



DAKE METAL CUTTING VERTICAL BANDSAW

Model 10-14

INSTRUCTIONAL MANUAL



WARNING!

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

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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:
 1. Model #
 2. Serial #
 3. Sales Order #

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

Warranty Exceptions

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

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

RETURN & REFUND POLICY

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

Returns

- All Dake manufactured / distributed machines, parts and couplings include a 30-day return option. These policies are valid from the date of final shipment to the end user. To be eligible for a return, the item must be unused and in the same condition as received.
- All requested warranty claims must be communicated to the distributor or representative responsible for the sale. Once communication has been initiated, Dake Customer Service must be contacted for approval:
 - Phone: (800) 937-3253
 - Email: customerservice@dakecorp.com
- Once the return request has been approved by Customer Service, a representative will supply a Return Material Authorization (RMA) number.
- The returned item must have the provided RMA number clearly marked on the outside packaging. Any item received without an RMA number clearly visible on the packaging will not be processed.
- An RMA number can only be provided by the Dake Customer Service team and must be obtained prior to the return shipment.

Refunds

- Once the item has been received and inspected for damages, a representative will notify the requestor referencing the provided RMA number. If the return is approved, a refund will be issued to the original method of payment, less a 20% restocking fee.
- The restocking fee may be waived if an order is placed at the time of return with like-value merchandise. Transportation costs are the responsibility of the end user and will not be credited upon return approval.
- Any item that is returned after the initial 30 days or has excessive/obvious use will not be considered for a full refund.

SPECIFICATIONS

Number	988050/988051
Horsepower	1 HP
Voltage	110V/220V Single Phase, 220V/440V 3-Phase
Blade Width	1/4"-1/2"
Blade Length	120"
Blade Speed (FPM)	70/140/270/540
Band Wheel Size	Ø14"


Throat Size	14"
Max Work Height	10"
Worktable Dimensions	15" x 16"
Worktable Tilt	5° left / 45° right
Worktable Height	24-1/2"
Machine Height	76"
Machine Base	24" x 28"
Weight	625 lbs.

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



Serial No.	
Model No.	
Install Date:	

SAFETY

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

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

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

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

SAFETY INSTRUCTIONS

LOCKOUT PROCEDURE

1. Announce lockout to other employees.
2. Turn power off at main panel.
3. Lockout power in off position.
4. Put key in pocket.
5. Clear machine of all personnel.
6. Test lockout by hitting run button.
7. Block, chain or release stored energy sources.
8. Clear machine of personnel before restarting machine.

Label Part No.
76462

SAFETY INSTRUCTIONS

1. Read the instruction manual thoroughly before operating this machine.
2. Wear safety glasses.
3. Wear gloves only when handling material or replacing blade.
4. Never wear gloves while blade is rotating.
5. Do not perform cutting operations which exceed machine capacity.
6. Do not force machine to stall blade or breakage might occur.
7. Clamp workpiece securely.
8. Always use stock stands on both sides of saw blade to support material.
9. Use blade with the correct specification for the material being cut.
10. Keep floor around machine clean and free from chips, scraps, oil, and coolant.
11. Turn electrical power off before performing maintenance, servicing, or changing blades.

Label Part No.
84605

WARNING



Never reach into the point of operation.

Do not operate without all guards in place.

Label Part No.
84604

⚠ DANGER

High voltage. Can cause severe injury or death.

Service by authorized personnel only.

Use lockout.



⚠ PELIGRO ⚠

Alta tensión. Puede provocar lesiones severas o la muerte.

Para reparaciones, emplee personal autorizado solamente.

Use cierre eléctrico.

Label Part No.
84395



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

Follow recommended precautions and safe operating practices.

- Always wear approved safety glasses/face shields while using this machine.
- Make sure that the machine is properly grounded.
- Before operating the machine remove all ties, rings, watches, other jewelry, and roll up sleeves above the elbows.
- Remove all loose clothing and tie up long hair.
- **DO NOT WEAR GLOVES WHILE OPERATING.**
- Keep the floor around the machine clean and free of scrap metal, oil, and grease.
- Always keep machine guards in place when the machine is in use. If removed for maintenance purposes use extreme caution and replace the guards immediately.
- Do not overreach.
- Always maintain a balanced stance so that you do not fall or lean against the blades.
- Dull blades are dangerous.
- Make all machine adjustments or maintenance with the machine unplugged from the power source.
- Use the correct blade. Do not force a blade to do a job which it was not designed for.
- Do not make cuts requiring more power than is available on the machine.
- Replace warning labels if they become obscured or removed.
- Make certain the motor switch is in the OFF position before connecting the machine to power.
- Always keep an eye on the work, careless acts can result in serious injury.
- Make a habit of checking to see that the keys and adjusting wrenches are removed before turning on the machine.
- Never place hands directly in line with the saw blade.
- Always use push sticks when cutting small material.
- Raise or lower the blade guide only when the machine has been turned off and the blade has stopped moving.
- Read and understand the warnings posted on the machine.
- Failure to comply with all these warnings could lead to serious injury.

SET UP

Blade Selection

For the operator's convenience a blade selector chart is located inside the saw cover (top access door). It provides recommended blade speeds, required teeth per inch, and minimum cutting radius for various band widths. If there are still questions on which blade to purchase please contact DAKE.

Note: You must have at least 3 teeth in to the work or blade damage will result. For straight cuts a 3/4" blade is best.

Blade Speed


 **Before performing this ensure that the machine is LOCKED OUT and unplugged.**

To change blade speed:

1. Loosen the motor mounting screws.
2. Lift the motor and move the V-belt to the correct pulley for the desired speed.
3. Tighten the motor mounting screws and ensure that there is not slack in the V-belt.

Note: The largest pulley will result in the slowest speed, and each step to a smaller pulley will give the next fastest speed of the saw.

Blade Removal And Installation

 **Before performing this ensure that the machine is LOCKED OUT and unplugged until instructed otherwise for this process. Gloves are required to handle the new and old blade.**

1. Release the blade tension handle.
2. Remove the blade.
3. Place new blade over the bottom wheel then the top wheel.
4. Tighten the blade handle enough to hold the blade firmly in place and push the blade into the guide inserts.
5. Close the access doors to the machine.
6. Turn the machine on to allow the blade to position itself then shut off the machine.
7. Finishing tightening the blade. Blade must be tight to ensure a straight cut.

