



# INSTRUCTIONS AND PARTS LIST FOR Models 8-025, 8-050, 8-075, and 8-150 Elec-Draulic II Presses

## SETTING UP THE PRESS FOR OPERATION

For shipping convenience some of the parts are not assembled. Assemble these parts in the following order:

1. Bolt the base angles to uprights using four bolts and nuts, which are provided. Make sure base angles are against stops on uprights.  
**NOTE: The press should set on a level floor with the base angles touching the floor at all points. Use shims where necessary.**
2. Switch box is mounted on left upright. Have electrician connect switch to power line. Pump can rotate in either direction.
- 3.
4. **Oil Requirements:** Fill reservoir thru street elbow at back of press with Mobil DTE oil No. 24 or equivalent. **NOTE: Oil level may be checked (with ram up) by removing the pipe plug on the right side of reservoir near the front. Replace plug before operating the press.**

Model 8-025 uses 3 gallons  
Model 8-050 uses 3 gallons  
Model 8-075 uses 3 gallons  
Model 8-150 uses 10 gallons

5. Attach nose piece to ram by inserting shank into ram and tightening the set screw.
6. **CAUTION! Place the hoist crank on the lift drum shaft. The table is raised to the desired height by turning the crank after removing the table pins. Check to make sure the hoist cable is tracking correctly. Run the table channels from top to bottom. The cable should be on each of the two upper pulleys and should track back and forth on the cable drum. Always place table pins under the table channels when servicing or tracking the cable. If a tracking problem exists, contact the Dake factory for instructions. Be sure all table pins are fully inserted in place before applying pressure. Always remove or release pressure on the cable before pressure is applied.**

# **SAFEGUARDING THE POINT OF OPERATION**

## **ANSI B11.2 – Hydraulic Power Presses Safety Requirements for Construction, Care and Use**

It is important that Dake press users have a clear understanding of their responsibility involving the care and use of their Dake hydraulic press, including point-of-operation safe guards. Dake strongly recommends that Dake press users obtain a copy of the current American National Standard Institute (ANSI) B11.2 standard, for a more complete understanding of their responsibilities.

ANSI B11.2 states the following, relative to point of operation safeguarding:

“Normally, only the employer (press user) can determine the requirements of the press productions system components, including the dies and methods for feeding. There fore, the employer is ultimately responsible to designate and provide the point-of-operation safeguarding system”.

The standard also discusses additional responsibilities of the employer. Some of the key responsibilities are:

- The employer is responsible for the safety, use and care of the hydraulic power press production system.
- The employer is responsible to consider the sources of hazards for all tacks to be implemented on the hydraulic power press production system.
- The employer is required to eliminate or control identified hazards in the scope of their work activity.
- The employer is responsible for the training of personnel, caring for, inspecting, maintaining and operating hydraulic press production systems to ensure their competence.
- The employer is responsible to provide and ensure that point-of-operation safeguarding is used, checked, maintained and where applicable, adjusted on ever production operation performed on a press production system.

A complete and current copy of the ANSI B11.2 standard can be obtained by contacting the following:

American National Standards Institute  
1430 Broadway  
New York, NY 10018

AMT – The Association for Manufacturing Technology  
7901 Westpark Drive  
Mclean, VA 22102

## **OPERATIONS**

The press has been completely tested at the factory and after setting up according to instructions above, the press is ready for operation. However, it is necessary for the operator to acquaint themselves with the controls.

1. Handcrank is provided to raise and lower table channels to proper height for work. When desired height is obtained insert table pins. Models 8-025 and 8-050 use 2 pins on each side (4 total) and Models 8-075 and 8-150 use 3 pins on each side (6 total).  
**NOTE: Be sure all table pins are in place and in as far as they can go before pressure is applied, also slack off on the cable.**
2. The two table plates and two V-blocks are used for supporting the work in process.
3. The control handle on the right side of the press is used for operation of the press. When the control handle is held in the down position, the ram will move down. When the control handle is held in the up position, the ram will move up. Upon release, the control handle will return to the neutral position and ram motion will stop. Pressure builds upon contact with the work. It is not necessary to stop the motor after each operation.
4. The relief valve located in the manual valve has been set at the factory to open at the maximum tonnage of the press. The valve can be adjusted by removing the hex cap nut located on the lower left hand front corner of the manual valve. Turning the adjusting screw counterclockwise lowers the setting.

## **MAINTENANCE**

**CAUTION: When disconnecting any parts of this machine be extremely careful that all parts are clean to prevent entrance of dirt in the hydraulic system.**

1. If press loses Pressure:
  - a. Check all tubing joints for leaks and tighten the tube nuts.
  - b. Trouble shoot throttling 4-way valve. Refer to bulletin on Dynex throttling 4-way valve.
  - c. Worn cup leather (Serial No < 192522) or T-ring seal (Serial No > 192523). If none of the previous conditions seem to have been the cause of the trouble, the cup leather or T-ring seal may be worn out or damaged. To inspect this it is necessary to drain the oil and remove the workhead from the press frame. Remove tube assembly (Item No. 48 & 49). Insert a rod into the hole located on the top side of cylinder and unscrew workhead assembly from frame. Insert rod into the hole on piston guide (item 47) and unscrew from cylinder. Remove piston from cylinder. The cup leather or T-ring seal can now be inspected and replaced if necessary. Also at this time, inspection of rod seal (item 44) and O-ring seal (item 43) is recommended. Replace if necessary in reverse order being careful not to damage the T-ring seals and O-ring seal.
2. If press will not develop rated tonnage.
  - a. Relief valve not set properly. This valve is located in the lower left hand front corner of the manual valve. The valve has been set at the factory to by-pass oil from the pump back to the reservoir when the pressure reaches rated capacity. To expose the relief valve for adjusting remove the control handle ball (item 53), the control panel (item 57), and the hex cap nut. The load on the spring which governs the pressure at which the valve will by-pass is adjusted by turning the adjusting screw clockwise to raise the setting. Replace the hex cap nut, control panel, and control handle ball after adjusting. The relief valve should not be tampered with after it is once set at the capacity of the press.
  - b. Trouble shoot throttling 4-way valve. Refer to bulletin on Dynex throttling 4-way valve.
  - c. Worn cup leather or T-ring seal (see Section I, item C above)
3. If nothing happens when press is operated.
  - a. If motor does not run, the electrical circuit should be investigated.

