

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



PH: (269) 382-2050

www.kalamazooind.com

**K16-18 16" TO 18" CHOP SAW
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.**

K16-18 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 2500 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.

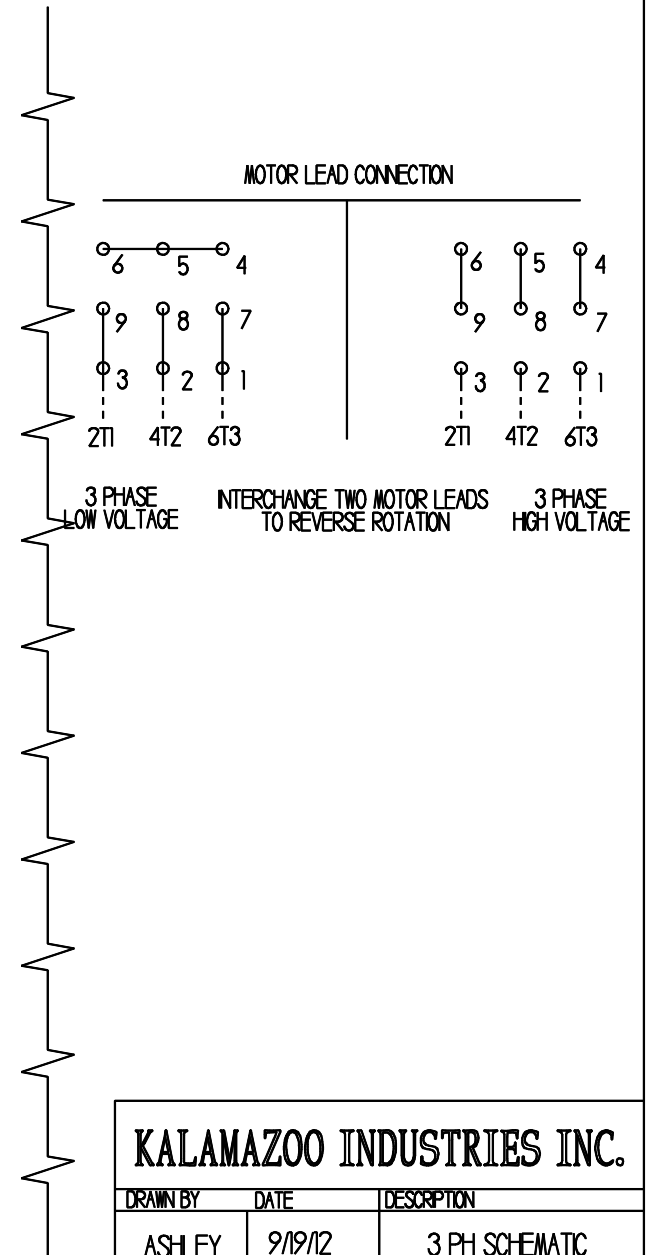
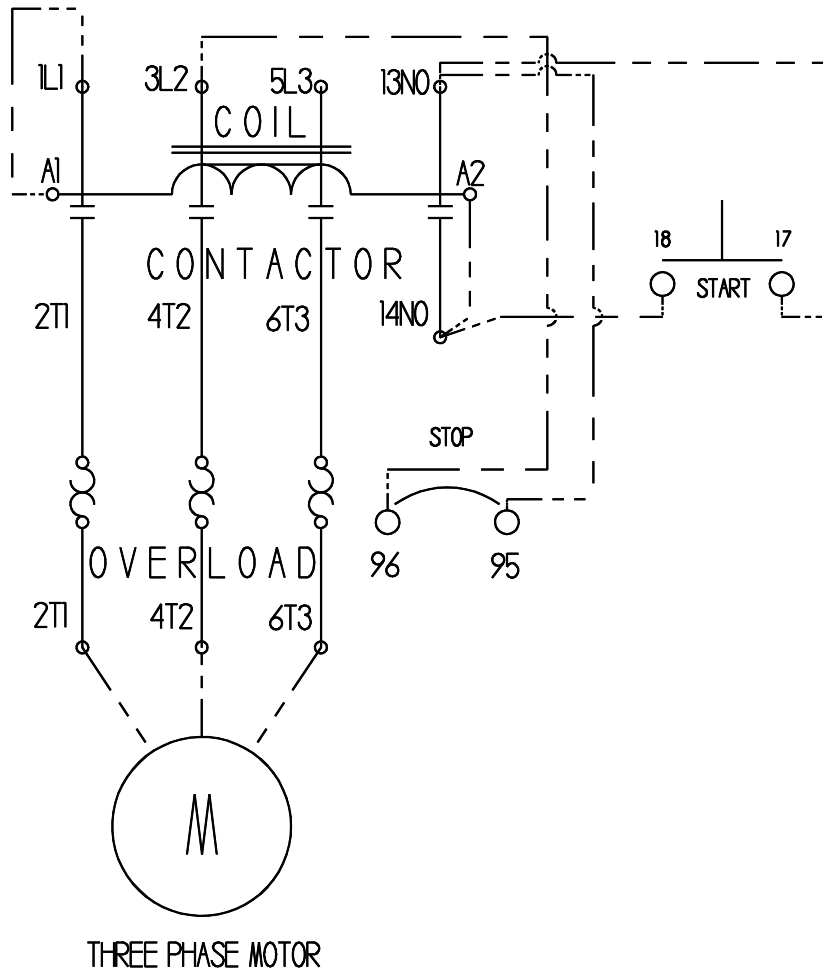
DON'T

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 fir 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 K16-18 AND K20SSF OPERATION

