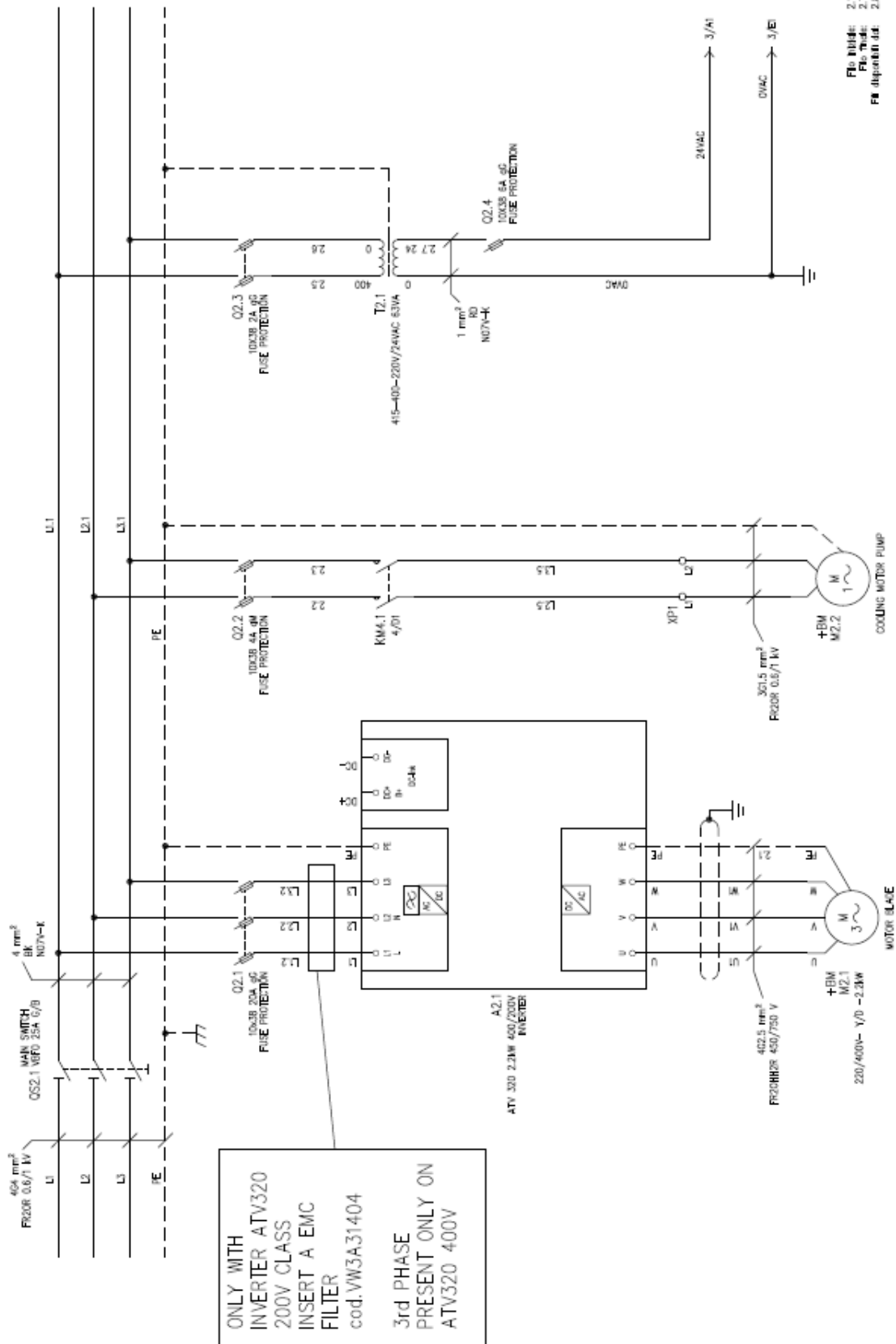
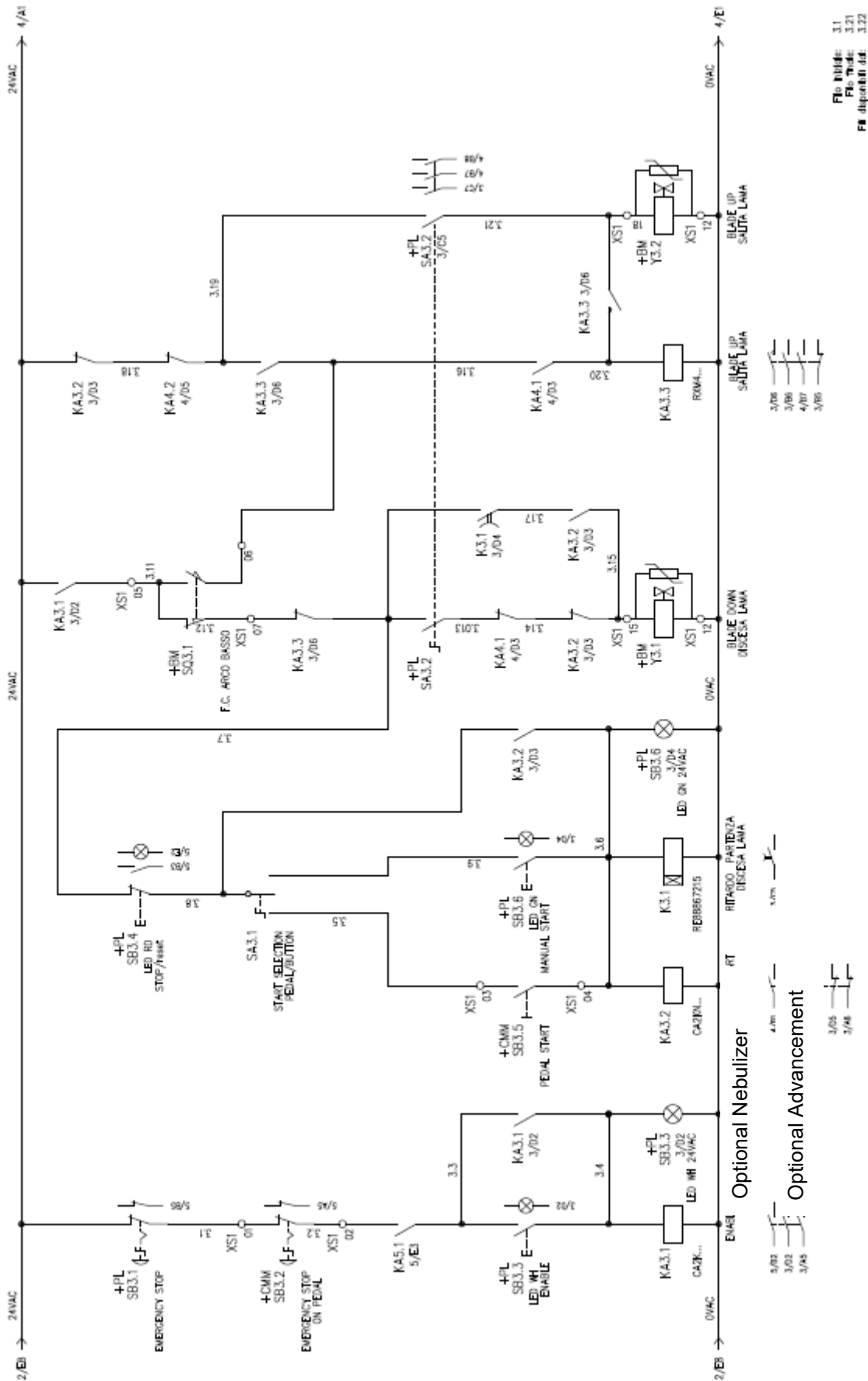
