KALAMAZOO INDUSTRIES, INC.

Instruction Manual

K12-14B 14″ Heavy Duty Abrasive Chop Saw

Kalamazoo Industries, Inc.
6856 E K Ave
Kalamazoo, Michigan
1-800-592-2050
www.kalamazooind.com

Serial Number: _____

Purchase Date: _____

Purchased From: _____

1. Introduction

Kalamazoo Industries thanks you for your purchase of the K12-14B 14″ Heavy Duty Abrasive Chop Saw. Engineered for demanding industrial environments, the K12-14B delivers reliable, high-speed abrasive cutting through mild steel, stainless steel, pipe, tubing, and structural shapes in fabrication, HVAC, and manufacturing applications.

The K12-14B is powered by a 5 HP industrial motor — available in single-phase 230V or three-phase 230V/460V configurations — and operates with a 14″ abrasive wheel at 4,400 spindle RPM. Its extra-heavy cast iron base, sealed spindle ball bearings, and cam lock vise deliver the stability and precision required for continuous production cutting.

This manual must be read in its entirety prior to installation, commissioning, or operation of the equipment. Thorough familiarity with the unit's capabilities, safety requirements, and prescribed maintenance procedures is essential to safe operation and optimal performance.

1.1 Intended Use

The K12-14B is designed for dry abrasive cutting of metals in industrial settings. Suitable applications include, but are not limited to:

- Cutting mild steel round stock, bar stock, flat stock, and angle iron to length
- Cutting structural steel shapes including beams, channels, and angles
- Cutting mild steel pipe and tubing up to 3″ diameter
- Cutting stainless steel with appropriate abrasive wheel selection
- HVAC and mechanical piping fabrication

⚠ **WARNING:** The K12-14B is designed for DRY abrasive cutting of metal only. It must not be used to cut wood, plastics, masonry, or non-metallic materials. Do not use cutting coolant or liquids during operation.

2. Safety Information

⚠ **WARNING:** TO REDUCE THE RISK OF FIRE, ELECTRIC SHOCK, OR PERSONAL INJURY, ALL SAFETY INSTRUCTIONS MUST BE READ AND UNDERSTOOD BEFORE OPERATING THIS EQUIPMENT. Non-compliance with these guidelines may result in serious injury or death.

2.1 General Safety Precautions

1. Appropriate personal protective equipment (PPE) must be worn at all times during operation, including safety glasses or a face shield, hearing protection, and flame-resistant clothing.
2. The work area must be kept clean, organized, and adequately illuminated at all times.
3. This equipment must not be operated by personnel who are under the influence of drugs, alcohol, or any medication that may impair judgment or reaction time.
4. Never reach under or around the wheel guard while the machine is in operation.
5. Power must be disconnected prior to performing maintenance, changing wheels, or servicing any component.
6. The unit must be positioned on a level, stable surface always during operation.
7. Always secure workpieces firmly in the cam lock vise before initiating a cut. Never attempt to cut freehand.
8. Unauthorized personnel must be kept clear of the operating machine at all times.
9. Be aware that sparks and hot material chips are generated during cutting. Ensure no flammable materials are present in the cutting area.

2.2 Abrasive Wheel Safety

⚠ **WARNING:** INSPECT THE ABRASIVE WHEEL BEFORE EACH USE. A damaged, cracked, or incorrectly mounted wheel can shatter at operating speed, causing severe injury or death.

- Use only 14″ abrasive wheels rated for a minimum of 4,400 RPM or higher.
- Inspect the abrasive wheel for cracks, chips, or deformation before mounting. Never use a damaged wheel.
- Ensure the wheel arbor bore matches the machine’s 1″ arbor (or 1.25″ if spindle arbor option was specified).
- Never use a wheel that has been dropped, subjected to thermal shock, or exposed to moisture.
- Tighten the wheel arbor nut securely using the KW1 spindle wrench. Do not over-tighten.
- After installing a new wheel, allow the machine to run unloaded for one minute before cutting to verify safe operation.

2.3 Electrical Safety

- The machine must be properly grounded prior to operation in accordance with applicable electrical codes.
- Voltage requirements must be confirmed against the facility's power supply before making any electrical connections.
- All electrical installation and repair work must be performed by a qualified electrician.
- The unit must not be operated if wiring or electrical components show signs of damage or deterioration.
- The magnetic on/off switch provides drop-out protection in the event of a power interruption. Do not bypass or defeat this safety feature.

2.4 Fire and Spark Safety

- Abrasive cutting generates significant sparks. Keep flammable and combustible materials well clear of the cutting zone.
- A fire extinguisher appropriate for metal fires must be readily accessible in the work area.
- Allow cut material and waste to cool completely before handling or disposal.

3. Technical Specifications

3.1 Motor and Performance

Description	Details
Motor Power	5 HP
Phase Options	1 PH 230V, 3 PH 230V, or 3 PH 460V (specify at time of order)
1 PH Full Load Amps	230V: 19.5A
3 PH Full Load Amps	230V: 12A / 460V: 6A
Spindle RPM	4,400 RPM
Wheel Size	14″ (355mm) abrasive wheels only
Wheel Arbor	1″ standard (1.25″ spindle arbor option available)

3.2 Cutting Capacity

Description	Details
Solid Round Stock	2.5″ maximum (based on mild steel)
Pipe and Tubing	Up to 3″ diameter (based on mild steel)
Flat Stock / Angle Iron	Per wheel capacity and material type
Abrasive Wheels	Not included — sold separately

3.3 Construction

Description	Details
Base	Extra-heavy cast iron base
Trunnion	Extra-heavy cast iron trunnion
Saw Arm	Extra-heavy cast iron saw arm
Bearings	Sealed spindle ball bearings
Wheel Guard	Steel-hinged wheel guard
Drive System	Dual V-belt drive with replaceable guard
Vise	Cam lock vise with replaceable jaws
Switch	Magnetic on/off push button switch (drop-out protection)
Backstop	Adjustable backstop for repeatable cuts

3.4 Dimensions and Weight

Description	Details
Shipping Length	38″
Shipping Width	36″
Shipping Height	36″
Shipping Weight	250 lbs. (crated)
Country of Origin	Made in the USA

Note: Shipping weights and dimensions are subject to change.

