

DAKE HORIZONTAL BANDSAW

Model JH10W1

INSTRUCTIONAL MANUAL





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.

<u>Parts</u>

 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
 - o Email: <u>customerservice@dakecorp.com</u>
- 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 <u>clearly</u> 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

	<u>JH10W1</u>	<u>JH10W3</u>	
Number	985017	985018	
Voltage	110V/220V, Single Phase	220V/440V, 3-Phase	
Capacity	10" rounds, [•]	18" flats	
Horsepower	1 HP		
Max Blade Speed	270 fp	m	
Blade Width	1"		
Blade Length	137"		
Blade Speeds	50/90/160/270 fpm		
Solid Round 90° Capacity	10"		
Solid Round 45° Right Capacity	7"		
Solid Rectangle 90° Capacity	5" x 18	3"	
Solid Rectangle 45° Right Capacity	ty 4" x 10"		
Bed Work Area	11" x 18"		
Weight	935 lbs.		
Height	75"		
Floor Space	30" x 65"		
Floor To Bed	23-3/4"		



SAFETY

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

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



Follow recommended precautions and safe operating practices.

Carefully read all safety messages in	This machine is intended to be operated
these instructions and on your saw's	by one person. Only properly trained
safety signs. Keep safety labels in good	personnel should be authorized to operate
condition. Replace missing or damaged	this machine.
safety labels.	



INSTALLATION

UNCRATING: Remove crating carefully. For ease in handling do not remove from skid until machine has been moved to its approximate location.

LEVELING: Position machine level, shim under legs if necessary. Wet machines should be more carefully leveled to be certain that the coolant intake remains submerged.

CAUTION: BE SURE ELECTRICAL CHARACTERISTICS OF MOTOR AND SWITCH CORRESPOND WITH ELECTRICAL POWER SUPPLY.

CONNECT INCOMING POWER TO THE STARTER PER APPLICABLE DIAGRAM, AND IN ACCORDANCE WITH ALL LOCAL CODES.

DO NOT ATTEMPT TO RUN THIS SAW UNTIL THE BLADE ALIGNMENT HAS BEEN CHECK AS PER THE OWNER'S MANUAL AND THE BLADE HAS BEEN PROPERLY RE-TENSIONED.

OPERATION

FEATURES

OFF/ON Switch: Machines are equipped with a with low voltage, dropout protected manual starter and a limit switch. When the machine frame reaches the end of its down travel it contacts the limit switch, turning off the machine.

Blade Tension Handle: To keep blade at proper tension turn the screw handle until it is at tight as possible. Check every 8 operating hours and retighten to compensate for possible stretching of the blades. Consult your blade manufacturer for the proper PSI tension.

Guide Arms: Guide arms should be set as close as possible to the work without interfering. Loosen the handle on the left guide arm to slide arm along the top of the frame, once in desired location tighten the handle to lock guide arm in place.

Hydraulic Control: The hydraulic control cylinder mounted on the rear of the machine is operated by a control valve mounted on the front of the machine head. To close the valve, turn the control to the right. When the valve is completely closed, the frame will remain stationary, the desired position. To open the valve, turn the control left. Opening of the valve will control the descending speed of frame (or head) and does not control frame weight. This control is mainly used for cutting pipe or thin-walled tubing, structural, etc., to prevent plunging of the saw blade.



Stock Stop Guide: Consisting of a stock stop assembly and a mounting bar installed in the tip-off block on front of the machine. The stop assembly can be moved along the bar to indicate correct length for duplicate cuts. Stock stop rod has a cap screw in the end for making fine adjustments. Rotate rod right to extend the rod into position in order measure stock and turn left to retract the rod before cutting.

Vise: The vise can be positioned straight for a 90° cut or at any angle to cut at 45°. The vise swivel jaw adjusts automatically to any position of the stationary jaw.

Vise Handwheel: Used to open and close the vise jaw, to do so the vise nut must be fully engaged. Turn the handwheel counterclockwise to open the vise and clockwise to close the vise.

