



DAKE 3 WHEEL METAL BELT GRINDER

Model BG-60V

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:
 - 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 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.



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 non-standard machinery upon the discretion of Dake. All custom 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: 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. our plant in Grand Haven, Michigan and Grand Prairie, Texas. 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 and shipment, at the discretion of Dake Accounting. For credit card purchases, a 3.5% processing fee may be applicable to the order. The following states are exempt from the 3.5% processing fee: CA, CO, KS, OK, TX, FL, NY, CT, MA, and ME. Dake's preferred method of payment is as follows: ACH Wire and credit card. Checks will be accepted but may cause delay in order processing. Below is our billing address:

1809 Industrial Park Drive, Grand Haven, MI 49417

WARRANTY If, within a period of one (1) year from date of shipment, 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

Model Number	961006
Horsepower	1.5HP
Voltage	110V Single Phase
Amps	10A
Belt Included	60 Grit 1.5" x 60"
Belt Speed	800-8000 FPM
Base	46" x 23"
Height	23"
Weight	75 lbs.

- In the space provided record the serial number and model number of the machine. 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 press be alert to the potential for personal injury.

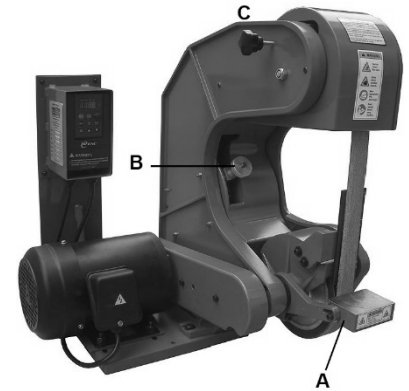
Employer is responsible to perform a hazard/PPE assessment before work activity.

Follow recommended precautions and safe operating practices.

- Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use.
- Only use machine in clean, dry, and safe environment. Make sure there are no flammable or combustible materials near the machine. Sparks cause from metal can cause ignition.
- Always disconnect machine from power supply BEFORE making adjustments, changing tooling, cleaning or servicing machine.
- Only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.
- Always wear approved safety glasses or a face shield when operating or observing machinery.
- Do not wear clothing or jewelry that can be caught in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.
- Dust created by machinery operations may cause cancer, birth defects, eye damage, respiratory issues or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material.
- Always wear hearing protection when operating or observing loud machinery.
- Do not set or leave tools on machine while machine is in use.
- Make sure machine is on stable ground, movement during operation increases risk of injury or machine damage.
- Turn machine off when not in use, never leave machine running unattended.
- Inspect machine before each use for damaged or loose parts.
- The gap between moving grinding belt and table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater the risk of fingers or workpieces getting caught in it. Minimize the risk of pinch and crush injuries by adjusting table/support to no more than 1/16" away from belt.
- Always use a jig when working on small workpieces, always keep fingers at least 2" away from work area.
- Do not wear gloves while grinding.
- Worn or damaged grinding belts can fly apart and throw debris, or aggressively grab workpiece, causing injury from operator loss of workpiece control. Always inspect belt before operation and replace if worn or damaged.
- Only grind against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving belt on the leading side of the workpiece.

SET UP & OPERATION

1. Make sure to place machine on a flat, level surface or workbench.
 - a. If a work bench is used, ensure workbench is reinforced properly to support machine weight and fasten machine to workbench using the 4 mounting holes on the bottom of the machine.



2. Adjust work support (A) so that it is no further than 1/16" to 1/8" from the wheel face.
3. Ensure belt is tensioned correctly, to do this raise the tensioning handle (B). Listen for mechanical "clicks", 3 to 8 clicks sufficiently tensions the belt.
 - a. To reduce or release belt tension, raise the tensioning handle slightly then press the button in the center of the handle, move handle downwards slightly to reduce tension, or move down all the way to release belt tension completely.
4. Connect machine to power supply, machine comes pre-wired to operate at 110V single phase.
5. Start machine by pressing the ON button, the belt should rotate smoothly with the belt traveling downwards.
 - a. If machine belt runs in reverse (upwards) the leads must be reversed in the motor cover. Diagram will be on inside of the motor cover.
6. Check belt tracking, if the belt does not stay in the center of the contact wheel use the tracking adjustment knob (C) on the upper left corner. Turn adjustment knob clockwise to move the belt left, and counterclockwise to move belt right on contact wheel.
7. Use the UP and DOWN arrow keys on the control panel to change belt speed.
8. Using a firm grasp to hold the material, place the material on the work support and slide it in toward the belt allowing the material to remain on the work support. Be aware of any potential for the belt to catch or snag the material and causing and ejection.
9. When job is complete, hit the stop STOP button to stop belt travel.

