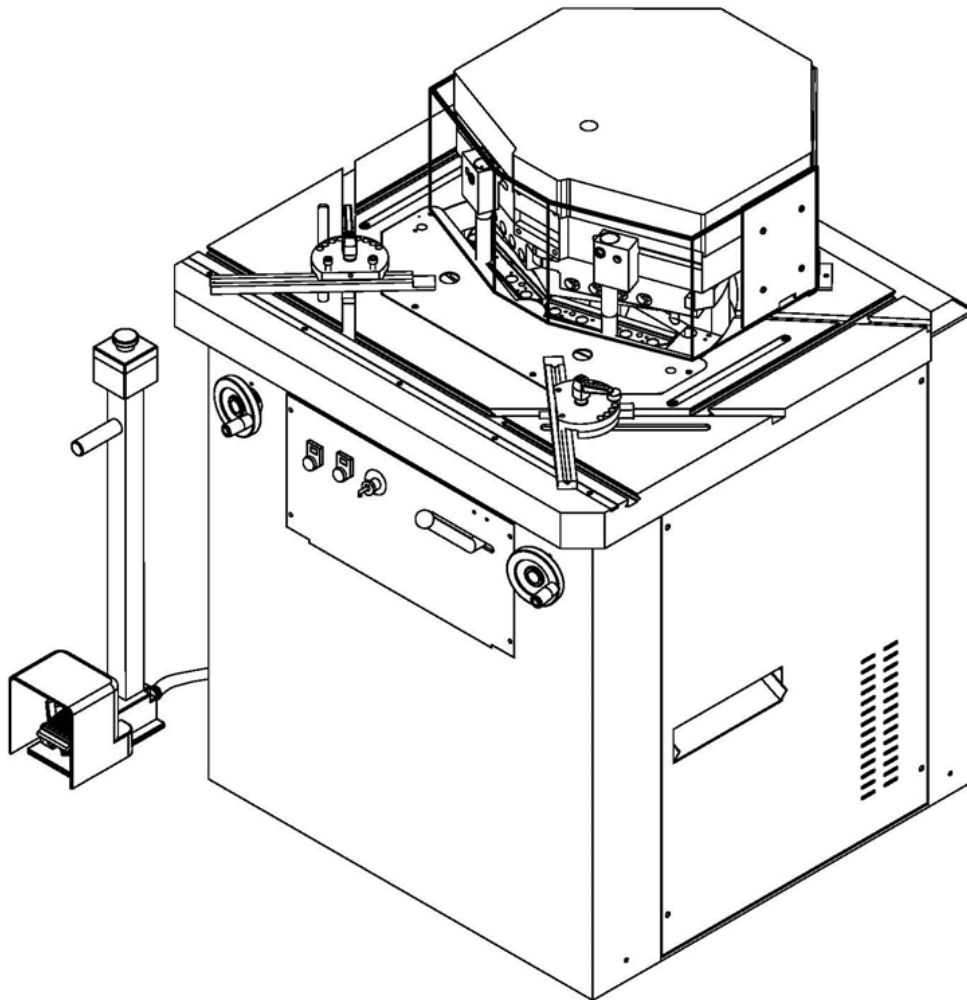




## DAKE HYDRAULIC NOTCHER

Model: DLN-6220V

INSTRUCTIONAL MANUAL



### WARNING!

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

Dake Corporation  
1809 Industrial Park Dr  
Grand Haven, MI 49417

Phone: 800.937.3253  
Fax: 800.846.3253

[www.dakecorp.com](http://www.dakecorp.com)

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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, the Warranty Representative at Dake Customer Service must be contacted for approval:

Phone: (800) 937-3253

Email: [customerservice@dakecorp.com](mailto:customerservice@dakecorp.com)

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 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 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 and parts 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 by the distributor or representative: Phone: (800) 937-3253 Email: [customerservice@dakecorp.com](mailto: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.

The item must be shipped and received back to Dake within 30 days from being issued the RMA number, or the return will be void and nonreturnable.

### **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.

## DAKE STANDARD TERMS & CONDITIONS OF SALE

All proposals and quotations for the original sale of our products are subject to the following terms and conditions:

**ACCEPTANCE OF ORDER:** All orders are subject to acceptance by Dake at its main office in Grand Haven, Michigan.

**APPLICABLE LAWS:** This quotation or acceptance shall be governed in all respects by the laws of the State of Michigan.

**CANCELLATION:** We reserve the right to cancel and/or refuse to complete your order if, in our opinion, you have not established credit to promptly meet the payment terms of your order. Any cancellation from the Purchaser may be subject to a 10% cancellation fee for any of our standard machinery and/or component parts upon the discretion of Dake. All non-standard or special quotes will not be eligible for cancellation, nor returns.

**DELIVERY:** The proposed shipment date is an estimate and is contingent upon causes beyond Dake's control. Under no circumstances shall Dake have any liability for loss of use or for any direct or consequential damages resulting from delay. All shipments from the Dake facilities are F.O.B.

**FREIGHT CLAIM:** Lost or damage freight claims must be submitted to Dake within thirty (30) days of shipment from Dake's facility. If shipment for order was set up by the Purchaser, Dake is not liable to handle the freight claims.

**PERMITS AND COMPLIANCE:** Dake shall not be responsible for obtaining any permits, inspections, certifications, or licenses required for the installation or use of the equipment. Dake makes no promise or representation that the equipment or any services to be furnished by Dake will conform to any federal, state, or local laws, ordinances, regulations, codes or standards.

**PRICES:** Unless otherwise agreed to in writing, all prices are F.O.B. from our plants in Grand Haven, Michigan, Grand Prairie, Texas, and Riverside, CA. In any event, the quoted prices for component parts become invalid ten (10) days after date of quotation, and machinery may become invalid sixty (60) days after date of quotation. Unless otherwise specified in Dake's quotation, installation services and final on-site adjustments are not included in the quotation.

**TAXES:** Prices do not include taxes. If any sales, use or similar tax is payable to Dake in connection with any transaction or part thereof between the Purchaser and Dake with respect to goods delivered, the Purchaser will, upon demand, pay to Dake the amount of any such tax. If you are tax exempt, please include your exemption document when submitting your order.

**TERMS OF PAYMENT:** Terms of payment are as stated in Dake's quotation subject to credit approval by our home office. Dake will invoice Purchaser when the equipment is completed and ready for shipment. Payment terms run from invoice date. Purchaser may be required to issue a down payment before production of order, at the discretion of Dake Accounting. For credit card purchases, a 2% processing fee may be applicable to the order. The following states are exempt from the 2% processing fee: CA, CO, KS, OK, TX, FL, NY, CT, MA, and ME.