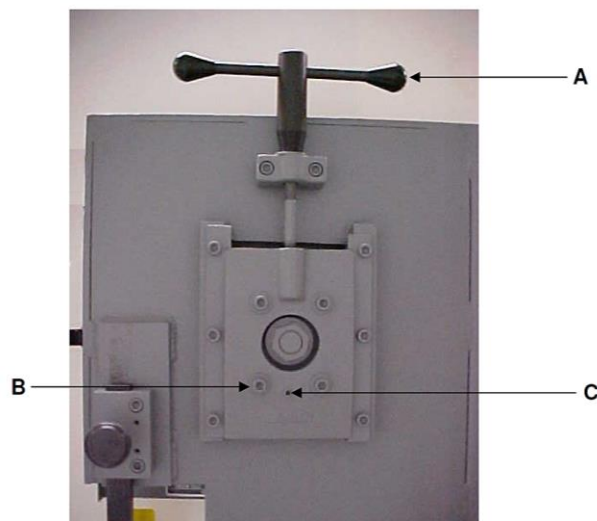
ADJUSTMENTS

Blade Tension Handle (Item A): Used to remove and install saw blade. Also used to set correct blade tension.

Upper Blade Wheel Adjustment (Item B & C): If the saw should get out of adjustment and the blade runs off the wheel or runs back against the lip,

1. Loosen the two bottom bolts on the wheel side.
2. Turn the set screw in or out to make the blade run approximately 1/32" away from the lip on the back of the wheel.
3. Tighten the two wheels slide bolts.

NOTE: If the blade can run against the lip on the wheel it will wear the lip off.



MAINTENANCE

Lubrication

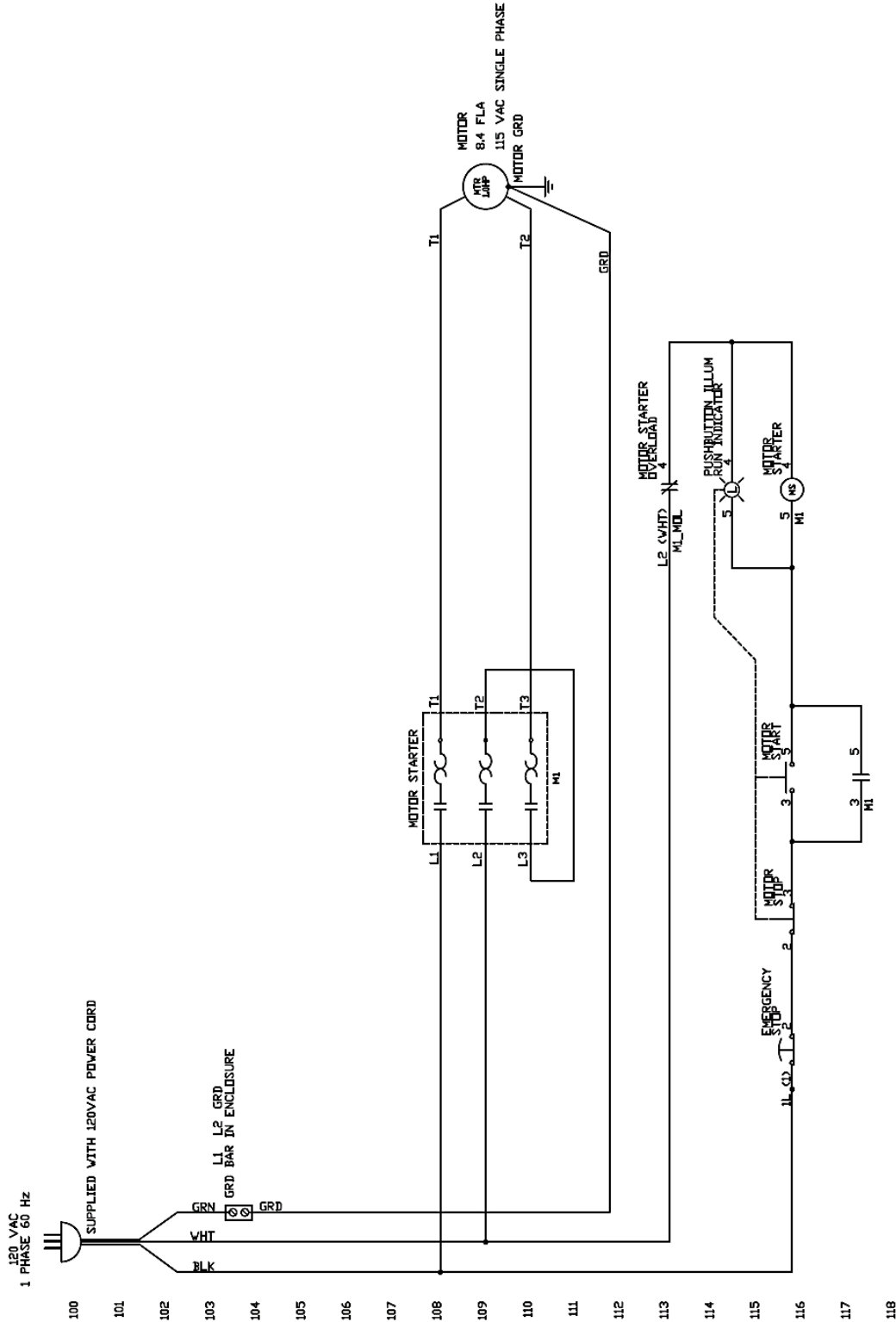
- The gear box is filled at the factory. Check the oil level upon arrival of the machine and six months thereafter. This is in the small sliver cup after opening the side panel of the base, if there is visible oil in the cup no refill is needed. Use 90 weight gear lube to maintain fluid level.

