

INSTRUCTION MANUAL KM10



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www.kalamazooind.com



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.**

KM10 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

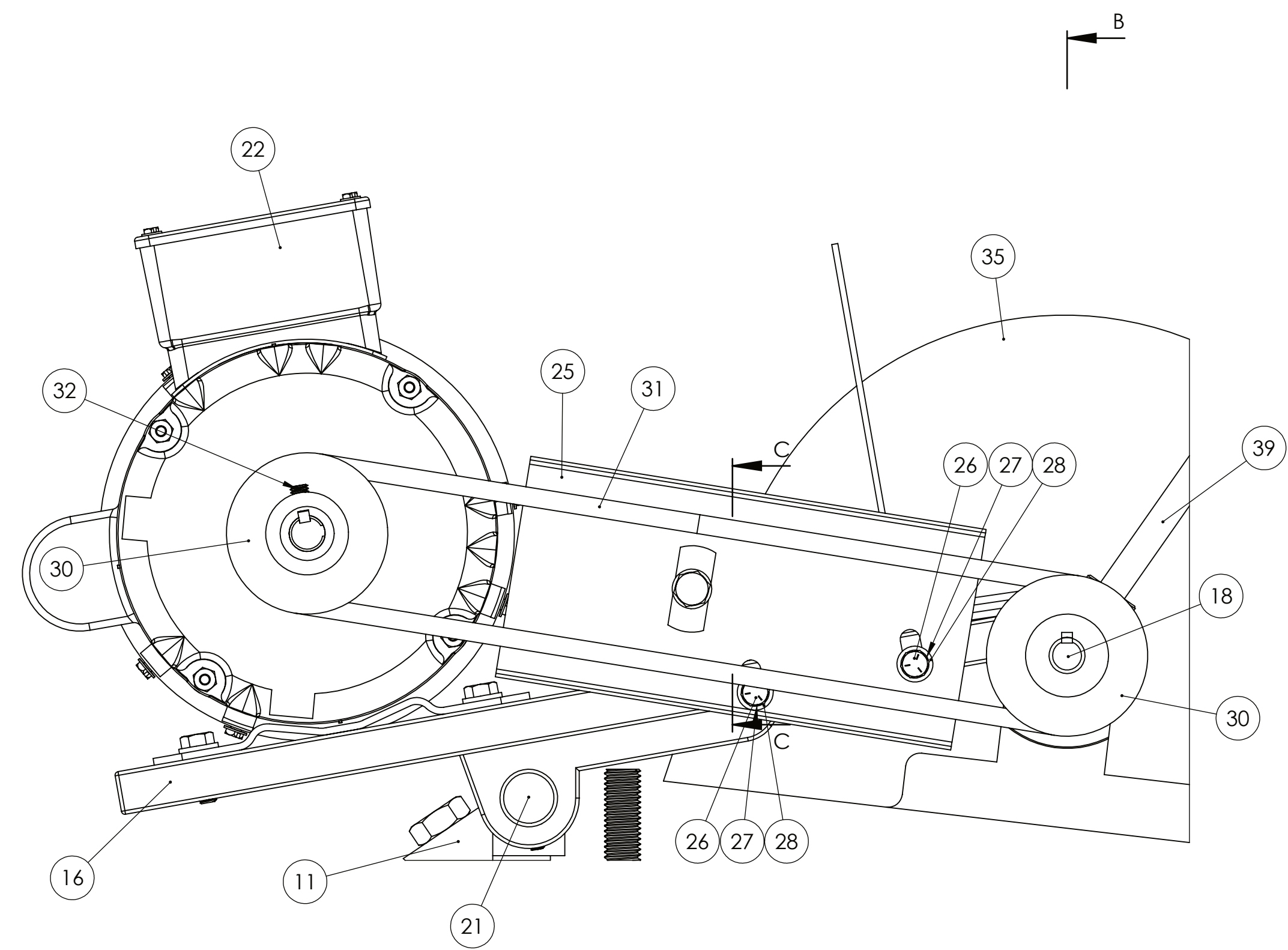
1. **DO** always handle and store wheels in the vertical position.
2. **DO** visually inspect all wheels before mounting for possible damage.
3. **DO** check machine speed against the established maximum safe operating speed marked on the wheel.
4. **DO** check mounting flanges for equal and correct 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

