DAKE SEMI-AUTO MITERING BANDSAW

SE-6.5M

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
1809 Industrial Park Dr
Grand Haven, MI 49417

Phone: 800.937.3253

www.dakecorp.com

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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.

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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.

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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.

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DAKE STANDARD TERMS & CONDITIONS OF SALE

All proposals and quotations for the original sale of our products are subject to the following terms and conditions:

ACCEPTANCE OF ORDER: All orders are subject to acceptance by Dake at its main office in Grand Haven, Michigan.

APPLICABLE LAWS: This quotation or acceptance shall be governed in all respects by the laws of the State of Michigan.

CANCELLATION: We reserve the right to cancel and/or refuse to complete your order if, in our opinion, you have not established credit to promptly meet the payment terms of your order. Any cancellation from the Purchaser may be subject to a 10% cancellation fee for any of our non-standard machinery upon the discretion of Dake. All custom or special quotes will not be eligible for cancellation, nor returns.

DELIVERY: The proposed shipment date is an estimate and is contingent upon causes beyond Dake's control. Under no circumstances shall Dake have any liability for loss of use or for any direct or consequential damages resulting from delay. All shipments from the Dake facilities are F.O.B.

FREIGHT CLAIM: Damage freight claims must be submitted to Dake within thirty (30) days of shipment from Dake's facility. If shipment for order was set up by the Purchaser, Dake is not liable to handle the freight claims.

PERMITS AND COMPLIANCE: Dake shall not be responsible for obtaining any permits, inspections, certifications, or licenses required for the installation or use of the equipment. Dake makes no promise or representation that the equipment or any services to be furnished by Dake will conform to any federal, state, or local laws, ordinances, regulations, codes or standards.

PRICES: Unless otherwise agreed to in writing, all prices are F.O.B. our plant in Grand Haven, Michigan and Grand Prairie, Texas. In any event, the quoted prices for component parts become invalid ten (10) days after date of quotation, and machinery may become invalid sixty (60) days after date of quotation. Unless otherwise specified in Dake's quotation, installation services and final on-site adjustments are not included in the quotation.

TAXES: Prices do not include taxes. If any sales, use or similar tax is payable to Dake in connection with any transaction or part thereof between the Purchaser and Dake with respect to goods delivered, the Purchaser will, upon demand, pay to Dake the amount of any such tax. If you are tax exempt, please include your exemption document when submitting your order.

TERMS OF PAYMENT: Terms of payment are as stated in Dake's quotation subject to credit approval by our home office. Dake will invoice Purchaser when the equipment is completed and ready for shipment. Payment terms run from invoice date. Purchaser may be required to issue a down payment before production of order and shipment, at the discretion of Dake Accounting. For credit card purchases, a 3.5% processing fee may be applicable to the order. The following states are exempt from the 3.5% processing fee: CA, CO, KS, OK, TX, FL, NY, CT, MA, and ME. Dake's preferred method of payment is as follows: ACH Wire and credit card. Checks will be accepted but may cause delay in order processing. Below is our billing address:

1809 Industrial Park Drive, Grand Haven, MI 49417

WARRANTY If, within a period of one (1) year from date of shipment, any part of any equipment sold by Dake is defective in material or workmanship and is so found after inspection by Dake, it will be replaced or repaired at the option of Dake, providing the equipment has been given normal and proper usage and is still the property of the original Purchaser. Purchased components such as Micro Drop mist system or the like, installed as a part of Dake equipment are warranted only to the extent of the original Manufacturer's warranty. Dake is not responsible for any service work performed unless authorized in advance.

THE FOREGOING WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES WHETHER WRITTEN, ORAL OR IMPLIED (INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE). UNDER NO CIRCUMSTANCES SHALL DAKE BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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SPECIFICATIONS

Machine Type	Hydraulic controlled feed horizontal mitering band saw
Blade Size	84-1/4” x 3/4"
Blade Speed	114-263 FPM
Head Feed	Hydraulic controlled down feed
Vise	Manual with quick opening release
Miter Cutting Capabilities	Up to 60° right
Controls	CE Certified
Horsepower	2.5
Weight	308 lbs
Work Height	37”
Overall Height, Open / Closed	65” open / 52” closed
Base Width	25”
Depth	48”
Lubricant	Flood type unit build into the machine (Electric)
Voltage	120V (Machine should be wired to main service by a qualified electrician)

CUTTING CAPACITIES

Degree	Round	Square	Flat
90°	6-1/2”	6-3/4”	7-3/4”
60°	3”	3”	4 x 2-3/4”
45°	4-1/4”	4-1/2”	6 x 4-1/4”

In the space provided record the serial number and model number of the machine. This information is only found on the black Dake tag. If contacting Dake this information must be provided to assist in identifying the specific machine.

Model No: SE-6.5M

Part No: 983110

Serial No: _____

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Date of Purchase: _____

SAFETY WARNINGS

WARNING: FAILURE TO FAOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

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

As will all machinery there are certain hazards involved with operation and use of the machine. Using the machine with respect and caution will considerably lessen the possibility or personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

This machine was designed for certain applications only. We strongly recommend that this machine NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the machine until you contact with us and we have advised, you.

Your machine might not come with a power socket or plug. Before using this machine, please ask your local electrician to install the socket or plug on the power cable end.

SAFETY RULES FOR ALL TOOLS

USER:

- Wear proper apparel: No loose clothing, gloves, rings, bracelets, or other jewelry to get caught in moving parts. Non-slip foot wear is recommended. Wear protective hair covering to contain long hair.
- Always wear eye protection. Refer to ANSLZ87.1 standard for appropriate recommendations. Also use face or dust mask if cutting operation is dusty.
- Do not overreach. Keep proper footing and balance at all times.
- Never stand on the machine. Serious injury could occur if the machine is tipped or if the cutting blade is accidentally contacted.
- Never leave the saw running unattended. Turn off power. Don't leave saw until it comes to a complete stop.
- Do not operate the tool while under the influence of drugs, alcohol, or any medication.
- Make sure the saw is disconnected from power supply while motor is being mounted, connected, or reconnected.
- Always keep hands and fingers away from table.
- Stop the machine before removing any chips or debris.

- Shut off power and clean the band saw and work area before leaving machine.

USE OF MACHINE:

- Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the saw before turning it on.
- Do not force the saw. It will do a more efficient and safer job at the rate for which it was designed.
- Use correct blade. Do not force blade or attachments to do a job for which it was not designed.
- Secure work. Use clamps or a vise to hold work when practical. It is safer than using your hands.
- Maintain blade is in top condition. Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- Use recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.
- Avoid accidental starting. Make sure the switch is in the "OFF" position before plugging in the cord.
- Direction of feed. Feed work into the blade against the direction of rotation of the blade.
- Adjust and position the blade guide arm before starting the cut.
- Keep blade guide arm tight. A loose blade guide arm will affect sawing accuracy.
- Make sure blade speed is set correctly for material being cut.
- Check for proper blade size and type.
- Stop the machine before putting material in the vise.
- Always have stock firmly clamped in vise before starting the cut.
- Ground all tools. If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.

ADJUSTMENTS:

- Make all adjustments with the power off. In order to maintain the machine, precision and correct ways of adjustment while assembling, the user should read the detailed instruction in this manual.

