

CHANGING COOLANT PUMP

1. Take the pipes of the lubricating system off.
2. Remove fastening screws and replace pump, being careful to keep the driving system centered on the drive shaft bearing.

TROUBLESHOOTING

SYMPTOM	CAUSE	SOLUTION
Tooth Breakage	Too fast of an advance on the material	Decrease the level of downward feed
	Wrong cutting speed	Change the blade speed or the diameter of the blade
	Wrong tooth pitch	Use the blade calculator to determine the correct pitch or consult your blade provider
	Low quality and/or dull blade	Speak with blade provider and sharpener
	Poor clamping pressure causing the part to move	Check the material for tightness before cutting
		Check the condition of the jaw faces
	Insufficient coolant or incorrect type of coolant	Check the level of coolant in tank and increase the flow of coolant.
Talk to your coolant provider		
Premature Blade Wear	Wrong blade being used	Consult your blade provider for adequate blade
	Wrong cutting speed or feed	
	Insufficient coolant or incorrect type of coolant	Check the level of coolant in tank and increase the flow of coolant
		Talk to your coolant provider
Blade Vibration	Wrong blade being used	Consult your blade provider for adequate blade
	Poor clamping pressure causing the part to move	Check the material for tightness before cutting
		Check the condition of the jaw faces

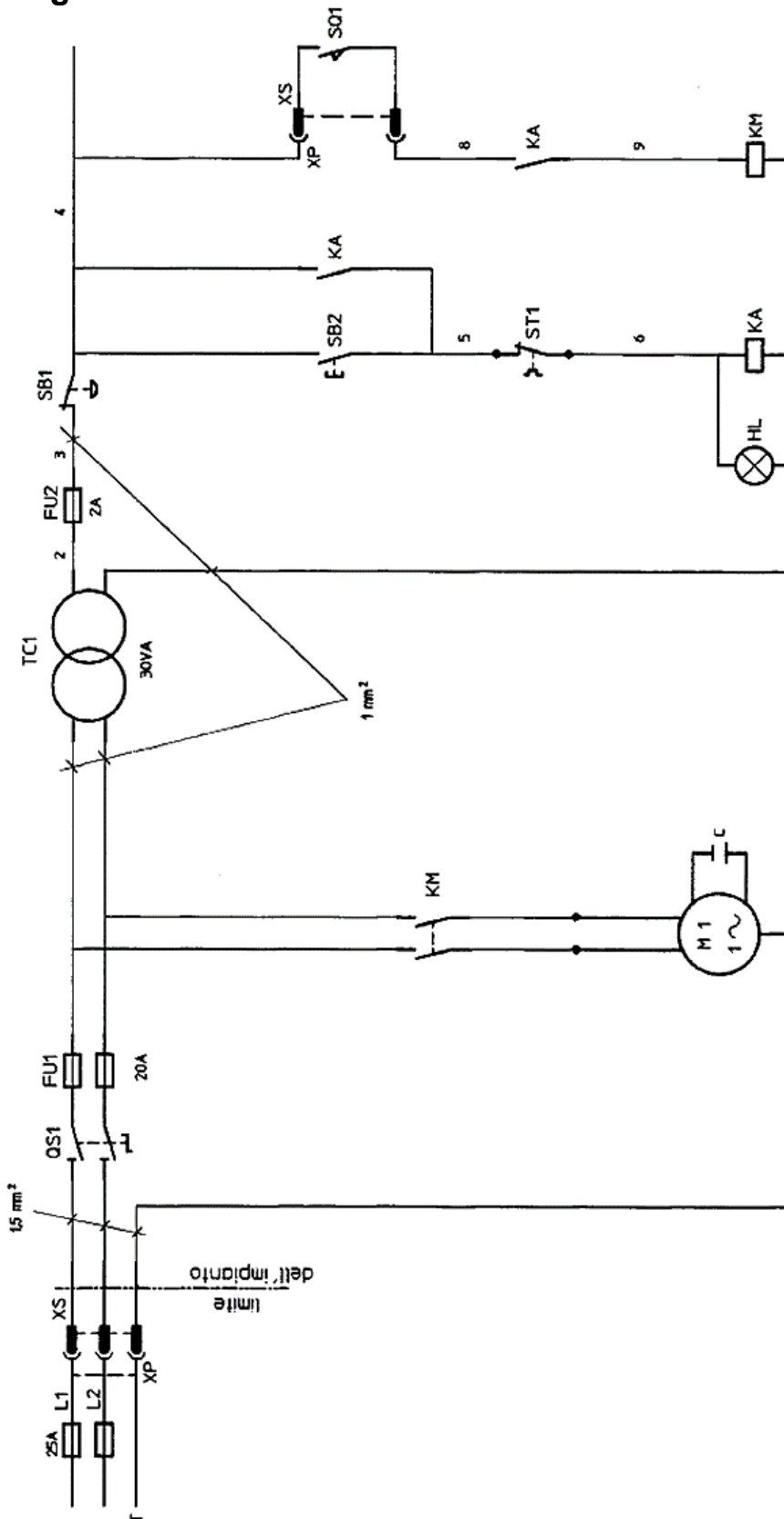
SYMPTOM	CAUSE	SOLUTION
	Dimensions of the solid section too large with respect to the maximum cutting dimensions	Check the cutting capacity of the saw
	Blade diameter incorrect and/or too large	Decrease blade diameter
Blade sticks in the cut	Too fast of an advance on the material	Decrease the level of downward feed
	Cutting speed too slow	Increase blade speed
	Wrong blade	Use the blade calculator to determine the correct pitch or consult your blade provider
	Sticky accumulation of material on blade	Use a higher quality of blade
		Check the blend of coolant
	Insufficient coolant	Check the level of coolant in tank and increase the flow of coolant Talk to your coolant provider
Ridges on cutting surface	Blade diameter incorrect and/or too large	Decrease blade diameter
	Poor clamping pressure causing the part to move	Check the material for tightness before cutting Check the condition of the jaw faces
	Blade advance is too fast	Exert less cutting pressure on the material
	Blade teeth are worn	Sharpen blade or replace
	Insufficient coolant	Check the level of coolant in tank and increase the flow of coolant Talk to your coolant provider
	Toothing does not unload shavings well	Select a blade with a larger tooth pitch
Cut is not straight	Blade advance is too fast	Exert less cutting pressure on the material
	Poor clamping pressure causing the part to move	Check the material for tightness before cutting Check the condition of the jaw faces
	Blade head is not straight	Adjust head
	Blade side are sharpened differently	Choose tool quality carefully in every detail in regard to type and construction characteristics
	Blade is thinner than the commercial standard	