**WARRANTY:** If, within a period of one (1) year from date of shipment of the original order, any part of any equipment sold by Dake is defective in material or workmanship and is so found after inspection by Dake, it will be replaced or repaired at the option of Dake, providing the equipment has been given normal and proper usage and is still the property of the original Purchaser. Purchased components such as Micro Drop mist system or the like, installed as a part of Dake equipment are warranted only to the extent of the original Manufacturer's warranty. Dake is not responsible for any service work performed unless authorized in advance.

**THE FOREGOING WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES WHETHER WRITTEN, ORAL, OR IMPLIED (INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE).  
UNDER NO CIRCUMSTANCES SHALL DAKE BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES**

## SPECIFICATIONS

<b>Motor</b>	4 HP	<b>Table Dimensions</b>	37.4" x 31.3"
<b>Blade Length</b>	8.6" x 8.6"	<b>Overall Dimensions</b>	38-1/2 x 36-1/2" x 55.1"
<b>Max Cutting Thickness</b>	3mm with 15° Blade 6mm with 30° Blade	<b>Net Weight</b>	16741 lbs.
<b>Strokes per minute</b>	15	<b>Noise @ 1 meter</b>	70.2 dB

## SAFETY

1. The operator must carefully follow recommendations provided and instructions herein stated for a better use, and preservation of the machine to avoid any damage to people or things.
2. When you unpack the machine, follow instructions provided by us in the relevant chapter carefully.
3. Before starting the machine, make sure there are no dangerous conditions for personnel in charge of the operation and no unauthorized object has been left inside or above the machine.
4. Keep the bench and/or work area clean and tidy to avoid any hindrance on portions of already cut material.
5. Verify that fixed hand protections are properly installed.
6. The use of gloves is highly recommended to avoid injuries.
7. It is advisable to take off clothes such as scarves, ties etc... along with jewelry and trinkets such as rings, watches, bracelets etc....
8. It is forbidden to cut material having a higher thickness or features differing from those for which the machine has been designed.
9. For cleaning, please read instructions for maintenance carefully.
10. In case of emergency, press the red button (Emergency Stop).
11. Before carrying out any maintenance operation, be sure that the main switch of the machine, placed on the control box is disconnected and locked to avoid accidental starting.
12. Carrying out controls, checking maintenance operations, take special care of all protruding parts to avoid any possible injuries.
13. Oil is not furnished with the machine, so fill it in at installation.
14. Do not throw the hydraulic oil, follow your local regulations on disposing of hydraulic oil.
15. The operator must be aware that the emergency stop button is designed to immediately set the machine's process to a halt when it is activated. Hence, preventing any electrical and mechanical parts to further move or cause any damage. Therefore it can be used to stop the machine immediately at any instance to ensure the safety of the user and/ or the machine. However, the machine's power won't be cut-off when the emergency button is activated. Hence to recover from emergency stop state, simply twist the emergency stop button clockwise.



**SAFETY LABELS**

**ATTENZIONE!**  
-NON ESEGUIRE TAGLI CON UNA SOLA LAMA  
SENZA UTILIZZO DEI PREMILAMIERA ALLO SQUADRO.

**WARNING!**  
-ALWAYS USE THE SQUARE HOLDDOWN WHEN  
CUTTING SHEET METAL FROM A SINGLE SIDE  
OF BLADE SYSTEM.

Figure 1. Always use hold-down device when cutting sheet metal.

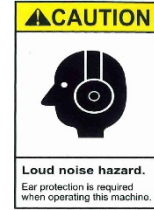


Figure 2. Operator needs to wear ear protection while operating this machine

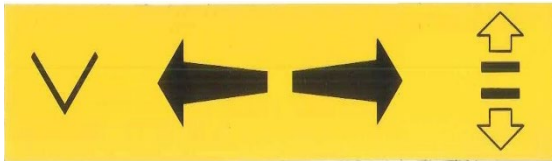


Figure 3. Manual Cylinder Switch.  
Left = Cylinder Locked.  
Right = Cylinder Unlocked

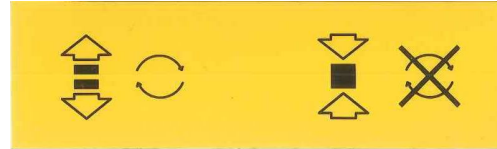


Figure 4. Use handwheel to adjust the angle of the blade set when the cylinder is unlocked.

**ONLY PROPERLY TRAINED AND  
AUTHORIZE PERSONEL  
SHOULD OPERATE  
THIS MACHINE**

Figure 5. Authorized Personel Safety Label

TO ALL CONCERNED MAKE SURE THAT THE OPERATOR UNDERSTANDS THE FOLLOWING

**WARNING**

TO PREVENT SERIOUS BODILY INJURY  
**NEVER** PLACE ANY PART OF YOUR BODY AT THE POINT OF OPERATION.  
**NEVER** OPERATE, SERVICE, REPAIR OR ADJUST MACHINE WITHOUT PROPER INSTRUCTION FROM YOUR SUPERVISOR AND WITHOUT READING AND UNDERSTANDING THE INSTRUCTION MANUAL.  
**NEVER** SERVICE MACHINE WITH MOTOR ON.

IT IS EMPLOYER'S RESPONSIBILITY TO IMPLEMENT THE ABOVE INSTRUCTIONS AND TO PROVIDE PROPER SAFETY MEASURES NECESSARY FOR EACH PARTICULAR USE, OPERATION, SETUP OR SERVICE OF THE MACHINE.

DO NOT REMOVE THIS SIGN FROM MACHINE FOR ANY REASON

Figure 6. Bodily Injury Safety Label

<b>CAUTION</b>	
	Read and understand operator's manual before using this machine. Failure to follow operating instructions could result in death or serious injury.
	<b>Loud noise hazard.</b> Ear protection is required when operating this machine.
	<b>Flying objects hazard.</b> Eye protection is required when operating this machine.
	<b>Respiratory hazard.</b> Wear approved respirator in this area.

Figure 7. Multi Safey Label

**WARNING**

**DO NOT'S:**  
**NEVER** OPERATE MACHINE UNLESS PROPERLY TRAINED.  
**NEVER** OPEN OR REMOVE GUARDS UNTIL MACHINE IS STOPPED.  
**NEVER** PLACE HANDS IN AREA NEAR MOVING PARTS OR MOVING MATERIAL.  
**DO NOT** OPERATE WHILE UNDER INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.  
**NEVER** SERVICE MACHINE WITH MOTOR ON  
**READ AND UNSTAND THE INSTRUCTION MANUAL BEFORE OPERATION.**

**FAILURE TO HEED THESE WARNINGS CAN RESULT IN SERIOUS INJURY.**

Figure 8.  
General safety rules to operate this machine

**ATTENTION**

Please inject the hydraulic oil into the oil tank before first time operation!!!

