



VERTICAL BAND SAWS

INSTRUCTION MANUAL AND PARTS LIST MODEL SXC

DAKE/PARMA



WHEN ORDERING PARTS

GIVE COMPLETE SERIAL NUMBER OF MACHINE
GIVE PART NUMBER AND NAME
GIVE AMOUNT REQUIRED

Unless the above data is included we cannot fill your order.

MODEL: _____

SERIAL NUMBER: _____

DATE PURCHASED: _____

DAKE Division of JSJ
724 Robbins Road
Grand Haven, MI 49417

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E-mail: technicalservice@dakecorp.com
Website: www.dakecorp.com

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SPECIFICATIONS

Part Number	988040 / 988041
Blade Width	1/4-3/4 inches
Blade Length	120 inches
Blade Speed	70/140/270/540
Band Wheels	2
Band Wheel Size	14 inches
Horsepower	1 h.p.
Blade travel into the work (band to column)	9 inches
Maximum work height	14-1/2 inches
Worktable Dimensions	29 x 18 inches
Worktable Height	30 inches
Machine Height	66 inches
Machine Floor Space	29 x 40 inches
Weight	770 pounds
Voltage	
	<ul style="list-style-type: none">• 20-amp service for 110 / 220 volt machine.• 16-amp service for 440-volt machine.

FEATURES

- Heavy duty welded steel base and frame
- Precision ground cast iron worktable
- Heat-treated blade guides
- Bronze gear speed reducer
- Variable feed rate system with hydraulic feed regulator
- Surface ground steel guide rails.

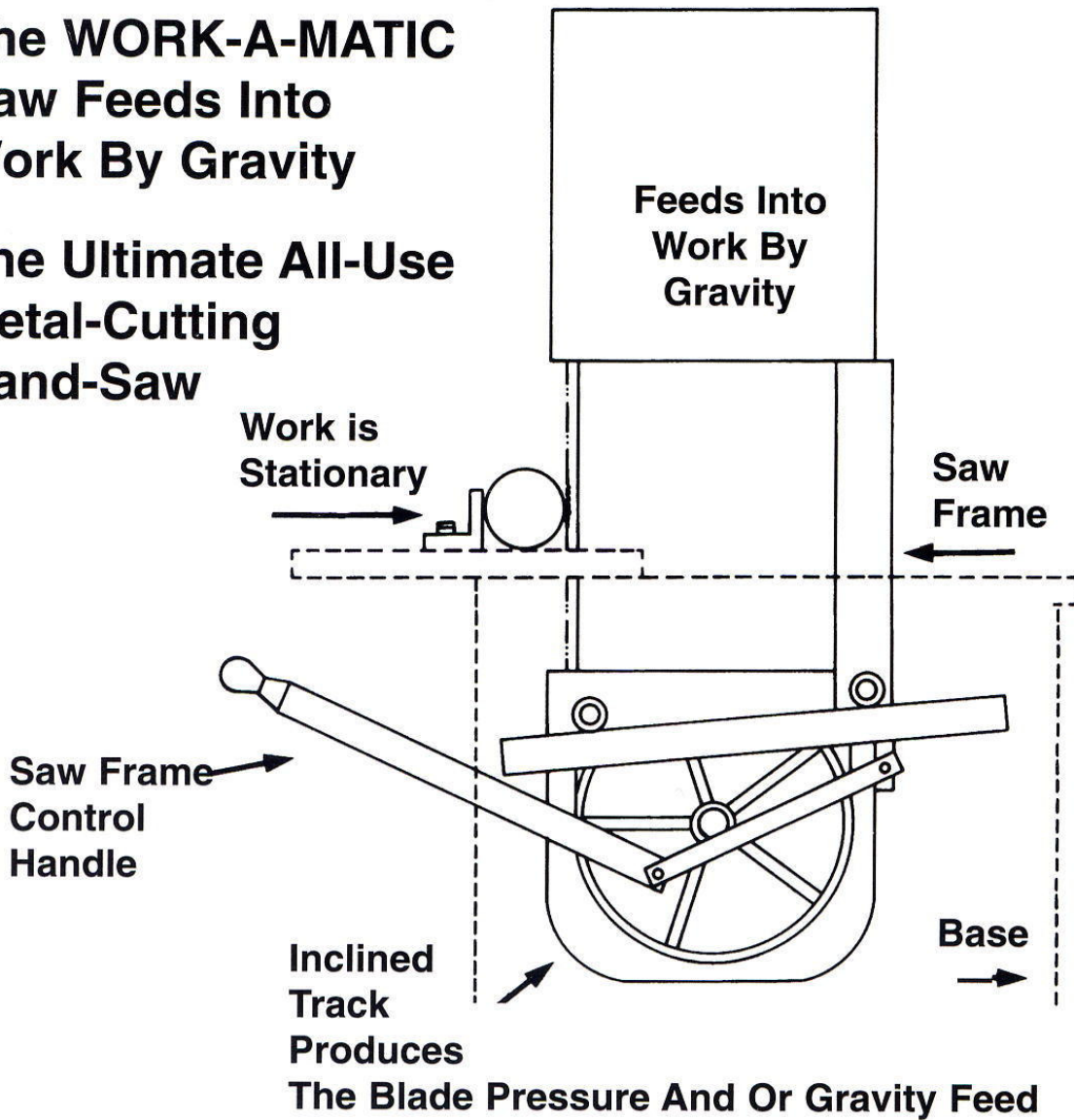
ACCESSORIES

Heavy Duty Casters – Adds mobility – move your SXC to the work, then lock the casters for stability.

