



## DAKE STANDING METAL BELT SANDER

# Model SG-75

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](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 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](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.

### 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

<b>Model Number</b>	961005
<b>Horsepower</b>	1.5HP
<b>Voltage</b>	220V Single Phase
<b>Amps</b>	3.9A
<b>Belt Included</b>	80 Grit 3" x 79"
<b>Belt Speed</b>	5018 FPM
<b>Base</b>	16" x 13"
<b>Height</b>	42"
<b>Weight</b>	117 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.

<b>Serial No.</b>	
<b>Model No.</b>	
<b>Install Date:</b>	

## 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, raspatory 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.



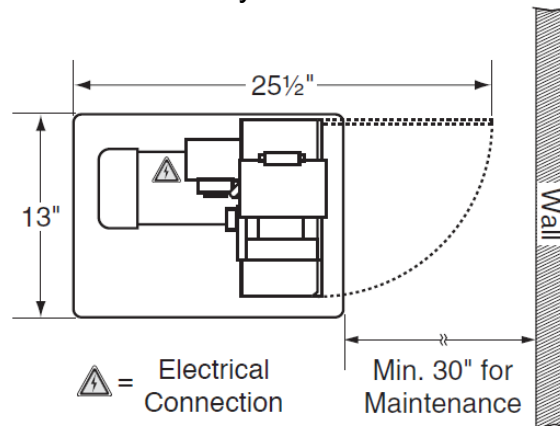
## SET UP

When unpacking machine inspect all parts for shipping damage.

A	Metal Belt Grinder	1
B	Belt Access Door Key (not shown)	1
C	Spark Tray (inside machine)	1

## PLACEMENT

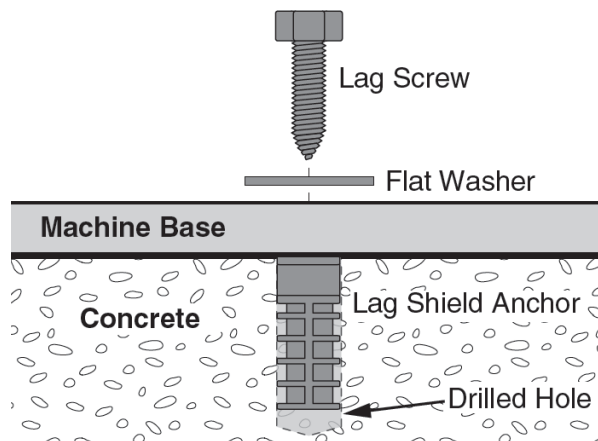
Below is the minimum area needed for machine. Plan enough space for workpieces and any material stands that may be used in the future.



## ANCHORING

**Make sure machine is compliant with local laws and legislation for anchoring machinery.**

- Anchoring machine to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs quieter and feels more solid.
- If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.
- If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.



## ELECTRICAL



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

Machine is prewired to operate on the following power supply requirements

Nominal Voltage	208V, 220V, 230V, 240V
Cycle	60 Hz.
Phase	3-Phase
Power Supply Circuit	15 Amps
Cord	"S"-Type, 4-Wire, 15 AWG, 300 VAC
Plug/Receptacle	NEMA 15-15 (not included)

Full-Load Current Rating at 220V: 3.9 Amps

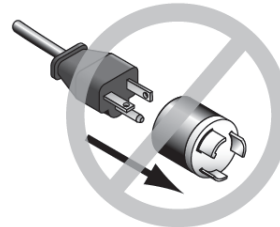
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result— especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult electrician or qualified service personnel to ensure circuit is properly sized for safe operation.