WORKING ENVIRONMENT:

- Keep work area clean. Cluttered areas and benches invite accidents.
- Do not use in dangerous environment. Do not use power tools in damp or wet locations or expose them to rain. Keep work area well-lighted.

- Keep children and visitors away. All children and visitors should be kept a safe distance from work area.
- Do not install or use this machine in an explosive, dangerous environment.

MAINTENACNE:

- Disconnect machine from power source when making repairs.
- Check damaged parts. Before further use of the saw, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other condition that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- Disconnect tools before servicing and when changing accessories such as blades, bits, cutters, etc.
- Make sure that the blade tension is properly adjusted. Green LED will light when properly tensioned. Saw will not operate until green light is lit.
- Re-check blade tension after initial cut with new blade.
- To prolong blade life always releases blade tension at the end of each work day.
- Check coolant daily. Low coolant level can cause foaming and high blade temperatures. Dirty or weak coolant can clog pump. This can cause low cutting rate and permanent blade failure. Dirty coolant can cause the growth of bacteria with ensuring skin irritation.
- When cutting magnesium never use soluble oils or emulsions (oil-water mix) as water will greatly intensify any accidental magnesium chip fire. See your industrial coolant supplier for specific coolant recommendations when cutting magnesium.
- To prevent corrosion of machined surfaces when a soluble on is used as coolant, pay particular attention to wiping dry the surfaces where fluid accumulates and does not evaporate quickly, such as between the machine bed and vise.

SPECIFIC USAGE:

This machine is used for general metals cutting within the range of cutting capacity.

SAFETY DEVICE:

By the time the saw arm cover is opened, the interlock switch will function to stop the all involvement. Do not remove this switch from machine for any reason and check its function frequency.

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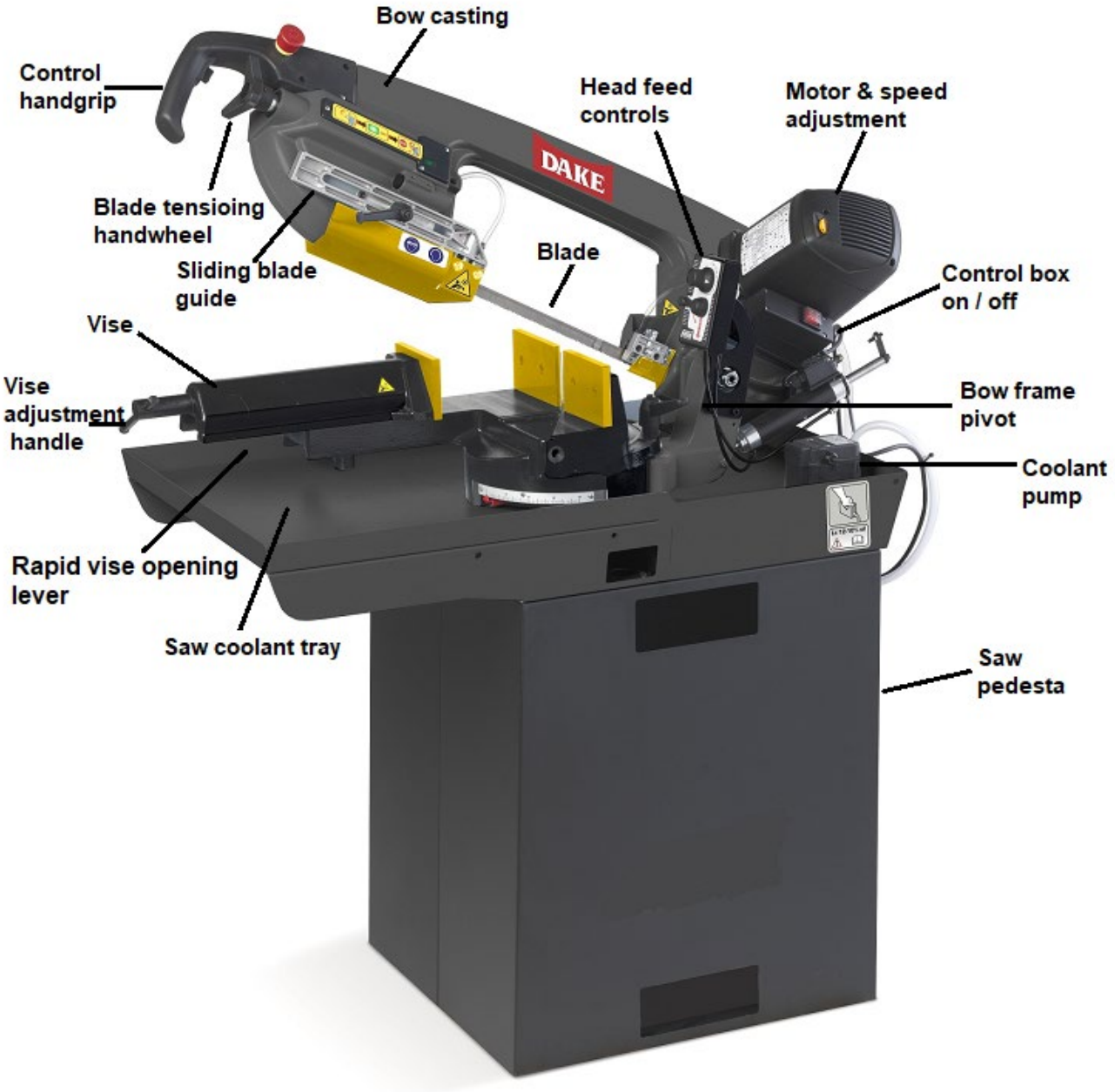
MAIN MACHINE CONTROLS



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SET UP

TRANSPORTATION OF MACHINE

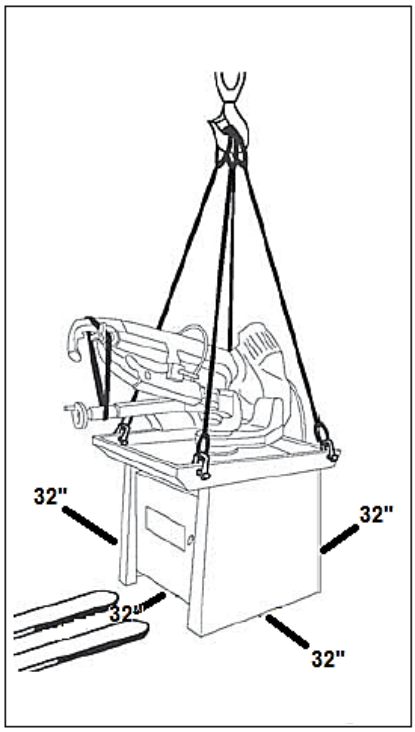
This machine weighs 300lbs.

Transport to desired location before unpacking, please use lifting jack.

Transportation after unpacking, please use heavy duty fiber belt to lift up the machine.

Always keep proper footing and balance while moving this machine.

Minimum space required for machine operation below:



INSTALLATION:

Assemble saw pedestal and bolt saw on the pedestal.

1. Tighten all locks before operation.
2. Turn off the power before wiring, and be sure machine is properly grounded. Overload and circuit breakers are recommended for safety wiring.
3. Check carefully if the saw blade is running in counterclockwise direction, if not, reverse the wiring per circuit diagram then repeat running test.

