



a JSJ business

DAKE AIR ARBOR PRESS

Model 1-204, 1-210 and 1-220

INSTRUCTIONAL MANUAL



WARNING!

Read and understand all instructions and responsibilities before operating. Failure to follow safety instructions and labels could result in serious injury.

Dake Corporation
724 Robbins Road
Grand Haven, MI 49417

Phone: 800.937.3253
Fax: 800.846.3253

www.dakecorp.com
customerservice@dakecorp.com



TABLE OF CONTENTS

DAKE STANDARD LIMITED WARRANTY.....	2
RETURN & REFUND POLICY	4
SPECIFICATIONS	5
SAFETY	6
SET UP.....	7
OPERATION	7
OPERATING.....	7
DOWN STROKE ADJUSTMENT	7
RAM SPEED ADJUSTMENT	8
TOOLING CHANGE CAUTION.....	8
EXPLODED VIEW & PARTS LIST	9
EXPLODED PARTS VIEW.....	9
PARTS LIST	10
ORDERING INFORMATION	11



DAKE STANDARD LIMITED WARRANTY

Finished Machines

Dake warrants to the original purchaser the finished machine manufactured or distributed by it to be free from defects in material and workmanship under normal use and service within 1 year (12 months) from the delivery date to the end user.

Parts

Dake warrants to the original purchaser the component part manufactured or distributed by it to be free from defects in material and workmanship under normal use and service within 30 days from the delivery date to the end user.

The standard limited warranty includes the replacement of the defective component part at no cost to the end user.

Sale of Service (Repairs)

Dake warrants to the original purchaser the component part repaired by Dake Corporation at the manufacturing facility to be free from defects in material and workmanship under normal use and service within 90 days from the return date to the end user, as it pertains to the repair work completed. The standard limited warranty includes repair of the defective component part, at no cost to the end user.

Warranty Process

Subject to the conditions hereinafter set forth, the manufacturer will repair or replace any portion of the product that proves defective in materials or workmanship. The manufacturer retains the sole right and option, after inspection, to determine whether to repair or replace defective equipment, parts or components. The manufacturer will assume ownership of any defective parts replaced under this warranty.

All requested warranty claims must be communicated to the distributor or representative responsible for the sale. Once communication has been initiated, Dake Customer Service must be contacted for approval:

Phone: (800) 937-3253

Email: customerservice@dakecorp.com

When contacting Dake, please have the following information readily available:

- Model #
- Serial #
- Sales Order #

Purchasers who notify Dake within the warranty period will be issued a Case number and/or a Return Material Authorization (RMA) number. If the item is to be returned per Dake's request, the RMA number must be clearly written on the exterior packaging. Any item shipped to Dake without an RMA will not be processed.



Warranty Exceptions:

The following conditions are not applicable to the standard limited warranty:

- (a) Part installation or machine service was not completed by a certified professional, and is not in accordance with applicable local codes, ordinances and good trade practices.
- (b) Defects or malfunctions resulting from improper installation or failure to operate or maintain the unit in accordance with the printed instructions provided.
- (c) Defects or malfunctions resulting from abuse, accident, neglect or damage outside of prepaid freight terms.
- (d) Normal maintenance service or preventative maintenance, and the parts used in connection with such service.
- (e) Units and parts which have been altered or repaired, other than by the manufacturer or as specifically authorized by the manufacturer.
- (f) Alterations made to the machine that were not previously approved by the manufacturer, or that are used for purposes other than the original design of the machine.



RETURN & REFUND POLICY

Thank you for purchasing from Dake! If you are not entirely satisfied with your purchase, we are here to help.

Returns

All Dake manufactured / distributed machines, parts and couplings include a 30-day return option. These policies are valid from the date of final shipment to the end user.

To be eligible for a return, the item must be unused and in the same condition as received.

All requested warranty claims must be communicated to the distributor or representative responsible for the sale. Once communication has been initiated, Dake Customer Service must be contacted for approval:

Phone: (800) 937-3253

Email: customerservice@dakecorp.com

Once the return request has been approved by Customer Service, a representative will supply a Return Material Authorization (RMA) number. The returned item must have the provided RMA number clearly marked on the outside packaging. Any item received without an RMA number clearly visible on the packaging will not be processed.