ELECTRICAL

Machine is shipped pre-wired to operate 110V single phase.

 **Electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.**

Motor can be re-wired to 220V Single Phase, follow motor wiring diagram found on the inside of the motor cover.

4—5—6	4	5	6
7 8 9	7	8	9
1 2 3	1	2	3
110V	220V		

If an extension cord is needed for operation, ensure the cord is in good condition and fits the below requirements. Undersized cords decrease voltage and lead to power loss and overheating. All cords should use a ground wire and plug-in.

Amp Rating	Length		
	25ft	50ft	100ft
1-12	16 AWG	16 AWG	14 AWG
13-16	14 AWG	12 AWG	12 AWG
17-20	12 AWG	12 AWG	10 AWG
21-30	10 AWG	10 AWG	NO

MATERIAL SELECTION



Dust created by machinery operations may cause cancer, birth defects, eye damage, respiratory issues or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material.

- Materials must be clean and dry (no oil).
- Material dimension must not exceed the capacity of the machine.

CHOOSING A BELT

Machine uses 1.5" x 60" belt.

Belt Material	Operation
Aluminum Oxide	Finishing, Ferrous metals
Zirconia Alumina	Finishing, Ferrous metals, some steels
Ceramic	Aggressing grinding, deburring. Heat sensitive metals
Silicon Carbide	Cutting, stock removal. Cast iron, steel, non-ferrous metals.

IDLER WHEEL ALIGNMENT



When making machine adjustments make sure machine is not connected to power supply.

If idler wheels are removed or replaced, they must be re-installed with proper alignment. Failure to properly align the wheels will lead to premature failure of the wheels. Premature failure may appear as at least one of the following:

- Outer diameters being excessively worn such that the wheels lose their factory crown,
 - Wear to a truncated form, or
 - Become out of balance.
1. After disconnecting machine from power, install rear idle wheel so that the inside bearing surface is approximately 0.06" from the wheel support. Secure wheel with locking set screw.
 2. Install front idle wheel so that the inside bearing surface is approximately 0.06" from it's bearing support. Secure wheel with locking set screw. Replace in pairs.
 3. Loosen retaining nut that locks the upper wheel adjusting screw. Using screw adjust the upper wheel until the center is in line with the center of the contact wheel.

4. Repeat step 3 to adjust rear idler wheel in line with the upper idler wheel and contact wheel. Tighten locking nuts.
5. Install new belt. Roll the belt manually to observe how it tracks. If belt does not track properly repeat steps 3 & 4 until belt tracks properly.
6. Reconnect machine to power and turn on to observe belt tracking. Turn the machine off immediately if you see the belt start to track off the wheels. The belt may track slightly to one side or the other.
7. Adjust tracking control to move belt either way on face of contact wheel to finish adjusting belt tracking.

MAINTENANCE



When making machine adjustments/repairs make sure machine is not connected to power supply.

Before each use:

- Loose nuts and bolts
- Worn or damaged belt
- Worn or damaged wires
- Blow out metallic filings from wheels
- Empty spark tray (as needed)
- Safety guards are in place and operational
- Any safety concern or damaged part

Weekly Maintenance:

- Lubricate threaded components and sliding devices
- Clean and inspect sliding surface underneath the top side of the belt
- Apply rust inhibitive lubricant on all non-pointed surfaces
- Inspect edges of the rubber contact wheel. Replace wheel if edges become rounded

Monthly Maintenance:

- Apply 2 drops of light machine oil to the rear wheel support to rear wheel handle interface.
- Check v-belt tension. If you can hear the belt hitting the belt guard when the motor starts, v-belt requires re-tensioning. Remove the 4 bolts that secure the motor to machine base and slide motor towards rear of the machine, tighten 4 bolts back down.