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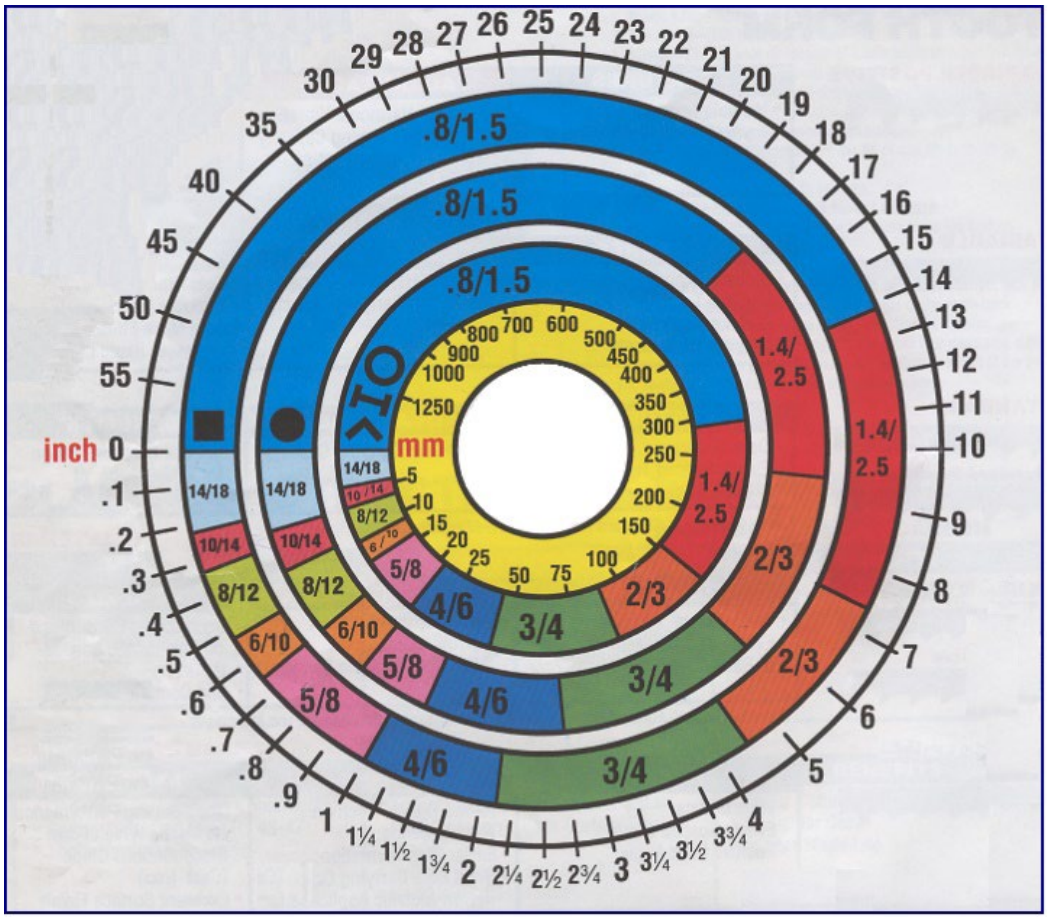
ADJUSTMENTS

TOOTH SELECTION

For maximum cutting efficiency and lowest cost per cut, it is important to select the blade with the right number of teeth per inch for the material being cut. The material size and shape dictate tooth selection.



You need to consider:

The width of the cut. That is, the distance in the cut that each tooth must travel from the point it enters the work piece until it leaves the work piece, and the shape of the work piece. Use the chart above to assist with tooth selection.

- Squares, Rectangles, Flats (Symbol: ■)
  Locate the width of your work piece on the chart. (Inches on the outer circle and millimeters on the inner circle.) Select the tooth pitch on the ring marked with square which aligns with the width of the cut.
  Example: 6” (150mm) square, use a 2/3 Vari-Tooth.

- Round Solids (Symbol: ●)
  Locate the diameter of your work piece on the chart. Select the tooth pitch on the ring marked with the circle which aligns with the size of stock you are cutting.
  Example: 4” (100mm) round, use a 3/4 Vari-Tooth.

- Tubing, Pipe, Structural (Symbols: O, H, ^)
  Determine the average width of cut by dividing the area of the work piece by the distance the saw blade must travel to finish the cut. Select the tooth pitch on the ring marked with the tubing and structural shape which aligns with the average width you are cutting.
  Example: 4” (100mm) outside diameter, 3” (75mm) inside diameter tubing.

4"(100mm) OD	=12.5 in^2 (79 cm^2)
3"(75 mm) ID	= 7.0 in^2 (44 cm^2)
Area	= 5.5 in^2 (35 cm^2)

5.5 in^2 (35 cm^2) / 4" (100mm) distance = 1.38” (35 mm) average width 1.38" (35 mm), use a 4/6 Vari-Tooth.

BLADE SPEED

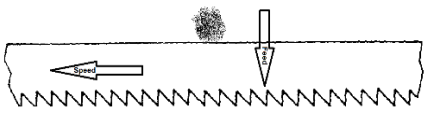
The band speeds are to be used as a starting point for most application. For exact parameters consult your saw blade supplier.

Material	Speed (FPM)
Tool, Stainless, Alloy Steels, Bearing Bronze	114
Med. to High Carbon Steels, Hard Brass or Bronze	130
Low to Med. Carbon Steel, Soft Brass	180
Aluminum, Plastic	262

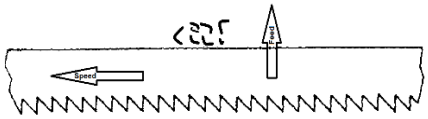
TELLTALE CHIPS

Chips are the best indicator of correct feed force. Monitor chip information and adjust feed accordingly.

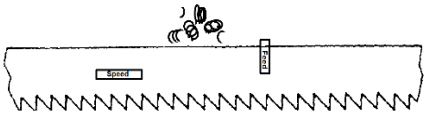
Thin or powdery chips – increase feed rate or reduce band speed.



Burned heavy chips – reduce feed rate and/or band speed.



Curly silvery and warm chips – optimum fed rate and band speed.



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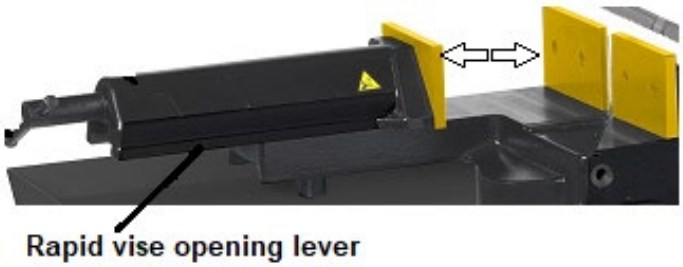
OPERATIONS

STARTING SAW

Trigger switch and lock button located on handle of the saw used for starting the saw in manual or semi-automatic mode.