**Hydraulic Oil Replacement:**

A. After first 3000 hours operation, please replace the new oil and filter.

B. Then after every 5000 hours operation, please replace the new oil and filter.

Figure 9. Fill with oil before use

**CAUTION**

Before make any service or maintenance, **please make sure air or electric power supply is disconnected.**

Failure to follow caution may result in serious injury.

Figure 10. Disconnect Power Label





Figure 11. Emergency Stop



Figure 12. Electrical Hazard Label



Figure 13. Warning label on safety cover.



Figure 14. Guarding label – do not remove guarding & keep hands away from point of operation



Figure 15. Hook installation point

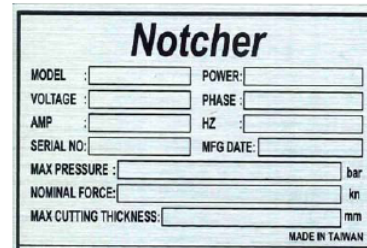


Figure 16. Specification plate



Figure 17. Shows main electrical power supply wire location. Connect machine with same voltage power as the motor.

**LABEL PLACEMENT**

**ATTENZIONE!**  
NON ESEGUIRE TAGLI CON UNA SOLA LAMA SENZA UTILIZZO DEI PREMLAMIERA ALLO SQUADRO.

**WARNING!**  
ALWAYS USE THE SQUARE HOLDDOWN WHEN CUTTING SHEET METAL FROM A SINGLE SIDE OF BLADE SYSTEM.

**CAUTION**

Loud noise hazard.  
Ear protection is required when operating this machine.

**Notcher**

VOLTAGE	PHASE
AMP	KV
SEAL NO.	W/DATE
MAX PRESSURE	HP
NOMINAL FORCE	IN
MAX CUTTING THICKNESS	IN

MODEL TALKER



**CAUTION**

Read and understand operator's manual before using this machine. Failure to follow operating instructions could result in death or serious injury.

**Loud noise hazard.**  
Ear protection is required when operating this machine.

**Flying debris hazard.**  
Eye protection is required when operating this machine.

**Respiratory hazard.**  
Wear approved respirator in this area.

**WARNING**

DO NOT remove the safety cover under operation. Failure to follow warning may result in serious injury.

**CAUTION**

**HOOK INSTALLATION POINT**

**WARNING**

DO NOT'S  
NEVER OPERATE MACHINE UNLESS PROPERLY TRAINED.  
NEVER OPEN OR REMOVE GUARDS UNITS, MACHINE IS STOPPED.  
NEVER PLACE HANDS IN AREA NEAR MOVING PARTS OR MOVING MATERIAL.  
DO NOT OPERATE WHILE UNDER INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.  
NEVER SERVICE MACHINE WITH MOTOR ON.  
READ AND UNDERSTAND THE INSTRUCTION MANUAL, BEFORE OPERATION.  
FAILURE TO HEED THESE WARNINGS CAN RESULT IN SERIOUS INJURY.

**ATTENTION**

Please inject the hydraulic oil into the oil tank before first time operation!!!

**Hydraulic Oil Replacement:**

A. After first 3000 hours operation, please replace the new oil and filter.

B. Then after every 3000 hours operation, please replace the new oil and filter.

**ONLY PROPERLY TRAINED AND AUTHORIZED PERSONNEL SHOULD OPERATE THIS MACHINE**

**WARNING**

**TO PREVENT SERIOUS BODILY INJURY**  
NEVER PLACE ANY PART OF YOUR BODY AT THE POINT OF OPERATION.  
NEVER SERVICE, REPAIR OR ADJUST ANY PART WITHOUT THE PROTECTION GUARDS AND SAFETY DEVICES.  
NEVER SERVICE MACHINE WITH MOTOR ON.  
IT IS EMPLOYEE'S RESPONSIBILITY TO ADHERE TO THE ABOVE INSTRUCTIONS AND TO REMOVE HANDS AWAY IMMEDIATELY FOR EACH PARTICULAR USE, OPERATION, STOP OR START OF THE MACHINE.  
DO NOT REMOVE THIS SIGN FROM MACHINE FOR ANY REASON.

**Trouble Shooting**

If the head set can not move up and down, please switch the wiring L1 & L2 of the power cord.  
(For 3 phase motor only)

CT-M001

**CAUTION**

Before make any service or maintenance, please make sure air or electric power supply is disconnected.

Failure to follow caution may result in serious injury.

**WARNING**

Do Not remove the protection guard and keep hands away during operation and cutting.

## TRANSPORT

Package handling must be carried out exclusively using a forklift truck with features suitable for hoisting the package taking into account the weight and dimensions of the package.

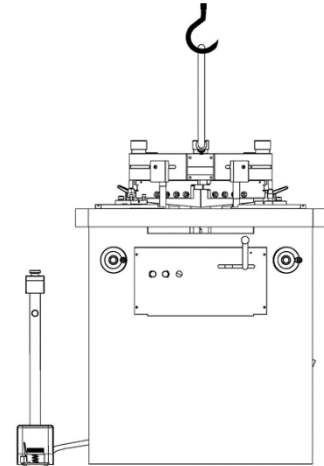
Position the forks to keep the package properly balanced.

Remove packaging materials and unscrew the machine from the pallet.

Remove the scrap container that is one the machines work table to prevent it from falling during handling.

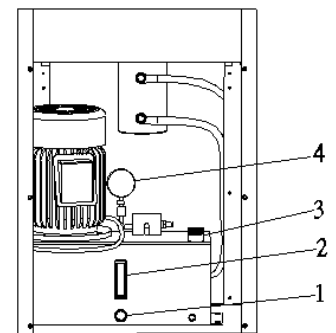
Machine loading and unloading should only occur using a hoist and lifting from the eyebolt on the top of the machine.

Never handle the machine manually or by any means that would result in injury of the operator and machine damage.




## INSTALLATION

1. Using the lifting eye on the top of the machine, lift and place the machine in the work area. Make sure there is enough space for production operation and safety of the operator.
2. Place foot pedal control at best position for the operator.
3. Unscrew the screws holding the front cover close. Then fill oil tank(3) with DTE #24 hydraulic oil or equivalent. Fill until oil reaches 4/5 on the oil indicator(2). About 9 gallons of oil.
4. The pressure gauge(4) is pre-set to 2100 psi. *Do not modify unless done so by a professional.*



## GROUNDING INSTRUCTIONS

The appliance must be grounded, if it should malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having equipment-ground conductor and grounding plug. The plug must be inserted into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

 **WARNING** Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician or service person if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with the appliance – if it will not fit the outlet; have a proper outlet installed by a qualified electrician.