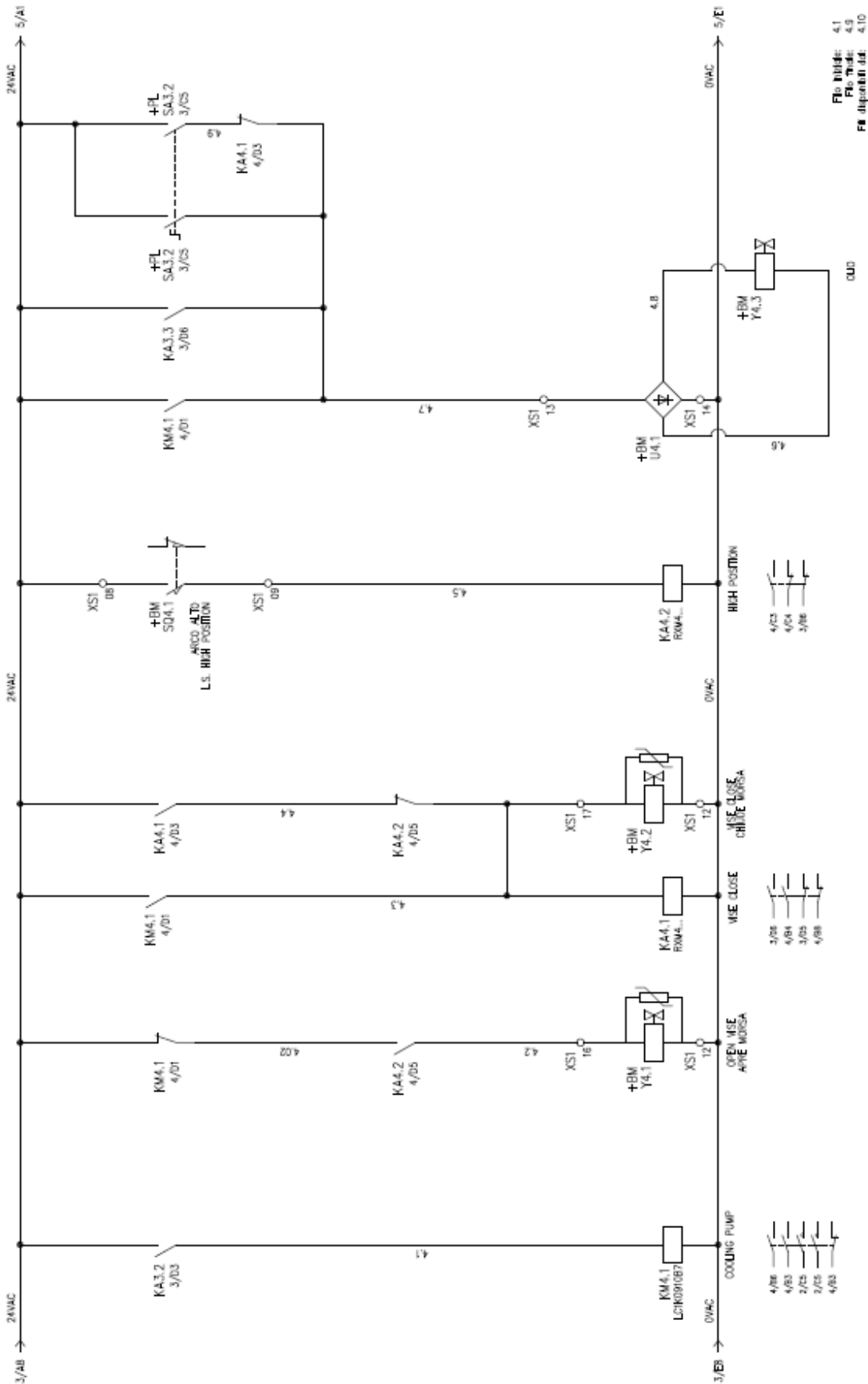