Vise Quick Release: Consists of the vise half-nut, vise lift, lift handle and a sliding holddown block to which the swivel jaw is attached. To move the vise, lift on the lift handle toward the front of the machine to disengage the vise nut from the vise screw; this allows the swivel jaw to move freely. Move the lift handle towards the rear of the vise to engage the vise nut when clamping.

BLADE SELECTION

Saw blades should be selected by choosing the blade that will give the best results at the lowest cost. Type of material and the speed at which it must be sawed determine the choice. Listed below are general factors affecting blade selection.

- 1. Blade Type
 - a. Carbon Steel Can be used to cut all types of ferrous, non-ferrous and composition materials except alloys containing high percentage of chrome and nickel. Limiting factor: low resistance to heat.
 - Bi-Metal Designed for cutting ferrous metals in production cut-off applications. Developed to saw high alloy materials that cannot be cut economically by other means. Can be operated at higher speeds and greater feed pressures than carbon steel blades.
- 2. Tooth Style
 - a. Standard Zero-degree rake angle and full round gullets. Best suited for cutting ferrous and non-ferrous materials.
 - b. Skip Tooth Basically the same as standard except for more widely spaced teeth. Provides added chip room when cutting non-ferrous materials.



- c. Hook Tooth Similar to skip tooth except teeth have positive rake. Effective in sawing non-ferrous metals and large ferrous sections when heavy feed pressures are required.
- 3. Tooth Spacing
 - a. Tooth spacing is determined by hardness of material and/or the cross-section. The harder the material, the more teeth per inch. Thin cross-sections require more teeth to avoid straddle. Rule: at least 3 teeth in contact with work.
- 4. Tooth Set
 - a. Raker Most widely used. Consists of a repeated pattern of one tooth set left, one right and one tooth straight. Recommended for production cutting where material is of uniform size, shape, and type.
 - b. Wavy Has groups of teeth set alternately to the left and to the right forming a wave-like pattern. Used for cutting thin stock or where the work varies such as in pipe, angles, channels, and extrusions.

BLADE REMOVAL

- 1. Raise frame a few inches above the bed and close feed cylinder valve to hold frame up.
- 2. Remove the necessary guarding and blade cleaning brushes.
- 3. Turn blade tension screw counterclockwise and pull the idle wheel toward the center of the machine.
- 4. Push blade down, out of blade guides and remove blade from machine.

BLADE INSTALLATION

- 1. Raise frame a few inches above bed and close the feed cylinder valve to hold frame up.
- 2. Remove necessary guards and blade cleaning brushes.
- 3. Turn blade tension screw counterclockwise and pull idle wheel toward center of machine.
- 4. Grasp blade in center forming two loops. From rear of machine place blade loops under wheels and rest the near portion on right front blade guard. CAUTION: BE SURE TO WEAR GLOVES WHEN HANDLING BLADES.
- 5. Push blade up into blade guides. CAUTION: BE AWARE OF HYDRAULIC & COOLANT LINES.
- 6. Fit blade up against flanges of the idle and drive wheels and tighten tension screw enough to hold blade in place. Depress side of blade near rear blade guard to hold blade on wheels while tightening tension screw.



- 7. Check to see that the blade is positioned correctly and tighten screw. Consult blade manufacturer for proper PSI tension.
- 8. Install blade cleaning brushes and guards that were removed earlier.

BLADE TRACKING ADJUSTMENT

- Saw blade should track on each wheel with the back of the blade up to, but not riding on the wheel flange. Adjust as follows:

Idle Wheel

- Open top cover on left end of machine to gain access to idle wheel. Idle wheel is mounted on a slide block, which contains the blade height adjustment screws.
- To raise the blade, loosen the two screws toward center of machine (A, on right) one-half turn and tighten the other two screws (B) onehalf turn. Be sure tension screw (C) is properly tightened to not over adjust.
- 3. Check by running machine after each adjustment.



To lower blade, reverse procedure – loosen screws (B) and tighten screws (A).