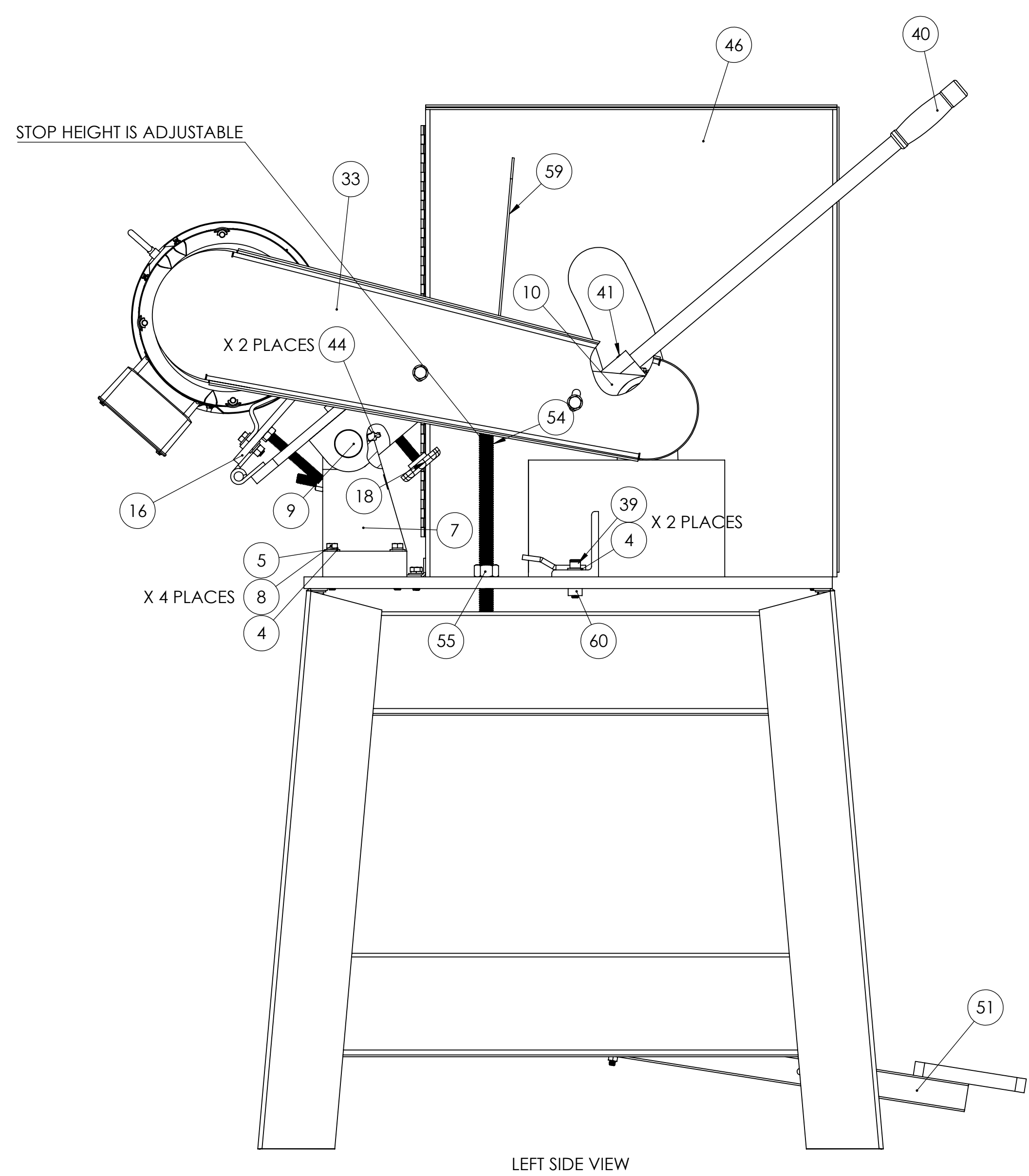
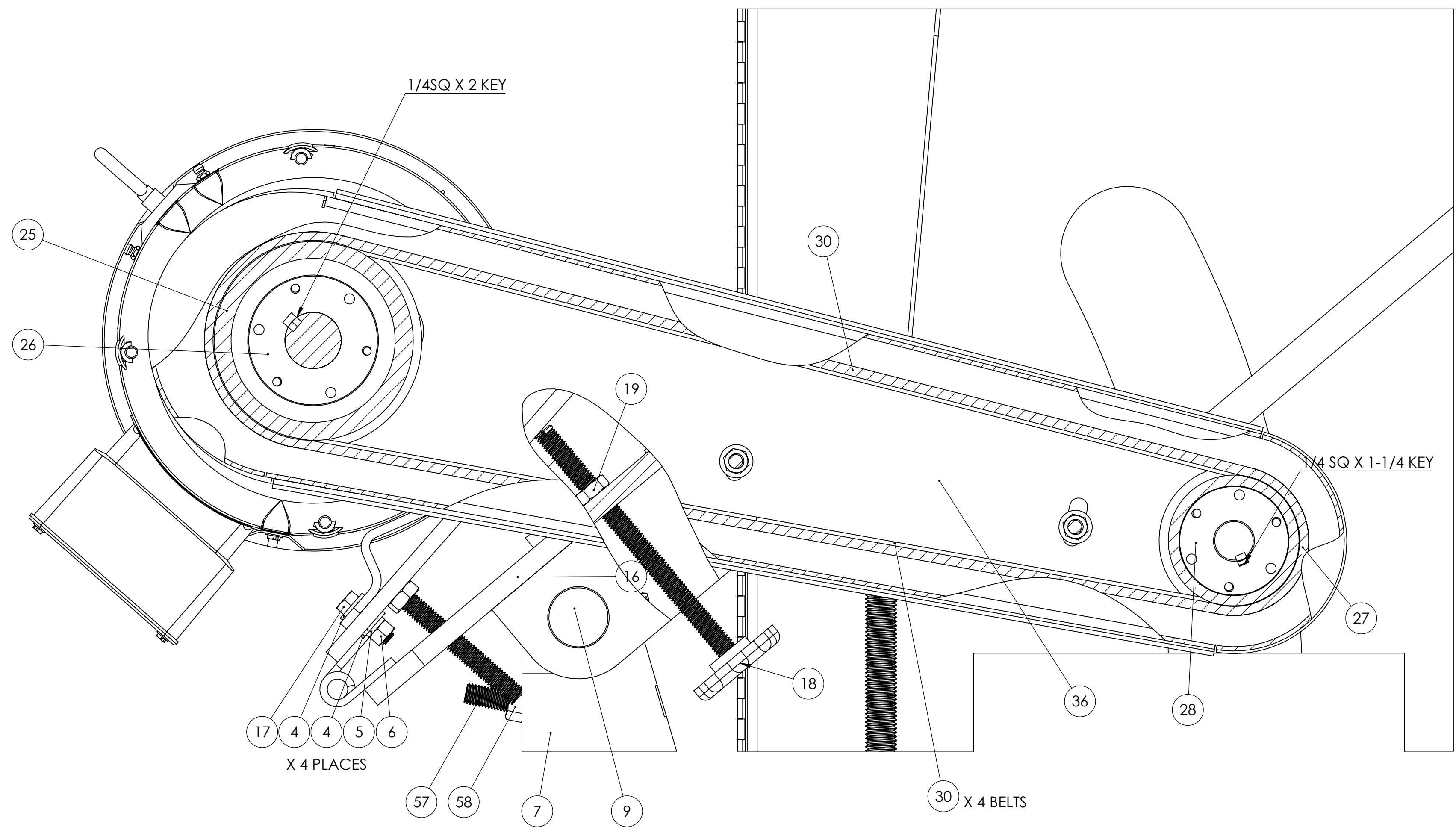
1. Be sure of the correct electrical power (phase and voltage) for the motor. The motor has a wiring diagram with specifications on the outer motor case. Verify electrical power before operating. Connect incoming AC power to **L1, L2, and L3** on the contactor. **CAUTION: IF NOT FAMILIAR WITH ELECTRICAL, CONSULT AN ELECTRICIAN!!! FOLLOW ALL SAFETY PROCEDURES. SEE THE ABRASIVE SAFETY SHEET.**
2. Clamp the part securely. Wrap the chain around the piece over the back fence as tight as possible (with foot pad to lock pad). Slip the chain link into the clevis; step down and to the right on the foot pad to close the foot pad and tighten the chain around the part. The part that you need to cut can't move when clamped. Re-adjust the chain if necessary and re-clamp. **NOTE: THE PART CENTER LINE SHOULD BE AHEAD OF THE WHEEL CENTER LINE.** Use any available piece to lay against the back fence first, then the part you want to cut. (No need to cut through spacer/shim).
3. Select the correct abrasive wheel for your job. Abrasive wheels vary in hardness and grain, etc. incorrect wheels will result in nasty cuts. Good cuts are bright, not blue, and or discolored black. Please call an abrasive wheel manufacturer to select the correct wheel for your job.
4. As the abrasive wheel wears down, the down stop will need to be adjusted to allow the abrasive wheel to cut thru your part. Re-adjust the down stop when you put a new abrasive wheel on your machine. Be sure that you check to make sure that the abrasive wheel does not cut into the abrasive saw top
5. Use forceful, steady downward pressure when cutting your part. A good shower of sparks will result. Keep flammable material clear of your work and spark area.
6. Keep drive belts (4 V-belts) tight. 1/2" of slack when squeezed together. Loose drive belts result in loo of power and binding of the abrasive wheel. Carefully use a prybar to pry the motor mount back to tighten the v-belts. Re-tighten the threaded knob against the motor plate to fix belt tension.
7. Be sure to wear adequate safety protection. Safety glasses, face shield, etc. **NOTE: DO NOT OPERATE IN FLAMMABLE AREAS. DO NOT USE STEEL-TOOTHED BLADES.**