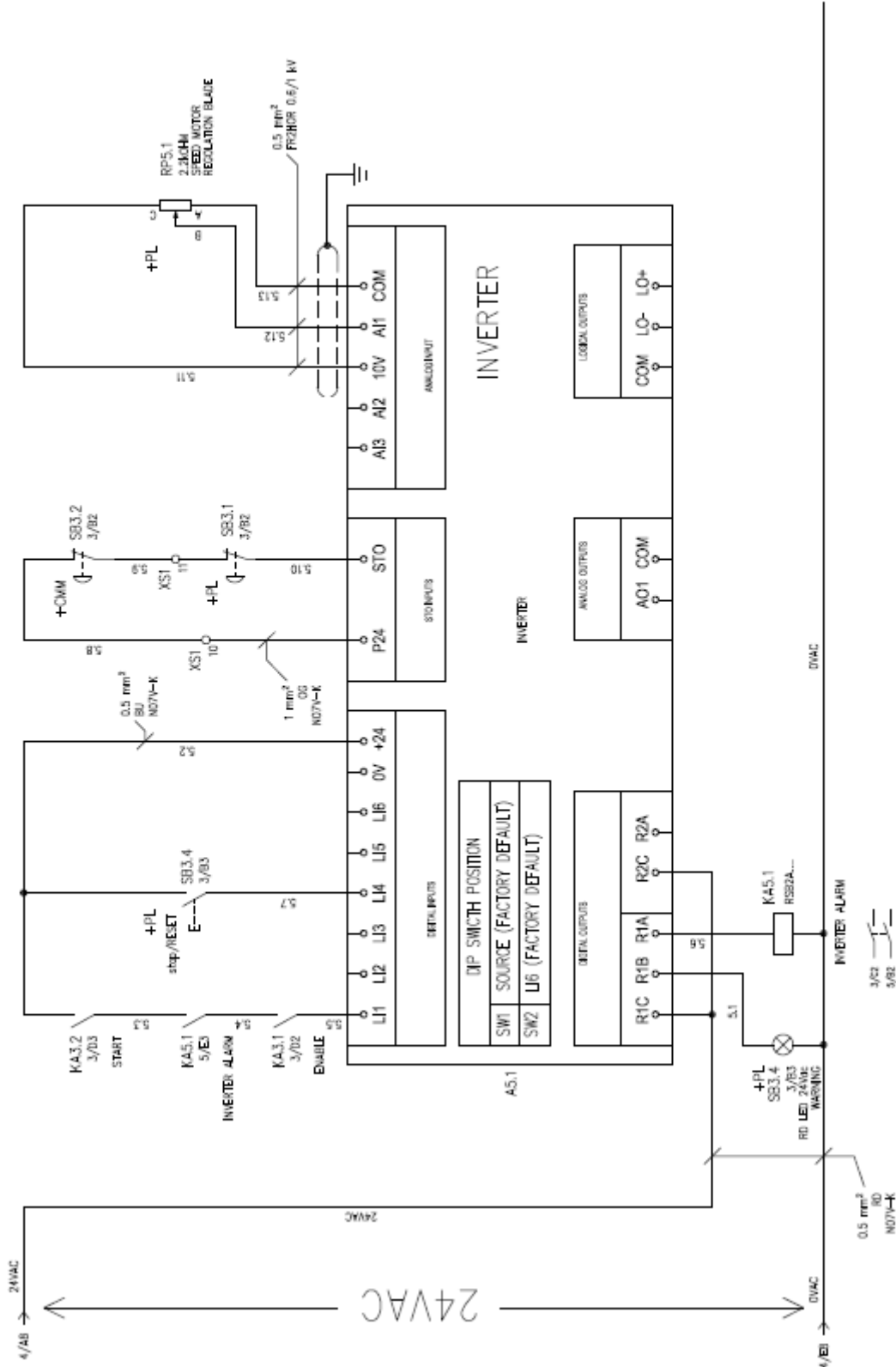
ELECTRICAL SCHEMATIC





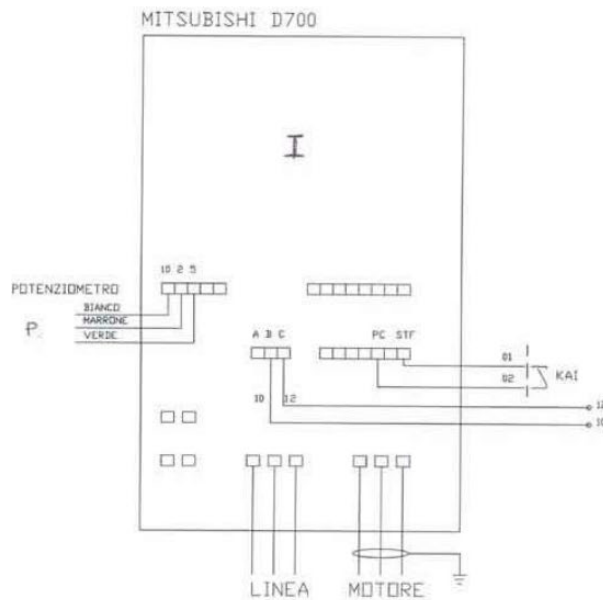


File Name: 4.1
File Title: 4.9
File Description: 4.10



	L2.5	L1	L2.5
COOLING MOTOR PUMP			KM4.1
	L3.5	L2	L3.5
COOLING MOTOR PUMP			KM4.1
	PE	PE	PE
COOLING MOTOR PUMP			
EMERGENCY STOP	3.1	01	SB3.2
EMERGENCY STOP	3.2	02	K45.1
SELECTION START	3.5	03	SB3.4
	3.6	04	SB3.4
	3.11	05	K43.1
	3.16	06	K43.3/Y3.2
	3.12	07	K43.3
SUPPORT RELAY/MANUAL START/RITARDO PARTENZA	24VAC	08	SQ4.1
	4.5	09	K44.2
	5.8	10	
EMERGENCY STOP/FUSE PROTECTION			
ARCO ALTO			
HIGH POSITION/USE CLOSE/SALITA LAMA/COOLING PUMP/...			SB3.2
HIGH POSITION/USE CLOSE/SALITA LAMA/COOLING PUMP/...			Y3.1
USE CLOSE/SALITA LAMA/SUPPORT RELAY/COOLING PUMP/...			Y3.2
HIGH POSITION/USE CLOSE/SALITA LAMA/COOLING PUMP/...			Y4.1
			Y4.2
			Y4.3
			Y4.3
			Y3.1
			Y4.1
			Y4.2
			Y3.2

SIGLA	DESCRIZIONE	DESCRIZIONE 2	DESCRIZIONE ESTESA	POSIZIONE	MORSI/ETIERA	UBICAZIONE	NOTE
A2.1	INVERTER		INVERTER	2/03			ATV 320 2.2KW 400/200V
A5.1	INVERTER		INVERTER	5/02			
K3.1	RTARDO PARTENZA	DISCESA LAMA	RTARDO PARTENZA DISCESA LAMA	3/04			REBBE7215
K4.1	ENABLE		ENABLE	3/02			CA2K...
K4.1	ENABLE		ENABLE	5/02			
K4.3.2	ACTIVE START		ACTIVE START	3/03			CA2KN...
K4.3.2	START		START	5/42			
K4.3.3	SAUTA LAMA	BLADE UP	SAUTA LAMA BLADE UP	3/06			ROMA...
K4.4.1	WRE CLOSE		WRE CLOSE	4/03			ROMA...
K4.4.2	HIGH POSITION		HIGH POSITION	4/05			ROMA...