SYMPTOM	CAUSE	SOLUTION
	Dirt on the gripping device	Carefully clean the contact surfaces
Control power indicator light does not work	Bad fuses	Check and/or change fuses
	Faulty power supply	Check incoming power
	Short circuit	Test for short and repair
	Bad light bulb	Replace light bulb
	Speed switch is off	Turn switch to desired speed
	Emergency switch is depressed	Pull switch out and make sure contacts are operating
	Thermal overload tripped	Wait 10-15 for motor to cool, check for continuity on the two thermal overload wires, if none, change motor or it have rewound
	Transformer	Check the incoming and the outgoing voltages which should be 24 volts
Motor will not work bit the indicator light is on	Auxiliary Relay	Check voltages to relay terminals, should be 24 volts. If not check for loose wires, if none relay should be replaced
	Socket and/or plug connecting the switch handle to the electrical box	Check the plug connections and the wire connections inside the handle switch
	Switch inside the handle	Make sure the switch makes the connection when pressed
	Main connection	Make sure there is incoming power and outgoing when the handle switch is made, no shorts if so, change the connector
	Motor	Check to see if it spins freely and it is not burnt, may need to be changed or rewound. Check to see if it is receiving voltage from the connector.

*All electrical troubleshooting should be done by a qualified electrician or a technician with a working knowledge for machine electrical systems.