## GROUNDING

**Machine must be grounded!**

**No adapter should be used with machine plug!**



The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

## EXTENSION CORD

**The use of an extension cord with this machine is not recommended!**

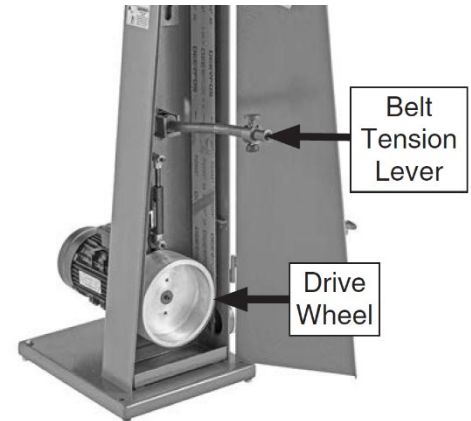
**Only use an extension cord if necessary and only on a temporary basis.**

If extension cord must be used temporarily make sure cord is in good condition, matches plug configuration, and meets the following requirements:

<b>Minimum Gauge Size</b>	<b>14 AWG.</b>
<b>Maximum Length</b>	<b>50 feet</b>

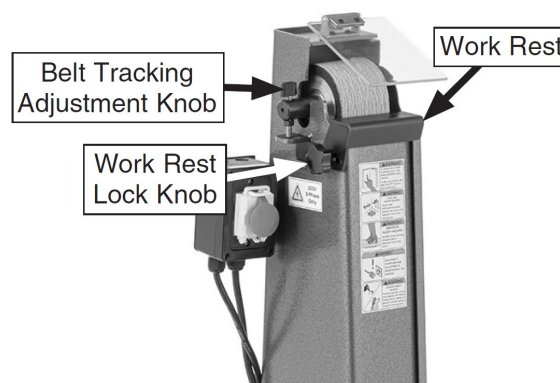
## INSTALLING/CHANGING BELT

1. Make sure machine is not connected to power source.
2. Use key to unlock and open belt access door.
3. Turn belt tension lock knob counterclockwise to loosen lock collar and release belt tension lever.
4. Move belt lever down and toward drive motor and release belt tension.
5. Remove old belt (in installed) and replace with new belt. Be sure the new belts arrow matches the direction of rotation of the machine.
6. Move belt tension lever up and away from drive wheel to raise motor and tension the belt.
7. Check and adjust belt tracking after installing new belt. See "FISRT RUN" section of this manual.



## CHECKING/ADJUSTING BELT TRACKING

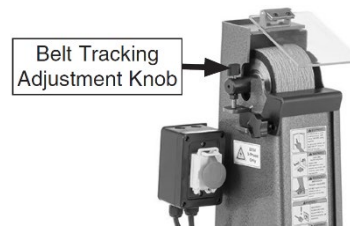
1. Make sure machine is not connected to power source.
2. Use key to unlock and open belt access door.
3. Standing in front of machine rotate either wheel by hand so the belt moves in the direction of rotation of the machine (counterclockwise on wheels and towards work rest)
  - a. If belt moves left on wheels (towards motor): Rotate belt adjustment knob counterclockwise 1/4 turn.
  - b. If belt moves right on wheels (away from motor): Rotate belt adjustment knob clockwise 1/4 turn.
4. Repeat step 3 until belt tracks in center of wheels, once done close access door.
5. Connect machine to power and verify belt is tracking correctly, fine-tune tracking as necessary while machine is running.
6. Once tracking is fine-tuned turn the machine OFF and loosen the work rest lock knob to adjust to work rest so that there is no more than a 1/16" between the rest and the belt. Tighten down lock knob to secure.