4. Features and Components

4.1 Key Features

5 HP Industrial Motor

The K12-14B is powered by a 5 HP industrial-grade motor available in single-phase 230V or three-phase 230V/460V configurations. The motor delivers consistent power to maintain 4,400 RPM spindle speed throughout heavy production cutting cycles, ensuring reliable performance on mild steel, stainless steel, and structural shapes.

Extra-Heavy Cast Iron Construction

The base, trunnion, and saw arm are constructed from extra-heavy cast iron, providing the mass and rigidity necessary to minimize vibration and maintain cut accuracy during demanding production runs. The substantial machine weight contributes to stability without requiring floor anchoring for routine use.

Cam Lock Vise with Replaceable Jaws

The cam lock vise provides rapid, secure clamping of workpieces with a single lever action. The vise jaws are field-replaceable, allowing continued operation without major service when jaw wear occurs. Consistent clamping ensures square, repeatable cuts across production runs.

Magnetic On/Off Push Button Switch

The magnetic on/off switch provides drop-out protection — in the event of a power interruption, the switch automatically drops out and must be manually re-engaged before the machine can restart. This critical safety feature prevents unexpected restart following power restoration.

Sealed Spindle Ball Bearings

Factory-sealed spindle ball bearings provide long service life with minimal maintenance. The sealed design protects bearing surfaces from abrasive dust contamination generated during cutting operations.

Dual V-Belt Drive System

The dual V-belt drive efficiently transfers motor power to the spindle with the shock absorption characteristics necessary for abrasive cutting. V-belt guards are field-replaceable, and belt inspection and replacement can be performed on-site without specialized tooling.

Adjustable Backstop

The adjustable backstop controls how far or how close the saw blade is to the material being cut, allowing the operator to position the workpiece at the precise cutting point before clamping.

Steel-Hinged Wheel Guard

The steel-hinged wheel guard provides passive guarding of the abrasive wheel during operation. The guard must always be fully functional. Never operate the machine with a missing, damaged, or defeated wheel guard.

5. Installation and Setup

5.1 Unpacking and Inspection

10. Remove all packaging materials carefully and thoroughly inspect the unit for any damage sustained during transit.
11. Verify that all components are present and accounted for against the packing list included with the shipment.
12. Any shipping damage or discrepancies in received components must be reported to Kalamazoo Industries immediately.
13. Remove any protective coatings or coverings from machined and finished surfaces prior to installation.

5.2 Location Requirements

- The unit must be installed on a level, stable surface of sufficient load-bearing capacity.
- Adequate clearance must be maintained on all sides to permit safe operation, material handling, and routine maintenance access.
- The installation area must be well-lit and adequately ventilated. Abrasive cutting generates metal dust and sparks that require proper ventilation management.
- Optional 12-L steel legs (sold separately) may be installed to bring the machine to a convenient working height.
- The unit must be kept clear of water, cutting coolant, and any other liquids at all times.

5.3 Electrical Connection

CAUTION: All electrical connections must be carried out by a qualified electrician and must comply with applicable local, state, and national electrical codes.

14. Confirm that the facility power supply voltage corresponds to the K12-14B configuration ordered. The unit is available in 1 PH 230V, 3 PH 230V, or 3 PH 460V.
15. Connect the unit to a properly rated circuit with appropriate overcurrent protection. Refer to Section 3.1 for full-load amperage values by voltage.
16. Verify that the unit is correctly grounded in accordance with applicable electrical code requirements.
17. Confirm correct motor rotation direction prior to full commissioning. On 3-phase units, reverse any two power leads to correct rotation direction.

5.4 Abrasive Wheel Installation

⚠ **WARNING:** Disconnect power at the source before installing or changing the abrasive wheel. Failure to do so may result in serious injury or death.

18. Disconnect power from the machine.
19. Verify the wheel is rated for at least 4,400 RPM and is designed for the material you will be cutting.
20. Install the wheel on the 1″ spindle arbor (or optional 1.25″/32mm arbor if equipped).
21. Secure with the flange and arbor nut, tightening snugly with the KW1 spindle wrench only.
22. Reconnect power and verify proper wheel rotation. The wheel must rotate clockwise when viewed from the operator position. On 3-phase units, if rotation is incorrect, disconnect power and swap any two of the three power leads to reverse the motor direction.

5.5 V-Belt Inspection and Tensioning

The K12-14B uses V-belts to transfer power from the motor to the spindle. Proper belt tension and pulley alignment are critical for consistent cutting performance and belt longevity.

⚠ **WARNING:** New V-belts will stretch during initial use and must be re-checked and re-tensioned after approximately 8 hours of cutting time.

