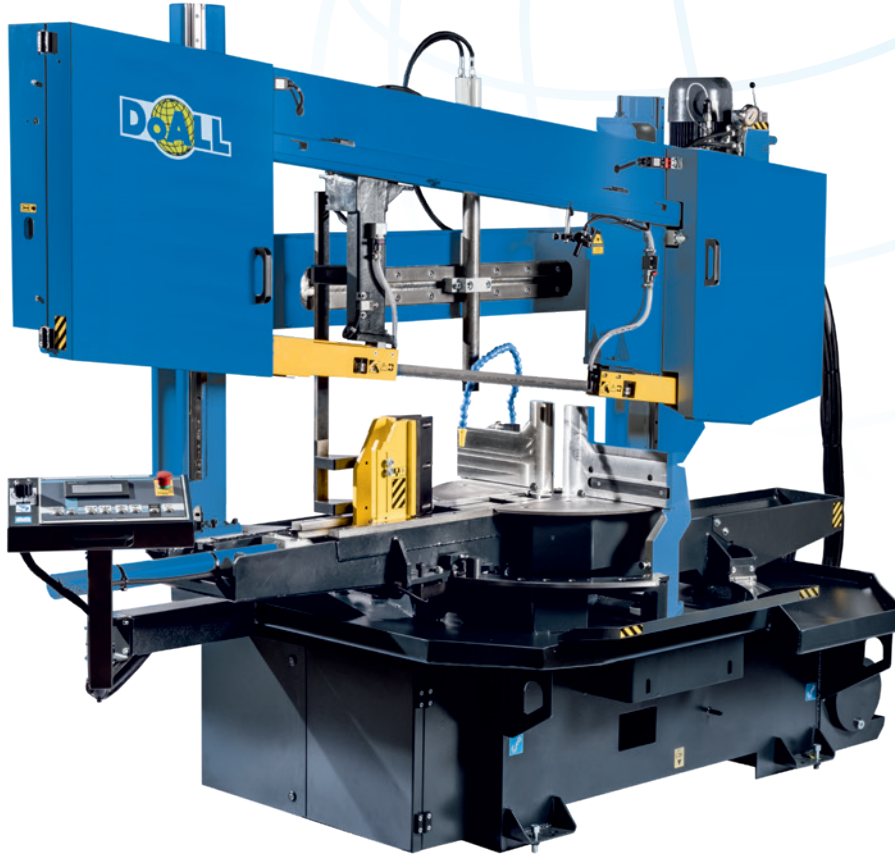


# Horizontal Structural Saws

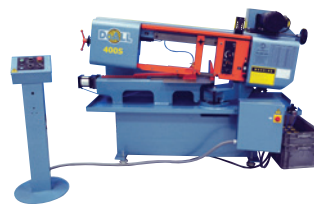


DCDS-600SA  
Horizontal Structural Saw –  
17¼" x 24" Rectangular Capacity  
and 18" Round Capacity

## STRUCTURALL®

DoALL StructurALL® series metal cutting band saws are among the best multi-purpose horizontal band saws in the industry. Specially engineered for high performance in fabricating environments, these horizontal swivel or scissor style saws are built for speed, accuracy and increased profits for your business.

DoALL offers a full range of StructurALL metal cutting band saws with round capacities up to 21½ inches. A large variety of optional accessories are available to customize these machines for specific sawing requirements. DoALL StructurALL metalworking saws are an economical, option to meet your needs without straining your budget!