K4.5.1	INVERTER ALARM		INVERTER ALARM	5/02			
K4.4.3	COOLING PUMP		COOLING PUMP	4/01			LC1K910E7
M2.1	MOTOR BLADE		MOTOR BLADE	2/E3	EXT	+BM	220/ACDV- Y/D -2.2KW
M2.2	COOLING MOTOR PUMP		COOLING MOTOR PUMP	2/E5	EXT	+BM	
Q2.1	FUSE PROTECTION		FUSE PROTECTION	2/03			10035 20A 00
Q2.2	FUSE PROTECTION		FUSE PROTECTION	2/05			10035 4A 0V
Q2.3	FUSE PROTECTION		FUSE PROTECTION	2/07			10035 2A 00
Q2.4	FUSE PROTECTION		FUSE PROTECTION	2/07			10035 5A 00
Q52.1	MAIN SWITCH		MAIN SWITCH	2/42			VEFO 25A 0/0
RPS.1	SPEED MOTOR	REGULATION BLADE	SPEED MOTOR REGULATION BLADE	5/06		+FL	2.2KWHM
S4.1	START SELECTION	FEDAL/BUTTON	START SELECTION PEDAL/BUTTON	3/03			
S8.1	EMERGENCY STOP		EMERGENCY STOP	3/02		+FL	
S8.1.2	EMERGENCY STOP	ON PEDAL	EMERGENCY STOP ON PEDAL	3/02		+CMM	
S8.1.3	ENABLE		ENABLE	3/02		+FL	LED NH
S8.1.4	STOP/RESET		STOP/RESET	3/03		+FL	LED RD
S8.1.4	WARNING		WARNING	5/E2		+FL	RD LED 24VAC
S8.1.4	STOP/RESET		STOP/RESET	5/03		+FL	
S8.1.5	PEDAL START		PEDAL START	3/03		+CMM	
S8.1.6	MANUAL START		MANUAL START	3/04		+FL	LED ON
SQ4.1	ARCO ALTO	L.S. HIGH POSITION	ARCO ALTO L.S. HIGH POSITION	4/05		+BM	
Y3.1	DISCESA LAMA	BLADE DOWN	DISCESA LAMA BLADE DOWN	3/05		+BM	
Y3.2	SAUTA LAMA	BLADE UP	SAUTA LAMA BLADE UP	3/07		+BM	
Y4.1	APRE MORSA	OPEN WRE	APRE MORSA OPEN WRE	4/03		+BM	
Y4.2	CHIUE MORSA	WRE CLOSE	CHIUE MORSA WRE CLOSE	4/04		+BM	
Y4.3	CLD		CLD	4/E7		+BM	