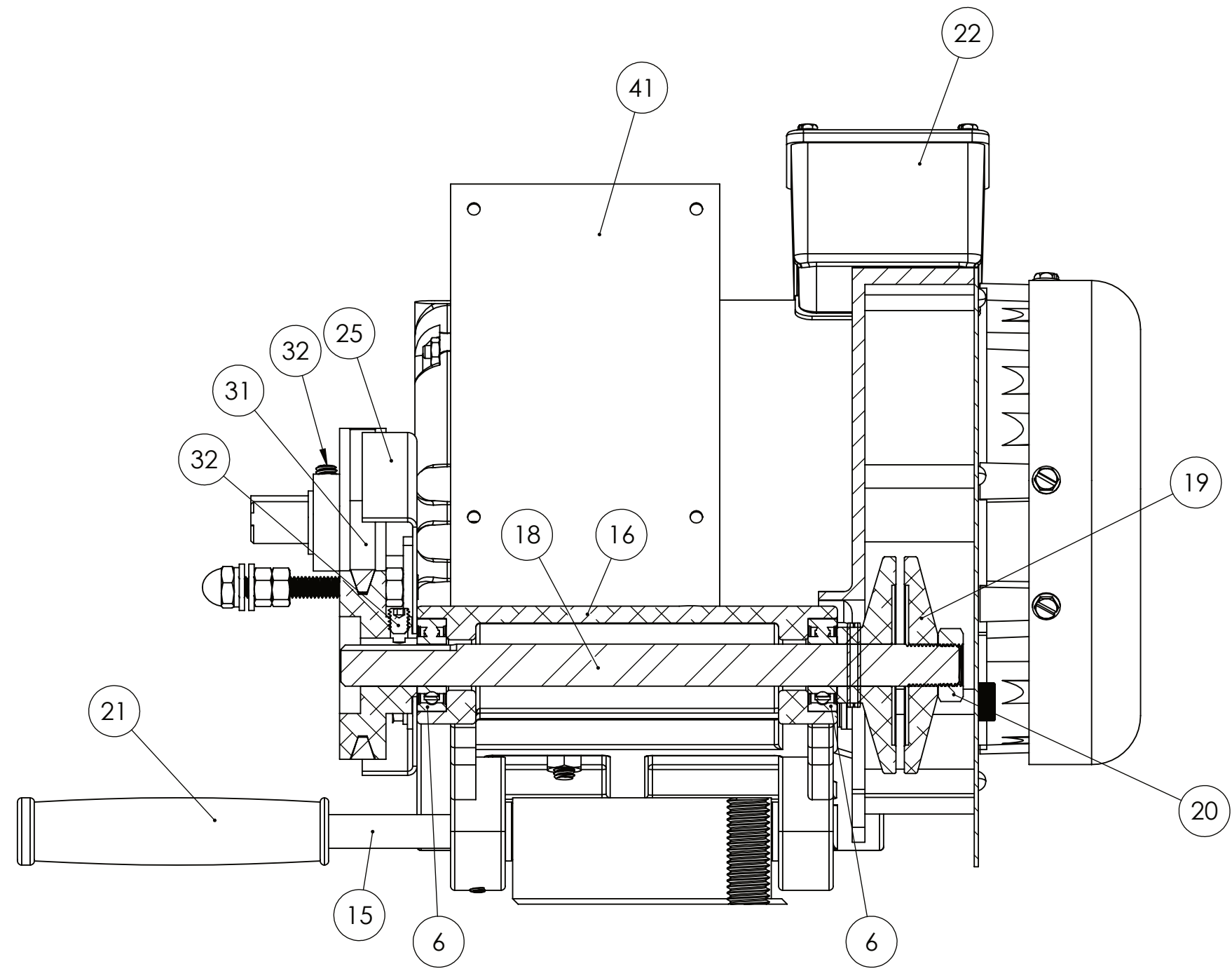
1. **DON'T** use a cracked wheel or one that has been dropped or has become damaged.
2. **DON'T** force a wheel onto the machine or alter the size of the mounting hole if wheel won't fit the machine.
3. **DON'T** ever exceed maximum operating speed established for the wheel.
4. **DON'T** use mounting 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