Drive Wheel

- To raise the blade, loosen two cap screws (A, on right) and tighten screws (B and C). All four screws must be turned equally and in small increments (about ¹/₂ turn) to avoid over adjustment.
- 2. Check by running machine after each adjustment.

To lower blade, reverse above procedure – loosen screws (B and C) and tighten screw (A).





BLADE GUIDE ADJUSTMENT

Note: The following instructions are for one guide arm; procedure is same for both arms. Left hand guide arm is shown to the right.

- Loosen nut (A, on right) and turn eccentric axle (B) until there is no light gap between rollers and blade...do not pinch the blade. Tighten nut (A).
- 2. Vertical and radial adjustment is provided by the clearance in the guide mounting holes (C). This allows squaring of the blade to the bed and holding the blade in the natural blade line.
- Proper guide adjustment may require adding or removing washer (shims) (D) for correct bearing height (E).



- To check for proper balance spring adjustment, lift frame at by the handle with an extension type scale (fish scale). The frame should weigh 12-15 pounds; if not, adjust by turning the nut on the tension screw on bottom of spring.

OPERATING INSTRUCTIONS

- 1. Raise frame and close feed cylinder valve to hold frame in elevated position.
- 2. Loosen the vise nut and open the vise. Place work in vise and slide the vise swivel jaw against the work piece. Engage the vise nut and tighten the vise screw to clamp the work securely.
- Slowly open feed cylinder valve and lower the frame until the blade is ½" to 1" away from the work. CAUTION: IF THE BLADE SHOULD REST UPON THE WORK BEFORE MOTOR IS STARED THE BLADE TEETH CAN BE DAMAGED. IF THE BLADE IS DROPPED ONTO THE WORK THE BLADE MIGHT BREAK. MAKE SURE THE BLADE IS PROPERLY BROKEN IN PRIOR TO CUTTING.





- 4. Move the adjustable guide arm as close as possible without contact to the work to provide maximum blade rigidity.
- 5. Check the blade tension, adjust if needed. Consult blade manufacturer for proper PSI tension.
- 6. Turn coolant valve on. CAUTION: DO NOT OPERATE MACHINE WITHOUT SUFFICIENT COOLANT IN TANK. COOLANT MUST BE WATER-SOLUBLE. DO NOT USE OIL.
- 7. Check blade speed needed for material being cut. Refer to blade manufacturer for proper speeds for materials.
- 8. To change blade speed, loosen thumbscrew on right end of machine and raise the pulley guard. Move drive belt to proper grooves in both pulleys for desired blade speed (See figure below), then replace the guard.



- 9. Start motor.
- 10. Open feed cylinder valve to the proper setting. "Proper" setting depends upon type of material, hardness and thickness of stock and desired accuracy and finish. Soft materials require less feed than hard materials. Thin cross-sections require less feed than solid cross sections. Generally, reduced feed pressure will result in a straighter more accurate cut.



MAINTENANCE

FEED CYLINDER BLEEDING

Air trapped in the hydraulic cylinder can cause the down fed of the machine head to be erratic or "bouncy". Before taking corrective steps observe CAUTION note.

CAUTION: UNDER NO CIRCUMSTANCES SHOULD THE HYDRAULIC TUBING CONNECTIONS BE LOOSENED OR DISCONNECTED WITH THE MACHINE HEAD IN THE UP POSITION.

- 1. Using AW32 hydraulic oil or equivalent, open the oil cup and fill to top with oil, then close.
- 2. With your finger over the oil cup lid raise the head of the machine then lower it.
- 3. Repeat steps 1 & 2 until the oil cup is full.

LUBRICATION

Lube Point	Description	Frequency	Lubricant	Instructions
	Drive wheel	Trequency	Lubricant	
1	ring gear	6 months	D	Clean thoroughly before lubricating.
				Maintain level at 2 to 3 ounces.
2	Gear box	Maintain	В	Drain and refill yearly. Capacity of 3
		level		ounces.
3	Pivot bar (2 fittings)	Monthly	С	Use grease gun.
4	Tension screw	6 months	С	Clean threads before lubricating.
5	Idle wheel	6 months	С	Clean thoroughly before lubricating.
	Silue ways	Maintain		Maintain loval found at the tap of ail
6	Feed cylinder	iviairitairi	Α	
	-	level		l cup.