Checking Belt Tension

23. Disconnect power from the machine.
24. Access the belt area through the rear maintenance access panel.
25. Press on the top span and bottom span of the V-belt. Each span should have approximately 1/4″ of squeeze (deflection) under moderate finger pressure.
26. If the belt is too loose or too tight, adjust the tension as described below.

Checking Pulley Alignment

27. The motor pulley and the spindle pulley must be parallel and aligned in the same plane.
28. Check alignment by placing a straight edge across the faces of both pulleys. The straight edge should contact both pulleys evenly without gaps.
29. If the pulleys are misaligned, loosen the motor mounting bolts and reposition the motor until the pulleys are parallel, then re-tighten.

Adjusting Belt Tension

30. Slightly loosen the motor mounting bolts — just enough to allow the motor to be moved. Do not fully remove the bolts.
31. Use the 051-035 belt tensioning tool to adjust the motor position until the correct 1/4″ squeeze is achieved on both the top and bottom spans of the belt.
32. Re-check pulley alignment with a straight edge after repositioning the motor.
33. Tighten all motor mounting bolts securely.
34. Reconnect power and briefly run the machine to verify smooth, vibration-free belt operation.

CAUTION: After installing new V-belts, re-check tension after approximately 8 hours of cutting. New belts will stretch during the break-in period and may require re-tensioning.

6. Operation Instructions

6.1 Pre-Operation Checklist

- Inspect the abrasive wheel for cracks, chips, or deformation. Do not use a damaged wheel.
- Confirm the wheel guard is fully functional, properly positioned, and secured.
- Inspect the cam lock vise and vise jaws for damage or excessive wear.
- Verify that the dual V-belt guard is in place and secured.
- Check the work area — remove flammable materials, confirm adequate lighting and ventilation.
- Verify that the facility power supply is consistent with the unit's voltage configuration.
- Don all required personal protective equipment before commencing operation.

6.2 Operating Procedure

35. Place the workpiece in the cam lock vise and position it against the adjustable backstop if cut-to-length repeatability is required.
36. Engage the cam lock vise firmly to secure the workpiece. Verify that the material cannot shift during the cut.
37. Energize the K12-14B using the magnetic on/off push button switch.
38. Allow the machine to reach full operating speed before beginning the cut.
39. Lower the saw arm smoothly and with consistent pressure to feed the wheel through the workpiece. Do not force the cut — allow the abrasive wheel to do the work.
40. Upon completion of the cut, raise the saw arm fully before releasing the workpiece from the vise.
41. De-energize the machine using the push button switch upon completion of cutting operations.
42. Allow cut material and spark debris to cool completely before handling.

6.3 Operating Recommendations

- Match the abrasive wheel type to the material being cut. Contact Kalamazoo Industries at 1-800-592-2050 for wheel recommendations specific to your application.
- Apply consistent, steady downward pressure during the cut. Excessive force accelerates wheel wear and increases the risk of wheel damage.
- Use the adjustable backstop for batch cutting to maximize repeatability and reduce setup time.
- Inspect the abrasive wheel periodically during extended production runs. Replace the wheel when wear reduces diameter to the minimum safe operating size.
- Under no circumstances should wet, oily, or liquid-contaminated materials be cut using this unit.

7. Maintenance

Adherence to a regular maintenance schedule is essential to the long-term reliability and performance of the K12-14B. The following procedures outline the minimum recommended maintenance intervals for this unit.

7.1 Daily Maintenance

- Inspect the abrasive wheel for cracks, chips, edge wear, or deformation. Remove from service if any defects are identified.
- Remove accumulated abrasive dust and metal debris from the machine base, trunnion, and vise using a brush or compressed air.
- Inspect the cam lock vise and vise jaws for wear or damage. Verify that the cam lock mechanism engages and holds firmly.
- Verify that the wheel guard opens and closes freely and is properly secured.

7.2 Weekly Maintenance

- Thoroughly clean all cast iron surfaces to remove accumulated abrasive dust. Apply a light coat of machine oil to unpainted surfaces to prevent rust.
- Inspect and clean the V-belt drive system. Refer to Section 5.5 for belt tension and pulley alignment procedures. Replace worn or frayed belts.
- Inspect the adjustable backstop for wear or loosening. Verify that it holds position under clamping force.
- Inspect the saw arm pivot and return spring for proper function. The arm should return smoothly to the rest position.
- Inspect and tighten all accessible fasteners.

⚠ **WARNING:** The abrasive wheel must be inspected after extended production runs and replaced when wear reduces the wheel diameter to the minimum safe operating size marked on the wheel or guard.

7.3 Monthly Maintenance

- Inspect the motor housing for dust accumulation and clean as necessary to prevent overheating.
- Inspect all wiring and electrical connections for signs of wear, heat damage, or loosening.
- Inspect the spindle arbor and flanges for wear, damage, or debris. Clean and confirm proper seating.
- Lubricate saw arm pivot points per manufacturer recommendations if equipped with grease fittings.

7.4 Abrasive Wheel Replacement Procedure

⚠ **WARNING:** Disconnect power from the K12-14B at the source prior to commencing any wheel service. Failure to disconnect power before wheel changes may result in serious injury.

43. Disconnect power at the source and allow the machine to come to a complete stop.
44. Open the steel-hinged wheel guard to access the spindle arbor.
45. Use the KW1 spindle wrench to loosen and remove the arbor nut.
46. Remove the outer flange and worn abrasive wheel.
47. Inspect the inner flange, outer flange, and spindle arbor for damage or debris. Clean all contact surfaces.
48. Install the new 14″ abrasive wheel, ensuring flanges are properly seated. Confirm the wheel bore matches the arbor diameter.
49. Tighten the arbor nut securely using the KW1 spindle wrench.
50. Close and secure the wheel guard.
51. Restore power and run the machine unloaded for one minute before making cuts.