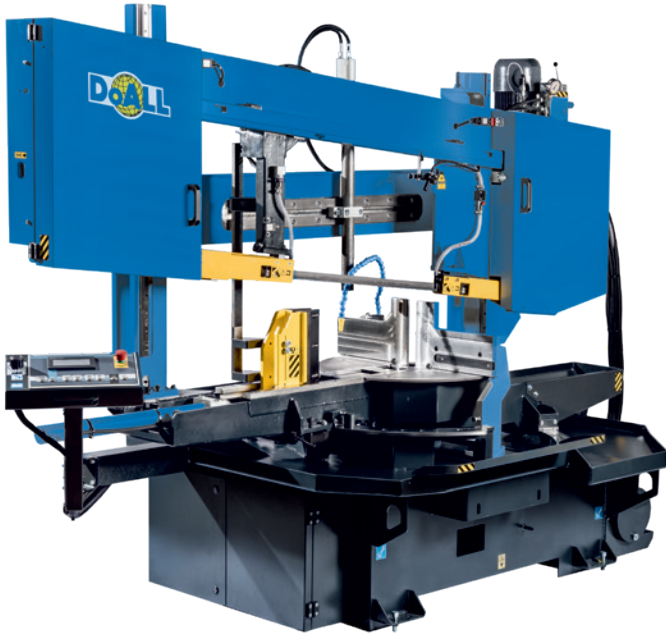
Solutions for ALL Your Sawing Needs

DoALL dual column, dual swivel are ideal for production sawing of a large variety of materials including, but not limited to, structural solids, stainless and tool steel. Double column, double miter saws are ideal machines for a fabricator cutting multiple angles in the same work piece.