- b. If the ram will come down only a fraction of its rated stroke, check the oil level in the reservoir with the ram at the top of its stroke. Oil should be visible when the oil level plug located on the rear of the reservoir is removed.
- 4. If press is operating slow, check for use of improper oil. It is essential that the recommended oil, Mobil DTE 24 or equal be used. Heavier oils cause marked reduction in the ram speed. **DO NOT USE HYDRAULIC JACK OIL!**
- 5. If press builds pressure and is not contacting the work on the down stroke, the rated extended stroke may be exceeded.
- 6. If press builds pressure on the return stroke the rated retract stroke may be exceeded.  
**CAUTION: Prolonged building of pressure at each end of the piston stroke may damage the workhead.**  
**CAUTION : When disconnecting any parts of this machine be extremely careful that all parts are clean to prevent entrance of dirt in the hydraulic system.**

**WARNING LABELS**



To the left is the safety Alert symbol. When you see these safety alert symbols on your press, be alert to the potential for personal injury.

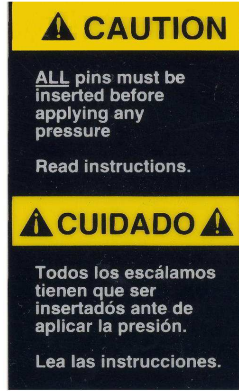
Follow recommended precautions and safe operating practices.

Carefully read all safety messages in these instructions and on your press safety signs.

Keep safety labels in good condition. Replace missing or damaged safety labels. **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.