### ***For Grounded, Cord-Connected Machine:***

This appliance is for use on a circuit having a normal rating and is factory-equipped with a specific electric cord and plug to permit connection to a proper electric circuit. Make sure that the appliance is connected to an outlet having the same configuration as the plug. No adaptor should be used with this appliance. If the appliance must be reconnected for use on a different type of electric circuit, qualified service personnel should make the reconnection.

### ***For Permanently Connected Machine:***

This appliance must be connected to a grounded metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment grounding terminal or lead on the appliance.

## OPERATING CONDITIONS:

**Voltage** Steady state voltage: 0,9 to 1,1 of nominal voltage.

**Frequency** 0,99 to 1,01 of nominal frequency continuously; 0,98 to 1,02 short time.

**Harmonics** Harmonic distortion not exceeding 10% of the total r.m.s. voltage between live conductors for the sum of the 2<sup>nd</sup> through to the 5<sup>th</sup> harmonic.

**Voltage interruption** Supply interrupted or at zero voltage for not more than 3 ms at any random time in the supply cycle with more than 1 s between successive interruption.

**Voltage dips** Voltage dips not exceeding 20% of the peak voltage of the supply for more than one cycle with more than 1 s between successive dips.

The minimum requirement for all electrical equipment is correct operation between air temperature of +5°C and +45°C.

Electrical equipment is capable of operating correctly when the relative humidity does not exceeding 50% at a maximum temperature of +45°C.

Electrical equipment is capable of operating correctly at altitude up to 1000 m.

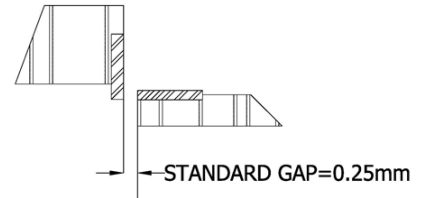
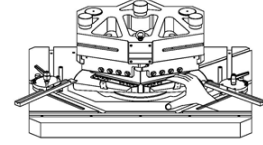
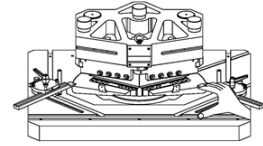
Electrical equipment is designed to withstand to protected against the effects of transportation, and storage temperature within a range of -25°C to +55°C and for short periods not exceeding 24h at up to +70°C.

Avoid exposing to vibration environment. Avoid exposing to direct sunlight or heat rays.

Have to connect to the factory grounding system correctly away from electric magnetic interference source sites, such welding, and discharge machine.

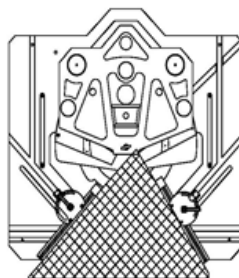
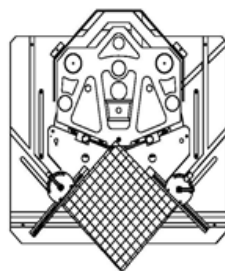
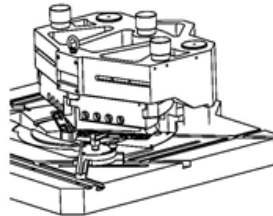
## ADJUSTING BLADE GAP

1. Disconnect machine from it's power source.
2. Unscrew the screws to the safety cover and then remove the safety cover.
3. Loosen the bias screws and blade screws to measure the blade gap.
4. Using the .25mm thickness gauge provided, adjust the upper and lower blades against the thickness gauge and tighten screws so that the blade gap is at .25mm.



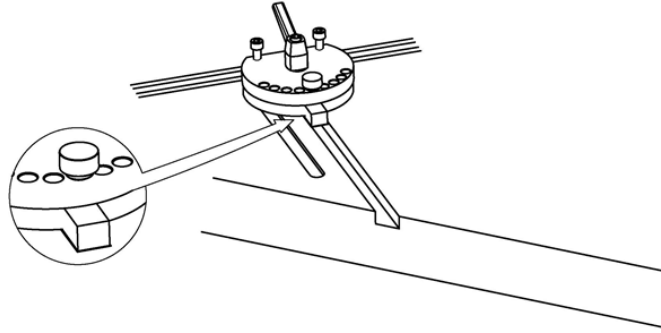
## ADJUSTING MOBILE SQUARE

1. Loosen handle to the length for the workpiece.
2. Take out pin and adjust to what angle is needed.
3. Adjust left and right block to match work piece.



## POSITIONING SQUARES

Positioning squares are inserted into the T-Slots on the table. There are several different direction T-slots to choose from when operating. All are equipped with a shoulder strut which can be used as a guide for the sheet metal. The holes on the square are in intervals of 15°, for locking fixed angles insert the knob pin into the hole for the desired angle.



## MAXIMUM CUTTING THICKNESS

Max Thickness: 6mm @ 30°-140°

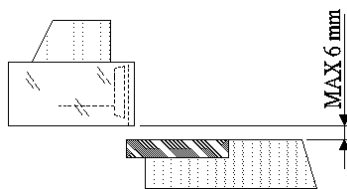
With 15° Blade (cut 30°-60°)

With 30° Blade (cut 60°-140°)

When cutting 3-4mm material keep at least 0.15mm of clearance between upper and lower blades.

When cutting 6mm material keep at least 0.4mm clearance between the upper and lower blades.

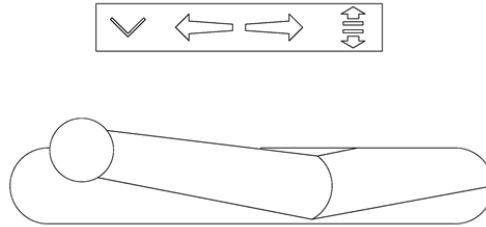
**⚠** When cutting stainless steel (2mm) you need to change to special made blades.