## FIRST TIME OPERATION

*In the first run, there are 3 things to look for:*

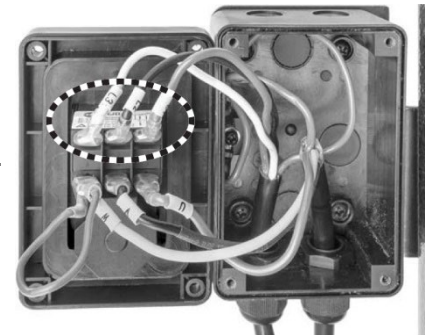
- Belt tracks properly and will not come off wheel.
  - Motor runs correctly.
  - E-Stop disables machine properly.
1. After connecting machine to power, jog the machine on but hitting the ON button followed by immediately hitting the OFF button.
  2. While the belt moves look to see if it is tracking correctly. Belt should remain centered on wheel as it rotates.
    - a. If belt tracks too far right or left belt edges will get destroyed.
    - b. Adjust tracking using the knob to the left of the work area.
    - c. Belt should rotate in same direction as arrow on machine. If this is incorrect refer to "CORRECTING PHASE POLARITY" section of this manual.
  3. Ensure motor runs smoothly then activate the E-Stop to ensure E-Stop is working properly.
    - a. When E-Stop is activated the cover will shut, if the cover does not close when the E-Stop is activated E-Stop is not working properly. Disconnect from power and troubleshoot.



## CORRECTING PHASE POLARITY

If you discover during the test run that the machine will not operate, or that the motor runs backwards, the plug may be wired "out of phase," meaning the polarity is incorrectly wired.

1. Disconnect machine from power source.
2. Remove cross head screws to open ON/OFF switch cover.
3. Swap any 2 leads of the 3 incoming power wires (L1, L2 L3)
4. Close ON/OFF switch cover and replace screws removed in step 2.
5. Reconnect machine to power.
6. Test machine



## DUST COLLECTION

To fit a dust collection system to the machine:

Fit 3" ducting over the dust port and secure with clamp. Make sure connection is secure.

## OPERATION

1. Turn machine on.
2. Position work piece on center of work rest. Always use 2 hands and the work rest to support your work.
3. Using both hands slowly feed it into contact wheel with light consistent pressure. DO NOT force the work against the belt/wheel.
  - a. There is workpiece clearance on both sides of the contact wheel to grind the sides of your work piece.

## CHOOSING A BELT

Machine uses 3" x 79" belt.

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

## MAINTENANCE

Before each use:

- Loose mounting bolts
- Worn or damaged belt
- Worn or damaged wires
- Any safety concern or damaged part

Weekly Maintenance:

- Remove dust and shavings from outside of machine.
- Remove dust or shavings from inside belt compartment, spark tray and from motor.

Monthly Maintenance:

- Lubricate belt tension pin. See TROUBLESHOOTING" section of this manual.