Label 300168



Label 84487



Label 84399

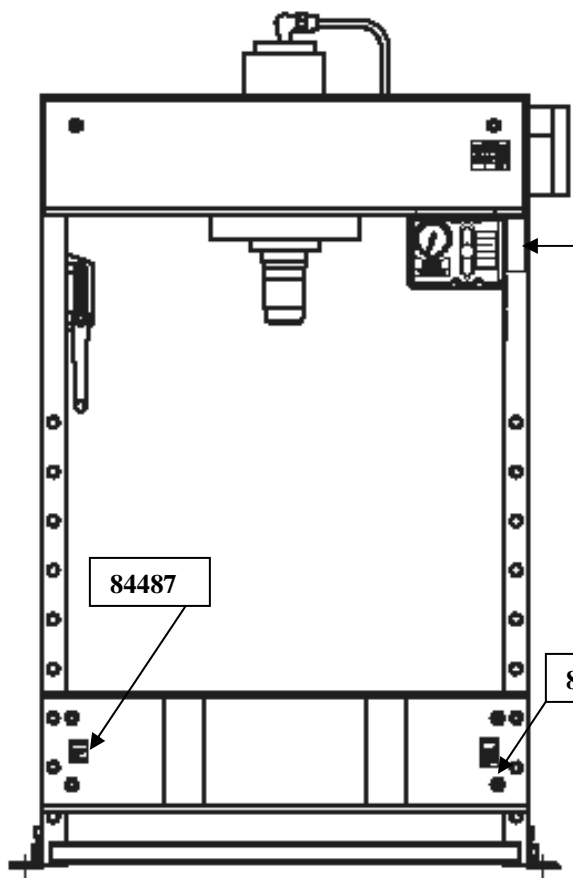


Label 84395



Label 36511

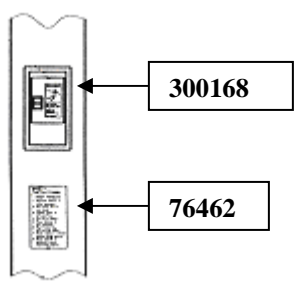
Label Placement View



84395

84487

84399



300168

76462

**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.

Label 76462

FOR WORKHEAD DETAIL  
SEE FIGURE 2

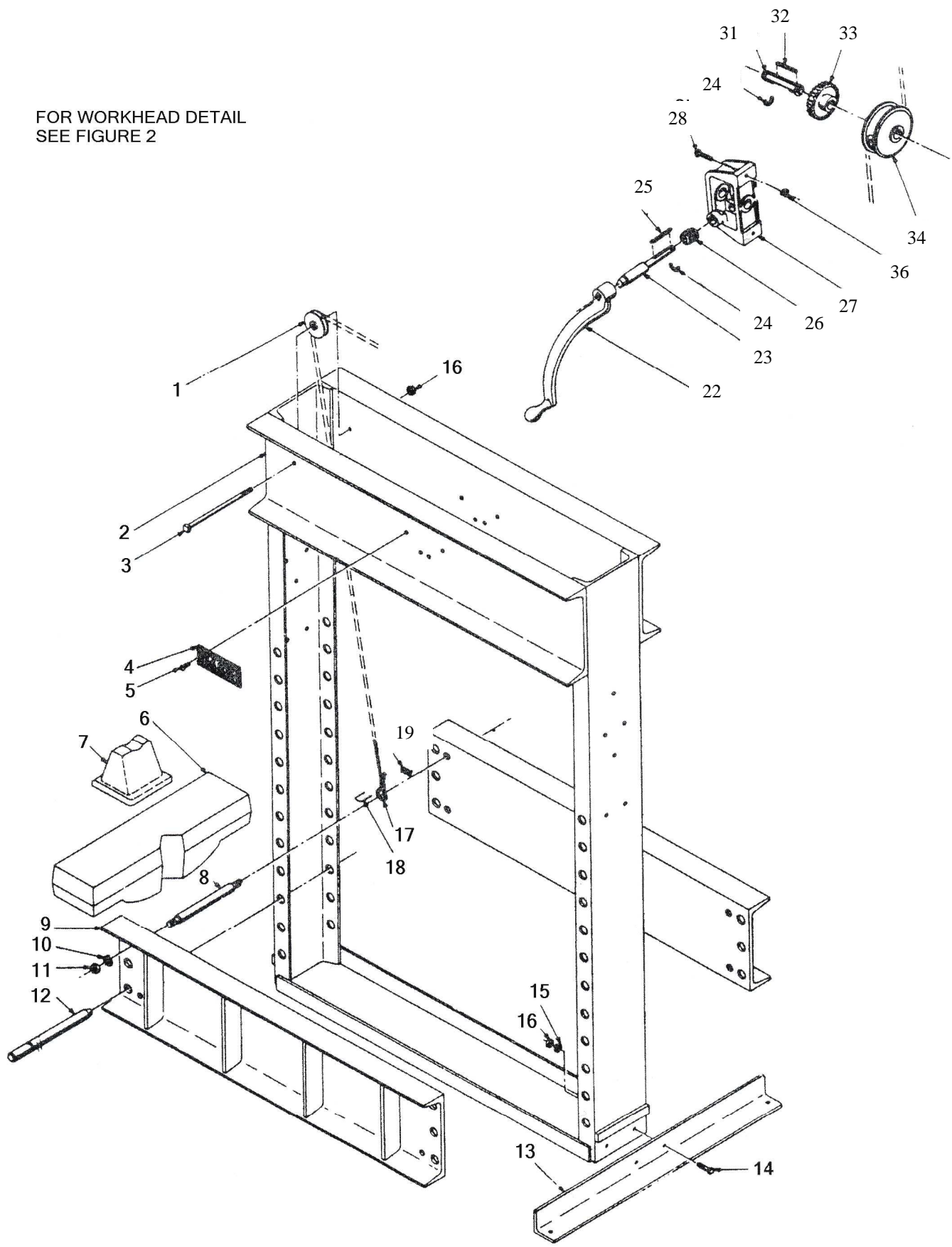
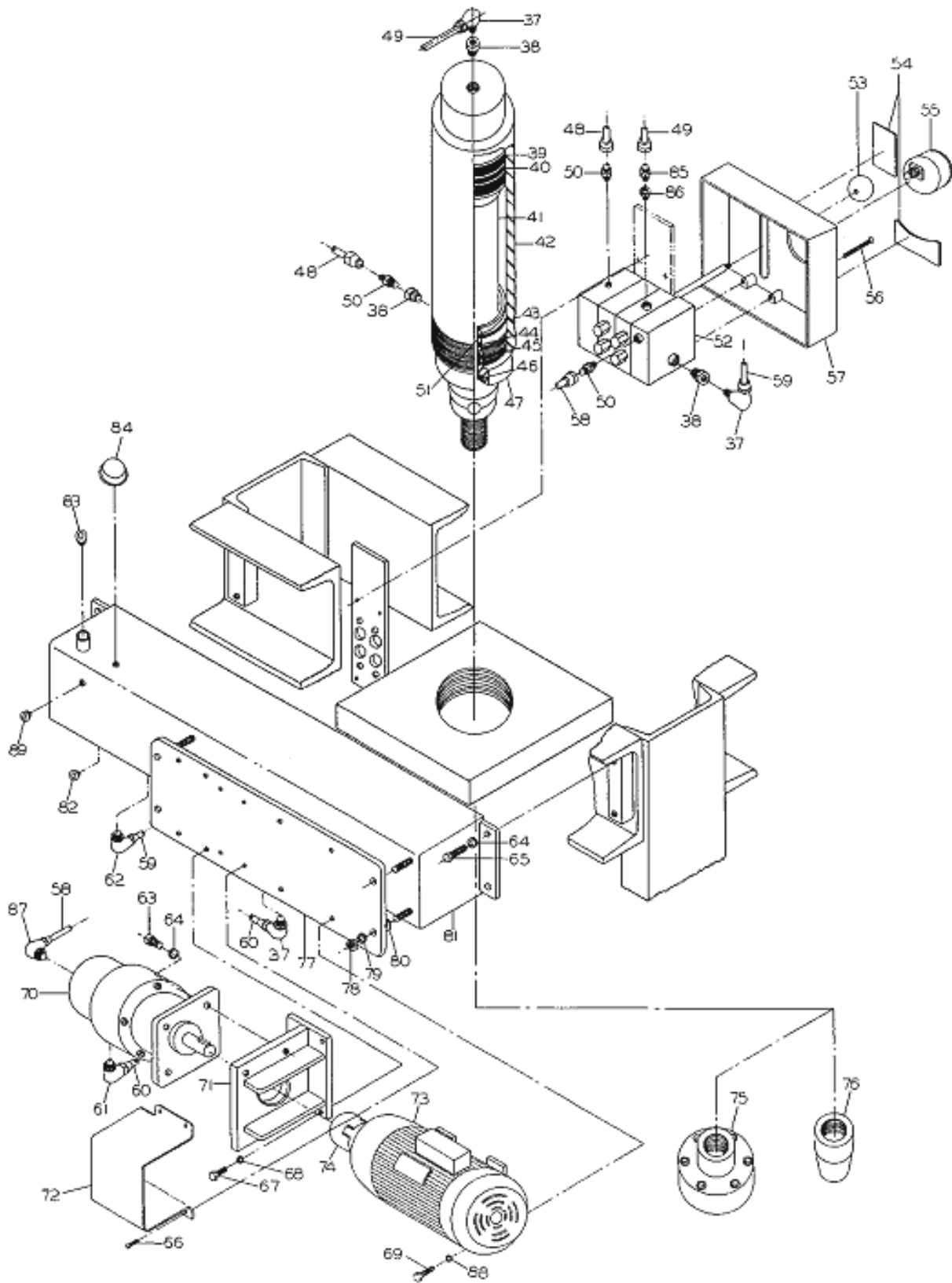