## BLADE ADJUSTMENT

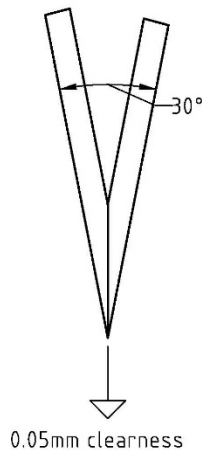
Blade Adjustment Handle: Left=Locked Position. Right=Unlocked Position



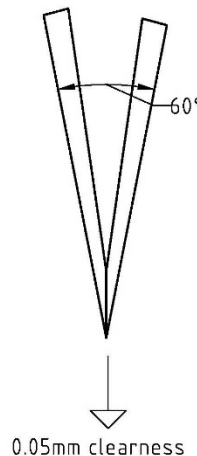
Upper Blades:

- If adjusting the upper blades with 15° blades (cut 30°-60°), keep at least 0.05mm of clearance at the 2 blade edges.
- If adjusting the upper blades with 30° blades (cut 60°-140°), keep at least 0.05mm of clearance at the 2 blade edges.

15° degree blades



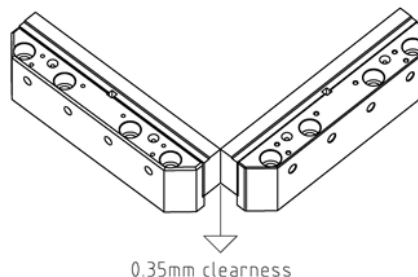
30° degree blades



**CAUTION: BLADES MUST BE CALIBRATED OFF THE MINIMUM ANGLE**

Lower Blades:

- If adjusting the lower blades, keep at least 0.35mm clearance at the 2 blade edges.

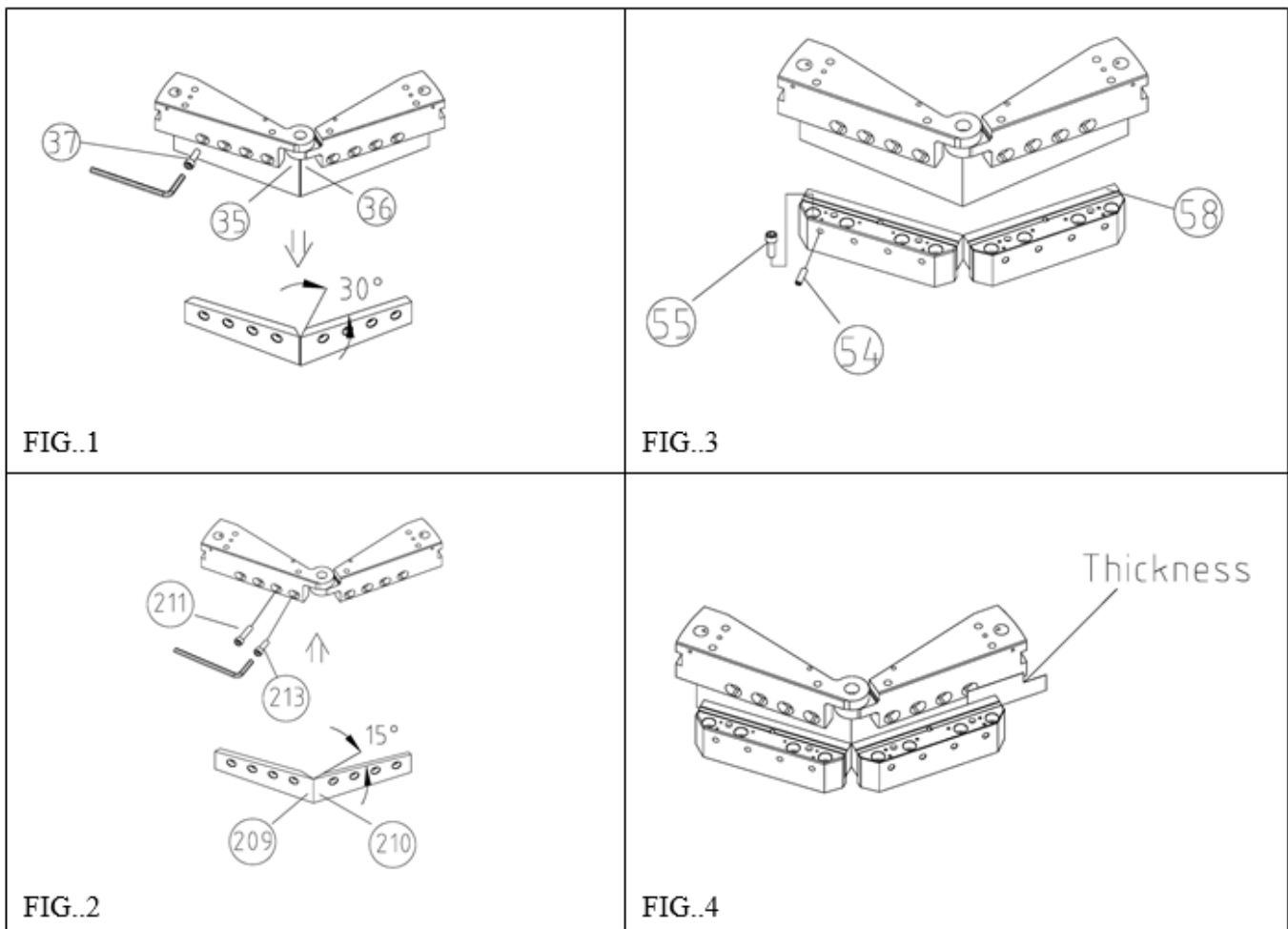




## BLADE KIT REPLACEMENT

To replace the 30° Upper Blade Kit to the 15° Upper Blade Kit follow the below steps:

1. Remove the eyebolt on top of the machine (item 30).
2. Remove the 8 cap screws (item 37) holding on the blade kit using an 8mm hex wrench. Then remove the 30° blade kit. See Figure 2.
3. Place 15° blade kit and replace 2 screws at the end of the blade, M10x20mm & M10x25mm.
  - a. Leave 0.5mm between the right and left blade kit for the cutter adjustment.
4. Loosen the set screw (item 54) & cap screw (item 55) to release the cutter (item 58). See Figure 3.
5. Turn on the machine and lower the table and shut down the machine.
6. Align the cutter with the blade kits and reserve the space for the blades by the thickness gauge. See Figure 4.
7. Adjust the set screw (item 54) and cap screw (item 55) to the top of the table and lock it. Turn on machine and left table.



## CLEANING

Keep the working table clean to avoid material fragments may damage the machine operation or operator.

