

KI **KALAMAZOO**
INDUSTRIES, INC.
KALAMAZOO, MI.



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K10B ABRASIVE SAW INSTRUCTION MANUAL



MADE IN USA

WARNING!

TO REDUCE THE RISK OF FIRE OR SHOCK HAZARD, DO NOT EXPOSE THIS EQUIPMENT TO RAIN, ANY LIQUID OR MOISTURE.

INSPECTION

If these goods are damaged in transit, the **DELIVERING TRANSPORTATION COMPANY** is required by law to make notation of damages on the freight bill. If in your opinion, there may be concealed damage, they are required to make an inspection after goods are unpacked. Transportation rates are made in proportion to damage. Therefore, the carrier and **NOT** the shipper should be charged with any loss or damage. Any claim should be filed with the delivering Transportation Company. **PLEASE DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS.**

Electrical: CAUTION: Voltage changes require wiring changes at drive motor. **WARRANTY DOES NOT COVER** unauthorized wiring changes/failures. **Consult an electrician an electrician if your not familiar with electrics.**

K10B SETUP

- BEFORE STARTING OR CONNECTING ELECTRICAL VERIFY THE PHASE AND VOLTAGE OF THE UNIT.
- BE SURE MACHINE IS BALANCED CORRECTLY SO IT WILL TIP OVER.
- TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBSERVE UNIT FOR THE FIRST FEW MINUTES OF OPERATION. GUARDS MUST NEVER BE REMOVED.
- BEFORE INSTALLING THE ABRASIVE WHEEL CONFIRM THAT THE CUTOFF WHEEL IS DESIGNED TO RUN AT 4800 SFPM (MOS). YOU CAN FIND THIS INFORMATION DIRECTLY ON THE THE SIDE OF YOUR CUTOFF WHEEL. IT

ABRASIVE SAW SAFETY

- NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT MACHINE FROM POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS.
- DO NOT USE AROUND FLAMMABLE MATERIALS OR LIQUIDS.
- MACHINES SHOULD BE OPERATED IN VENTILATED AREAS.
- ALWAYS WEAR SAFETY GLASSES OR A FULL FACE SHIELD FOR PROTECTION.
- DO NOT USE TOOTHED BLADE WITH THIS SAW AND DO NOT ATTEMPT TO USE STEEL BLADES ON THIS SAW.
- KEEP HANDS CLEAR OF THE CUTTING AREA.
- DO NOT WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.
- ALWAYS KEEP HAIR TIED BACK OR COVERED.
- ALWAYS KEEP FLANGES CLEAN AND TIGHT AGAINST CUTTING WHEEL.
- MANUALLY TIGHTEN AND LOOSE SPINDLE NUT.
- DO NOT USE IMPACTED GUN TO LOOSEN OR TIGHTEN SPINDLE NUT.
- ALWAYS KEEP WHEEL GUARD IN THE DOWN POSITION.
- BE SURE WORK PIECE IS CLAMPED SECURELY IN VISE BEFORE CUTTING.

WARNING!!!!

IMPROPER USE MAY CAUSE BREAKAGE AND SERIOUS INJURY.

DO

1. **DO** always handle and store wheels in the vertical position.
2. **DO** visually inspect all wheels before mounting for possible damage.
3. **DO** check machine speed against the established maximum safe operating speed marked on the wheel.
4. **DO** check mounting flanges for equal and correct diameter.
5. **DO** use mounting blotters when supplied with wheels.
6. **DO** always use a safety guard covering a least one-half of the abrasive wheel.
7. **DO** allow newly mounted wheels to run at operating speed, with guard in place, for at least one minute before cutting.
8. **DO** always wear safety glasses or some type of eye protection when cutting.
9. **DO** tie back hair.

DON'T

1. **DON'T** use a cracked wheel or one that has been dropped or has become damaged.
2. **DON'T** force a wheel onto the machine or alter the size of the mounting hole if wheel won't fit the machine.
3. **DON'T** ever exceed maximum operating speed established for the wheel.
4. **DON'T** use mounting flanges on which the bearing surfaces are not clean, flat and free of burrs.
5. **DON'T** tighten the spindle nut excessively.
6. **DON'T** start the machine until the wheel guard is in place.
7. **DON'T** jam work into wheel.
8. **DON'T** force cutting so that motor slows noticeable or work gets hot.
9. **DON'T** wear gloves and or have loose clothing when operating machine.
10. **DON'T** use tooth blade on saw.