CAUTION: Appropriate respiratory protection must be worn during all maintenance operations involving abrasive dust. Fine metal and abrasive particulates may present an inhalation hazard.

8. Troubleshooting

Problem	Possible Cause / Solution
Motor will not start	Verify power supply connections and confirm the circuit breaker has not tripped. Check that the supply voltage matches the unit's configured rating. Inspect the magnetic switch for faults. Confirm the switch has not dropped out — press the ON button firmly.
Motor runs but wheel does not spin	Inspect the V-belt drive for broken or slipped belts. Check belt tension and confirm belts are properly seated on both pulleys. Replace damaged belts as required.
Reduced cutting speed / wheel stalls	Check motor voltage — low voltage will reduce motor torque. Inspect V-belts for slippage or wear. Verify the wheel is appropriate for the material being cut. Reduce feed pressure during the cut.
Excessive wheel wear	Confirm the wheel type is correct for the material. Reduce feed pressure. Inspect the spindle arbor and flanges for proper seating. Avoid forcing the cut.
Rough or uneven cuts	Inspect the abrasive wheel for uneven wear or damage. Verify that the workpiece is firmly clamped in the vise without movement. Replace a worn wheel.
Excessive vibration or noise	Inspect the abrasive wheel for damage, deformation, or incorrect mounting. Verify all fasteners are tight. Confirm the machine is positioned on a level, stable surface. Inspect V-belts and pulleys for wear.
Wheel guard does not open / close properly	Inspect the hinge and guard mechanism for damage or debris. Clean and lubricate hinge points. Replace damaged guard components.
Cam lock vise will not hold workpiece	Inspect vise jaws for excessive wear. Replace vise jaws as required. Verify the cam lock mechanism is engaging fully.
Machine will not restart after power interruption	The magnetic drop-out switch has de-energized as designed. Press the ON button to restart. This is a normal safety function, not a fault.

9. Replacement Parts

Genuine Kalamazoo Industries replacement parts are maintained in stock and shipped directly from Kalamazoo, Michigan. All components of the K12-14B are serviceable and replaceable regardless of the age of the unit. The use of genuine replacement parts is strongly recommended to ensure continued performance, reliability, and warranty compliance.

9.1 Available Replacement Parts

Description	Details
KW1 Spindle Wrench (14″ Saws)	KW1
12-L Steel Legs (14″ Saws)	12-L
Replacement Cam Lock Vise Jaws	912-015
V-Belt Drive Belts	051-006
Replacement Wheel Guard	342-025

9.2 Ordering Parts

Replacement parts may be ordered by contacting Kalamazoo Industries directly or through the online parts store at www.kalamazooind.com/parts-by-category. Please have the machine model number (K12-14B) available when placing an order to ensure accurate part selection.

10. Warranty Information

10.1 Warranty Coverage

All parts are warranted for one year from the original date of purchase to the original purchaser. This warranty covers the replacement of parts found to be defective in material or workmanship under normal use. Some exclusions may apply.

10.2 Warranty Exclusions

This warranty does not cover:

- Normal wear items including abrasive wheels, belts, and bearings.
- Damage resulting from misuse, abuse, or improper maintenance.
- Damage from cutting inappropriate materials.
- Modifications or alterations to the machine.
- Damage caused by improper electrical connection or voltage supply.
- Labor or installation costs.

This warranty is non-transferable and applies only to the original purchaser.

10.3 Return Authorization

A Return Authorization (RA) number must be obtained before returning any merchandise. Contact Customer Service at 1-800-592-2050 to request authorization. Items returned without prior authorization may not be accepted.

- Return shipping costs are the responsibility of the customer.
- Credit will be issued upon inspection of the returned item.
- A 10% restocking fee applies to all returns.
- The restocking fee is waived if a replacement order is placed on the same day the return is initiated.

11. Contact Information

KALAMAZOO INDUSTRIES, INC.
Kalamazoo, Michigan

www.kalamazooind.com
Office Hours: Monday – Friday, 8:00 AM – 4:30 PM EST

Online Resources

- Product Registration: www.kalamazooind.com/product-registration
- Parts Orders: www.kalamazooind.com/parts-by-category
- Technical Videos: www.kalamazooind.com/videos
- Contact Form: www.kalamazooind.com/contact-us

Thank you for choosing Kalamazoo Industries!