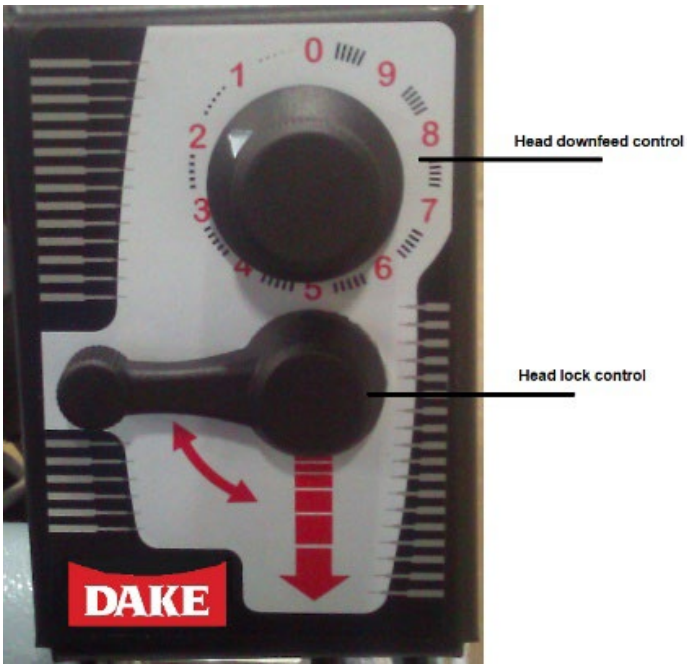
USAGE OF RAPID OPENING VISE

The workpiece is places between the vise jaws with the amount to be cut off extending out past the blade. Your machine is equipped with a “rapid vise jaw” which allows you to instantly position the movable vise jaw. This is for quick change over a different material. Simply release the lever located under the vise and move the vise jaw open or closed to the desired position. Then tighten the lever. Adjust vise normally.



DOWN FEED CONTROLS

This control regulates the speed at which the head descends and pressure. When the head lock control is all the way to the left it locks the head at any height chosen. Rotating the lever down or in any position in between allows the head to descend allowing for regulated cutting pressure.



The upper rotary control “head down feed control” varies the speed at which the head descends during the cut. The dial with numbers corresponds to the speeds and feed recommendations listed on the motor label. Turn the dial to a higher number to increase the down feed speed.

Note: If cutting in manual mode, both of these controls are to be set at their maximum settings. Be careful not to let go of the cutting head which can drop and cause injury.

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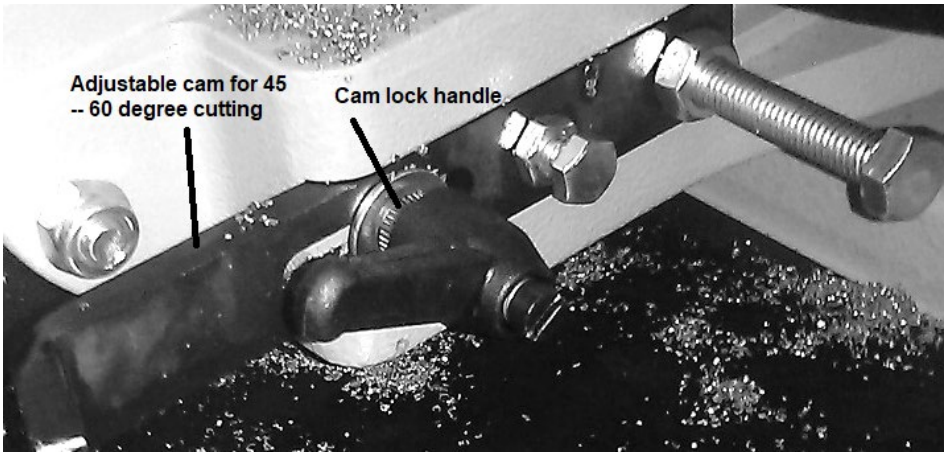
QUICK HEAD ADJUSTMENT FOR ANGLE CUTS

1. Loosen the head swivel lock handle.
2. Rotate head to the required angle by aligning indicator to the scale. Three presets can be used, or any angle in between.
3. Lock head back down.

For mitering beyond 45° slide the cam located on the left side attached to the swivel. Loosen the handle and slide the cam to allow for greater angles. This can also be used to adjust angles if needed.



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CUTTING SPEED ADJUSTMENT

The motor speed selection chart can help you figure out the best speeds for the material, blade recommendation, head feed range and corresponding reference number for the speed adjusting wheel. These are good stating points.

Always allow the blade to achieve speed before starting your cut. This saw incorporates “constant speed control” to prevent bod downs when cutting.

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MAINTENANCE

⚠ CAUTION - WARNING

Make certain that the unit is disconnected from the power source before attempting to service or remove any component.

It is easier to keep the machine in good condition or best performance by means of maintaining it at any time than remedy it after it is out of order.

Regular Maintenance Schedule:

Daily	Check and fill cutting fluid if needed, before starting the machine every day. Water soluble cutting fluid is recommended. Avoid cutting oils.
	If there is a strange or unusual noise or malfunction, stop the machine immediately to check it for the problem source. Repairs must be made by qualified personnel before continuing use.
	Clean work area.
Weekly	Clean and coat any machines surfaces with oil to prevent rust.
	Check to see if sliding surfaces and turning parts lack of lubricant. If lubrication is insufficient, fill it.
Monthly	Check electrical cord, plugs, switched at least once a month to avoid loosening or wearing.

CHANGING BLADE

Check the compatibility of the NEW blade for the saw. Only use a blade with a thickness between .025” and .035”.

Raise saw head to upper most position and open the blade guards. Loosen tension screw knob sufficiently to allow the saw blade to slip off the wheels. Install the new blade with the teeth slanted toward the motor as follow:

1. Place the blade in between each of the guide bearings.
2. Slip the blade around the motor wheel (rear) with the left hand and hold on position.
3. Hold the blade taut against the motor wheel by pulling the blade towards the front wheel with the right hand and adjust the position of the front wheel by slipping the blade around the wheel using thumb, index, and little finger as guides.
4. Adjust the blade tension knob clockwise until the green LED is lit on the no/go tensioning gauge. Do not tighten excessively.
5. Replace the blade guards. Rear blade cover has interlocks and will not allow the saw to run without these interlocks engaged.

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TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Excessive Blade Breakage	1. Materials loosen in vise. 2. Incorrect speed or feed. 3. Blade teeth spacing too large. 4. Material too coarse for blade. 5. Incorrect blade tension. 6. Teeth in contact with material before saw is started. 7. Blade runs on wheel flange. 8. Miss-aligned guide bearings. 9. Blade is too thick. 10. Cracking at weld.	1. Clamp work securely. 2. Adjust speed or feed. 3. Replace with a finer tooth spacing blade. 4. Use a blade at slower speed with proper teeth spacing. 5. Adjust to where the green LED lights up. 6. Place blade in contact with work after motor is started. 7. Adjust wheel alignment. 8. Adjust guide bearings. 9. Use a thinner grade. 10. Reweld blade.
Premature Blade Dulling	1. Teeth too coarse. 2. Blade speeds too fast. 3. Inadequate feed pressure. 4. Hard spots or scale on material. 5. Work hardening of material. 6. Blade twist. 7. Insufficient blade tension. 8. Blade slips.	1. Use finer teeth. 2. Reduce speed. 3. Adjust pressure setting. 4. Reduce speed, increase feed pressure. 5. Increase feed pressure. 6. Replace with a new blade and adjust blade tension. 7. Tighten blade tension adjustment knob. 8. Tighten blade tension.
Unusual Wear on Side/Back of Blade.	1. Blade guides worn. 2. Blade guides not adjusted properly. 3. Blade guides are loose.	1. Replace. 2. Adjust. 3. Tighten.
Teeth Ripping from Blade	1. Tooth too coarse for work. 2. Too heavy of pressure; too slow of speed. 3. Vibrating workpiece. 4. Gullets loading up.	1. Use finer tooth blade. 2. Decrease pressure, increase speed. 3. Clamp workpiece securely. 4. Use coarser tooth blade or brush to remove chips.