BASIC OPERATION

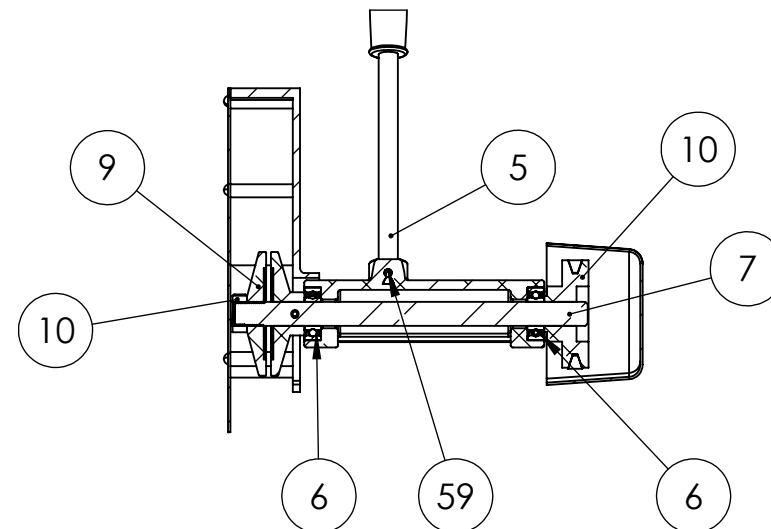
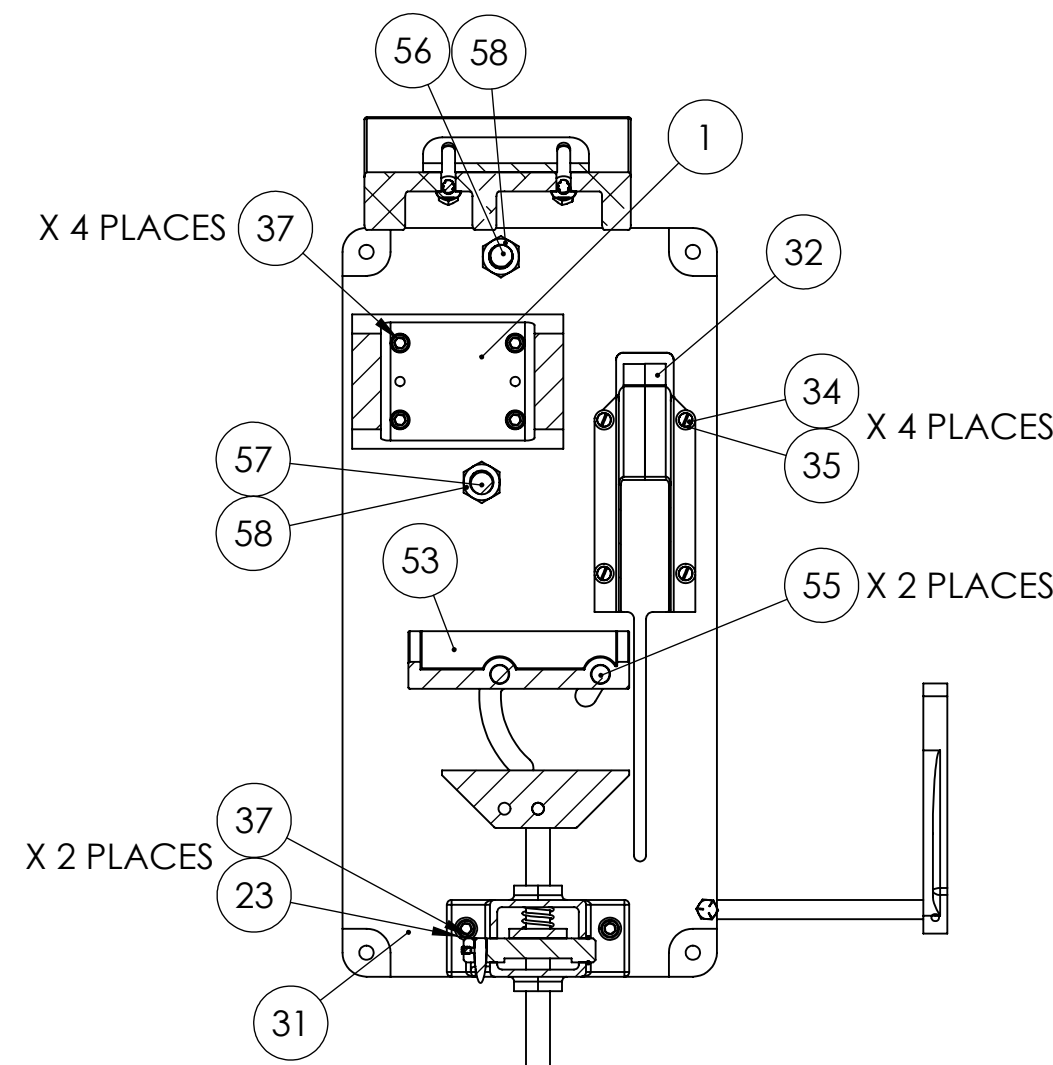
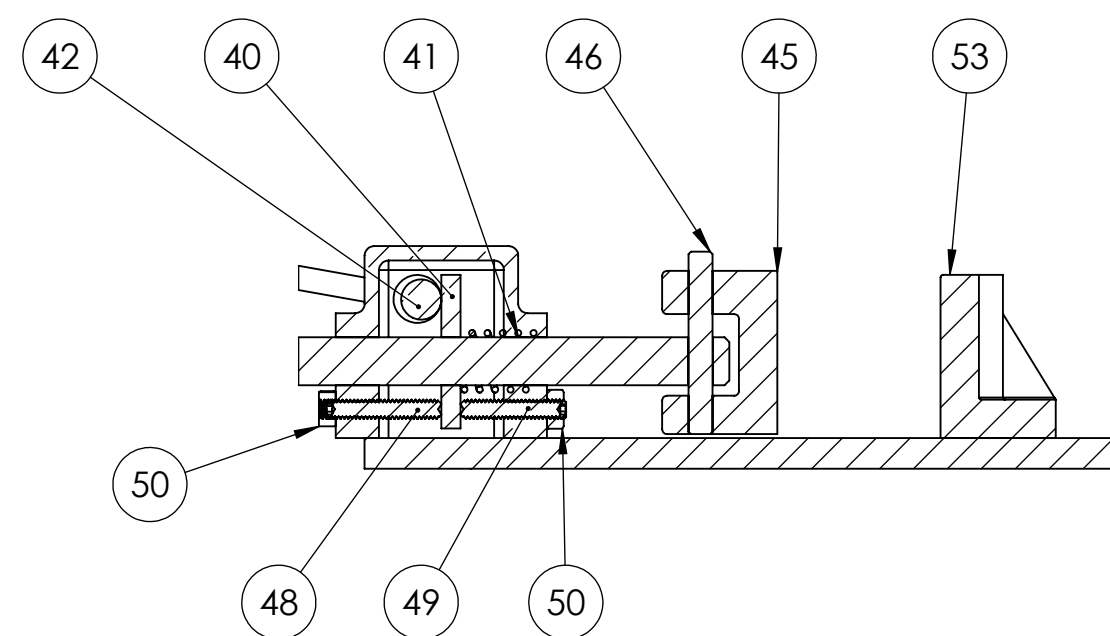
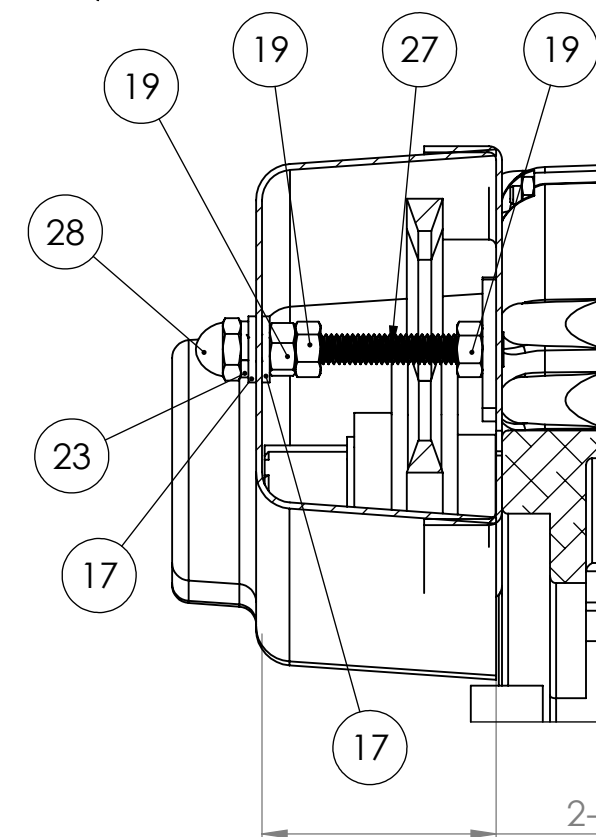
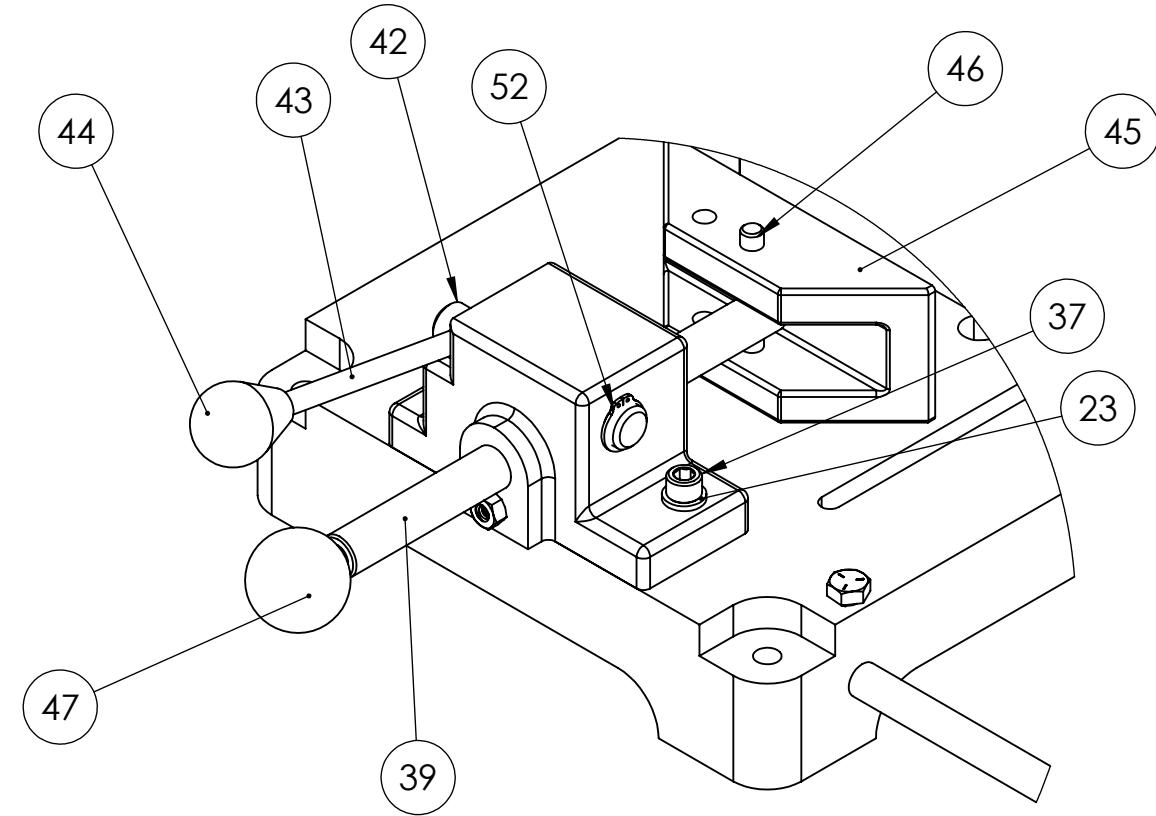
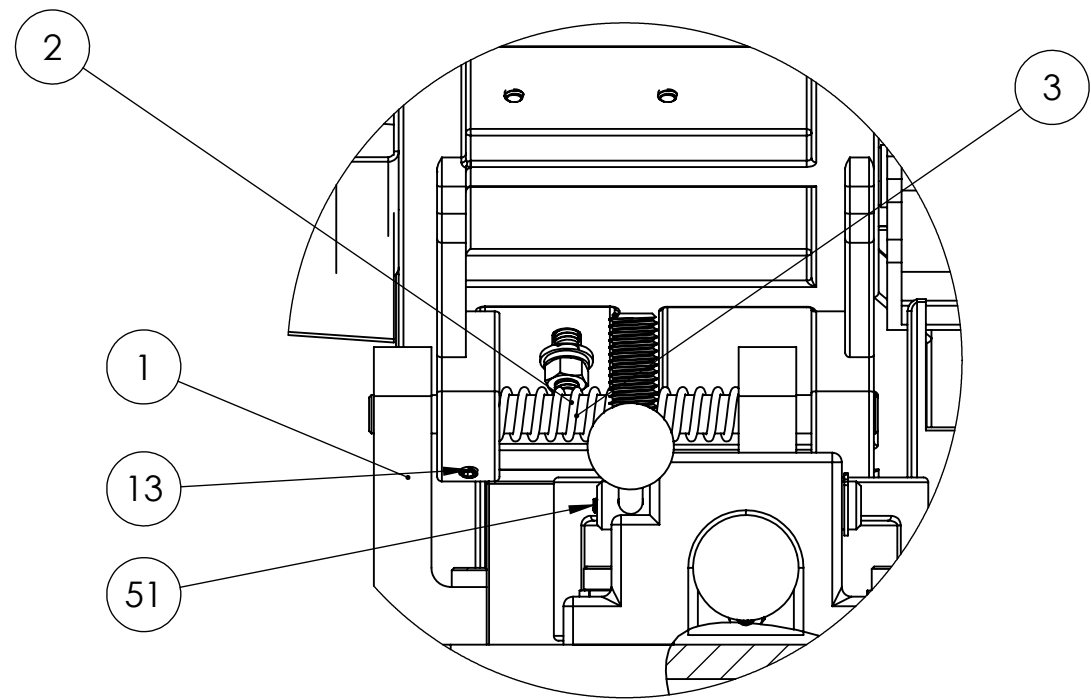
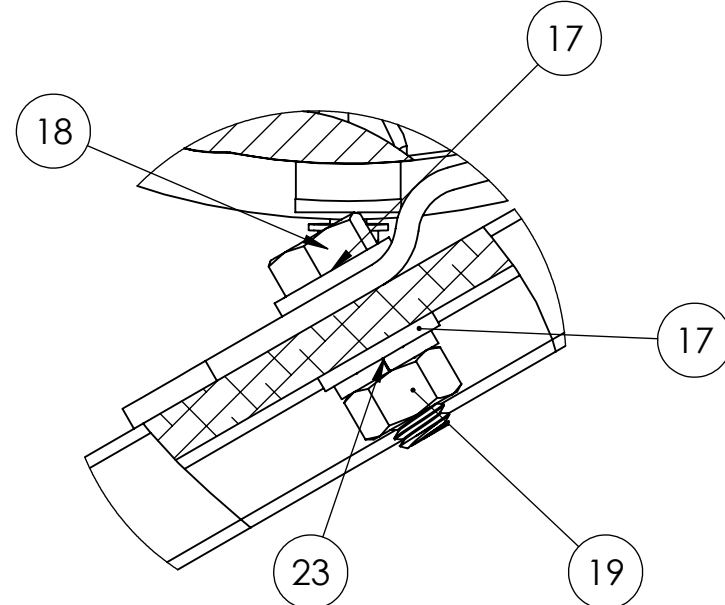
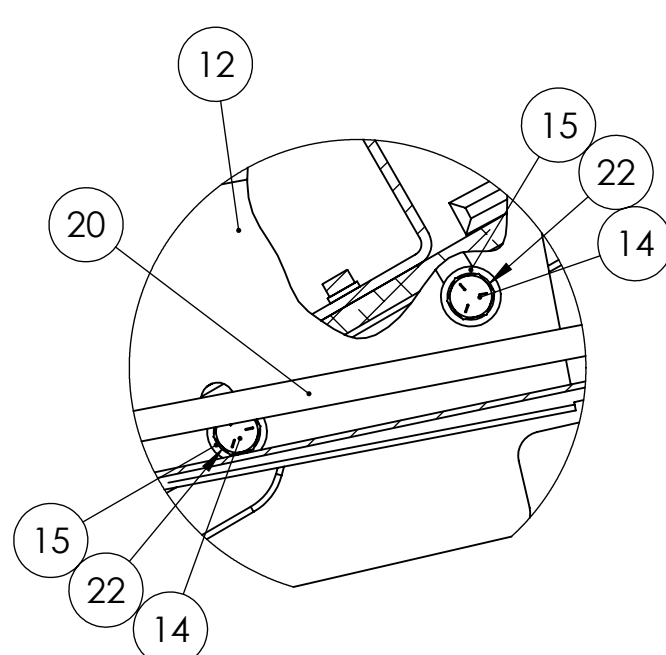
