



VERTICAL BAND SAWS

# INSTRUCTION MANUAL AND PARTS LIST MODEL SXC

## DAKE/PARMA

### WHEN ORDERING PARTS

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

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

MODEL: \_\_\_\_\_

SERIAL NUMBER: \_\_\_\_\_

DATE PURCHASED: \_\_\_\_\_



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## **SPECIFICATIONS**

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

## **FEATURES**

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

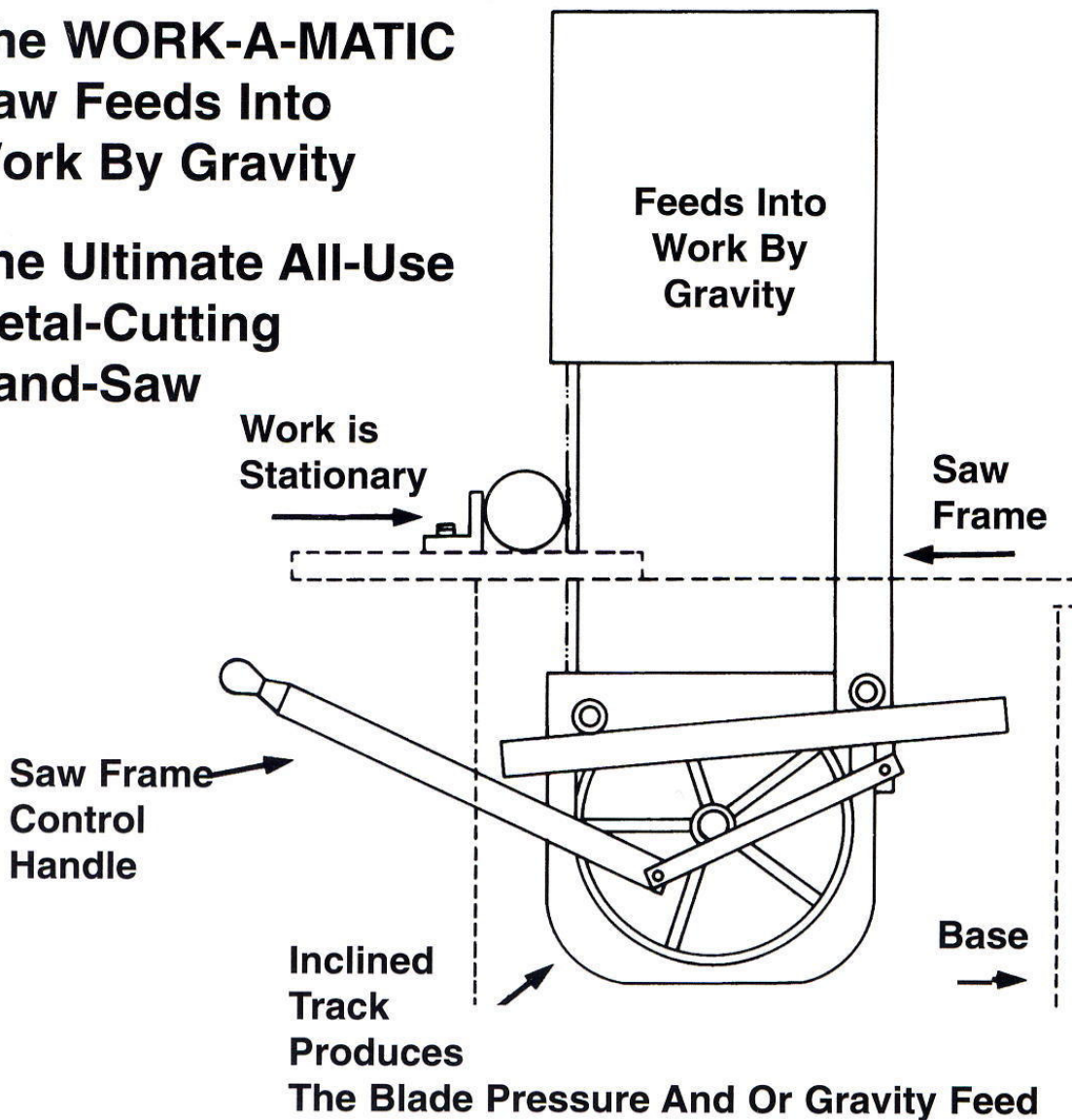
## **ACCESSORIES**

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

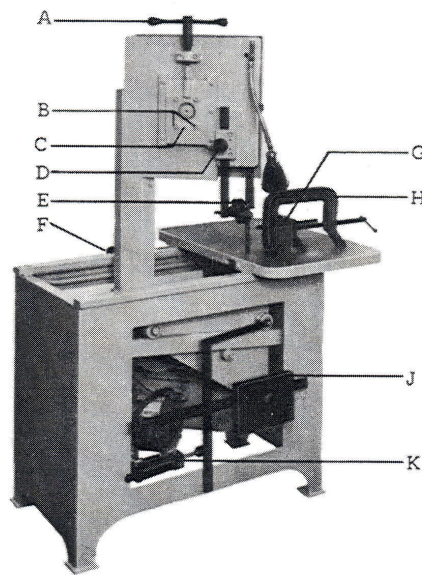
## HOW THE DAKE PARMA SXC OPERATES

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