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

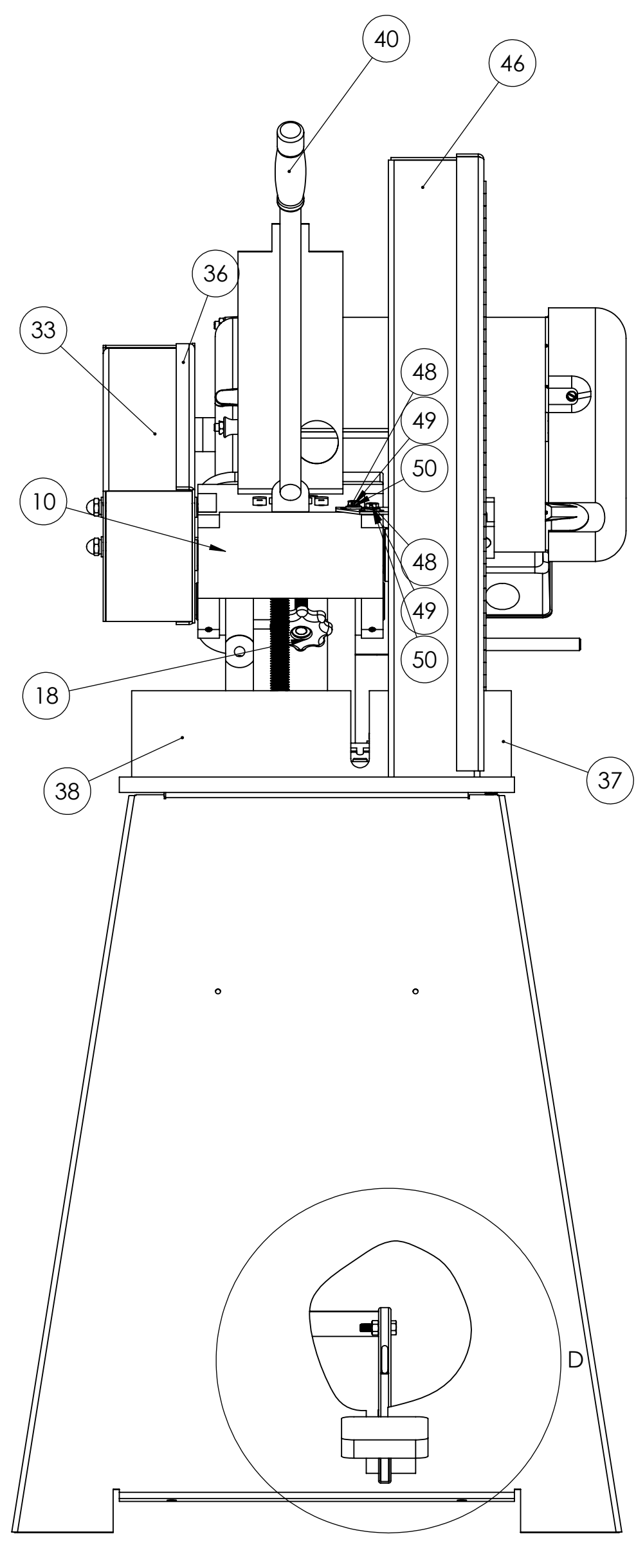


KALAMAZOO INDUSTRIES INC.		
DRAWN BY	DATE	DESCRIPTION
ASHLEY	9/19/12	3 PH SCHEMATIC
REVISED BY	DATE	PART #
MATERIAL		

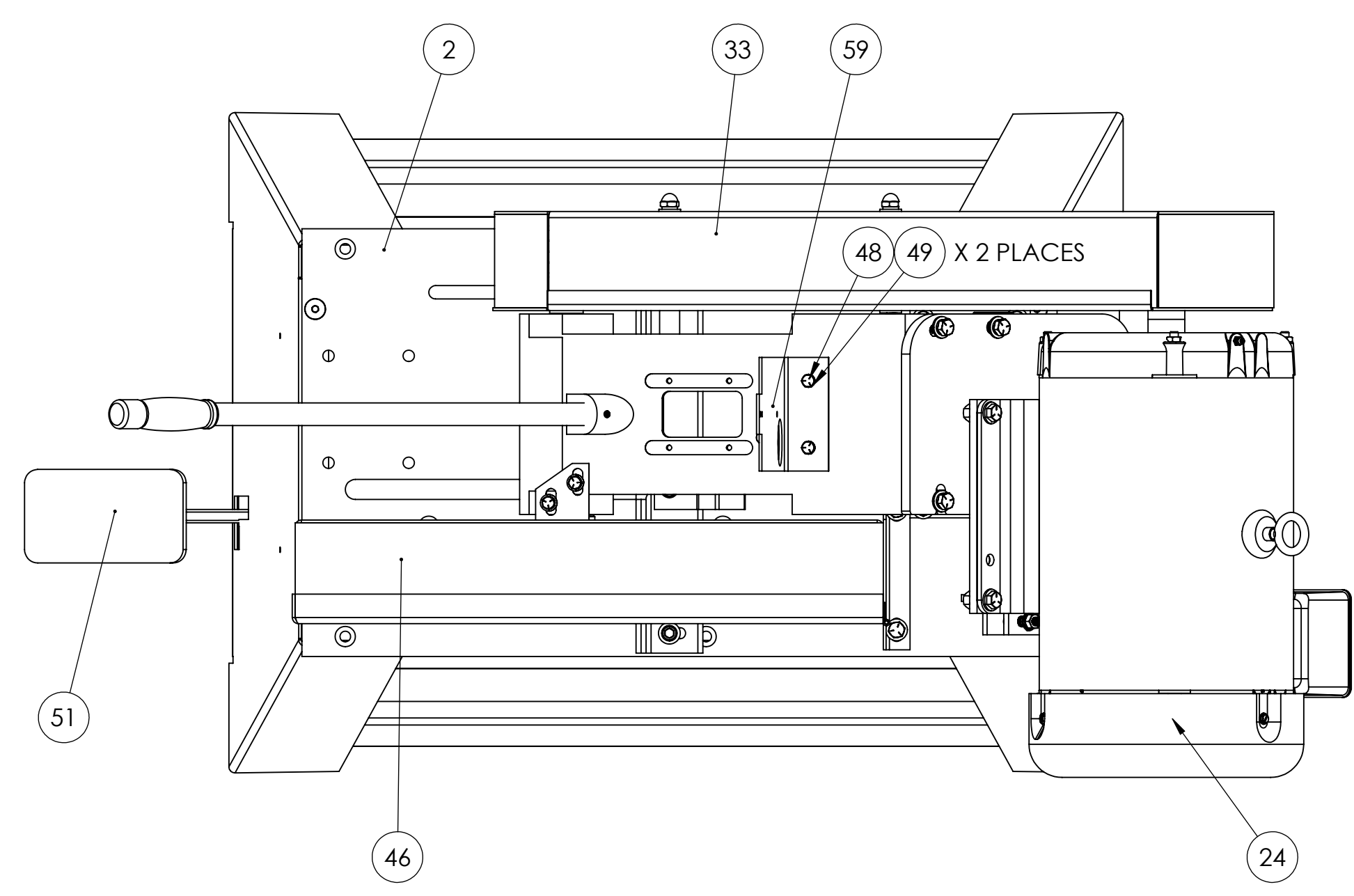
Y
X



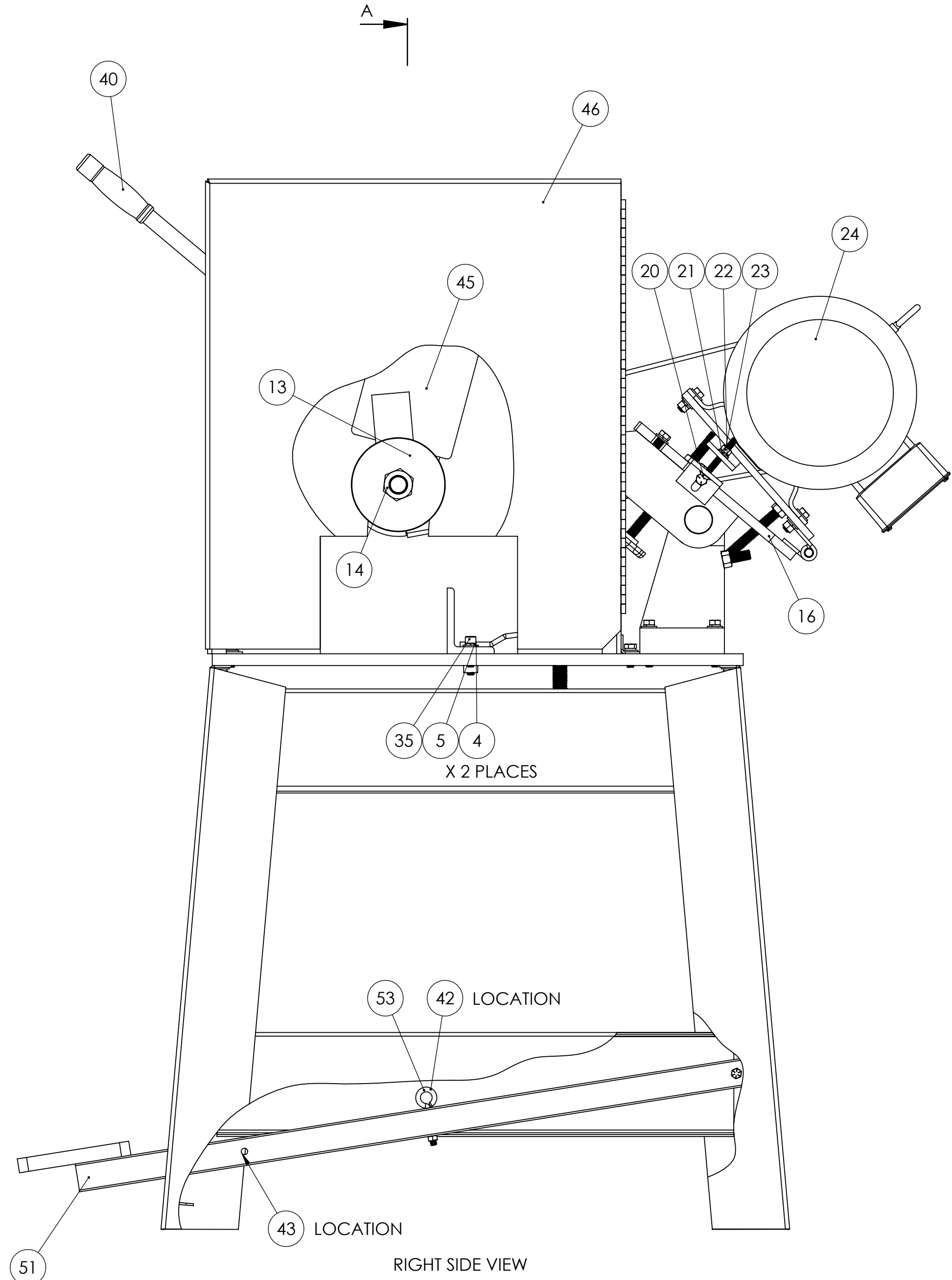
LEFT SIDE VIEW



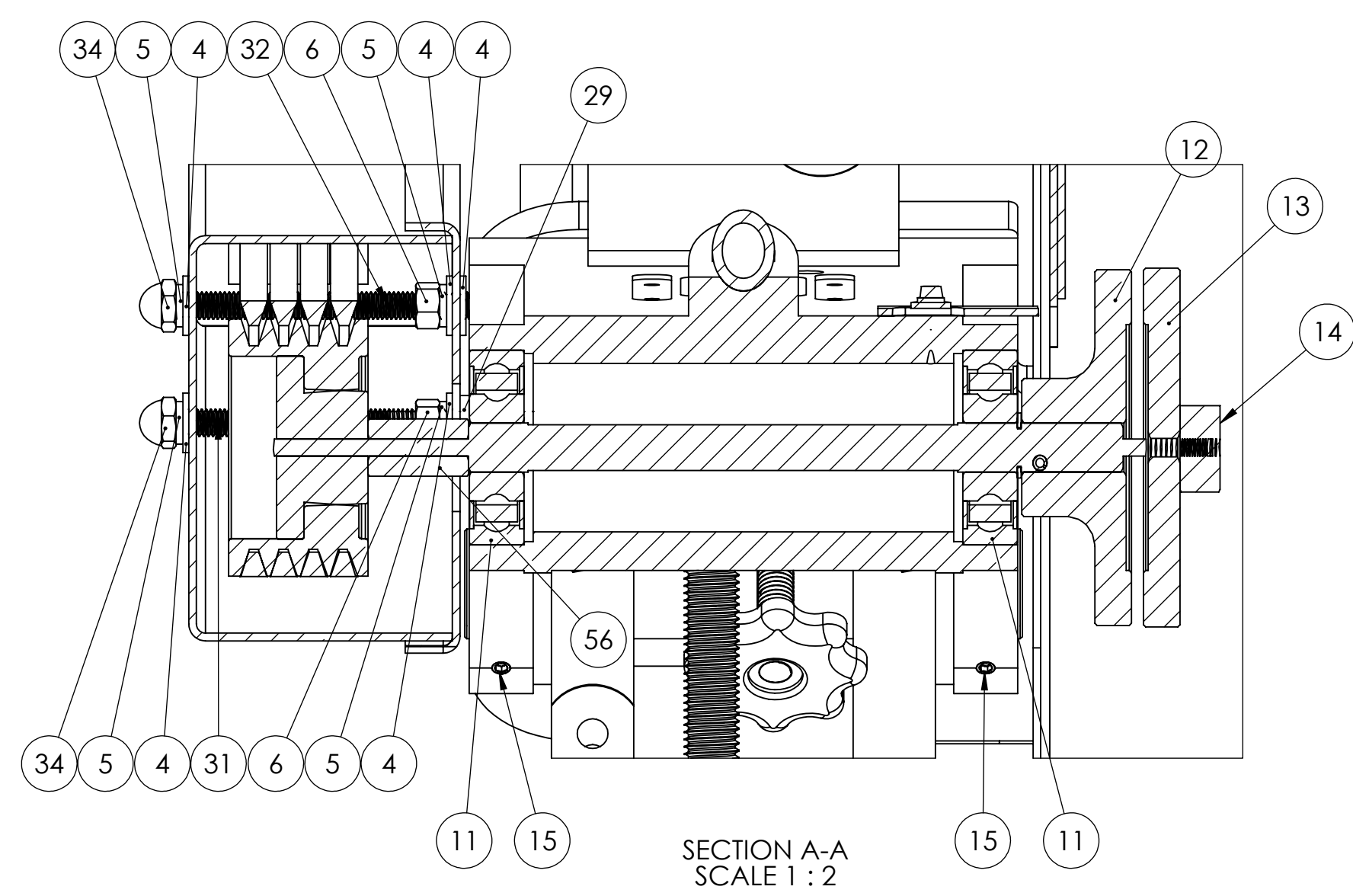
FRONT VIEW



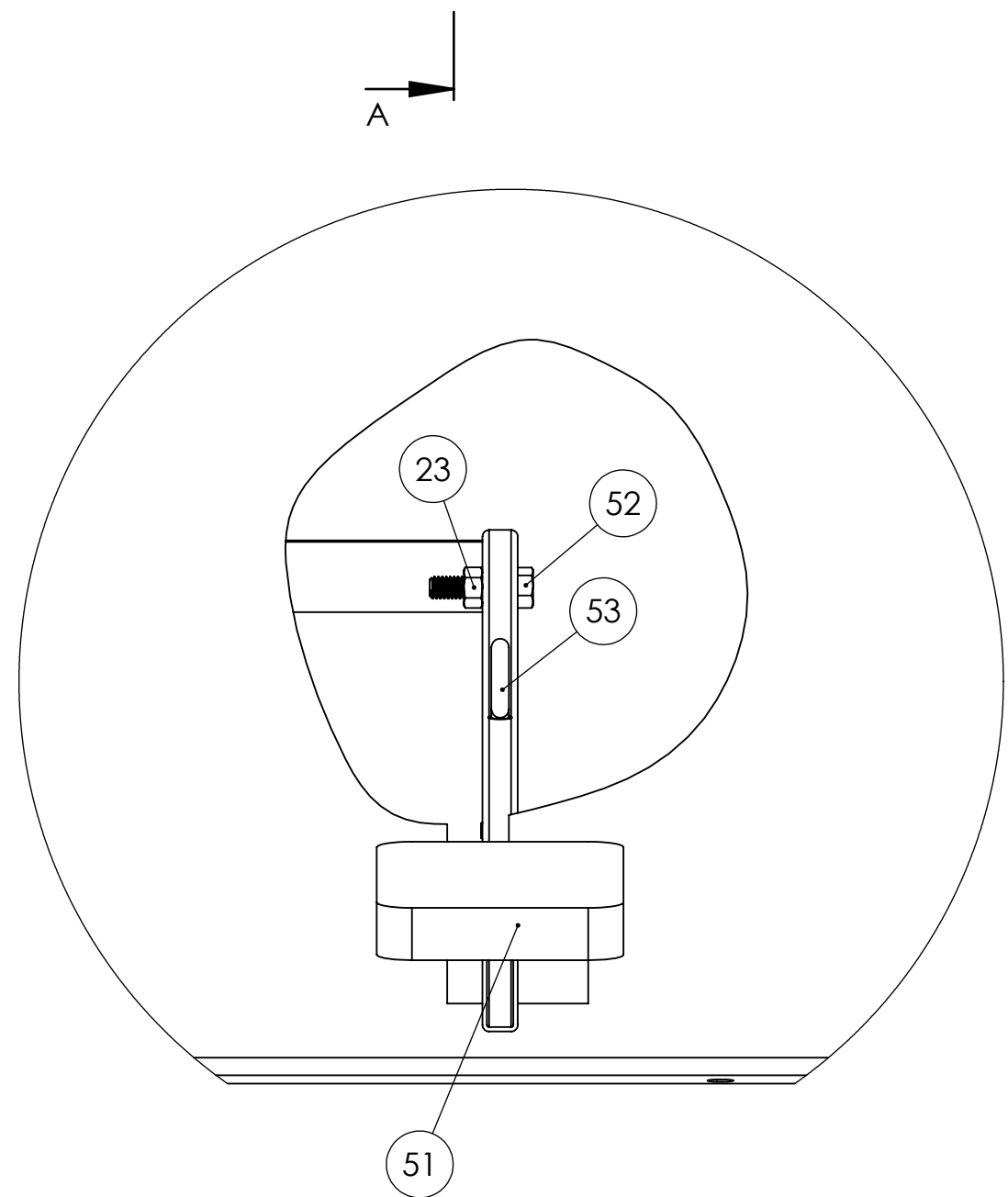
TOP VIEW



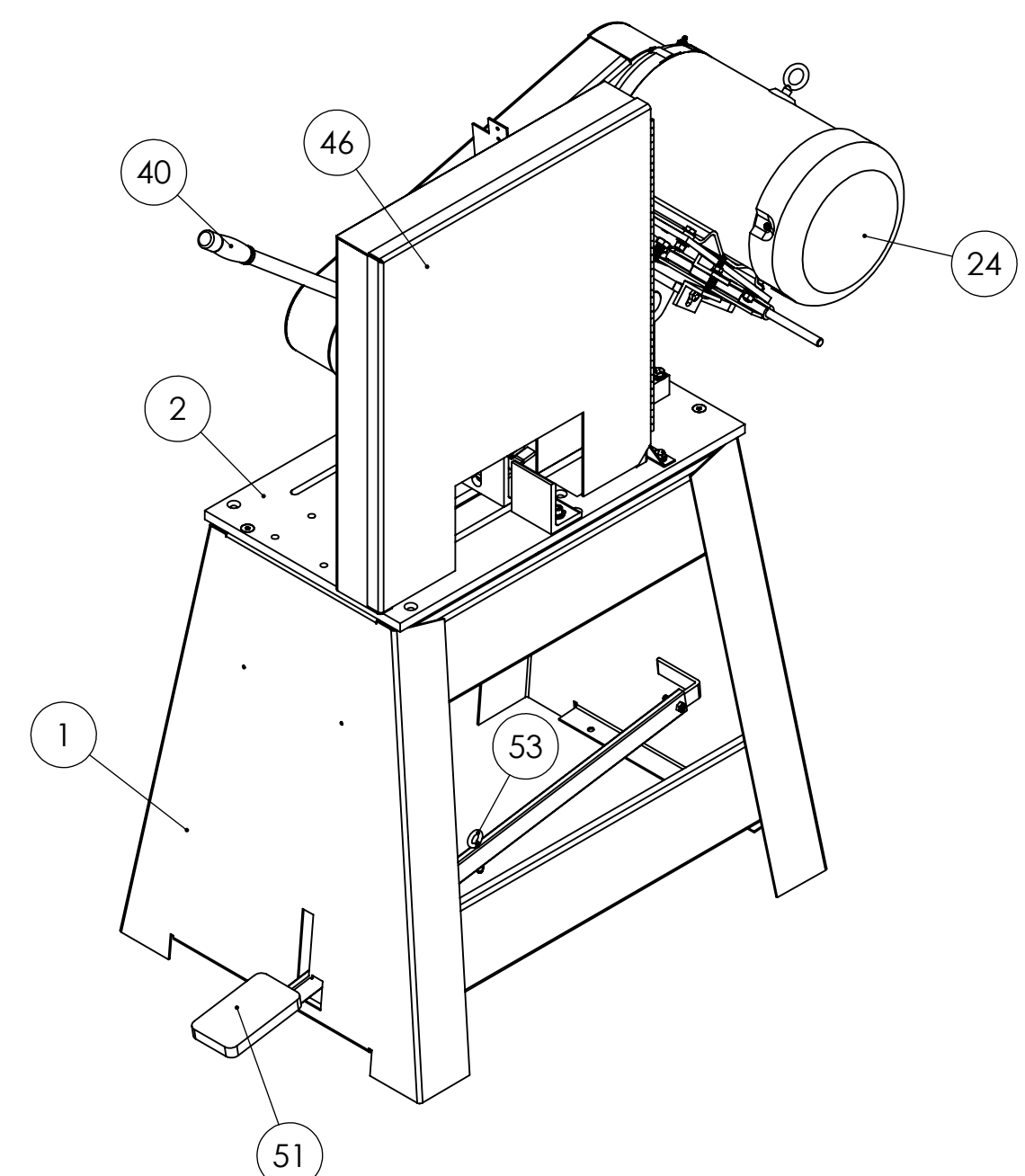
RIGHT SIDE VIEW



SECTION A-A
SCALE 1:2
INTERNAL SPINDLE VIEW



DETAIL D
SCALE 2:5



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-023	STAND ASSEMBLY FOR K16-18	1
2	050-018A	BASE, PLATE K16-18 [NEW STYLE AFTER 08/20/2014]	1
3	FSCA037020	3/8-16 X 1-1/4 FSHCS	4
4	UFWZ037	3/8 USS F/W Z	34
5	SLWZ037	3/8 SPLIT L/W Z	28
6	FHN5037	3/8-16 FHN GR5 Z	12
7	831-021	TRUNNION FOR KM16-18, K16-18, K20SSF (NEW STYLE)	1