FIGURE 1



**FIGURE 2**

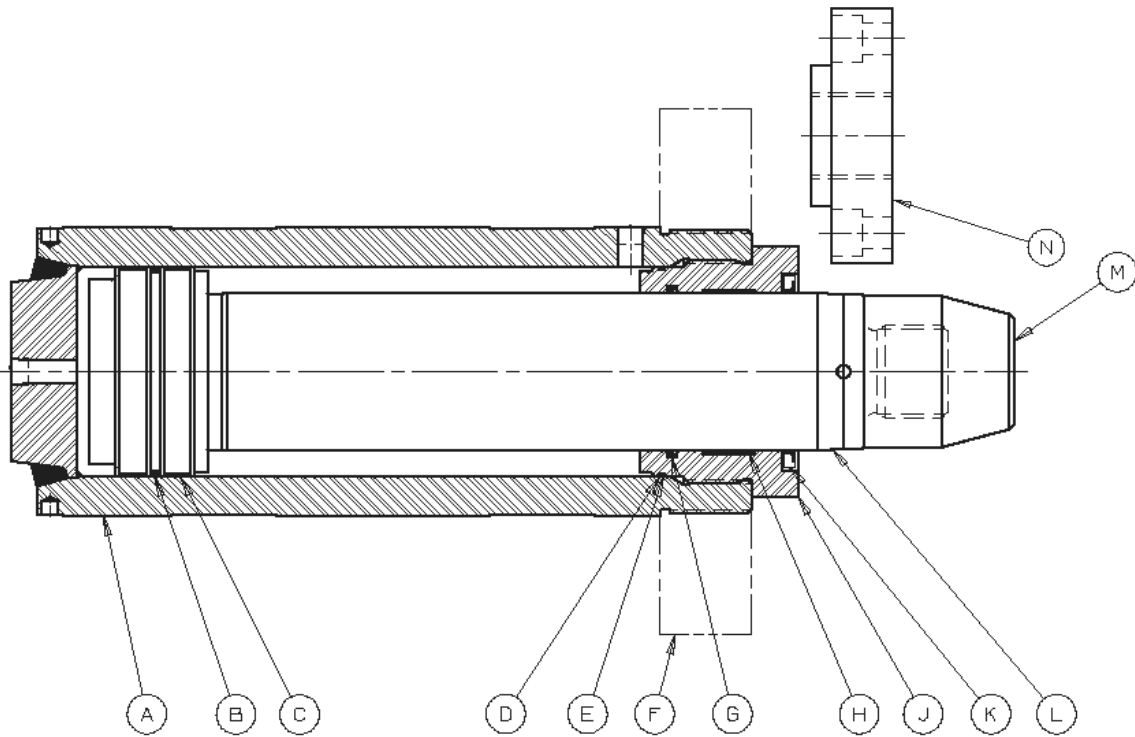
**Figure 1**

Item	Part Name	Model 8-025	Model 8-050	Model 8-075	Model 8-150	Qty
1	Pulley	602	602	727	1563	2
2	Frame	708303	708462	408452	408315	1
3	3/8-16x8 1/2 Hex Cap Screw	433420	43342	N/A	N/A	2
3	1/2-13X10" Hex Cap Screw	N/A	N/A	43361	N/A	4
3	3/4-10X14" Hex Cap Screw	N/A	N/A	N/A	43720	4
4	Name Plate	81002	81002	81002	2252	1
5	6-32x1/4" Self Tapping Screw	43876	43876	43876	43876	4
6	Table Plate	545	545	702	1534	2
7	V- Block	336	336	336	1576	2
8	Table Spacer	716692	568	716	1553	4
9	Table Channel	4100	4100	2243	4207	2
10	5/8" Lockwasher	43648	43648	43648	N/A	4
10	3/4" Lockwasher	N/A	N/A	N/A	43649	4
11	5/8-11 HEX Nut	43917	43917	43917	N/A	4
11	3/4-10 Hex Nut	N/A	N/A	N/A	43919	4
12	Table Pin	2256	2256	2256	N/A	4
12	Table Pin	N/A	N/A	N/A	1555	6
13	Base Angle	566	566	566	1551	2
14	1/2-13X1-1/4" Hex Cap Screw	43348	-	43349	1551	4
14	1/2-13X1-1/2" Hex Cap Screw		43349			
14	5/8-11X1 3/4 Hex Cap Screw	N/A	N/A	N/A	43365	4
15	1/2" Lockwasher	43647	43647	43647	N/A	4
15	5/8 Lockwasher	N/A	43648	N/A	43648	4
16	1/2-13 Hex Nut	43916	43916	43916	N/A	4
16	5/8-11 Hex Nut	N/A	43917	N/A	43917	4
17	Cable	580	580	580	1562	1
18	Cable Clamp	991	991	583	583	4
22	Hand Crank Assembly	701653	701653	701653	701653	1
23	Worm Shaft	384	7530	384	742	1
25	Worm Key	47364	47364	47364	746	1
26	Worm	385	385	385	744	1
27	Hoist Frame	725	725	725	739	1
28	3/8-16x2 1/2 Hex Cap Screw	43335	43335	43335	N/A	
28	3/8-16X2-3/4" Hex Cap Screw	43335	43335	43335	43353	2
30	3/8-16 Hex Nut	43912	43912	43912	N/A	2
30	1/2-13 Hex Nut	N/A	N/A	N/A	43916	
31	Drum Shaft	724	724	724	741	1
32	Drum Key	737	737	737	745	1
33	Worm Gear	736	736	736	743	1
34	Cable Drum	723	723	723	740	1
35	Retaining Ring	43983	43983	43983	-	
36	Retaining Ring	-	-	-	43982	
36	Grooved Pin	-	-	-	44062	
37	Tube Elbow	1252	1252	1252	1944	1
38	Bushing	1657	1657	1657	N/A	1
39	Wear Ring	37036	37041	37046	37051	2
40	T-Ring	17976	17878	17942	37052	1
41	Piston	35811	35563	35575	35585	1
42	Cylinder	34321	35561	35589	35584	1
43	O-Ring	29637	29638	37048	25823	1
44	T-Ring	37037	37044	36311	37054	1
45	Wear Ring	37038	37045	37050	37055	1or2
46	Oil Seal	944	1477	1357	1524	1
47	PistonGuide	34322	35562	35573	35592	1
48	Tube Valve to bot. cyl.	-	-	-	-	1
49	Tube valve to top cyl	-	-	-	-	1
50	Straight fitting	17920	17920	17920	17920	3

