

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



PH: (269) 382-2050

www.kalamazooind.com

K12-14V INSTRUCTION MANUAL



MADE IN USA

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



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GENERAL INFORMATION

WARRANTY

All products are guaranteed for a period of one year from receipt of order to the original purchaser, against defects in material workmanship under normal use. Electric motors are warranted by the motor manufacturer for a period of one year and will be repaired by the nearest motor repair station. If non-repairable, they will be replaced by Kalamazoo Industries. Please call for instructions (269) 382-2050.

RETURN POLICY

Authorization must be obtained before returning merchandise. Please call our customer service department for a return authorization number (269) 382-2050. Please include with your return a copy of your invoice of packing slip. All material must be new and unused in the original packaging. Material must be sent back prepaid (unless otherwise indicated) by Kalamazoo Industries. Credit upon inspection at Kalamazoo Industries. All returns will be subject to a 10% restock charge. Used merchandise is non-returnable. No returns will be accepted after one year of invoice date.

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 filled with the delivering **TRANSPORTATION COMPANY. PLEASE DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS.**

NOTE: SEE NEXT PAGE FOR RETURN POLICY AND WARRANTY.

BEFORE STARTING OR CONNECTING ELECTRICAL VERIFY THE PHASE AND VOLTAGE OF UNIT.

TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBERVE UNIT FOR THE FIRST MINUTES OF OPERATION. BLADE GUARDS MUST NEVER BE REMOVED.

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WARNING!

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

IMPROPER USE MAY CAUSE BREAKAGE AND SERIOUS INJURY.

IMPORTANT

Read Operating Instructions before using equipment.

ABRASIVE SAW SAFETY

1. NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS.
2. ELECTRIC MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR AN OPERATOR STANDING ON A WET FLOOR.
3. DO NOT USE AROUND FLAMMABLE MATERIALS OR LIQUIDS.
4. MACHINES SHOULD BE OPERATED IN VENTILATED AREAS.
5. ALWAYS WEAR SAFETY GLASSES OR A FULL FACE SHIELD FOR PROTECTION.
6. KEEP HANDS CLEAR OF THE CUTTING AREA.
7. DO NOT WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.
8. ALWAYS KEEP HAIR TIED BACK OR COVERED.
9. ALWAYS KEEP FLANGES CLEAN AND TIGHT AGAINST CUTTING WHEEL.
10. ABRASIVE MACHINES ARE FOR ABRASIVES NOT STEEL TOOTHED BLADES. DO NOT ATTEMPT TO USE STEEL BLADES UNLESS CORRECTLY GUARDED WITH AN ENCLOSED WHEEL GUARD. KEEP STEEL BLADES FULLY RETRACTED INTO WHEEL GUARD WHEN DONE CUTTING.
11. ALWAYS KEEP WHEEL GUARD IN DOWN POSITION.
12. BE SURE WORK PIECE IS CLAMPED SECURELY IN VISE BEFORE CUTTING

DO

- DO always handle and store wheels in careful manner.
- DO visually inspect all wheels before mounting for possible damage.
- DO check machine speed against the established maximum life operating speed marked on the wheel.
- DO check mounting flanges for equipment correct diameter.
- DO use mounting blotters when supplied with wheels.
- DO always use a safety guard covering at least one-half of abrasive wheel.
- DO allow newly mounted wheels to run at operating speed, leave the guard in place, for at least one minute before cutting.
- DO always wear safety glasses or some type of eye protection when cutting.

DON'T

- DON'T use a cracked wheel or one that has been dropped or has become damaged.
- DON'T force a wheel onto the machine or alter the size of the mounting hole-if wheel won't fit the machine, get one that will.
- DON'T ever exceed maximum operating speed established for the wheel.
- DON'T use mounting flanges on which the bearing surfaces are not clean, flat and free of burrs.
- DON'T tighten the mounting nut excessively.
- DON'T start the machine until the wheel guard is in place.
- DON'T jam work into wheel.
- DON'T force cutting so that motor slows noticeable or work gets hot.
- DON'T wear gloves when operating machine.

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BASIC OPERATION/ SAW INSTALLATION

1. Before installation be sure of machine voltage and phase. Machines are pre-wired to customer specifications before shipment. Voltage changes require re-wiring of motors leads and changing ON/OFF switches. If not familiar with electrics consult and electrician.
2. Hold workpiece securely in vise. Do not allow workpiece movement during cutting. Workpiece movement results in broken wheels.
3. Abrasive wheels- wheels vary in grit, bond, wet, dry, ect... Not all abrasive wheels are created equal. Choose the correct wheel for the material being cut. Consult your dealer for the proper abrasive wheel for the job. Good cuts are not black/blue/green but bright like the OD of the material. Try another wheel grade to get good cuts. When you find the wheel that works the best stay with that grade.
4. Position the workpiece slightly ahead of wheel center (towards the operator). The back fence is positioned slightly behind wheel center to handle large parts. Small parts positioned too far behind wheel center will cause the wheel to bounce. Position a shim of some material at the fence first, then clamp your part to bring it out towards the operator to eliminate bouncing of the wheel. Pull on the saw handle hard enough to cause the wheel to "breakdown" or cut.
5. The dust collector uses a panel type filter element. The filter is accessed thru a flap door on the side of the unit. The filter element is designed for approximately 50 micron. Finer materials like graphite will not be caught and will bypass thru the element. The unit is not designed for graphite. Remove the filter element as needed and clean it. Replace as needed.
6. Safety- follow all safety procedures. Wear safety glasses/face shield at all time while operating machine. DO NOT wear gloves, long hair, loose clothing that can get caught in the V-belts and wheel. Abrasive saws are designed for abrasive wheels NOT steel carbide tipped blades. Full OSHA clam guards are required for steel blades.
7. Maintenance- keep V belts tight with a 1/2" of "squeeze". Keep machine clean.

NOTE: SEE NEXT PAGE FOR V-BELT ALIGNMENT INSTRUCTIONS

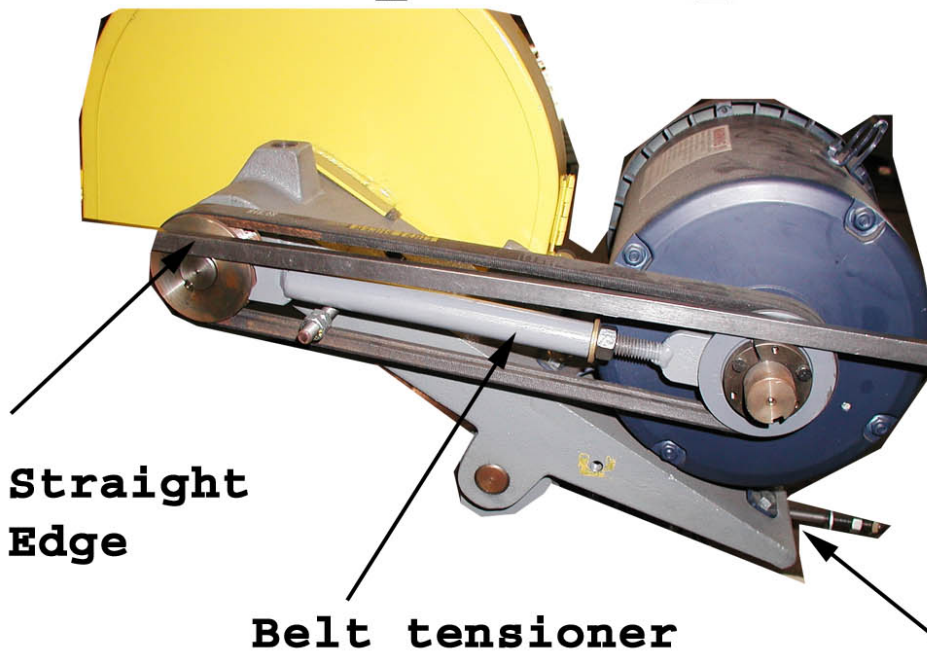
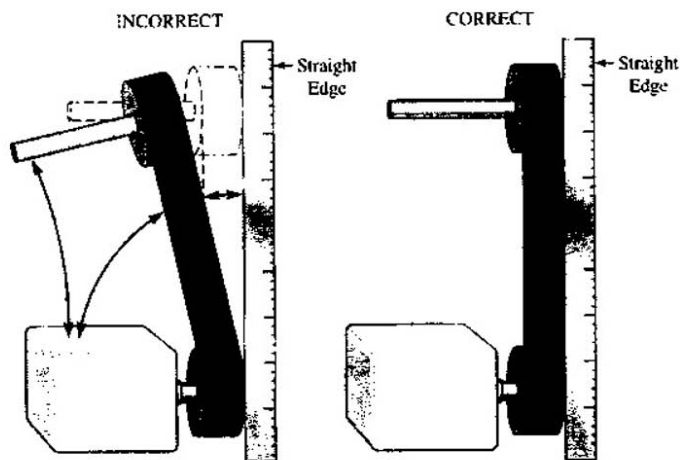
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K14 series V belt replacement.

Check belt tension after approximately 8 hours use. Make sure belt(s) and pulley run true with motor and arbor shaft, and motor shaft and arbor shaft are parallel.