8	HHC5037036	3/8-16 X 2-1/4 HHCS GR 5 Z	4
9	700-003	NEW STYLE TRUNNION PIN FOR K16-18, KM STYLE TRUNNION, K20SSF	1
10	002-005	SAW ARM FOR K16-18, KM16-18, AND K20SSF SAW	1
11	044-004	K20 SPINDLE BEARING	2
12	701-010	SPINDLE W TIGHT FLANGE FOR K16-18, K20SSF, K20E SAWS	1
13	292-011	LOOSE FLANGE FOR K16-20, KM16-18, KM20-22	1
14	537-027	SPINDLE NUT FOR K16-20	1
15	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
16	486-010	MOTOR MOUNT PLATE FOR K16-20 ASSEMBLY	1
17	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	8
18	696-029	MOTOR PLATE TENSION SCREW FOR K16-K20 SAWS	1
19	FJNZ050	1/2-13 F H JAM NUT Z	1
20	CRBZ031040	5/16-18 X 2-1/2 CARRIAGE BOLT Z	1
21	UFWZ031	5/16 USS F/W Z	1
22	SLWZ031	5/16 SPLIT L/W Z	1
23	FHN5031	5/16-18 FHN GR5 ZINC	2
24	486-019	10HP MOTOR FOR K16-18, KM16-18, BG14	1