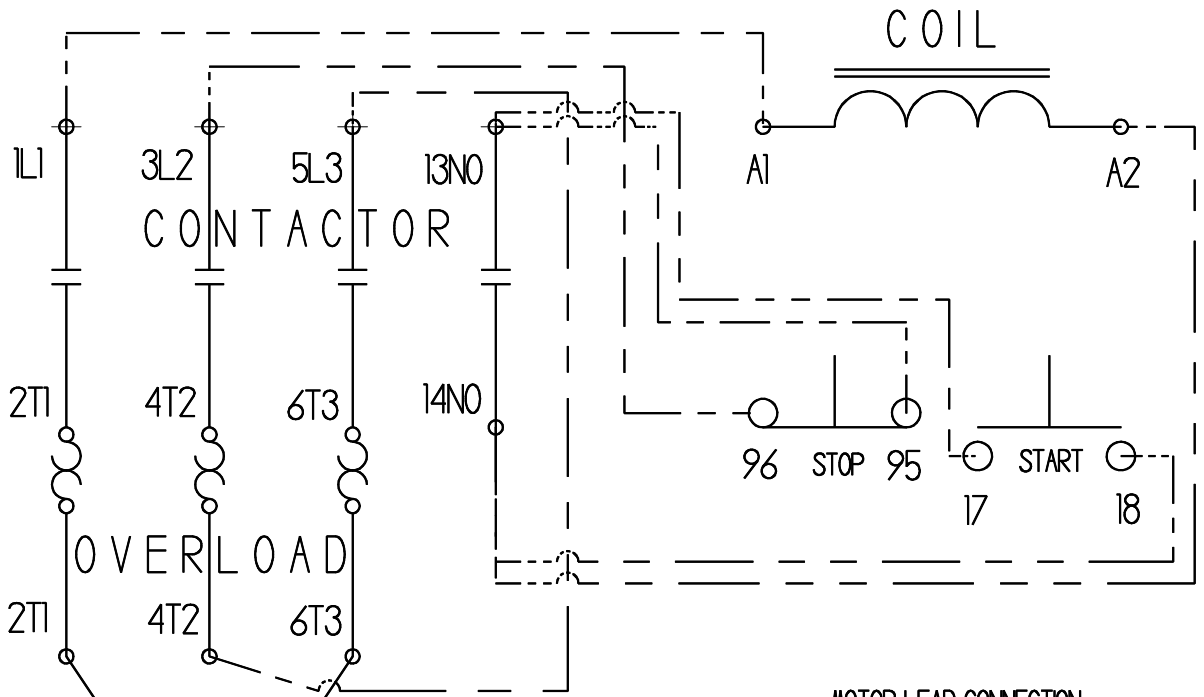
Made in the USA

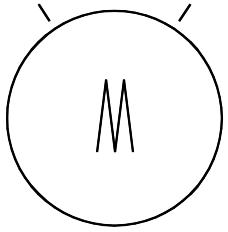
Maintenance Log

Record all maintenance, inspections, and service activities below. This log should accompany the unit for the duration of its service life.

Date	Performed By	Service Description	Notes / Parts Used	Sign Off

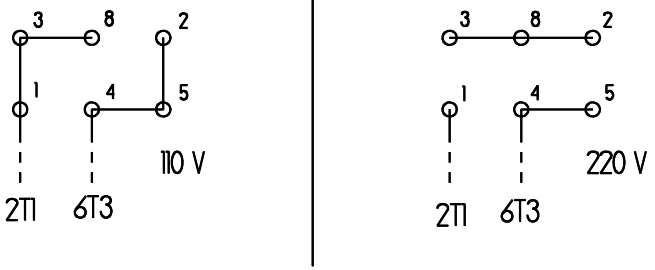
INCOMING LINE VOLTAGE
CONNECTS TO 1L1 AND 3L2





SINGLE PHASE MOTOR

MOTOR LEAD CONNECTION



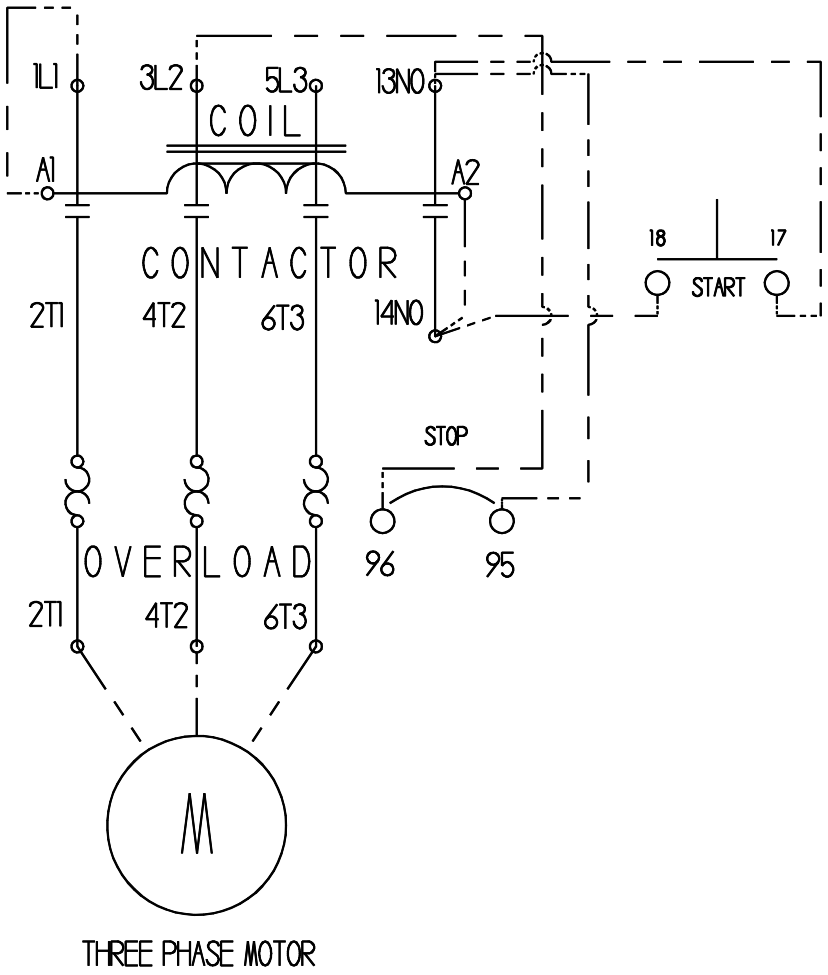
INTERCHANGE #5 AND #8 LEADS
TO REVERSE ROTATION

