



DAKE VERTICAL BAND SAW


Model V-26 E

INSTRUCTION MANUAL



V-26 shown

Please record your saws information

 a JSJ business		VERTICAL BANDSAW	
MODEL	V-26 E	MOTOR	2.2 KW
WELDER	4.2 KVA	CONTROL VOLT	110 V
VOLTAGE	220 V	TORQUE MOTOR	0.01 KW
		FREQUENCY	60 Hz
SER. NO	<input type="text"/>	DATE	<input type="text"/>
www.dakecorp.com			

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FOREWARD

First of all, we would like to take this opportunity to thank you for selecting our Dake V-26 E model vertical Bandsaw.

As you know, the vertical bandsaw is a universal saw for contour cutting. Blade selection is important and by choosing the right blade, you can make most any pattern cutting on most any material with this machine. However, the most important thing is to realize how to operate it in a safe and correct way and how to maintain it.

We have tried to supply you all the information about these. Please be sure to look through all the contents in this manual so that you may obtain the maximum efficiency and the longest machine life with minimum expense.

The specifications and information in this manual were current at the time this manual was approved for printing. Dake, whose policy is one of continuous improvement, reserves the right, however, to change specifications or design at any time without incurring obligations.

Always include the part number, model number, and parts description, for parts orders or correspondence concerning your bandsaw, so we can supply you a rapidly after-sales service.

▲WARNING

1. Read the operator's manual carefully. Learn the tools applications and limitations, as well as the specific potential hazards peculiar to it.
2. Always wear approved safety glasses/face shields while using this machine.
3. Make certain the machine is properly grounded.
4. Before operating the machine, remove tie, rings, watches, other jewelry, and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. DO NOT wear gloves when operating.
5. Keep the floor around the machine clean and free of scrap material, oil and grease.
6. Keep machine guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
7. DO NOT over reach. Maintain a balanced stance at all times so that you do not fall or lean against blades or other moving parts.
8. Use only sharp blades. Dull blades are dangerous.
9. Make all machine adjustments or maintenance with the machine unplugged from the power source.
10. Use the right tool. Don't force a tool or attachment to do a job which it was not designed for.

11. DO NOT make cuts requiring more power than is available on the machine.
12. Replace warning labels if they become obscured or removed.
13. Make certain the motor switch is in the OFF position before connecting the machine to power.
14. Give your work undivided attention. Looking around, carrying on a conversation. And “horse-play” is careless acts that can result in serious injury.
15. Make a habit of checking to see that keys and adjusting wrenches are removed before turning on the machine.
16. Keep visitors a safe distance from the work area.
17. Use recommended accessories; improper accessories may be hazardous.
18. Never place hands directly in line with the saw blade.
19. Always use push sticks when cutting small material.
20. Raise or lower the blade guide only when the machine has been turned off and the blade has stopped moving.
21. Read and understand warnings posted on the machine.
22. DO NOT use attachments for any other purpose than for what they were designed for.
23. Failure to comply with all of these warnings could lead to serious injury.

INSTALLATION

WARNING!!!

The machine table must NOT be used as a lifting point. Damage to the saw could occur.

UNLOADING: Remove the shrink-wrap covering the machine, careful not to damage painted surfaces. **Carefully inspect the machine for physical damage. If damage is noted, notify the truck line at once. They may require inspection, and that a claim be filed.** Check that all standard accessories are with the machine. Some accessories may be boxed or placed behind the rear access door. The band saw is provided with a lifting eye that is screwed into the top of the machine. This lifting eye may be located in the rear compartment.

Particular care should be taken in selecting areas of the machine for handling, as electrical components and adjustment knobs can be marked up or damaged. Remove the mounting bolts holding the machine to the skid, using the lifting eye, remove the machine from the skid and set in designated area.

CLEANING

1. Remove anti-rust oil.
2. Remove the coating with a clean brush applied with appropriate solvent.
3. When the coating has been softened, remove it with clean rag.

POWER SUPPLY

1. Shut off the main power switch before connecting cable.
2. Check motor voltage against supply voltage.
3. Make sure the power supply is connected to comply with the local safety regulations.
4. Your saw may be pre-wired with a power cable attached. This cable can be hard wired or the preferred method of installing a properly rated quick disconnect.
5. The leads connect to L1, L2, and L3 and ground. The bandsaw must be grounded.
6. Check that the blade is running in the correct clockwise direction. If the blade runs backwards, disconnect the power. Then reverse any two of the three L1, L2, and L3 leads. Do not reverse the ground.

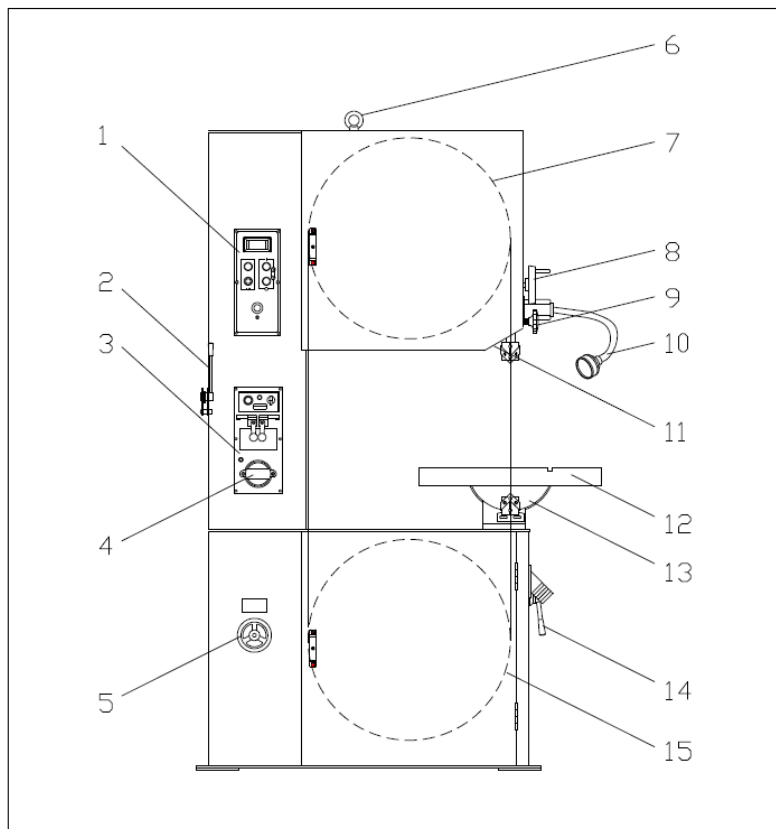
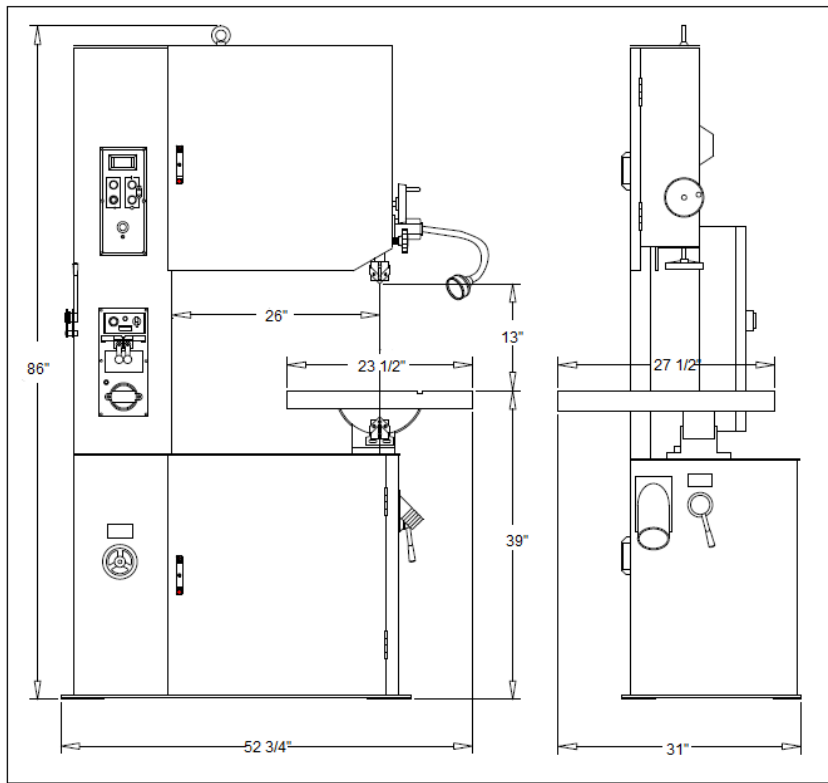
▲ WARNING

All electrical connections must be done by a qualified electrician. Failure to comply may cause serious injury!

All adjustment or repairs must be done with the machine disconnected from the power source. Failure to comply may result in serious injury!

SPECIFICATIONS

Capacity	26" X 13"
Blade Width Cap.	1/8" ~ 1"
Blade Speed	50 - 5,000 fpm
Table Size	23.5" x 27.5"
Table Travel	12"
Table Force	80 kgcm max.
Table Speed (No Load)	Forward 12" in 28 seconds, Reverse 12" in 24 seconds
Table Tilt	R-45 ° , L-10 °
Main Drive Motor	230 volt 3 Phase, 3 HP
Grinder Motor	110V, 1 Phase, 0.04 KW
Blade Length	184"
Blade Welder Cap	4.2 KVA, 1/8" ~ 3/4"
Band Wheel Diameter	26"
Table Height	39"
Dimension	52 3/4" (Length) 31" (Width) 86" (Height)
Mach. Weight	1,377lbs.



1	Control Panel	8	Guide Post Lifting Wheel
2	Blade Shear	9	Guide Post Locking Knob
3	Welder Panel	10	Work Lamp
4	Grinding Wheel Motor	11	Blade Guide Holder
5	Variable Speed Handwheel	12	Work Table
6	Lifting Eye	13	Table Support Housing
7	Upper Wheel	14/15	Low / High Range Lever, Lower Wheel

▲CONTROLS

Low/High Range Shift Lever –

Located on right side of machine base. Pull toward the front of the machine to shift into the low speed range. Push toward the rear of the machine to shift into the high-speed range. Caution: Do not change the speed range while the machine is running. Adjust only when the machine is stopped NOTE: If the lever will not mesh the speed range, slightly rotate the band wheel and the lever will go into gear.

Variable Speed Hand Wheel –

Located below the worktable on right side of machine base. Turn clockwise to increase speed and counter-clockwise to decrease speed.

Caution: Do not turn handle while machine is stopped. Adjust speed only when machine is running. RPMs will be displayed on the control panels digital readout.

Upper Guide Post Lock Knob –

Located on right side of upper frame. Turn counter-clockwise to loosen and clockwise to tighten. Always support the guide post when adjusting this knob to prevent unexpected dropping of the guide post.

Work Lamp Switch – Turn lamp on and off. Caution must be used as light will be hot.

Blade Shear Lever –

Located on upper left hand side of the column. Lever up position allows insertion of the blade into the shear. Pull lever downward to cut the blade. (This shear unit must be mounted during set up)

Grinder Toggle Switch –

Located on the blade welder panel found on columns front. Flip switch up to start grinder; flip down to stop grinder. This motor has temperature protection which will turn off the power automatically when the motor is over-heating. Motor will reset once it cools down.

Weld Button –

Located on the blade welders panel found on the front of the column. Depress and hold to start welding. Shuts off automatically when weld is done. Release when weld is completed

Anneal Button –

Located on the blade welders panel found on the front of the column. Depress and hold to anneal blade, release to stop.

Blade Clamp Pressure Knob –

Located on the blade welders panel found on front of the column. Sets pressure for different width blades.