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



## SXC ADJUSTMENT



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

## **BLADE SELECTION**

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

### **Standard Tooth Applications**

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

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

### **Blade Speed (Feet per minute)**

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

### **Blade Removal and Installation**

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

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

**IMPORTANT: Blade must be tight to insure straight cut.**

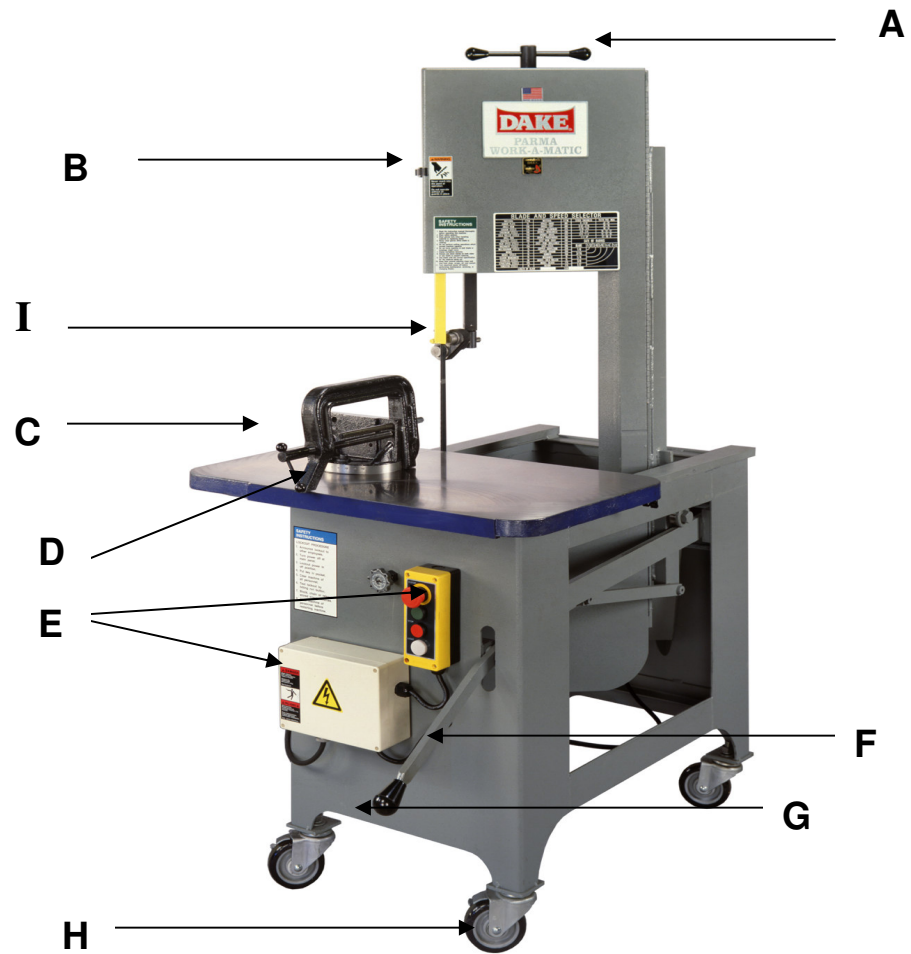
**Please Note:** The most common causes of the SXC not cutting straight are:

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

## **LUBRICATION**

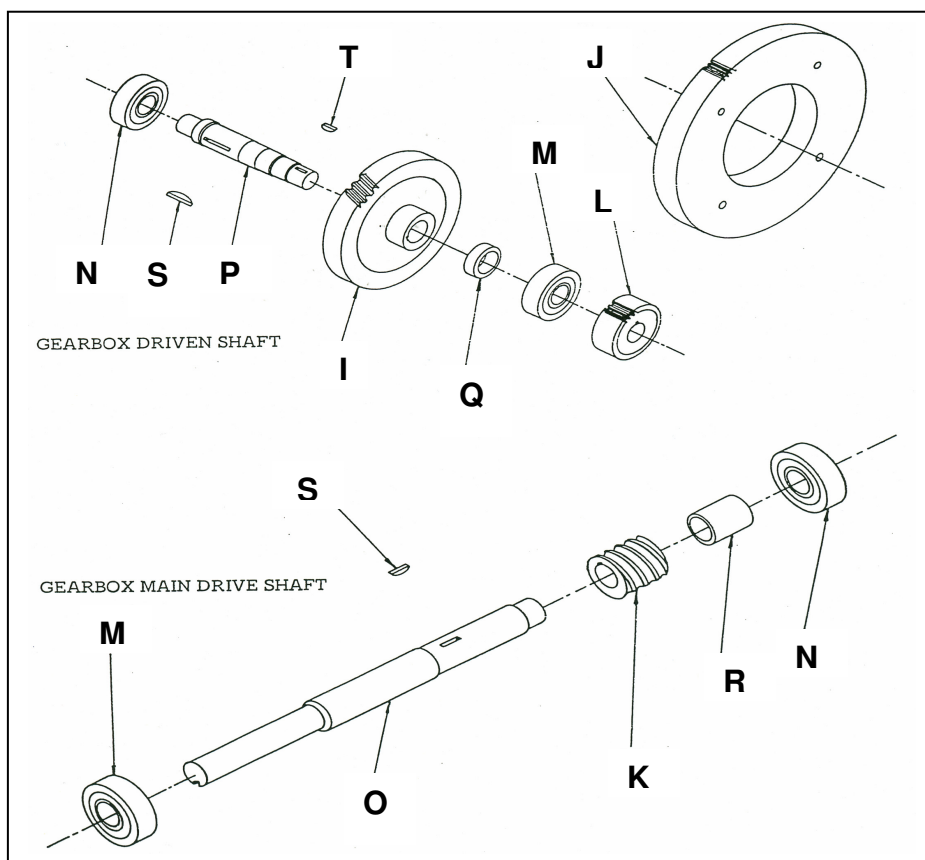
**Gear Box** Your SXC gearbox is filled at the factory. Check the fluid level on arrival, and then check every six months thereafter. Use 90-weight gear lube to maintain fluid level at the fill/check pipe plug.