Lista parametri

P1=FREQUENZA MAX	100Hz
3=FREQUENZA LINEA	60Hz
7=ACCELERAZIONE	2
8=DECELERAZIONE	2
9=ASSORB. MOTORE	---
18=FREQ. MAX	100
22=LIMITE STALLO	OK=150 (200 con mot. saccardo)
71=TIPO MOTORE	3
72=TIPO FREQ.	3
80=PDOT. MOTORE	---
83=TEWS. MOTORE	---
84=FREQ. MOTORE	50/60 Hz
96=AUTO TEST	11/13
125=GUADAGNO	100

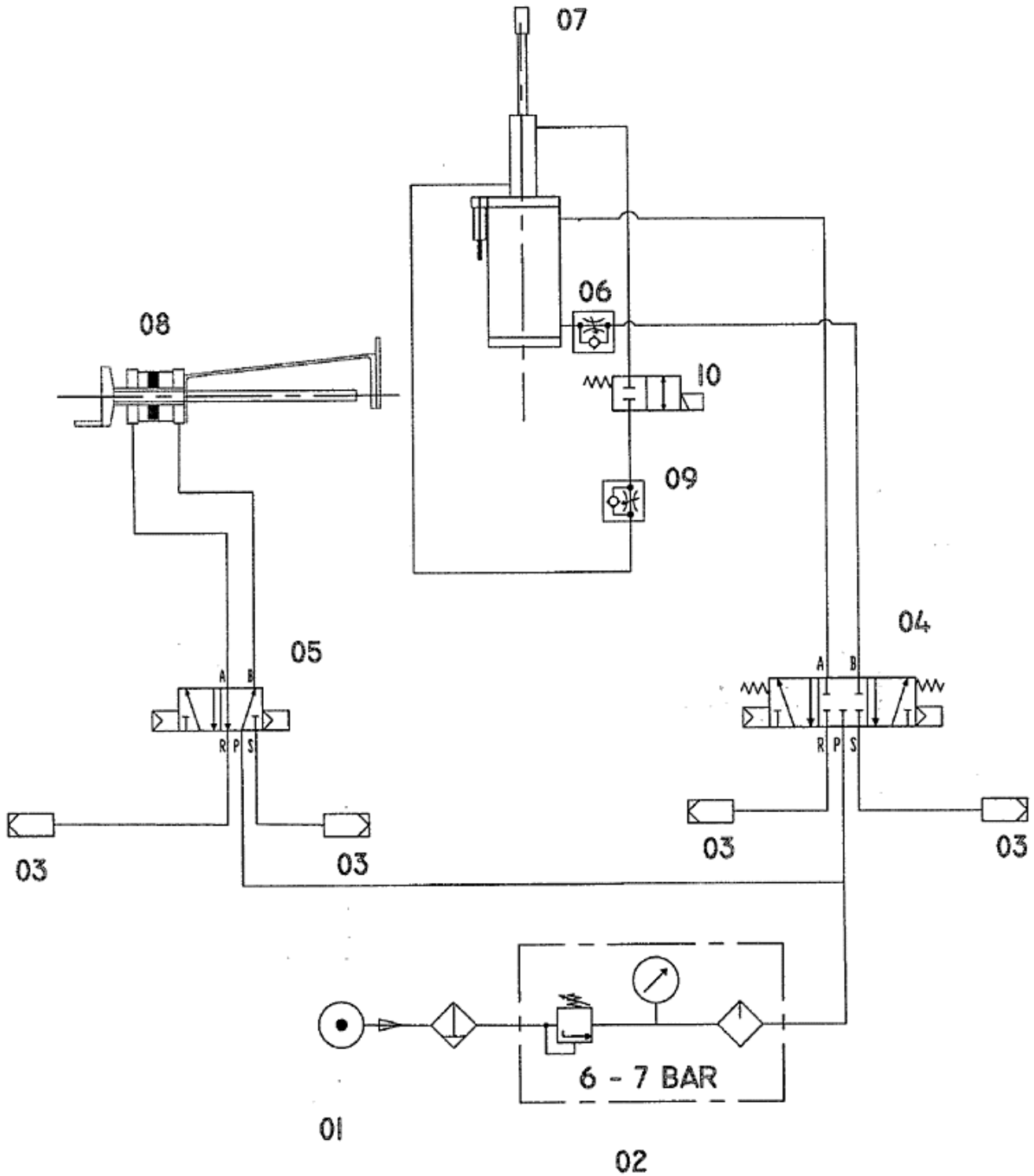
C= PER INSERIRE FREQ. MINIMA=PDOTENZ. A 0
C2=20