Blade Clamps –

Located on the blade welder panel found on the front of the column. Down position allows insertion of the blade into the clamp. Up position locks blade

Blade Tension Hand Wheel –

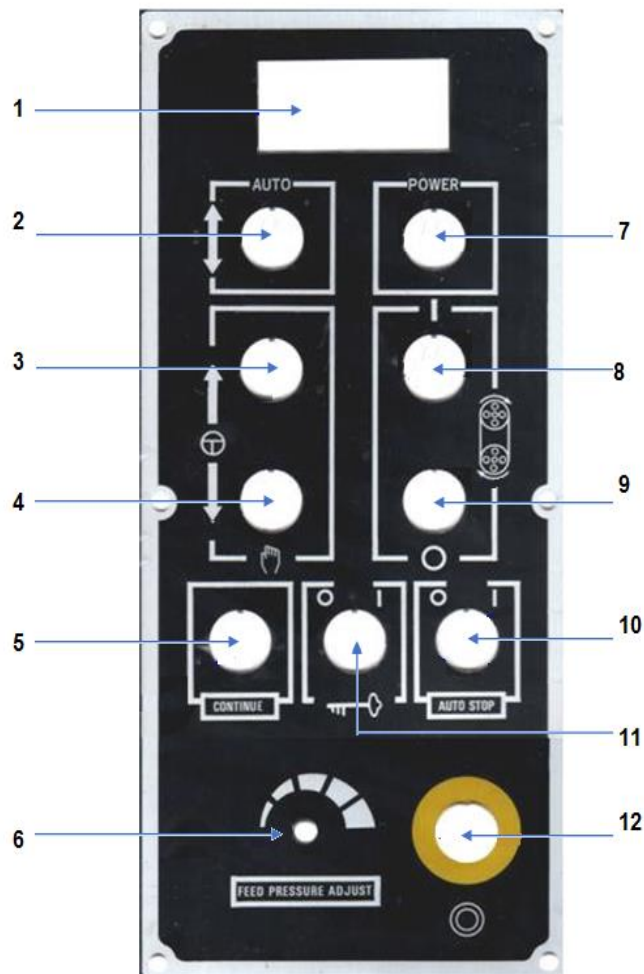
Located on underside of the upper frame. Turn clockwise to tension the blade; counter-clockwise to release tension on the blade.

Blade Tracking Hand Wheel –

Located at the upper rear of the saw. Turn clockwise to track the blade toward front of the blade wheel Turn counter-clockwise to track blade toward rear of the blade wheel. (Do not let the blade ride up onto the wheel lip)

Table Tilt Mechanism – Located under worktable. To tilt table left or right, loosen hex cap

screws at the rear of the mechanism. Always tighten table bolts before operating the saw



Control Panel:

1. Digital Readout- Located on control panel. Shows blade speed in feet per minute. Note: When starting up or changing speed, allow time for the readout to stabilize to the new setting.

2. Automatic Cutting Switch – Press this button to make the table travel forward and reverse automatically.

3. Table Manual Forward Switch – Press this button to make the table travel forward, release to stop.

4. Table Manual Reverse Switch – Press this button to make table travel reverse, release to stop

5. Continue Cutting Select Switch – Turn “ON” this button to make continuous cuts.

6. Table Feed Pressure Selector – Adjust the feed pressure. Rotate from 9 o’clock position (minimum) to 3 o’clock position (maximum).

7. Power indicator Light – Indicates that power to the control panel is on.

8. Main Motor Start Switch –Depress to start bandsaw

9. Main Motor Stop Switch –Depress to stop bandsaw.

10. Automatic Stop Select Switch –Turn “ON” this button while cutting work piece. machine will stop automatically after the cut is finished. Turn “**OFF**” this button after finishing to return to normal work.

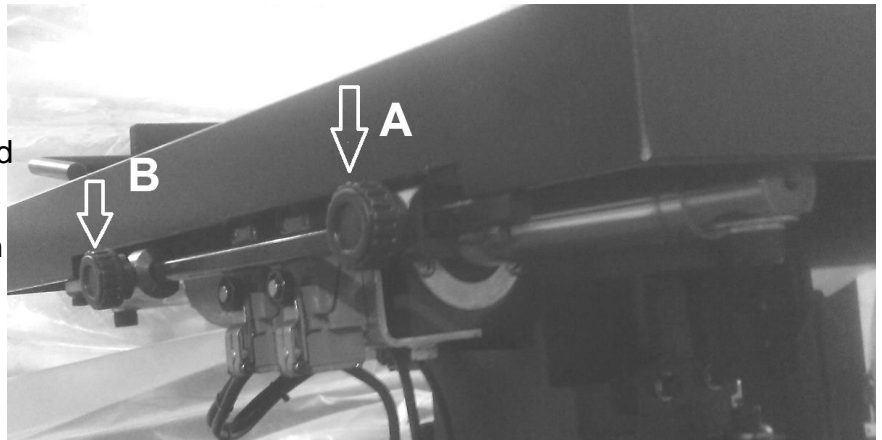
11. Key Lock Switch– Turn the key to the 12 o'clock position and remove key to lock out power from the control panel.

12. Emergency Stop Switch –

Press to stop the machine. Turn knob 90° to reset.

MANUAL CUTTING, TABLE STATIONARY

1. Adjust table all the way forward
2. Make sure “Auto-stop” is off.
3. Depress the motor start button
4. Adjust your blade speed.
5. Begin free hand cutting.



AUTOMATIC CUTTING

Please make sure that the “Auto Stop” switch is in the “**OFF**” position before making this adjustment.

1. Turn “pressure selector knob” all the way to the maximum. (3 o'clock setting)
2. Depress manual forward and reverse buttons to make table travel. Adjust limits as follows.
3. Adjust the forward limit switch to the position (B) where you want the cut to stop. Adjust knob to just trip the limit switch.
4. Adjust the reverse limit switch to the position (A) where you want the cut to start. Adjust knob to just trip limit switch.
5. Adjust table to the start position, load material, set “pressure selector knob” to the minimum (9 o'clock) position that forces the table travel to start at a slow rate
6. Depress “machine start switch”. (Adjust blade speed if needed) Using the manual reverse switch run the blade up to the material.
7. Depress “automatic” button, to make the table travel and slowly start cutting the work piece. Adjust to proper cutting pressure. Adjust “pressure selecting knob” to the position where the work is being cut safely and efficiently.
8. At the end of the cut the blade will keep running and back itself out of the cut. Shut the blade off with main motor off button.
9. To stop the blade at the end of cut switch “Auto Stop switch on when the cut starts. Remove piece and turn off Auto Stop. Blade and table movement will shut off at the end of the cut.

CONTINUOUS CUTTING

Set up stops as mentioned above. Depress “continuous cutting switch”, this will provide a

continuously cutting cycle for light material.

SINGLE PIECE CUTTING

Switch on “automatic stop selector” knob when the saw is cutting. Machine will stop automatically after the cut is finished.

▲NOTE

Depress “manual-reverse” button to back the work piece from the blade if there is any damage or binding to the blade while cutting, or when table travel set up needs adjusting. However, be sure to adjust feeding pressure lower when reversing out of a cut, to resume the cut the work piece cut should be close to the blade before you start to feed the table again. Do not start blade if the teeth are in contact with the material.

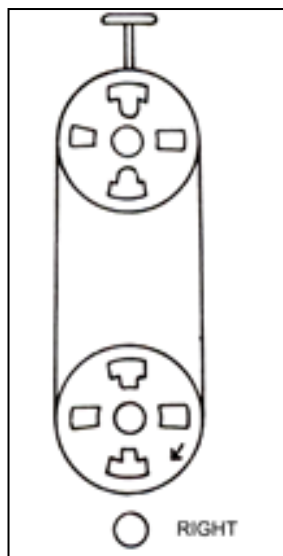
“Table Feed Pressure Selector” is just to adjust the pressure of table feed, not for the “feeding speed”.

OPERATIONS

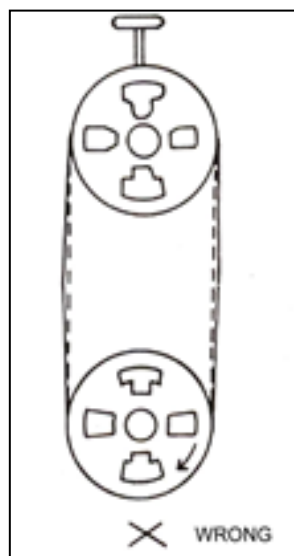
BLADE INSTALLATION

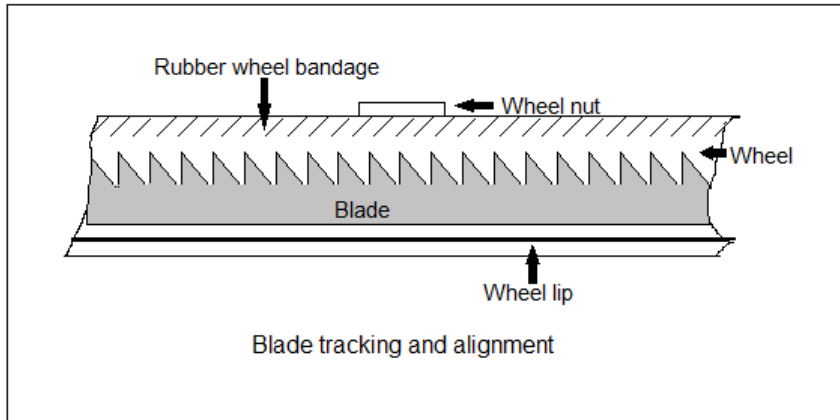
1. Install the blade as illustrated through the guides and onto the upper and lower wheels. Replace any guarding that was removed after blade is installed.
2. Adjust blade tension per the tension scale by turning the blade tension adjustment hand wheel. The scale is visible from the rear side.
3. Jog the machine to see if the blade tracks properly, adjust blade tracking by turning the tracking adjuster when it is necessary. (See blade tracking section on next page for further details)

Proper tensioning



Improper tensioning





BLADE TRACKING

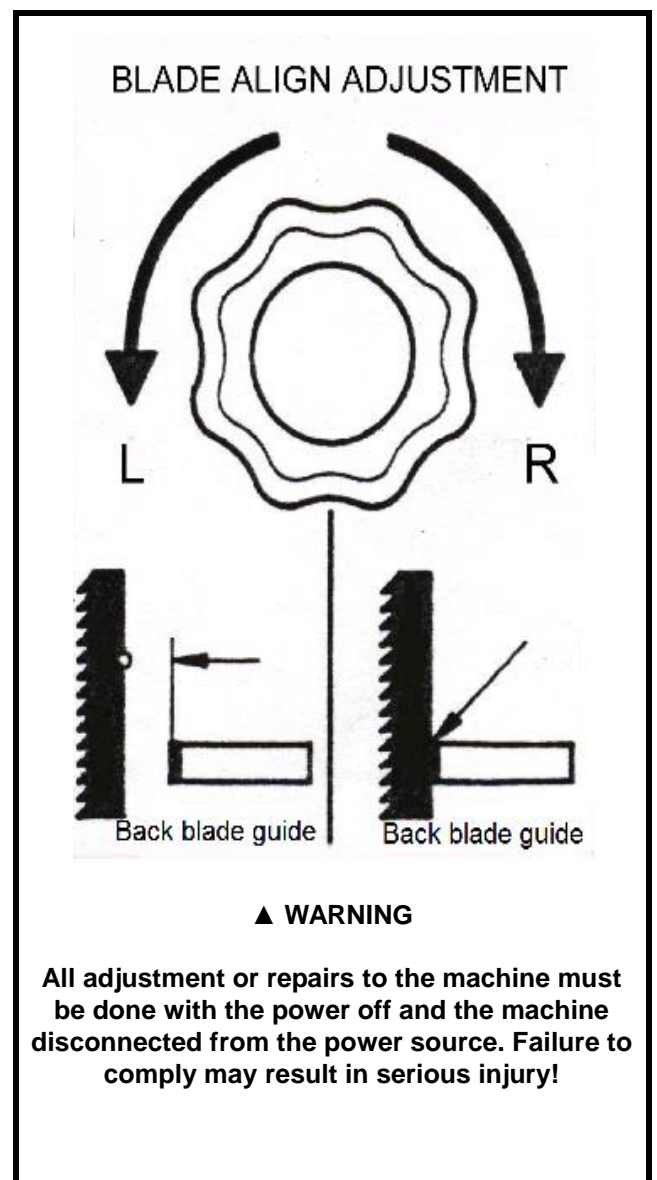
Blade tracking may be required from time to time depending on the blade size and tension. Disconnect the machine from the power source and open both blade wheel doors. Shift the high-low gearbox lever into the neutral position. Turn the upper blade wheel by hand while observing blade position on the upper blade wheel to determine if adjustment is necessary:

- a. Turn blade tracking knob clockwise to track blade toward front of blade wheel.
- b. Turn counter-clockwise to track blade toward rear of blade wheel. Blade should be tracked as close of the center of the top blade wheel as possible. Do not allow blade to run on the wheel lip.

▲Note: Upper and lower blade guides should be moved away and left loose from the blade while tracking adjustments are being made.

GUIDE POST ADJUSTING

1. Loosen the guide post locking knob. Always support the guide post when loosening the guide post to prevent it from unexpectedly falling. (Figure A next page)
2. The height of the upper guide post setting is in relationship to the height of the material. The height between the material and the blade guide end is suggested to be about 1/4". (See figure B illustration on next page)
3. Lock the guide post tightly.