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



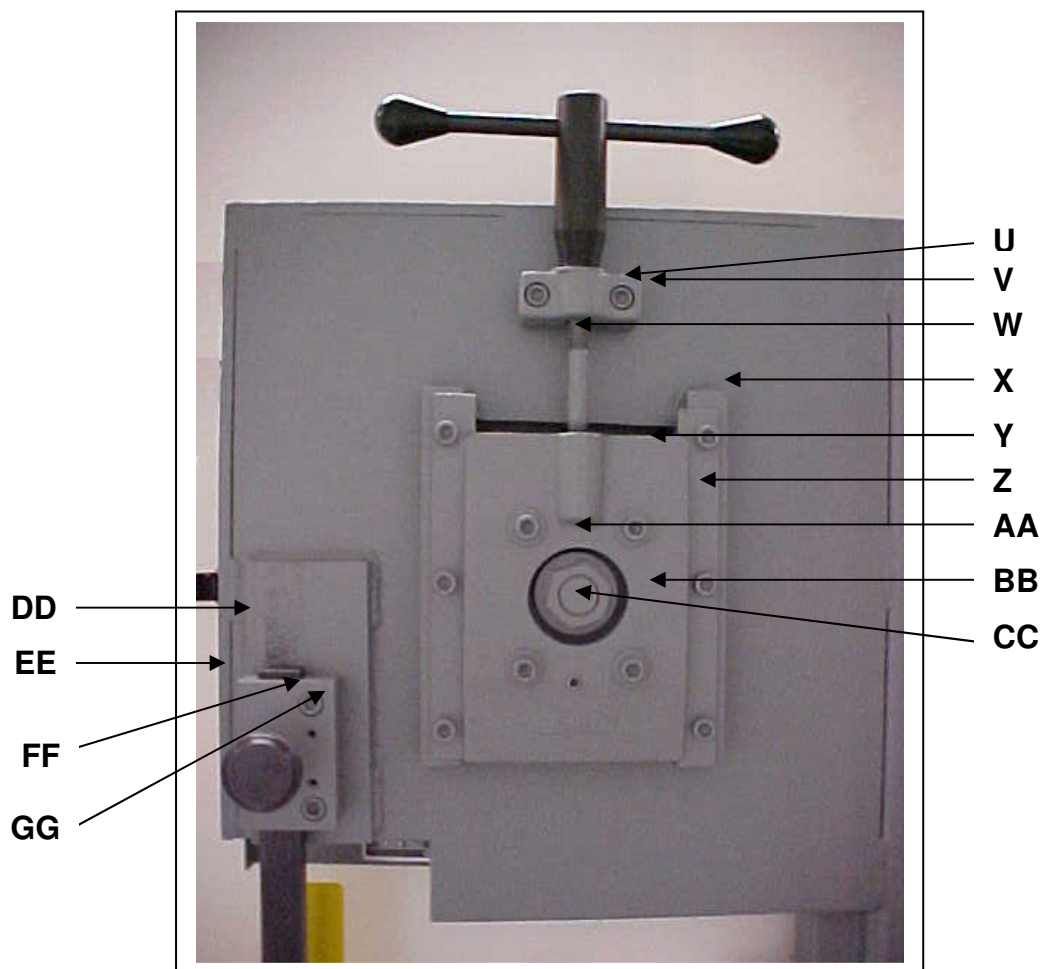
Item	Part Number	Description	Quantity
A	716716	Tension Handle Assembly	1
B	86747M	Door Latch	1
C	716714	C-Clamp Assembly	1
D	716703	Angle Plate with Pin	1
E1	716764	New Style Complete Electrical Kit – 1 ph 110 volt	1
E2	716765	New Style Complete Electrical Kit – 1 ph 220 volt	1
E3	716766	New Style Complete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