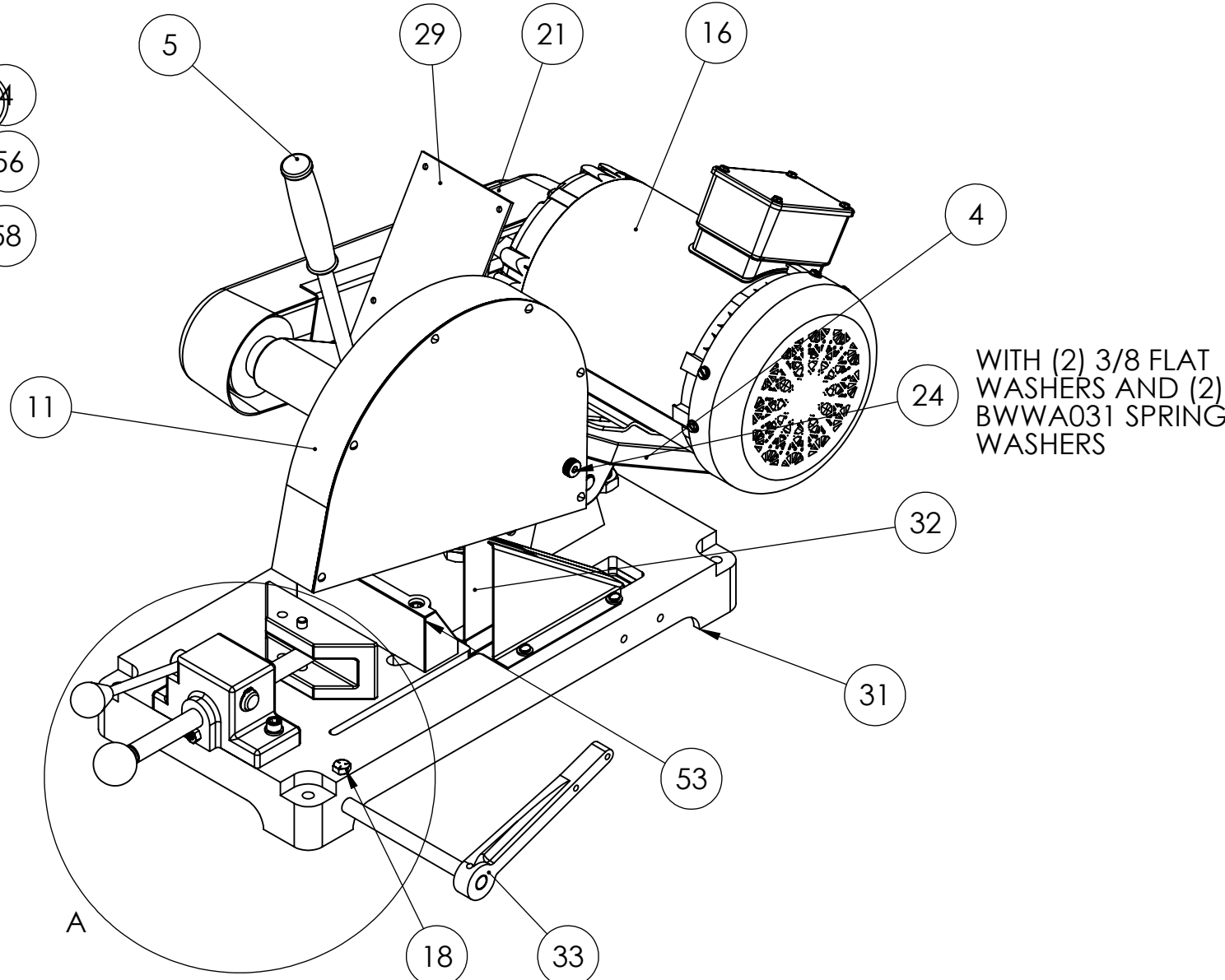
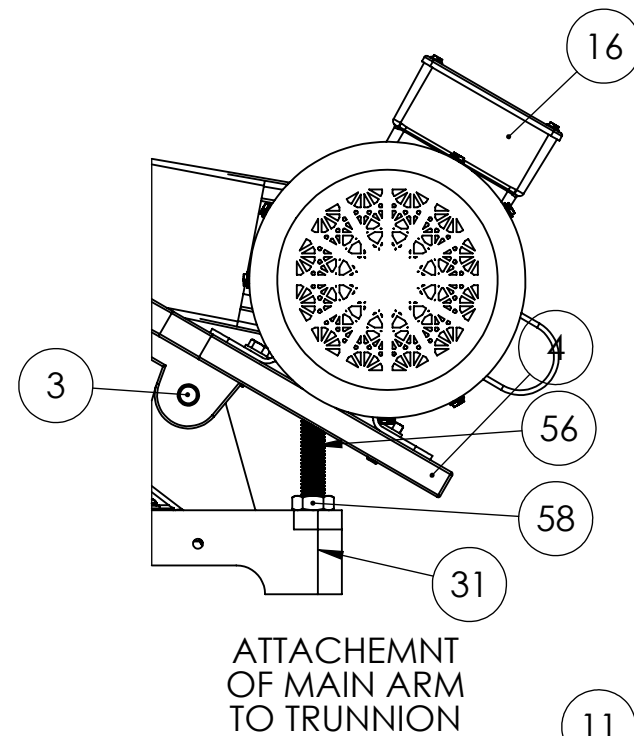
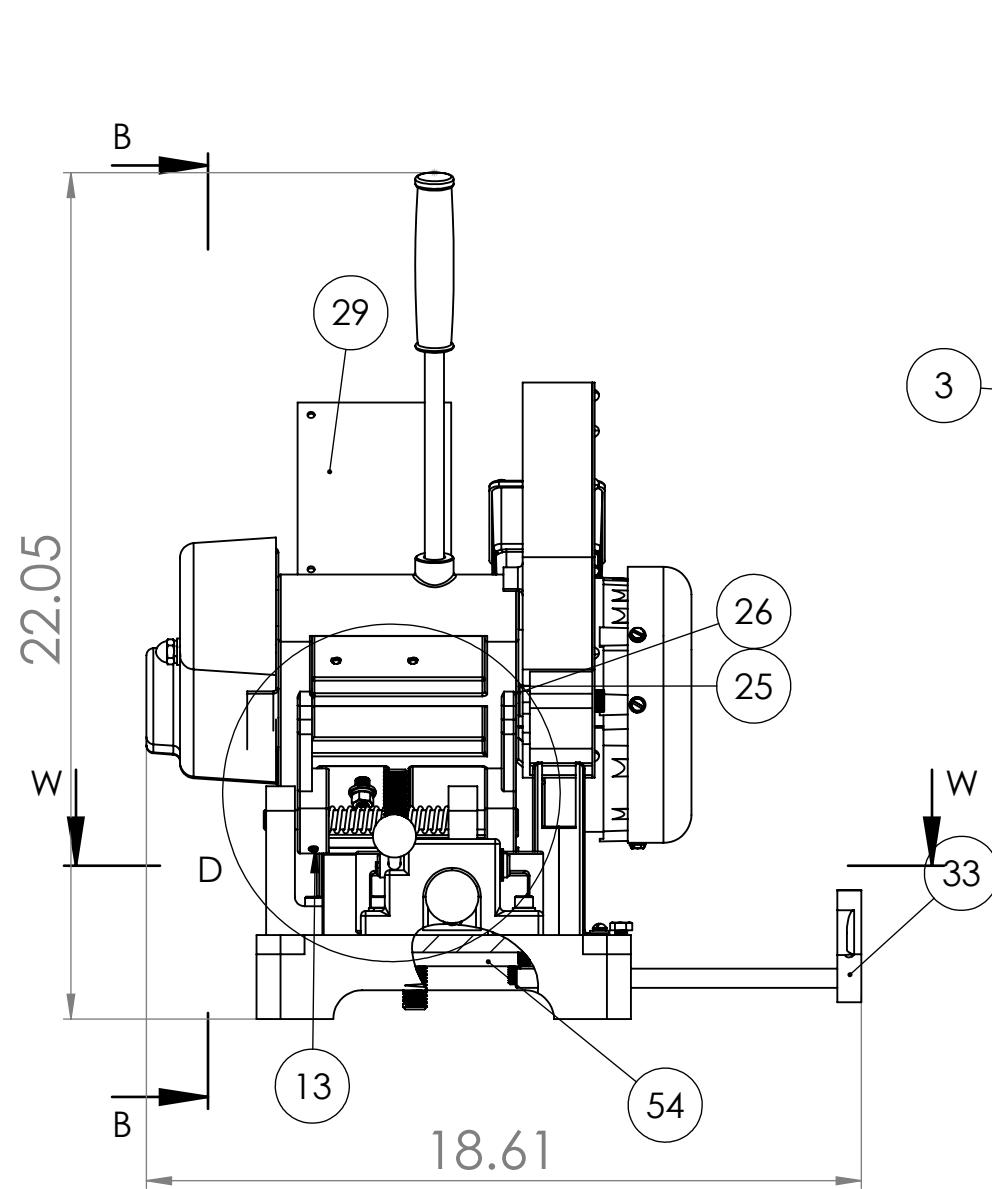
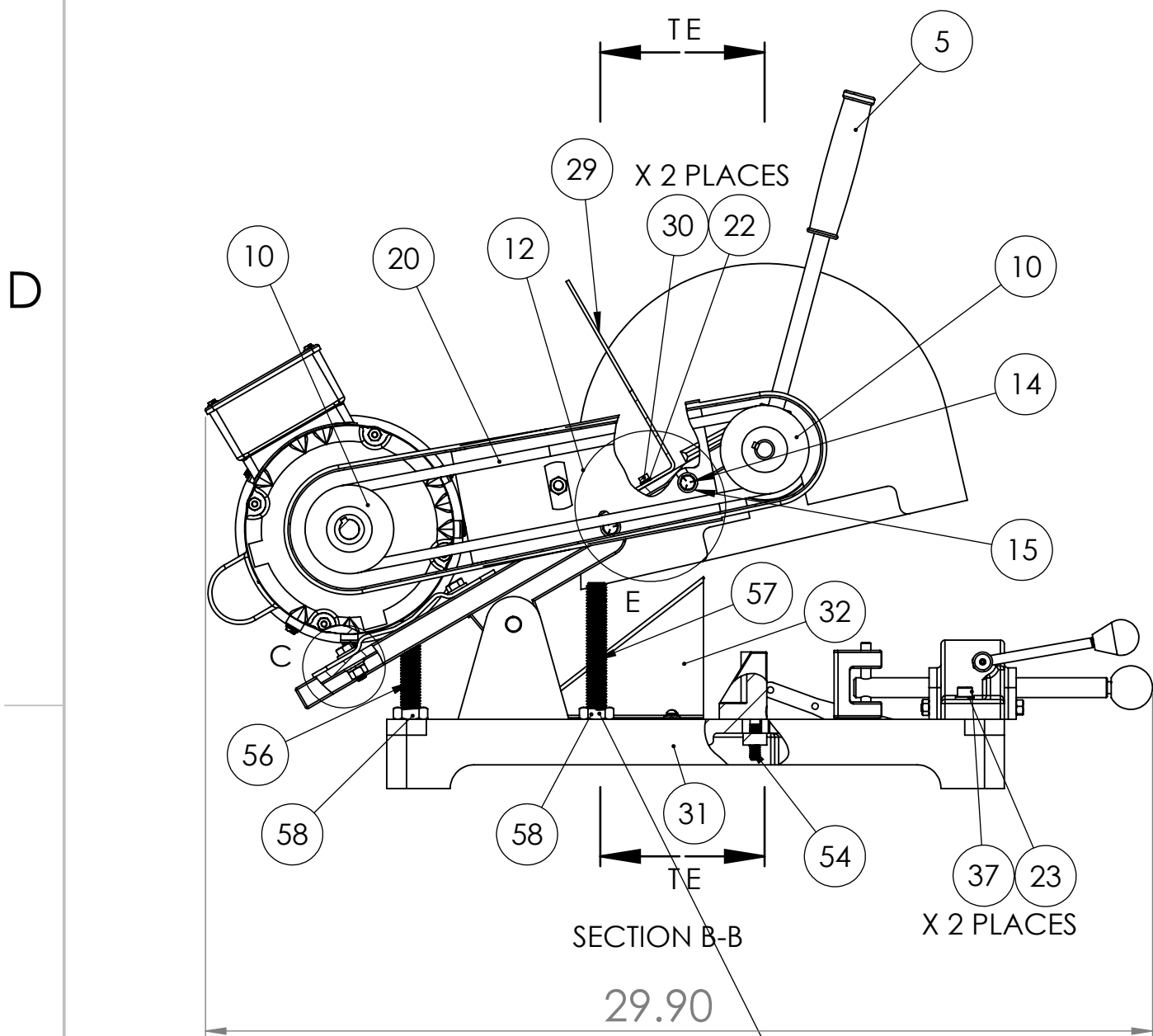
1. Be certain correct wiring is matched to motor.
2. Always keep flanges clean and tight against the abrasive wheel.
3. Be certain work piece is securely clamped in the vise. Any movement