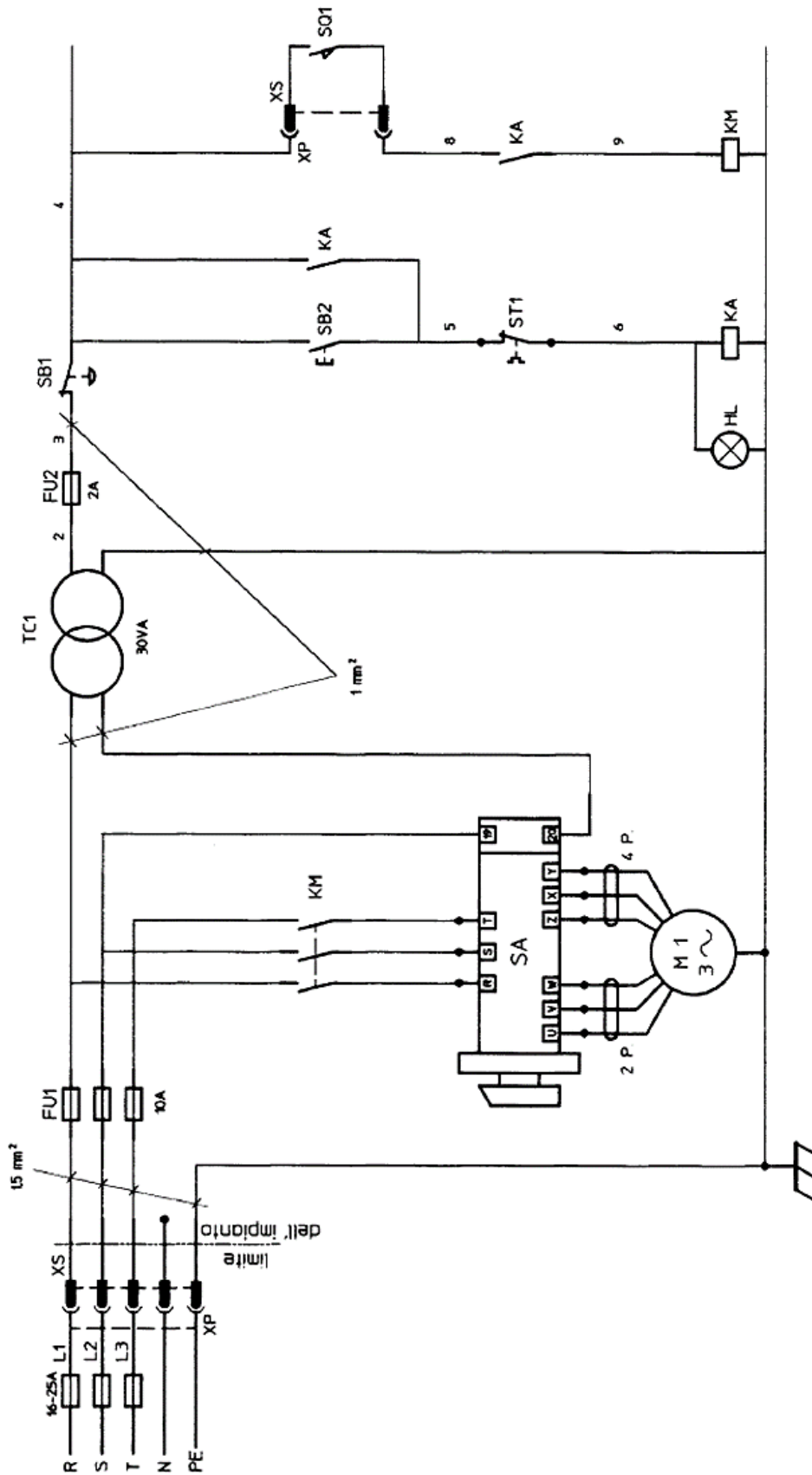
ELECTRICAL COMPONENTS

Single-Phase:

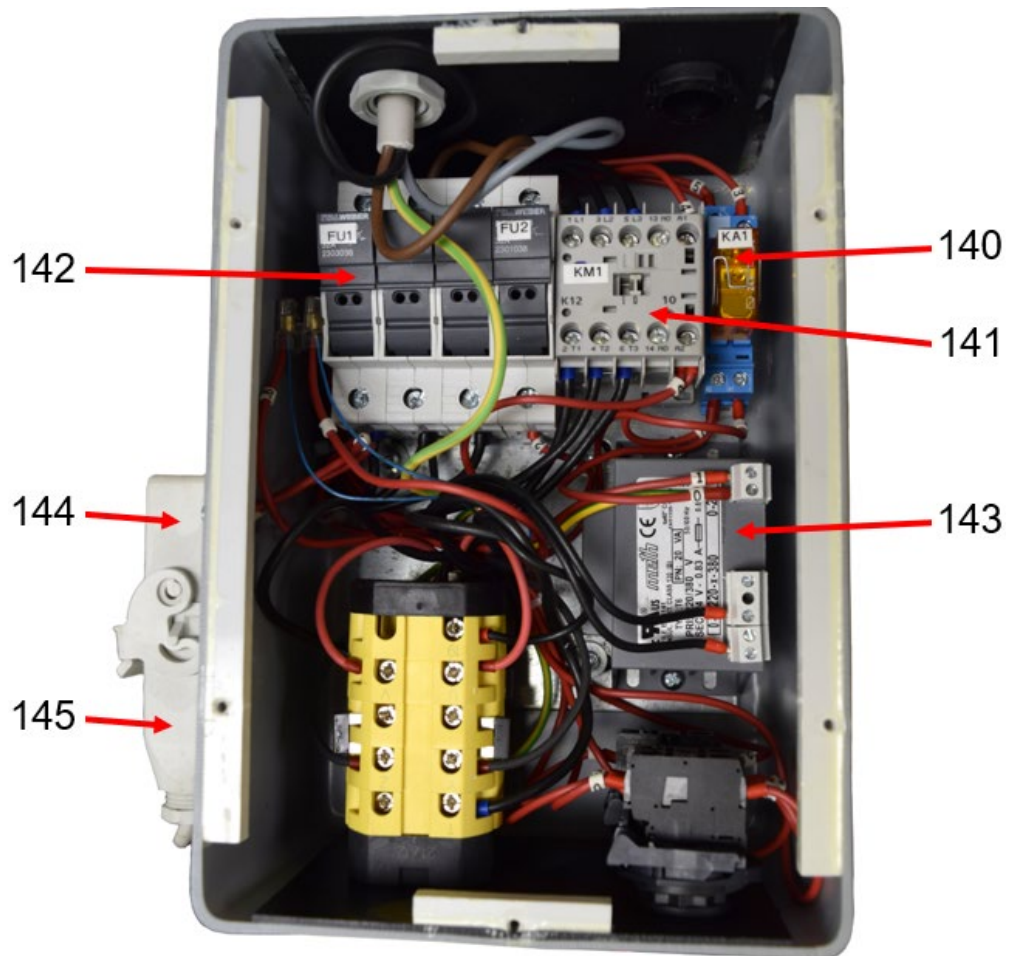


CODE	DESCRIPTION	CODE	DESCRIPTION
M1	Disk Motor	SQ1	Microswitch
XP	Socket	SB1	Emergency Stop
XS	Plug	SB2	LED Button
QS	Isolation Switch	HL	Pilot Lamp
C	Condenser	KA	Auxiliary Relay
FU1	Fuse Cartridge	KM	Remote-control Switch
FU2	Fuse Cartridge	ST1	Thermal Probe
TC1	Transformer		

Three-Phase:



CODE	DESCRIPTION	CODE	DESCRIPTION
M1	Disk Motor	SQ1	Microswitch
XP	Socket	SB1	Emergency Stop
XS	Plug	SB2	LED Button
SA	Switch	HL	Pilot Lamp
FU1	Fuse Cartridge	KA	Auxiliary Relay
FU2	Fuse Cartridge	KM	Remote-control Switch
TC1	Transformer	ST1	Thermal Probe