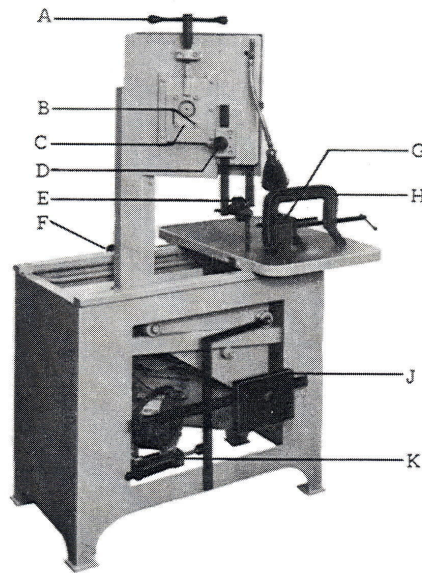
HOW THE DAKE PARMA SXC OPERATES

**The WORK-A-MATIC
Saw Feeds Into
Work By Gravity**

**The Ultimate All-Use
Metal-Cutting
Band-Saw**



SXC ADJUSTMENT



- A** BLADE TENSION HANDLE – Used to remove and install saw blade. Also used to set the correct blade tension – Be sure blade is tight.
- B&C** UPPER BLADE WHEEL CONT ADJUSTMENT – If your saw should get out of adjustment and the blade runs off the wheel or runs back against the lip, loosen the two bottom bolts on the wheel slide (B) Turn the set screw (C) in or out to make the blade run approximately 1/32" away from the lip on the back of the wheel. Tighten the two wheel slide bolts. **IMPORTANT: If the blade is allowed to run against the lip on the wheel it will wear the lip off.**
- D** GUIDE BAR LOCK – Used to lock the roll guides in position.
- E** ROLL GUIDES – Should be adjusted so they clear your work by approximately 1/2". This will insure maximum blade rigidity.
- F** STOP CLAMP – Has two uses: 1) The stop clamp can be set for depth of cut. 2) The stop clamp, if placed behind the neck, will lock the frame in a forward position for contour work.
- G** ANGLE PLATE – Used to hold stock in place for cutting. Graduations are provided to set angle cuts.
- H** C-CLAMP – Used mainly for round stock. Flat stock needs no clamping.
- I** COUNTERWEIGHT – Used to maintain the blade pressure you desire.
- J** HYDRAULIC CYLINDER – This should be adjusted to allow the frame to travel rapidly but not free fall. **This is a safety device and should be kept properly adjusted.**

BLADE SELECTION

For operator convenience, a blade selector chart is located inside the saw cover. It provides recommended blade speeds, required teeth per inch, and minimum cutting radius for various blade widths. The following chart can be used to select the blade needed:

Standard Tooth Applications

Thickness of Material	Teeth per Inch
Up to 1/8"	18T
1/8" to 1/4"	14T
1/4" to 1/2"	10T
1/2" to 1"	8T
1" to 3"	6T-4T
3" to 6"	4T-6T
6" and longer	3H

Note: 1) A minimum of 3 teeth into your work is required or blade damage will result.
2) For straight cuts, a 3/4" blade is best.

Blade Speed (Feet per minute)

To change blade speeds, bring the frame all the way forward. Lift the motor and move the V-belt to one of the three speeds offered: 70, 140, 270, or 540. Refer to the blade selector chart inside the cover on your SXC for the appropriate speed.

Blade Removal and Installation

To remove the blade, release the blade tension handle (A). Remove the blade.

To install blade, place the blade over the bottom wheel, then on the top wheel. Teeth must point down toward the table. Tighten the blade tension handle enough to hold the blade firmly in place, and then push the blade into the roller guides. Turn the machine on to allow the blade to position itself, and then finish tightening the blade.

IMPORTANT: Blade must be tight to insure straight cut.