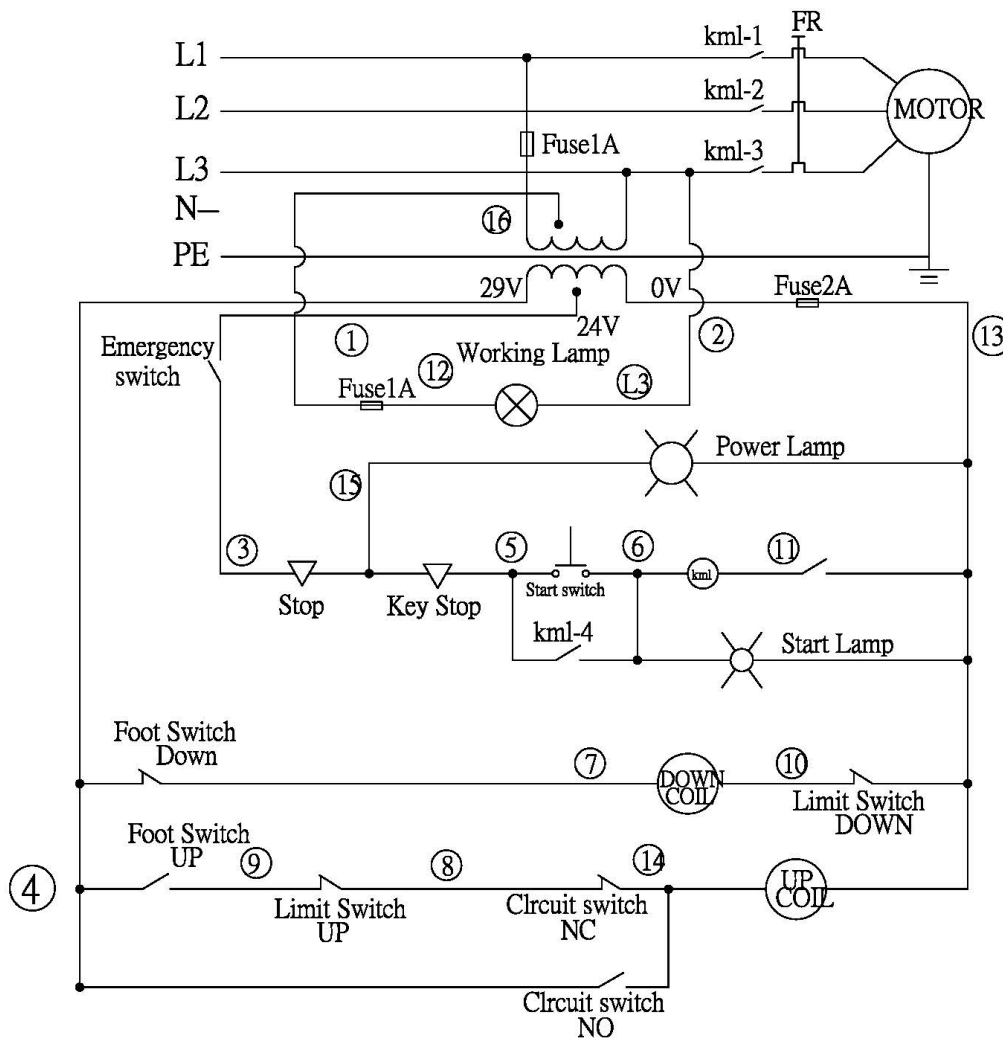
**DO NOT USE A WATER JET TO CLEAN**

## MAINTENANCE

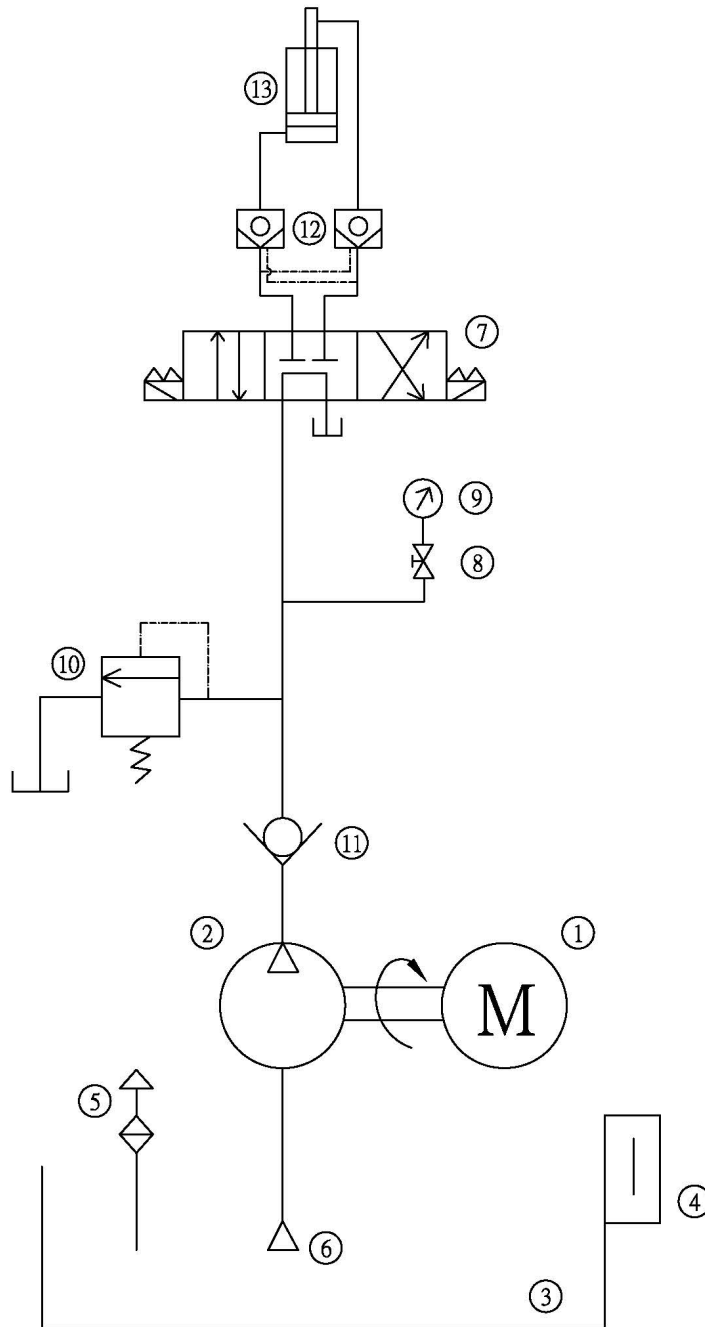
**⚠ Do not perform any maintenance on the machine until the machine has been properly locked out and disconnected from it's power supply**

Hydraulic oil and filter needs replacing after the first 3,000 hours of operation, and then every 5,000 hours after the first replacement.