in the work piece during cutting will result in broken abrasive cutoff blades.
4. Down stop screw located on saw base (#57) under the saw arm (#4) must be adjusted so the abrasive wheel does not cut into the saw base. Adjust the screw up when installing a new wheel so as not to allow the wheel to cut into the saw base. Keep adjusting the screw down as the wheel wears so you can cut thru the work piece.
5. Keep the blade guard in the down position at all times. Guarding is designed for abrasive blades only. **DO NOT USE STEEL TOOTHED BLADES!!! GUARDING IS NOT DESIGNED FOR STEEL TOOTHED BLADES PER OSHA AND ANSI STANDARDS.**
6. **Saw spindle speed is set at 3,450 SFPM select cutoff wheel that's designed to run at 3,450 SFPM . Contact the wheel manufacturer or dealer for the correct wheel. NOTE: DON'T USE IMPACT GUN TO TIGHTEN SPINDLE NUT.**
7. Always follow safety procedures. Wear safety glasses, never wear gloves or loose fitting clothing that can get caught in the moving parts and tie back loose hair. Always keep hands out of sawing area when cutting. See attached safety sheet.
8. V-belts will stretch with use over time. Keep v-belts tight with 1/2" of "squeeze". Use a v-belt tensioner to tighten v-belt belt. Keep both faces of spindle and motor pulley aligned in the same plane with a straight edge. Check motor and spindle pulleys set prior to operating the machine.