25	560-046	MOTOR PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, KM20-22/15, KM20-22W/15 (K20SSF 7 1/2 HP), SPINDLE PULLEY SHEAVE FOR K20SW-15HP & 20HP	1
26	049-003	MOTOR PULLEY BUSHING FOR K16-18, KM16-18, K20SSF-15, K20RS-15, K20SW-15, KM20-22-15HP, KM20-22W-15, FOR K16-18, KM16-18, K20SSF-15, K20RS-15, K20SW-15, KM20-22-15HP, KM20-22W-15	1
27	560-047	SPINDLE PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, K20RS, KM20-22/15, MOTOR PULLEY SHEAVE FOR K20SW-20HP	1
28	049-004	SPINDLE PULLEY BUSHING FOR K16-18, K20SSF-15HP, K20RS-15, KM16-18, KM20-22-15HP	1
29	RND-3/4CF C1018X7/8	7/8 INCHES OF RND-3/4 CF C1018	1
30	051-005	V-BELT FOR K16-18, K20SSF, K20E, K20RS, K20SW	4
31	RND-3/8-16THRDRODX6.25	6-1/4 INCHES OF RND-3/8-16 THREADED ROD	1
32	RND-3/8-16THRDRODX5.375	5-3/8 INCHES OF RND-3/8-16 THREADED ROD	1
33	342-039	OUTER GUARD, BELT FOR K16-18 AND K20SSF SAWS	1
34	CPNZ037	3/8-16 CAP NUT NICKEL	2