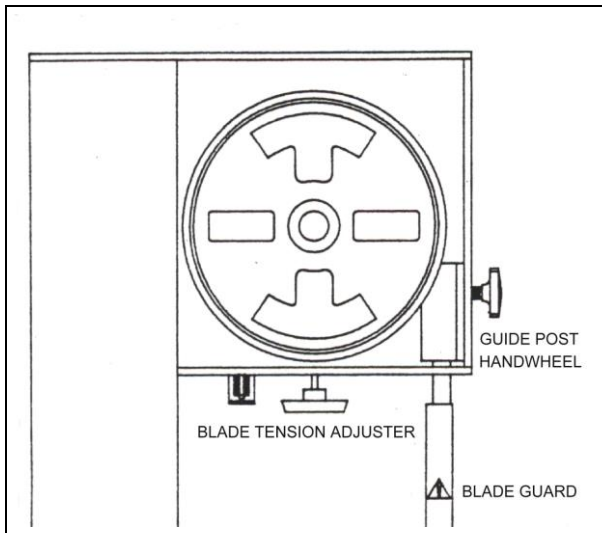


Figure A

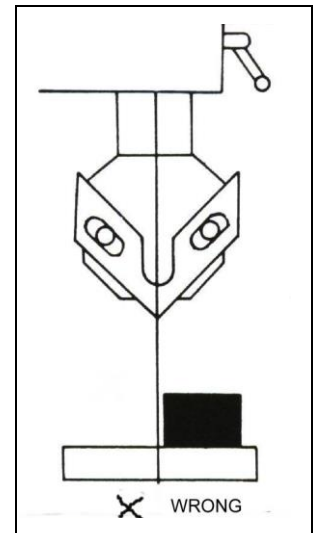
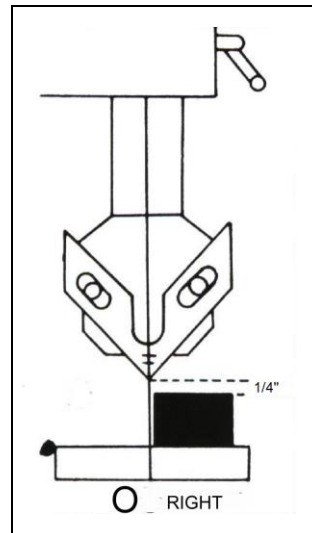
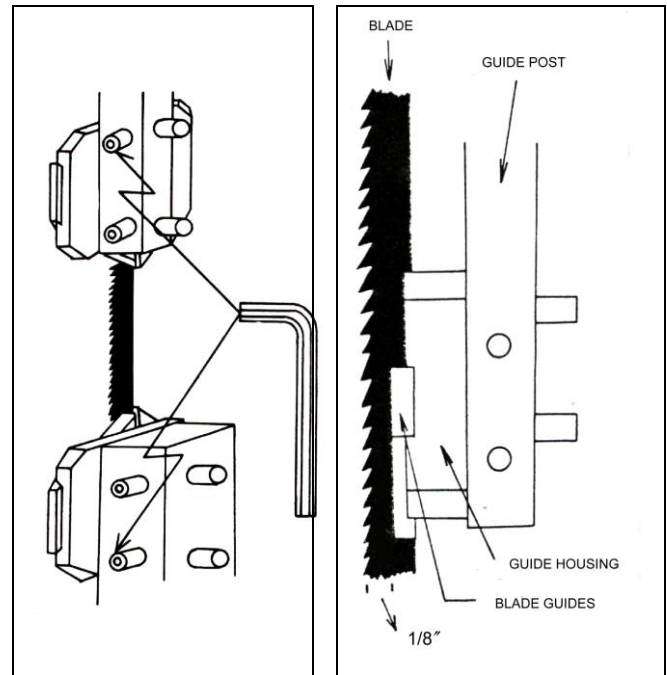


Figure B

▲ It may be necessary to open the blade guides, before you adjust the guide post to allow free movement of the guide post.

GUIDE HOLDER ADJUSTMENT

1. Loosen the inner hex screws located at the right lower side of guide post with an “L” shaped allen wrench.
2. Adjust the guide holder forward or backward according to the blade width. The front edge of the blade guides must be adjusted about 1/8” behind the blade teeth. (see figure B next page)
3. Tighten the screws securely.



BLADE GUIDE ADJUSTING

1. Loosen the inner hex screws of the blade guide with an “L” shaped allen wrench.
2. Adjust the blade guides very close to the blade but not touching the guide faces. (approx. thickness of a business card)
3. With blade tight allow guides to ride up to the blade not forcing them off center. Tighten the blade guides securely. (See figure A next page)

NOTE: There are a total of four blade guides and two guide holders located above the table and under the table, all to be adjusted to the same position.

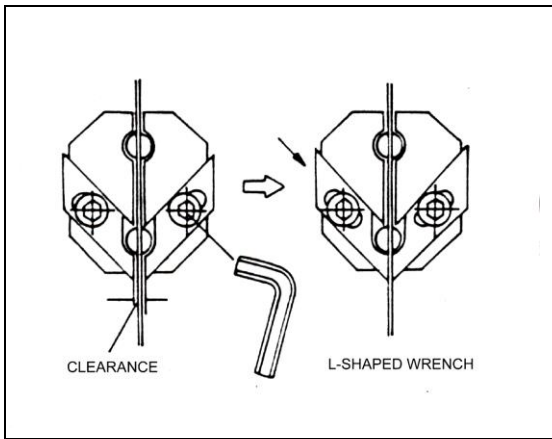


Figure A

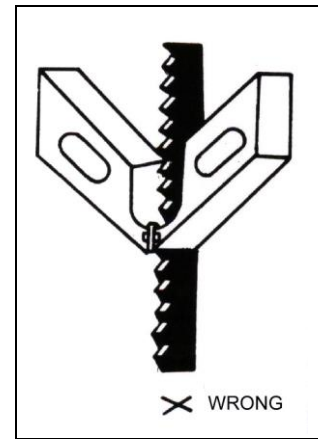
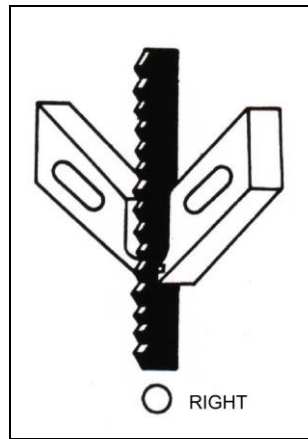
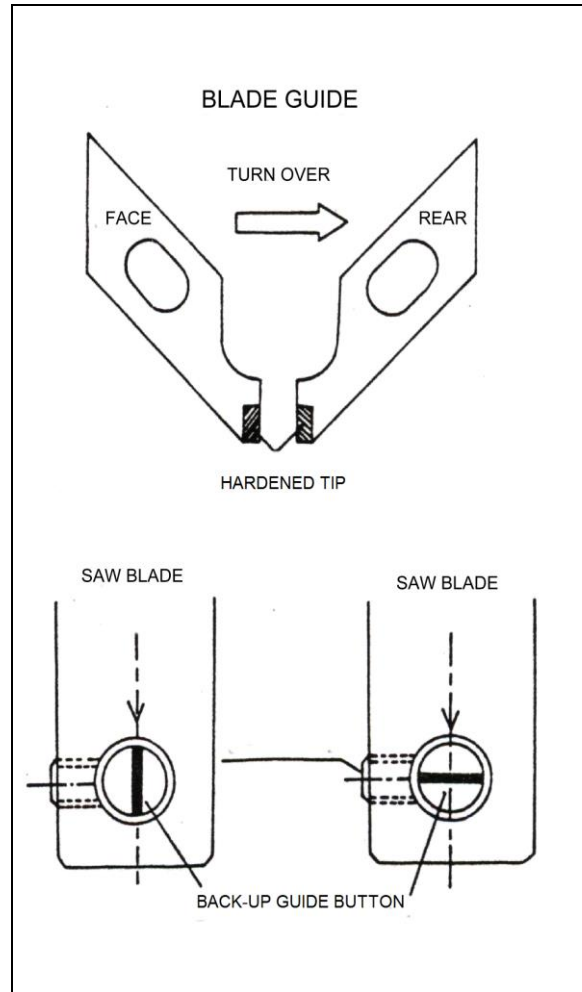


Figure B

The blade guides will wear after time at the front faces. If the blade guides become hard to be properly adjusted, turn the left blade guide over to the right side, as illustrated in the right illustration, and turn the right-side blade guide over to the left side as well. The blade guides can then be used on both sides getting more mileage out of the guides.

The backup blade guide button will wear over time as friction from the saw blade may cause a worn line on its surface. If this is found to happen, loosen the lower guide holder bolt and turn it to rotate the button shaft to change the buttons position on the saw blade.



▲ CAUTION

Blade guide must be properly adjusted or damage may occur to the blade and/or the guides.

BLADE SELECTION

To get the most satisfactory work from your saw, it is important to choose a blade that is correct for the work. Blade life, cut straightness, finishing quality and sawing efficiency is all related to the choice of blade. Blade breakage, teeth stripping, crooked cuts, and other common complaints are, in most instances, caused by using the wrong blades. Blades are classified by materials, tooth shapes, and types of set.

TYPES OF BLADES

Bandsaw blades are available in specific sizes, or in 100 feet coils. They are made from several different metals:

1. Carbon Steel Blade: which are widely used because of their general adaptability for all types of work and the low cost. They are excellent for cutting nonferrous metals and plastics.
2. High-Speed Steel Blade: which resist heat generated in cutting to far greater extent than carbon steel blades. They are best suited for cutting ferrous metals.
3. Alloy Steel Blade: which are tougher and more wear resistant than either of the above. They will cut faster and longer than blades of carbon or high-speed steel.
4. Carbide-Tipped Blade: which are best used for cutting unusual materials such as uranium, titanium, and beryllium. These metals are difficult to cut with other types of blades.

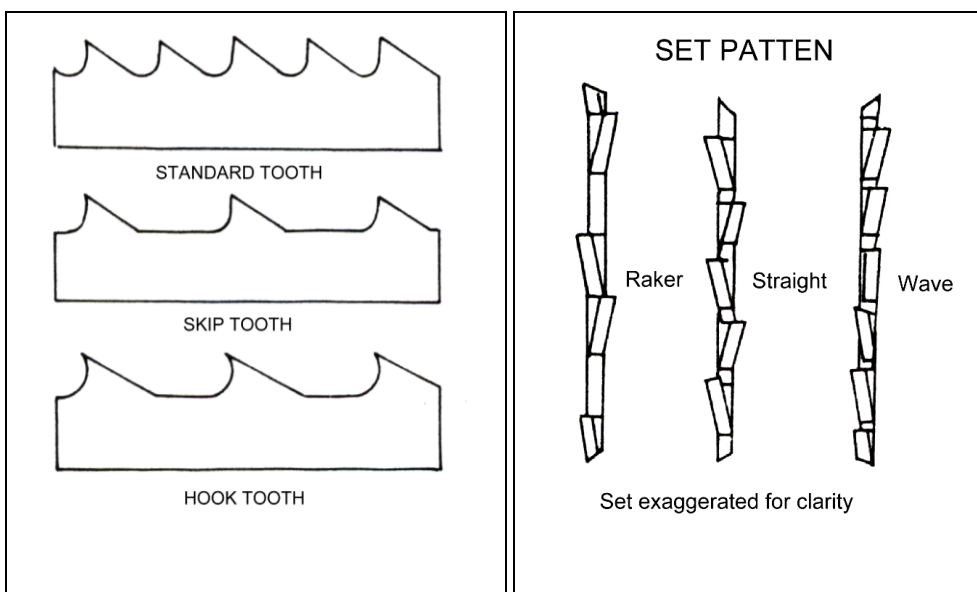
TOOTH SHAPES

The regular or standard tooth is preferred for all ferrous metals and general-purpose cutting. The skip-tooth blade has widely spaced teeth to provide the added chip clearance needed for cutting softer nonferrous materials. The hook, or saber tooth blades has a 10° undercut which permits better feed and chip removal, it is best for the harder nonferrous alloys.

SET TYPES

Regular or rake set is generally furnished on saws that have 2 to 24 teeth per inch. These blades have one tooth set to left, one to right, and one unset tooth called a rake. This set is used when material is to be contour cut. Wavy set is furnished on saws that have 8 to 32 teeth per inch. This set has groups of teeth bent alternately to left and right, which greatly reduce the strain on individual teeth. Saws with wavy set are used where tooth breakage is a problem, such as in cutting thin stock or where a variety of work is cut without changing blades.

Of the three common set patterns, only raker and wave are now used in metalworking.



Always use rake set except:

For work of varying cross section use wave set.