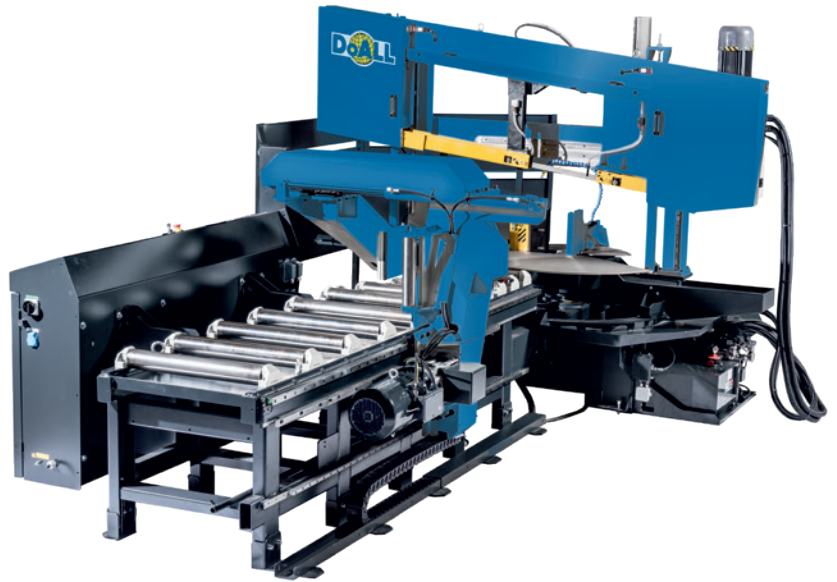
DoALL Model Number	DCDS-600SA	DCDS-600NC	DCDS-750SA	DCDS-750NC
Warranty	Parts/Service	Parts/Service	Parts/Service	Parts/Service
Warranty Length	2-year standard	2-year standard	2-year standard	2-year standard
Capacity Rectangle at 90° HxW	17.25 x 24" (440x610mm)	17.25 x 24" (440x610mm)	19 x 30" (480x750mm)	19 x 30" (480x750mm)
Capacity Round at 90°	18.5" (470mm)	18.5" (470mm)	20" (500mm)	20" (500mm)
Round Solid Capacity at 90°	9-7/8" (250mm)	9-7/8" (250mm)	15-3/4" (400mm)	15-3/4" (400mm)
Rectangle Capacity at 45°	19.5 x 16.3" (495x415mm)	19.5 x 16.3" (495x415mm)	19.7 x 18.9" (500x480mm)	19.7 x 18.9" (500x480mm)
Round Capacity at 45°	18.5" (470mm)	18.5" (470mm)	19.7" (500mm)	19.7" (500mm)
Rectangle Capacity at 60°	12 x 16.7" (305x425mm)	12 x 16.7" (305x425mm)	13 x 18.9" (330x480mm)	13 x 18.9" (330x480mm)
Round Capacity at 60°	13" (330mm)	13" (330mm)	13" (330mm)	13" (330mm)
Blade Drive Motor	5 hp (4kW)	5 hp (4kW)	5 hp (4kW)	5 hp (4kW)
Blade Speeds	65-328 fpm (20-100mpm)	65-328 fpm (20-100mpm)	65-328 fpm (20-100mpm)	65-328 fpm (20-100mpm)
Maximum Blade Length	238-1/2" (6060mm)	238-1/2" (6060mm)	256" (6500mm)	256" (6500mm)
Blade Widths & Gage	1-1/4 x 0.042" (34x1.1mm)	1-1/4 x 0.042" (34x1.1mm)	1-1/2" x 0.05" (41x1.3mm)	1-1/2" x 0.05" (41x1.3mm)
HMI Controller	Yes	Yes	Yes	Yes
Standard Indexer	N/A	6.56 ft (2m)	N/A	6.56 ft (2m)
More information at	doallsaws.com/dcds-600sa	doallsaws.com/dcds-600nc	doallsaws.com/dcds-750sa	doallsaws.com/dcds-750nc
Material Pass Line Height	31-1/2" (800mm)	31-1/2" (800mm)	32" (815mm)	32" (815mm)
Floor Space Required	138 x 69 x 87" (3500x1760x2200mm)	126 x 192 x 94" (3200x4880x2390mm)	142 x 67 x 95" (3600x1700x2400mm)	142 x 232 x 95" (3600x5880x2400mm)
Weight	3715 lbs (1685kg)	8455 lbs (3835kg)	4409 lbs (2000kg)	9149 lbs (4150kg)
Miter Cutting	60 degrees Left and Right	60 degrees Left and Right	60 degrees Left and Right	60 degrees Left and Right
Blade Guides	Carbide Faced	Carbide Faced	Carbide Faced	Carbide Faced
Index System	Hydraulic Control	Electromotor and gearbox	Hydraulic Control	Electromotor and gearbox
Hydraulic Pump	3.8 hp (2.84kW)	3.8 hp (2.84kW)	3 hp (2.2kW)	3 hp (2.2kW)
Hydraulic Tank Capacity	N/A	N/A	3.4 gal (13.0 L)	3.4 gal (13.0 L)
Coolant Pump	0.16 hp (0.12kW)	0.16 hp (0.12kW)	0.16 hp (0.12kW)	0.16 hp (0.12kW)
Coolant Tank Capacity	6-5/8 gal (25 lit)	6-5/8 gal (25 lit)	10-1/2 gal (40 lit)	10-1/2 gal (40 lit)
Auto Index Single Stroke Min-Max	N/A	0.12-78.7" (3-2000mm)	N/A	0.12-78.7" (3-2000mm)
Auto Index Multiple Stroke Min-Max	N/A	394" (9999mm)	N/A	394" (9999mm)
Max Bundle Capacity at 90°	24" x 10" (610x255mm)	24" x 10" (610x255mm)	29.5" x 10.2" (750x260mm)	29.5" x 10.2" (750x260mm)
Min Bundle Capacity at 90°	0.4" (10mm)	0.4" (10mm)	0.4" (10mm)	3.3" (85mm)
Minimum Butt End	1.2" (30mm)	5.5" (140mm)	1.2" (30mm)	4.7" (120mm)
Vise	Hydraulic	Hydraulic	Hydraulic	Hydraulic

## Features and Benefits:

- True dual column design with high rigidity for outstanding cutting performance and life
- Dual miter capability up to 60 degrees right and left
- Standard work area lighting
- Optional right and left modular work conveyors
- Optional power work conveyors
- Optional lift conveyors
- Optional right and left work roll table to ease movement of material