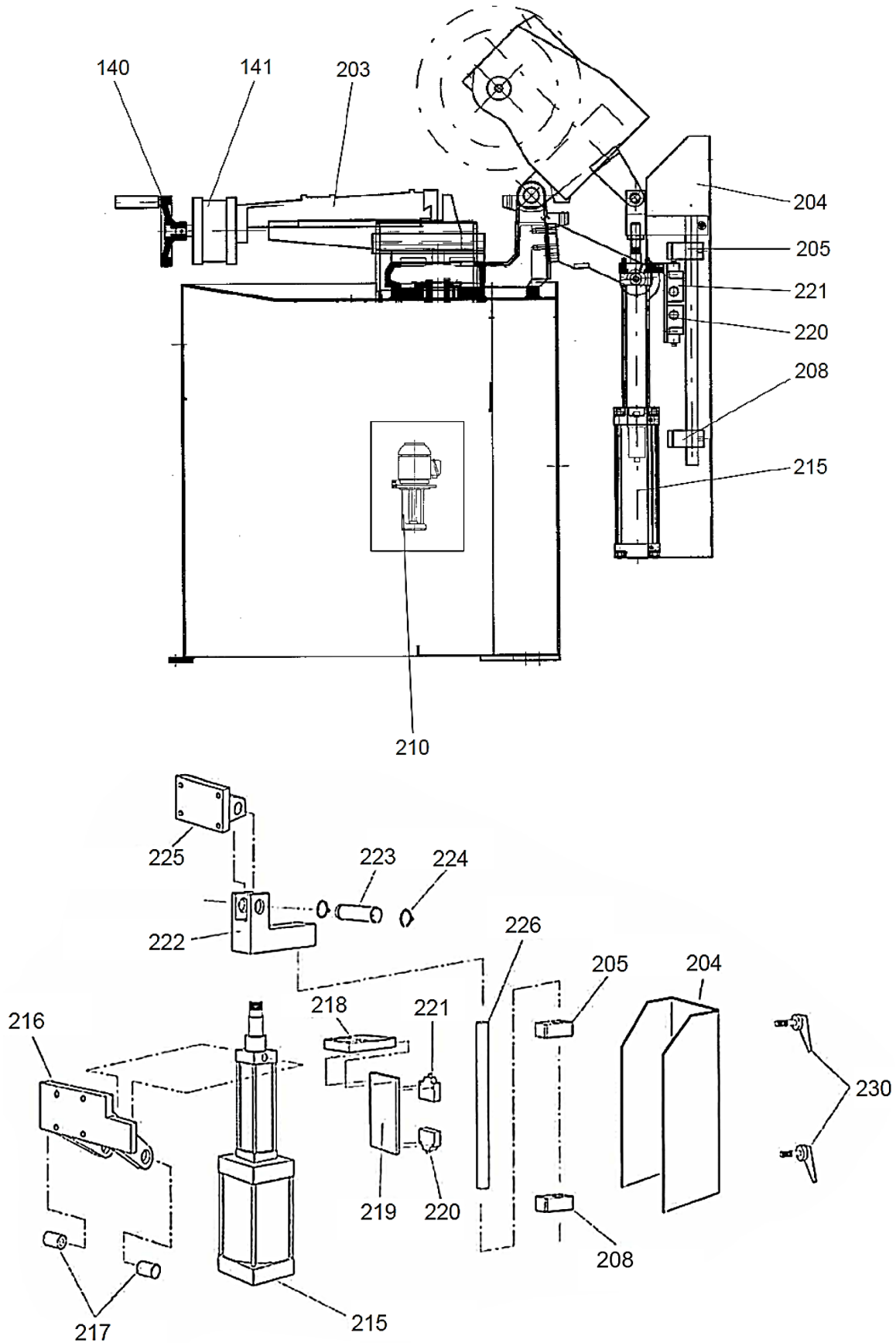
LEGENDA - Electrical components

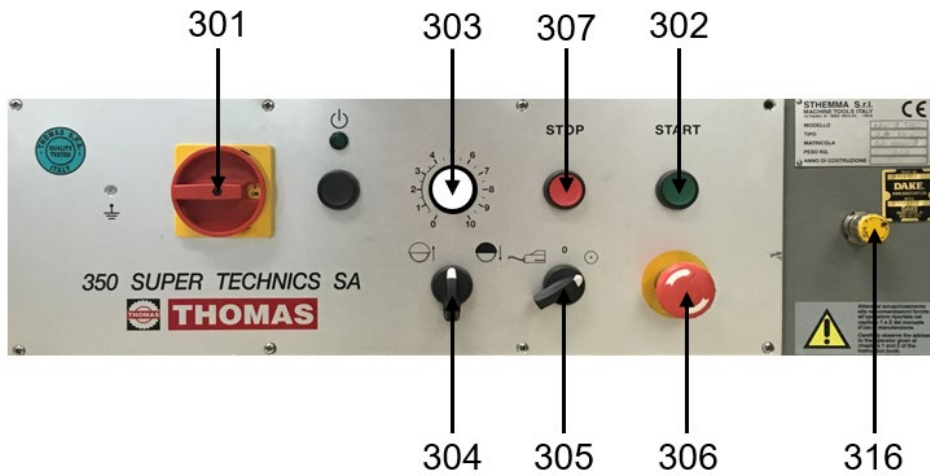
QS1.....	Main Switch
FU1.....	Fuse Cartridge
FU2.....	Fuse Cartridge
FU3.....	Fuse Cartridge
TC.....	Transformer
KM1.....	Remote Switch
SA2.....	Cutting up/downfeed
SB0.....	Emergency Stop
SB1.....	Emergency Stop
SB2.....	Line push-button
SB3.....	Cycle Start push-button
SB4.....	Cycle Stop push-button
KA.....	Aux Relay
KA0.....	Remote switch Line (*)
KA1.....	Aux Relay
KA2.....	Aux Relay
KA3.....	Aux Relay
KA4.....	Aux Relay
KB.....	Aux Relay (*)
KC.....	Aux Relay (*)
KL.....	Aux Relay (*) KX Aux Relay
SQ3.....	Microswitch on lower endstroke
SQ5.....	Microswitch on upper endstroke
SQ6.....	Microswitch on carriage back stop (*)
SQ7.....	Microswitch for material end (*)
SQ8.....	Microswitch on carriage (*)
SQ9.....	Microswitch on carriage protection (*)
SQ10.....	Microswitch on front guard (*)
YV1.....	Electrovalve for head downfeed
YV2.....	Electrovalve for head upstroke
YV3.....	Electrovalve for vice locking
YV4.....	Electrovalve for vice opening
YV5.....	Electrovalve for blocking
YV6.....	Electrovalve for feeding vice (*)
YV7.....	Electrovalve for carriage (*)
YV8.....	Electrovalve for oil nebulizer (option)
HL1.....	Light bulb
HL2.....	Light bulb (*)
HL3.....	Light bulb (*)
HL4.....	Light bulb (*)
KT1.....	Timer for delaying feeding vice opening (*)
KT2.....	Timer for delaying carriage start (*)
KT3.....	Timer for delaying carriage return (*)
KT4.....	Timer for delaying head downfeed start

