower
5	301150	Bolt M10 x 120mm	2
6	301149	Lock washer 10mm	2
7	301148	Union Support	1
8	301147	Base angle	2
9	301146	Bolt M8 x 25	12
10	301129	Lock washer 8mm	12
11	301128	Nut M8	12
12	301145	Angle support strap	4
13	301144	Pump support bracket	1
14	301143	Bolt M10 x 25	5
15	301142	Lock washer 10mm	4
16	301141	Nut M10	4
17	301123	Work table	1
18	301124	Table plate	2
19	301127	Flat nose piece	1
20	301126	Step nose piece	1
21	301140	Ram / Cylinder	1
22	301121	Pumping unit	1
23	301125	Table pin	2
24	301136	Bolt M12 x 110mm	4
25	301135	Lock washer 12mm	4
26	301134	Nut M12	4
27	301120	Gauge	1

Spare seals should be stored in safe location out of direct sunlight if future is required.

When ordering parts have model and date of purchase information ready.

For assistance call Dake Service at 1-800-937-3253 or fax to 1-800-846-3253
e-mail to customerservice@dakecorp.com

10 TON FLOOR UTILITY PRESS