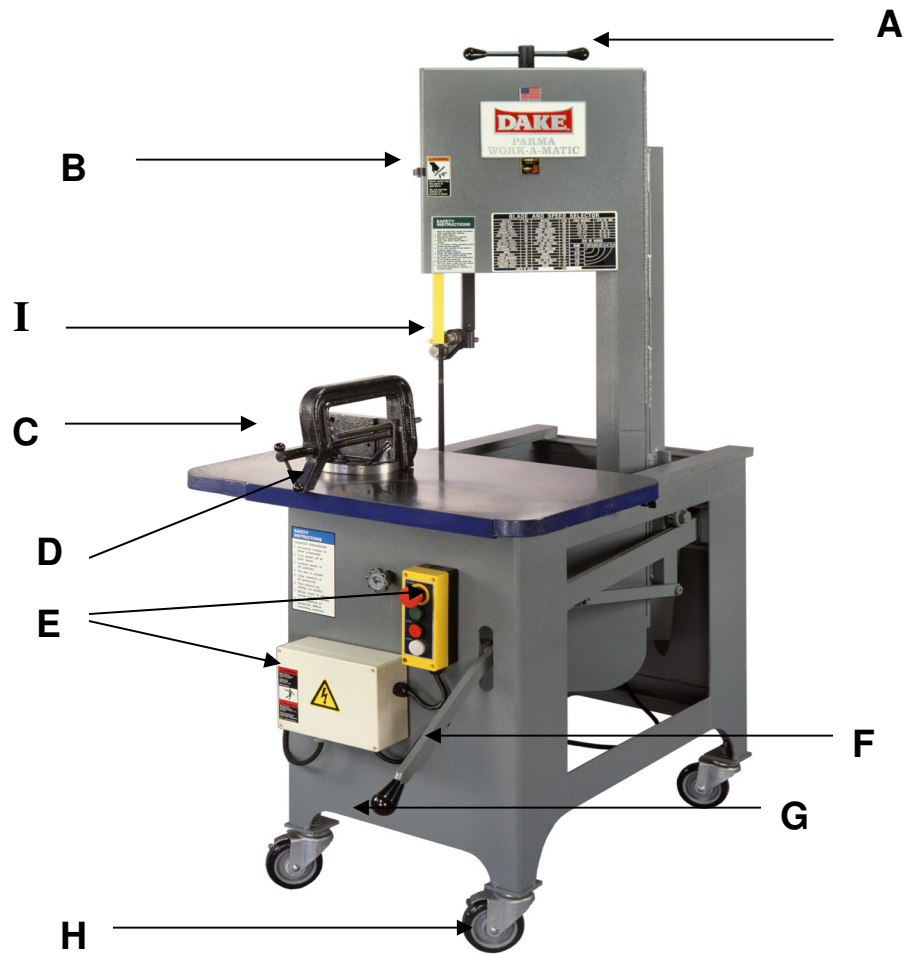
Please Note: The most common causes of the SXC not cutting straight are:

- 1) Blade tension is too low.
- 2) Blade is dull or worn on one side.
- 3) Blade was installed upside down. The teeth must point down toward the table.

LUBRICATION

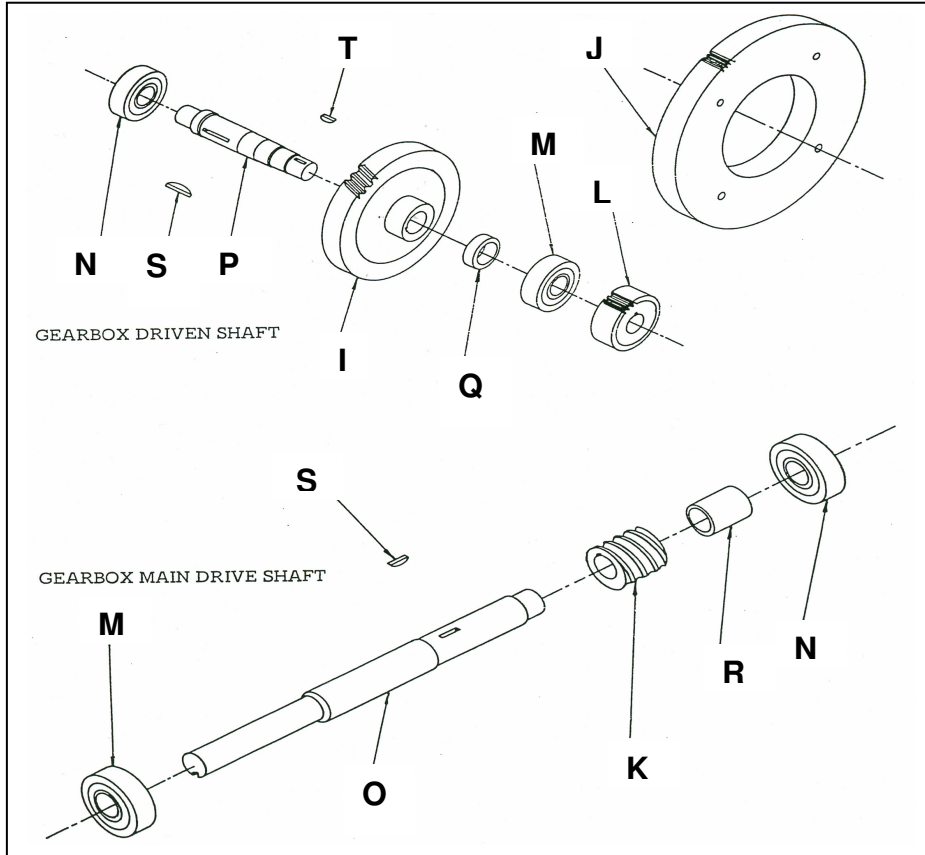
Gear Box Your SXC gearbox is filled at the factory. Check the fluid level on arrival, and then check every six months thereafter. Use 90-weight gear lube to maintain fluid level at the fill/check pipe plug.

Cylinder Keep the cylinder reservoir 1/2 to 3/4 full. Use light hydraulic oil to refill.