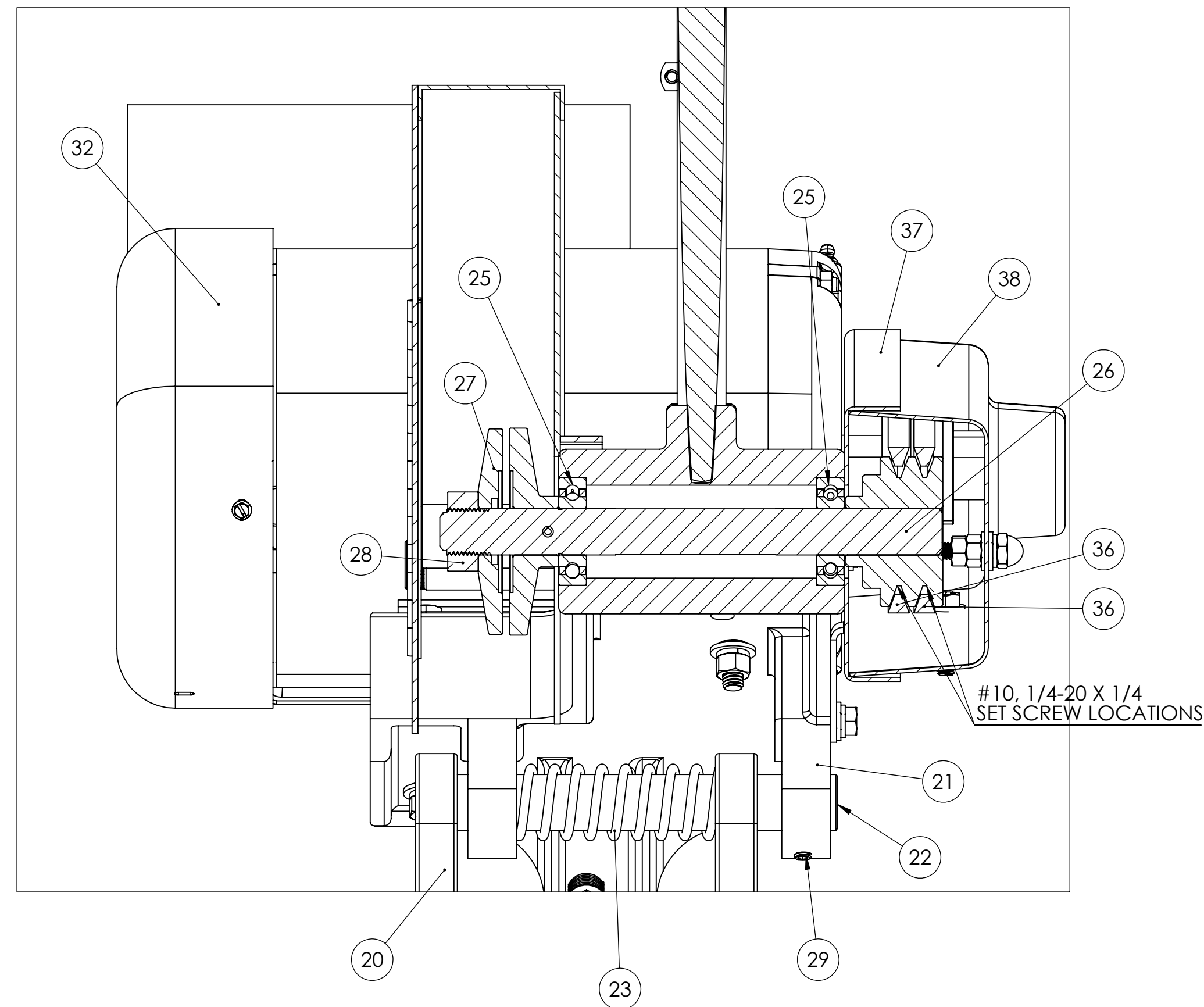


**Straight
Edge**

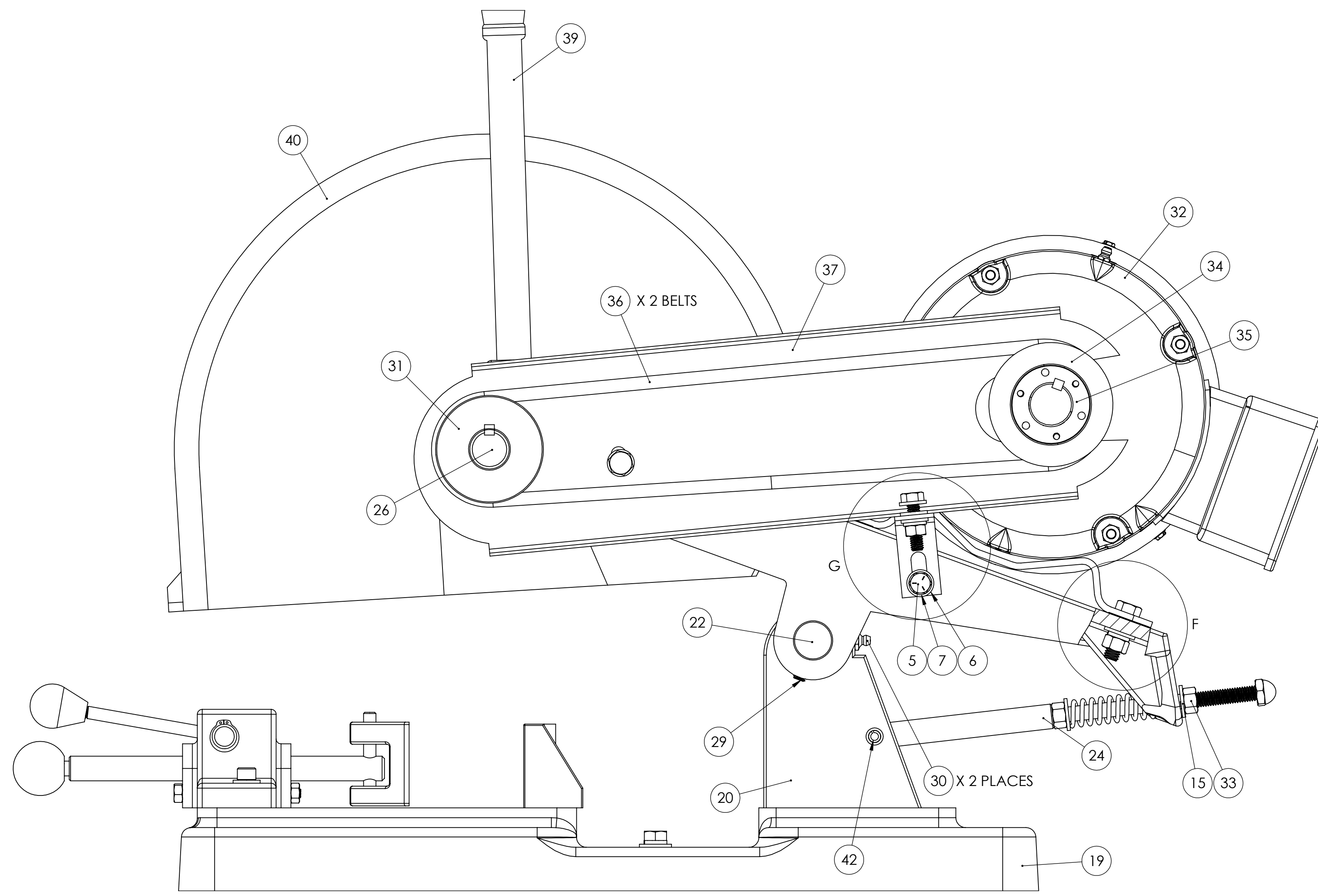
Belt tensioner

Do not over tighten.
1/2" of "squeeze" on belt
tension.

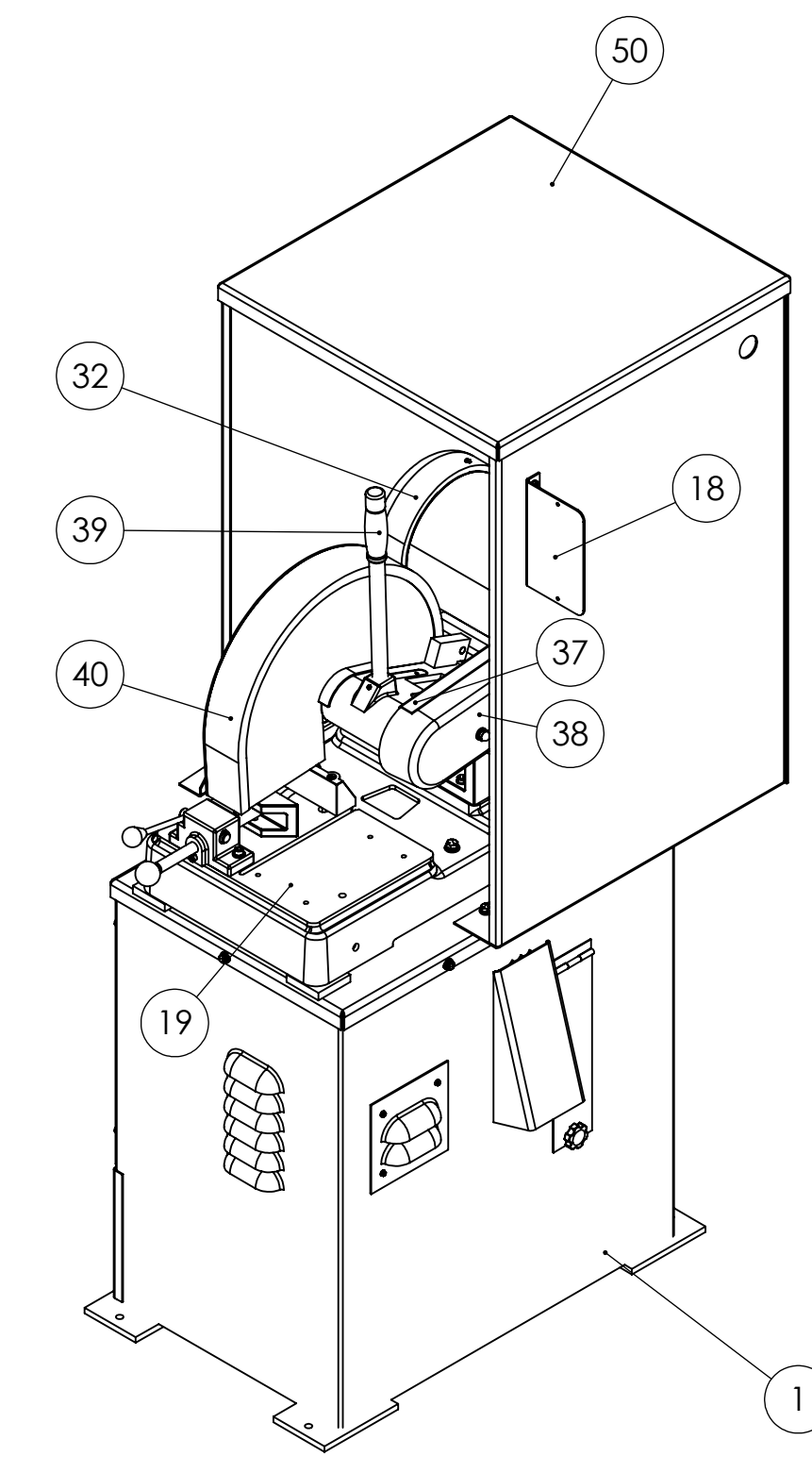
Loosen motor bolts,
tension belt, line up
belt, re-tighten
belt.