(*).....These parts are for the machine equipped with automatic material feeding system only.

PNEUMATIC SYSTEM SCHEMATICS

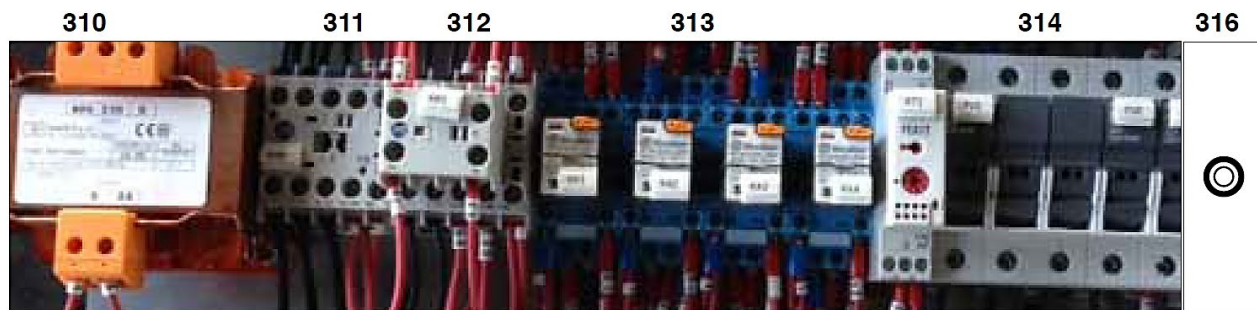






KEY

- 301** Main Switch
- 302** Start Push-button
- 303** Potentiometer
- 304** Cutting Head Up/Down Selector
- 305** Cycle Start Selector
- 306** Emergency Push-button
- 307** Stop Push-button
- 310** Transformer
- 311** Auxiliary Contact
- 312** Remote Control Switch
- 313** Auxiliary Relay
- 314** Fuse Cartridges
- 316** Head Descent Speed Adjustment



308 Inverter - controls blade speed



<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
1*	Machine Bed	AGB81040
2	Revolving Arm	AGB90025
3	Revolving Arm Locking Pin	AFB90029
4*	Revolving Arm Locking Bushing (Not Shown)	AFB90029
5*	Revolving Arm Locking Lever (Not Shown)	AGB80027
6*	Screw (M10)	81110110
7	Countervise	AGB90040
8	Mobile Countervise	AGB90041
9	Countervise Jaws	AFB90042
10	Burr-free Jaws	AFB90043
11	Countervise Rotating Locking Pin	AFB90044
12*	Roller Arm	AFB91100
13*	Roller	49001001
14*	Nut (M12)	81600012
15*	Screw (M12)	81100195
18	Vise Jaws	AFB90056
19	Vise Jaw Washer	AFB8B037
20	Screw (M12)	81110133
21	Washer (8.5mm ID x 21mm OD)	82100000
22	Screw (M12)	81110133
23*	Dowel (M8 X 30)	81132081
24*	Lever Bushing	AFB80032
25*	Quick Lock Vise Lever	AGB80031
26*	Thrust Bearing (AX 3047) & Counter-bearing (CP 3047)	84500001
27*	Quick Lock Vise Lever Washer	AFB80033
29*	Elastic Pin (Ø6)	82504217
30*	Washer (8.5mm ID x 21mm OD) (Not Shown)	82100000
31*	Screw (M8)	80521
32	Vise Gib	AFB80036

<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
33	Dowel (M8 X 30)	81132081
34	Hex Nut (M8)	81600008
35*	Vise Thread	AFB80034
36*	Quick Lock Vise Spring	AFB80035
37	Burr-free Transverse Plate	AFB90058
38	Burr-free Plate	AFB90059
	Burr-free Plate	110B0038
40	Socket Cap Screw (M8-1.25 x 20mm)	80521
41*	Tank Cover Filter	AFB80044
42*	Screw (M6)	80521
43*	Bar Stop Rod	AFB80024
44*	Ruler	AHB80026
45*	Screw (M2)	
46*	Bar Stop	AG260030
47	Oiler (Ø8)	82901005
48*	Dowel (M8 x 30)	81132081
49*	Tank Cover Gasket	ANB80042
50*	Ring (Seeger Ø421)	82610000
51*	Tank Cover Filter	AFB80043
52*	Tank Cover Wire Gauze	AFB8B043
53*	Tank Cover	ANB80041
54*	Washer (8.5mm ID x 21mm OD)	82100000
55*	Coolant Flow Control Valve (1/4")	88600000
56*	Coolant Tube	69102002
57	Extra Shield	AFB90091
60	Hex Nut (M12)	81600012
61	Screw (M12)	81100195
62	Head	AGB90001
63	Oil Plug (M15 x 1.5)	88302002
64*	Ring Nut (GUK M25 x 1.5)	81700025
65*	Spring Thrusting Washer	AFB90018
66	Oil Plug (M15 x 1.5)	88302002
67	Cylindrical Hinge Pin	AFB90027