Y
X

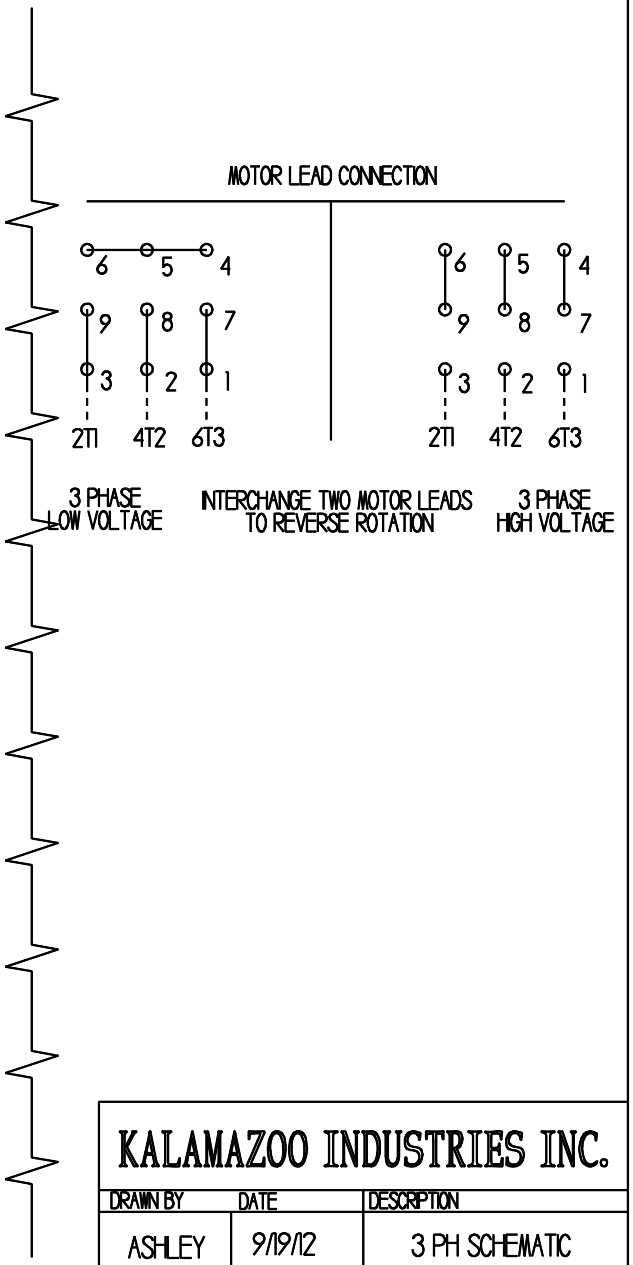
KALAMAZOO INDUSTRIES INC.		
DRAWN BY	DATE	DESCRIPTION
ASHLEY	08/22/12	1 PH SCHEMATIC
REVISED BY	DATE	PART #
MATERIAL		