D

C

B

A



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	041-006	TRUNNION BRACKET FOR K10	1
2	697-013	TENSION SPRING FOR 2FS, 2FS72, 2FSM, BG142, 2FS72M, K12-14B	1
3	562-004	TRUNNION PIN FOR K7B, K8B, K10B	1
4	002-001	ALUMINUM SAW ARM FOR K7B, K8B, K10B (TAKES NEW 6202-2RS-1/2 BEARINGS)	1
5	381-003	HANDLE W GRIP FOR K7B, K8B, K10B SAWS	1
6	044-007	K10 BEARING	2
7	701-003	K10 SPINDLE W TIGHT FLANGE	1
10	560-045	K10B, K10SW, KM10 PULLEY	2
9	292-008	LOOSE FLANGE FOR K10B AND 2SK7	1
10	FJNZ063	5/8-18 F H JAM NUT Z	1
11	342-006	WHEEL GUARD FOR K10B SAWS	1
12	342-027	K10B INNER GUARD BELT BRACKET	1
13	SSKA025008	1/4-20 X 1/2 SOC SET KNURL PT.	1
14	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	2
15	UFWZ025	1/4 USS F/W Z	2
16	486-006	3 HP MOTOR FOR FOR K8B, K10B, KM10, BG260H AND S460W	1
17	UFWZ031	5/16 USS F/W Z	8
18	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
19	FHN5031	5/16-18 FHN GR5 ZINC	6
20	051-003	V-BELT FOR K10, KM10, S6MW, S460W	1
21	342-043	K10B, KM10 PLASTIC OUTER BELT GUARD	1
22	SLWZ025	1/4 SPLIT L/W Z	4
23	SLWZ031	5/16 SPLIT L/W Z	6
24	SSBA031006	5/16 X 3/8 SOC SHOULDER BOLT	1
25	UFWZ037	3/8 USS F/W Z	1
26	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
27	RND-5/16-18 THRD RODX3	3 INCHES OF 5/16-18 THREADED ROD	1
28	CPNZ031	5/16-18 CAP NUT NICKEL	1
29	041-050	SWITCH BRACKET FOR K8B AND K10B	1
30	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	2
31	050-008	K10 BASE	1
33	709-002	WORK STOP FOR K10B	1
34	SRMZ011008	10-24 X 1/2 SLT ROUND MS Z	4
35	MSWZ010	#10 M.S. F/W Z	4
36	SLWZ010	#10 SPLIT L/W Z	4
37	SHCA031024	5/16-18 X 1-1/2 SHCS	6
38	386-001	K10-16 VISE HOUSING	1
39	645-001	K10-16 SHORT VISE ROD	1
40	454-001	K10-16 VISE CAM PLATE	1
41	697-001	K10-16 VISE ROD SPRING	1
42	129-001	K10-16 VISE CAM	1
43	381-001	K10- 16 VISE HANDLE	1
44	441-002	K10-16 VISE LOCK HANDLE KNOB	1
45	431-001	FRONT VISE JAW K10, K14, KM14	1
46	562-001	VISE JAW PIN FOR K10B, K12B, K14B, KM16-18 VISE ASSEMBLIES	1
47	441-001	K10- 16 VISE ROD KNOB	1
48	SSSA025024	1/4-20 X 1-1/2 SOC SET CUP PT.	1
49	SSSA025022	1/4-20 X 1-3/8 SOC SET CUP PT.	1
50	FHN5025	1/4-20 FHN GR5 Z	2
51	SSKA010004	10-24 X 1/4 SOC SET KNURL PT	1
52	641-016	RETAINING RING FOR S6, S460W, S612	1
53	431-002	K10- 14 REAR VISE JAW	1
54	537-014	K10-14 FENCE NUT	1
55	SHCA031048	5/16-18 X 3 SHCS	2
56	RND-5/8-11 THRD RODX4.	4-1/2 INCHES OF 5/8-11 THREADED ROD	1
57	RND-5/8-11 THRD RODX5.5	5-1/2 INCHES OF 5/8-11 THREADED ROD	1
58	FJNZ062	5/8-11 F H JAM NUT Z	2
59	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	1

PROPRIETARY AND CONFIDENTIAL
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UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± ANGULAR: MACH ± BEND ± TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	DRAWN CHECKED ENG APPR. MFG APPR.	NAME DATE	KALAMAZOO INDUSTRIES, INC.
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL	FINISH	Q.A. COMMENTS:	TITLE: MODEL K10 B
NEXT ASSY USED ON APPLICATION	DO NOT SCALE DRAWING	SIZE DWG. NO. D K10 B	REV SCALE: 1:5 WEIGHT: SHEET 1 OF 1