TROUBLESHOOTING

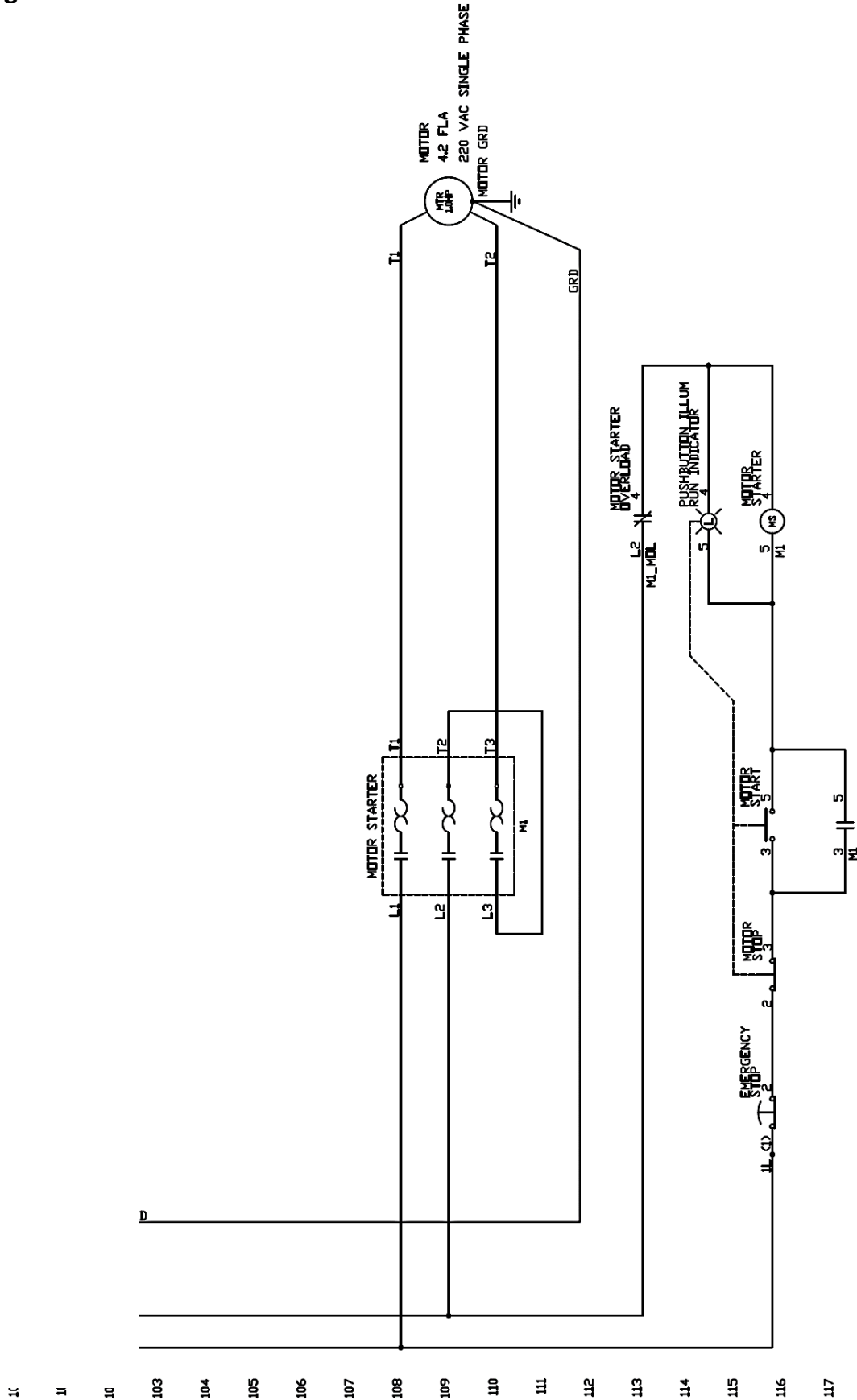
SYMPTOM	CAUSE	SOLUTION
Saw is not cutting straight	Blade tension is too low	Increase blade tension
	Blade is dull or worn on one side	Replace blade
	Blade is upside down. Teeth must point down.	Correct blade orientation
Blade teeth breaking	Incorrect blade pitch for application	Use the pitch and speed selector on the saw or contact Dake if unsure what blade to use for the application
	Inferior blade	Change to a higher quality blade
Blade Damage	Blade tension is incorrect	Adjust blade tension
	Blade is being overfed	Slow the rate material is pushed into the blade
	Blade teeth hitting guides	Adjust a proper gap between the blade and the guide insert
Blade is twisting	Blade installed improperly	Check and fix if found improperly installed
	Blade tension too loose	Tighten blade tension
	Blade is being overfed	Slow the rate material is pushed into the blade
Sawing direction deviates	Blade teeth are worn unevenly	Make sure a quality blade is used
	Blade tension is too loose	Tighten blade tension
	Guidepost was set too high	Set guidepost to be within a 1/4" of the work
Blade walks	Blade tension is too loose	Tighten blade tension
	Blade is not tracking correctly	See "Adjustment" in this manual to adjust the upper blade wheel
Blade dulling prematurely	Blade speed used is too fast	Adjust speed lower
	Blade selection is improper for application	Use the pitch and speed selector on the saw or contact Dake if unsure what blade to use for the application
	Blade is being overfed	Slow the rate material is pushed into the blade
Excessive noise when machine is running	Saw is not sitting flat on the floor	Reposition the machine on a flat, even floor