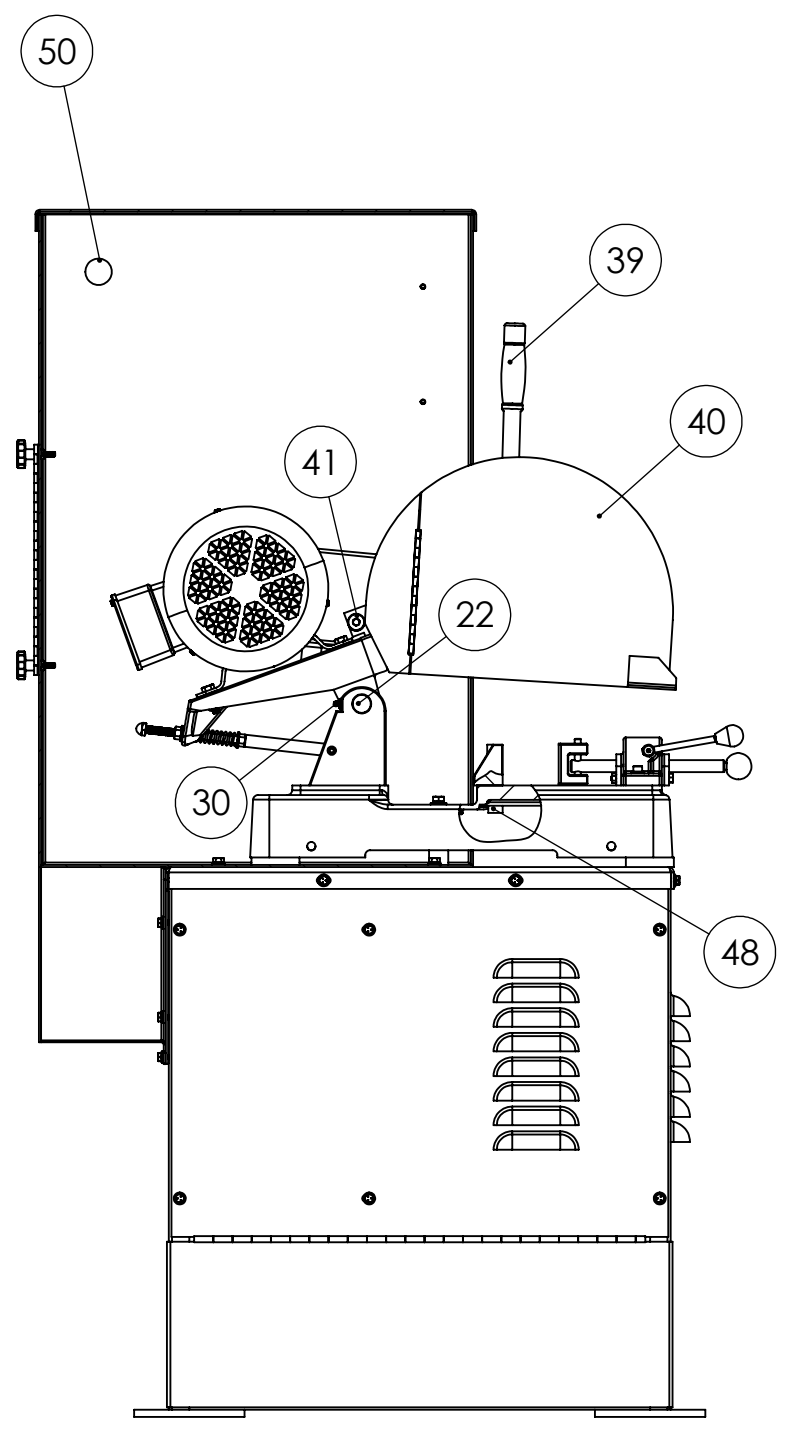
SECTION C-C
SCALE 1 : 2



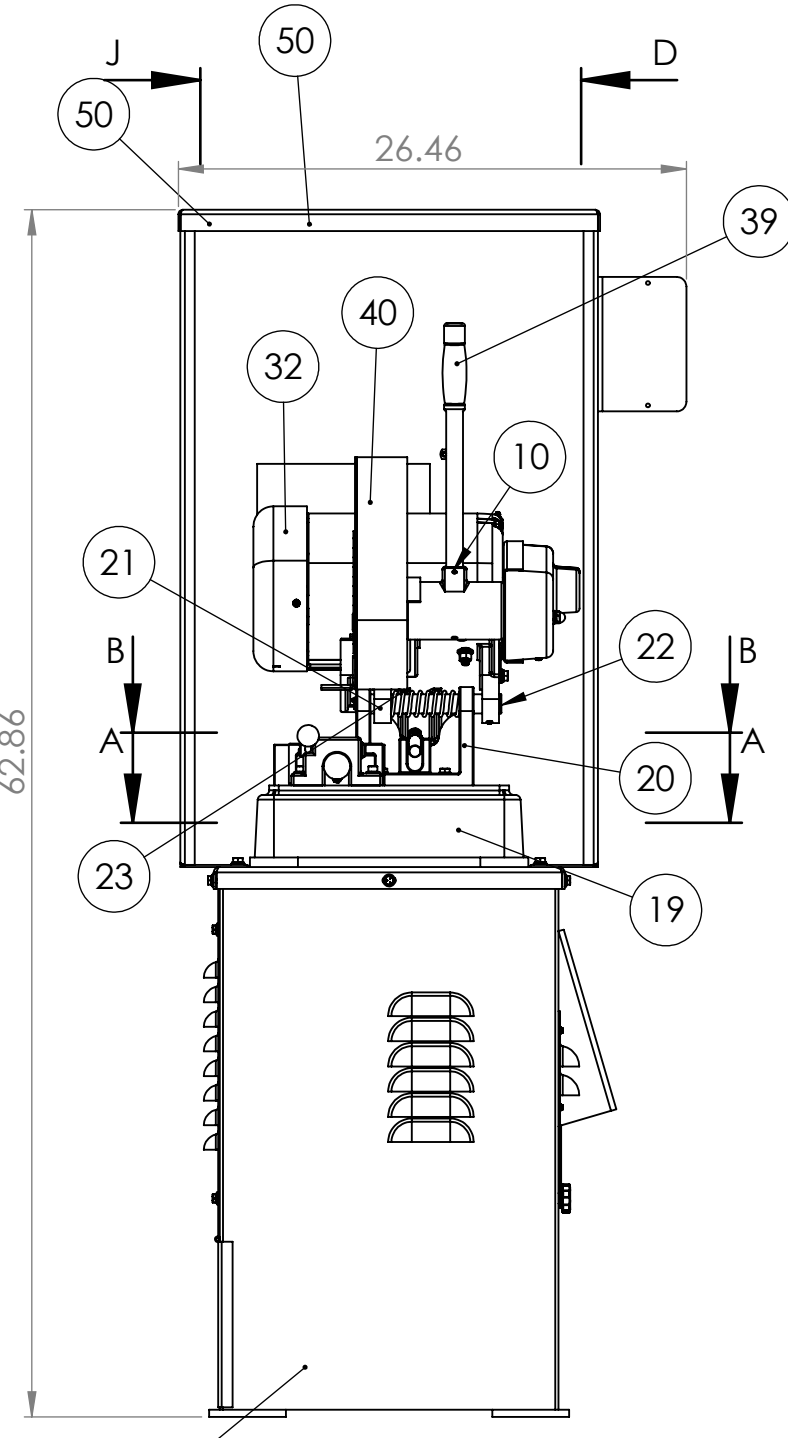
INTERNAL RIGHT SIDE VIEW



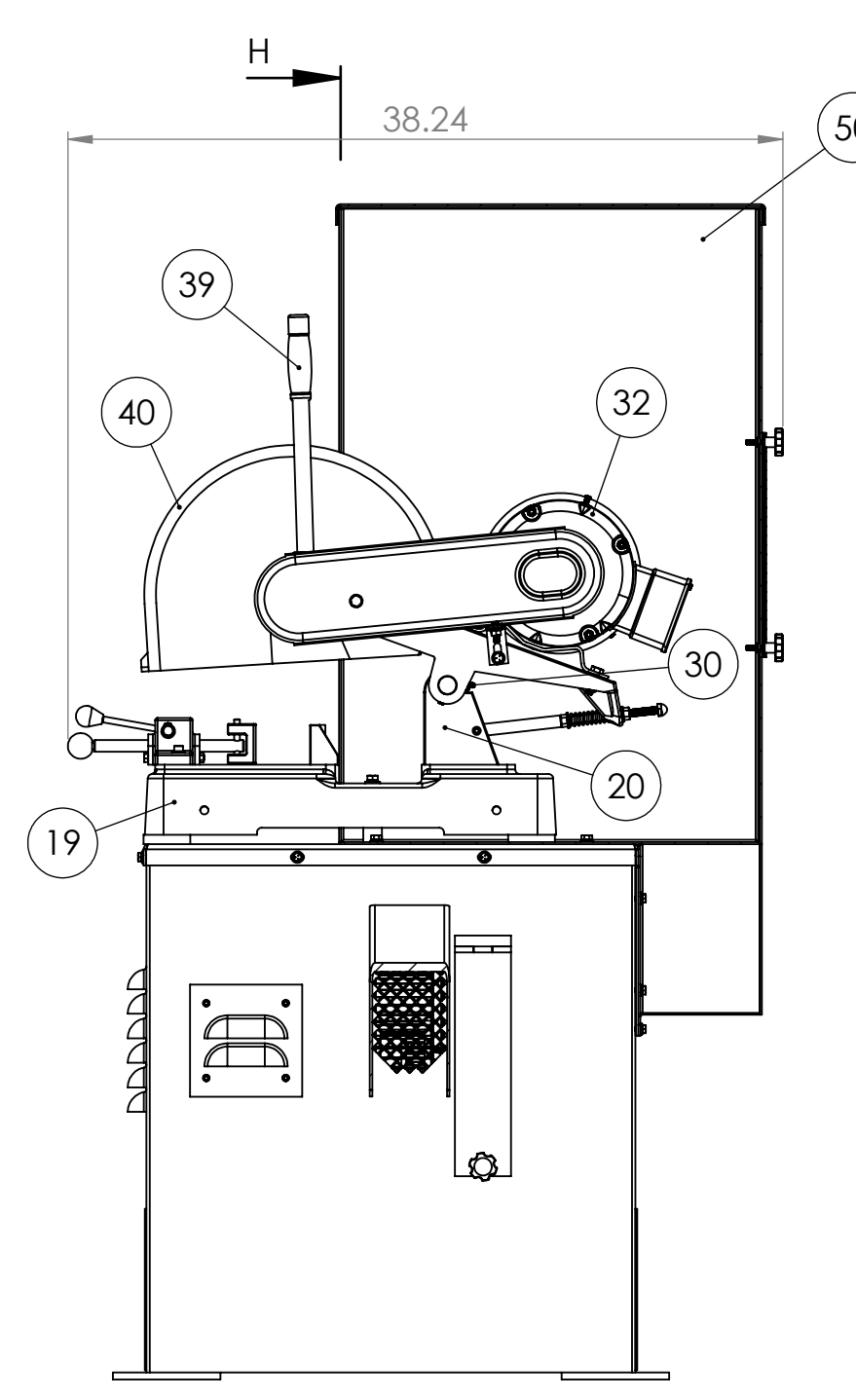
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	DCV-6	DCV-6 DUST COLLECTOR	1
2	BUCKND2724	5/16-18 DOUBLE TAP SPOTWELD NUT	4
3	SLWZ025	1/4 SPLIT L/W Z	7
4	UFWZ025	1/4 USS F/W Z	5
5	HHC5031012	5/16-18 X 3/4 HHCS GR5 Z	1
6	UFWZ031	5/16 USS F/W Z	13
7	SLWZ031	5/16 SPLIT L/W Z	12
8	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
9	FHN5031	5/16-18 FHN GR5 ZINC	4
10	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	3
11	441-015	907B-2500-1.00S 1/4 THUMBSCREW 1-1/2 DIA	2
12	124-006A	BLOCK WELDED TO MODIFIED DCV-6 VACUUM CABINET TOP	4
13	124-006B	STAND-OFF WELDED TO MODIFIED DCV-6 VACUUM CABINET TOP	2
14	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	6
15	UFWZ037	3/8 USS F/W Z	7
16	SLWZ037	3/8 SPLIT L/W Z	6
17	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	7
18	041-058	K12-14V SWITCH BRACKET, MOUNTED ON SIDE OF HOOD	1
19	050-002	K12-14V SAW BASE	1
20	041-003	K12-K14 TRUNNION	1
21	002-002	K12-14V SAW ARM	1
22	562-003	K12-14 TRUNNION PIN	1
23	697-024	SPRING, TENSION FOR BG260 S460, S6M SANDERS, K12-14V SAW, KS390, KS490, KS690 BELT GRINDERS	1
24	645-004	K12B-14B BACK STOP ASSEMBLY	1
25	044-001	K12 BEARING	2
26	701-002	SPINDLE W TIGHT FLANGE FOR K12B, K14B, K12-14V, KM14, K12-14MS	1
27	292-004	K12-14 LOOSE FLANGE	1
28	537-026	L.H. SPINDLE NUT 1"-14 FOR K14, KM14	1
29	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	1
30	ZERK012000	1/8-27 X 1 1/16 STRT LUBE FITTING	2
31	560-001	K12-14 SPINDLE PULLEY	1
32	486-001	5 HP MOTOR FOR K12B, K14B, KM14, KM14HS & S6MS-SHP	1
33	FHN5037	3/8-16 FHN GR5 Z	5
34	560-002	MOTOR PULLEY SHEAVE FOR K12-14B, K12-14V, K12-14MS AND KM14	1
35	049-022	MOTOR PULLEY BUSHING FOR K12B, K14B AND KM14	1
36	051-006	V-BELT (TWO REQUIRED) FOR K12, K14, KM14 SAWS (SAME AS 591-009)	2
37	342-086	K12-14 INNER BELT GUARD ASSEMBLY FOR PLASTIC GUARD	1
38	342-004	K12-14 OUTER BELT GUARD/PLASTIC	1
39	381-002	HANDLE W GRIP FOR K12-14 SAWS	1
40	342-025	WHEEL GUARD FOR K12-14B SAWS	1
41	SSBA062044	5/8 X 2-3/4 SOC SHOULDER BOLT	1
42	ROLA031024	5/16 X 1-1/2 ROLL PIN	1
43	RND-0.31-18THRDX3.75	3-3/4 INCHES OF 5/16-18 THREADED ROD	1
44	HHC5031020	5/16-18 X 1-1/4 HHCS GR 5 Z	1
45	CPN2031	5/16-18 CAP NUT NICKEL	1
46	SHCA031024	5/16-18 X 1-1/2 SHCS	2
47	431-002	K10-14 REAR VISE JAW	1
48	537-014	K10-14 FENCE NUT	1
49	SHCA031048	5/16-18 X 3 SHCS	2
50	124-012	HOOD ASSEMBLY FOR DCV-6 DUST COLLECTOR	1
51	HHC5031024	5/16-18 X 1-1/2 HHCS GR5 Z	4
52	386-001	K10-16 VISE HOUSING	1
53	645-001	K10-16 SHORT VISE ROD	1
54	454-001	K10-16 VISE CAM PLATE	1
55	697-001	K10-16 VISE ROD SPRING	1
56	129-001	K10-16 VISE CAM	1
57	381-001	K10-16 VISE HANDLE	1
58	441-002	K10-16 VISE LOCK HANDLE KNOB	1
59	431-001	FRONT VISE JAW K10, K14, KM14	1
60	562-001	VISE JAW PIN FOR K10B, K12B, K14B, KM16-18 VISE ASSEMBLIES	1
61	441-001	K10-16 VISE ROD KNOB	1
62	SSSA025024	1/4-20 X 1-1/2 SOC SET CUP PT.	1
63	SSSA025022	1/4-20 X 1-3/8 SOC SET CUP PT.	1
64	FHN5025	1/4-20 FHN GR5 Z	2
65	SSKA010004	10-24 X 1/4 SOC SET KNURL PT	1
66	641-016	RETAINING RING FOR S6, S460W, S612	1