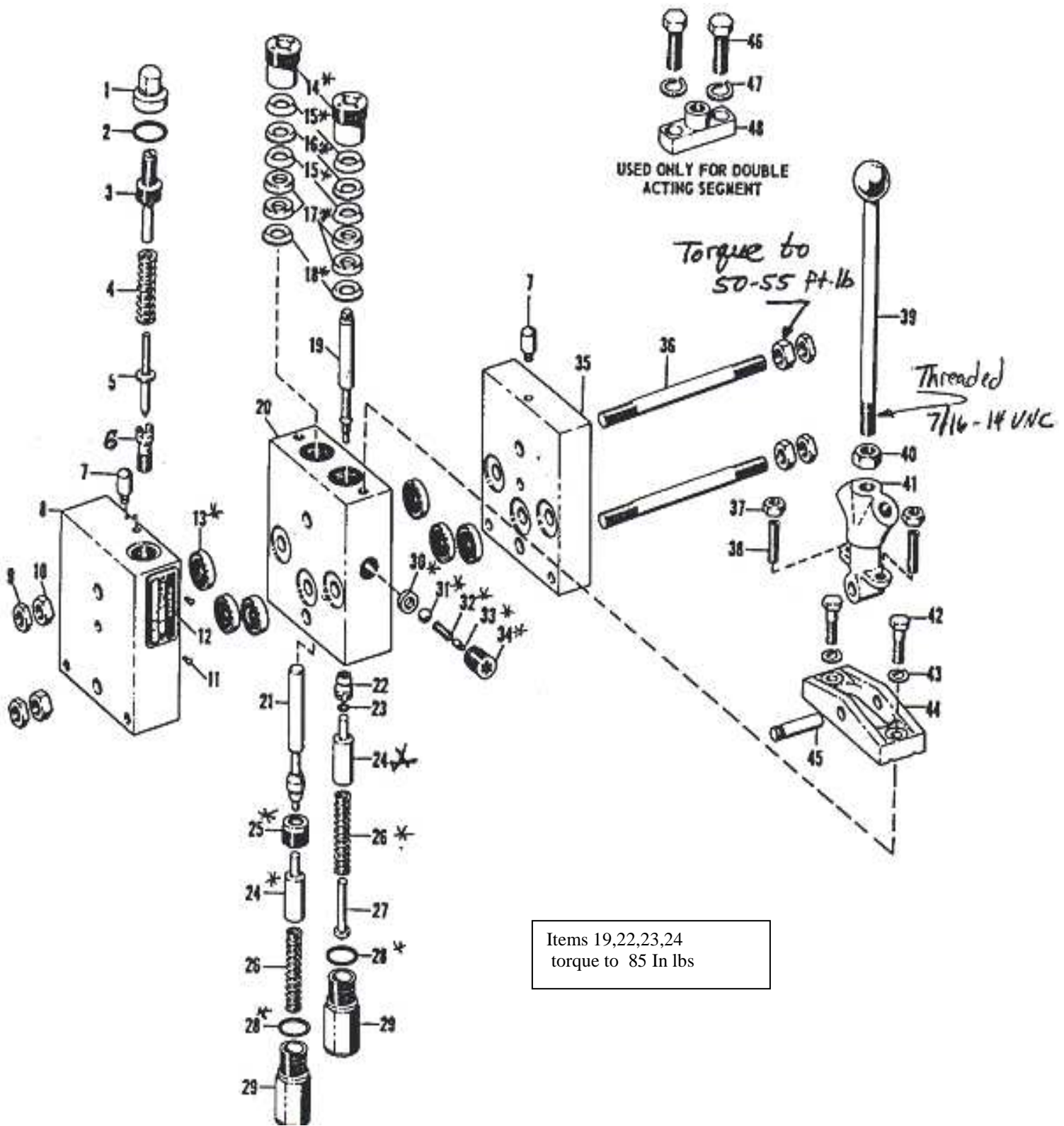


51	Back up washer	37040	37043	37049	37053	1
52	Manual 4 way valve	29662	29662	29662	29662	1
53	Tube Valve to gauge	-	-	-	-	1
54	Panel decal	36590	36590	36590	36590	1
55	Gauge	71270	71271	71272	71273	1
56	10-24x2-3/4" mach. Flat hd. Screw	300248	300248	43821	43821	4
57	Control Panel	81395	81395	81395	81395	1
58	Tube pump to valve	-	-	-	-	1
59	Tube valve to reservoir	-	-	-	-	1
60	Tube reservoir to pump	-	-	-	-	1
61	Tube elbow					
62	Tube elbow					
63	1/2-13x1 Socket Hd Cap screw	43469	43347	43469	-	4
63	1/2-13x1 1/4	43470	43470	43470	43470	4
64	1/2" Lockwasher	43647	43647	43647	-	4
65	1/2-13x3/4	43345	43345	43345	-	4
66	10-24x3/8 Pan hd. Screw	43881	43881	43881	-	4
67	5/16-18x1 Hex Cap Screw	43315	43315	43315	-	4
68	5/16" Lockwasher	43644	43644	43644	-	4
69	5/16-18x3/4 Hex Cap Screw	43314	43314	43314	-	4
69	3/8-16x1 Hex Cap Screw	-	-	-	43328	4
70	Pump	301756	301756	301756	29608	1
71	Pump Support	25916	25916	25916	36299	1
72	Coupling Guard	36761	36761	36761	-	1
73	Motor	-	29744	-	-	1
74	Coupling	28498	28498	28498	-	1
	Coupling Half	-	-	-	29556	1
	Coupling Half	-	-	-	29557	1
	Spider	-	-	-	29942	1
75	Adapter Flange	1067	1181	1400	2029	1
76	Nose Piece	942	1150	3276	1987	1
77	Pump & Motor Base	36509A	36509A	36509A	-	1
78	3/8-16 Nut hex	43912	43912	43912	-	4
79	3/8 Lockwashers	43645	43645	43645	-	4
80	Washers	2248	2248	2248	-	4
81	Reservoir	36510	36510	36510	36527	1
82	1/4 Soc pipe plug	1567	1567	1567	1567	1
83	3/4 Soc pipe plug	1745	1745	1745	1745	1
84	Breather Filter	29571	29571	29571	29571	1
85	Straight Fitting	17920	17920	17920	1943	1
86	3/4x1/2 Reducer	-	-	-	1153	2
87	Tube Elbow	1252	1252	1252	17974	1
88	5/16 Lockwashers	43644	43644	43644	-	4
88	3/8 Lockwashers	-	-	-	43645	4