## LUBRICATION

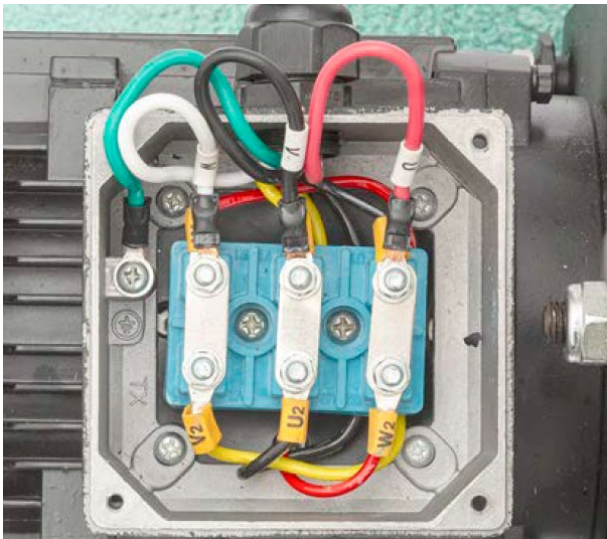
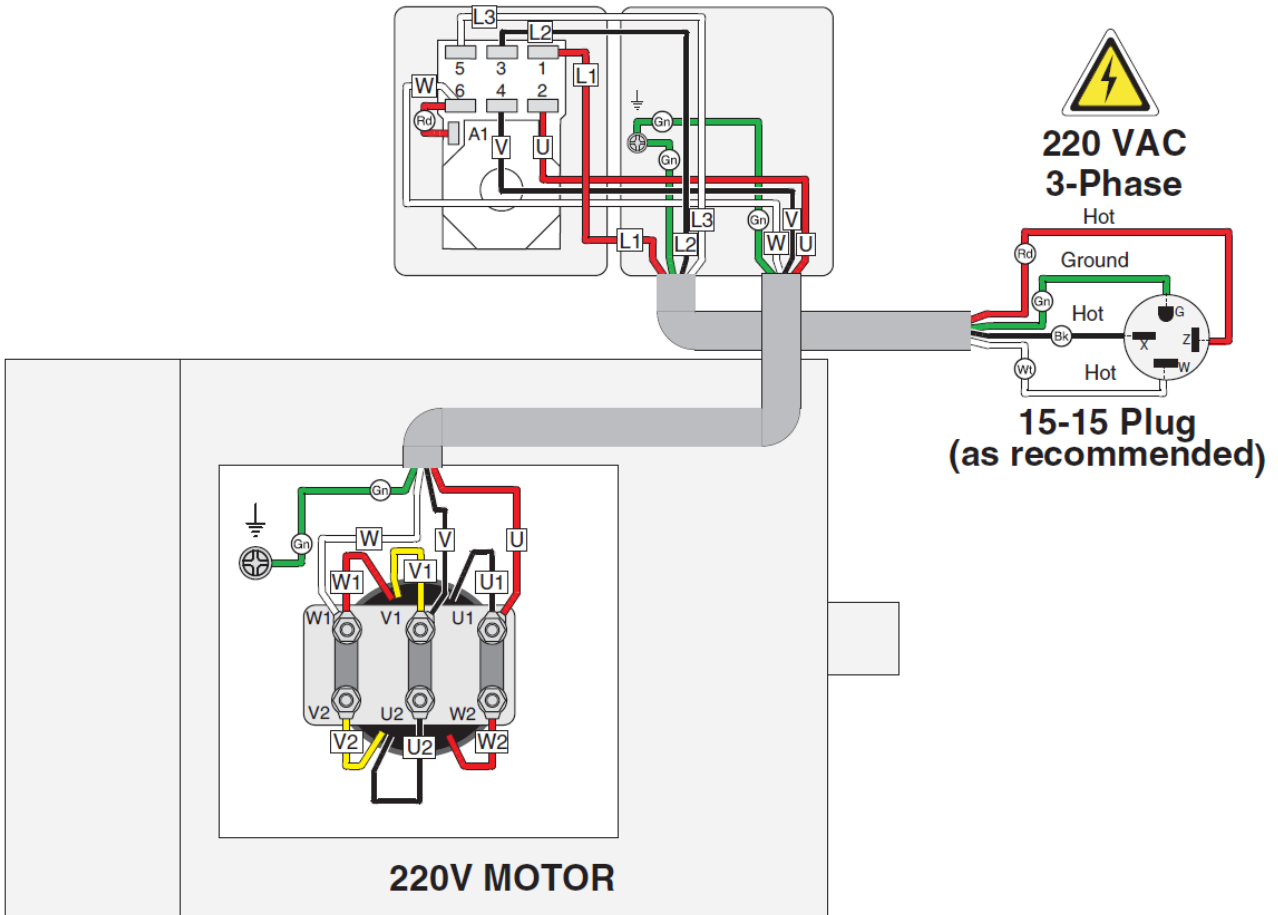
- Bearings are permanently sealed and lubricated.
- Once a month apply 2 drops of an ISO 32 oil. Release and apply belt tension to distribute oil.