An RMA number can only be provided by the Dake Customer Service team and must be obtained prior to the return shipment.

Refunds

Once the item has been received and inspected for damages, a representative will notify the requestor referencing the provided RMA number.

If the return is approved, a refund will be issued to the original method of payment, less a 20% restocking fee. The restocking fee may be waived if an order is placed at the time of return with like-value merchandise.


Transportation costs are the responsibility of the end user and will not be credited upon return approval.

Any item that is returned after the initial 30 days or has excessive/obvious use will not be considered for a full refund.

SPECIFICATIONS

Model	1-204	1-210	1-220
Number	901204	901210	901220
Capacity	400 lbs	1,000 lbs	2,000 lbs
Air Pressure	90 psi	85 psi	100 psi
Ram Travel	2"	4"	4"
Weight	70 lbs	110 lbs	195 lbs
Thread	1/2"-20	3/4"-16	3/4"-16
Length of Thread	3/4"	1-1/8"	1-1/8"
Daylight w/ nose piece	5"	8"	8"
Daylight w/o nose piece	5-11/16"	8-11/16"	8-11/16"
Nose piece diameter	1"	1-1/4"	1-1/4"
Throat	5"	5"	5"
Work area	9" x 6"	9" x 8"	9" x 8"
Plate Thickness	1"	1-1/4"	1-1/2"
Base	13-3/8" x 6"	14-9/16" x 8"	15-3/4" x 8"
Hole Pattern	7-1/4" x 1-3/4"	7-1/4" x 3-1/4"	7-1/4" x 3-1/4"
Overall height	23"	34"	35"

SAFETY

 **This is the safety alert symbol.** When you see this symbol on your press be alert to the potential for personal injury.

Employer is responsible to perform a hazard/PPE assessment before work activity.



WARNING: This product contains Nickel, a chemical known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov



Label Part No. 300168

Follow recommended precautions and safe operating practices.

<p>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.</p>	<p>This machine is intended to be operated by one person. This person should be conscious of the press ram movement not only for themselves but also for persons in the immediate area of the machine.</p>	<p>Under no circumstances increase the leverage ratio of the press by using a longer handle or by placing a pipe over the handle. Never hammer on top of the ram.</p>
--	---	--

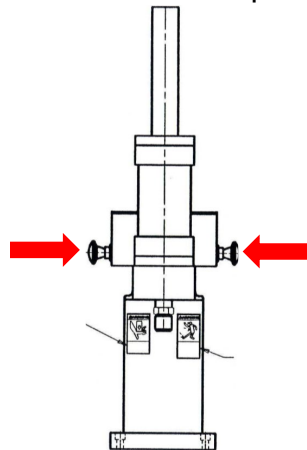
SET UP

1. Fasten press to bench or work surface using the mounting holes provided (item 1 below).
2. Connect a 3/8" air supply to the filter-regulator (item 38) located at the rear of the press frame. **⚠ CAUTION! Air must be moisture free! Water in the air supply may damage the press beyond repair! Airline lubrication is not required.**
3. Adjust the air regulator for proper operating pressure as follows:
 - a. 400 pound model (1-204) at 90 psi.
 - b. 1,000 pound model (1-210) at 85 psi.
 - c. 2,000 pound model (1-220) at 100 psi.

OPERATION

OPERATING

- To activate press simultaneously push both control buttons (item 27 below) on either side of the press. Shown in the picture below.
- The releasing of either button will cause the press to open fully.



DOWN STROKE ADJUSTMENT

The Stroke Control adjustment (item 10 below) is located inside the guard (item 12 below). This adjustment may be used to limit the closing of the press to any point in the stroke. Always tighten the locknut to keep the adjustment in place. **WARNING! ALWAYS REPLACE THE GUARD (item 12 below). NOT DOING THIS COULD RESULT IN SERIOUS INJURY!**