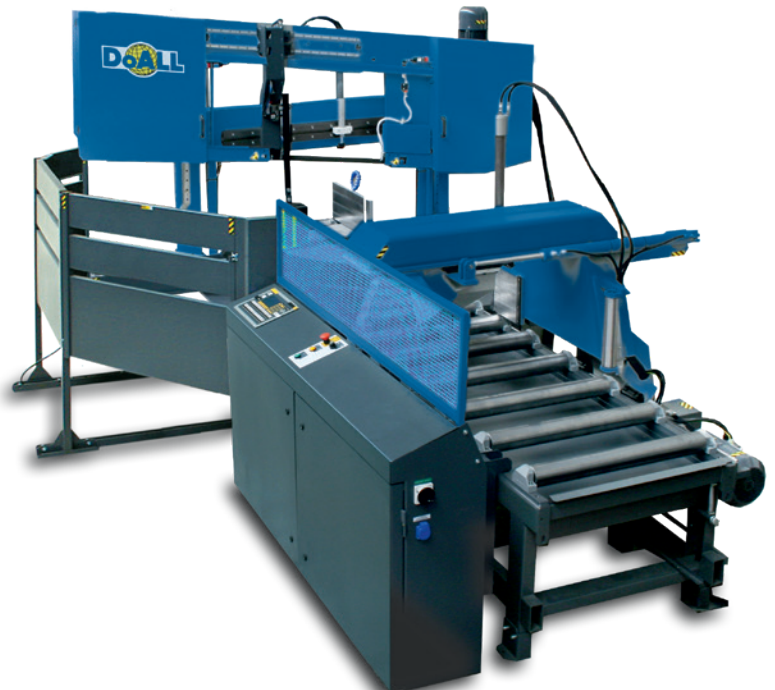
DCDS-600SA



DCDS-600NC



DCDS-750SA



DCDS-750NC

DoALL offers a variety of low cost, general purpose production metal-cutting band saws. These saws are ideal for small shops and maintenance facilities that have an occasional need to cut structural material. A large variety of optional accessories are available to customize the machine for specific sawing requirements.

DoALL Model Number	DS-280M	DS-320M	S-320CNC	S-500CNC - Coming Soon
Warranty	Parts/Service	Parts/Service	Parts/Service	Parts/Service
Warranty Length	1 year standard	1 year standard	1 year standard	1 year standard
Capacity Rectangle at 90° WxH	8.2 x 11" (210 x 280mm)	11.75 x 12.5" (300 x 320mm)	11.75 x 12.5" (300 x 320mm)	14 x 20" (360 x 500mm)
Capacity Round at 90°	9" (230mm)	11.75" (300mm)	11.75" (300mm)	14" (360mm)
Round Solid Capacity at 90°	5.875" (150mm)	7" (180mm)	7" (180mm)	9-7/8" (250mm)
Rectangle Capacity at 45°	7.1 x 6.7" (180 x 170mm)	11.75 x 9.75" (300 x 250mm)	11.75 x 9.75" (300 x 250mm)	17.3 x 8.6" (440 x 220mm)
Round Capacity at 45°	7.5" (190mm)	11.75" (300mm)	11.75" (300mm)	14.2" (360mm)
Rectangle Capacity at 60°	4.75 x 4" (100 x 70mm)	7.75 x 7.75" (200 x 200mm)	7.75 x 7.75" (200 x 200mm)	12.2 x 8.6" (310 x 220mm)
Round Capacity at 60°	4.75" (100mm)	7.75" (200mm)	7.75" (200mm)	11.8" (300mm)
Blade Drive Motor	1 - 1.5 hp (.75-1.1 kW)	2 - 2.5 hp (1.4-1.8 kW)	4 hp (3kW)	5 hp (4kW)
Blade Speeds	115/230 fpm (35/70 mpm)	115/230 fpm (35/70 mpm)	65-328 fpm (20-100 mpm)	65-328 fpm (20-100 mpm)
Maximum Blade Diameter	107" (2720mm)	144" (3660mm)	144" (3660mm)	188" (4780mm)
Blade Widths & Gage	1 x 0.035" (27 x 0.9mm)	1 x 0.035" (27 x 0.9mm)	1 x 0.035" (27 x 0.9mm)	1-1/4 x 0.042" (34 x 1.1mm)
HMI Controller	Standard control panel	Standard control panel	Mitsubishi	Mitsubishi
Compatible Voltage	230v, 3-Phase, 60Hz Wye configuration required	230v, 3-Phase, 60Hz Wye configuration required	230v, 3-Phase, 60Hz Wye configuration required	460v, 3-Phase, 60Hz Wye configuration required
More Information Found at	doallsaws.com/ds-280m	doallsaws.com/ds-320m	doallsaws.com/s-320cnc	doallsaws.com/ds-500cnc
Material Pass Line Height	31-1/3" (795mm)	31-1/2" (800mm)	31-1/2" (800mm)	31-1/2" (800mm)
Floor Space Required	65 x 35 x 74" (1650 x 885 x 1860mm)	90 x 46 x 81" (270 x 1170 x 2040mm)	91 x 90 x 81" (2309 x 2278 x 2041mm)	100 x 100 x 56" (2550 x 2550 x 1420mm)
Weight	618 lbs (280kg)	1209 lbs (548kg)	3000 lbs (1361kg)	3307 lbs (1500kg)
Miter Cutting	60 degrees Right and 45 degrees Left	60 degrees Right and 45 degrees Left	0-60 degrees Right	0-60 degrees Right
Feed System	Manual/Gravitational	Manual/Gravitational	Hydraulic Control	Hydraulic
Coolant Pump	0.07 hp (0.05kW)	0.6 hp (0.44kW)	0.6 hp (0.44kW)	0.07 hp (0.05kW)
Coolant Tank Capacity	2-3/8 gal (10 lit)	5-1/4 gal (20 lit)	5-1/4 gal (20 lit)	5-1/4 gal (20 lit)
Auto Index Single Stroke Min-Max	N/A	N/A	0.12-19.7" (3-500mm)	0.12-19.7" (3-500mm)
Auto Index Multiple Stroke Min-Max	N/A	N/A	394" (9999mm)	394" (9999mm)
Maximum Nesting Capacity at 90° (wxh)	11 x 4.7" (80x120mm)	12.5 x 6.25" (320x160mm)	9 x 4.75" (230x120mm)	Coming Soon
Minimum Nesting Capacity at 90° (wxh)	0.20" (5mm)	0.12" (3mm)	7.9" x 0.4" (200x10mm)	Coming Soon
Minimum Butt End	N/A	1.2" (30mm)	0.8" (20mm)	0.8" (20mm)