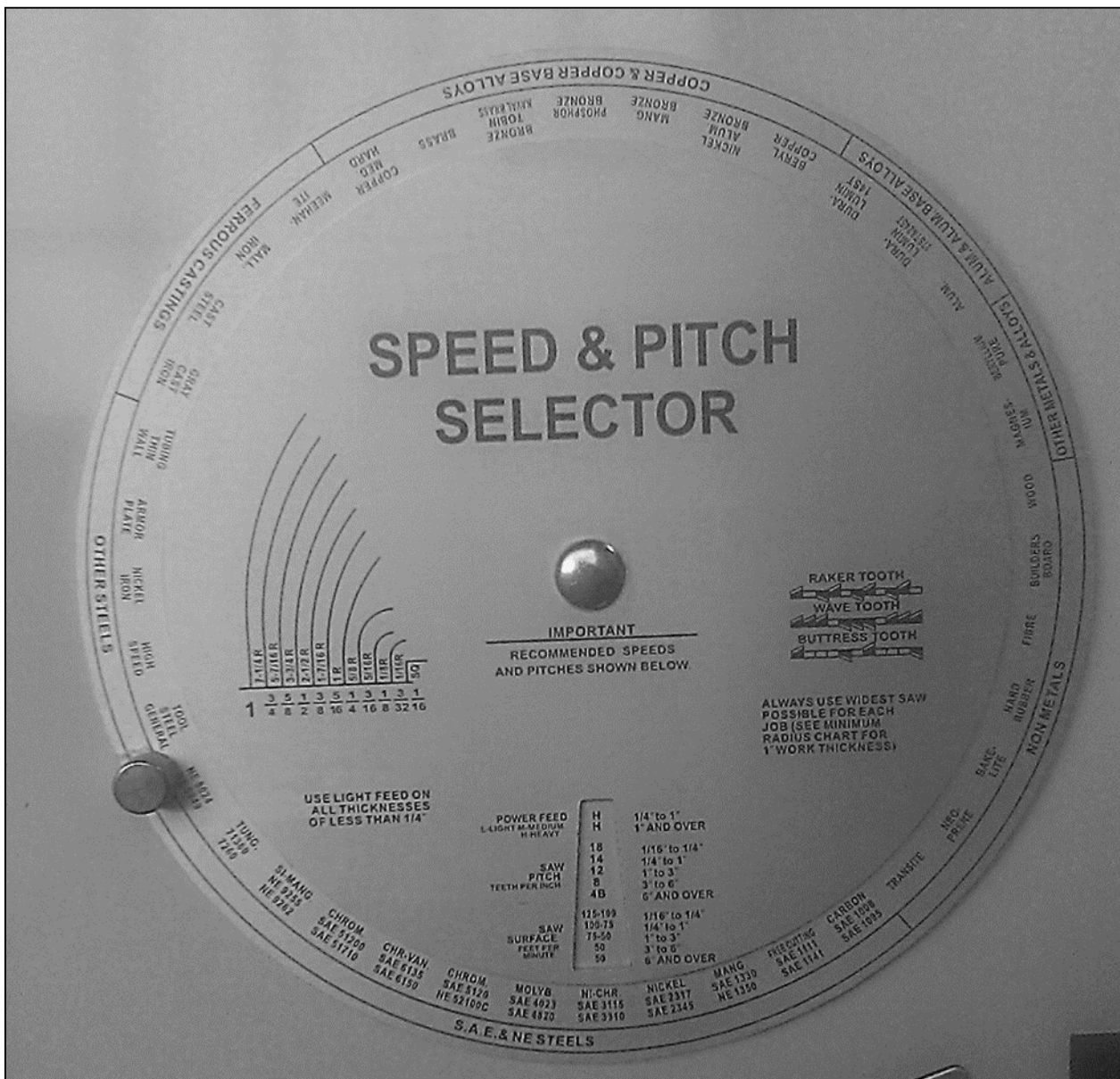
When one blade must be used for a range of material sizes use wave set

▲ PLEASE NOTE THAT CORRECT BLADE SELECTION IS VERY IMPORTANT TO BANDSAW OPERATING AT FULL POTENTIAL. ALWAYS SELECT A BLADE ACCORDING TO THE MATERIAL SHAPE AND THICKNESS OF THE WORK
Always break in the blade per blade manufactures recommendations.

SAW BLADE SELECTION

	MATERIAL SHAPE	MATERIAL SHAPE	MATERIAL SHAPE
MATERIAL IN	■	●	○ H A
INCHES	TOOTH SELECTION	TOOTH SELECTION	TOOTH SELECTION
0	14 / 18	14 / 18	14 / 18
.1	14 / 18	14 / 18	14 / 18
.2	14 / 18	14 / 18	14 / 18
.3	10 / 14	14 / 18	10 / 14
.4	8 / 12	10 / 14	8 / 12
.5	8 / 12	8 / 12	6 / 10
.6	6 / 10	8 / 12	5 / 8
.7	6 / 10	6 / 10	5 / 8
.8	5 / 8	6 / 10	5 / 8
.9	5 / 8	5 / 8	5 / 8
1	5 / 8	5 / 8	4 / 6
1 1/4	4 / 6	5 / 8	4 / 6
1 1/2	4 / 6	4 / 6	4 / 6
1 3/4	4 / 6	4 / 6	4 / 6
2	4 / 6	4 / 6	3 / 4
2 1/4	4 / 6	4 / 6	3 / 4
2 1/2	3 / 4	4 / 6	3 / 4
2 3/4	3 / 4	4 / 6	3 / 4
3	3 / 4	3 / 4	3 / 4
3 1/4	3 / 4	3 / 4	3 / 4
3 1/2	3 / 4	3 / 4	3 / 4
3 3/4	3 / 4	3 / 4	2 / 3
4	3 / 4	3 / 4	2 / 3
5	2 / 3	3 / 4	2 / 3
6	2 / 3	3 / 4	2 / 3
7	2 / 3	2 / 3	1.4 / 2.5
8	1.4 / 2.5	2 / 3	1.4 / 2.5
9	1.4 / 2.5	2 / 3	1.4 / 2.5
10	1.4 / 2.5	1.4 / 2.5	1.4 / 2.5
11	1.4 / 2.5	1.4 / 2.5	1.4 / 2.5
12	1.4 / 2.5	1.4 / 2.5	1.4 / 2.5

Please refer to the "Speed & Pitch Selector wheel that is supplied on your saw for speeds and feeds, radius cutting and blade pitch selection.



Select saw blades in relationship to the thickness of materials. The following suggestions are a rule of thumb to consider when selecting a blade.

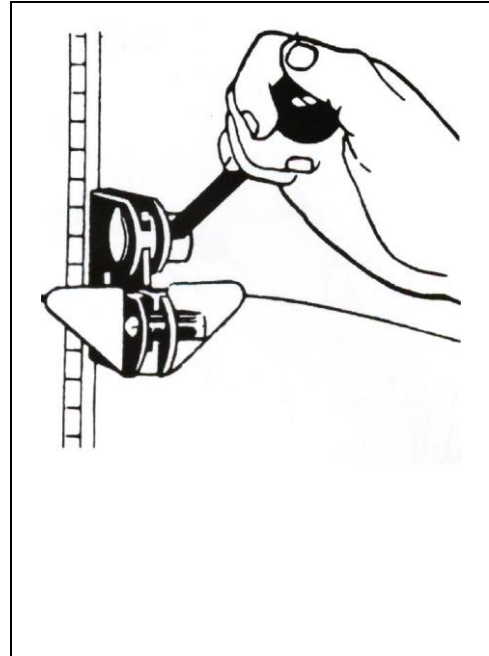
- A. Select a larger pitch blade for a thicker material.
- B. Select a smaller pitch blade for a thinner material.
- C. Use a smaller pitch blade to obtain a smooth cutting surface.
- D. Use a larger pitch blade to obtain a faster cutting speed.
- E. It is important to have different blades for different applications

WELDER OPERATION

This welder is for occasional use for blade repair and is not intended for welding blades on a regular basis from bulk stock. This welder is best suited for carbon bands but with practice both carbon and bi-metal can also be welded.

BLADE CUTTING

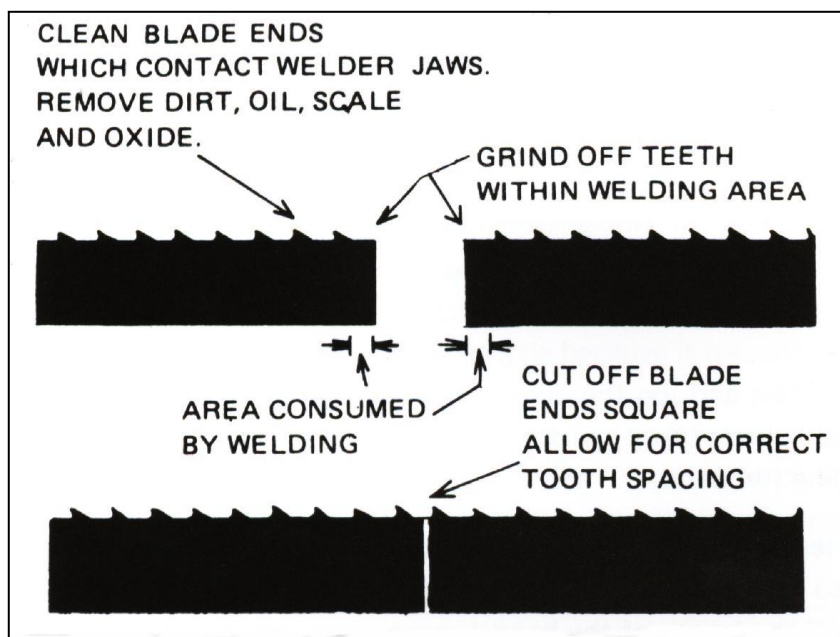
1. Cut the blade to the length of the machine. Using the blade shear will insure that the blade ends are cut flat, square and smooth.
2. Place the back edge of blade against the square cutting guide of the shear and firmly pull the cutting lever down to shear the blade. Both ends of the blade must be sheared to allow for a good butt weld.
3. Keep the shear blade clean and free from blade end pieces that can get trapped in the shear.



Using the Blade Shear.

TOOTH SPACING

1. On fine-pitched blades, one or more teeth on each side of the cut must be removed by grinding so that the cross section of the weld area of the blade is uniform. Following these guidelines will help make the teeth uniformly spaced after the weld.

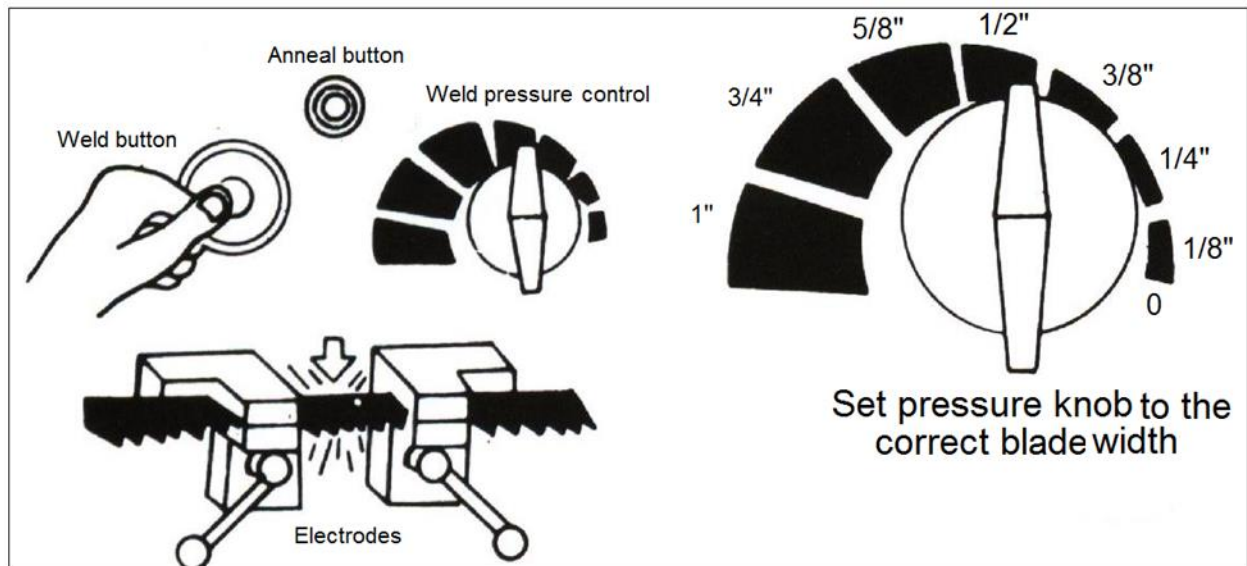


▲ **CAUTION:** If the saw blade is rusty, the rust must be ground off before the blade is welded.

WELDING

1. Turn pressure knob to "0" position.
2. Butt blade ends together and locate joint in the center between the two electrodes.
3. Set pressure knob to blade width. (Due to the different materials and thickness of blade, please pay especial attention to the pressure adjustment. Thicker the blade higher the pressure setting.)
4. Press and hold welder button. Do not release until the blade joint is "red" hot.