## TROUBLESHOOTING

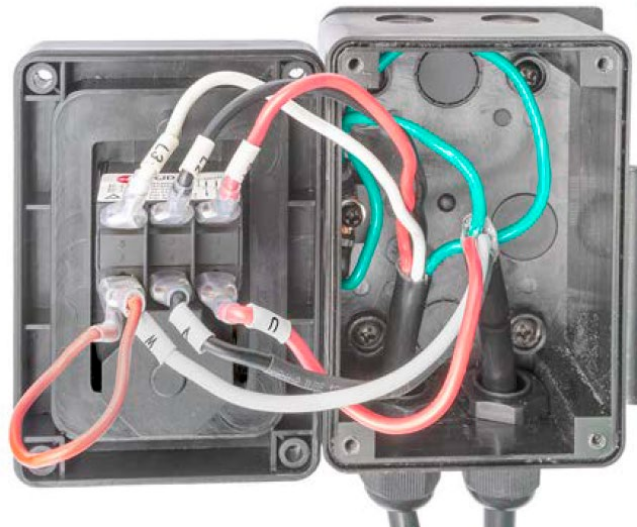
Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> <li>1. E-Stop cover depressed/at fault</li> <li>2. Incorrect power supply voltage or circuit size.</li> <li>3. Plug/receptacle at fault/wired incorrectly</li> <li>4. Power supply circuit breaker tripped or fuse blown.</li> <li>5. Motor wires connected incorrectly</li> <li>6. Wiring broken, disconnected or corroded.</li> <li>7. ON/OFF switch at fault</li> <li>8. Motor or motor bearings at fault</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove E-Stop over to reset. Replace if at fault.</li> <li>2. Ensure correct power supply voltage and circuit.</li> <li>3. Test for good contacts/correct wiring.</li> <li>4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.</li> <li>5. Correct motor wiring connections</li> <li>6. Fix broken wires or disconnected/corroded.</li> <li>7. Replace switch</li> <li>8. Replace motor</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Excessive feed pressure applied</li> <li>2. Wrong workpiece material (metal)</li> <li>3. Motor wires connected incorrectly</li> <li>4. Plug/receptacle at fault/wired incorrectly</li> <li>5. Machine undersized for task</li> <li>6. Motor overheated</li> <li>7. Extension cord too long</li> <li>8. Motor or motor bearings at fault</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean belt and reduce workpiece pressure</li> <li>2. Use correct size/type of metal</li> <li>3. Correct motor wiring connections</li> <li>4. Test for good contacts/correct wiring.</li> <li>5. Clean/replace belt, reduce feed rate/grinding depth</li> <li>6. Clean motor, let cool, and reduce workload.</li> <li>7. Move machine closer to power supply, use shorter extension cord.</li> <li>8. Replace motor</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Belt not tracking correctly</li> <li>2. Motor or component loose</li> <li>3. Motor mount loose/broken</li> <li>4. Motor fan rubbing on fan cover</li> <li>5. Motor bearings at fault</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure belt is tracking correctly</li> <li>2. Replace damaged or missing bolts/nuts or tighten if loose</li> <li>3. Tighten/replace</li> <li>4. Fix/replace fan cover, replace loose/damaged fan</li> <li>5. Test by rotating shaft, rotational grinding/loose shaft requires bearing replacement</li> </ol>
Machine vibrates excessively (non-motor related).	<ol style="list-style-type: none"> <li>1. Incorrect grinding belt tension</li> <li>2. Broken/defective belt</li> <li>3. Drive wheel cap screw missing or loose</li> </ol>	<ol style="list-style-type: none"> <li>1. Make sure tension is locked in tensioning position</li> <li>2. Replace belt</li> <li>3. Replace or tighten screw</li> </ol>
Grinding belt slaps or vibrates excessively.	<ol style="list-style-type: none"> <li>1. Incorrect grinding belt tension</li> <li>2. Belt tracking not set correctly</li> <li>3. Broken/defective belt</li> <li>4. Contact or drive wheel loose</li> </ol>	<ol style="list-style-type: none"> <li>1. Make sure tension is locked in tensioning position</li> <li>2. Ensure grinding belt is set correctly</li> <li>3. Replace belt</li> <li>4. Tighten contact or drive wheel</li> </ol>
Grains easily rub off belt.	<ol style="list-style-type: none"> <li>1. Belt has been stored in damp environment</li> <li>2. Belt has been smashed or folded</li> <li>3. Belt is too old</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace belt, store replacements in cool, dry area.</li> <li>2. Replace belt, do not bend or fold belt</li> <li>3. Replace with new belt</li> </ol>