## WIRING DIAGRAM



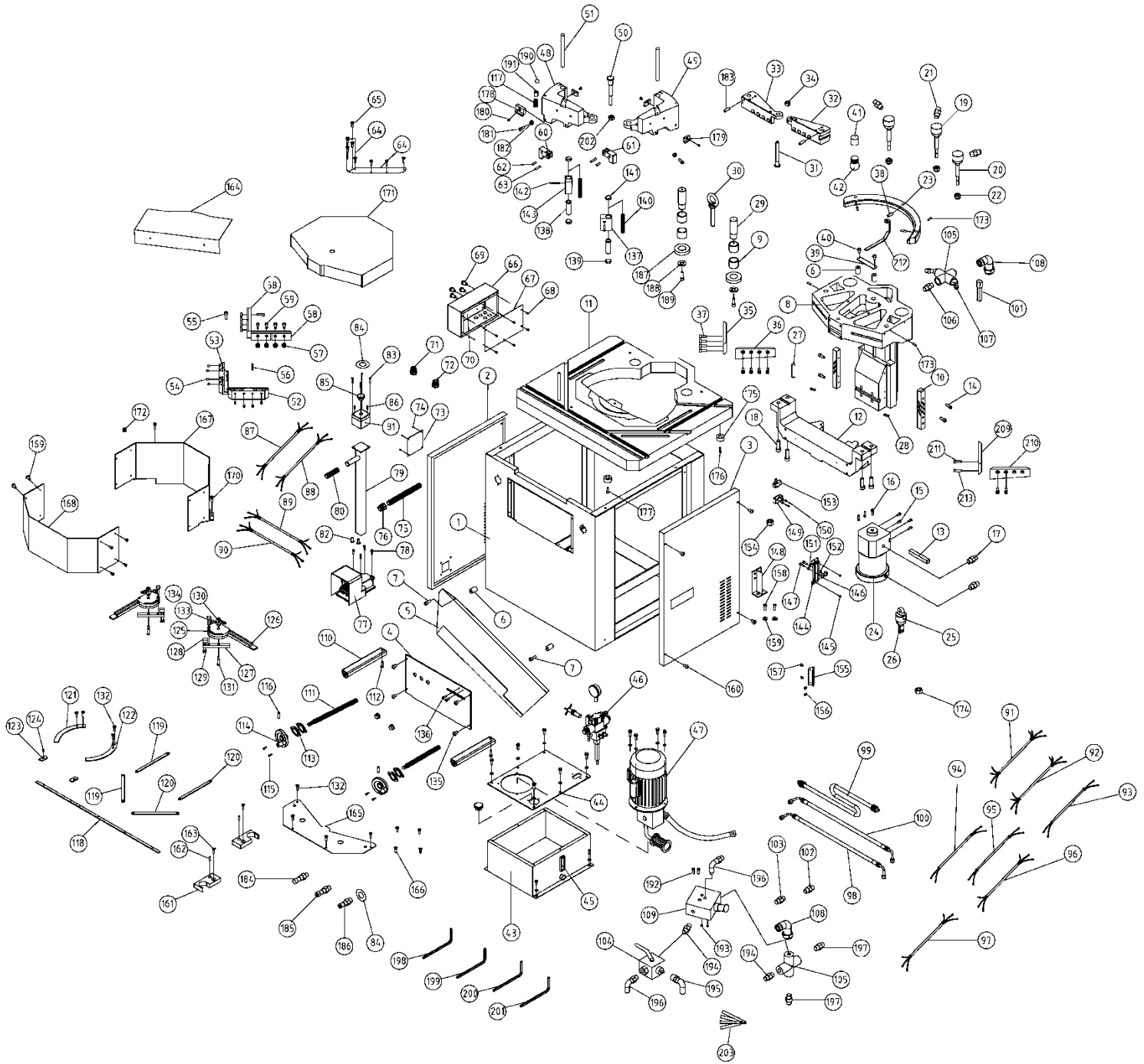
# HYDRAULIC DIAGRAM



REF.	DESCRIPTION
1	4 HP Motor
2	Hydraulic Pump
3	Oil Tank
4	3" Oil Gauge
5	Oil Filling Point
6	1/2" Filter

REF.	DESCRIPTION
7	Solenoid Valve
8	1/4" Pressure Gauge Cut Off
9	250 KGS Oil Gauge
10	Pressure Regulator
11	Check Valve 3/8"
12	Stop Valve
13	Oil Cylinder

# EXPLODED VIEW



## PARTS LIST

<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
1	Base	-	1
2	Right Cover	-	1
3	Left Cover	-	1
4	Control Box Cover	-	1
5	Scrap Discharge Chute	-	1
6	Plastic Pad	-	4
7	Cap Screw (M6x50)	-	2
8	Head Set	-	1
9	Copper Rod (Ø70xØ60)	-	4
10	Packing	-	2
11	Table	-	1
12	Lower Set	-	1
13	Cylinder Key (20x20x150mm)	-	1
14	Cap Screw (M16x35)	-	4
15	Cap Screw (M16x50)	-	4
16	Cap Screw (M16x100)	-	1
17	Oil Bushing (PT3/8"xPT3/8"x90°)	-	2
18	Cap Screw (M16x60)	-	4
19	Single Direction Cylinder	-	3
20	Oil Pressure Rod	-	3
21	Oil Tube Connector (PT1/8"xH1/4")	-	2
22	Lock Nut (M14)	-	3
23	Turning Track	-	1
24	Cylinder	-	1
25	Single Direction Cylinder	-	2
26	Cylinder Fixing Plate	-	2
27	Pin	-	2
28	Key (14x9x60mm)	-	2
29	Main Spindle	-	2
30	Hook (M24)	-	1
31	Blade Setting Rod	-	1
32	Upper Right Blade Kit	-	1
33	Upper Left Blade Kit	-	1
34	Lock Nut (M16)	-	1
35	Left Upper Cutter (30°)	-	1
36	Right Upper Cutter (30°)	-	1
37	Cap Screw (M10x30)	-	8
38	Sets Screw (M8x10)	-	3
39	Bulb Fixing Board	-	1
40	Button Head Screw (M6x10)	-	2
41	Bulb Cap	-	1
42	Bulb	-	1
43	Oil Tank	-	1