## GEARBOX ASSEMBLY

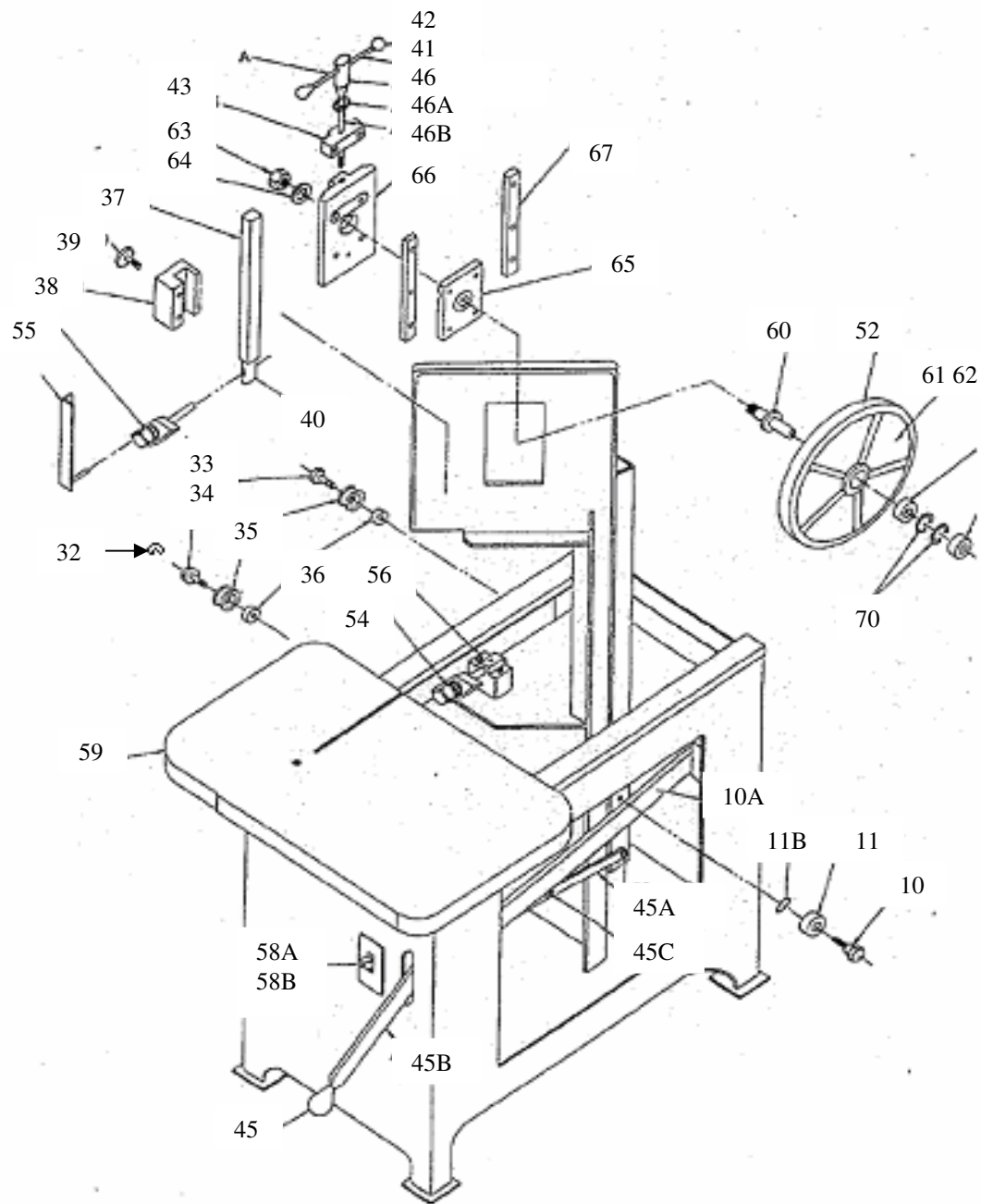


Item	Part Number	Description	Quantity
	<b>716712</b>	<b>Gearbox Assembly</b>	<b>1</b>
	300472	Bearing, Seal	2
	300490	Gasket, Gearbox	1
	300491	Gasket, Gearbox	4
	300589	Dowel Pin 3/16 x 1/2	2
	43412	Screw, Soc Cap	16
	43414	Screw, Soc Cap	6
	43590	Screw, Soc Set	3
	86820	Bearing Cover, Small/hole	2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





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



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

Not Pictured	300505	Cylinder, Hydraulic Reservoir (1 oz) - OLD STYLE
Not Pictured	300510	Cylinder, Hydraulic Reservoir (2 oz) - OLD STYLE
Not Pictured	716754	Cylinder Rebuilt Kit - OLD STYLE
Not Pictured	n/a	Cylinder Rebuild Kit - NEW STYLE
Not Pictured	300598	Cylinder, Hydraulic Shoulder bolt - OLD STYLE
Not Pictured	300529	Electric Cord Set with Plug
Not Pictured	86836	Excentric Roller Gravity Feed
<b>10</b>	86816	Stud Flat Track
<b>10A</b>	86852	Flat Track Rail
<b>11</b>	300471	Bearing Flat Track W204
<b>11A</b>	86839	Flat Track Roller Spacer
<b>32</b>	300477	E-Clip
<b>33</b>	86837	Stud Lever Weight
<b>34</b>	86819	Stud Grooved Roller
<b>35</b>	716706	Roller With Groove and Bearing
<b>36</b>	86838	Spacer Gravity Feed (3/8)
<b>37</b>	86815	Guide Support Bar - <b>STD</b>
<b>37</b>	86817	Guide Support Bar - <b>XC, SXC</b>
<b>38</b>	86810	Holder Guide Bar
<b>39</b>	300832	Guide Bar Lock Knob
<b>40</b>	86813	Swivel Guide Support Bar
<b>43</b>	86827	Pillow Block
<b>44</b>	86828	Tension Handle Body
<b>44A</b>	43634	Tension Handle Washer 1/2"
<b>44B</b>	86830	Screw Tension
<b>45</b>	300450	Knob Return Handle
<b>45A</b>	86841	Link Return Handle
<b>45B</b>	86782	Handle Return
<b>45C</b>	43777	Return Handle Shoulder Bolt 1/2 x 1/2
<b>45D</b>		Return Handle Axle Bolt - 1/2-13 x 3" SHCS
<b>45E</b>	86839	Spacer Return Handle (1/4)
Not Pictured	86798	Axle, Motor Mounting
Not Pictured	86800	Block Motor Mounting
<b>52</b>	300459	Band Blade Wheel Rubber Tire
<b>53</b>	10025-01	Bearing Roll Guide
<b>54</b>	87087	Roll Guide 1"
<b>54</b>	86809	Roll Guide 3/4"
<b>54A</b>	716717	Upper/Lower Roll Guide Assembly w/Bearing,Holder,Guide,Screw
<b>55</b>	86811	Holder Guide Rollers / housing
<b>56</b>	86805	Holder Guide Roll / Pillow Block
<b>56A</b>	86814	Excentric Top Guide
<b>56B</b>	86812	Pin Guide Lower Rolls
<b>57</b>	86791	Stop Frame
Not Pictured	300832	Knob, Stop Weight
<b>59</b>	86796	Tables-Raw
<b>60</b>	86803	Axle Lower & Upper Wheel
<b>62</b>	86795	Wheel Blade Lower
<b>63</b>	78650	Washer
<b>64</b>	300651	Nut
<b>65</b>	300461	Wheel Bearing (6205)