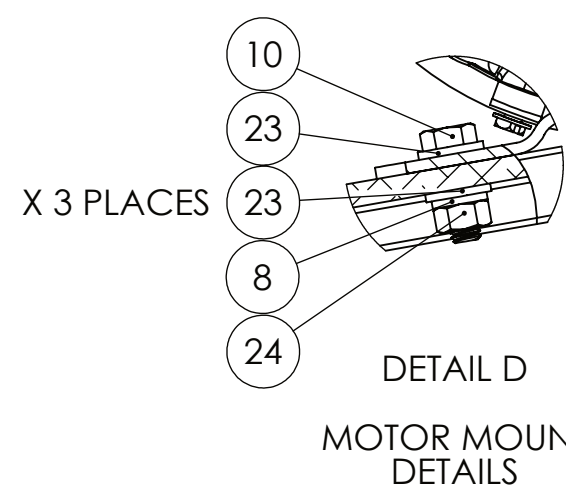
1. Be certain correct wiring is matched to motor.
2. Always keep flanges clean and tight against the abrasive wheel.
3. Be certain work piece is securely clamped in the vise. Any movement in the work piece during cutting will result in broken abrasive cutoff blades.
4. Down stop screw located on saw base (#60) under the saw arm (#16) 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. Select the correct abrasive wheel for the material. Every abrasive wheel performs differently. With low HP motors a free cutting wheel like the Kalamazoo Industries #KAB10N non-reinforce wheels give free cutting on most materials. Good cuts are bright like the material and not burned or discolored. If burning occurs then select another grade of abrasive wheel. Consult your dealer or wheel manufacturer for wheel grade selection. It may take many test cuts on different wheels to obtain the wheel that works the best for your material. Use enough cutting force to make the wheel wear or "break down".
7. **Saw spindle speed is set at 3,450 SFPM select cutoff wheel that's designed to run at 3,450 SFPM or greater. Using cutoff wheel's designed to run under 3,450 SPM could cause wheel failure and could cause serious injury to operator. Contact the wheel manufacturer or dealer for the correct wheel.**
8. 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.
9. 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 plan with a straight edge. Check motor and spindle pulleys set prior to operating the machine.