inch

INCOMING LINE VOLTAGE
CONNECTS TO 1L1, 3L2, AND 5L3



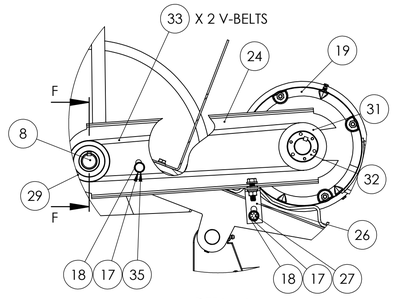
THREE PHASE MOTOR



KALAMAZOO INDUSTRIES INC.		
DRAWN BY	DATE	DESCRIPTION
ASHLEY	9/19/12	3 PH SCHEMATIC
REVISED BY	DATE	PART #
MATERIAL		

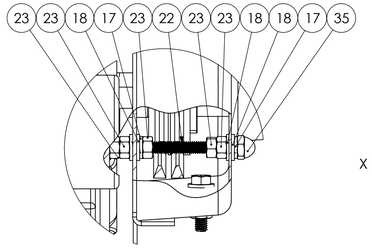
Y
X

inch



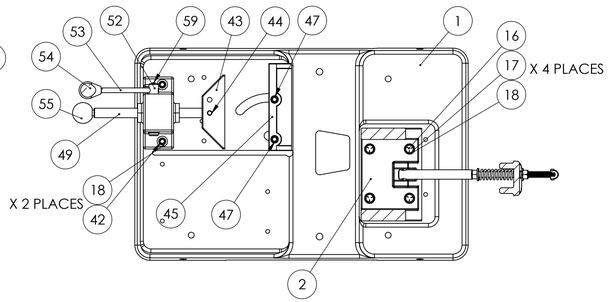
DETAIL A
SCALE 1 : 5

PULLEYS, BELTS,
AND GUARD
DETAIL



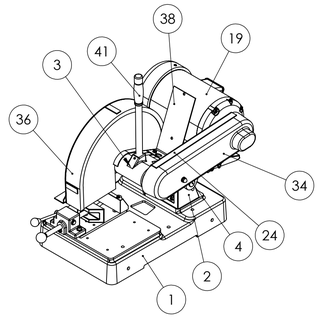
DETAIL E
SCALE 1 : 2

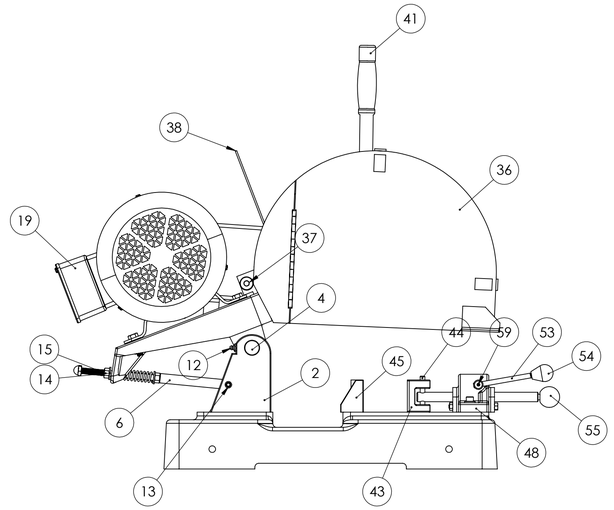
ATTACH PLASTIC GUARD

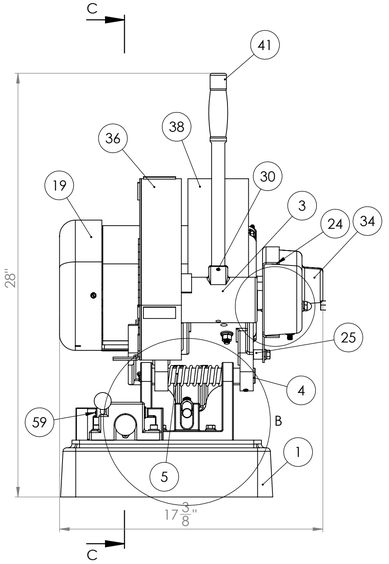


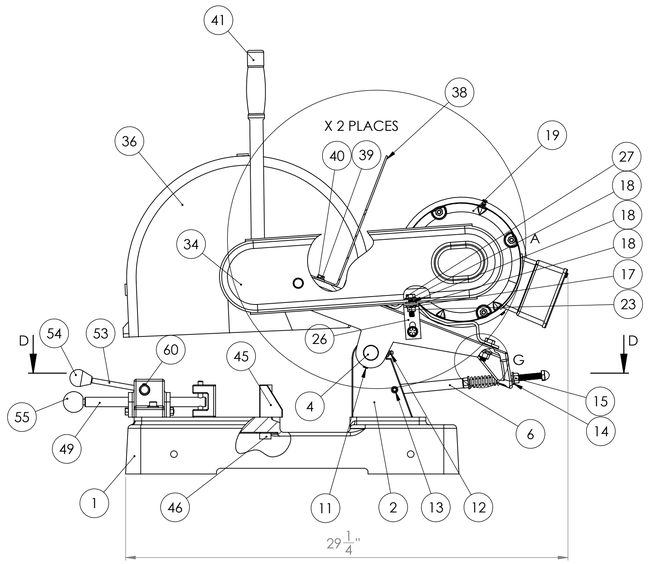
SECTION D-D
SCALE 1 : 5

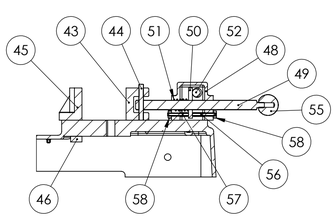
PIVOT BLOCK AND
VISE MOUNTING DETAILS





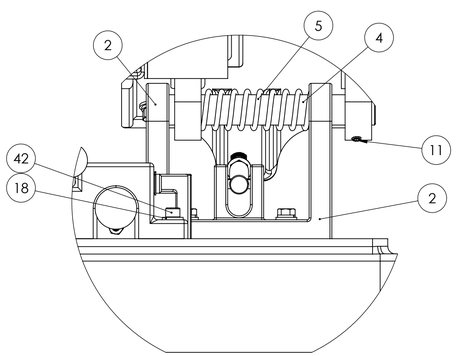






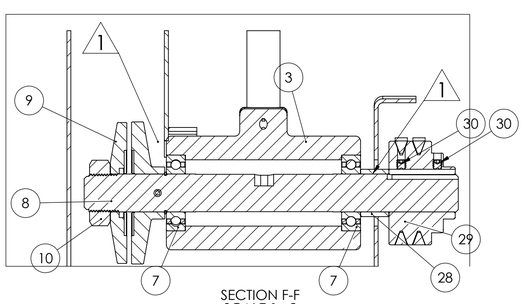
SECTION C-C
SCALE 1 : 5

VISE DETAIL



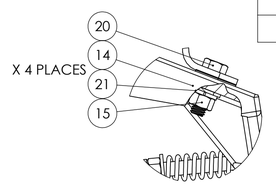
DETAIL B
SCALE 2 : 5

PIVOT, SPRING
AND PIVOT SHAFT
DETAIL



SECTION F-F
SCALE 1 : 2

SPINDLE DETAILS



DETAIL G
SCALE 1 : 2

MOTOR MOUNT
DETAILS

ITEM NO.	PART NUMBER	DESCRIPTION	
1	050-002	K12-14 SAW BASE	1
2	041-003	K12-K14 TRUNNION	1
3	002-002	K12- 14 SAW ARM	1
4	562-003	K12-14 TRUNNION PIN	1
5	697-024	SPRING, TENSION FOR BG260, S460, S6M SANDERS, K12-14B SAW, KS390, KS490, KS690 BELT GRINDERS	1
6	645-004	K12B- 14B BACK STOP ASSEMBLY	1
7	044-001	K12 BEARING	2
8	701-002TB	SPINDLE W TIGHT FLANGE FOR K12-14 SAWS WITH COG BELT DRIVE (7/8 LONGER THAN STANDARD SPINDLE)	1
9	292-004	K12-14 LOOSE FLANGE	1
10	537-026	L.H. SPINDLE NUT 1"-14 FOR K14, KM14	1
11	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	1
12	ZERK012000	1/8-27 X 11/16 STRT LUBE FITTING	2
13	ROLA031024	5/16 X 1-1/2 ROLL PIN	1
14	UFWZ037	3/8 USS F/W Z	5
15	FHN5037	3/8-16 FHN GR5 Z	5
16	HHC5031024	5/16-18 X 1-1/2 HHCS GR5 Z	4
17	SLWZ031	5/16 SPLIT L/W Z	8
18	UFWZ031	5/16 USS F/W Z	14
19	486-001	5 HP MOTOR FOR K12B, K14B, KM14, KM14HS & S6MS-5HP	1
20	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	4
21	SLWZ037	3/8 SPLIT L/W Z	4
22	RND-0.31-18THRDX4	4 INCHES OF 5/16-18 THREADED ROD	1
23	FHN5031	5/16-18 FHN GR5 ZINC	6
24	342-086	K12-14 INNER BELT GUARD FOR PLASTIC GUARD	1
25	342-086SPACER	SPACER FOR K12-14B INNER V-BELT GUARD BRACKET	1
26	342-086BRKT	K12-14 INNER BELT GUARD BRACKET	1
27	HHC5031020	5/16-18 X 1-1/4 HHCS GR 5 Z	2