<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
44	Oil Tank Cover	-	1
45	Oil Indicator	-	1
46	Electric Distributor	-	1
47	Motor	-	1
48	Right Blade Adjust Set	-	1
49	Left Blade Adjust Set	-	1
50	Blade Setting Rod	-	1
51	Rod	-	2
52	Right Cutter Set	-	1
53	Left Cutter Set	-	1
54	Set Screw (M10x12)	-	8
55	Cap Screw (M10x65)	-	8
56	Key (Ø6 x 20mm)	-	6
57	PU Rod	-	8
58	Cutter	-	2
59	Cap Screw (M10x65)	-	8
60	Right Moving Block	-	1
61	Left Moving Block	-	1
62	Pin (Small)	-	2
63	Pin (Big)	-	2
64	Stainless Cover	-	2
65	Countersunk Phillips Head Screw (M5x8)	-	4
66	Control Box	-	1
67	Control Box Cover	-	1
68	Phillips Head Screw (M4x8)	-	6
69	Button Head Screw (M6x15)	-	4
70	Bottom Board Of Control Box	-	1
71	Connector Of Power Cord	-	4
72	Connector Of Power Cord	-	2
73	Acrylic Board	-	1
74	Rivet	-	4
75	Wire Tube (1/2" x 1050mm)	-	1
76	Bushing (1/2")	-	2
77	Footpad Control Switch	-	1
78	Phillips Head Screw (M5x15)	-	4
79	Emergency Stop Switch Rod	-	1
80	Handle Cap	-	1
81	Emergency Stop Switch Box	-	1
82	Phillips Head Screw (M6x12)	-	2
83	Tapping Screw (M4x42)	-	4
84	Emergency Switch Sticker	-	2
85	Emergency Stop Switch	-	1
86	Phillips Head Screw (M4x8)	-	2
87	Power Cord	-	1
88	Motor Cord	-	1
89	Emergency Switch Cord	-	1

<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
90	Cord Of Footpad Switch	-	1
91	Limit Switch	-	1
92	Limit Switch	-	1
93	Light Cord	-	1
94	Stopping Cord	-	1
95	Solenoid Valve Cord-In	-	1
96	Solenoid Valve Cord-Off	-	1
97	Stopping Cord Of Manual Switch	-	1
98	High Pressure Oil Tube (In) (H3/8"x600)	-	1
99	High Pressure Oil Tube (Out) (H3/8"x1000)	-	1
100	High Pressure Oil Tube (H3/8"x600)	-	1
101	Oil Pipe (H1/8"x1800)	-	1
102	Oil Pipe (H1/8"x700)	-	3
103	Oil Pipe (H1/8"x230)	-	2
104	High Pressure Reduce Bore (1/4")	-	1
105	Cross Joint-(Inner Thread ) (PT1/4")	-	2
106	Bushing (PT1/4"xT1/4")	-	1
107	Bushing (PT1/4"xH1/4"x45°)	-	2
108	Bushing (PT1/4"xH1/4"x90°)	-	2
109	Insert Type-Pressure Reduction Valve	-	1
110	Angle Adjustment Set	-	2
111	Stopping Nut (7/8")	-	2
112	Cap Screw (M12x30)	-	2
113	Bearing Set	-	2
114	Hander Wheel	-	2
115	Button Head Screw (M6x15)	-	4
116	Spring Pin (Ø4 x 30)	-	2
117	Rod Spring	-	2
118	Scale	-	1
119	Left Long Scale	-	2
120	Right Long Scale	-	2
121	Left Round Scale	-	1
122	Right Round Scale	-	1
123	Short Scale	-	2
124	Phillips Head Screw (M4x8)	-	13
125	Positioning Square	-	2
126	Shoulder Strut	-	2
127	Adjust Moving Plate	-	2
128	Adjust Plate	-	2
129	Cap Screw (M5)	-	4
130	Handle	-	2
131	Rotator of Protractor	-	2
132	Flat Head Screw (M4x8)	-	8
133	Pin	-	2
134	Knob (M6x10)	-	2
135	Button Head Screw (M6x30)	-	4



<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
136	Flat Head Screw (M4x10)	-	2
137	Left Pressing Plate	-	1
138	Rod	-	2
139	Round Pad	-	2
140	Spring	-	2
141	Cap	-	2
142	Cap Screw (M8x50)	-	2
143	Right Pressing Plate	-	1
144	Limit Switch Plate	-	1
145	Button Head Screw (M6x10)	-	2
146	Set Block	-	2
147	Flange Bolt (M5x12)	-	4
148	Limit Switch Board	-	1
149	Switch Cover	-	4
150	Phillips Head Screw (M4x30)	-	8
151	Washer (1.5x1/4"x16)	-	2
152	Spring Washer (M5)	-	4
153	Limit Switch	-	4
154	Nut (M4)	-	8
155	Fixing Plate	-	1
156	Button Head Screw (M8x10)	-	2
157	Button Head Screw (M6x10)	-	2
158	Cap Screw (M6x15)	-	2
159	Washer (1.5x1/4"x18)	-	2
160	Button Head Screw (M6x50)	-	8
161	Fixing Block	-	2
162	Fixing Pin (Ø6 x 20)	-	2
163	Countersunk Phillips Head Screw (M4x16)	-	2
164	Chip Leading Board	-	1
165	Angel Plate	-	1
166	Flat Head Screw (M4x8)	-	4
167	Safety Cover	-	1
168	Head Set Acrylic Cover Board	-	1
169	Button Head Screw (M6x10)	-	12
170	Cap Screw (M6x15)	-	2
171	Head Set Cover	-	1
172	Bushing (PG-16)	-	1
173	Set Screw (M6x20)	-	3
174	Nut (M10)	-	2
175	PU Pad	-	4
176	Flat Head Screw (M10x30)	-	2
177	Cap Screw (M10x30)	-	2
178	Right Anti-Chip Plate	-	2
179	Left Anti-chip Plate	-	2
180	Flat Head Screw (M4x8)	-	4
181	Cap Screw (M6x40)	-	2

<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Qty</u>
182	Nut (M6)	-	2
183	Set Screw (M6x20)	-	2
184	Power Light	-	1
185	Start Switch	-	1
186	Key Lock Switch	-	1
187	Main Spindle Packing	-	2
188	Spring Washer (M16)	-	2
189	Cap Screw (M16x40)	-	2
190	Steel Ball (Ø6)	-	2
191	Bearing	-	2
192	Cap Screw (M6x50)	-	2
193	Nut (M6)	-	2
194	Vertical Bushing (PT3/8"xPT1/4")	-	2
195	Bushing (PT1/4"xH3/8"x90°)	-	2
196	Bushing (PT3/8"xH1/4"x90°)	-	2
197	Vertical Bushing (PT1/4"xH1/4")	-	2
198	Allen Wrench (2.5mm)	-	1
199	Allen Wrench (4mm)	-	1
200	Allen Wrench (5mm)	-	1
201	Allen Wrench (8mm)	-	1
202	Lock Nut (M18)	-	1
203	0.05mm-.08mm Thickness Gauge	-	1
209	Left Upper Cutter (15°)	-	1
210	Right Upper Cutter (15°)	-	1
211	Cap Screw (M10x25)	-	2
212	Flipping Plate	-	1
213	Cap Screw (M10x20)	-	2

*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.