The switch is automatic and will shut welder off after a preset time of 3 or 4 seconds and the blade returns to original color. **Note: The weld joint may throw sparks during welding so wear safety glasses and proper apparel.**



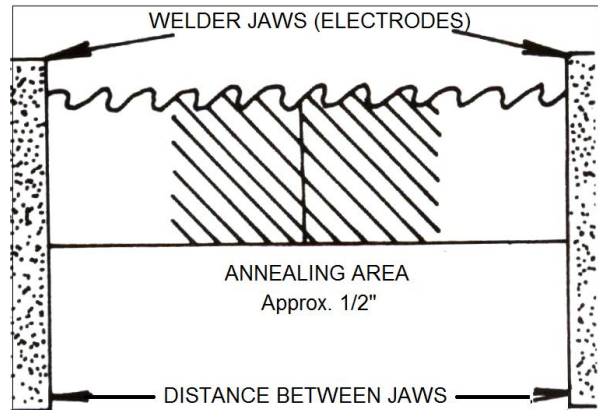
ANNEALING (Carbon Blades)

1. Turn pressure knob to "0" position.
2. Release blade and center the weld joint at the front of the electrodes. (At the wider part)
3. Press and jog the annealing switch button until the weld is a "dull cherry" to "cherry red" color. Allow the blades to cool slowly by decreasing the jogging frequency.
4. Perform the annealing operations 4 or 5 times, gradually reducing the heat each time.
5. Remove any welding dust or scale from the joint and anneal 2 or 3 more times, successively at lower temperatures. (quicker series of press and release of annealing button)

ANNEALING (Bi-Metal)

Set up blade for annealing as mentioned above for carbon blades steps 1 & 2.

Heat the band slowly by jogging the annealing switch button until the weld just begins to emit light (this would be the dull red color) or minute puff of smoke. The desired color may not be visible in normal room light. Always shade the weld area with your hand. Cool the weld quickly by releasing the annealing button. Repeat this operation 4 or 5 times.



▲ NOTE: This procedure should be followed both before and after grinding BI-METAL Blades.

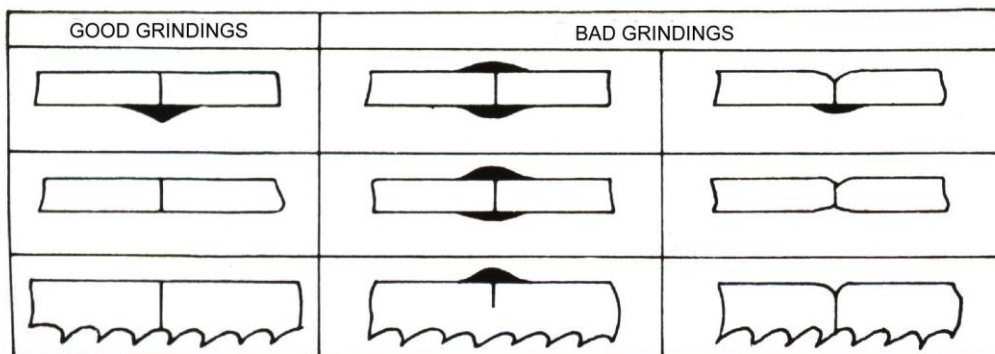
GRINDING THE WELDED BLADE

▲ WARNING
Keep hands away from rotating grinding wheel. When not in use make, sure wheel is covered with built in cover

After welding, the blade must be dressed to remove excess metal or flash from the weld. Grind the welded area down to the same thickness as the rest of the band. Handle the blade carefully.

Grind Carefully: do not hit the teeth; or grind deeper than the thickness of the blade; or overheat the weld area. Be sure to remove flash from the back edge of the blade. Any flash or “stub” teeth that project beyond the normal set or height of the other teeth must be ground off.

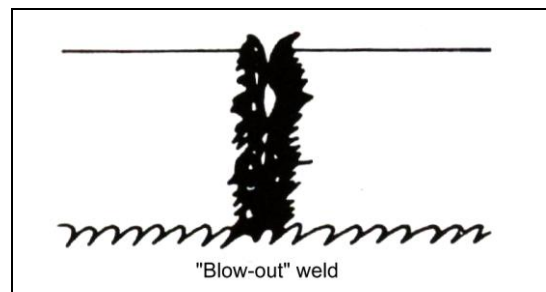
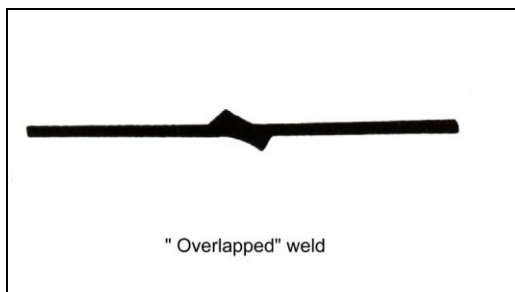
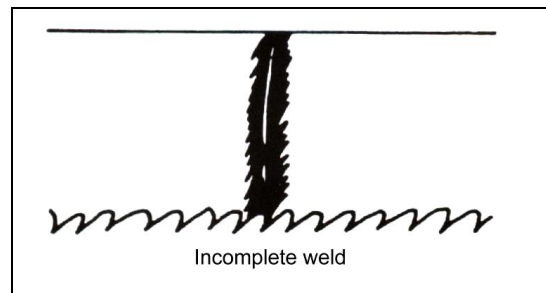
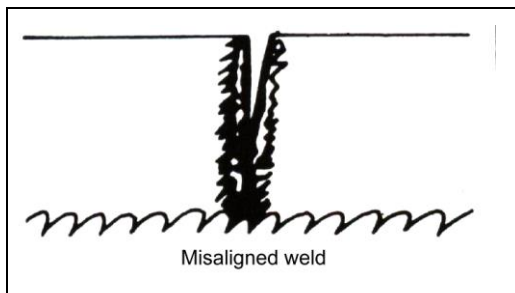
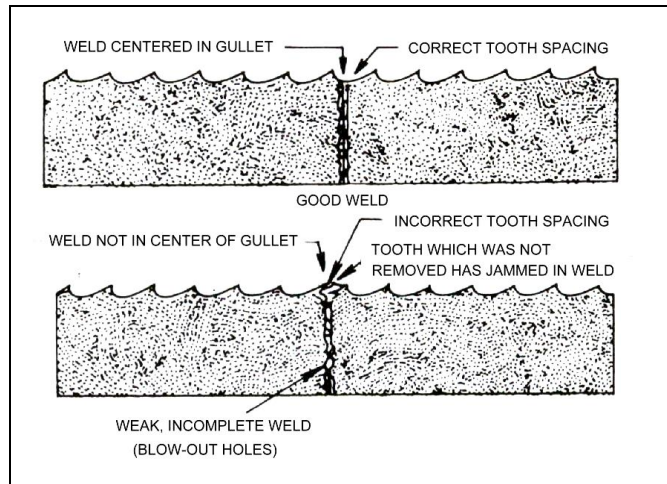
Anneal the welded area that was ground again. Anneal 2 or 3 times using a lower temperature. (Just as area starts to emit light)



INSPECION OF THE WELD

When the blade is removed from the welder it should be inspected carefully.

The spacing of the teeth should be uniform and the weld should be located in the center of the gullet. Major jaw misalignment is easily noted at this time from the weld appearance. See the trouble shooting chapter if the weld is imperfect.



▲ CAUTION: This welder is designed for intermittent use. Repeated welding within a short period of time may cause the welder to overheat.

TROUBLE SHOOTING

MISALIGNED WELD

- (1) Dirt or scale on jaws or blade.
- (2) Blade ends not cut off square.
- (3) Blade ends not correctly aligned when clamped in jaws.
- (4) Worn jaws or inserts.
- (5) Jaws are not aligned correctly.

MISALIGNED WELD-BLADE ENDS ARE OVERLAPPED

- (1) Jaw Upset Force Control set for wider blade than used, re-adjust correctly.
- (2) Blade ends or jaws not aligned correctly.

WELD BREAKS WHEN USED

(Joint is not complete, “blow holes” in joint)

- (1) Weld not annealed correctly.
- (2) Weld has been ground too thin.
- (3) Weak “Incomplete” weld.

INCOMPLETE WELD (Items 3 – 8 requires welder removal)

- (1) Incorrect Initial Set-Up:
 - (a) Initial jaw gap (weld lever position) not set correctly.
 - (b) Upset force control not set correctly.
- (2) Improper clamping procedures.
- (3) Defective cut-off switch may not break the circuit at end of welding operation.
- (4) Cut-off Switch not adjusted correctly.
- (5) Points of cut-off switch welded together.
- (6) Slide Rod sticking because of rust or dirt. Clean and oil the rod.
- (7) Slide Rod movement obstructed because the stop screw too tight on the Rod.
- (8) Jaw movement obstructed by kinked jaw cable or tangled wires. Bend cable and untangle wires.

BRITTLE WELDS

Weld has not been annealed correctly; see “Annealing” in operation chapter. Poor annealing can be caused by:

1. Incorrect annealing heat. Bring weld up to correct color as described under “Annealing” in welder operations chapter.
2. Scale or oil on weld can cause poor annealing.

TROUBLE SHOOTING

PROBLEM	CAUSE	SOLUTIONS
The Weld could not be made, the Jaws do not move	A. The wire connection is poor, the connecting point of welding switch is bad B. The transformer is burnt out C. Some oil is on the blade D. Some rust is on the blade ends E. The adjustment of the welding pressure is incorrect	A. Change the welding switch. B. Change the transformer. C. Remove the oil D. Grind off the rust E. Loosen the adjusting screw that is in center of it
The weld area melts the blade not welds it when welding switch is pushed	A. The welding switch cut off too late B. The Welding Pressure is too weak C. The jaw movement is too slow	A. Screw the welding switch Connecting Nut tight B. Turn the welding pressure adjuster clockwise C. Put some oil on the rear side of the welding lever jaws

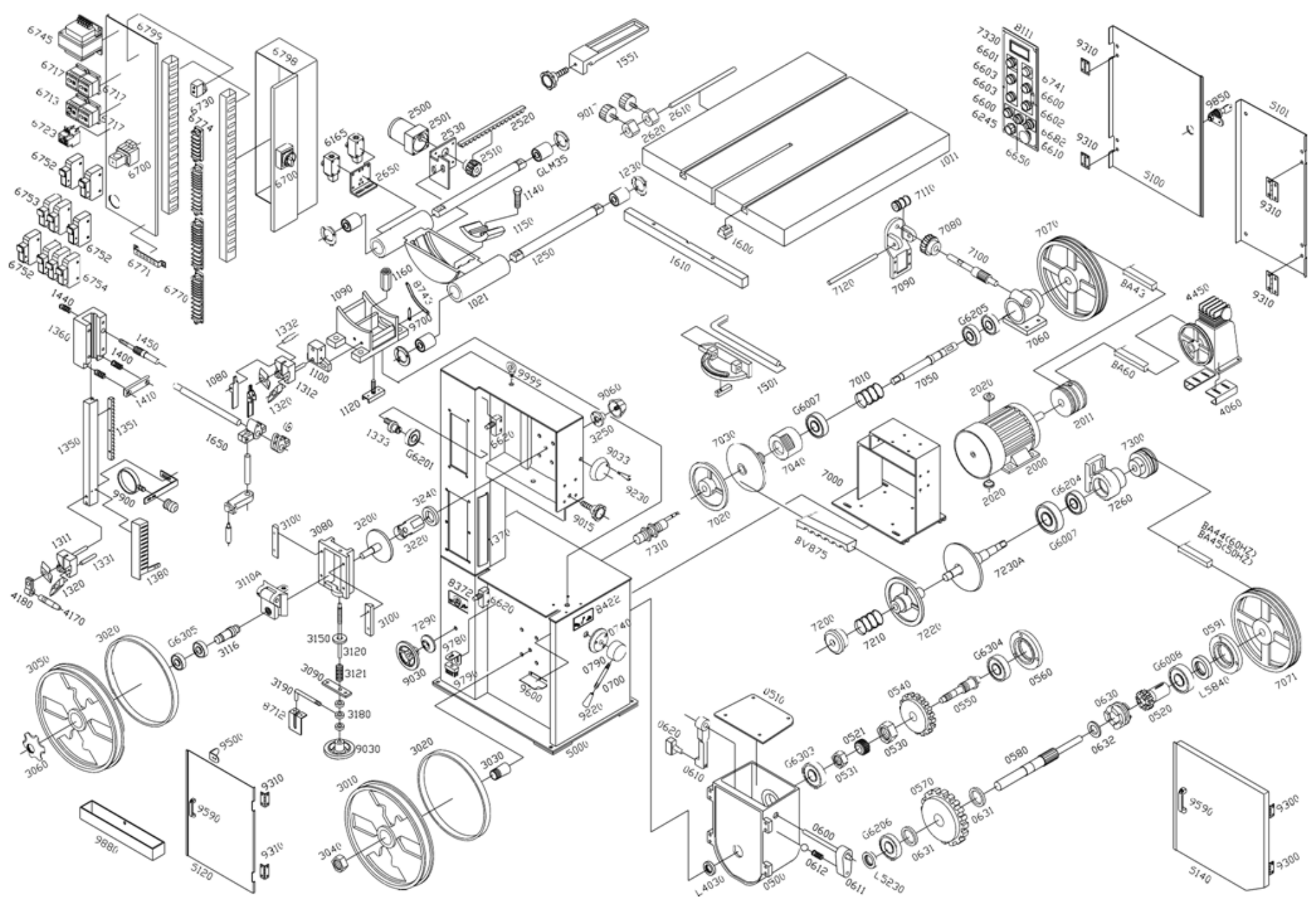
The annealing job cannot be made when pushing the anneal button	A. The connection of annealing switch is loose or broken B. The fuse is blown C. The connection of the electrodes to blade is poor	A. Change an anneal switch B. Change a fuse C. Clean electrode surfaces
The grinder is not running when the grinder switch on	A. The grinder motor is defective B. The grinder switch is defective	A. Replace the grinder B. Replace the switch
The blade can not be tightly clamped with the jaw clamps	A. The jaw clamps are burnt or defective B. The lower jaw inserts defective C. The Jaws are burnt or eroded	A. Change clampers B. Change lower jaw Inserts C. Change jaws
The annealing button will not release to neutral position	Some dust or debris around the anneal button restricting movement	Release the anneal button by gently pulling it to the neutral position Clean out any dust or debris
Blade tooth broken	A. Incorrect pitch for the application B. Brittle blade improper annealing C. Inferior blade	A. Select a right pitch blade B. Re-weld and anneal C. Decrease feeding rate D. Change to high quality blade
Blade damaged	A. Brittle blade improper annealing B. Blade tension out of adjustment C. Too Fast feeding D. Blade teeth hitting guides. E. Cannot cut radius without blade twisting.	A. Decrease the annealing temperature B. Adjust blade tension C. Decrease feed rate D. Adjust a proper gap between the blade and the guide insert E. Change to a narrower blade