RAM SPEED ADJUSTMENT

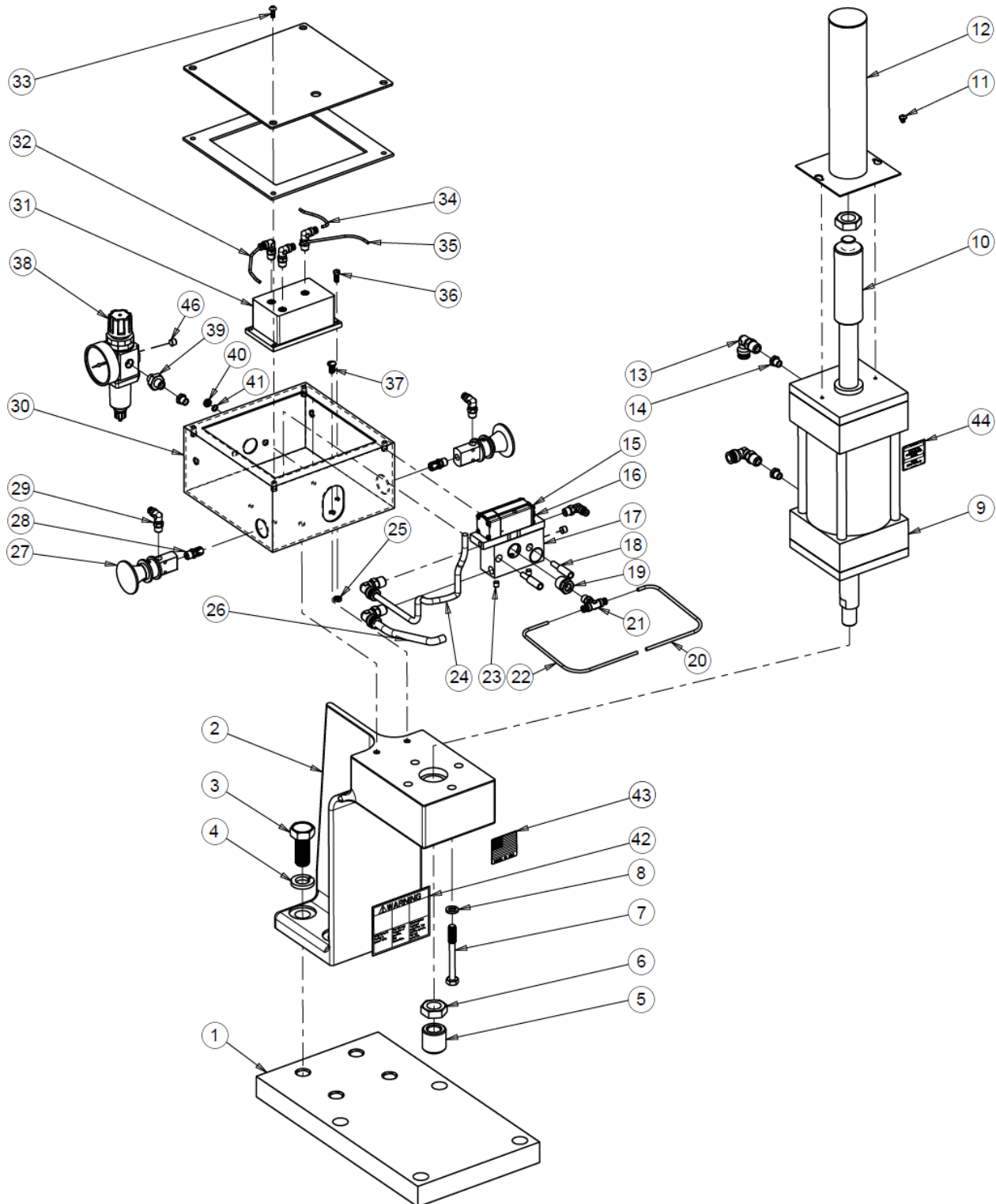
There are openings in each side of the control enclosure for screwdriver adjustment of the press ram speed. The opening on the right side (looking from the front) controls the up speed and the other one is for the down speed. Turning the screw clockwise decreases the speed.