	RECOMMENDED LUBRICANTS
Α	Mobil DTE 24 or 26 oil.
	Viscosity range 310SSU @ 100°F
В	Gear oil 80/90.
	Mobil SCH634 synthetic gear lube.
С	General purpose grease.
	Viscosity range NLGI-2.
D	Open gear lubricant.



TROUBLESHOOTING

Blac	de not	cuttir	ng stra	aight		
↓	↓ Blade breaking/teeth stripping					
	↓	Prer	matur	e blac	de dulling	
		\downarrow	Bac	k of b	lade swaging over	
			\downarrow	Piec	ces breaking away from the back o	of the blade
				↓		
						1
•			•		Improper blade tensions	Adjust tension screw
•	•		•		Excessive feed rate/cutting pressure	Turn cylinder control knob to decrease head descent speed and/or move slide weight to right
•			•		Guide arms too far from work or cutting pressure all on one guide	Move guide arm
•	•				Improper contact to cleaning brushes with blade	Clean brushes and adjust holder; replace brushes if worn out
•					Damaged or worn blade	Replace blade
•	•				Material insecurely held in vice	Adjust vice handwheel
•	•				Improper guide roller adjustment	Readjust rollers
•					Blade guides improperly adjusted	Readjust guides
	•				Head approaching work piece too fast	Turn cylinder control knob to decrease head descent speed
	•	•			Blade too coarse	Install proper blade
	•				Excessive blade tension	Readjust blade tension
		•			Insufficient feed pressure	Turn cylinder head control knob to increase head descent aped and/or move slide weight to left
			•		Blade riding up on wheel flanges	Re-adjust blade tracking
				•	Blade tracking too high on wheels	Adjust drive and idle wheels for proper blade tracking.



ELECTRICAL DIAGRAM





NOTE: SOME NUMBERS MAY NOT BE FOUND. THIS ALLOVS ALL J-SAVS CONVERSION FLEXABILITY. 715339 LAST NUMBER USED 13 ELECTRICAL MATERIAL LIST 715338

230V Single Phase







EXPLODED VIEW & PARTS LIST



<u>ltem</u>	Part Name	Part Number	<u>Qty</u>
1	Front Frame	10002-01	1
2	Rear Frame	10003-01	1
3	Bed	10001-00	1
4	Pivot Bar	10066-00	1
5	Shaft Locking Collar	13010-08	2
6	Right Leg	10004-02	1
7	Left Leg	10005-02	1
8	Balance Spring – includes carriage bolt and nut	10070-00	1
9	Spring Perch	10100-01	1
10	Outboard Bearing Casting – (3/8" bolt, lock washer, & nut)	10101-00	1
11	Stock Stop Assembly	5527-00	1
11A	Holder Casting	5027-00	1
11B	Rod	5213-00	1
11C	Spring	5028-00	1
11D	Handle (S/N 10962)	5200-00	1
12	Stock Stop Mounting Bar	5027-01	1
13	Tip-off Block	10006-01	1
14	Coolant Drawer Pan	10269-00A	1
15	Left Hand Blade Guard	300405A	1
16	Right Hand Blade Guard	300404A	1
18	Left Leg Pan	10268-07A	1
19	Right Leg Pan	10268-05A	1
20	Frame Handle	10093-00	1
21	Brush Holder Guard	10229-00	1
22	Name Plate	72295	1
23	Submersible Coolant Pump – Electric 110 Volt	71541	1