LUBRICATION

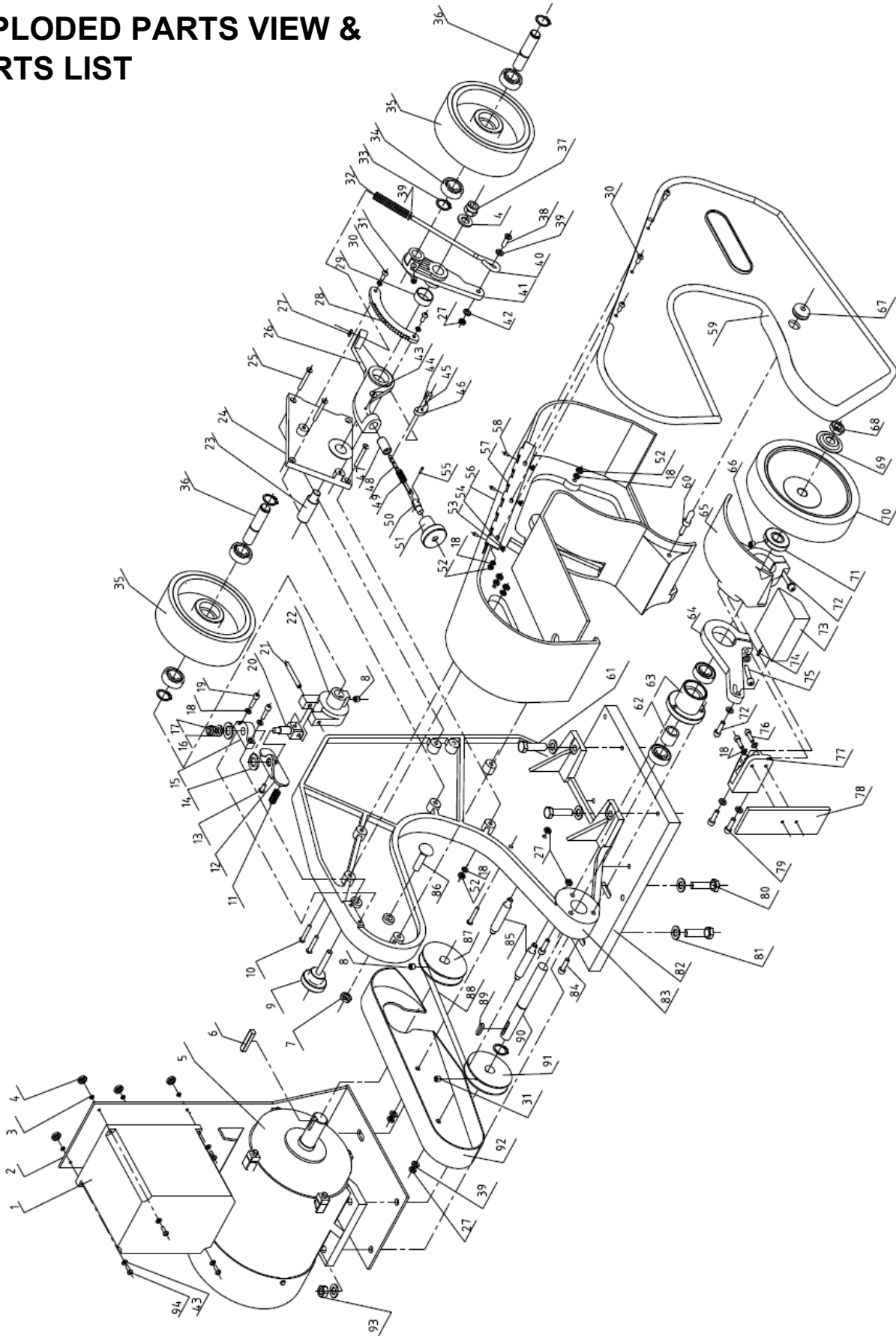
- Bearings are permanently sealed and lubricated.
- Once a month apply 2 drops of an ISO 32 oil. Release and apply belt tension to distribute oil.