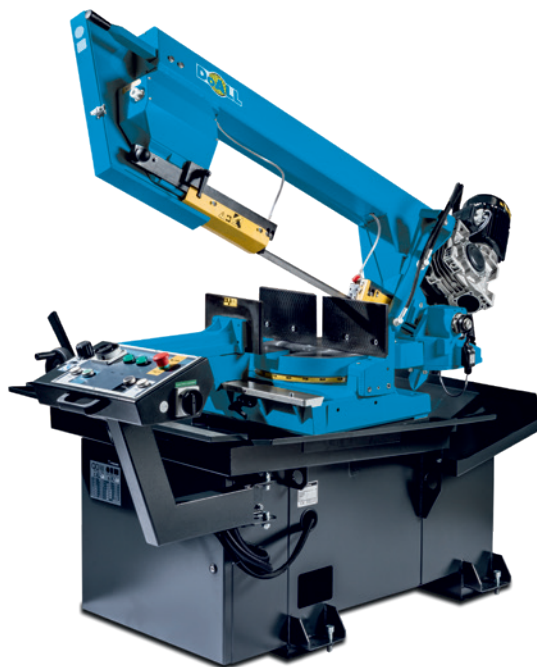
## Features and Benefits:

- Wide range of blade speeds
- Over feed protection
- High level of dampening with use of many key cast components
- Lift points of the machine are clearly indicated for ease of movement and installation
- Optional right or left miter modular designed work conveyors in 40" and 80" lengths
- Optional power roller conveyor makes moving heavy material easy





DS-280M



DS-320M



S-320CNC



S-500CNC

DoALL miter and non-miter saws increase flexibility and improve efficiency in fabrication shops or other sawing applications that require the efficient cutting of structural material. DoALL offers a full range of saws that feature a variety of cutting capacities with both straight and angle cutting options.