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Bad Cuts (Crooked)	1. Feed pressure too great. 2. Guides not adjusted properly. Too far from work. 3. Inadequate blade tension. 4. Dull blade. 5. Blade speed is incorrect. 6. Blade guide assembly loose. 7. Blade tracking too far away from wheels.	1. Reduce pressure. 2. Adjust guides closer to work. 3. Increase blade tension. 4. Replace blade. 5. Adjust speed. 6. Tighten. 7. Re-track blade.
Bade Cuts (Rough)	1. Too much speed or feed. 2. Blade is too coarse. 3. Blade tension loose.	1. Decrease speed or feed. 2. Replace with finer blade. 3. Adjust blade tension.
Blade is twisting.	1. Cut is binding blade. 2. Too much blade tension	1. Decrease feed pressure 2. Decrease blade tension.

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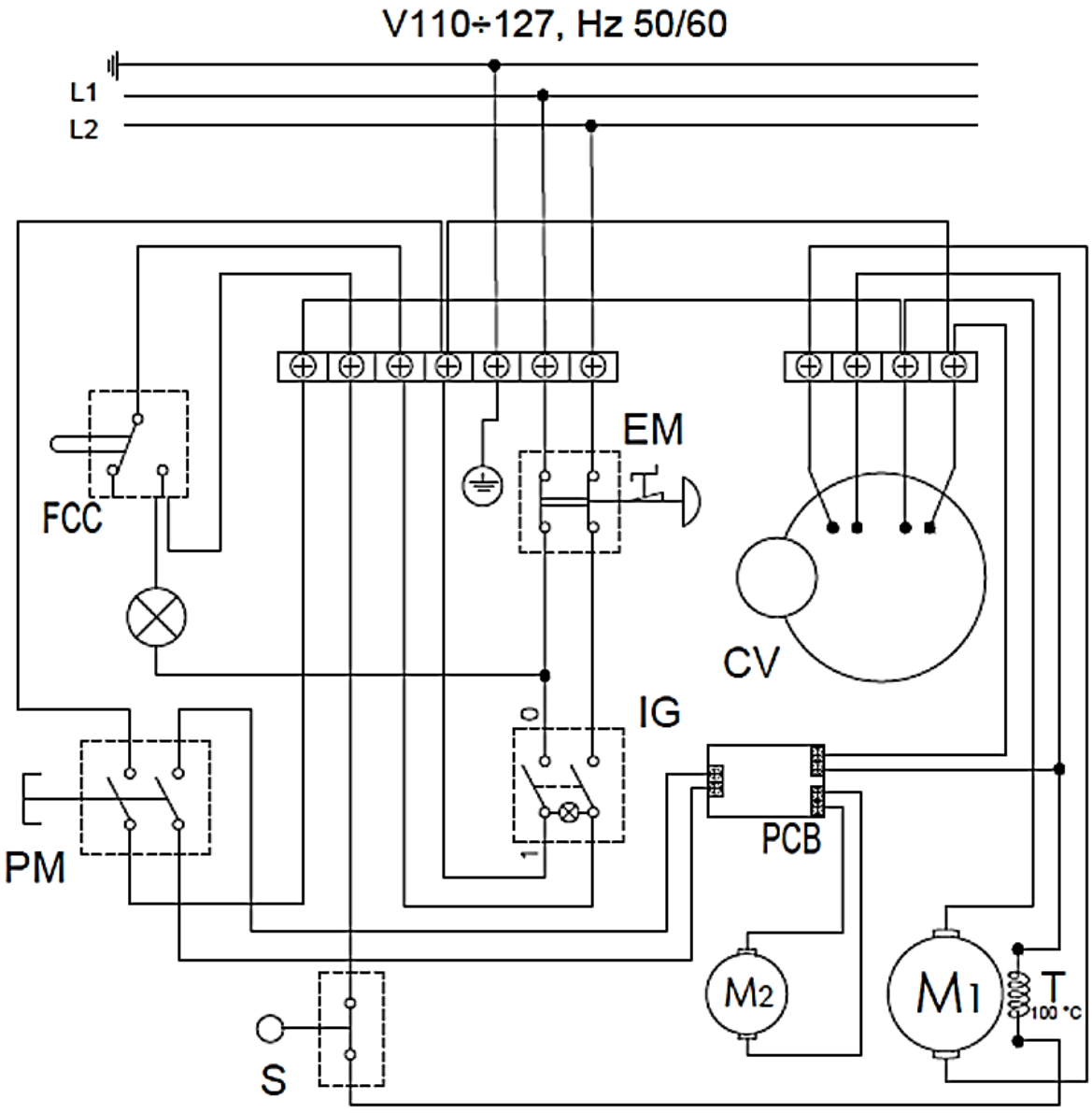
ELECTRICAL DIAGRAM