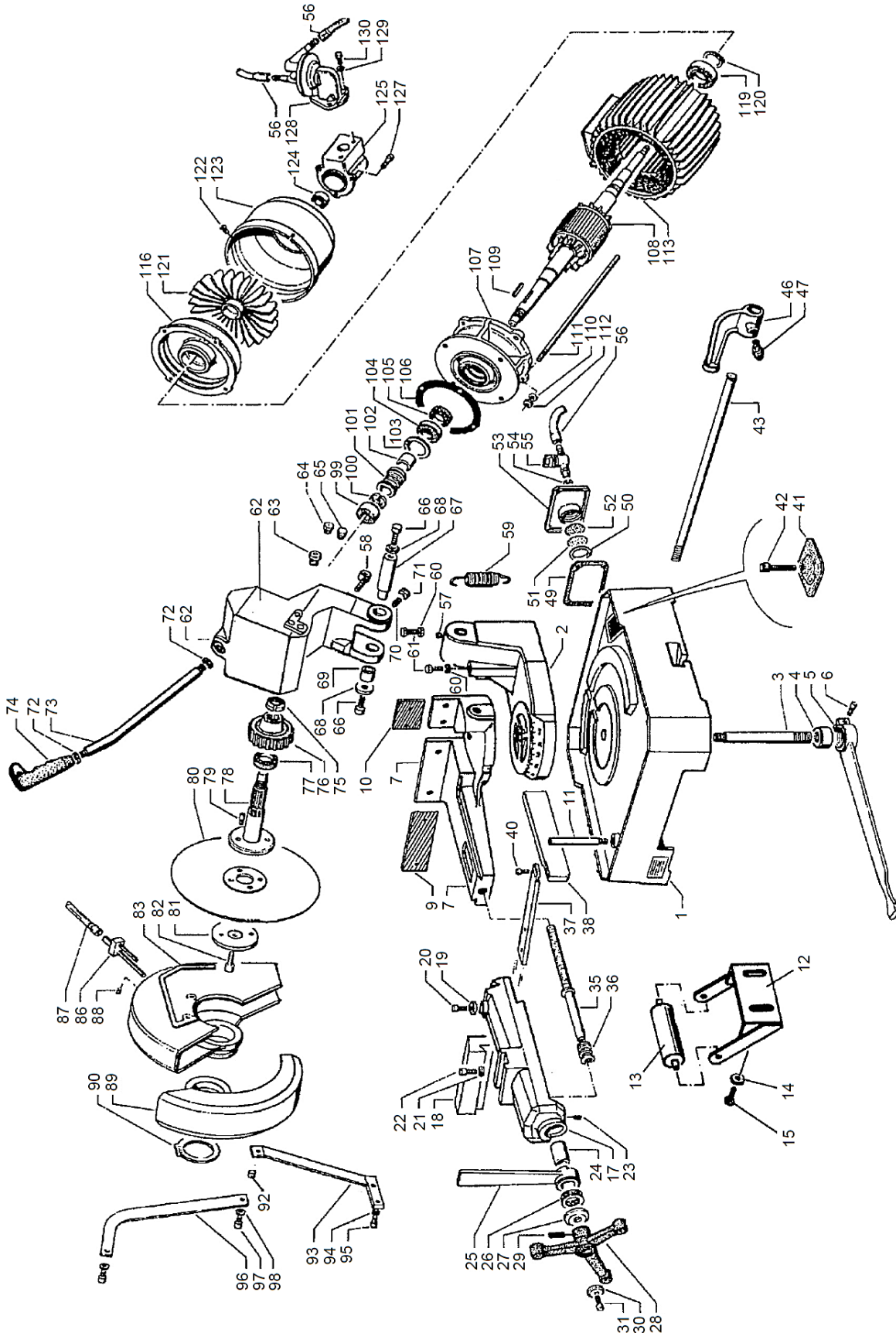
KEY

- 140 Auxiliary Relay
- 141 Remote-control Switch
- 142 Fuse Carrier
- 143 Transformer
- 144 Socket Connector
- 145 Plug Connector

- 146 Speed Switch
- 147 Reset Button
- 148 Emergency Stop
- 149 Electric Components Box



EXPLODED VIEW



PARTS LIST

<u>Item</u>	<u>Part Name</u>	<u>Part No.</u>
1	Machine Bed	303340
2	Revolving Arm	020A0002
3	Revolving Arm Pin	302835
4	Revolving Arm Lock Bushing	AFB80012
5	Revolving Arm Locking Lever	AGB80016
6	Screw (M8-1.25 x 20mm)	80521
7	Counter-Vise	050B0008
9	Counter-Vise Short Jaw	130B0019
10	Counter-Vise Long Jaw	130B0018
11	Counter-Vise Fixing Pin	AFB80023
12	Material Support	303343
13	Material Support	303343
14	Washer (M8 x 21mm O.D.)	82100000
15	Screw (M10 x 30mm L)	81505
17	Vise (cast iron)	050B0009
18	Vise Jaw	130B0015
19	Vise Jaw Washer	AFB8B037
20	Screw (M12)	81110133
21	Vise Jaw Washer	AFB8B037
22	Screw (M12)	81110133
23	Roll Pin, M8 5927	81132081
24	Lever Bushing	AFB80032
25	Quick Lock Vise Lever	AGB80031
26	Bearing AX 3047 + CP 3047	84500001
27	Quick Lock Vise Washer	AFB80033
28	Vise Handwheel (Ø18mm)	47100000
29	Elastic Pin (Ø5mm)	82504189
30	Washer (M8 x 21mm O.D.)	82100000
31	Screw (M8-1.25 x 20mm L)	80521
35	Quick Lock Vise Screw	D50B0100
36	Quick Lock Vise Spring	AFB80035
37	Burr-free Transverse Plate	302962
38	Burr-free Plate	302962
39	Roll Pin, M8 5927	81132081
41	Tank Cover Filter	AFB80044
42	Screw (M6 x 12mm L, coarse)	80625
43	Bar Stop Rod	AFC10047
46	Bar Stop	ANC10046
49	Tank Cover Gasket	ANB80042
50	Ring SEEGER Ø42mm	82610000
51	Complete Assembly 51, 52, 53	ANB80041
52	Complete Assembly 51, 52, 53	ANB80041