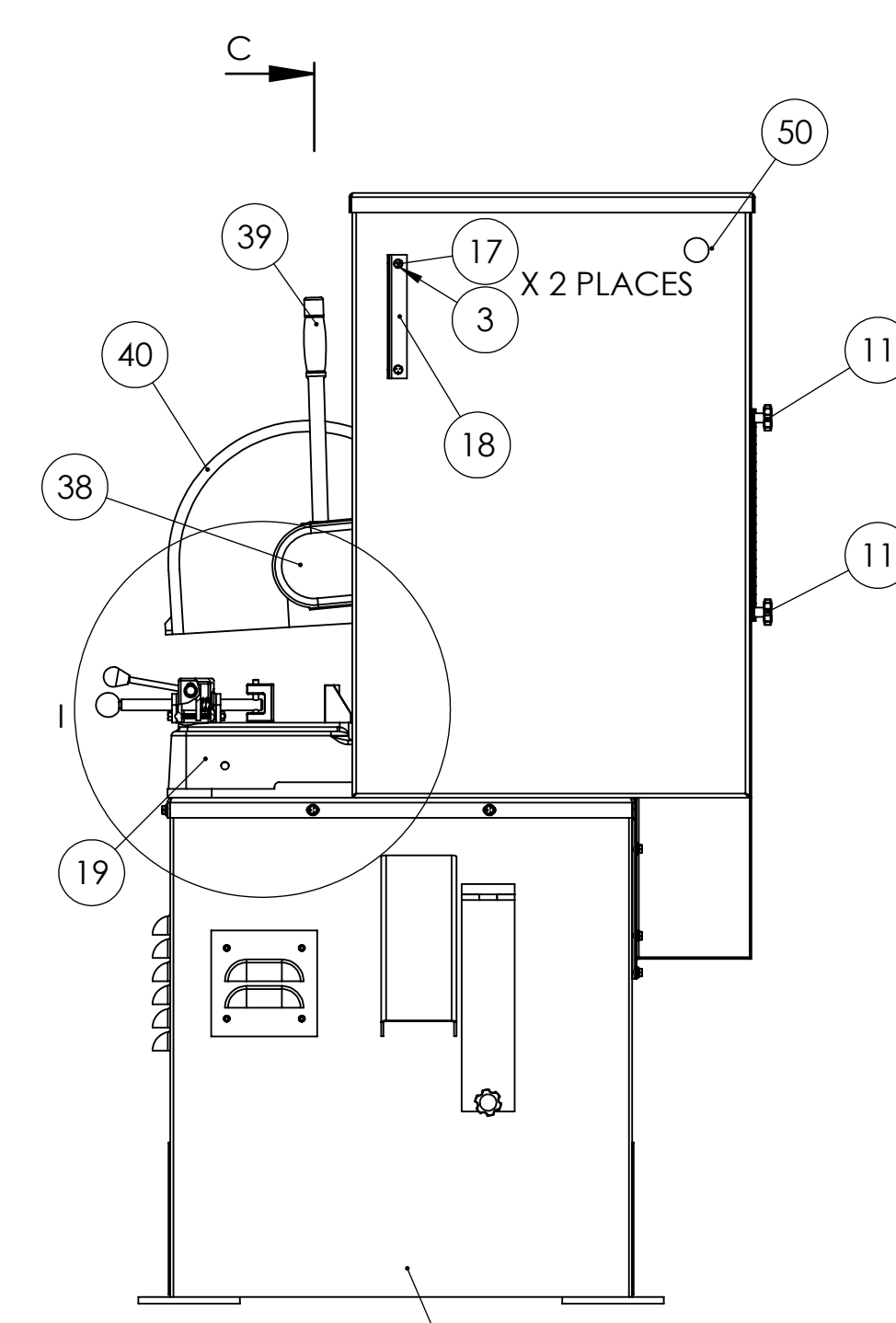
SECTION J-J
SCALE 1 : 10
INTERNAL LEFT VIEW



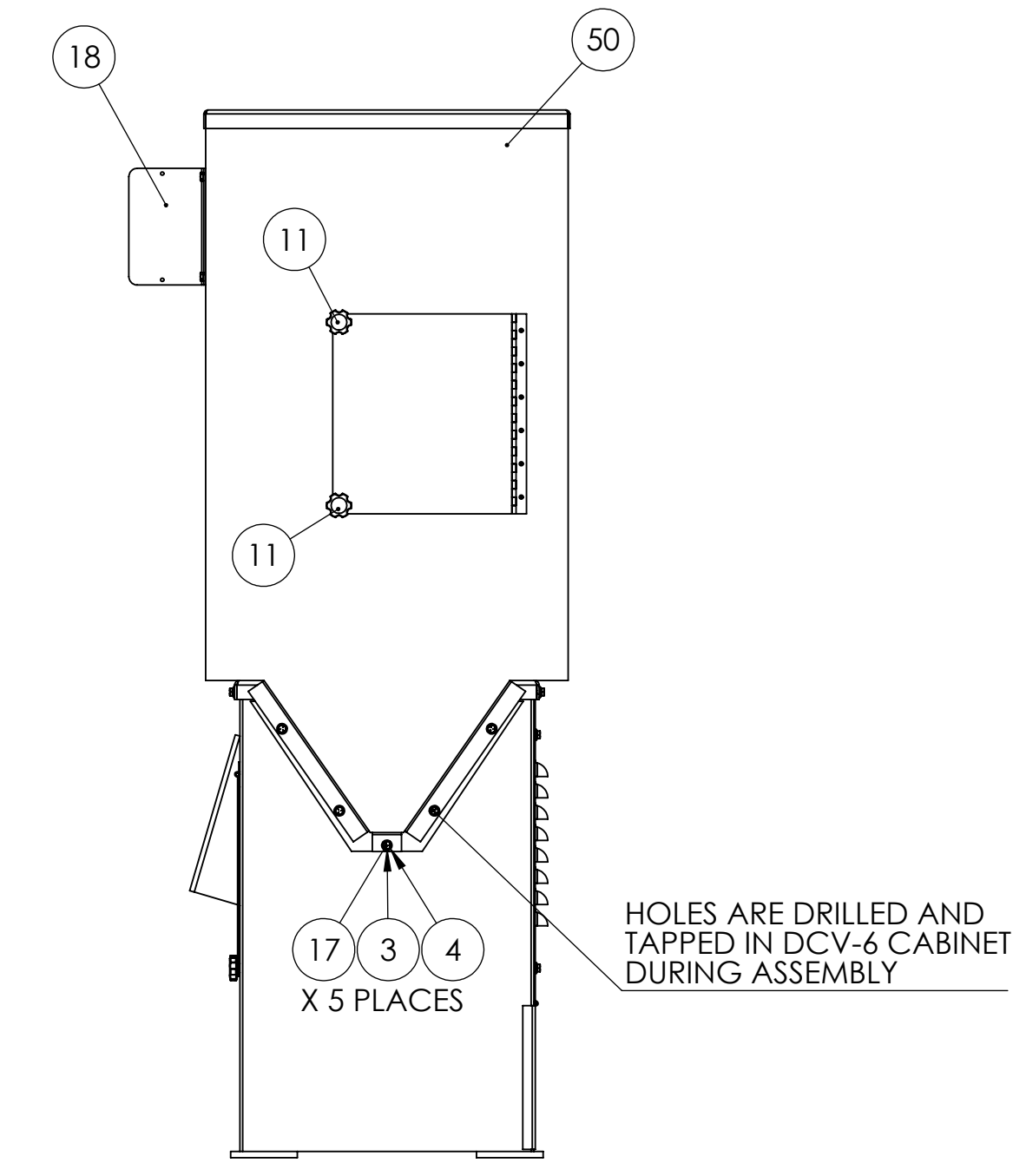
FRONT VIEW



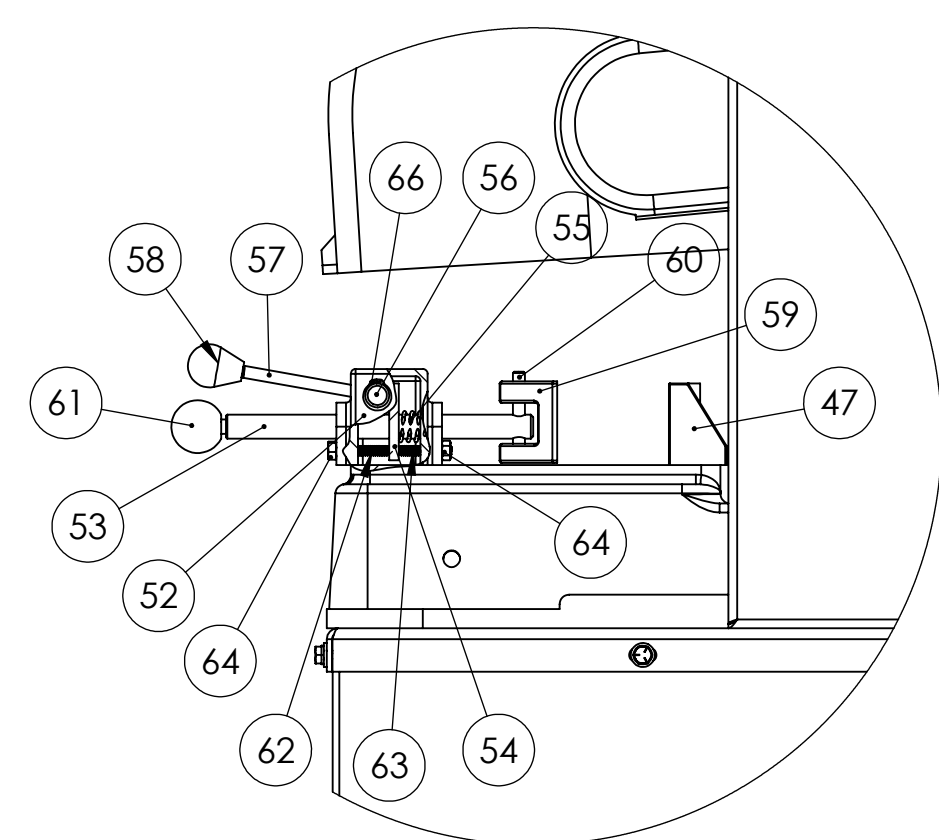
SECTION D-D
SCALE 1 : 10
INTERNAL RIGHT VIEW