ELECTRICAL COMPONENTS

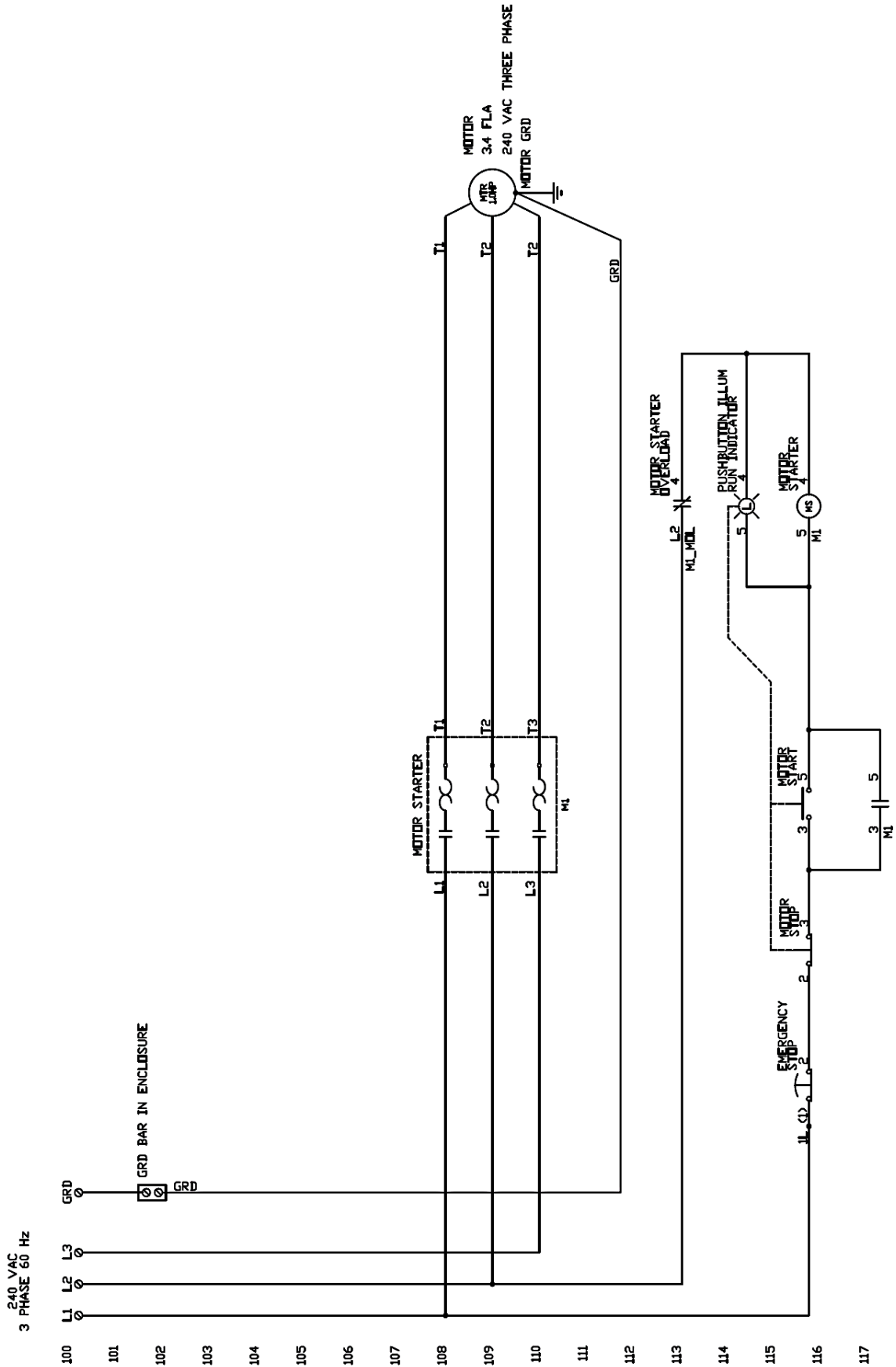
120 Volt Single Phase:



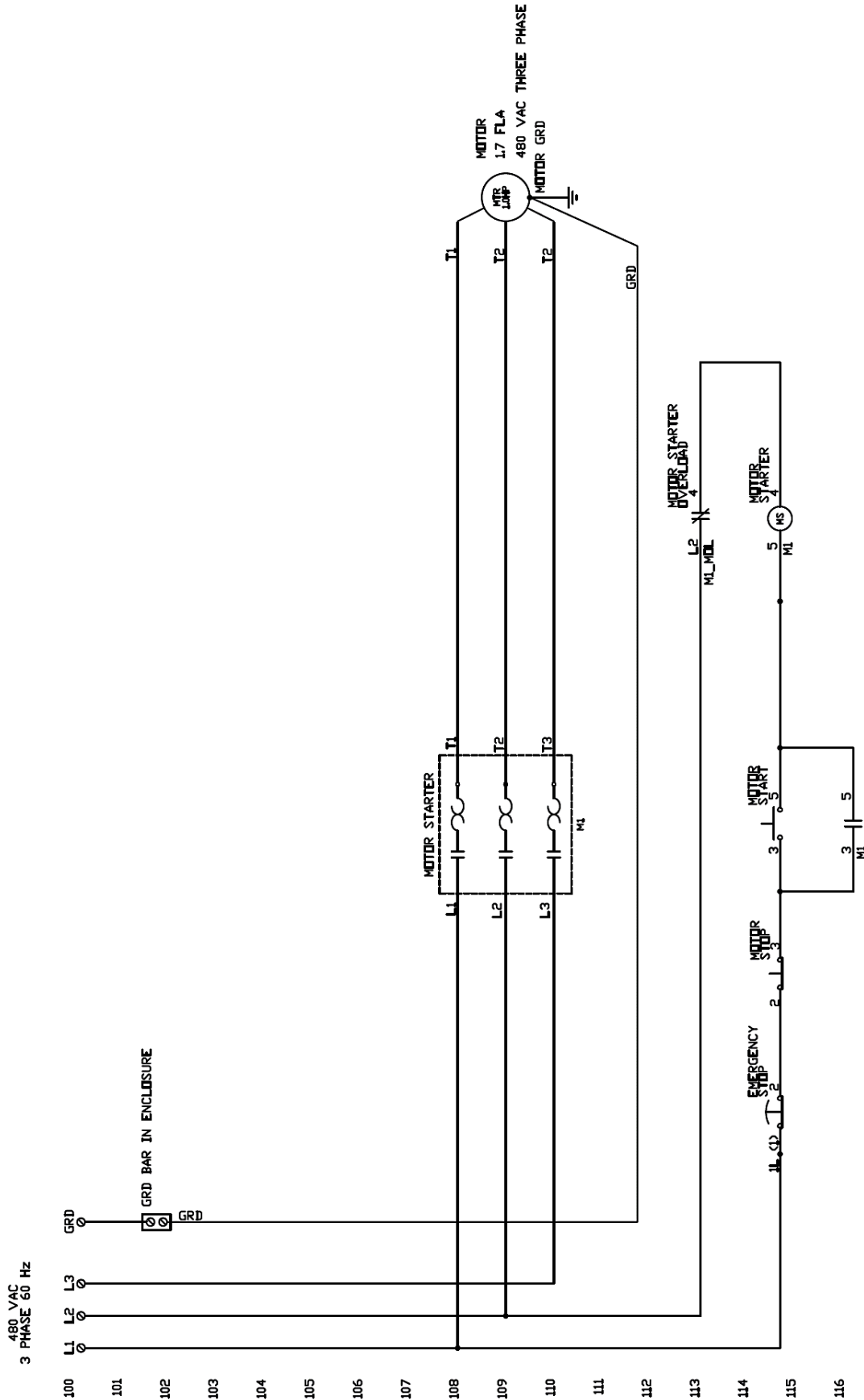
220 Volt Single Phase:



220 Volt 3-Phase



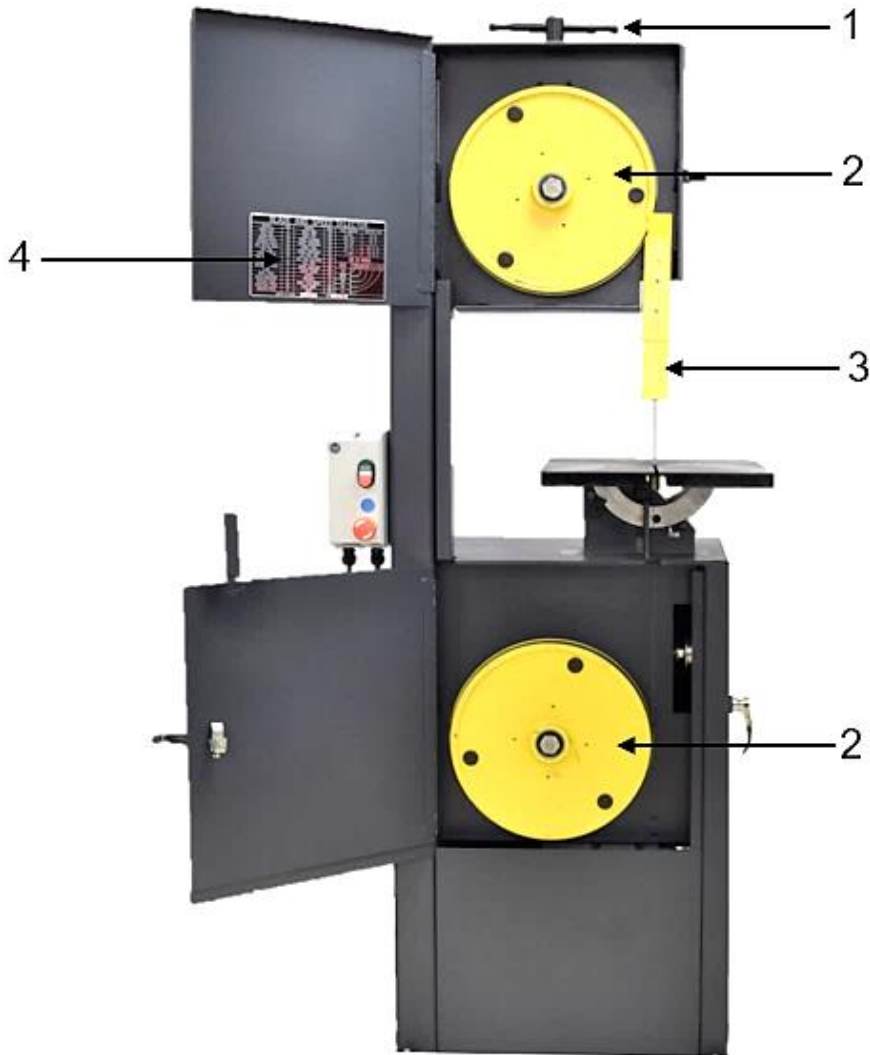
480 Volt 3-Phase:



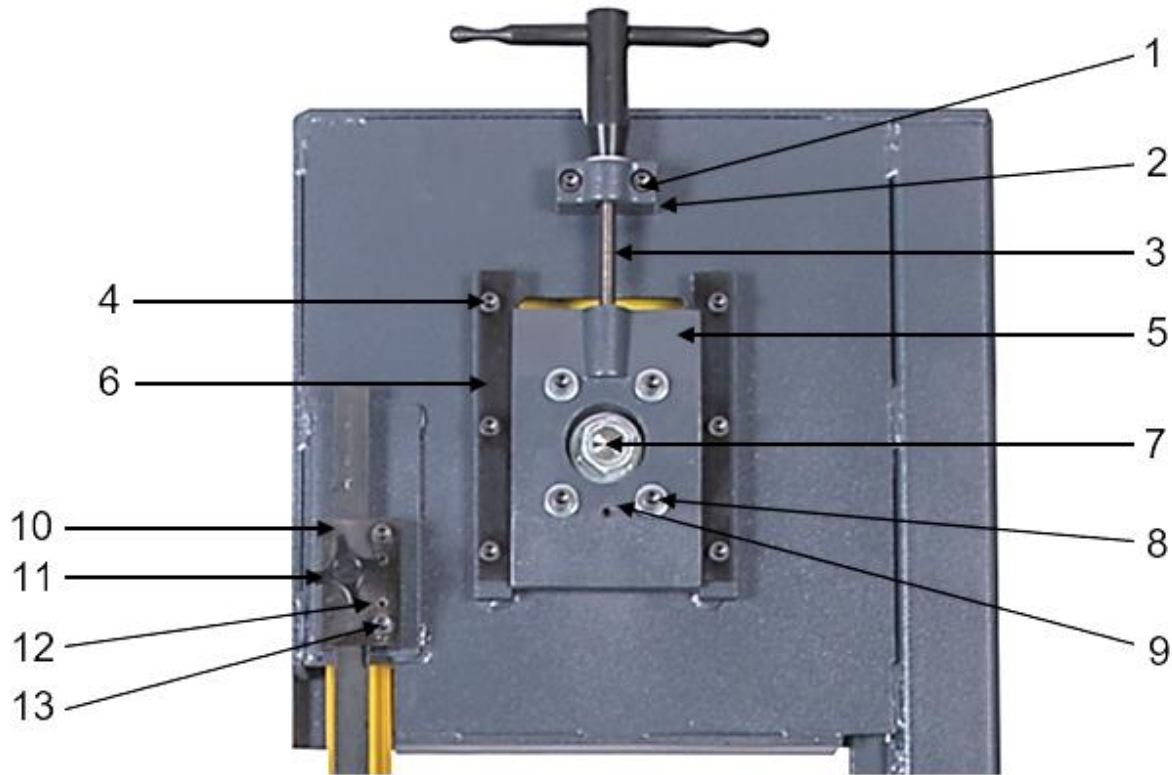
EXPLODED VIEW & PARTS LIST



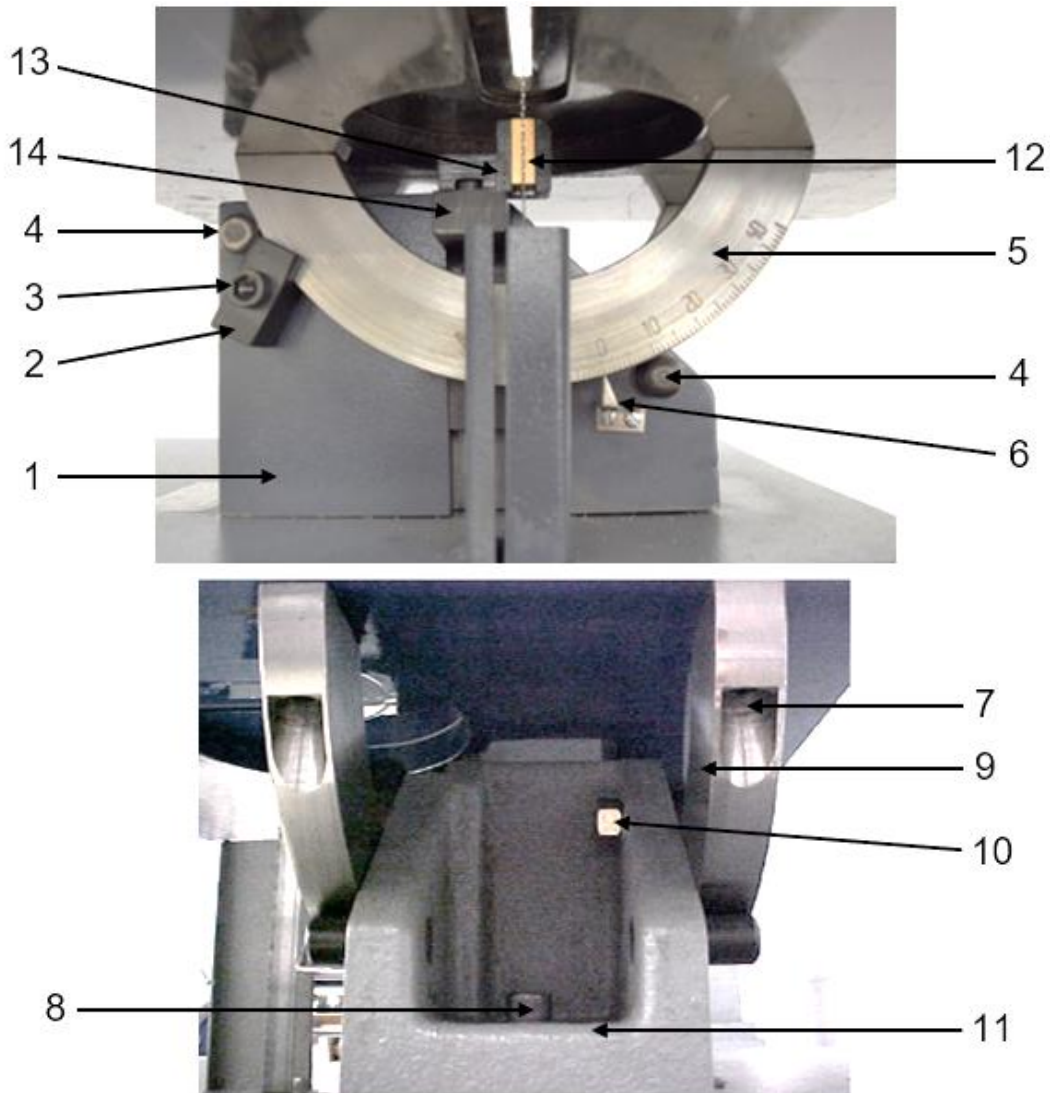
<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	716716	Tension Handle Assembly	1
2	86747M	Door Latch	1
3	87080	Table	1
4A	300568	Door Handle	2
4B	300569	Door Latch	2
5	716745	Frame Assembly	1



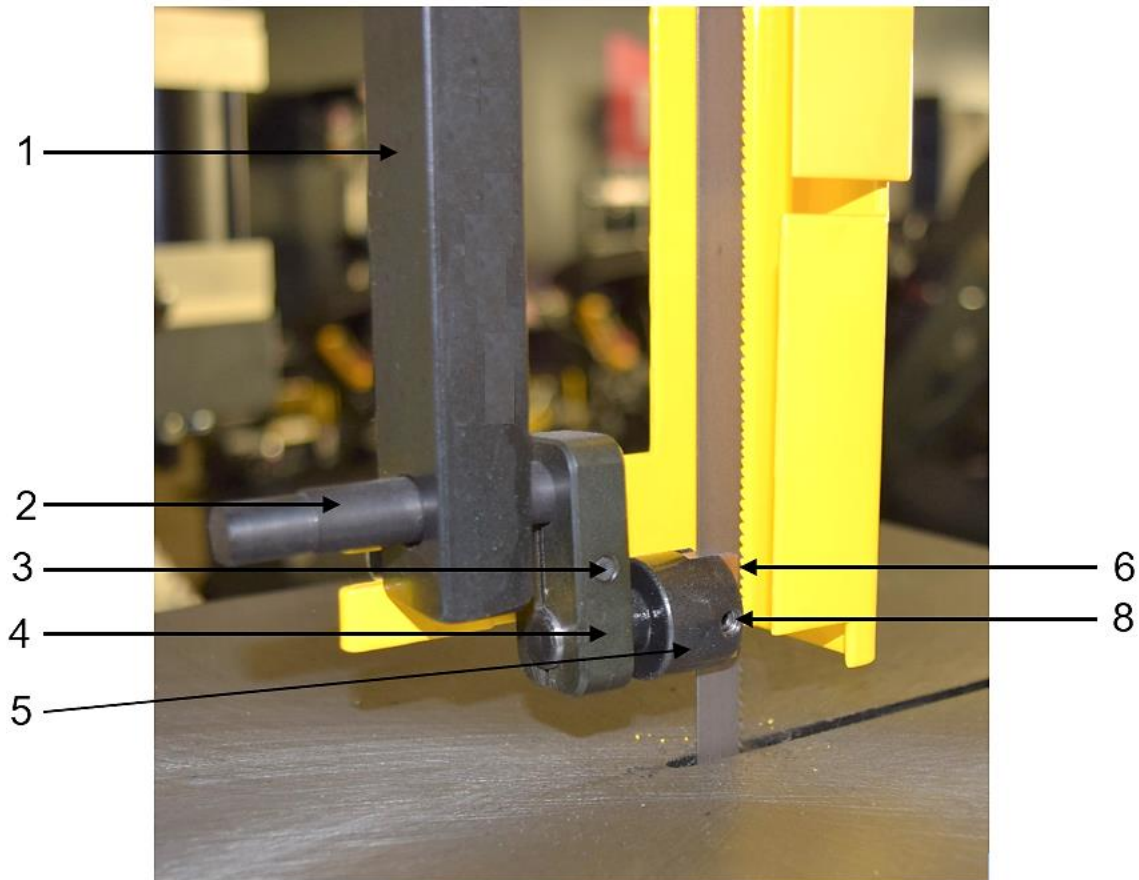
<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	716716	Tension Handle Assembly	1
	86828	Tension Handle Body	1
	87104	Tension Handle	2
2	716705	Wheel Assembly	2
	300459	Blade Wheel Band	1
	300693	Wheel Bearing	2
	86795	Wheel Blade – Lower/Upper	1
	86803	Axle Wheel – Lower/Upper	1
	86804	Stud – Wheel	1
3	300917 & 300918	Blade Guard	1
	300342	Thumb Screw	2
4	300912	Speed Selector Label	1