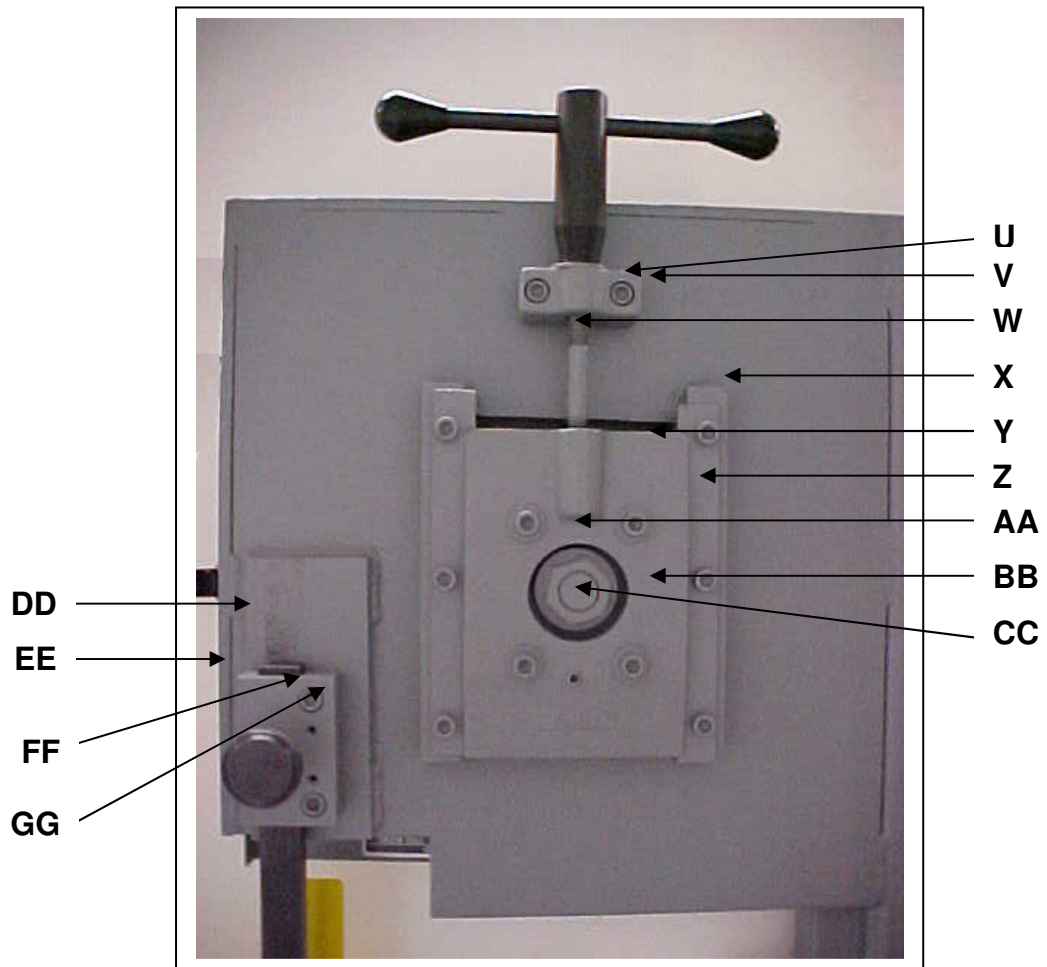


Item	Part Number	Description	Quantity
A	716716	Tension Handle Assembly	1
B	86747M	Door Latch	1
C	716714	C-Clamp Assembly	1
D	716703	Angle Plate with Pin	1
E1	716764	New Style Complete Electrical Kit – 1 ph 110 volt	1
E2	716765	New Style Complete Electrical Kit – 1 ph 220 volt	1
E3	716766	New Style Complete Electrical Kit – 3 ph 230 volt	1
E4	716767	New Style Complete Electrical Kit – 3 ph 460 volt	1
F	86782	Return Handle	1
G	300450	Knob, Return Handle	1
H	716725	Caster Set - Optional	1
I	87093M	Blade Guard	1