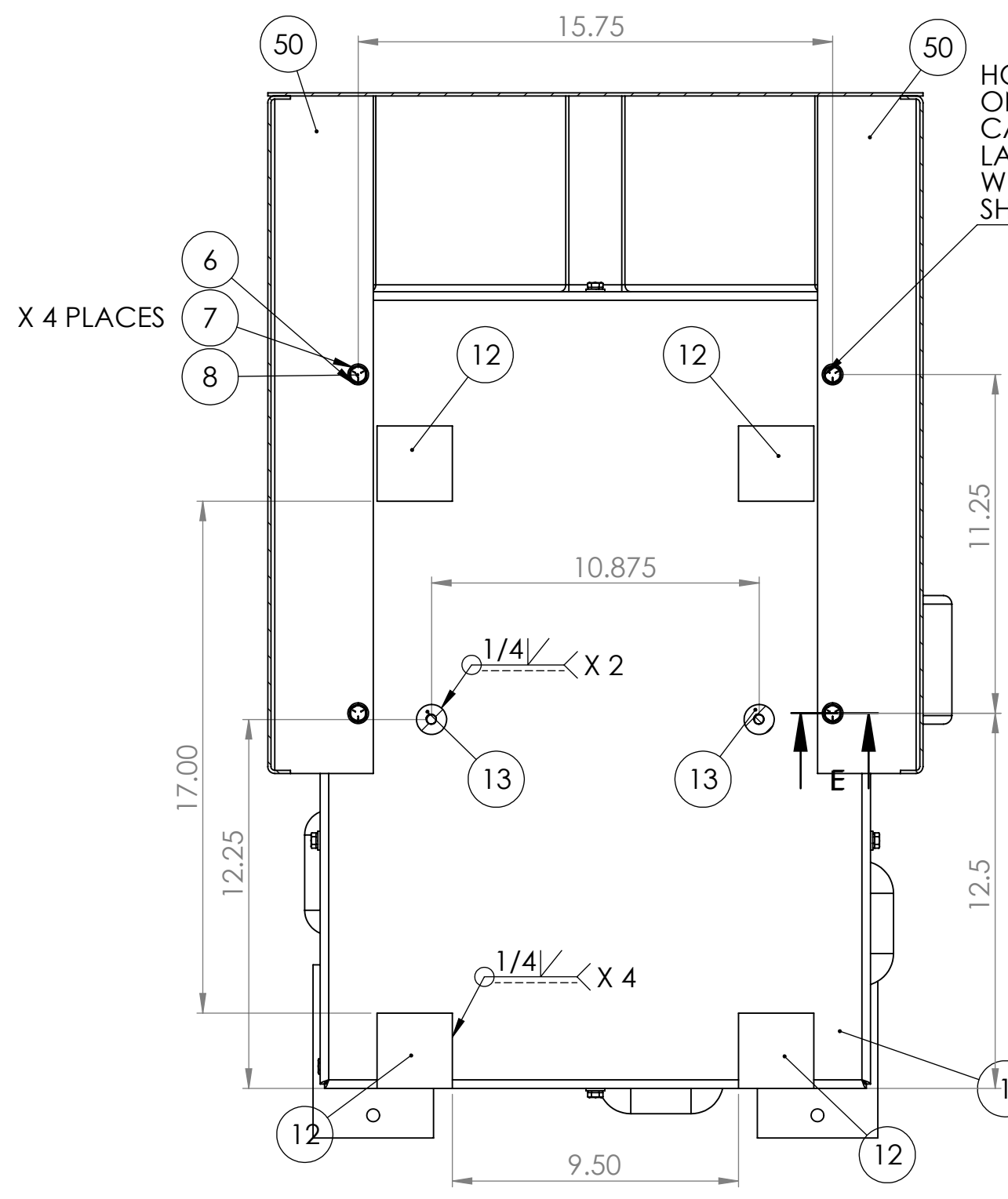
RIGHT VIEW



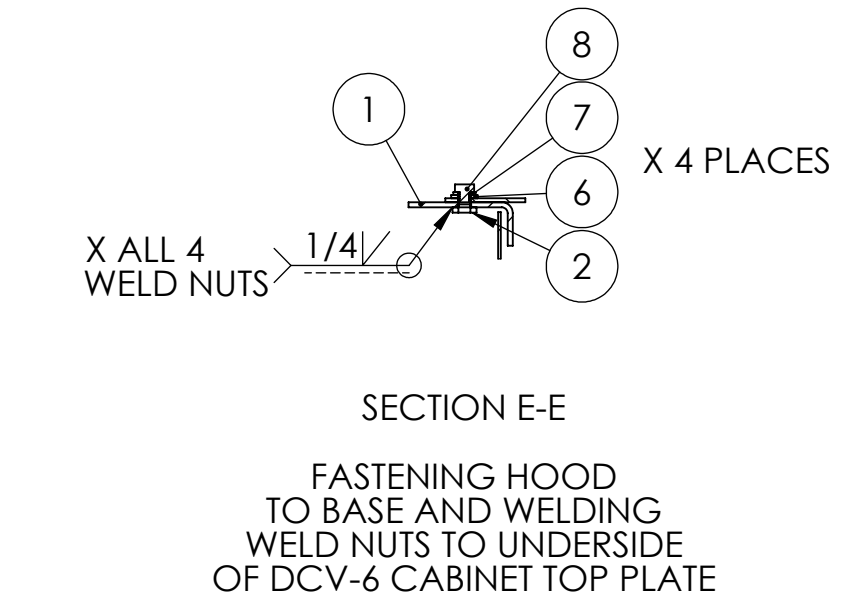
HOLES ARE DRILLED AND TAPPED IN DCV-6 CABINET DURING ASSEMBLY



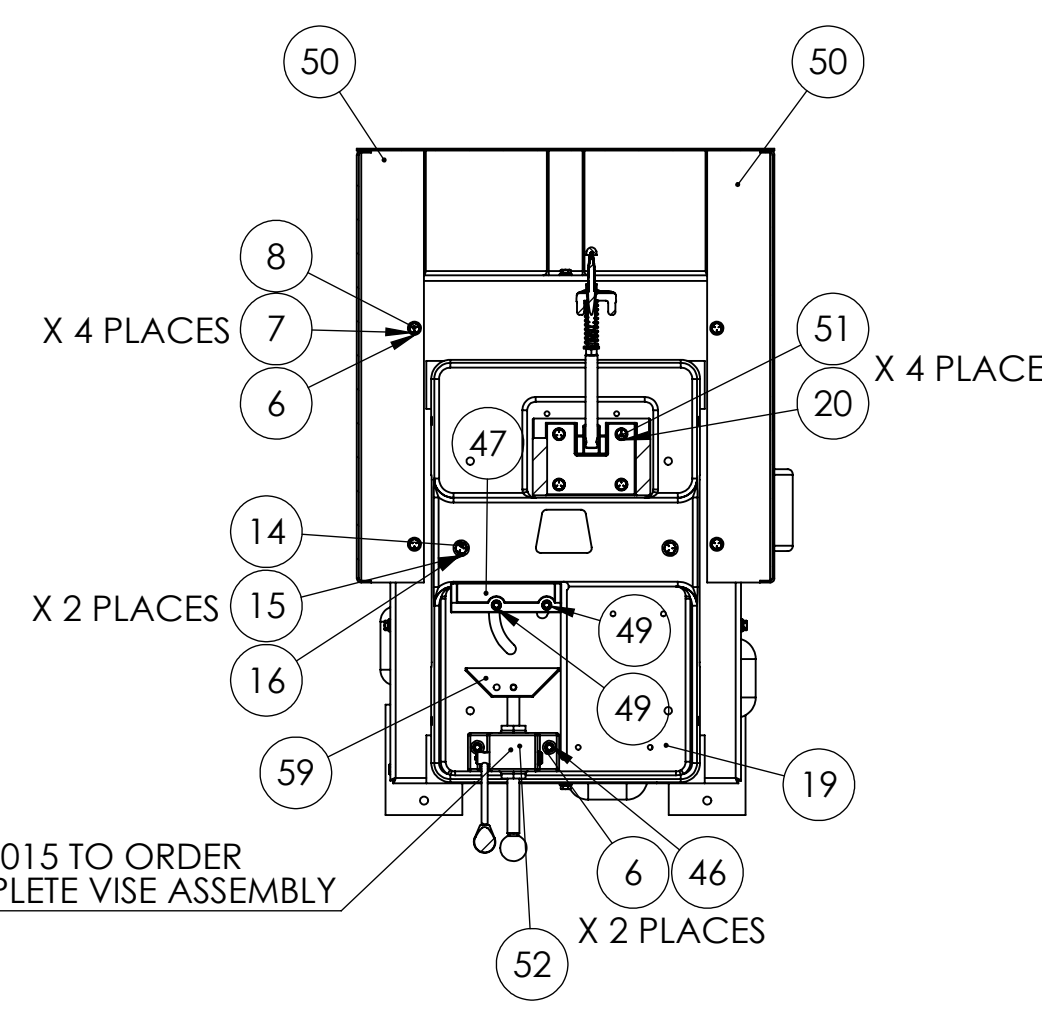
DETAIL I
VISE DETAILS



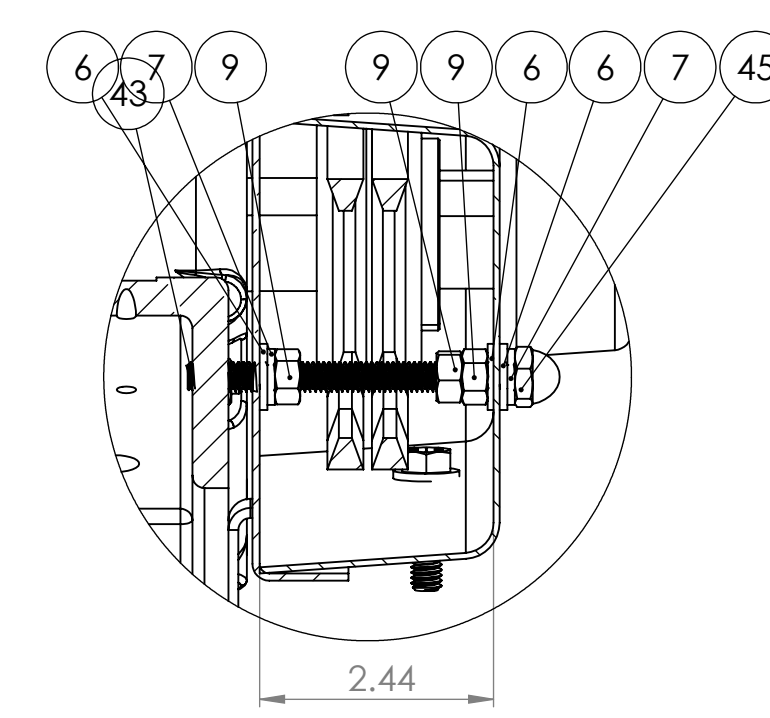
SECTION A-A
LAYOUT OF MODIFIED
DCV-6 CABINET TOP PLATE