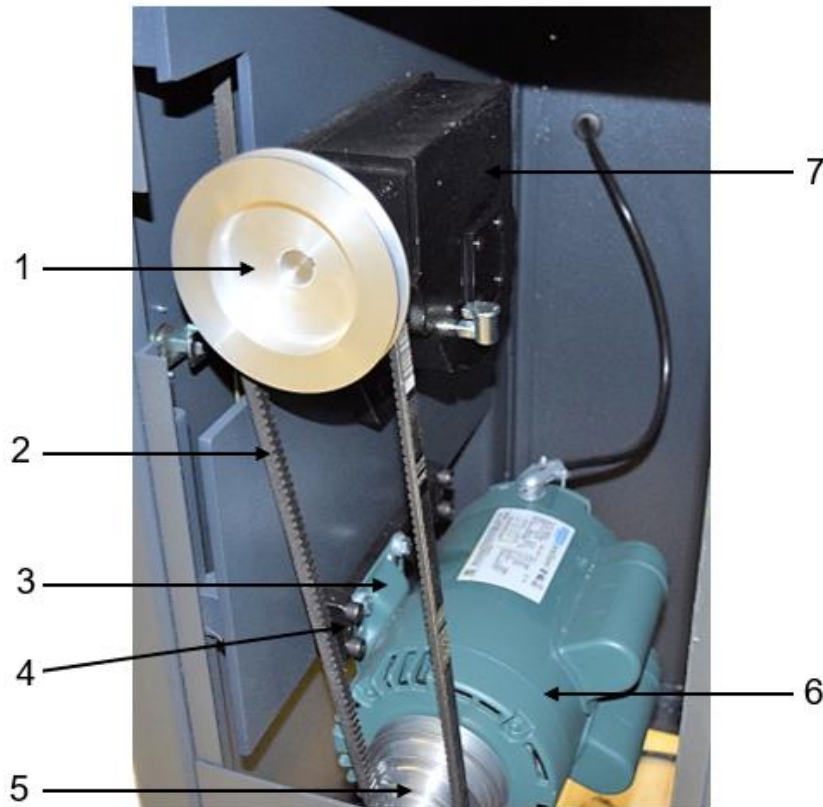
<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	43450	Socket Cap Screw (3/8"-16 x 1-1/4")	2
2	86827	Pillow Block	1
3	86828P	Tension Screw	1
4	43447	Socket Cap Screw (3/8"-16 x 3/4")	6
5A	86824	Wheel Slide – External piece	1
5B	86825	Wheel Slide – Internal piece	1
6	86826	Rail Slide Wheel	2
7A	43939	Hex Nut (7/16"-20)	1
7B	43638	Flat Washer (1")	1
8A	43452	Socket Cap Screw (3/8"-16 x 1-3/4")	4
8B	43632	Flat Washer (5/16")	4
9	43591	Set Screw (3/8"-16 x 1)	1
10	86810	Guide Bar Holder	1
11	300832	Knob Assembly (1-1/2")	1
12	44337	Roll Pin (1/4" x 1-3/4")	2
13	43591	Socket Cap Screw (3/8"-16 x 1-1/2")	1
14	86556	Handles	3