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

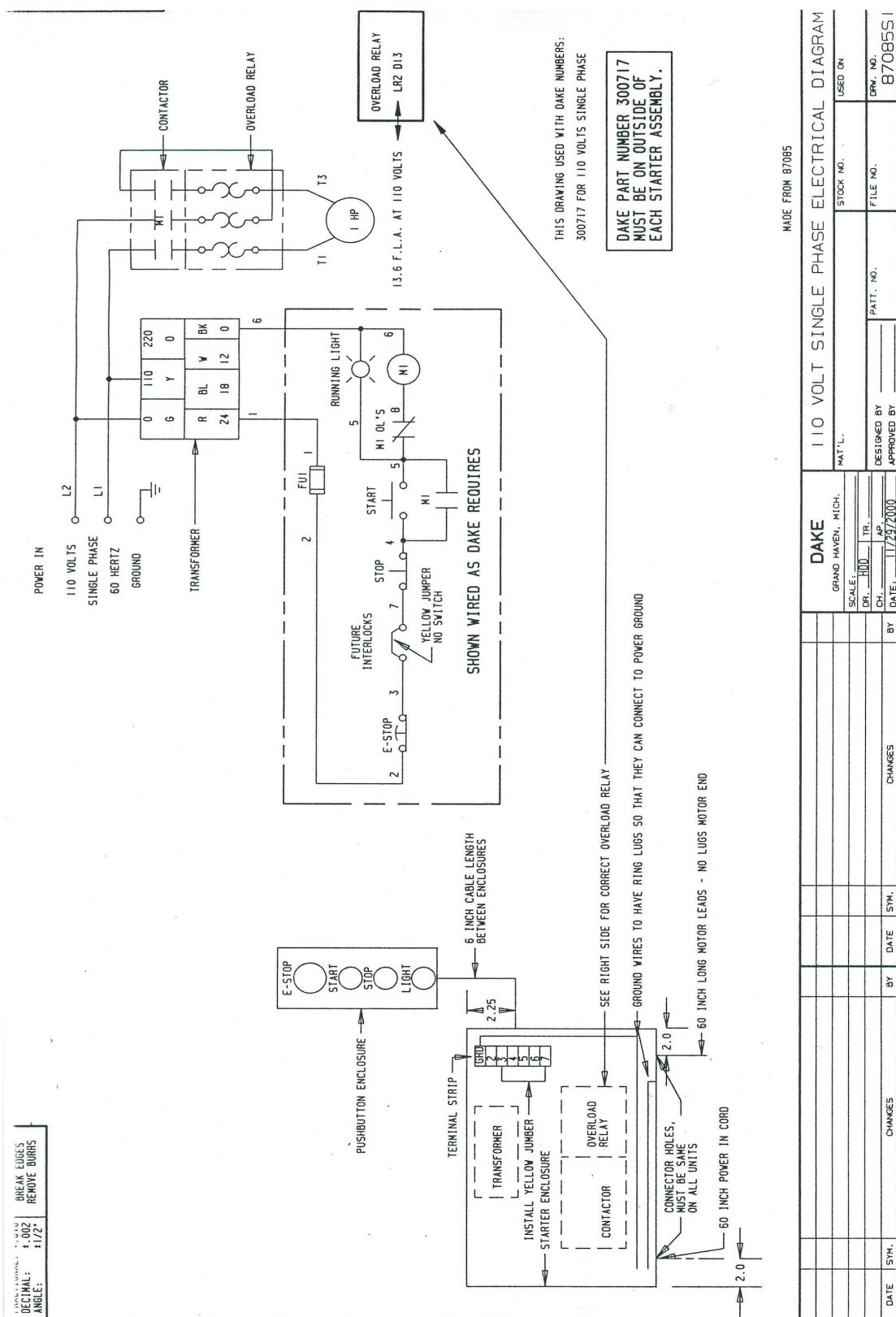
**110 Volt – Single phase @ 14 Amps**

**220 Volt – Single phase @ 7.5 Amps**

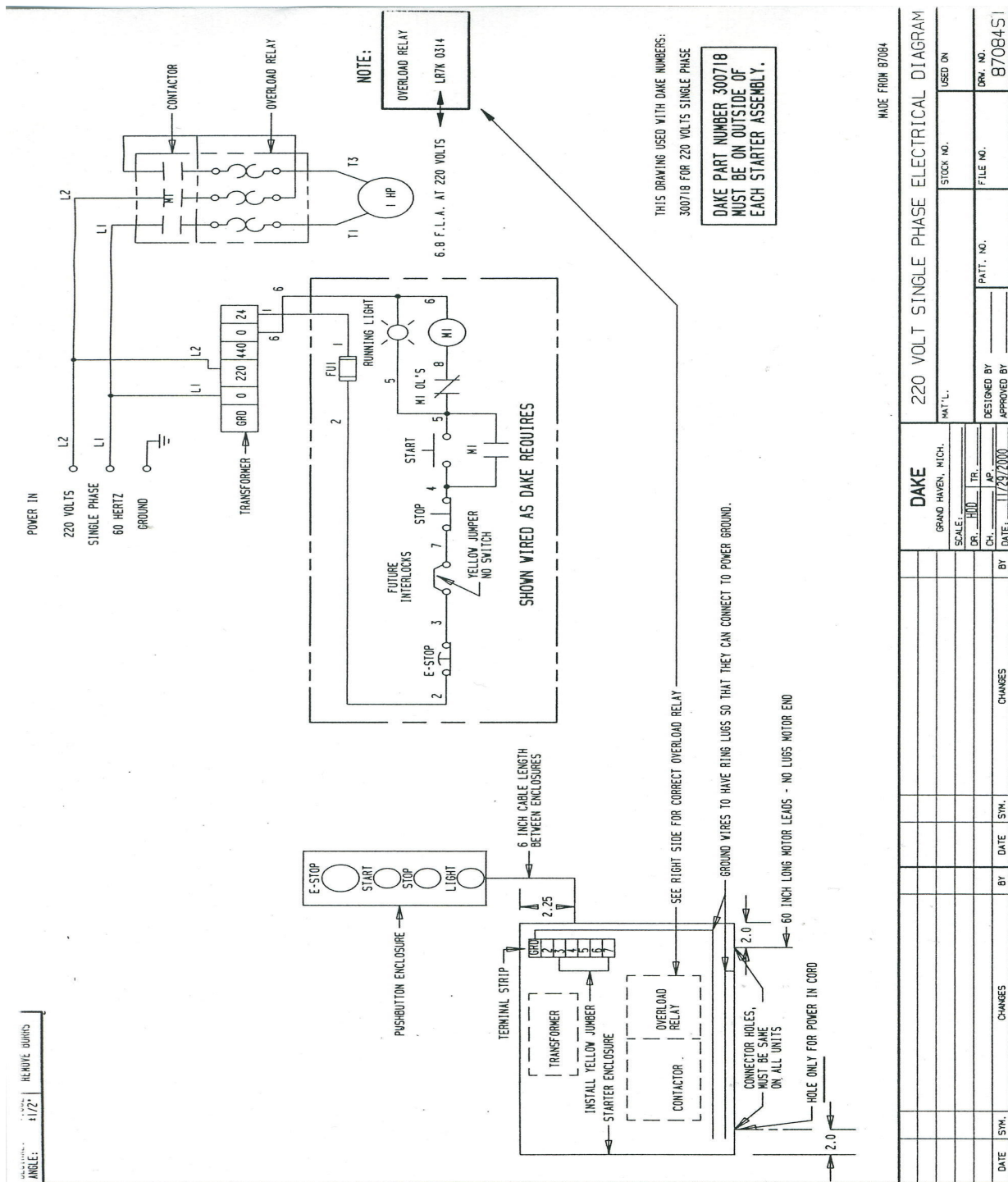
**230 Volt – Three phase @ 4 Amps**

**460 Volt – Three phase @ 2 Amps**

## 110 Volt