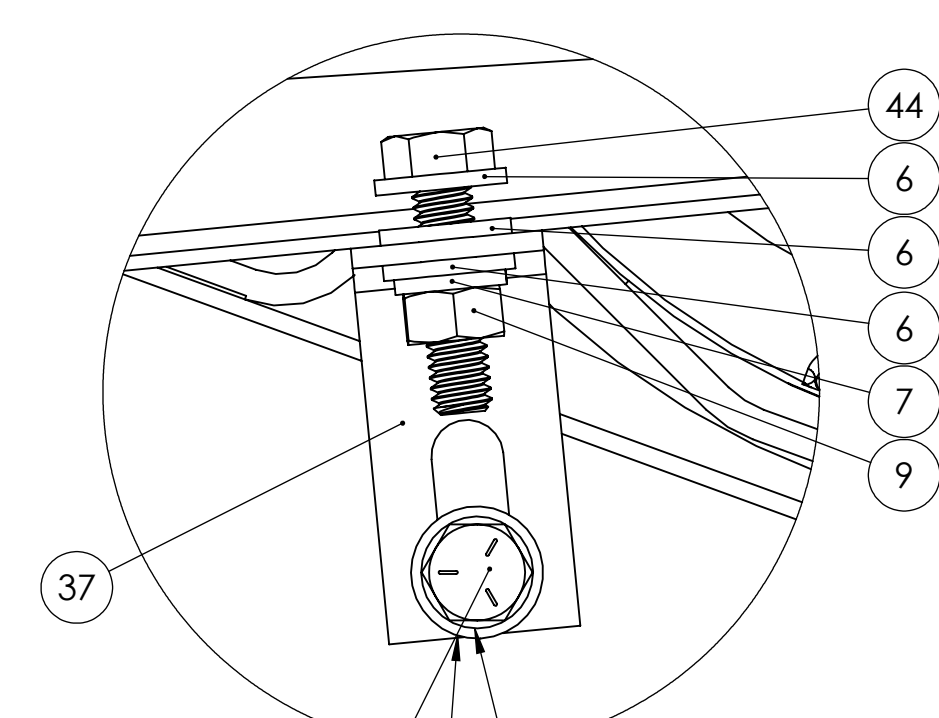
SECTION E-E
FASTENING HOOD TO BASE AND WELDING WELD NUTS TO UNDERSIDE OF DCV-6 CABINET TOP PLATE



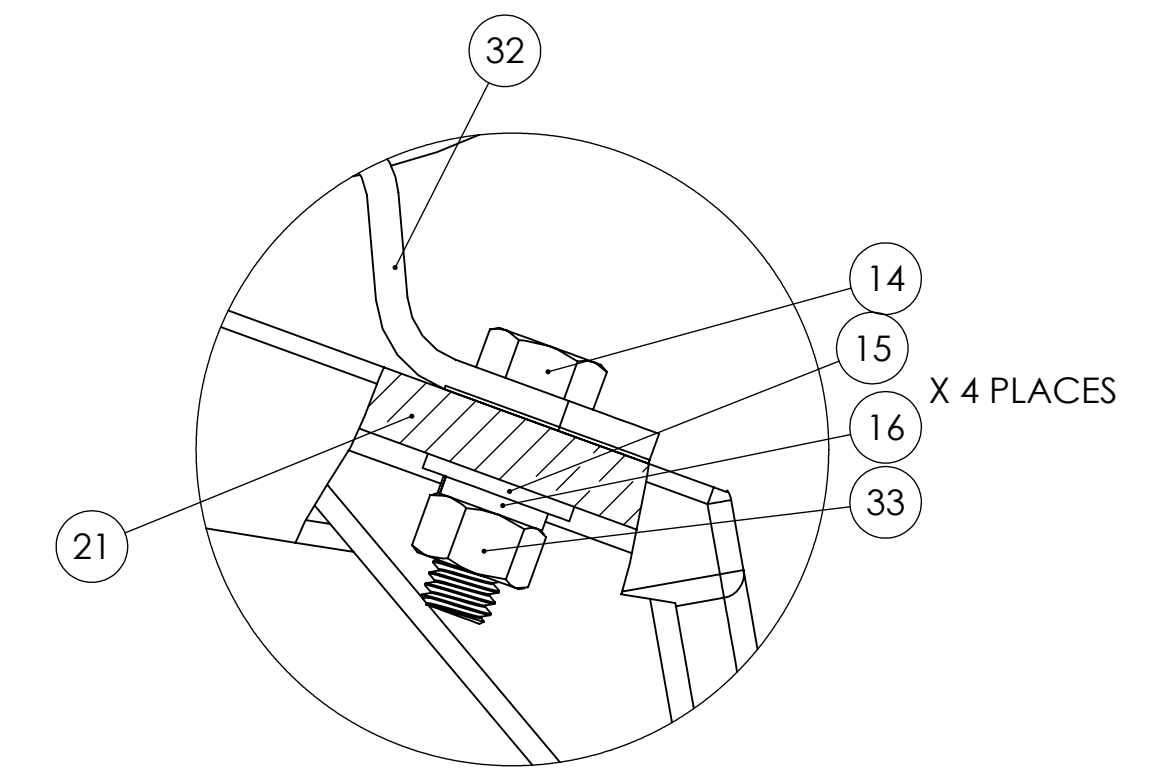
SECTION B-B
SCALE 1 : 10
TOP VIEW LAYOUT



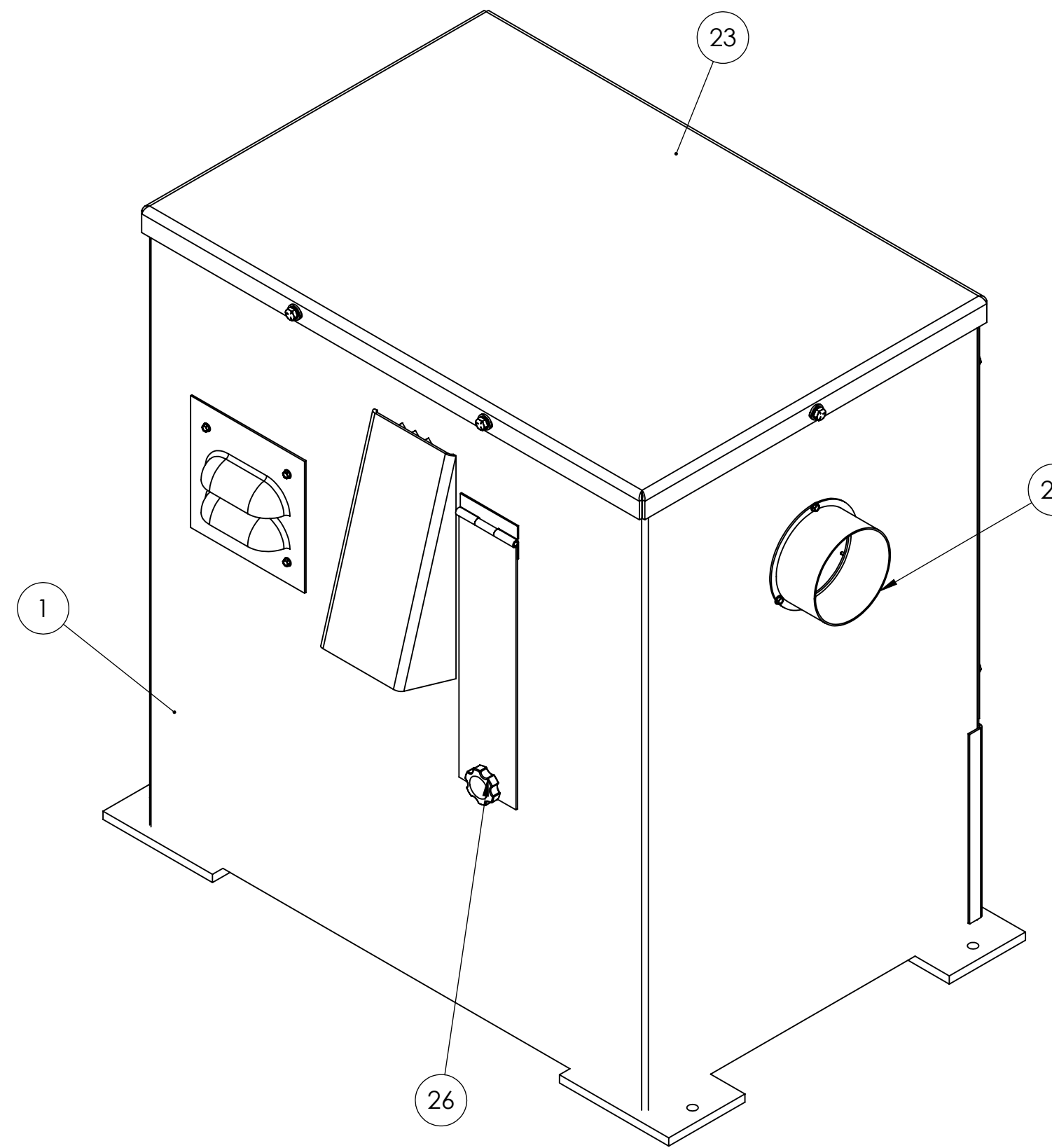
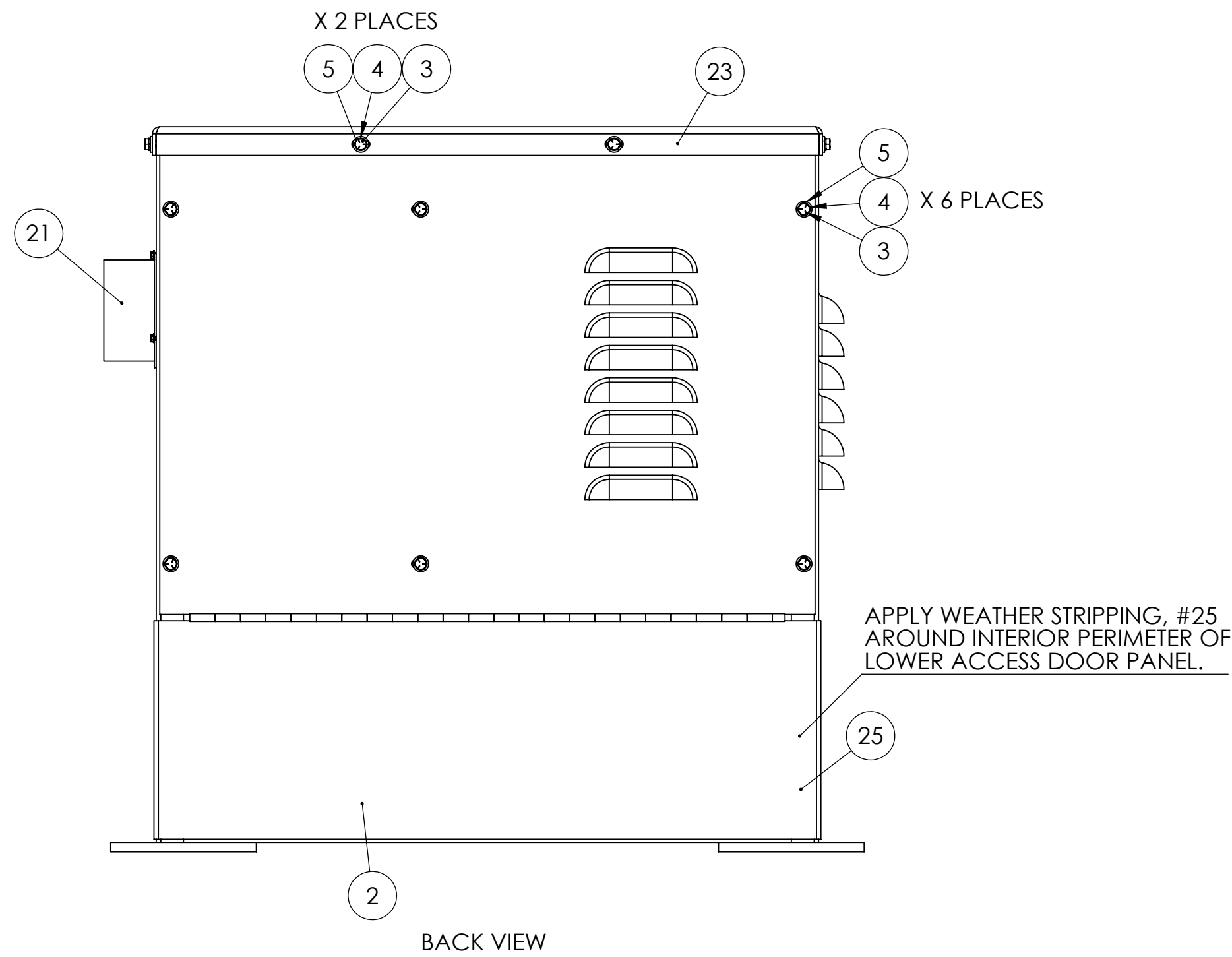
SECTION H-H
SCALE 1 : 2
ATTACHMENT OF
PLASTIC OUTER WHEEL GUARD