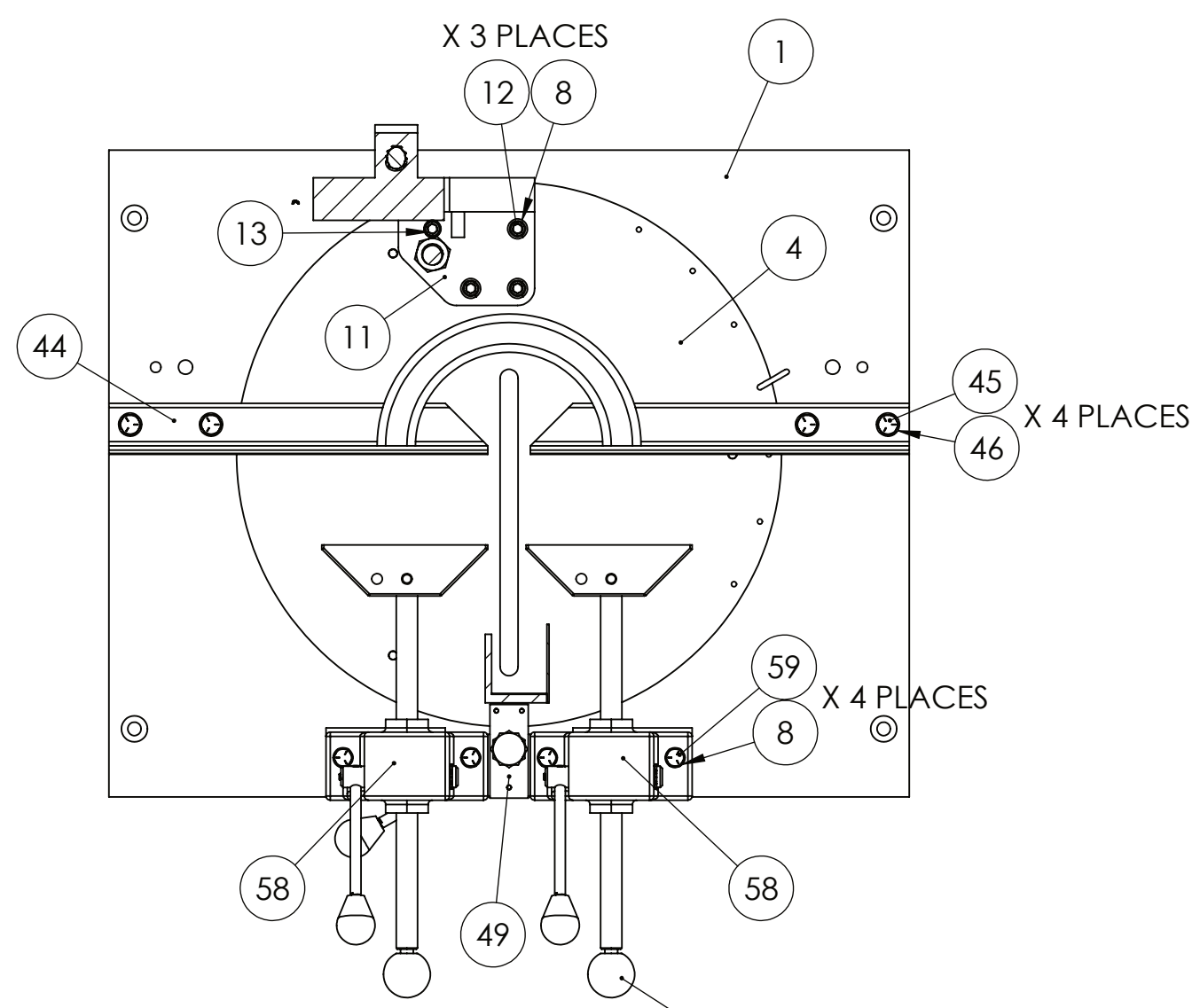
INTERNAL BELT GUARD
VIEW



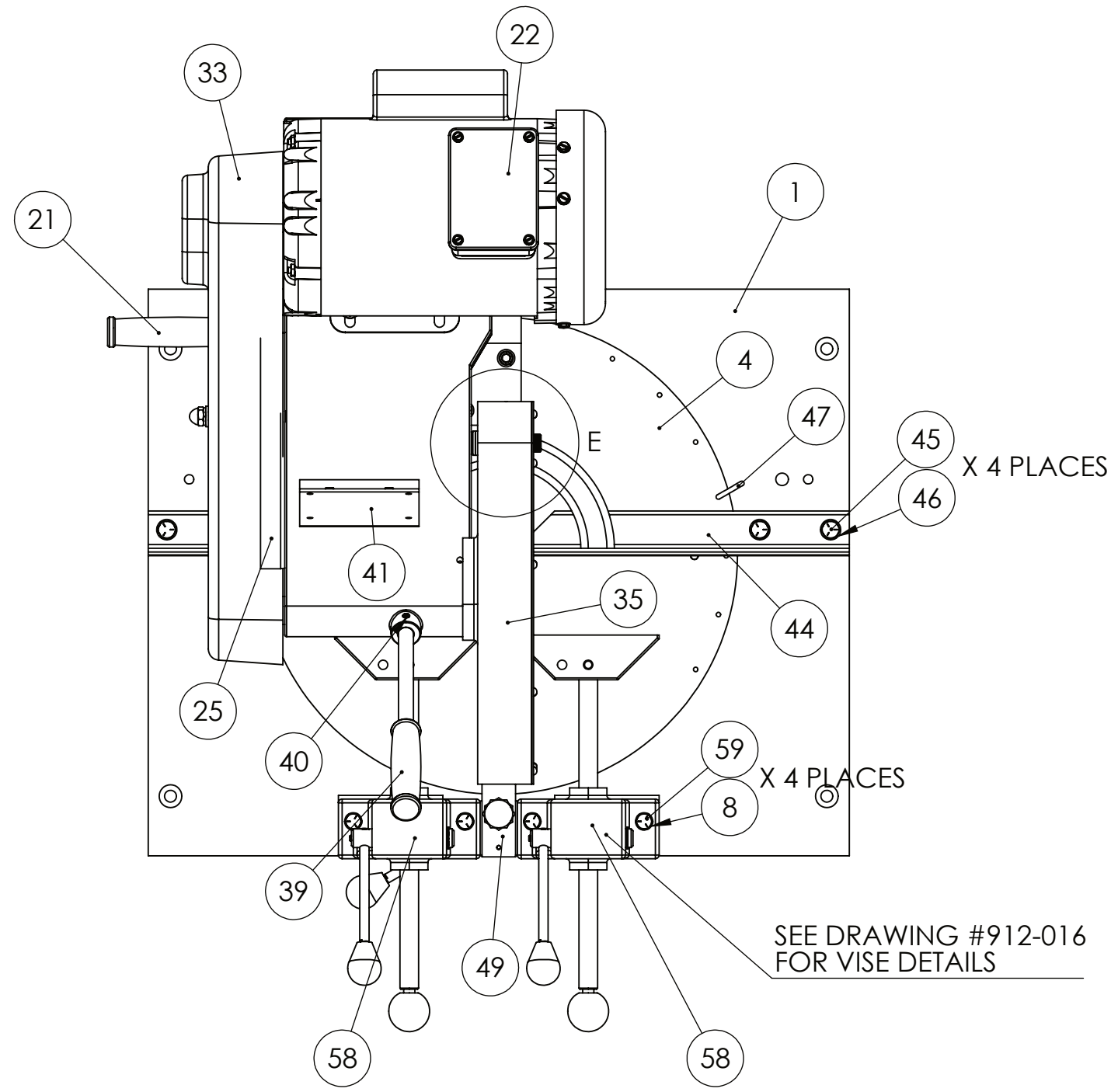
SECTION B-B