400S

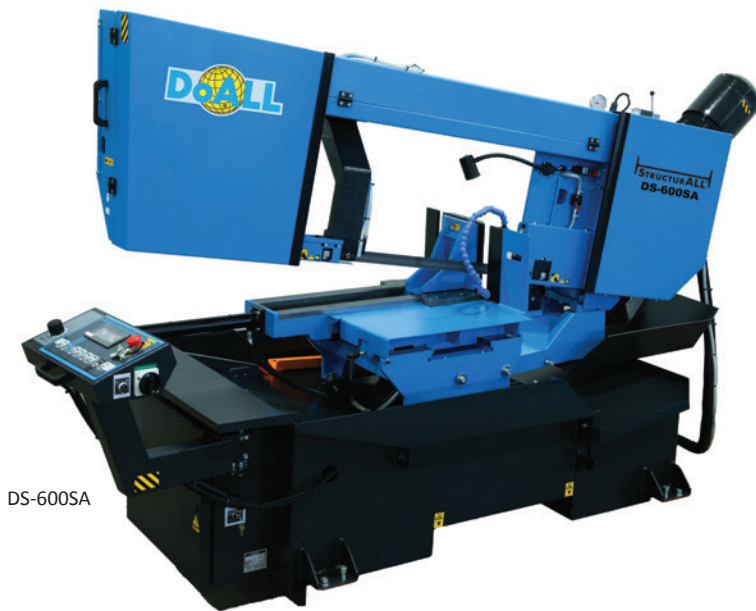


DS-500SA

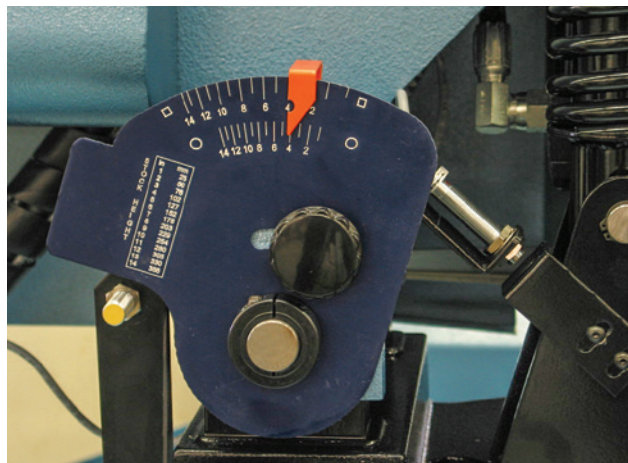
DoALL Model Number	DS-320SA	400-S	DS-500SA	DS-600SA
Warranty	Parts/Service	Parts Only	Parts/Service	Parts/Service
Warranty Length	1 year standard	Send new parts	1 year standard	1 year standard
Capacity Rectangle at 90° WxH	11.75 x 12.5" (300 x 320mm)	10 x 16" (254 x 406mm)	14 x 20" (360 x 500mm)	18 x 23.5" (460 x 600mm)
Capacity Round at 90°	11.75" (300mm)	10-3/4" (273mm)	15" (380mm)	18" (460mm)
Round Solid Capacity at 90°	7" (180mm)	10-3/4" (273mm)	9-7/8" (250mm)	15-3/4" (400mm)
Rectangle Capacity at 45°	11.75 x 9.75" (300 x 250mm)	9 x 10-3/4" (229 x 273mm)	15.75 x 7.5" (400 x 190mm)	18.5 x 9.8" (470 x 250mm)
Round Capacity at 45°	11.75" (300mm)	10-3/4" (273mm)	14.2" (360mm)	18" (460mm)
Rectangle Capacity at 60°	7.75 x 7.75" (200 x 200mm)	N/A	10.6 x 12.6" (270 x 320mm)	12.6 x 9.5" (320 x 240mm)
Round Capacity at 60°	7.75" (200mm)	N/A	12.2" (310mm)	12.5" (320mm)
Blade Drive Motor	2 - 2.5 hp (1.4-1.8 kW)	2 hp (1.5kW)	5 hp (4kW)	5 hp (4kW)
Blade Speeds	115/230 fpm (35/70 mpm)	105-275 fpm (32-82mpm)	65-328 fpm (20-100 mpm)	65-328 fpm (20-100 mpm)
Maximum Blade Diameter	144" (3660mm)	158" (4013 mm)	188" (4780mm)	212" (5380mm)
Blade Widths & Gage	1 x 0.035" (27 x 0.9mm)	1 x 0.035" (25.4x0.89mm)	1-1/4 x 0.042" (34 x 1.1mm)	1-1/2" x 0.05" (41 x 1.3mm)
HMI Controller	Mitsubishi	Yes	Mitsubishi	Mitsubishi
Compatible Voltage	230v, 3-Phase, 60Hz Wye configuration required	230v, 3-Phase, 60Hz Wye configuration required	460v, 3-Phase, 60Hz Wye configuration required	460v, 3-Phase, 60Hz Wye configuration required