TOOLING CHANGE CAUTION

The cylinder rod of the press has a non-rotating feature that could be damaged if care is not used when attaching tooling. Always hold the rod from rotating using a wrench on the flats above the threads when attaching tooling or tooling adapters

EXPLODED VIEW & PARTS LIST

EXPLODED PARTS VIEW





PARTS LIST

Item	Parts Name	Part Number			Qty
		Model 1-204	Model 1-210	Model 1-220	
1	Mounting Plate	67474	67731	67734	1
2	Main Frame	67472	67728	67733	1
3	Hex Cap Screw	43349 (1/2"-13 x 1-1/2")	43372 (3/4"-10 x 1-3/4")	43383 (1"-8 x 1-1/2")	4
4	Lock Washer	43647 (1/2")	43649 (3/4")	43650 (1")	4
5	Nose Piece	68391	68392	68392	1
6	Hex Jam Nut	43941 (1/2"-20)	43946 (3/4"-16)	43946 (3/4"-16)	2
7	Hex Cap Screw	43336 (3/8"-16 x 2-3/4")	43339 (3/8"-16 x 3-1/2")	43359 (1/2"-13 x 4-1/2")	4
8	Lock Washer	43645 (3/8")	43645 (3/8")	43647 (1/2")	4
9	Air Cylinder	67473	67730	67735	1
10	Stroke Control	67464	67732	67732	1
11	#10-24 x 5/16" Phillips Hd. Machine Screw	60477	60477	60477	2
12	Stroke Control Guard	67462	67729M	67729M	1
13	Male Elbow Conn. – Brass	60467 (1/4")	60470 (3/8")	60470 (3/8")	4
14	1/4" Male Tube Conn. – Brass	50790	50790	50790	3
15	4 Way Air Valve Assembly	67468	67468	67468	1
16	Stack Speed Control	62031	62031	62031	1
17	Manifold Sub-plate	67470	67470	67470	1
18	Hex Screw 1/4" - 20 x 3/8"	67470 A	67470 A	67470 A	2
19	3/8" x 1/8" Hex Bushing – Brass	60478	60478	60478	1
20	1/8" Tube Line (R.H. air valve to tee)	68489	68489	68489	1
21	1/8" Male Branch Tee – Brass	60468	60468	60468	1
22	1/8" Tube Line (L.H. air valve to tee)	68490	68490	68490	1
23	1/4" Pipe Plug – Brass	33771	33771	33771	2
24	Tube Line (Top of air cylinder to sub-plate)	67764 (1/4")	67762 (3/8")	67762 (3/8")	1
25	#10-32 Hex Nut	43907	43907	43907	4
26	Tube Line (Bottom of air cylinder to sub-plate)	67765 (1/4")	68486 (3/8")	68486 (3/8")	1
27	Control Button	67467	67467	67467	2
28	1/8" Male Tube Conn. – Brass	60464	60464	60464	2
29	1/8" Male Elbow Conn. – Brass	60463	60463	60463	6
30	Control Enclosure	68390M	68390M	68390M	1
31	Logic Element	67453	67453	67453	1



<u>Item</u>	<u>Parts Name</u>	<u>Part Number</u>			<u>Qty</u>
		Model 1-204	Model 1-210	Model 1-220	
32	1/8" Tube Line (L.H. air valve to element)	68488	68488	68488	1
33	#10-24 x 1/2" Screw	43847	43847	43847	4
34	1/8" Tube Line (Sub-plate to element)	68491	68491	68491	1
35	1/8" Tube Line (R.H. air valve to element)	68487	68487	68487	1
36	#10-32 x 1/2" Rd. Hd. Screw	43858	43858	43858	4
37	1/4"-20 x 3/8 Rd. Hd. Screw	43862	43862	43862	2
38	Filter Regulator	62552	62552	62552	1
39	1/4" Pipe Nipple – Brass	44511	44511	44511	1
39	1/4" Pipe Nipple – Brass	44511	44511	44511	1
40	1/4" Hex Nut	67470_C	67470_C	67470_C	2
41	1/4" Washer	67470_B	67470_B	67470_B	2
43	Label – Made in U.S.A.	76936	76936	76936	1
44	Label – Model Number	607	607	607	1
45	Warning Label – Ganged	300168	300168	300168	1
46	1/8" Pipe Plug – Brass	60469	60469	60469	2
Not shown	1/4" Lock Washer *Located on item 37	43643	-	-	2

Please contact factory for current prices.

ORDERING INFORMATION

Parts are available for direct purchase from Dake or through a distributor. When placing a parts order, you will need to provide the part number, name of part, and model number. All parts shipped F.O.B. Factory in Grand Haven, MI.