SPINDLE CROSS-SECTION



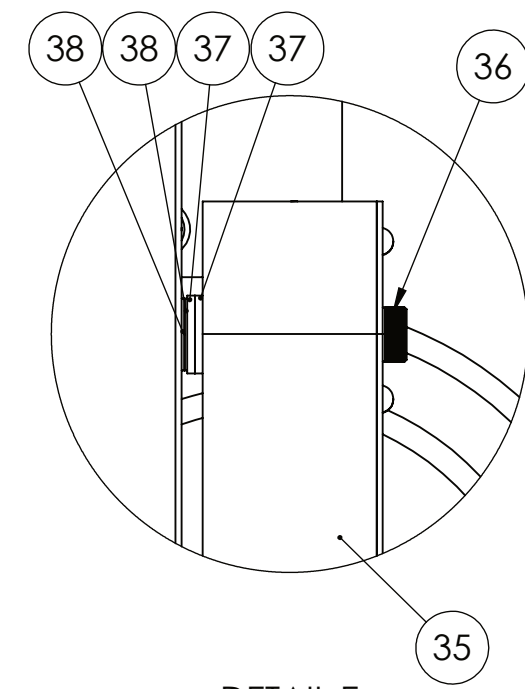
DETAIL D
MOTOR MOUNT
DETAILS



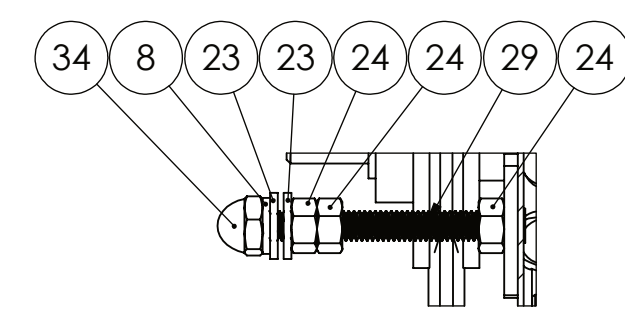