More Information Found at	doallsaws.com/ds-320sa	doallsaws.com/400s	doallsaws.com/ds-500sa	doallsaws.com/ds-600sa
Material Pass Line Height	31-1/2" (800mm)	29-1/8" (740mm)	32-1/3" (820mm)	31-1/2" (800mm)
Floor Space Required	90 x 46 x 81" (2270 x 1170 x 2040mm)	87 x 42 x 55" (2210 x 1067 x 1397mm)	109 x 38 x 90" (2750 x 950 x 2270mm)	136 x 45 x 107" (3457 x 1140 x 2700mm)
Weight	1290 lbs (585kg)	1200 lbs (544kg) - spec says 1150 lbs	1576 lbs (715kg)	2646 lbs (1200kg)
Miter Cutting	60 degrees Right and 45 degrees Left	45 degrees	60 degrees Left and Right	60 degrees Left and Right
Feed System	Semi-Automatic Hydraulic	Hydraulic Control, Infinitely variable, Spring balanced head	Semi-Automatic Hydraulic	Semi-Automatic Hydraulic
Coolant Pump	0.6 hp (0.44kW)	N/A	0.6 hp (0.44kW)	0.07 hp (0.05kW)
Coolant Tank Capacity	5-1/4 gal (20 lit)	6 gal (22 lit)	5-1/4 gal (20 lit)	5-1/4 gal (20 lit)
Auto Index Single Stroke Min-Max	N/A	N/A	N/A	N/A
Auto Index Multiple Stroke Min-Max	N/A	N/A	N/A	N/A
Maximum Nesting Capacity at 90° (wxh)	12.5 x 6.25" (320x160mm)	N/A	19.7" x 8.7" (500x220mm)	23.6 x 9.8" (600x250mm)
Minimum Nesting Capacity at 90° (wxh)	0.12" (3mm)	N/A	0.20" (5mm)	0.20" (5mm)
Minimum Butt End	1.2" (30mm)	N/A	N/A	N/A

## Features and Benefits:

- Extremely accurate
- Large variety of options available for custom applications
- Budget friendly list pricing
- Wide band for faster cutting speeds
- Fast, accurate cut positioning
- Simple design for easy saw operation