89	1/8 Soc pipe plug	589	589	589	589	1
90	Repair Kit items 39, 40, 43, 44, 45, 46, 51	711016	711017	711018	711019	
N/A	Table Hoist Assembly items 22,23,24,25,26,27,31,32,33,34	700112-S	700112-S			1

### Work head exploded view



Item	Part Name	Model 25 ton	Model 50 ton	Model 75 ton	Model 150 ton	Qty
N	Adaptor Flange	1067	1181	1400	2029	1
M	Nose Piece	942	1150	3276	1987	1
L	Piston	35811	35563	35575	35585	1
K	Oil Seal	944	1477	1357	1524	1
J	Piston Guide	34322	35562	35573	35592	1
H	Teflon wear ring	37038	37045	37050	37055	2
G	Palmetto ring	37037	37044	36311	37054	1
F	Cylinder flange	86610	35565	35593	83880	1
E	Back-up washer	37040	37043	37049	37053	1
D	O-ring	29637		37048	25823	1
C	Teflon wear ring	37036	37041	37046	37051	2
B	Palmetto Ring	17976	17878	17942	37052	1
A	Cylinder	34321	35561	35589	35584	1
N/A	Complete assembly	707725	708077	708055	708078	1
	Repair Kit items C, B, D, G, H, K, E	711016	711017	711018	711019	



Item	Part Name	Part number	Qty
2-6	Pressure head repair kit one each of 2-6	54165	1
13	Grommet	47298	1
39	Handle	301328	1
41	Saddle	301329	1
48	Dual valve operating lever	301330	1
* Kit	Valve segment unit repair kit, includes one each of items 25 and 30 thru 34, two each of items 14, 16, 18, 24, 26 and 28, four each of 15 thru 17, 6 each of 13	67741	1 or 2
**Kit	Segment replacement, includes one each of 19 thru 23, 25, 27, 30 thru 34, 41, 44 and 45, two each of 14, 16, 18, 24, 26, 28, 29, 37, 38, 42 and 43.	301735	

\*Note: 1 pc. For a 3 way valve (new 3way valve part number is 29661) **These Dynex valves have all ½" NPT port sizes**  
 2 pc. For 4 way valve (new 4 way valve part number is 29662)

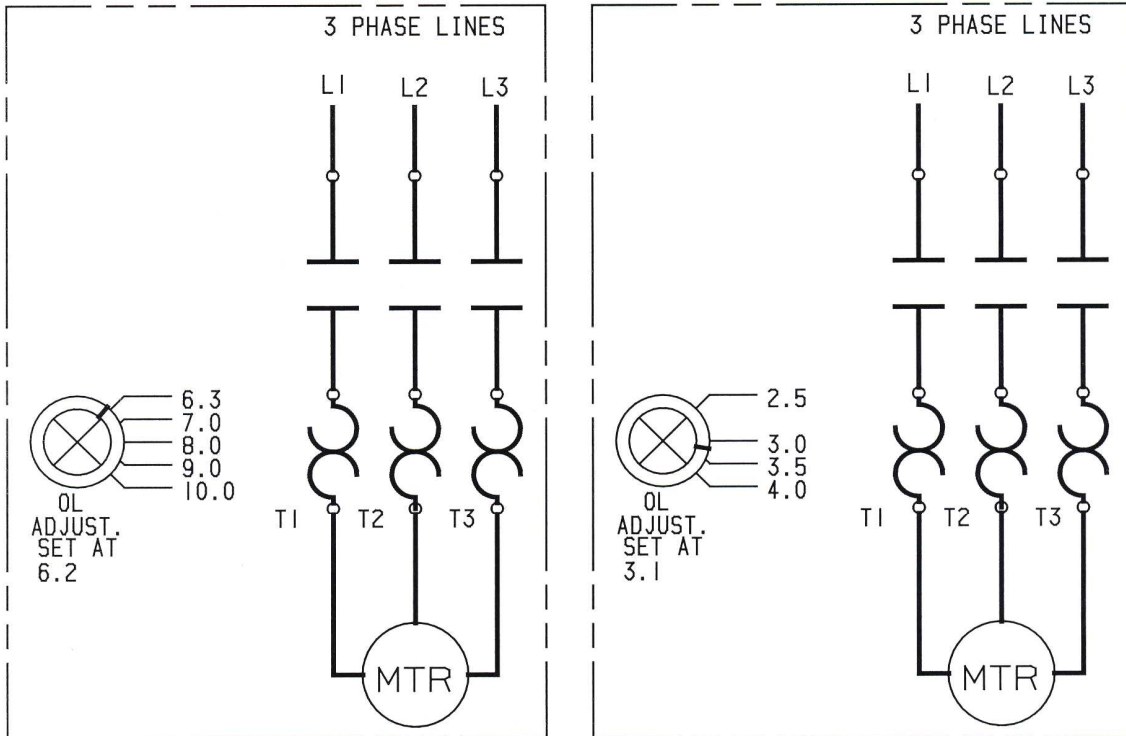
\*\* Note: This kit is completely assembled and pre tested and ready for service.