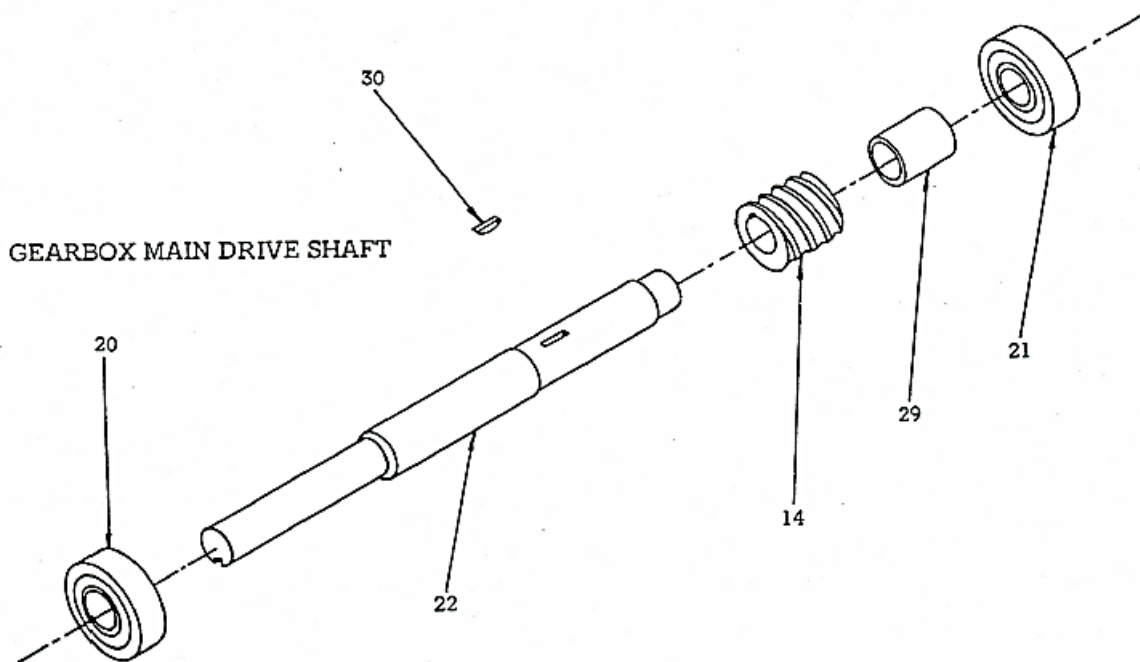
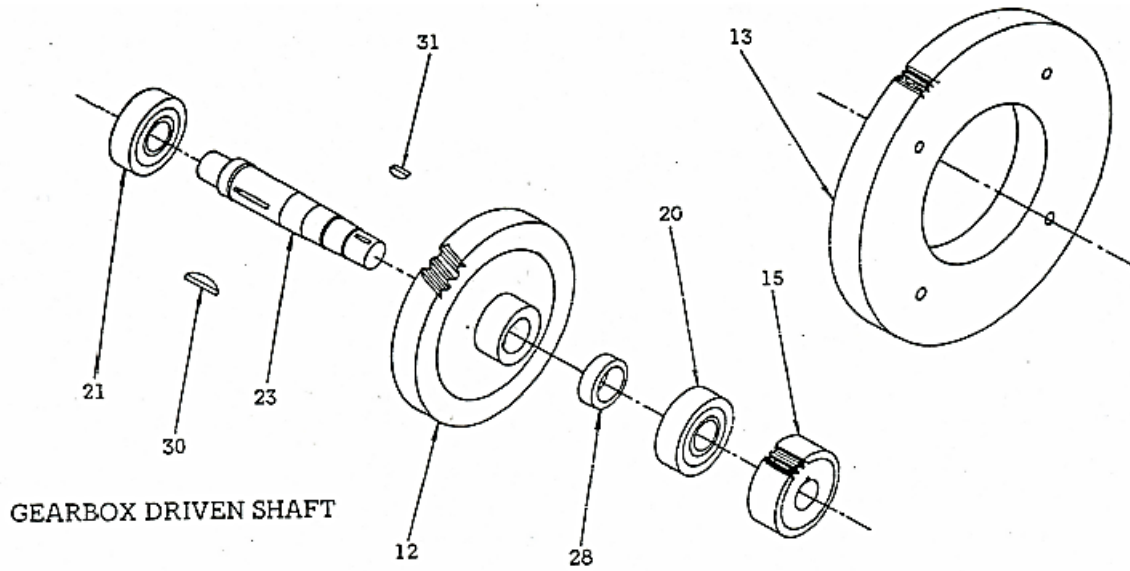
<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
	716749	Saddle Assembly	1
1	87081	Table Top Base	1
2	87025	Table Lock	1
3	43939	Hex Jam Nut (7/16"-20)	1
4	44033	Dowel Pin (5/8" x 1-1/2")	4
5	87078	Rocker Rings	2
6	87077M	Rocker Ring Pointer	1
7	43449	Socket Cap Screw (3/8"-16 x 1.0)	4
8	43451	Socket Cap Screw (3/8"-16 x 1-1/2")	2
9	300564	Cam Follower	1
10	43939	Hex Jam Nut (7/16"-20)	1
11	44337	Roll Pin	2
12	86806	Contour Guide Insert	1
13	87034	Lower Guide Holder	1
14	87033	Guide Bracket	1



<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	87029	Guide Bar	1
2	300701	Guide Kit	1
3	43545	Socket Cap Screw	1
4	87028	Upper Guide Swivel	1
5	86808	Holder Contour Insert	1
6	86806A	Insert Contour Guide 1/2" Blade Carbide	1
6	86806B	Insert Contour Guide 1/2" Blade Brass	1
8	43545	Socket Cap Screw (#10-24 x 1/4" Cup Point)	1
-	716756	Lower Roll Guide Assembly	1
-	716753	Upper Roll Guide Assembly	1



<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	300473	Gearbox Pulley	1
	71061	Key for Pulley (3/16" x 3/16" x 1-1/4")	1
2	10077-10	V-Belt	1
3	86798	Motor Mounting Axle	1
4	86800	Motor Mounting Block	2
	43450	Socket Cap Screw (3/8"-16 x 1-1/4")	4
	43414	Socket Cap Screw (1/4"-20 x 3/4")	2
5	300473	Motor Pulley	1
	71061	Key for Pulley (3/16" x 3/16" x 1-1/4")	1
6	300485	Motor – Single Phase	1



<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
12	300666	Worm Gear (Bronze)	1
13	86784	80 Tooth Gear	1
14	300456	4-Lead Worm	1
15	300646	24 Tooth Gear	1
20	5072-00	Gearbox Bearing	2
21	5073-00	Gearbox Bearing	2
22	86785	Main Drive Shaft	1
23	86781	Gearbox - Short Axel	1
28	86783	Gearbox Spacer (1-1/4" OD)	1

<u>Item</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
29	86786	Gearbox Spacer (1" OD)	1
30	300449	Woodruff Key #13	2
31	300451	Woodruff Key #5	1
	300472	Bearing Seal	2
	300490	Gearbox Gasket	1
	300491	Gearbox Gasket	4
	300589	Dowel (3/16" x 12)	2
	43412	Socket Cap Screw (1/4"-20 x 1/2")	16
	43414	Socket Cap Screw (1/4"-20 x 3/4")	6
	43590	Socket Set Screw (3/8"-16 x 3/4")	3
	86820	Small/hole Bearing Cover	2
	86821	Small Bearing Cover	2
	86822	Bearing Casting	1
	86823	Gearbox Cover	1
	716712	Gearbox Assembly	1

Electrical Components:

<u>Description</u>	<u>Part Number</u>
Contactora 460 Volt	716818
Contactora 230 Volt 3-Phase	716817
Contactora 220 Volt Single Phase	300718A
Contactora 110 Volt	300717

ORDERING INFORMATION

Please contact factory for current prices.

- 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.