35	SHCA037020	3/8-16 X 1-1/4 SHCS	2
36	342-039A	GUARD, INNER BELT FOR K16-18, KM16-18, K20SSF SAWS	1
37	293-003	FENCE, RIGHT FOR K16-18, K20SSF	1
38	293-002	FENCE, LEFT FOR K16-18, K20SSF	1
39	SHCA037024	3/8-16 X 1-1/2 SHCS	2
40	381-009	HANDLE WITH GRIP FOR K16-20 ABRASIVE SAW	1
41	SSKA025006	1/4-20 X 3/8 SOC SET KNURL PT.	1
42	697-021	SPRING FOR HOOK CHAIN ASSY FOR K16-18 AND K20SSF SAWS	1
43	697-022	SPRING, FOOT PEDAL FOR K16-18 AND K20SSF SAWS	1
44	ZERK012000	1/8-27 X 1 1/16 STRT LUBE FITTING	2
45	342-030	INNER WHEEL GUARD FOR K16-18, K20SSF SAWS	1
46	342-014	WHEEL GUARD FOR K16-18 SAW	1
47	HHC5037016	3/8-16 X 1 HHCS GR5 Z	4
48	HHC5025008	3/4-10 FHN GR5 Z	4
49	SLWZ025	1/4 SPLIT L/W Z	4
50	UFWZ025	1/4 USS F/W Z	2
51	041-007	Default	1
52	HHC5031020	5/16-18 X 1-1/4 HHCS GR 5 Z	1
53	TEBZ031032	5/16X2 TURNED EYE BOLT Z	1