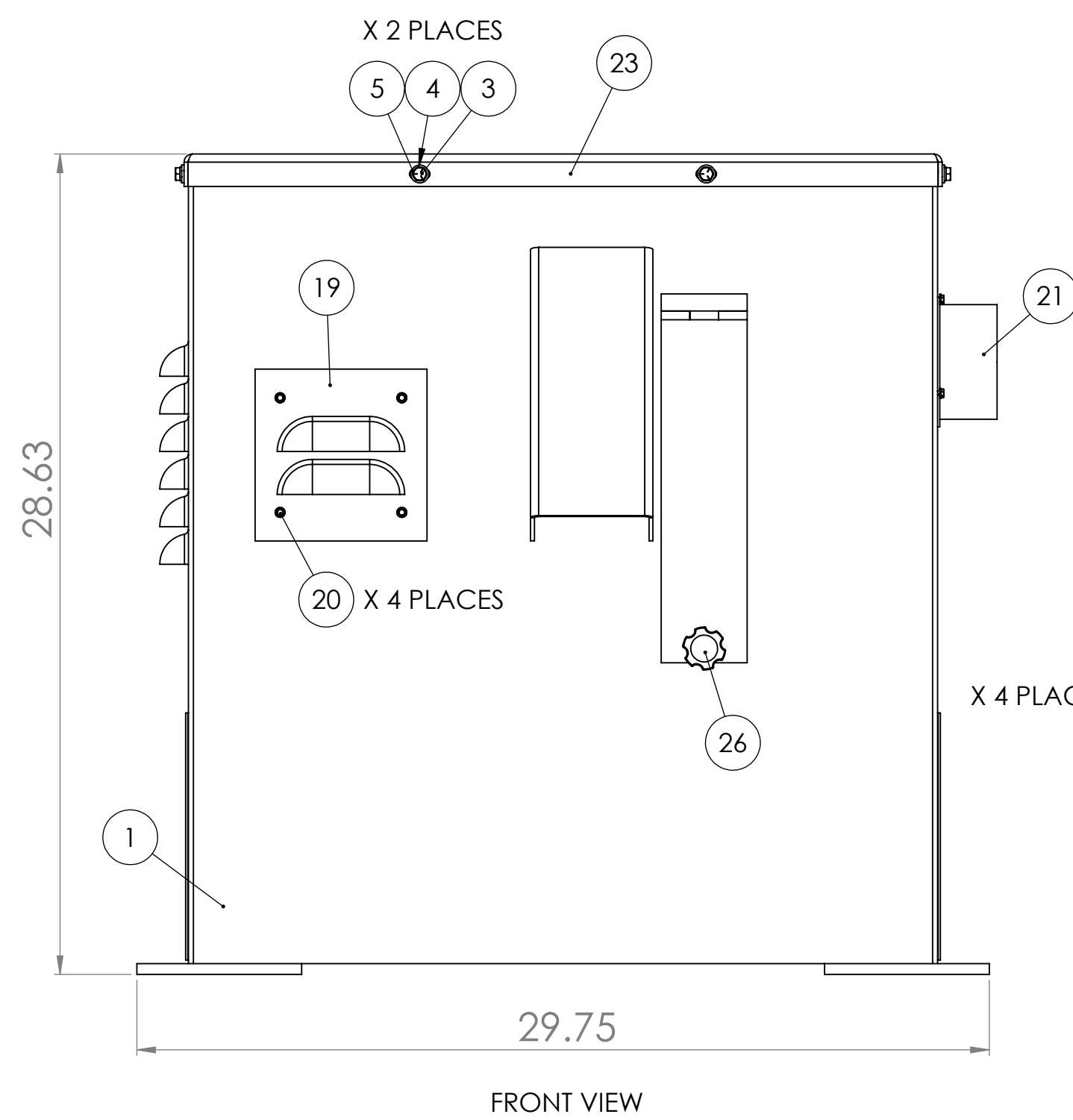
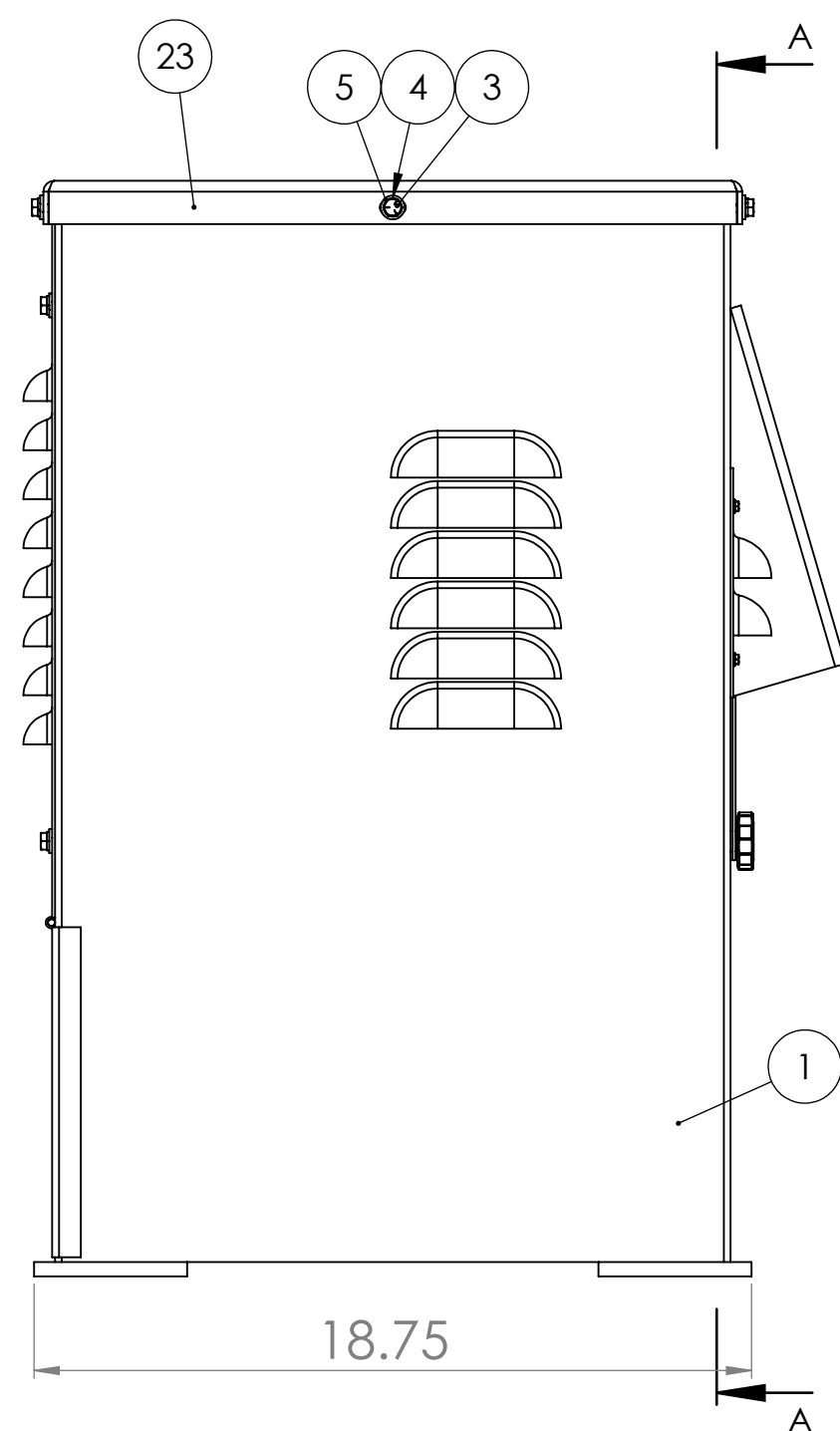
DETAIL G
SCALE 1 : 1
WHEEL GUARD BRACKET
ATTACHMENT DETAILS