29662 Dynex valve replaces the Dake valve 26-300 and 26-302. Repair kit for the 26-300 is part number 710146. No repair kit available for the 26-302.

29661 Dynex valve replaces the Dake valve 26-301. Repair kit for the 26-301 is part number 710146.

**Note:** If replacing a Dake valve with a Dynex valve, the port location may be different than the Dake valve.

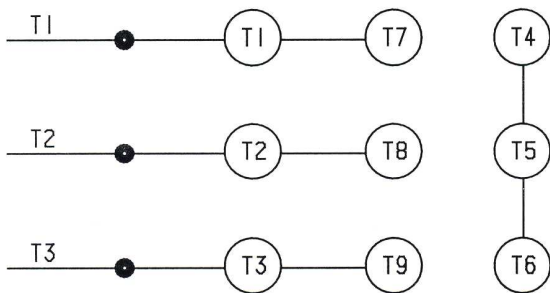
# THIS DIAGRAM IS FOR THE 25, 50 AND 75 TON MODELS ONLY



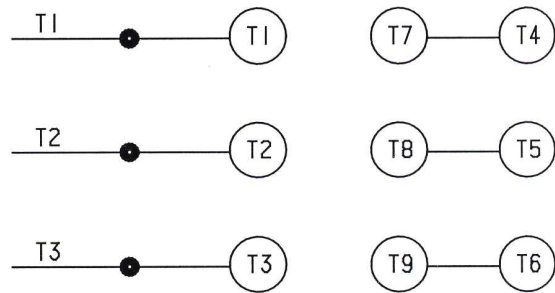
230 VOLTS  
 FOR 2 HP MOTOR DPN IS 75675  
 FOR 3 HP MOTOR DPN IS 75675

460 VOLTS  
 FOR 2 HP MOTOR DPN IS 75674  
 FOR 3 HP MOTOR DPN IS 76846

SET STARTER OVERLOAD SETTING TO MATCH THE MOTOR NAMEPLATE VALUE FOR THE MOTOR THAT IS BEING USED. DRAWING SHOWS VALUES FOR 2 HP MOTOR.