<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
68	Ring Nut (GUK M25 x 1.5)	81700025
69	Eccentric Hinge Pin	AFB90026
70	Eccentric Bushing	AFB90028
71	Bearing (6202)	84101031
72*	Hex Nut (M20)	81600020
73*	Head Lever	120C0004
74*	Head Lever Handgrip	44600001
75*	Bushing	AFB90012
76*	Bearing (32008X)	84320032
77*	Ring (DPSM 50728)	86000000
78*	Cylindric Pin (Ø5 x 12)	302417
79	Blade Shaft	AFB90010
80	Blade	-
81	Blade Shaft Flange	AF710163
82	Screw (M12 x 35 left threaded)	S1110136
83	Fixed Blade Guard	AGB90085
84	Dowel (M8 x 30)	81132081
85	Front Head Cover	AGB90002
86	Coolant Distributor	AFB80055
87	Coolant Tube	69102002
88	Dowel (M8 X 30)	81132081
89	Mobile Blade Guard	160C0063
90	Ring (Seeger Ø60)	82600000
91	Pin	AF190092
92	Screw (M6 x 12mm)	80625
93	Tie Rod Support	AFB90087
94	Screw (M6 x 12mm)	80625
95	Screw (M6 x 12mm)	80625
96	Tie Rod	AFB90088
97	Ring (Seeger Ø 10)	82600000
98	Tie Rod Support Pin	AF19B090
99*	Ring (OR 4205)	86002004
100	Ring Nut (GUK M20 x 1)	81700020

<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
101	Worm Screw	AFB90015
102	Worm Screw Spacer	AFB90017
103	Ring (Seeger Ø 621)	82610000
104	Bearing (3305)	84301010
105	Ring (SM 32527)	301959
106	Rings (OR 4312)	302920
107	Front Motor Flange	ABG90004
108	Motor Shaft (Rotor)	AFB90008
109	Key (5 x 6 x 35mm)	82502025
110	Washer (in motor assembly)	-
111	Stud Bolt (in motor assembly)	-
112	Nut (in motor assembly)	-
113	Motor (Frequency Driven)	303318
113	Motor (2 Speed, 3-Phase, old model)	74320125
113	Motor (3 Speed, 3-Phase, old model)	74320130
116	Motor Rear Flange	ABG90005
117	Ring (Seeger Ø25)	82600000
118	Head Cover Gasket	ANB90003
119	Nilos Ring (4205 AV)	86005005
120	Bearing (4205)	84130010
121	Motor Fan	74310007
122	Fan Cover	AHB90006
123*	Bearing (609)	84101016
129*	Washer (8.5mm ID x 21mm OD)	82100000
130*	Screw (TE M6)	-
131*	Clutch Cone	AFB90014
132*	Worm Gear	ABB90016
133*	Clearance Adjustment Ring	AFB90013
134*	Ring Nut (KM8 M40 x 1.5)	81702040
135*	Safety Washer (MB8)	81703040
136*	Belleville Washer	82505101
137*	Blade Shaft Flange Pin	AFB8B007
140	Vise Handwheel	47100000R

<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
141	Pneumatic Vise Cylinder	78200096
-	Vise Cylinder Repair Kit	86045005
203	Vise Casting	303092
204	Cylinder Guard	-
205	Upper Adjustable Stock	110H0016
208	Lower Adjustable Stop	110H0016
210	Coolant Pump	302666
215	Cutting Head Cylinder	200H0006
	Head Cylinder Repair Kit	302725
	Oil Cylinder Pump	302824
	Oil Pump Nozzle	302494
216	Head Cylinder Bracket	-
217	Bushings	-
218	Plate	-
219	Plate for Microswitch	-
220	Microswitch	72212000
221	Microswitch	72212000
222	Cylinder Mounting Fork	110H0013
223	Fork Pin	-
224	Ring (Seeger Ø20)	-
225	Fork Attachment	-
226	Head Guide Rod	060H0001
230	Handle for Limit Switch	300362
301	Main Switch	70201011
302	Start Push-button	70101000
303	Potentiometer (2-speed, old model)	70221013
303	Potentiometer (3-Speed, old model)	70201018
303	Potentiometer (current model)	303650
304	Cutting Head Up/Down Selector	71100000
305	Cycle Start Selector	716812
306	Emergency Push-button	716538
307	Stop Push-button	716539
308*	Start Cycle Foot Control	73903000

<u>Item</u>	<u>Part Name</u>	<u>Part Number</u>
310	Transformer 100VA	73322011
311	Auxiliary Contact	72610001
312	Remote Control Switch	73401001
313	Auxiliary Relay	72300000
314	Fuse Cartridges	73142005
316	Head Descent Speed Adjustment	88900007
	Service Tool Bag – Complete	53100004
*	Parts not shown in exploded view	

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.

DEACTIVATING THE MACHINE

If the machine is not going to be in use for a long period of time it is recommended that you do the following:

1. Unplug machine.
2. Empty coolant tank.
3. Carefully clean and grease machine.
4. If necessary cover the machine.

DISMANTLING THE MACHINE

If this machine is permanently demolished and/or scrapped, divide the material to be disposed of and dispose of them in accordance to local disposal laws. This includes raw materials such as metals, electrical components, and special waste such as old oils.