



K20E General Maintenance Checklist

Wet enclosed metallurgical cutoff saw - general shop-floor checklist (E-Stop references removed).

Safety every time (before any maintenance)

- ☐ Lockout/tagout electrical power.
- ☐ Shut off shop air and bleed the pressure down.
- ☐ Let the wheel come to a complete stop before opening/servicing.
- ☐ Wear face shield + safety glasses + gloves when cleaning swarf/grit.

Daily (start of shift / end of shift)

Cutting area + enclosure

- ☐ Remove swarf/grit from the cutting area, table, and cabinet floor (don't let sludge build up).
- ☐ Wipe viewing windows and verify the internal light works.
- ☐ Confirm doors close/latch fully and safety interlocks function (doors should not open during operation).

Abrasive wheel + guarding

- ☐ Inspect wheel for cracks, chips, glazing, or excessive wear; replace if questionable.
- ☐ Verify wheel guard and covers are secure (no loose hardware).

Coolant system

- ☐ Check coolant level in the tank and top off as needed (keep flow steady).
- ☐ Confirm coolant pump runs and coolant is flowing to both hoses.
- ☐ Use rust-inhibiting coolant only.
- ☐ Quick rinse/washdown as needed, then clean up standing coolant to prevent sludge.

Air/oil downfeed + vise

- ☐ Confirm shop air is dry and set at/under 60 PSI max.
- ☐ Verify vise opens/closes smoothly and clamps securely.
- ☐ Check for obvious air/oil leaks (hoses, fittings, cylinder area).

Weekly

Coolant care

- ☐ Skim/remove floating grit/sludge; wipe tank area and cabinet sump.
- ☐ Inspect pump intake/strainer (if equipped) and clear debris.
- ☐ Inspect coolant hoses for cracks/kinks and tighten clamps/fittings.

Drive + motion

- ☐ Inspect V-belts for wear and tension; adjust if needed.
- ☐ Listen for unusual spindle/motor noise during a test run.
- ☐ Check head movement is smooth (downfeed/return) and not “sticking.”

Controls + safety

- ☐ Test STOP/start functions (normal operating controls).
- ☐ Quick check of visible wiring/connectors (no rub-through, no loose conduit).

Monthly

Air/oil system

- ☐ Check hydraulic oil reservoirs/levels and condition:
- ☐ Maintain one reservoir about 1/4 full and the other about 3/4 full (they alternate during the cycle).
- ☐ If oil looks cloudy, it indicates water contamination.
- ☐ Cycle downfeed several times after topping off to purge air from lines.

Fasteners + alignment

- ☐ Tighten accessible bolts/screws that can loosen from vibration.
- ☐ Check wheel flanges/arbor area for grit buildup; clean mating surfaces before reinstalling wheel.

Electrical

- ☐ Inspect electrical connections for looseness/corrosion (power off).

Quarterly (or every ~250 hours)

- ☐ Inspect spindle bearings for play/noise.
- ☐ Inspect all guards, door latches/interlocks, and STOP function; replace worn parts.
- ☐ Inspect air valves/regulators for sticking/corrosion (dry air prevents failures).
- ☐ Drain/refresh coolant if it's dirty, smells rancid, or leaves heavy residue (per coolant supplier guidance).

Annual (or every ~1,000 hours)

- ☐ Full mechanical inspection: belts, pulleys, spindle, pivot points, clamps/vises, fasteners.
- ☐ Full electrical inspection by a qualified person: contactor/overloads, wiring condition, grounding.
- ☐ Replace wear items proactively if the saw is a daily runner (belts, coolant hoses, light, seals as needed).

Simple maintenance log (copy/paste)

Date: _____ Hours/Cycles: _____ Performed by: _____

Daily: ☐ Clean out grit/swarf ☐ Wheel check ☐ Coolant level/flow ☐ Air pressure/dry ☐ Vise/interlocks

Weekly: ☐ Belts ☐ Pump/hoses ☐ STOP/start check ☐ Noise/vibration check

Monthly:☐ Oil levels/condition ☐ Tighten hardware ☐ Electrical visual check

Notes / parts needed: _____