PROBLEM	CAUSE	SOLUTIONS
Saw blade is twisted	A. Improper weld B. Blade installed in improper way C. Blade tension too loose D. The blade is being over fed	A. Re-weld the blade again B. Set the guide inserts closer C. Increase blade tension D. Decrease the feeding rate when starting the cut E. Use a proper width blade for radius cutting
The sawing direction deviates	A. The blade tooth is not on even or worn unevenly. B. The blade tension is too loose C. The guide post was set too high	A. Make sure a good blade is used without damaged teeth B. Increase blade tension C. Set the guide post to be within a 1/4" of the work D. Decrease feeding rate
Saw blade walks off	A. Blade tension is too loose B. Blade is not tracked properly	A. Increase blade tension B. Adjust the wheel alignment

The blade dulling prematurely	A. The blade speed is too fast B. The selection of blade is improper C. Feeding rate too fast	A. Slow down the blade speed B. Use a proper blade for the application C. Decrease feeding rate
The blade is not cutting straight vertically	A. The blade dull B. The guide post is not properly fixed C. The blade tension is too loose D. The blade is not exactly 90° to the table	A. Change to a new blade B. Fix the guide post properly ¼" above material C. Increase blade tension D. Adjust it to be 90°
Excessive noise when machine is running	A. The variable speed pulley is damaged C. The saw is not sitting flat on the floor	A. Change a new pulley B. Reposition the machine on a flat even hard floor

MAINTENANCE

PART OR PLACE TO BE OILDED OR GREASED	TYPE OF OIL OR GREASE	LUBRICATING PERIOD	REMARKS
Bearings	Gear oil	every 6 months	Gear Box:
Guide post sliding part	Grease	weekly	#1350 & #1360
Speed Change handle	Grease	every 6 months	#0600, # 0740, #7120 & #7290
Gear and thread	Grease	every 3 months	#7080 & 7110
Variable pulley	Grease	N/A	#9995: V-16 only
Table slide shaft	Machine oil	daily	#1250: E-type only
Upper wheel slide block	Machine oil	monthly	#3100 & #3110
Blade Tension Screw	Grease	monthly	#3110 & #3120
Welder Jaw			(clean up daily)
Rubber Tire			(clean up daily)
Work Table Assembly			(clean up daily)



GEAR BOX COMPONENT

0500	1 *	GEAR BOX
0510	1 *	GEAR BOX COVER 303243
0520	1 *	GEAR
0521	1 *	GEAR
0530	1 *	SCREW NUT
0531	1 *	SCREW NUT
0540	1 *	GEAR 303245
0550	1 *	GEAR SHAFT
0560	1 *	SHAFT COVER
0570	1 *	GEAR 303244
0580	1 *	MAIN SHAFT
0591	1 *	MAIN SHAFT COVER
0600	1 *	SPEED CHANGING SHAFT
0610	1 *	SPEED CHANGING ARM
0611	1 *	SHAFT STOPPER
0612	1 *	SPRING
0620	1 *	SLIDE BLOCK
0630	1 *	CLUTCH
0631	2 *	BRASS BRACKET
0632	1 *	BRASS BRACKET
G6008	1 *	BALL BEARING
G6206	1 *	BALL BEARING
G6303	1 *	BALL BEARING
G6304	1 *	BALL BEARING
L4030	1 *	OIL SEAL
L5230	1 *	OIL SEAL
L5840	1 *	OIL SEAL
CP0500	1	GEAR BOX COMPLETE 303242
0700	1	SPEED CHANGING LEVER
0740	1	SHAFT HOUSING
0790	1	SPEED LEVER RIGHT
7071	1	PULLEY 303228
9220	1	LEVER KNOB
BA44	2	V-BELT, 7071+7300 (60HZ)
BA45	2	V-BELT, 7071+7300 (50HZ)

WORK TABLE COMPONENT

1011	1	WORK TABLE
1021	1	TABLE SUPPORT FRAME
1080	2	BLADE GUARD

GUIDE POST COMPONENT

1311	1	GUIDE SUPPORT, UPPER
1312	1	GUIDE SUPPORT, LOWER
1320	4	BLADE GUIDE 303233
1331	1	BLADE STOPPER, LONG 303251
1332	1	BLADE STOPPER, SHORT 303263
1333	1	ECCENTRIC SHAFT
1350	1	BLADE GUIDE POST
1351	1	GEAR BAR
1360	1	GUIDE POST HOUSING
1370	1	BLADE GUARD, LEFT
1380	1	BLADE GUARD, RIGHT
1400	2	SPRING
1410	1	SPRING HOUSING
1440	1	POST HOUSING SPRING
1450	1	POST ELEVATING GEAR
1650	1	CIRCLE CUTTING ATTACHMENT
9015	1	GUIDE POST LOCK
9033	1	POST ELEVATE HANDWHEEL
9230	1	HANDLE KNOB
G6201	1	BALL BEARING

MAIN DRIVE

2000	1	MAIN DRIVE MOTOR 303255
2011	1	MOTOR PULLEY
2020	4	MOTOR ROTARY SEAT
BA43	2	V-BELT, 2011+7070
BA60	1	V-BELT, 2011+4450

WHEEL COMPONENT

3010	1 *	LOWER WHEEL
3020	1 *	RUBBER TIRE 303261
CP3010	1	LOWER WHEEL COMPLETE
3030	1	TAPER SLEEVE
3040	1	WHEEL LOCKING NUT
3020	1 *	RUBBER TIRE
3050	1 *	UPPER WHEEL
G6305	2 *	BALL BEARING
CP3050	1	UPPER WHEEL COMPLETE
3060	1	UPPER WHEEL LOCK

WORK TABLE CONT.			WHEEL COMPONENT CONT.		
			3080	1 *	SLIDE BLOCK HOUSING
1090	1	TABLE SUPPORT HOUSING	3090	1 *	SLIDE BLOCK SEAT
1100	1	GUIDE SUPPORT HOUSING	3100	2 *	SLIDE BLOCK GUIDE
1120	1	RIGHT-HANDED SCREW	3110A	1 *	UPPER WHEEL SLIDER
1140	1	LEFT-HANDED SCREW	3116	1 *	SLIDER SCREW SHAFT
1150	1	SLIDER	3120	1 *	WHEEL ELEVATE SHAFT
1160	1	TABLE TILT ADJUST SCREW	3121	1 *	SPRING
1230	4	BEARING COVER	3150	1 *	WASHER
1250	2	TABLE STROKING SHAFT	3180	3 *	INDICATOR RING
1501	1	METER GAUGE	CP3080	1	SLIDE HOUSING COMPLETE
1551	1	RIP FENCE + LOCK 303256	3190	1	TENSION INDICATOR
1600	2	T-BLOCK	3200	1	WHEEL TILT ADJUSTER
1610	1	RIP FENCE SLIDE GUIDE	3220	1	WHEEL TILT CONNECTER
2500	1	TORQUE MOTOR	3240	1	CONNECTER WASHER
2501	1	TORQUE MOTOR SPEED REDUCER	3250	1	CONNECTER HOUSING
2510	1	WHEEL GEAR	9030	1	HANDWHEEL
2520	1	SLIDE GEAR	9060	1	TILT ADJUST HANDWHEEL
2530	1	TORQUE MOTOR HOUSING			
2610	1	SET RING SLIDE BAR			
2620	2	LIMITED SWITCH SET RING			
2650	1	LIMITED SWITCH HOUSING			
6165	2	LIMITED SWITCH			
9017	2	SET RING LOCK			
GLM35	4	LINER BEARING			

AIR PUMP COMPONENT

4060	2	AIR PUMP SEAT
4170	1	AIR NOZZLE
4180	1	AIR NOZZLE CLIPPER
4450	1	AIR COMPRESSOR 303229
BA60	1	V-BELT, 2011+4450

MAIN BODY & MISCELLANEOUS

5000	1	MAIN BODY
5100	1	REAR DOOR, LARGER
5101	1	REAR DOOR, SMALLER
5120	1	LOWER DOOR
5140	1	UPPER DOOR
8111	1	CONTROL PLATE

VARIATOR COMPONENT

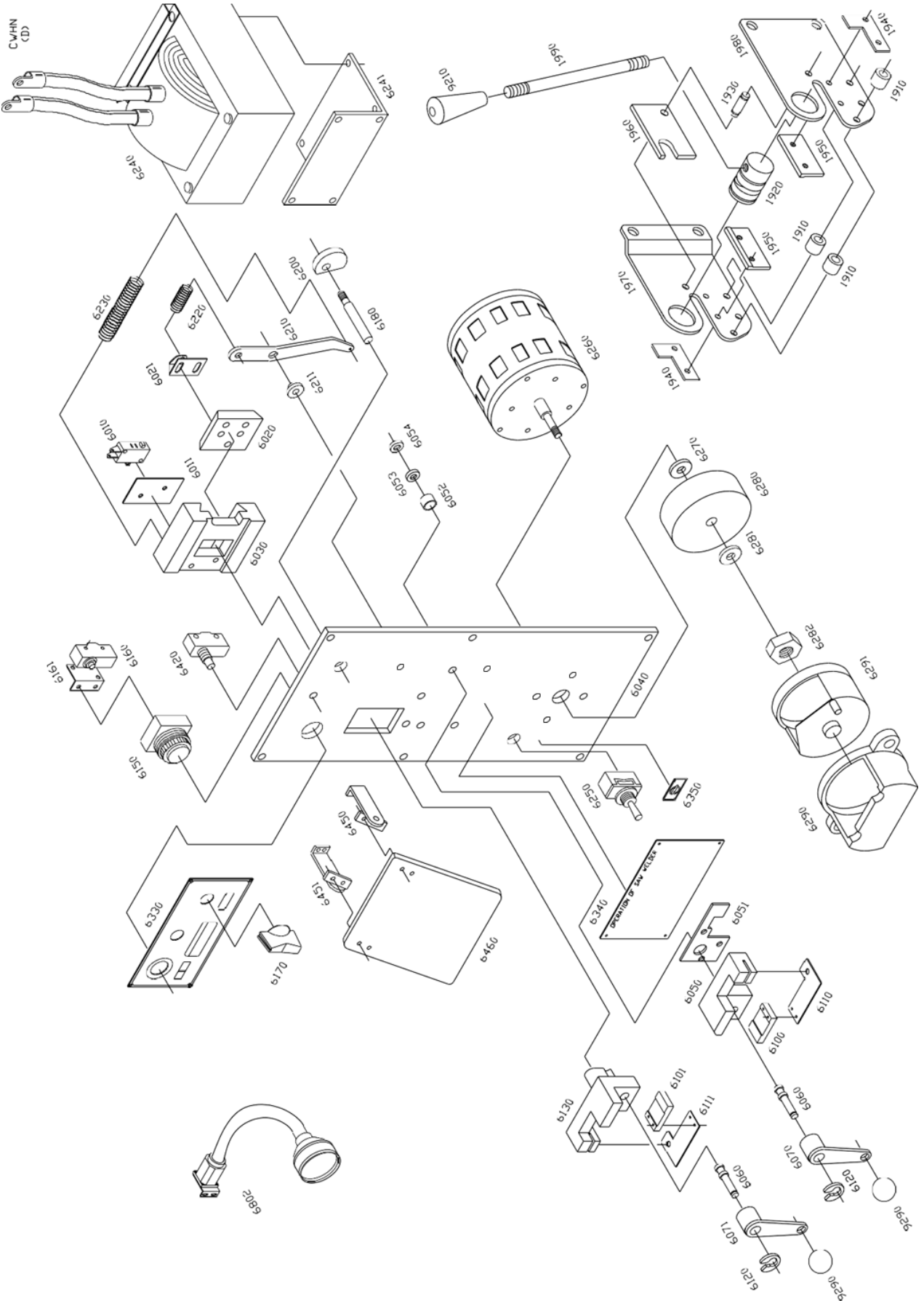
7000	1	MOTOR SPRING HOUSING
7010	1 *	SPRING
7020	1 *	VAEIATOR DISK, UPPER
7030	1 *	VAEIATOR DISK, UPPER
7040	1 *	VARIATOR HOUSING TUBE
7050	1 *	VARIATOR SHAFT
7060	1 *	VARIATOR HOUSING
G6007	1 *	BALL BEARING
G6205	2 *	BALL BEARING
CP7060	1	VARIATOR HOUSING
7070	1	PULLEY
7080	1	WORM GEAR
7090	1	WORM GEAR HOUSING
7100	1	GEAR SHAFT
7110	1	WORM
7120	1	WHIRLING ARM
7200	1 *	SPRING HOUSING
7210	1 *	SPRING