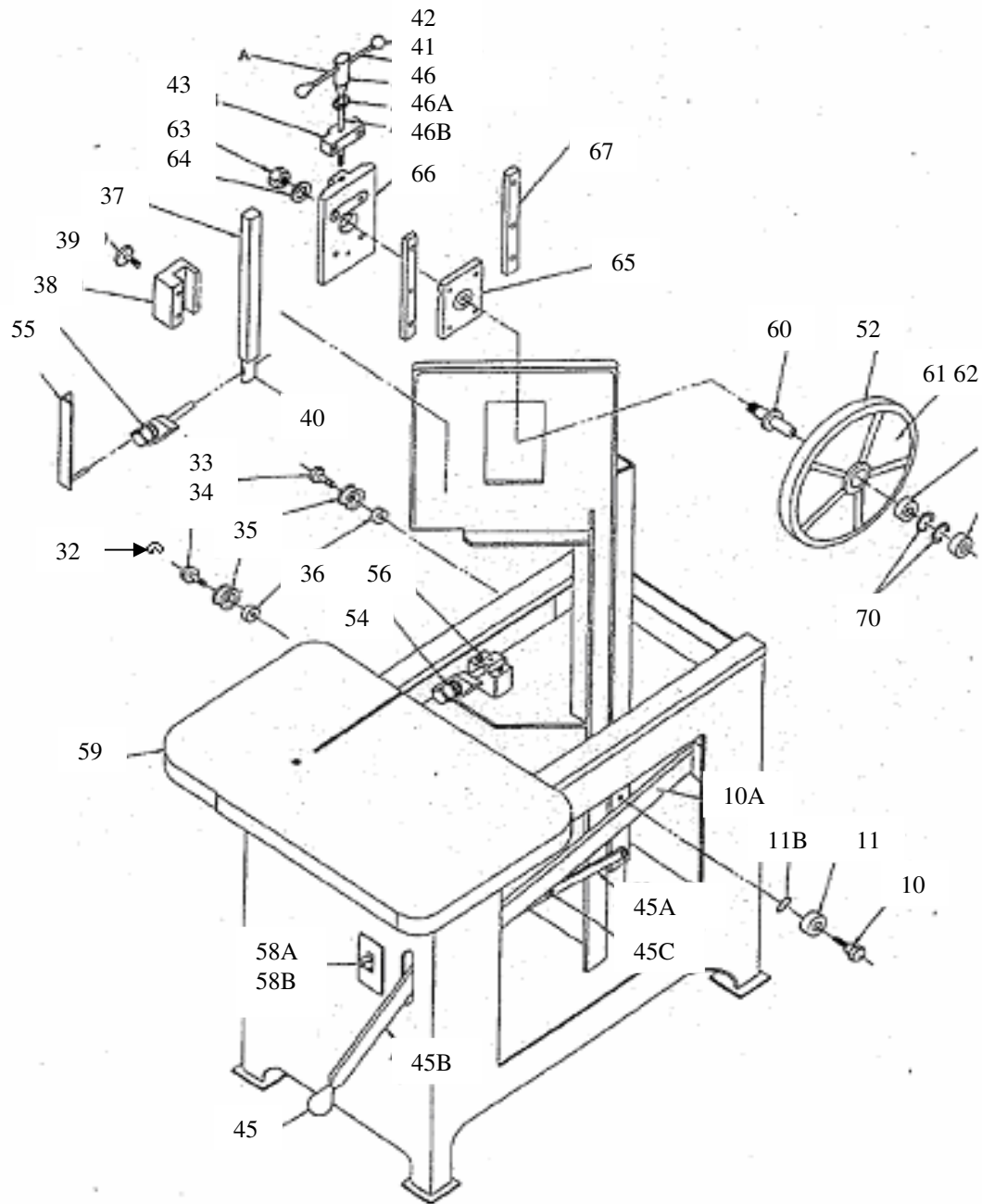
GEARBOX ASSEMBLY



Item	Part Number	Description	Quantity
	716712	Gearbox Assembly	1
	300472	Bearing, Seal	2
	300490	Gasket, Gearbox	1
	300491	Gasket, Gearbox	4
	300589	Dowel Pin 3/16 x 1/2	2
	43412	Screw, Soc Cap	16
	43414	Screw, Soc Cap	6
	43590	Screw, Soc Set	3
	86820	Bearing Cover, Small/hole	2
	86821	Bearing Cover, Small	2
	86822	Gearbox Casting	1
	86823	Cover, Gearbox	1
I	300666	Gear, Worm 40T Bronze	1
J	86784	80 Tooth Gear	1
K	300456	Worm, 4-Lead	1
L	300646	24 Tooth Gear	1
M	5072-00	Bearing, Gearbox	2
N	5073-00	Bearing, Gearbox	2
O	86785	Shaft, Main Drive	1
P	86781	Axle, Gearbox-Short	1
Q	86783	Spacer, Gearbox 1-1/4" O.D.	1
R	86786	Spacer, Gearbox 1" O.D X 3/4 I.D. X 1-1/8 LONG	1
S	300449	Key, Woodruff #13	2
T	300451	Key, Woodruff #5	1



Item	Part Number	Description	Quantity
U	43450	Cap Screw	2
V	86827	Wheel Slide Tension Mounting block	1
W	10117-00	Tension Screw	1
X	43447	Cap Screw	6
Y1	86824	Wheel Slide – External piece	1
Y2	86825	Wheel Slide Adjustment – Internal piece	1
Z	86826	Rail Wheel Slide	2
AA1	43922	Nut	1
AA2	43638	Washer	1
BB1	43452	Soc Cap Screw 3/8-16 x 1-3/4	4
BB2	43632	Washer 5/16" flat	4
CC	43591	Set Screw 3/8-16 x 1	1
DD	86810	Guide Bar Holder	1
EE	300832	Knob Assembly 1-1/2"	1
FF	70287	Roll pin	2
GG	43451	Cap Screw	2