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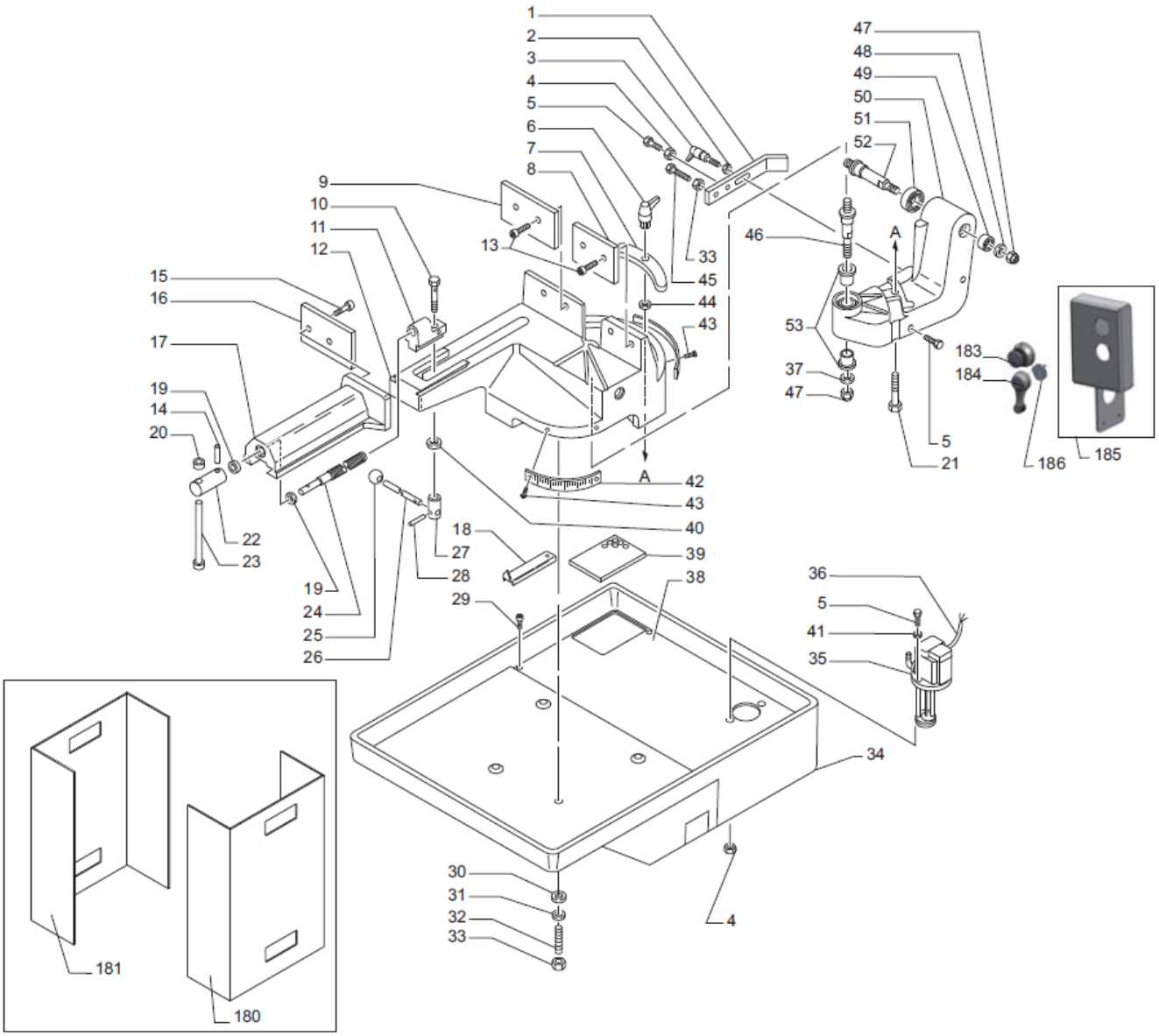
EXPLODED VIEWS & PART LIST



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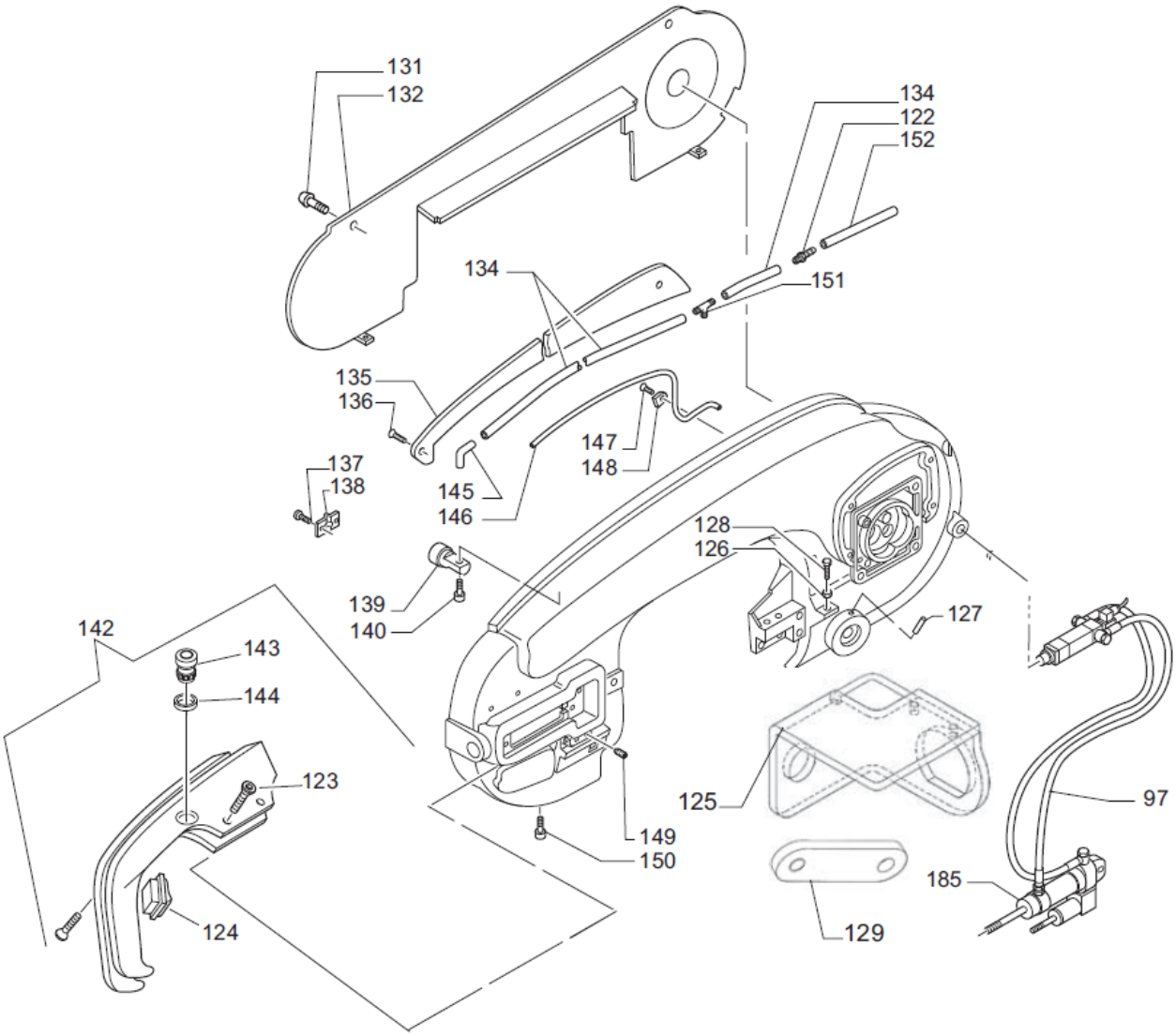