28	049-120	SPACER BUSHING FOR K20 SERIES/20HP SPINDLE	1
29	560-001	K12- 14 SPINDLE PULLEY	1
30	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	3
31	560-002	MOTOR PULLEY SHEAVE FOR K12-14B, K12-14W, K12-14MS AND KM14	1
32	049-022	MOTOR PULLEY BUSHING FOR K12B, K14B AND KM14	1
33	051-006	3V X 375 V-BELT FOR K12, K14, KM14 SAWS (REQUIRES 2 BELTS)	2
34	342-004	K12-14 OUTER BELT GUARD/PLASTIC	1
35	CPNZ031	5/16-18 CAP NUT NICKEL	1
36	342-025	WHEEL GUARD FOR K12-14B SAWS	1
37	SSBA062044	5/8 X 2-3/4 SOC SHOULDER BOLT	1
38	041-057	SWITCH BRACKET FOR K12-K14	1
39	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	2
40	SLWZ025	1/4 SPLIT L/W Z	2
41	381-002	HANDLE W GRIP FOR K12-14 SAWS	1
42	SHCA031024	5/16-18 X 1-1/2 SHCS	2
43	431-001	FRONT VISE JAW K10, K14, KM14	1
44	562-001	VISE JAW PIN FOR K10B, K12B, K14B, KM16-18 VISE ASSEMBLIES	1
45	431-002	K10- 14 REAR VISE JAW	1
46	537-014	K10-14 FENCE NUT	1
47	SHCA031048	5/16-18 X 3 SHCS	2
48	386-001	K10-16 VISE HOUSING	1
49	645-001	K10-16 SHORT VISE ROD	1
50	454-001	K10-16 VISE CAM PLATE	1
51	697-001	K10-16 VISE ROD SPRING	1
52	129-001	K10-16 VISE CAM	1
53	381-001	K10- 16 VISE HANDLE	1
54	441-002	K10-16 VISE LOCK HANDLE KNOB	1
55	441-001	K10- 16 VISE ROD KNOB	1
56	SSSA025024	1/4-20 X 1-1/2 SOC SET CUP PT.	1
57	SSSA025022	1/4-20 X 1-3/8 SOC SET CUP PT.	1
58	FHN5025	1/4-20 FHN GR5 Z	2
59	SSKA010004	10-24 X 1/4 SOC SET KNURL PT	1
60	641-016	RETAINING RING SHR-62 ST PA 5/8	1
	486-023	ALTERNATE 5HP, 1PH MOTOR	
	486-001/5	ALTERNATE 5HP, 3PH, 575V MOTOR	
	486-001/50	ALTERNATE 5HP, 3PH, 50HTZ MOTOR	

FOR A COMPLETE SPINDLE ASSEMBLY
ORDER #702-004

INCLUDES:

044-001 BEARINGS, QTY 2
537-026 L.H. SPINDLE NUT, QTY 1
701-002 SPINDLE W TIGHT FLANGE, QTY 1
292-004 LOOSE FLANGE, QTY 1
ROLA018022, 3/16 X 1-3/8 ROLL PIN, QTY 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	701-002 CHANGED TO 701-002TB. 049-120 ADDED	12/27/2024	

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ±
ANGULAR: MACH ± BEND ±
TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±
INTERPRET GEOMETRIC TOLERANCING PER:
MATERIAL
FINISH
NEXT ASSY | USED ON
APPLICATION | DO NOT SCALE DRAWING

	NAME	DATE
DRAWN		
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

KALAMAZOO INDUSTRIES, INC.

TITLE:
K12B-K14B MODEL ASSEMBLY-REVISION 1

SIZE D | DWG. NO. K12-14B-REV1 | REV 1

SCALE: 1:10 WEIGHT: | SHEET 1 OF 1