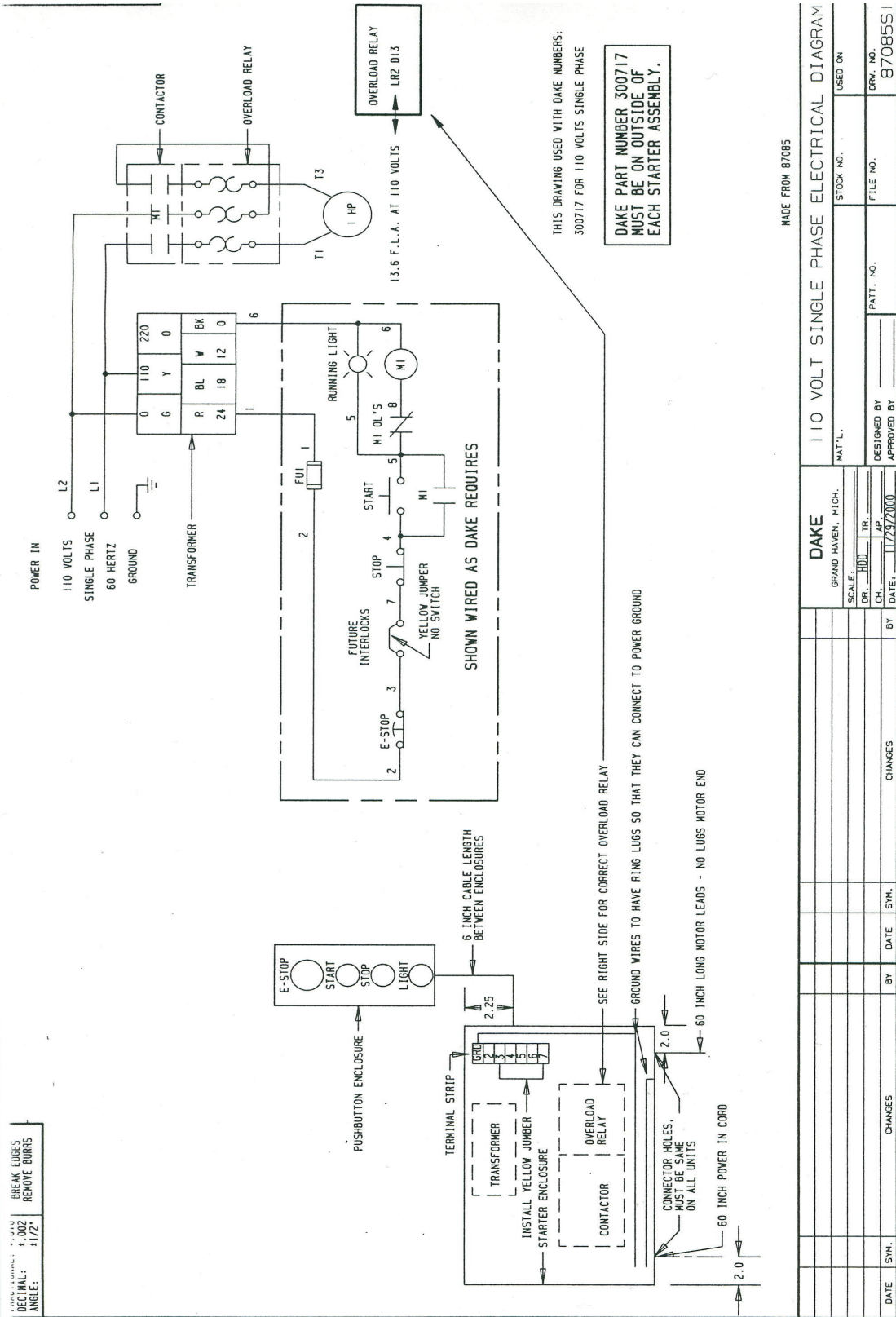
Not Pictured	86806B	Insert Brass Contour Large, 1/2"
Not Pictured	86807B	Insert Brass Contour Small, 1/4"
Not Pictured	86792	Contour Guides (Casting)
Not Pictured	86808	Holder Contour Insert
Not Pictured	86806A	Carbide Inserts, Set of 2, 1/2"
Not Pictured	86807B	Carbide Inserts, Set of 2, 1/4"
Not Pictured	86833	Counterweight Casting
Not Pictured	86831	Counterweight Fulcrum
Not Pictured	86834	Counterweight Lever Link
Not Pictured	716709	Cylinder Hydraulic Complete - OLD STYLE before 9/27/02 - OBSOLETE - Must retrofit New Style 716769
Not Pictured	716769	Cylinder Hydraulic - NEW STYLE with retro-fit kit. Ater 9/28/02
Not Pictured	86842	Cylinder, Hydraulic Eye Bolt - OLD STYLE

Not Pictured	300505	Cylinder, Hydraulic Reservoir (1 oz) - OLD STYLE
Not Pictured	300510	Cylinder, Hydraulic Reservoir (2 oz) - OLD STYLE
Not Pictured	716754	Cylinder Rebuilt Kit - OLD STYLE
Not Pictured	n/a	Cylinder Rebuild Kit - NEW STYLE
Not Pictured	300598	Cylinder, Hydraulic Shoulder bolt - OLD STYLE
Not Pictured	300529	Electric Cord Set with Plug
Not Pictured	86836	Excentric Roller Gravity Feed
10	86816	Stud Flat Track
10A	86852	Flat Track Rail
11	300471	Bearing Flat Track W204
11A	86839	Flat Track Roller Spacer
32	300477	E-Clip
33	86837	Stud Lever Weight
34	86819	Stud Grooved Roller
35	716706	Roller With Groove and Bearing
36	86838	Spacer Gravity Feed (3/8)
37	86815	Guide Support Bar - STD
37	86817	Guide Support Bar - XC, SXC
38	86810	Holder Guide Bar
39	300832	Guide Bar Lock Knob
40	86813	Swivel Guide Support Bar
43	86827	Pillow Block
44	86828	Tension Handle Body
44A	43634	Tension Handle Washer 1/2"
44B	86830	Screw Tension
45	300450	Knob Return Handle
45A	86841	Link Return Handle
45B	86782	Handle Return
45C	43777	Return Handle Shoulder Bolt 1/2 x 1/2
45D		Return Handle Axle Bolt - 1/2-13 x 3" SHCS
45E	86839	Spacer Return Handle (1/4)
Not Pictured	86798	Axle, Motor Mounting
Not Pictured	86800	Block Motor Mounting
52	300459	Band Blade Wheel Rubber Tire
53	10025-01	Bearing Roll Guide
54	87087	Roll Guide 1"
54	86809	Roll Guide 3/4"
54A	716717	Upper/Lower Roll Guide Assembly w/Bearing,Holder,Guide,Screw
55	86811	Holder Guide Rollers / housing
56	86805	Holder Guide Roll / Pillow Block
56A	86814	Excentric Top Guide
56B	86812	Pin Guide Lower Rolls
57	86791	Stop Frame
Not Pictured	300832	Knob, Stop Weight
59	86796	Tables-Raw
60	86803	Axle Lower & Upper Wheel
62	86795	Wheel Blade Lower
63	78650	Washer
64	300651	Nut
65	300693	Wheel Bearing (6205)