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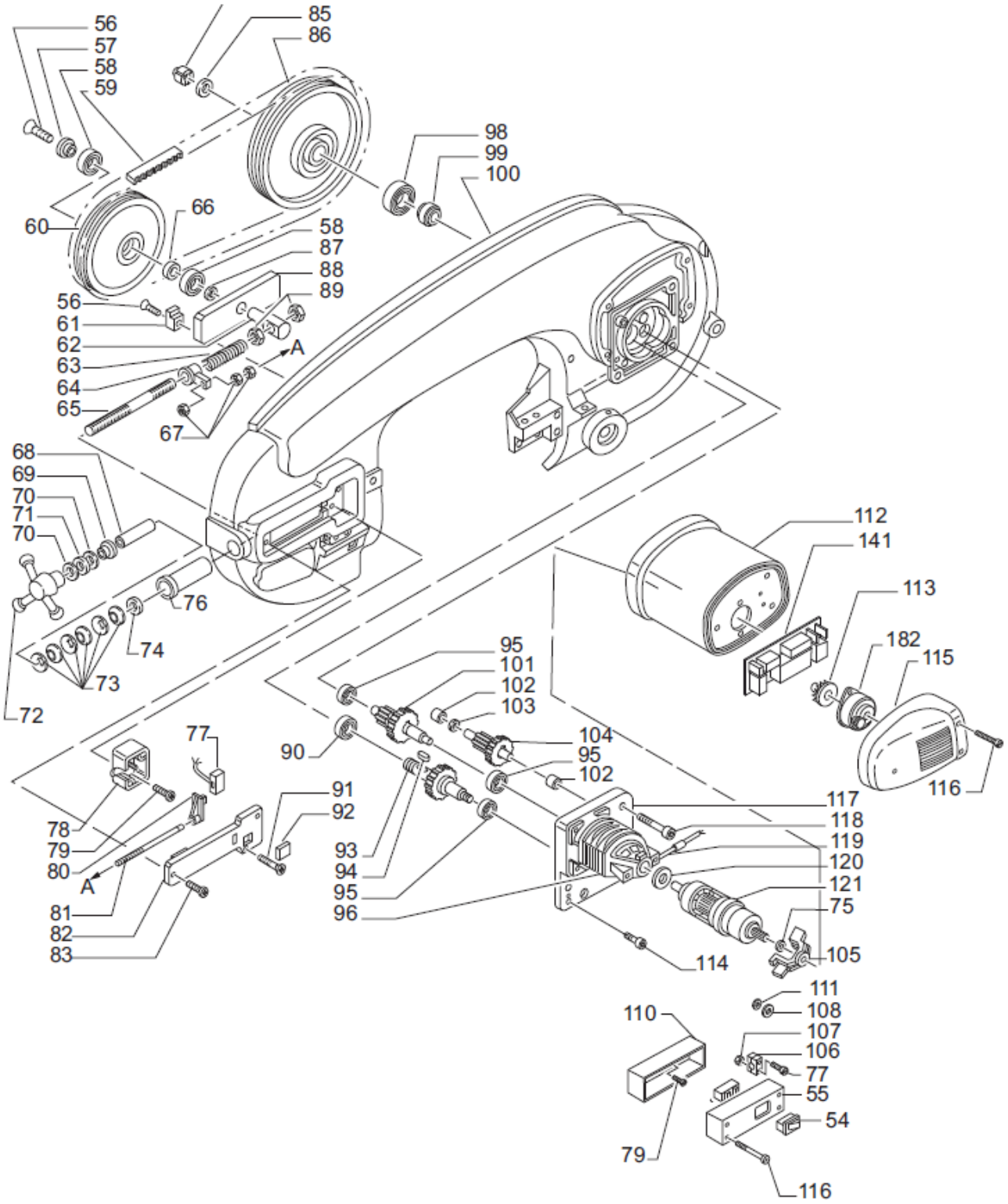

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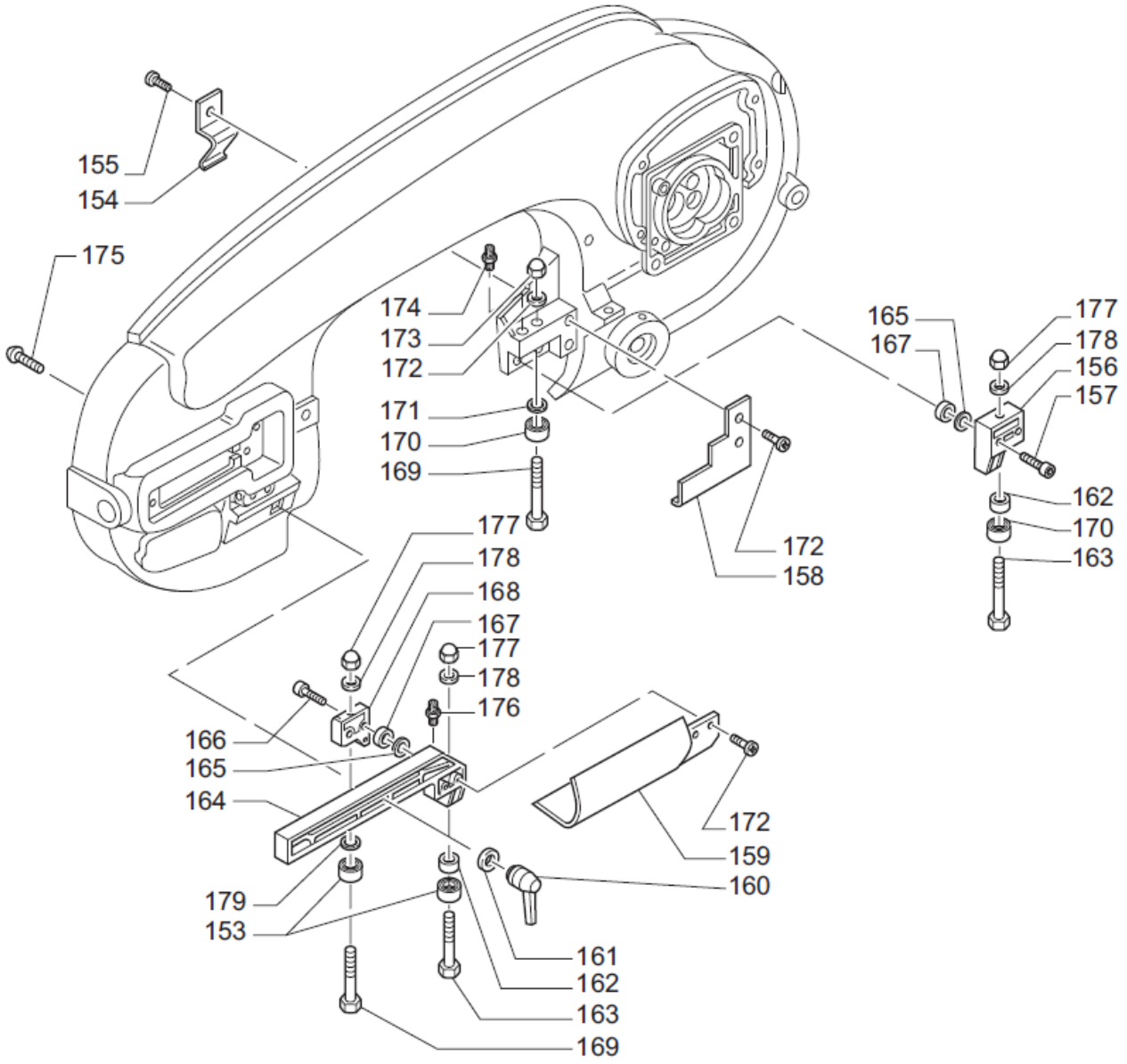

Pos.	Description	Dake Part #	Reference #
1			5.13.07.96
2	Washer, Plain		UNI 6592 Ø 6.5X18
3			0.14.70.07
4	Nut, Hex		UNI 5588 M6
5	Bolt, Hex		UNI 5737 M6x20
6	Handle, Miter Vise Adjust		6.14.70.17
7			5.18.25.32
8	Vise Plate, Small Stationary		5.15.25.94
9	Vise Plate, Left Stationary		5.15.25.95
10	Bolt, Round Head Square Neck		UNI 5732 M14x70
11	Vise Nut		5.13.08.64
12	Vise Base - Cast		5.13.79.63
13	Screw, Soc Head Cap		UNI 5931 M8x20