PARTS NOT ILLUSTRATED

Description	<u>Part No.</u>	<u>Qty</u>
Motor, 110/230 Volt, 60 Hz Single-Phase, 1 H.P.	10079-07	1
Motor Pulley – 5/8" Bore (1 Used on Old Style)	10042-10	2
Drive Belt	10077-10	1
Pulley Guard	10223-10A	1
Motor Mounting Bracket	5107-00	1
Stationary Motor Bracket	5106-02	1
Motor Mounting Pin	5106-03	1
Frame Covers (Left and Right)	300403A	2
Knob for Frame Covers	300804	4
Rear Frame Blade Guard	10230-10A	1
Drive Wheel Drip Pan	10271-00A	1
Wheel Pan Strap	10287-00	1
Wheel Pan Bar	10286-00	1
Thumb Screw – Drive Wheel Drip Pan (S/N 10962)	70295	2
Spring Bracket Top	10209-01	1
Lower Left Front Cover	10126-13A	1
Frame Rest (S/N 10962)	10091-10	1
Drive Wheel Cover	300407A	1
Idle Wheel Cover	300408A	1
Drive & Idle Wheel Spoke Guards (Not used on current model)	300409A	-
Wire Ties	300246	8



OTHER VOLTAGE MODELS

Bandsaw Sub-Assembly same for 985017-1, 985017-2, 98518-2, & 985018-4. Parts that differ from 110V Model below:

5		
Part Name	Part Number	Qty
Motor, 110/230 Volt, 60 Hz Single-Phase, 1 H.P.	10079-07	1
Wire Nut	300171	4
16-14 Wire #10 Stud Non-Insulated Ring Terminal	300245	4
Wire Tie	300246	8
Quick Connect Terminal	300524	3
Electrical Control Box Assembly	716676	1
Flexible Conduit Assembly	716679	1
Connector, Cord	75151	1
Locknut, Conduit, 1/2 In.	75257	1
Roll Pin (1/4" x 2-1/2")	75516	4

985017-2 220V Single Phase Model

985018-2 220V 3-Phase Model

Part Name	Part Number	Qty
Motor, 208/230/460V, 50/60 Hz. 3-Phase	10079-05	1
Wire Nut	300171	5
16-14 Wire #10 Stud Non-Insulated Ring Terminal	300245	4
Wire Tie	300246	3
Quick Connect Terminal	300524	3
Electrical Control Box Assembly	716677	1
Flexible Conduit Assembly	716680	1
Connector, Cord	75151	2
Locknut, Conduit, 1/2 In.	75257	2
Roll Pin (1/4" x 2-1/2")	75516	4

985018-4 440V 3-Phase Model

Part Name	<u>Part Number</u>	<u>Qty</u>
Motor, 208/230/460V, 50/60 Hz. 3-Phase	10079-05	1
Wire Nut	300171	5
16-14 Wire #10 Stud Non-Insulated Ring Terminal	300245	4
Wire Tie	300246	3
Quick Connect Terminal	300524	3
Electrical Control Box Assembly	716678	1
Flexible Conduit Assembly	716680	1
Connector, Cord	75151	2
Locknut, Conduit, 1/2 In.	75257	2
Roll Pin (1/4" x 2-1/2")	75516	4