TROUBLESHOOTING

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. E-Stop depressed/at fault 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Wiring broken, disconnected or corroded. 	<ol style="list-style-type: none"> 1. Remove E-Stop over to reset. Replace if at fault. 2. Ensure correct power supply voltage and circuit. 3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 4. Fix broken wires or disconnected/corroded.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Excessive feed pressure applied 2. Wrong workpiece material (metal) 3. Machine undersized for task 4. Motor overheated 5. Extension cord too long 6. Motor at fault 	<ol style="list-style-type: none"> 1. Clean belt and reduce workpiece pressure 2. Use correct size/type of metal 3. Clean/replace belt, reduce feed rate/grinding depth 4. Clean motor, let cool, and reduce workload. 5. Move machine closer to power supply, use shorter extension cord. 6. Replace motor
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Belt not tracking correctly 2. Motor or component loose 3. Motor mount loose/broken 4. Idler wheels out of alignment 	<ol style="list-style-type: none"> 1. Ensure belt is tracking correctly 2. Replace damaged or missing bolts/nuts or tighten if loose 3. Tighten/replace 4. Adjust idler wheel alignment
Machine vibrates excessively (non-motor related).	<ol style="list-style-type: none"> 1. Incorrect grinding belt tension 2. Broken/defective belt 3. Drive wheel cap screw missing or loose 	<ol style="list-style-type: none"> 1. Make sure tension is locked in tensioning position 2. Replace belt 3. Replace or tighten screw
Grinding belt slaps or vibrates excessively.	<ol style="list-style-type: none"> 1. Incorrect grinding belt tension 2. Belt tracking not set correctly 3. Broken/defective belt 4. Idler or drive wheel loose 	<ol style="list-style-type: none"> 1. Make sure tension is locked in tensioning position 2. Ensure grinding belt is set correctly 3. Replace belt 4. Tighten idler or drive wheel
Grains easily rub off belt.	<ol style="list-style-type: none"> 1. Belt has been stored in damp environment 2. Belt has been smashed or folded 3. Belt is too old 	<ol style="list-style-type: none"> 1. Replace belt, store replacements in cool, dry area. 2. Replace belt, do not bend or fold belt 3. Replace with new belt
Grinding belt slips during use.	<ol style="list-style-type: none"> 1. Incorrect grinding belt tension 2. Excessive feed pressure 	<ol style="list-style-type: none"> 1. Make sure tension lever is locked in tensioning position 2. Clean belt then reduce workpiece pressure
Grinding belt will not track properly.	<ol style="list-style-type: none"> 1. Incorrect grinding belt tension 2. Belt is stretched unevenly 3. Contact wheel is worn 	<ol style="list-style-type: none"> 1. Make sure tension lever is locked in tensioning position 2. Replace belt 3. Replace contact wheel
Belt tracks to one side under load.	<ol style="list-style-type: none"> 1. Belt tracking is not set correctly 	<ol style="list-style-type: none"> 1. Make sure belt is tracking properly
Deep grinding grooves or	<ol style="list-style-type: none"> 1. Excessive feed pressure applied 	<ol style="list-style-type: none"> 1. Clean belt and reduce workpiece pressure

Symptom	Possible Cause	Possible Solution
scratches in workpiece.	<ol style="list-style-type: none"> 2. Workpiece held in same spot on belt for too long 3. Grinding belt too coarse 4. Contact wheel damaged 	<ol style="list-style-type: none"> 2. Keep workpiece moving when grinding 3. Use a finer belt grit 4. Replace contact wheel
Snake-shaped marks on workpiece.	<ol style="list-style-type: none"> 1. Belt loaded up with material 2. Belt is damaged 	<ol style="list-style-type: none"> 1. Clean belt 2. Replace belt
Belt clogs quickly.	<ol style="list-style-type: none"> 1. Excessive feed pressure applied 2. Belt is worn or damaged 3. Workpiece material softer metal more prone to belt-clogging 	<ol style="list-style-type: none"> 1. Clean belt and reduce workpiece pressure 2. Replace belt 3. Reduce feed pressure or use coarser belt
Excessive grinding belt replacement.	<ol style="list-style-type: none"> 1. Not using full width of grinding surface 2. Excessive feed pressure 	<ol style="list-style-type: none"> 1. Move workpiece back and forth grinding surface when grinding 2. Clean belt and reduce workpiece pressure
Workpiece frequently gets pulled out of hand when grinding.	<ol style="list-style-type: none"> 1. Not properly supporting your workpiece against the work rest 2. Leading edge or sharps grab onto grinding belt 	<ol style="list-style-type: none"> 1. Use work rest to support workpiece 2. Change angle or orientation of workpiece so that piece is not digging into incoming direction of the belt