66	86824	Wheel Slide
67	86826	Rail Wheel Slide
68	86825	Shield Slide Adjustment Rocker
69	86804	Stud Upper & Lower Wheel
70	300466	Retaining Ring Blade Wheel
Not Pictured	87065A	Wheel Guard
Not Pictured	300685	Pulley Guard Assembly
Not Pictured	300522	V-Belt
Not Pictured	43632	Washer Angle Plate
Not Pictured	86835	Lever Link Weight

110 Volt – Single phase @ 14 Amps
220 Volt – Single phase @ 7.5 Amps
230 Volt – Three phase @ 4 Amps
460 Volt – Three phase @ 2 Amps

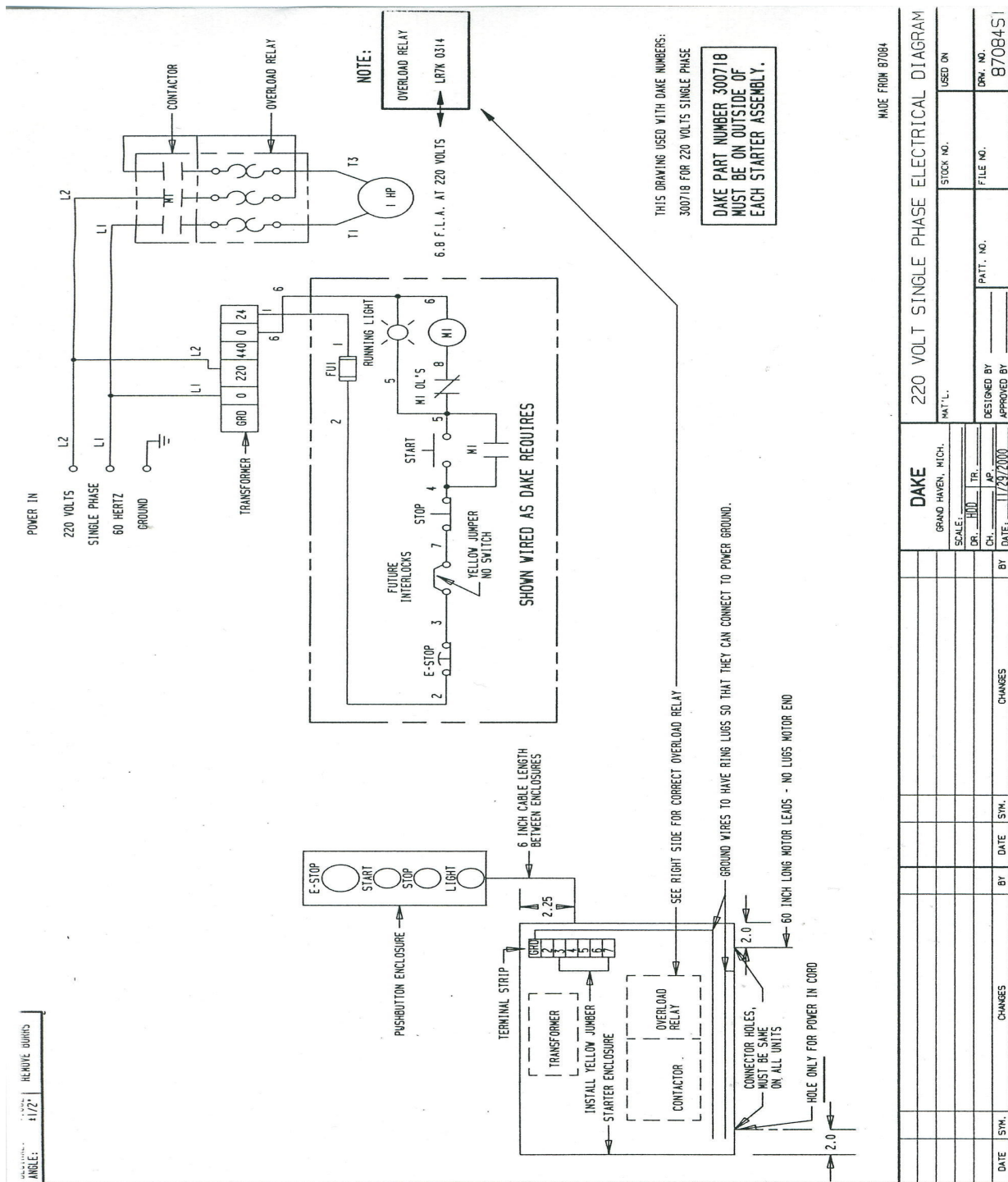
110 Volt Single Phase



MADE FROM 87085

DAKE		GRAND HAVEN, MICH.	
SCALE:	TR.	STOCK NO.	USED ON
DR. HOD	TR.	FILE NO.	87085S1
CH. AP	DATE: 11/29/2000	PATT. NO.	DRW. NO.
DESIGNED BY	APPROVED BY		