WHEEL ASSEMBLIES



<u>ltem</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
1	Idle Wheel/Frame Mounting Bracket (Outboard)	10064-09	1
2	Idle Wheel Assembly	10510-04A	1
2	Idle Wheel Assembly (Old Style)	10510-04	0
2A	Idle Wheel Only	13035-01A	1
2A	Idle Wheel Only (Old Style)	13035-01	0
2B	Wheel Axle	10062-00	1
2C&D	Bearing – Sealed (2 per wheel assembly)	81583	1
-	Snap Ring for Bearing #81582	81585	2
2C	Bearing Cup (Old Style)	10134-01	0
2D	Bearing Cone (Old Style)	10134-02	0
2E	Dust Collar (Old Style)	10135-00	0
2F	Snap Ring (Old Style)	10136-00	0
2G	Grease Fitting (Old Style)	5143-00	0
2H	Hex Jam Nut 1"-14 N.F.	14123	1
2J	Locknut 1"-14 N.F.	70296	1
3 & 4	Slide & Rocker Block Assembly	5011-01	1
5	Idle Wheel & Frame Mounting Bracket (Inboard)	86526	1
6&7	Tension Screw Assembly	10125-01	1
8	Wheel Guideway Angle - Top	10210-00	1
10	Wheel Guideway Angle - Bottom	10067-00	1
12	Drive Wheel & Frame Mounting Bracket (Inboard)	86525	1
13	Gear Box Mounting Plate	10063-00	1
14	Drive Wheel & Frame Mounting Bracket (Outboard)	10064-06	1
15	Driven Pulley – 3/4" Bore (Key – Part No. 71061)	10043-10	1
16	Drive Wheel Assembly	10510-03A	1
16	Drive Wheel Assembly (Old Style)	10510-03	0
16A	Drive Wheel only	10010-03A	1
16A	Drive Wheel only (Old Style)	10010-03	0
16B	Ring Gear	10052-00	1
16C	Wheel Axle	10062-00P	1
16C	Wheel Axle (Old Style)	10062-00	0
16D&E	Bearing – Sealed (2 per wheel assembly)	81583	2
-	Snap Ring for Bearing #81582	81585	2
16D	Bearing Cup (Old Style)	10134-01	0
16E	Bearing Cone (Old Style)	10134-02	0
16F	Dust Collar (Old Style)	10135-00	0
16G	Snap Ring (Old Style)	10136-00	0
16H	Grease Fitting (Old Style)	5143-00	0
16J	Hex Jam Nut, 1"-14 N.F.	14123	1
16K	Locknut 1"-14 N.F.	70296	1
16M	Soc Cap Screw Flathead 1/4"-20 x 1-1/4"	78489	6
Not Shown	Idle Wheel Mounting Bolts (3/4"-16 x 1-1/4")	70346	2



GEARBOX ASSEMBLY



Item	Description	Part No.	<u>Qty</u>
-	Gear Case Complete	10544-00A	1
-	Gear Case Complete (Old Style)	10544-00	0
1	Bearing Cap	5047-00	2
2	Cap Gasket	5138-00	2
3	Bearing	5073-00	1
4	Gear Case	5044-00	1
5	Dowel Pin	3922	2
6	Bearing	5072-00	3
7	Worm Gear Shaft	10049-00	1
8 & 15	Worm – Steel Worm & Bronze Gear Assembly	10050-00	1
9	Cover Gasket	13080-01	1
10	Gear Case Cover	5045-00	1
11	Breather Vent	7368	1
12	Oil Seal	5137-22	2
13	Snap Ring	5136-00	2
14	Worm Shaft	5048-00AP	1
14	Worm Shaft (Old Style)	5048-00	0
15A	Key (3/16" x 3/16" x 3/4")	71061	1
16	Spur Gear (Set Screw – Part No. 43558)	10053-00	1
17	Key (3/16" x 3/16" x 1/2")	10047-01	1
	Key (3/16 x 3/16" x 1")	47364	
-	Woodruff Key (S/N 10962)	26189	2
-	Bearing & Seal Kit (Includes Items 2, 3, 6, 9, 12, 13)	714706	-