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Pos.	Description	Dake Part #	Reference #
14			0.15.26.30
15	Screw, Soc Head Cap		UNI 5931 M8x20
16	Vise Plate, Movable		5.15.26.11
17	Cover, Vise Screw		5.13.08.63
18	Index	303393	5.15.95.17
19	Washer, Plain		UNI 6592 Ø14
20	Knob, Vise Handle		0.14.00.59
21	Bolt, Hex threaded fully		UNI 5739 M12x50
22	Head, Vise Screw		5.17.10.40
23	Rod, Vise Handle		5.14.20.23
24	Vise Screw		5.10.03.34
25			0.14.00.73
26			5.14.20.90
27			5.17.10.35
28			0.15.24.30
29	Screw, Cross Pan Head Tapping		UNI 6954 P8x9.5
30			5.12.40.33
31			0.12.07.08
32	Screw, Set, Flat Point		UNI 5923 M8x35
33	Nut, Hex		UNI 5588 M8
34	Saw Bed		5.13.38.03
35	Coolant Pump	303392	7.11.35.25
36			5.87.10.72
37	Washer		UNI 6592 Ø16
38			5.18.25.33
39	Filter, Coolant Tank	303391	5.18.25.34
40			5.12.40.56
41	Washer, Plain		UNI 6592 Ø6
42	Angle Graduate Plate	303471	7.07.50.64
43			0.40.29.05
44			0.12.40.32
45	Bolt, Hex		UNI 5737 M8X50
46			5.17.10.38
47			0.10.17.16
48	Washer, Plain		UNI 6592 Ø16
49			0.60.62.03
50	Swivel Base - Cast		5.13.81.00
51	Bearing		0.60.63.06
52			5.17.10.39
53			5.06.30.36
54	Switch	303390	0.80.23.16
55			5.18.25.04
56	Screw, Hex Soc Countersunk		UNI 5933 M8x25
57			5.12.40.60
58	Bearing		0.60.62.04
59	Belt		3.27.73.97
60	Idle Wheel	303475	5.21.42.24
61			5.13.07.46
62			5.00.15.62
63			5.08.10.07

Pos.	Description	Dake Part #	Reference #
64			5.14.20.58
65			5.10.05.05
67			5.12.06.61
68	Nut, Hex		UNI 5588 M4
69			5.12.20.17
70			5.12.40.30
71			0.71.15.28
72	Handle, Blade Tensioning		0.14.00.99
73			0.08.02.60
74			0.08.02.60
75	Bushing, Rubber	304212	5.06.10.38
76			5.06.60.16
77	Limit Switch	303434	0.80.11.01
78			5.18.28.42
79	Screw, Self-Tapping		DIN 7500 M5x10
80	Button, Limit Switch	303462	5.14.30.05
81			5.14.20.59
82	Cover	304260	5.18.25.23
83	Screw, Filister		UNI 7687 M4x10
84			0.10.61.20
85	Washer, Plain		UNI 6592 Ø20
86	Drive Wheel	303474	5.21.40.26
87			0.15.51.49
88			5.13.07.95
89	Nut, Thin Hex		UNI 5589 M12
90	Bearing		0.60.62.04
91	Screw, Cross Pan Head Tapping		UNI 6954 P7x16
92	Pilot Light	303425	0.89.40.07
93	Gear Assembly	303468	7.21.30.06
94	Key		0.15.01.39
95	Bearing		0.58.62.00
96			5.02.41.22
97	Hydraulic Cylinder Assembly	303464	7.24.10.09
98	Bearing		0.60.60.07
99			5.12.40.54
100	Upper Frame		5.04.29.23
101	Gear Assembly	303435	7.21.30.05
102			0.73.12.12
103			0.12.40.26
104	Gear	303470	7.21.30.04
105	Support, Motor Brush	304211	5.85.00.06
106			5.15.45.01
107	Nut, Hex		UNI 5588 M4
108			0.18.10.21
109	Elec. Speed Regulator	303465	7.82.01.54
110			5.18.28.23
111			0.18.10.18
112			5.18.28.43
113	Motor Fan with Magnetic Ring	303473	5.85.01.11
114	Screw, Soc Head Cap		UNI 5931 M6x20

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Pos.	Description	Dake Part #	Reference #
115			5.18.25.25
116	Screw, Filister		UNI 7687 M5x35
117	Motor – Internals only	303472	7.80.16.11
118	Screw, Soc Head Cap		UNI 5931 M6x40
119			0.91.60.05
120			5.06.10.41
121			7.01.31.58
	Motor Complete	304217	7.80.16.11
122			0.24.14.43
123			0.40.05.13
124	Switch, “On”	303431	0.80.26.11
125			5.13.80.99
126	Nut, Hex		UNI 5588 M10
127	Screw, Set Cone Point		UNI 5927 M8x10
128	Screw, Soc Cap w/ full dog point		UNI 5925 M10x45
129			5.13.10.13
130	Washer, Plain		UNI 6592 Ø5
131			0.32.06.12
132	Blade Cover, Back	303467	5.18.18.58
133			0.12.33.15
134			1.85.58.03
135			5.18.16.88
136	Screw, Self-Tapping		DIN 7500 M5x10
137	Screw, Self-Tapping		DIN 7500 M5x16
138			5.15.25.96
139			7.13.05.67
140	Screw, Soc Head Cap		UNI 5931 M5x16
141	Electronic Card	303389	7.82.01.21
142	Handle Assembly (Includes pos. 123, 124, 143 & 144)	303463	7.13.07.40
143			0.80.60.29
144			5.12.40.91
145			0.24.13.67
146			5.87.36.06
147	Screw, Self-Tapping		DIN 7500 M2x15
148			5.15.41.03
149	Screw, Set Cone Point		UNI 5927 M6x10
150	Screw		0.41.06.34
151			0.24.13.66
152			1.85.58.05
153	Ball Bearing		7x19x6 2RS
154			5.18.18.71
155	Screw		UNI 7987 M6x10
156			5.13.07.47
157	Screw, Soc Head Cap		UNI 5931 M8x30
158	Blade Guard. Right		5.18.18.72
159	Blade Guard, Left		5.18.18.32
160	Handle, Blade Guard	303466	0.14.70.02
161			0.12.40.29
162			0.06.30.25

Pos.	Description	Dake Part #	Reference #
163			5.10.00.69
164	Bracket, Blade Guide		5.13.09.42
165			0.12.40.27
166	Screw, Soc Head Cap		UNI 5931 M6x25
167			0.60.06.26
168			5.13.09.43
169			5.10.00.70
170	Ball Bearing		7x19x6 2RS
171			5.12.06.38
172	Washer, Plain		UNI 1751 Ø6
173	Nut, Cap		UNI 5751 M6
174			0.24.14.42
175	Bolt, Round Head Square Neck		UNI 5732 M10x40
176			0.24.14.42
177	Nut, Cap		UNI 5721 M6
178	Washer		UNI 1751 Ø6
179			5.12.06.38
180	Base Half		5.13.38.28
181	Base Half		5.13.28.29
182			7.82.01.54
183	Knob, Feed Speed		5.14.00.71
184	Knob/Lever Blade Feed		5.14.21.14
185	Hydraulic Valve Assemblies	304271	5.13.80.98
Hydraulic Assembly (Includes Items 97 & 185, knobs not included)		303464	7.24.10.09
Blade - 84.5" x 3/4" 10/14 TPI .035		303506	
Blade - 84.25" x 3/4" 6/10 TPI .035		303601	

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.