54	709-003	STOP, DOWN FOR K16-18 AND K20SSF SAWS	1
55	FHN5075	3/4-10 FHN GR5 Z	1
56	049-116	SPACER BUSHING FOR K20 SERIES SPINDLE	1
57	RND-1/2-13THRDRODX2	2 INCHES OF RND-1/2-13 THREADED ROD	1
58	FHN5050	1/2-13 FHN GR5 Z	1
59	041-092	SWITCH BRACKET FOR MAG SWITCH ON K20 ARM	1
60	537-007	LONG FENCE NUT FOR K16-20 SAWS	1

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONS ± .005
DECIMALS ± .001
ANGLES ± .01
HOLE POSITION ± .010
HOLE SIZE ± .0015
HOLE LOCATION ± .010
HOLE DRILLING ± .0015
HOLE TAPER ± .0015
HOLE SURFACE ± .0015
HOLE FINISH ± .0015
HOLE THREAD ± .0015
HOLE TOLERANCE ± .0015

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DATE: 08/20/2014
DRAWN BY: [REDACTED]
CHECKED BY: [REDACTED]
ENG APPR: [REDACTED]
MFG APPR: [REDACTED]
D.A.
COMMENTS:

TITLE: **K16-18 CUT-OFF SAW**

SIZE: E
DWG. NO.: **K16-18**
SCALE: 1:5
WEIGHT: [REDACTED]
REV: [REDACTED]
SHEET 1 OF 1