HYDRAULIC ASSEMBLY



<u>ltem</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
-	Hydraulic Assembly (Includes Cylinder & Control Valve Assembly)	10530-10	1
-	Cylinder Assembly Only	10530-09	1
1	Cylinder Base	10031-00	1
2	Fiber Seal	10203-03	2
3	Tie Rod	10205-02	3
4	Spring	5129-00	1
4A	Spring – R Style, included in repair kit.	5116-00	-
5	Valve Ball 3/8"	17817	1
6	Piston Rod	10204-02	1
7	Head Stop Spring	10033-00	1
8	Cylinder Head	5030-10	1
9	Head Seal (O-Ring) (S/N 10962)	10115-02	1
9A	Older Models Garlock Shaft Seal (1/2" ID, 7/8" OD, 1/8" Thick) (S/N 10962)	10115-03	1
9B	Older Models Garlock Shaft Seal (1/2" ID, .801" OD, 1/8" Thick) (S/N 10962)	13080-03	1
10	Yoke	10013-00	1
11	Hex Nut #10-24	43905	3
12	Tube Elbow (Includes furrow and nut)	71357	2
13	Cylinder Body	10203-02	1
14	Piston	5119-00	1
15	Piston Nut	5120-00	1
16	Leather Cup	5130-00	1
	Control Valve Assembly	10530-08	
23	Hydraulic Needle Valve (Incudes Knob) (New Style: Serial No. > 1403165)	303690	1
23B	Hydraulic Needed Valve (Old Style: Serial No. < 1403165)	5131-00	-
24	Tube Fitting (For New Style Valve)	303691	2
24	Tube Fitting (For Old Style Valve)	44143	0
26	Face Plate	10030-00	1
27	Knob (For Old Style Valve)	13018-14	1
28	Drive Screws	70277	4
29	Tubing 5/16"	40515-00	8 ft.
30	Tubing 5/16"	40515-00	8 ft.
_	Hydraulic Filler Cap. Items 18-21 not needed if saw is equipped with filler	5032-00	1
	cap.		
-	Hydraulic Cylinder Repair Kit (Items 2, 4, 4A, 5, 9, 9A, 9B & 16)	714717	-
-	Rod & Piston Assembly (Items 4, 5, 6, 14, 15, & 16)	10530-01	-



GUIDE ARM ASSEMBLY



ltem	<u>Description</u>	Part No.	<u>Qty</u>
-	1" Guide Arm Assembly Complete – Stationary – Right	10519-11A	1
-	1" Guide Arm Assembly Complete W/ Coolant Nozzle – Left	10519-10AW	1
1	Guide Arm (LH/RH)	10019-10	2
2	Guide Holder	10020-10	2
3	Guide Arm Handle	10084-01	1
4	Side Guide Bearing	10025-01	2
5	Upper Guide Bearing	5026-00	2
6	Upper Guide Bushing	5023-01	2
7A	Side Guide Bushing	5075-00	2
7	Inside Concentric Axle (Not on current model)	10022-02	2
8	Outside Eccentric Axle Only. Nut #42326, Washer #43644	10022-10	2
9	Brush Holder	5122-00	1
10	Blade Brush Kit – 6 Pairs	5133	1
11	Coolant Hose Assembly	715342	1
	(Includes Nozzle, Connector, & Flex hose)		
12	Tube Fitting, Poly-Tite	34528	1
12B	Nozzle Mounting Bracket	82668	1
13	Tubing 3/8"	67762	8 ft.
14	Guide Arm (T-Slot) Bolt	10512-10	2
15	Spacer Washer (JH Model Only, not on current models)	70462	8
	Washer for Guide Arm	43634	2
	Hex Nut for Stationary Guide Arm	43916	1
	Guide Holder Assembly (Includes 2, 4, 5, 6, 7A, 8 &	10520-10	
	Fasteners)		
	Guide Bearing Kit (Includes 4, 5, 6, & 7A)	715104	
	Blade, J-Saw, 3/4" x 137" x .035, 5/8" VP – Bi-Metal	75958	
	Blade, JH-Saw, 1" x 137" x .035, 5/8" VP – Bi-Metal	75957	
	Guide Arm Assembly Complete LH & RH 1" (Old Style)	10519-10	



VISE ASSEMBLY

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<u>ltem</u>	Description	<u>Part No.</u>	<u>Qty</u>
1	Hold Down Block (S/N 10962)	10007-00	1
2	Vise Lift	10099-00	1
3	Handle 1/4"-20 x 2"	5200-00	1
4	Movable Vise Jaw (Bolt – Part No. 43383)	10008-00	1
5	Stationary Vise Jaw (Bolt – Part No. 43348)	10009-00	1
7	Lift Pin	10116-00	1
8	Vise Nut Plate (Self Tapping Screw (10-24) – Part No. 43882)	10201-00	2
9	Vise Nut	10016-00	1
10	Vise Screw	10015-10	1
11	Handwheel	10014-00	1
12	Stop Collar	70464	1

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.