230V MOTOR CONNECTION



460V MOTOR CONNECTION

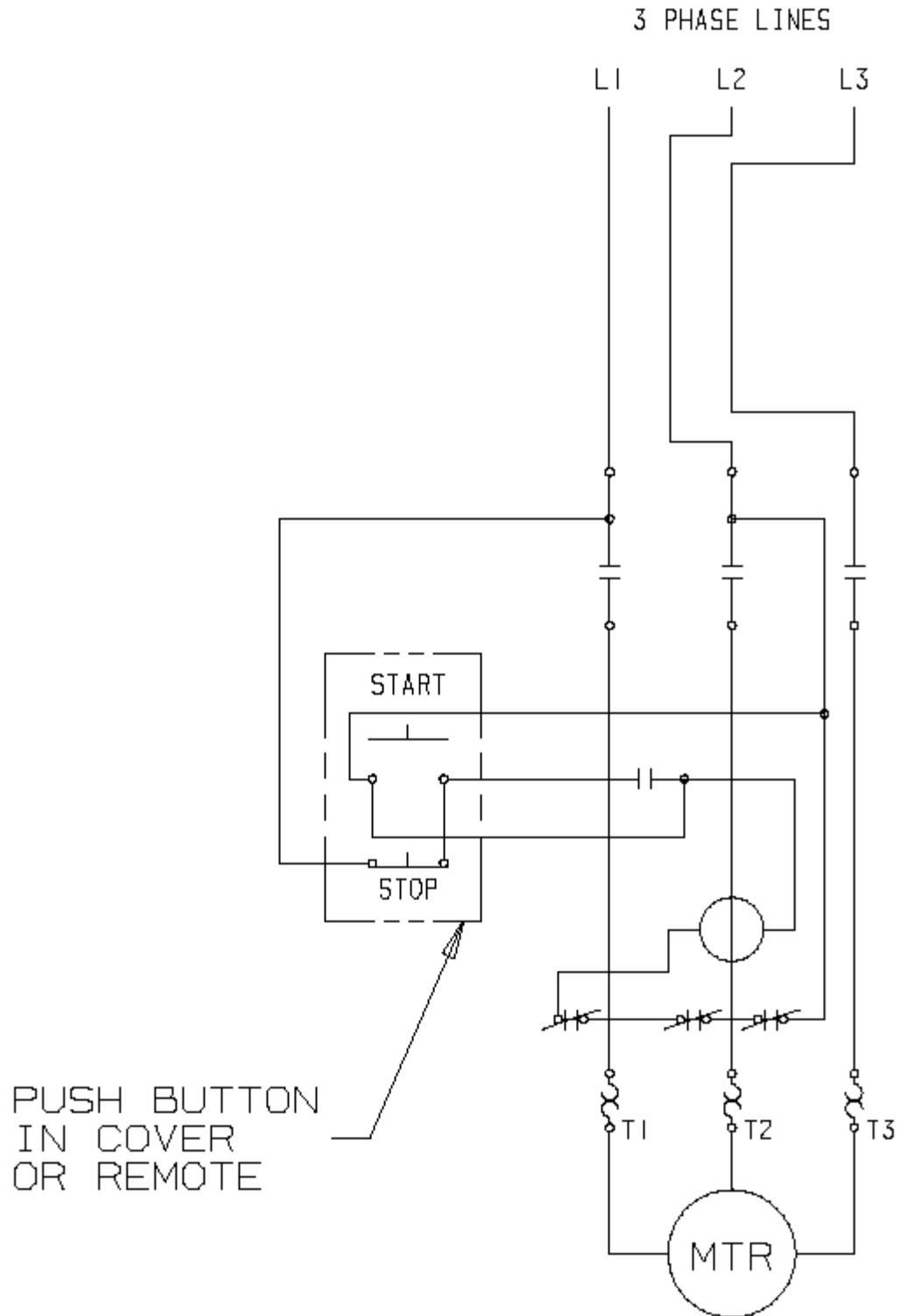
D# 33720

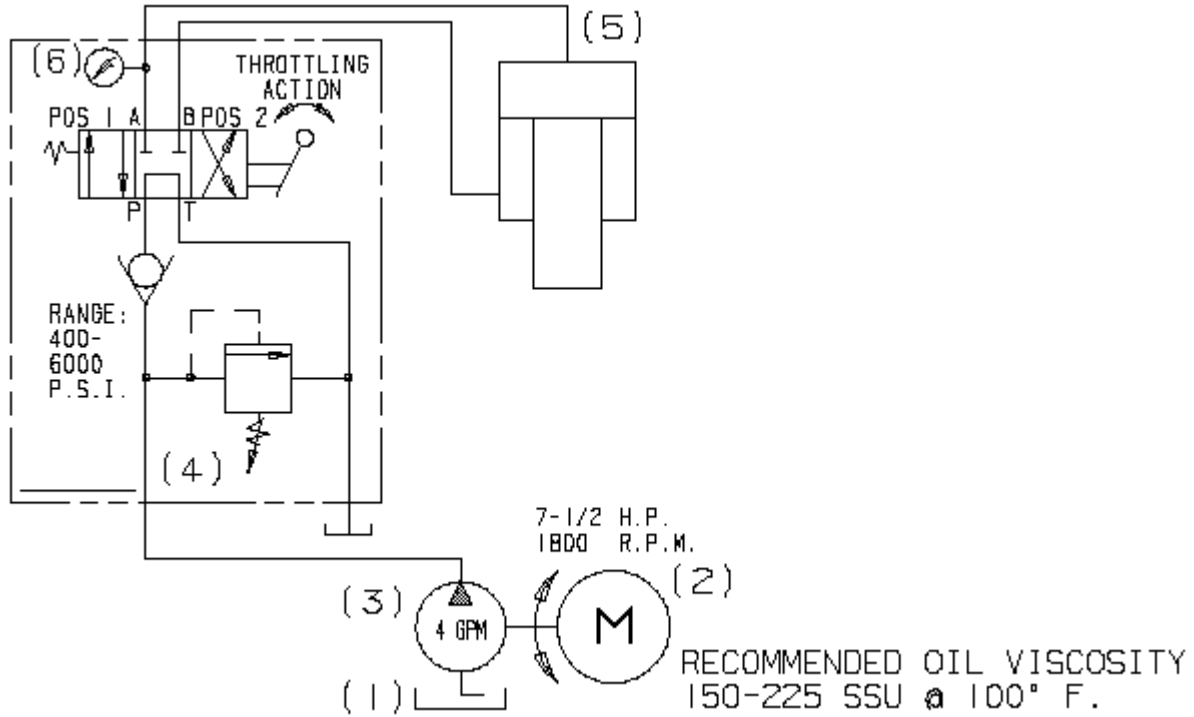
### Electrical parts list

Part #	Part description	Qty
302062	Starter enclosure	1
29796	Switch manual	1
302187	Motor starter 220 volt	1
	Motor starter 440 volt	1

66244	Heater overload (150 ton only)	3
-------	--------------------------------	---

## 150 ton model only





D# 81020

	Part Name	25 ton	50 ton	75 ton	150 ton	Qty
1	Reservoir	36510	36510	36510	36527	1
1	Reservoir filter breather	29571	29571	29571	29571	
2	Motor – electric	301382	301382	301382	70901	1
3	Pump	301756	301756	301756	29608	1
4	4 way valve w/relief valve	29662	29662	29662	29662	1
5	Work Head	707725	713717	708055	708078	1
6	Gauge	71270	71271	71272	71273	1
N/A	Cylinder bore	3 5/8"	5"	6"	8"	N/A
N/A	Rod diameter	2 3/4"	4"	4 3/4"	6"	N/A
N/A	Stroke	10"	10"	10"	16"	N/A
N/A	PSI	4845	5100	5305	5970	N/A
N/A	Piston Thread diameter ACME	1 1/2 - 6	2 - 6	2 1/2 - 4	3 1/2 - 4	N/A



a JSJ business

724 Robbins Road  
Grand Haven, MI 49417  
Phone: 616-842-7110 800-937-3253  
Fax: 616-842-0859 800-846-3253  
Web: [www.dakecorp.com](http://www.dakecorp.com)  
E-mail: [customerservice@dakecorp.com](mailto:customerservice@dakecorp.com)  
[technicalservice@dakecorp.com](mailto:technicalservice@dakecorp.com)