8372	1	VARIATOR INSTRUCTION	7220	1	*	VARIATOR DISK, LOWER
8422	1	GEAR BOX INSTRUCTION	7230A	1	*	VARIATOR DISK, LOWER
8712	1	INDICATOR PLATE	7260	1	*	SHAFT HOUSING
8743	1	TILT INSTRUCTION	G6007	1	*	BALL BEARING
9300	2	UPPER DOOR HINGE	G6204	1	*	BALL BEARING
9310	6	HINGE	CP7260	1		SHAFT HOUSING COMPLETE
9500	4	SPRING PLATE	7290	1		SPEED CHANGE WHEEL SEAT
9590	2	HANDLE ARM	7300	1		PULLEY
9600	1	CHIP STOPPER	7310	1		SPEED READOUT DETECTOR 303264
9700	1	INDICATE MIDDLE	7330	1		DIGITAL TACHOMETER 303238
9780	1	BRUSHER BRACKET	9030	1		HANDWHEEL
9790	1	CHIP BRUSHER 303237	BA44	-		V-BELT, 7071+7300 (60HZ)
9850	1	KEY FOR REAR DOOR	BA45	-		V-BELT, 7071+7300 (50HZ)
9880	1	CHIP COLLECTOR	BA43	-		V-BELT, 2011+7070
9999	1	EYE BOLT	BV875	1		V-BELT

CONTROL SWITCH COMPONENT

6245	1	VARIABLE TRANSFORMER
6600	2	PUSH BUTTON, ON, GREEN
6601	1	PUSH BUTTON, ON, WHITE
6602	1	PUSH BUTTON, OFF, RED
6603	2	PUSH BUTTON, ON/OFF, BLACK
6610	1	EMERGENCY SWITCH
6620	2	DOOR LIMIT SWITCH 303239
6650	1	KEY SWITCH
6682	1	SELECT SWITCH
6700	1	MAIN POWER SWITCH
6713	1	MAGNETIC SWITCH 303254
6723	1	OVERLOAD STARTER 303258
6730	1	CONDENSER
6741	1	PILOT LAMP, GREEN
6745	1	VOLTAGE REDUCER 303266
6752	4	FUSE SEAT
6753	1	FUSE SEAT
6754	1	FUSE SEAT
6717	3	POWER RELAY
6770	3	WIRE HOUSING
6771	1	GROUND SEAT
6774	1	WIRE HOUSING
6798	1	ELECTRIC BOX
6799	1	WIRING PLATE

CWHN
(D)



WELDER COMPONENT

6010	1 *	LIMIT SWITCH 303250
6011	1 *	INSULATOR
6020	1 *	GUIDE BLOCK
6040	1 *	HOUSING
6050	1 *	STATIONARY JAW
6051	1 *	INSULATOR
6052	3 *	INSULATING TUBE
6053	3 *	WASHER, INSULATE
6054	3 *	SPACER
6060	2 *	ECCENTRIC SHAFT
6070	1 *	CLAMP LEVER, RIGHT
6071	1 *	CLAMP LEVER, LEFT
6100	1 *	CLAMP SUPPORT, RIGHT
6101	1 *	CLAMP SUPPORT, LEFT
6110	1 *	CLAMP PLATE, RIGHT
6111	1 *	CLAMP PLATE, LEFT
6120	2 *	CAM
6130	1 *	MOVING JAW
6150	1 *	WELD BUTTON 303271
6160	1 *	MICRO SWITCH
6161	1 *	MICRO SWITCH BRACKET
6170	1 *	PRESSURE ADJUST KNOB
6180	1 *	SHAFT
6200	1 *	CAM
6210	1 *	WELD TENSION ARM
6211	1 *	BUSHING
6220	1 *	SPRING, SHORTER
6230	1 *	SPRING, LONGER
6240	1 *	TRANSFORMER (4.2KVA)
6241	1 *	MOUNTING BRACKET (4.2KVA ONLY)
6250	1 *	SWITCH
6260	1 *	GRINDER MOTOR
6270	1 *	SPACER
6280	1 *	GRINDER WHEEL 303248
6281	1 *	1/4" WASHER, FLAT
6282	1 *	6 mm-1.0 HEX NUT
6290	1 *	GRINDER GUARD 303247
6291	1 *	GRINDER COVER 303246
6330	1 *	WELDER NAME PLATE
6340	1 *	INSTRUCTION LABEL
6350	1 *	GRINDER LABEL
6420	1 *	ANNEAL BUTTON 303231
6450	1 *	DEFLECTOR BRACKET, RIGHT
6451	1 *	DEFLECTOR BRACKET, LEFT
6460	1 *	SPARK DEFLECTOR
9290	2 *	KNOB 303249
WCP	1	42-WELDER ASSEMBLY

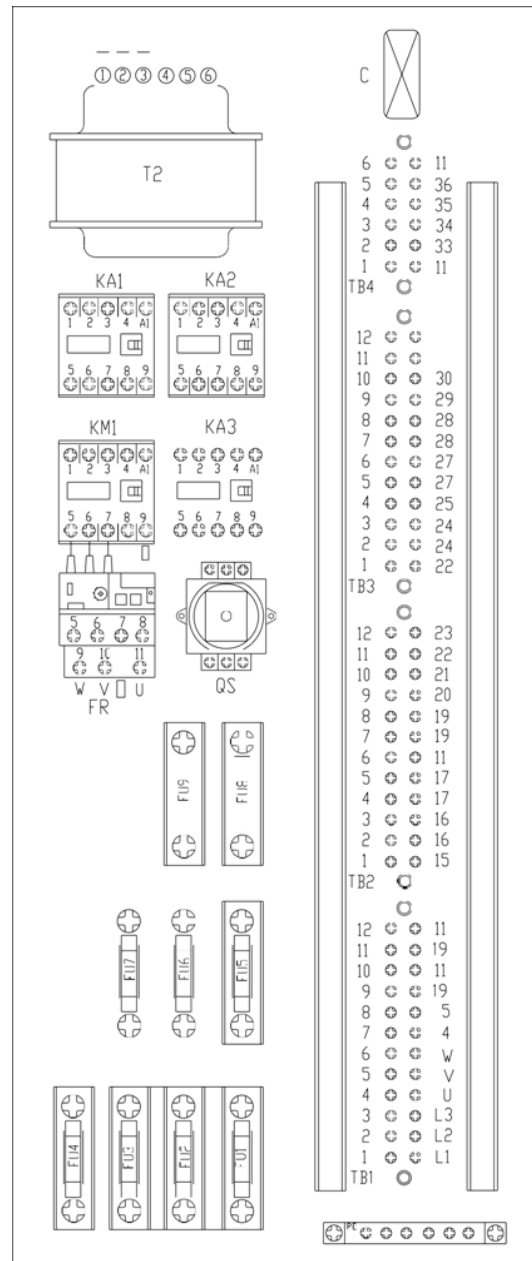
Electric appliance arrangement
diagram

WORK LAMP COMPONENT

6802	1 *	WORK LAMP COMPONENT 303272 Bulb MR 16 12v 20W
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SHEAR COMPONENT

1910	3 *	SPINDLE BUSHING
1920	1 *	SPINDLE LIFT
1930	1 *	BLADE SHAFT
1940	2 *	VANED IRON PLATE
1950	2 *	LOWER BLADE
1960	1 *	UPPER BLADE
1970	1 *	JOINT PLATE, LEFT
1980	1 *	CHAIN JOINT, RIGHT
1990	1 *	HANDLE BAR
9210	1 *	KNOB
SCP	1	SHEAR COMPLETE 303234