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

## ELECTRICAL DIAGRAM



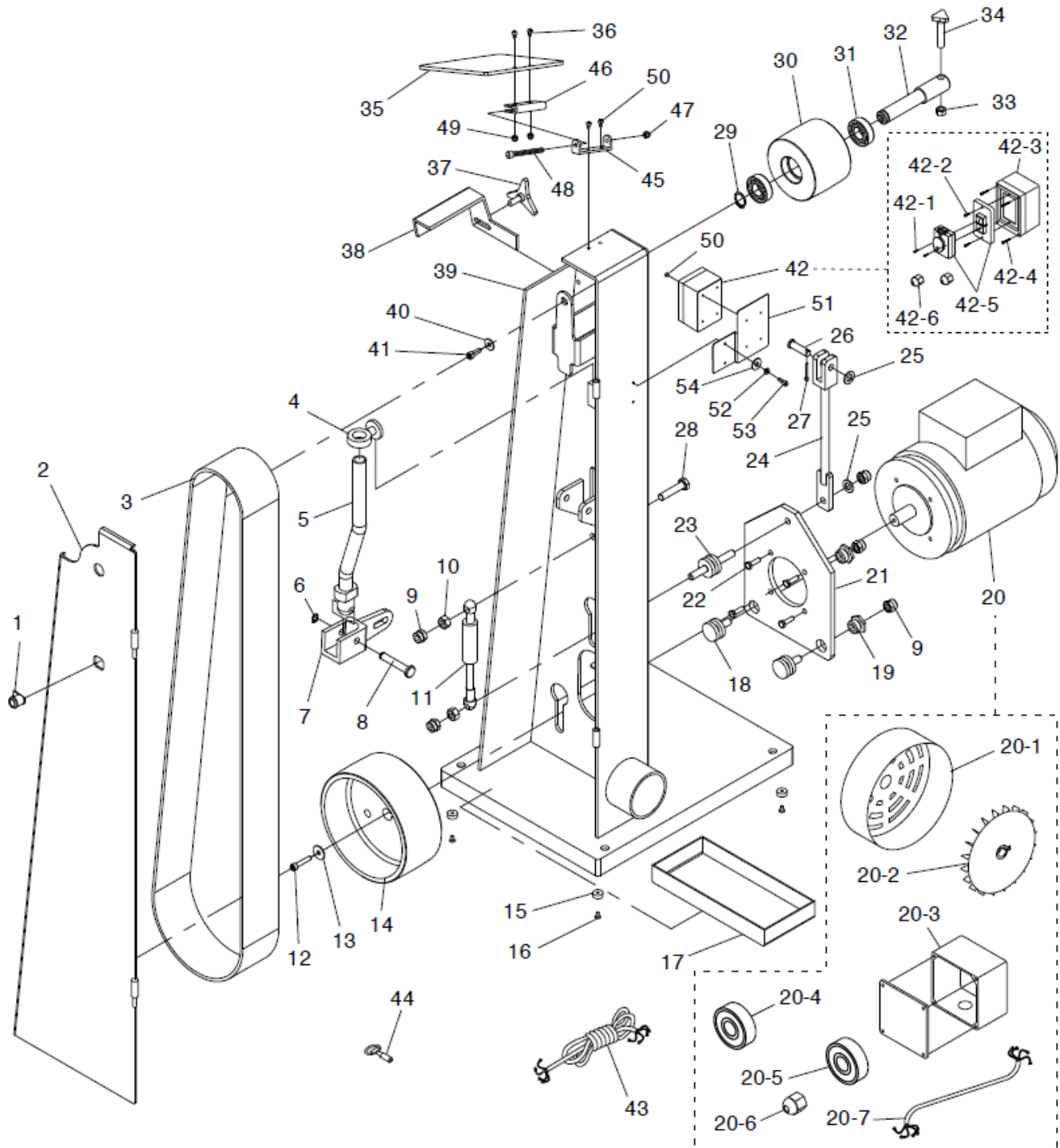
Motor junction box



Push button magnetic switch



## EXPLODED PARTS VIEW



## PARTS LIST

Item	Description	Part No
1	Door Lock	
2	Door	
3	Belt 3" x 79" 80 Grit (Included)	
3	Belt 3" x 79" 60 Grit	77021
4	Tension Lock Collar	
5	Belt Tension Lever	
6	Retaining Ring (10mm)	
7	Tension Bracket	
8	Swivel Pin	
9	Lock Nut (M10-1.5)	302585
10	Hex Nut (M10-1.5)	302794
11	Gas Spring w/ Eyelet Fitting	
12	Screw, Soc Cap (M6-1.0x30mm)	
13	Flat Washer (8.5x30x1.7mm)	
14	Drive Wheel	
15	Foot	
16	Screw, Flat Head (M4-0.7x8mm)	
17	Spark Tray	
18	Guide Bolt (M10-1.5x27mm)	
19	Hex Standoff (Male/Female M20-1.5x5mm, M10-1.5)	
20	Motor 1-1/2HP 220V 3-Phase	
20-1	Motor Fan Cover	
20-2	Motor Fan	
20-3	Motor Junction Box	
20-4	Ball Bearing – Front 204ZZ	
20-5	Ball Bearing – Rear 204ZZ	
20-6	Strain Relief Type-3 (M18-1.5)	
20-7	Motor Cord (15G, 4W, 47")	
21	Motor Mounting Plate	
22	Hex Bolt (M6-1.0x20mm)	