<u>Item</u>	<u>Part Name</u>	<u>Part No.</u>
53	Complete Assembly 51, 52, 53	ANB80041
54	Washer (M8 x 21mm O.D.)	82100000
55	Flow Valve	88600000
56	Coolant Hose	69102002
57	Oiler (Ø8mm)	82901005
58	Spring Tie Rod	303341
59	Head Return Spring	AFC10021
60	Hex Nut (M12 x 1.75)	301134
61	Screw (TCCE M12)	81110133
62	Head	302858
63	Sight Glass	88302002A
64	Oil Plug	88302002
65	Oil Plug	88302002
66	Screw (M8-1.25 x 20mm)	80521
67	Hinge Pin	AFB80013
68	Hinge Pin Washer	D80C0083
69	Hinge Pin Bushing	AFB80014
70	Roll Pin, M8 5927	81132081
71	Hex Nut (M8-1.25)	81573
72	Hex Nut (M16)	81600016
73	Head Lever	120C0004
74	Handgrip	44600001
75	Ring Nut (M25-1.5)	81700025
76	Worm Wheel	ABB81005
77	Ring SM (35x47x7mm)	86000000
78	Blade Shaft	060C0009
79	Blade Shaft Flange Stakes	AFB8B007
81	Blade Flange	300977
82	Socket Cap Screw (M12-1.75 x 35mm)	S1110136
83	Fixed Blade Guard	160C0020
86	Coolant Nozzle	AFB80055
87	Coolant Hose	69102002
88	Cap Screw (M6-1.0 x 20mm)	64179
89	Mobile Blade Guard	AHB80051
90	Ring SEEGER Ø60mm E	82600000
93	Tie-rod Support	AFB90087
94	Washer (M8 x 21mm O.D.)	82100000
95	Socket Cap Screw (M8-1.25 x 20mm)	80521
96	Tie-rod Mobile Guard	302908
97	Socket Cap Screw (M8-1.25 x 20mm)	80521
98	Washer (M8 x 21mm O.D.)	82100000
99	Bearing 6301	84101027
100	Ring Nut (M17-1.0)	303053
101	Worm Screw	AFA5B048
102	Worm Screw Spacer	080C0004

<u>Item</u>	<u>Part Name</u>	<u>Part No.</u>
103	Ring SEEGER Ø42mm I	82610000
104	Bearing 3204	302901
105	Ring (DPSM 25x40x7mm)	86001049
106	Head Gasket	ANC10002
107	Mobile Front Flange	AGC20004
116	Rear Motor Flange	N/A
119	Bearing 6205 2RS	80673
120	Ring SEEGER Ø25mm E	N/A
121	Motor Fan	74310007-B
122	Cap Screw (M4)	81701
123	Fan Cover	AHC20006
124	Bearing 609	84101016
125	Pump Connection Box	AG190044
127	Cap Screw (M6-1.0 x 20mm)	64179
128	Coolant Pump	88141000
129	Washer (M6)	43631
130	Cap Screw (M6 x 12mm L)	80625
-	Motor 3 Phase CE	74320127
-	Motor Single Phase CE	74320122-1
140	Auxiliary Relay	72300000
141	Remote Control Switch	301462
142	Fuse Holder	73142005
143	Transformer 30VA	73327011
144	Socket Connector	73600005
145	Plug Connector	73600052
146	Switch, 2 speed CE	70221013
147	Reset Push Button	716812
148	Emergency Push Button	716538
149	Electrical Box	230E0017
-	Pneumatic Vise Kit	AAL3100L
-	Pneumatic Vise Cylinder	200B0003
-	Pneumatic Vise Seals Kit	86045005
-	Single Phase 1 Speed SW	70201011
-	Run Capacitor	302020

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.