Single Phase

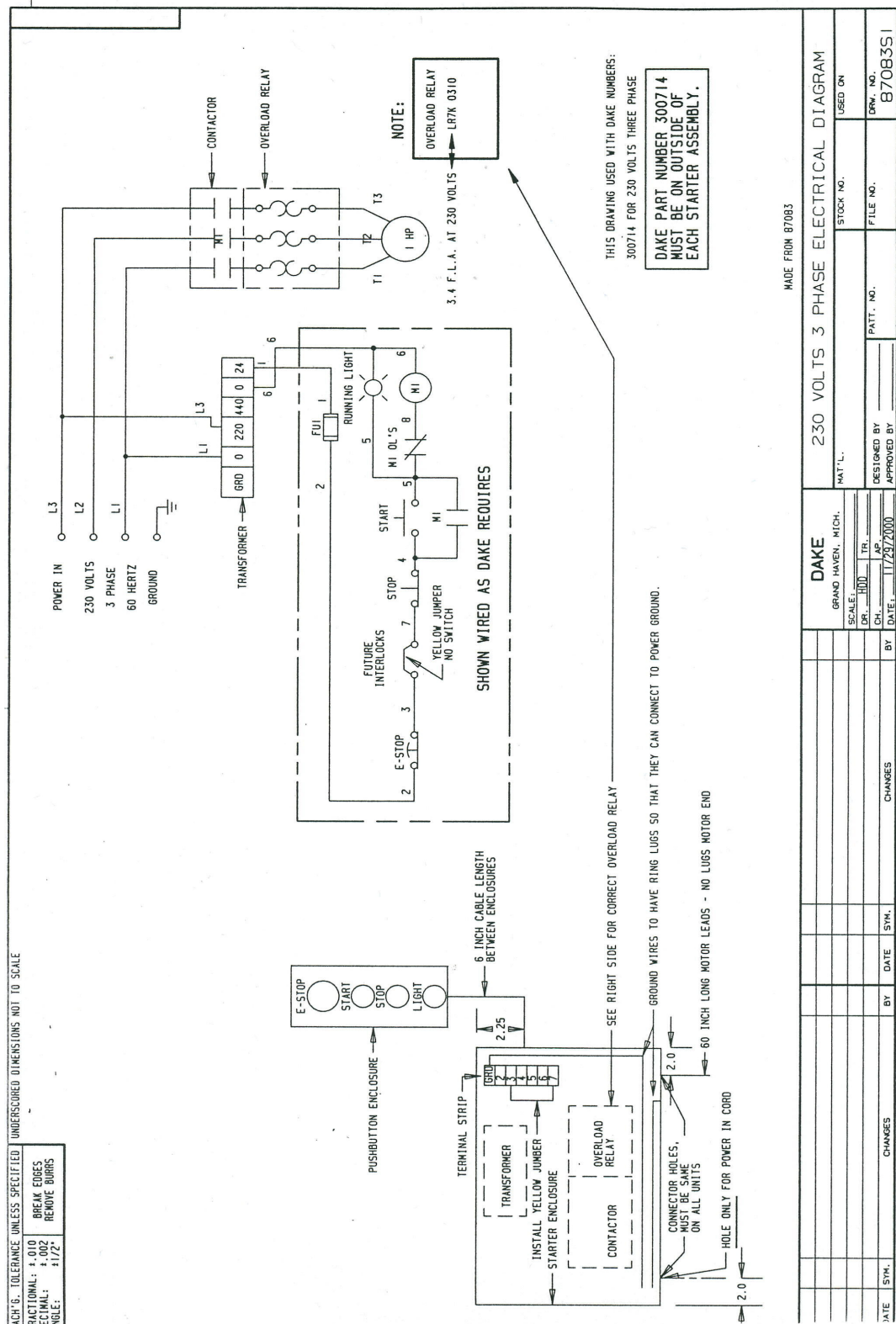


### **220 Volt Single Phase**





### **230 Volt Three Phase**



# 460 Volt Three Phase