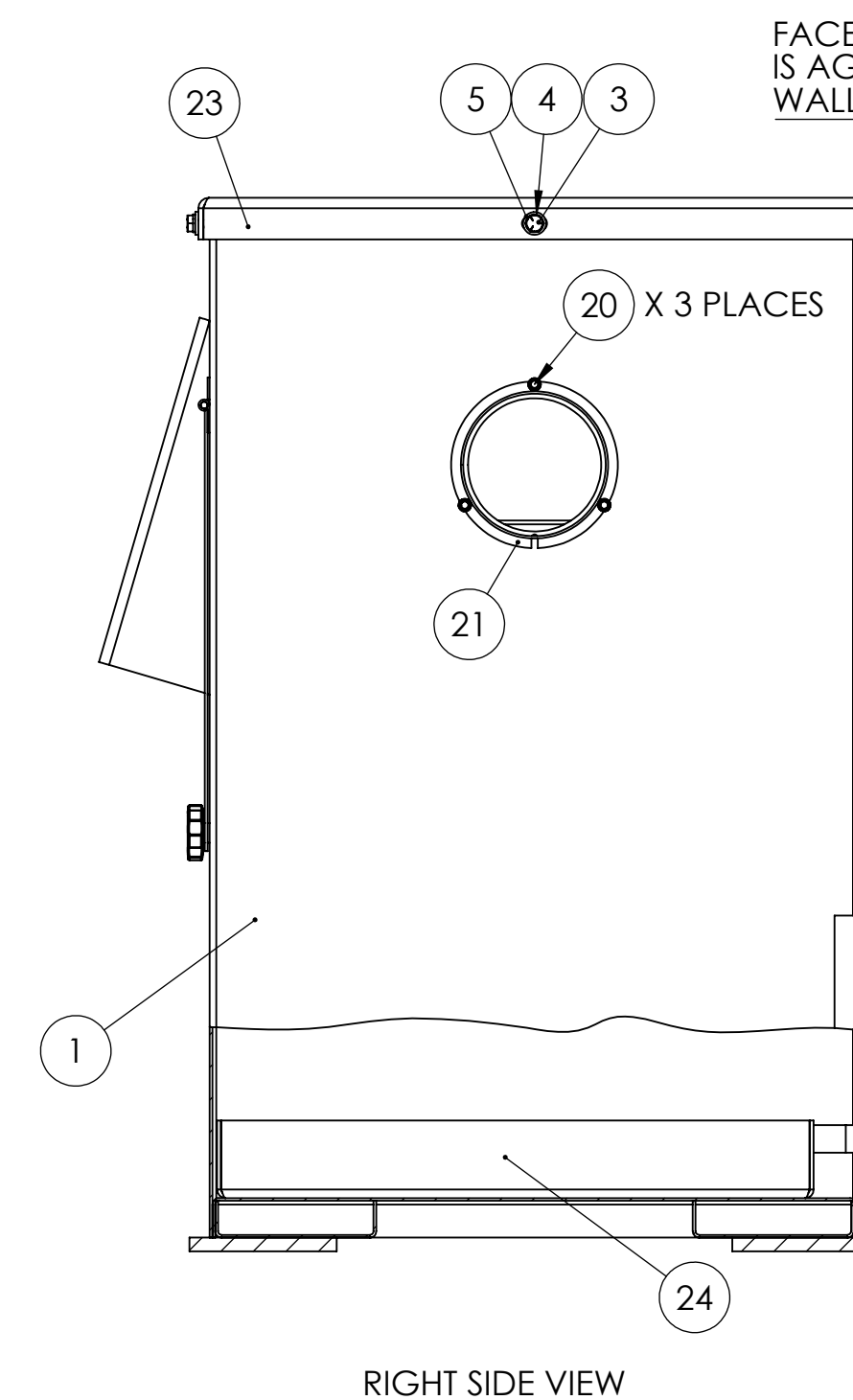
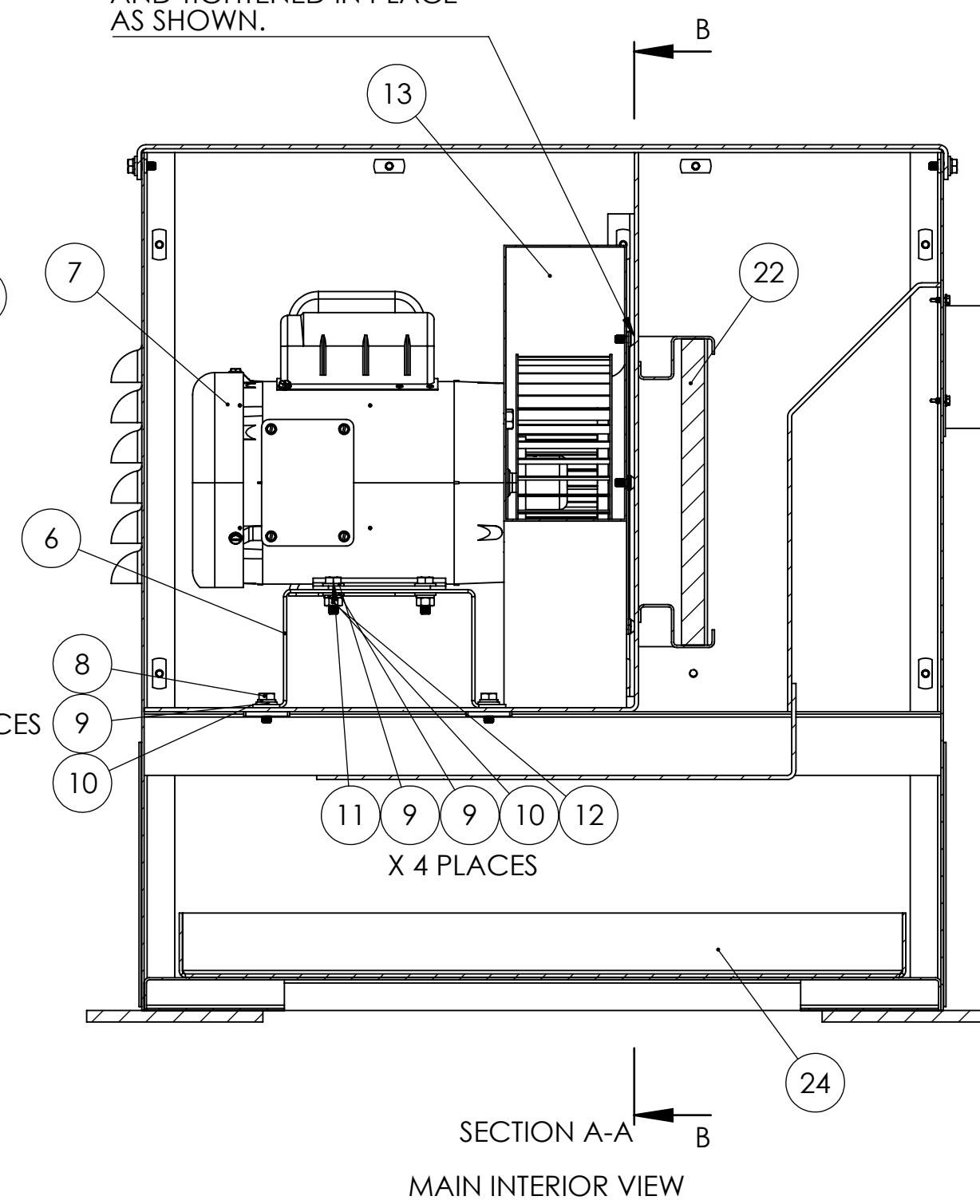
DETAIL F
SCALE 1 : 1
MOTOR MOUNT DETAILS



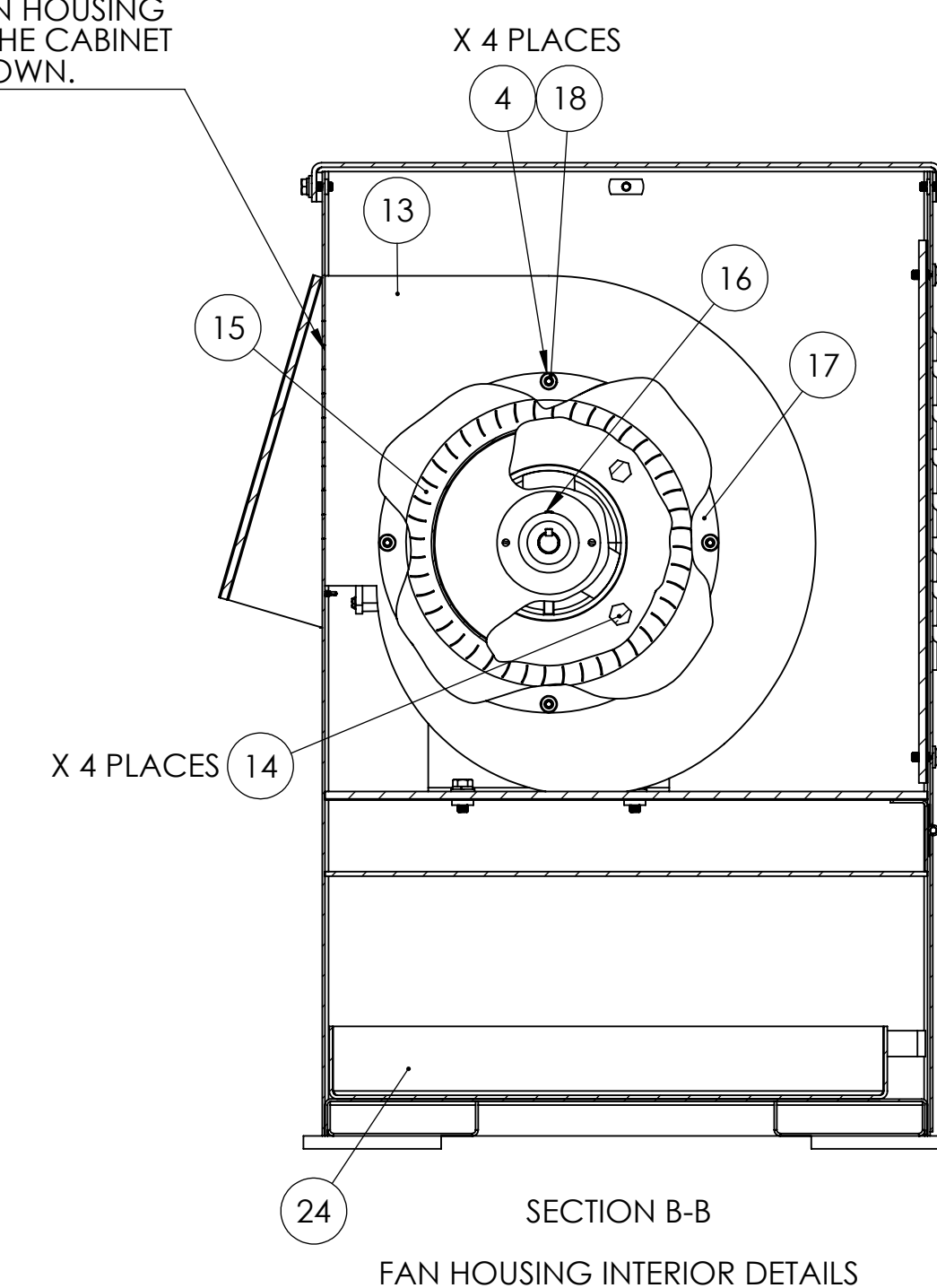
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	124-005	CABINET FOR DCV-6 DUST COLLECTOR	1
2	124-005-BACKPANEL	BACK PANEL ASSEMBLY FOR DCV-6 CABINET	1
3	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	12
4	SLWZ025	1/4 SPLIT L/W Z	16
5	UFWZ025	1/4 USS F/W Z	12
6	041-015	DCV-6 VACUUM MOTOR MOUNT BRACKET	1
7	486-002	1 HP MOTOR FOR 2FSM-1HP, 2FS72M-1HP, S272, S45-1HP, S45WB, S460D, BG272, DCV-6, DCV-8	1
8	HHC5031012	5/16-18 X 3/4 HHCS GR5 Z	4
9	UFWZ031	5/16 USS F/W Z	12
10	SLWZ031	5/16 SPLIT L/W Z	8
11	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
12	FHN5031	5/16-18 FHN GR5 ZINC	4
13	386-026	HOUSING FAN FOR DCV-6	1
14	HHC5037016	3/8-16 X 1 HHCS GR5 Z	4
15	296-001	FAN, SQUIRREL CAGE FOR DCV-6	1
16	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	1
17	004-005	ADAPTOR, INLET CONE FOR DCV-6	1
18	BSCA025008	1/4-20 X 1/2 BSHCS	4
19	455-018	SMALL LOUVER PANEL FOR DCV-6 DUST COLLECTOR	1
20	HWTZ008008	#8 X 1/2 HWH TEKS Z	7
21	342-069B	4" ORIFACE W/ FLANGE FOR 6" SANDER GUARDS	1
22	294-003	FILTER FOR DCV-6	1
23	124-006	VACUUM CABINET TOP FOR DCV-6	1
24	834-002	DUST TRAY FOR DCV-6	1
25	933-001 X 65 INCHES	65 INCHES OF WEATHER STRIPPING AROUND CABINET LOWER ACCESS DOOR	1
26	441-015	907B-2500-1.00S 1/4 THUMBSCREW 1-1/2 DIA	1



MOTOR BASE, MOTOR, AND FAN HOUSING ASSEMBLY IS PUSHED AGAINST THE WALL AND TIGHTENED IN PLACE AS SHOWN.



FACE OF FAN HOUSING IS AGAINST THE CABINET WALL AS SHOWN.



LEFT SIDE VIEW

FRONT VIEW

SECTION A-A
MAIN INTERIOR VIEW

RIGHT SIDE VIEW

SECTION B-B
FAN HOUSING INTERIOR DETAILS

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES			
FRACTIONAL: ±			
ANGULAR: MATCH ±	BEND ±		
TWO PLACE DECIMAL: ±	THREE PLACE DECIMAL: ±		
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL			
FINISH			
APPLICATION	DO NOT SCALE DRAWING		

DRAWN	CHECKED	ENG APPR.	MEG APPR.	Q.A.	COMMENTS:

TITLE: **DCV-6 DUST COLLECTOR**

SIZE DWG. NO. **D DCV-6** REV

SCALE: 1:5 WEIGHT: SHEET 1 OF 1