EXPLODED PARTS VIEW & PARTS LIST



Item	Description	Part No	Qty
1	Variable Frequency Drive		1
2	Work Support for Variable Speed Drive		1
3	Washer, Lock (M4)		4
4	Nut, Hex Thin (M4-0.7)		4
5	Motor		1
6	Key		1
7	Nut, Hex Thin (M10-1.5)		1
8	Screw, Soc Set, (Cup Pt. M8-1.25x10mm)		1
9	Knob, Star (M8-1.25x35mm)		1
10	Screw, Soc Head Button (M5-0.8x35mm)		5
11	Compression Spring		1
12	Bracket, Pivot Block		1
13	Screw, Soc Head Button (M5-0.8x12mm)		6
14	Washer, Flat (M12)		3
15	Pivot Block		1
16	Washer, Flat (M8)		1
17	Screw, Soc Set (M8-1.25x?)		1
18	Washer (M5)		18
19	Screw, Soc Cap (M5-0.8x20mm)	78740	2
20	Pivot Block Mount		1
21	Spring Pin (Ø6x50mm)		1
22	Tracking Body		1
23	Fixed Shaft		1
24	Base Plate		1
25	Screw, Slotted C'Sink Head (M5-0.8x40mm)		4
26	Tension Arm		1
27	Nut, Hex Thin (M6-1.0)		5
28	Rachet		1
29	Copper Bushing		1
30	Screw, Hex Button Hd. (M5-0.8x12mm)		6
31	Screw, Soc. Set (Cup Pt. M8-1.25x8mm)		2
32	Compression Spring		1
33	Retaining Ring (Shaft Ø15mm)		5
34	Bearing (6202-2Z)		6
35	Idler Wheel		2
36	Shaft		2
37	Nut, Hex Thin (M12-1.75)		1
38	Screw, Cross head (M6-1.0x20mm)		1
39	Washer (#6)		11
40	Eyebolt		1
41	Rear Wheel Support		1
42	Washer, Lock (6mm)		1
43	Washer, Flat (4mm)		5
44	Rivet, Semi Tubular (Ø4x15mm)		1
45	Screw, Flat Head (Ø5x12mm)		1

46	Pawl		1
47	Pipe Nipple		1
48	Strip		1
49	Compression Spring		1
50	Button		1
51	Knob		1
52	Nut, Hex Thin (M5-0.8)		12
53	Washer, Lock (#3)		3
54	Nut, Hex Thin (M3-0.5)		3
55	Spring Pin (Ø2.5x10mm)		1
56	Safety Guard		1
57	Hinge		1
58	Screw, Soc. Cap (M3-0.5x8mm)		3
59	Door		1
60	Pin		1
61	Screw, Soc. Cap (M10-1.5x30mm)		4
62	Bushing		1
63	Contact Wheel Bearing Assembly		1
64	Work Support for Arm		1
65	Guard for Contact Wheel		1
66	Screw, Soc. Set (Cup Pt. M5-0.8x10mm)		1
67	Robber Grommet		1
68	Nut, Hex Thin (M14-2.0)		1
69	Washer for Spring Flange		1
70	Contact Wheel		1
71	Bushing		1
72	Screw, Soc. Cap (M6-1.0x25mm)		2
73	Work Rest		1
74	Spring Pin (Ø3x10mm)		1
75	Screw, Soc. Cap (M6-1.0x30mm)		1
76	Screw, Soc. Cap (M5-0.8x16mm)		2
77	Bracket for Platen		1
78	Platen		1
79	Screw, Soc. Cap (M6-1.0x20mm)		1
80	Bolt, Hex Head (M10-1.5x40mm)		1
81	Washer, Flat (#10)		12
82	Base		1
83	Main Frame		1
84	Screw, Flat Hd. (M6-1.0x40mm)		3
85	Standoff for Guard		2
86	Bolt, Cup Hd. Squ. Neck (M10-1.5x35mm)		1
87	Pulley		1
88	V-Belt		1
89	Key (5x5x20mm)		1
90	Shaft		1
91	Pulley		1



92	Guard for V-belt		1
93	Nut, Hex (M10-1.5)	302794	4
94	Screw, Cross Head (M4-0.7x12mm)		4

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.