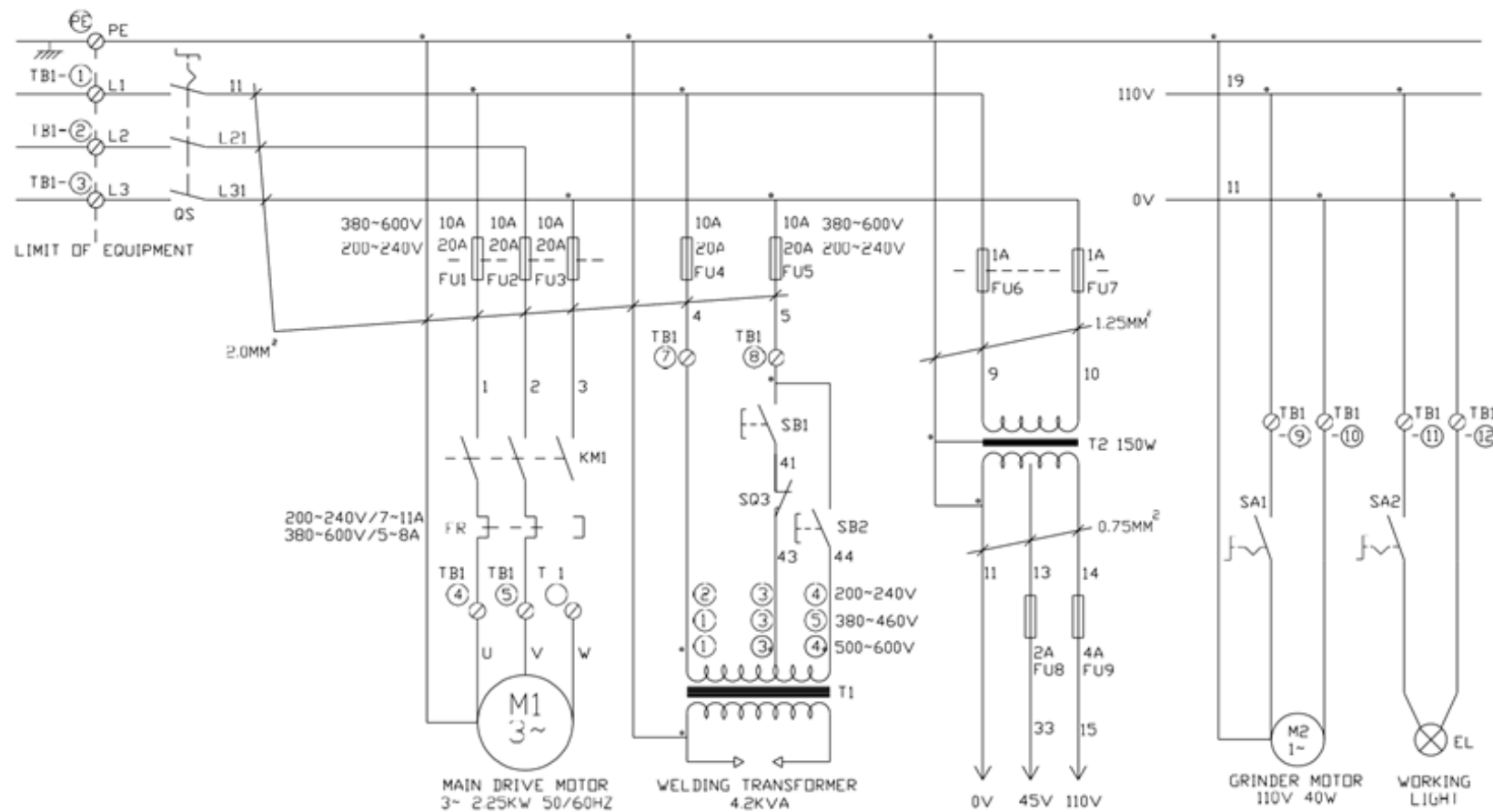
WIRING DIAGRAM

AC 3 ϕ 200V~240V

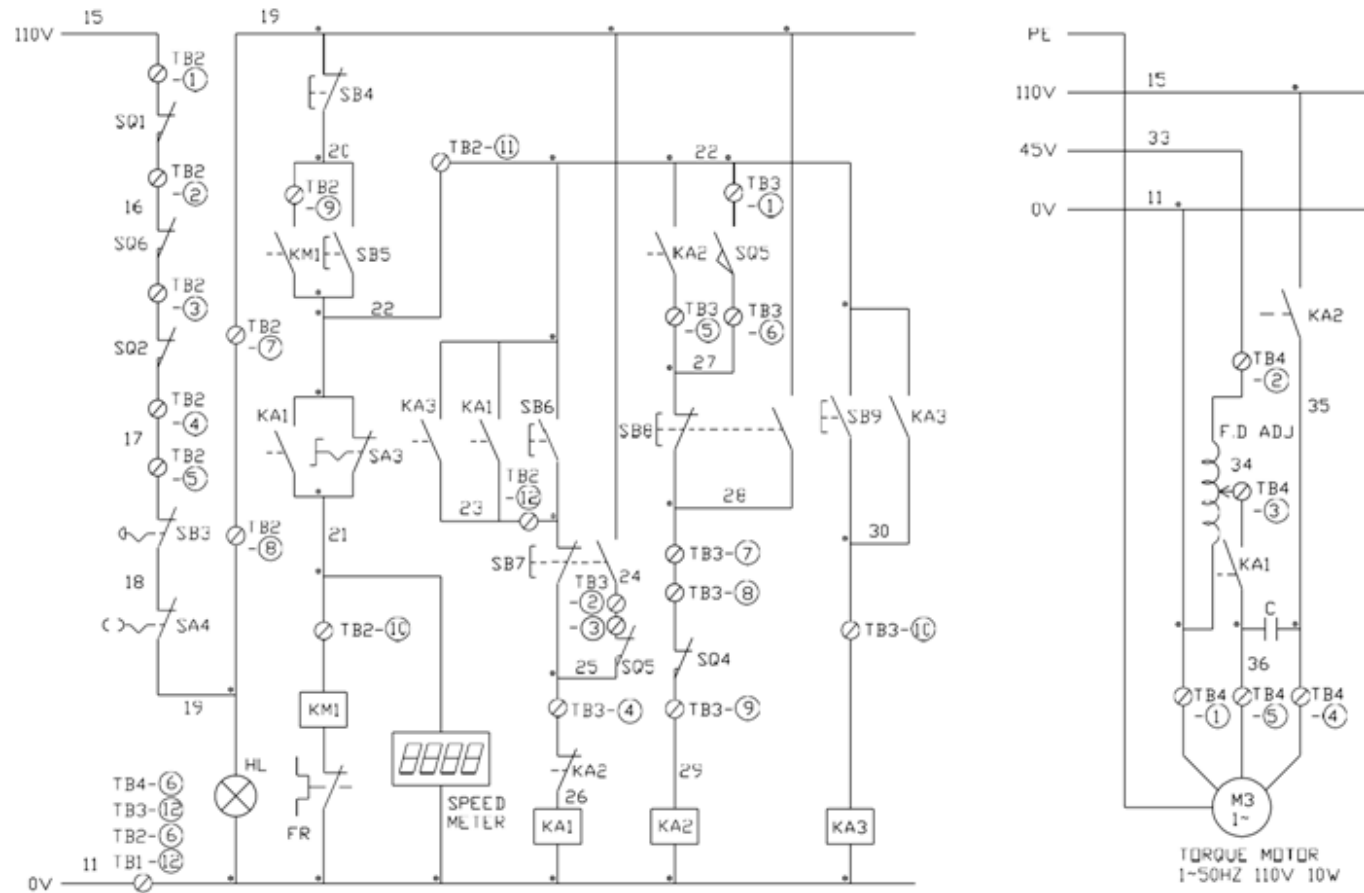
AC 3 ϕ 380V~460V

AC 3 ϕ 500V~600V

V-26 E



V-26 E



SB1	WELD ON	WHITE	SB8	REVERSE	BLACK	EL	WORK LAMP 60W,115V	SQ6	SAFETY SWITCH 36"TYPE ONLY	T1	TRANSFORMER
SB2	ANNEAL ON	GREEN	SB9	CONTINUE	GREEN	QS	MAIN SWITCH	KM1	CONTACTOR	T2	TRANSFORMER
SB3	EMERGENCY STOP	RED	SA1	GRINDER MOTOR ON		SQ1	SAFETY SWITCH	FR	OVERLOAD RELAY	FD ADJ	PRESSURE ADJUSTMENT
SB4	MAIN MOTOR OFF	RED	SA2	WORK LAMP ON		SQ2	SAFETY SWITCH	KA1	CONTACTOR RELAY	FU1-FU9	FUSE
SB5	MAIN MOTOR ON	GREEN	SA3	AUTO STOP		SQ3	WELD AUTO STOP	KA2	CONTACTOR RELAY		
SB6	AUTO	WHITE	SA4	KEY SWITCH		SQ4	TABLE SLIDE REVERSE	KA3	CONTACTOR RELAY		
SB7	FORWARD	BLACK	HL	INDICATOR LIGHT	GREEN	SQ5	TABLE SLIDE FORWARD	C	CONDENSER		

Warnings

- Employer is responsible to perform a hazard/PPE assessment before work activity.
- Do not make repairs or adjustments unless you are competent or working under competent supervision. If in doubt consult a qualified technician or engineer
- Only use Dake original parts
- Do not alter this band saw from the original design.
- Lock out Tag out procedures must be followed by authorized employees as per OSHA.

ELECTRIC – Electric must be locked out in accordance to OSHA standards.

WARNING LABELS



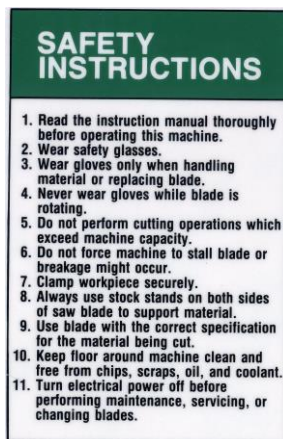
To the left is the safety Alert symbol. When you see these safety alert symbols on your band saw, be alert to the potential for personal injury.

Follow recommended precautions and safe operating practices.

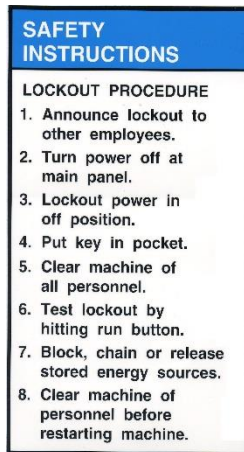
Carefully read all safety messages in these instructions and on your band saw safety signs. Keep safety labels in good condition. Replace missing or damaged safety labels. **This machine is intended to be operated by one person.**



Label 84604



Label 84605



Label 76462



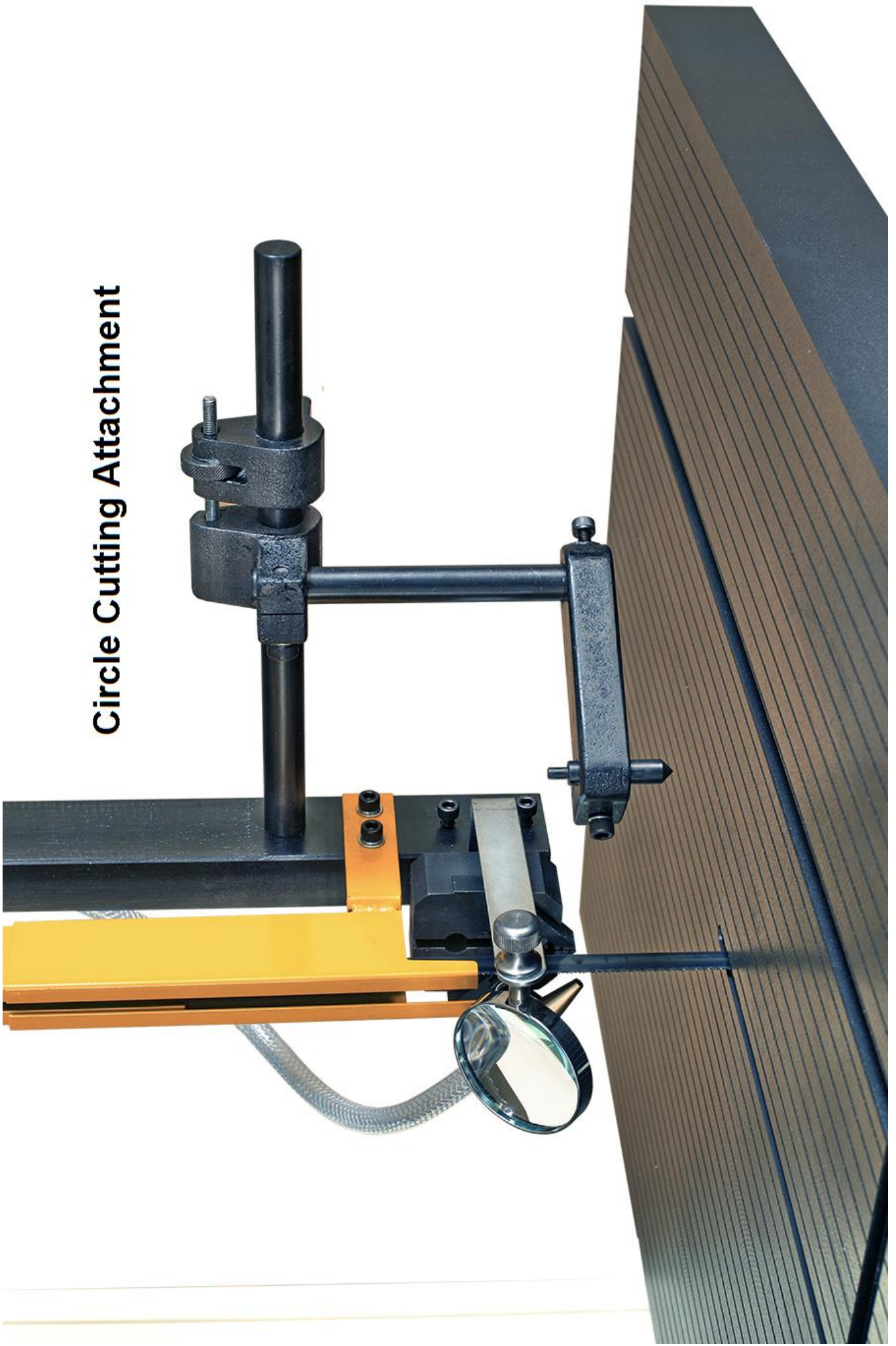
76462
on side
of
machine



Label Placement View

This machine is wired for 220
volt 3 phase!

Circle Cutting Attachment



CIRCULAR CUTTING ATTACHMENT:

1. Install the Circular Cutting Attachment. <Figure 1>
2. A. The position of the blade tooth should be opposite to the cutting center at nine o'clock position. <Figure 2>
B. The height between the object and the blade guide end is suggested to be about 5 mm. <Figure 3>
C. Use the blade under 8mm width if possible, it will avoid interference. When cut smaller circle, use smaller width blade.
3. A. Measure the cutting radius, set the distance between the blade tooth and the Set Point by the Lock Screws. Loosen the Lock Screw (1) & (2) to adjust the cutting radius. Tighten the Lock Screw (1) & (2) after finish it. <Figure 1, 4 & 6>
B. Use the Micro Adjust Screw to get the precise cutting radius. Loosen the Lock Screw (1), and then adjust the Micro Adjust Screw. Tighten the Lock Screw (1) after finish it. <Figure 1 & 4>
4. Mark a center point (or drill 5mm hole) and draw a circle on the object. Start to cut from the object nearby until touch the rim, and then fix the Set Point in the object. <Figure 5 & 6>
5. Rotate the object to finish it. <Figure 6>