220 Volt Single Phase



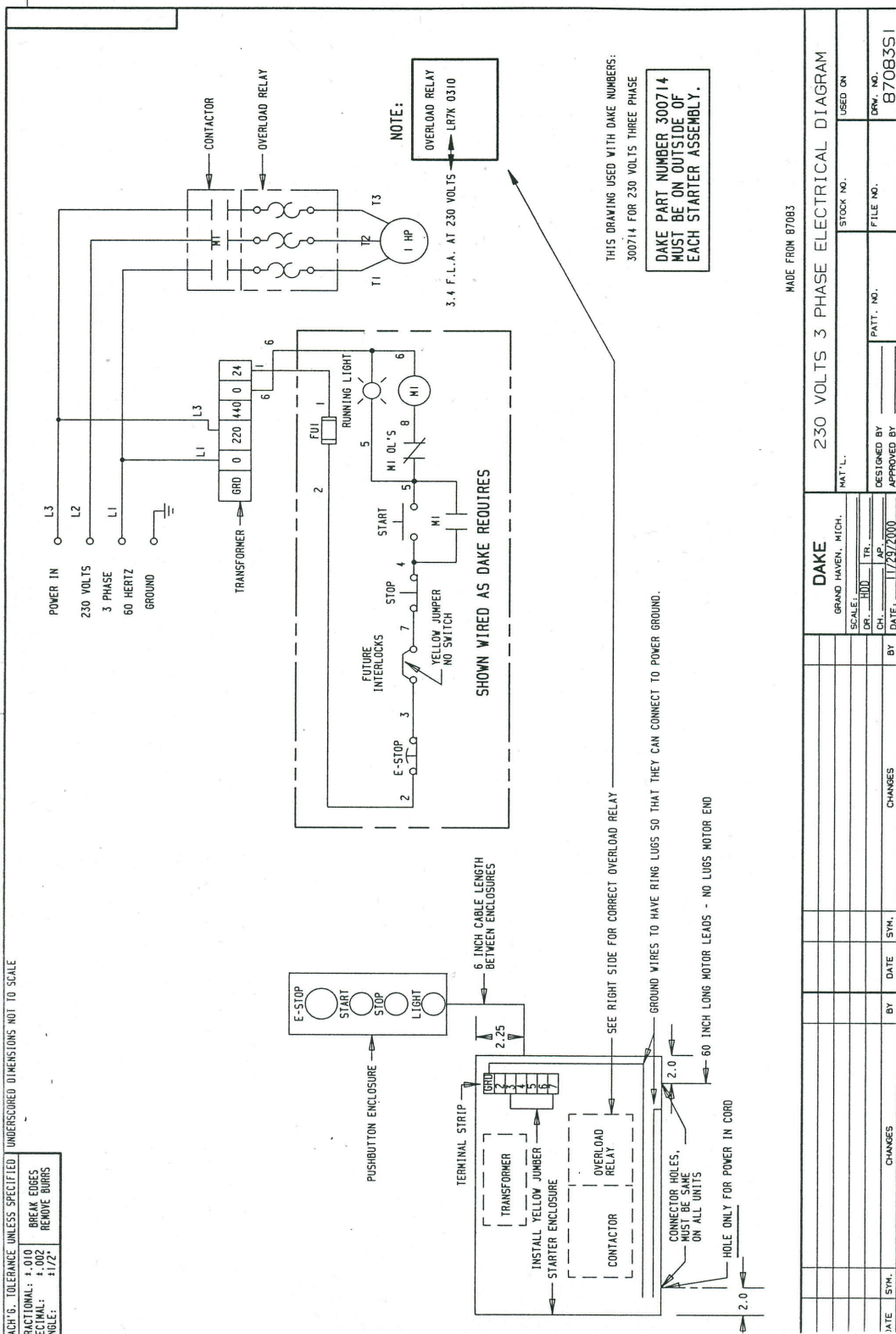
THIS DRAWING USED WITH DAKE NUMBERS:
300718 FOR 220 VOLTS SINGLE PHASE

**DAKE PART NUMBER 300718
MUST BE ON OUTSIDE OF
EACH STARTER ASSEMBLY.**

MADE FROM 87084

DAKE		220 VOLT SINGLE PHASE ELECTRICAL DIAGRAM	
GRAND HAVEN, MICH.	SCALE: 1/16" = 1"	STOCK NO.	USED ON
DR. JRD	TR.	FILE NO.	DRW. NO.
CH. HP	DATE: 11/29/2000	DESIGNED BY	87084S1
BY	DATE	APPROVED BY	
CHANGES	BY	DATE	SYN.
CHANGES	BY	DATE	SYN.

230 Volt Three Phase



460 Volt Three Phase