Laser



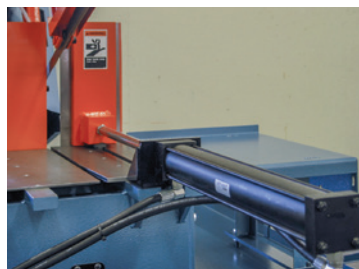
Work height sensor



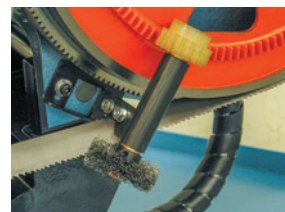
Band door interlocks



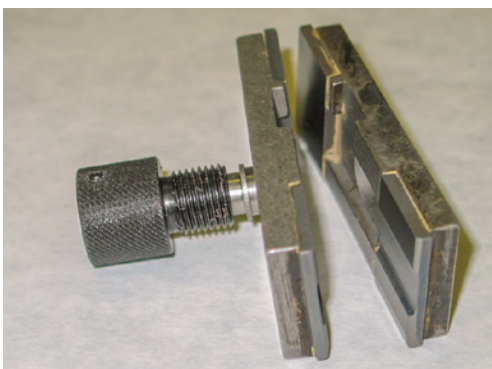
Work light



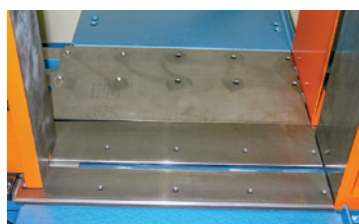
Full stroke vises



Gear driven band brush



Insert assembly



Wear plates



## Standard Equipment on most models:

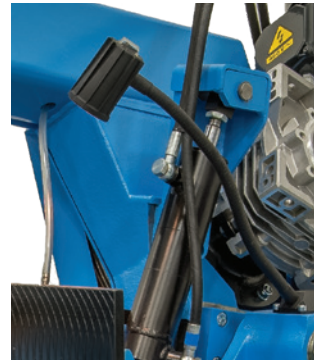
- HMI saw control
- Digital read out of cutting angle
- Work light
- Hydraulic band tension
- Feed rate indicator
- Automatic feed control
- Automatic guide arm setting
- Band brush
- Safety covers
- Flood coolant
- Tool kit
- Complimentary DoALL cutting fluids package
- One DoALL bi-metal saw blade
- Digital copy of operation and parts manuals

## Optional Accessories on most models:

- Chain chip conveyor with pan
- Front and rear vise nesting
- Mist-style saw band lubrication
- Laser line generator
- Cut piece collection box with drain
- Large chip pan with drain
- Handle for chip pan or collection box
- Input or output roller conveyors
- Heavy-duty input or output roller conveyors
- Input and output powered conveyor for angle cuts
- Indexing extension
- Hydraulic lift input or output roller conveyor
- Fixed or movable side vertical guide roller
- Vertical hold down
- Additional conveyor rollers
- Wear parts service kit



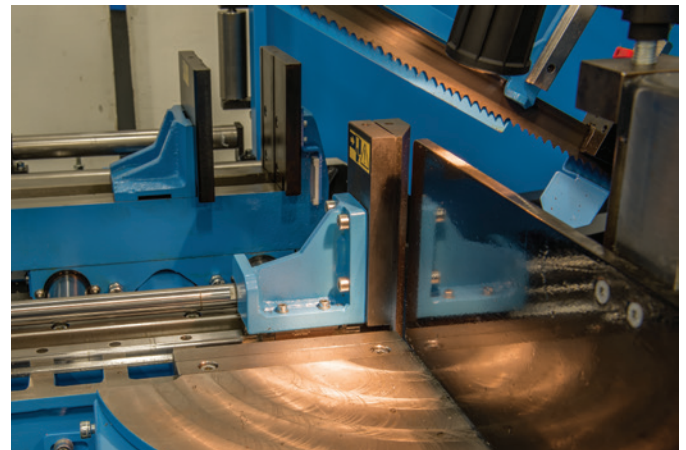
Sample control panel



Work light



Chip blower



Vise Nesting

Visit [www.DoALLsaws.com](http://www.DoALLsaws.com) for most accurate information on standard equipment and accessories

**DoALL**  
SAWING PRODUCTS

5505 West 123rd Street  
Savage, MN 55378 USA  
[www.DoALLsaws.com](http://www.DoALLsaws.com)  
1-888-362-5572

DSP-STRUCT-092618

Copyright © 2018 DoALL Sawing Products. All Rights Reserved. No image(s) or part(s) from this site may be reproduced without the written permission of Continental Machines, Inc. Options, specifications, prices and site content is subject to change without notice or obligation. Machine safety items may be omitted for illustration purposes only -- For proper application, always read the operation manual. DoALL, StructurALL - The Sawing Answer Man are all registered trademarks of DoALL Company.