23	Guide Bolt (Male/Male M10-1.5x30mm, M10-1.5x39mm)	
24	Pull Rod	
25	Washer, Flat (10mm)	
26	Pivot Pin (10x35mm)	
27	-	-

Item	Description	Part No
28	Hex Bolt (M10-1.5x55mm)	
29	Retaining Ring (20mm)	
30	Idler Wheel	
31	Ball Bearing 6004ZZ	
32	Idler Wheel Axle	
33	Hex Nut (M8-1.25)	
34	Knob Bolt (M8-1.25x50mm)	
35	Eye Shield	
36	Screw, Hex M4-0.7x12mm	
37	Knob Bolt (M8-1.25x25mm)	
38	Work Rest	
39	Body	
40	Fender Washer (6mm)	
41	Screw, Soc Cap (M6-1x16mm)	64179
42	Magnetic Switch Assembly	
42-1	Tap Screw (M2.2x6.5)	
42-2	Tap Screw (M4.2x9.5)	
42-3	Switch Box	
42-4	Tap Screw (M4.2x19)	
42-5	Magnet Switch w/ E-Stop Cover	
42-6	Strain Relief (Type-3 M18-1.5)	
43	Power Cord (15G, 4W, 98")	
44	Belt Access Door	
45	Eye Shield Mounting Bracket	
46	Eye Shield Hinge Bracket	
47	Lock Nut (M5-0.8)	
48	Screw, Soc Cap (M5-0.8x8mm)	
49	Hex Nut (M4x0.7)	64184
50	Screw, Hex Head (M5-0.8x60mm)	
51	Magnet Switch Mounting Bracket	
52	Lock Washer (5mm)	
53	Screw, Soc Cap (M4-0.8 x12mm)	81701
54	Flat Washer (5mm)	

## 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.