SECTION A-A
TOP VIEW LAYOUT
SCALE 1 : 5



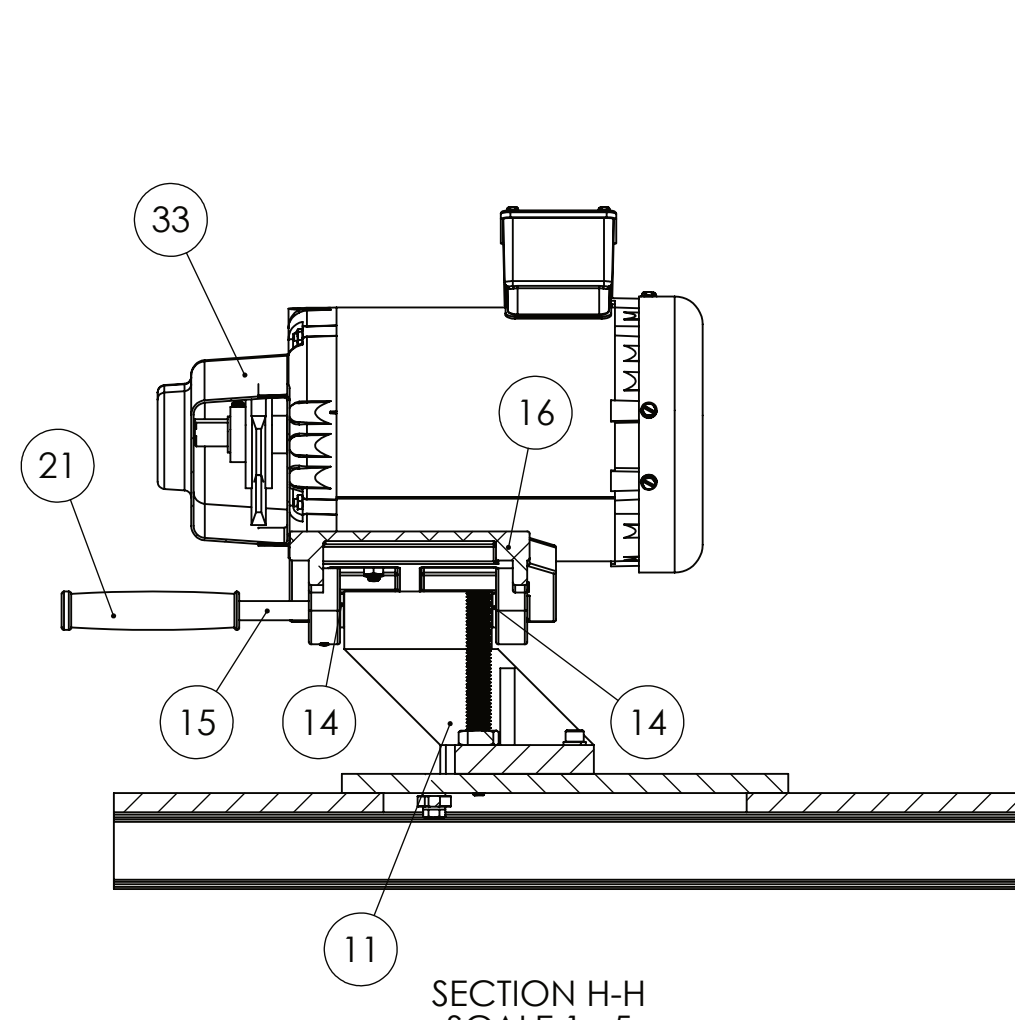
SEE DRAWING #912-016
FOR VISE DETAILS



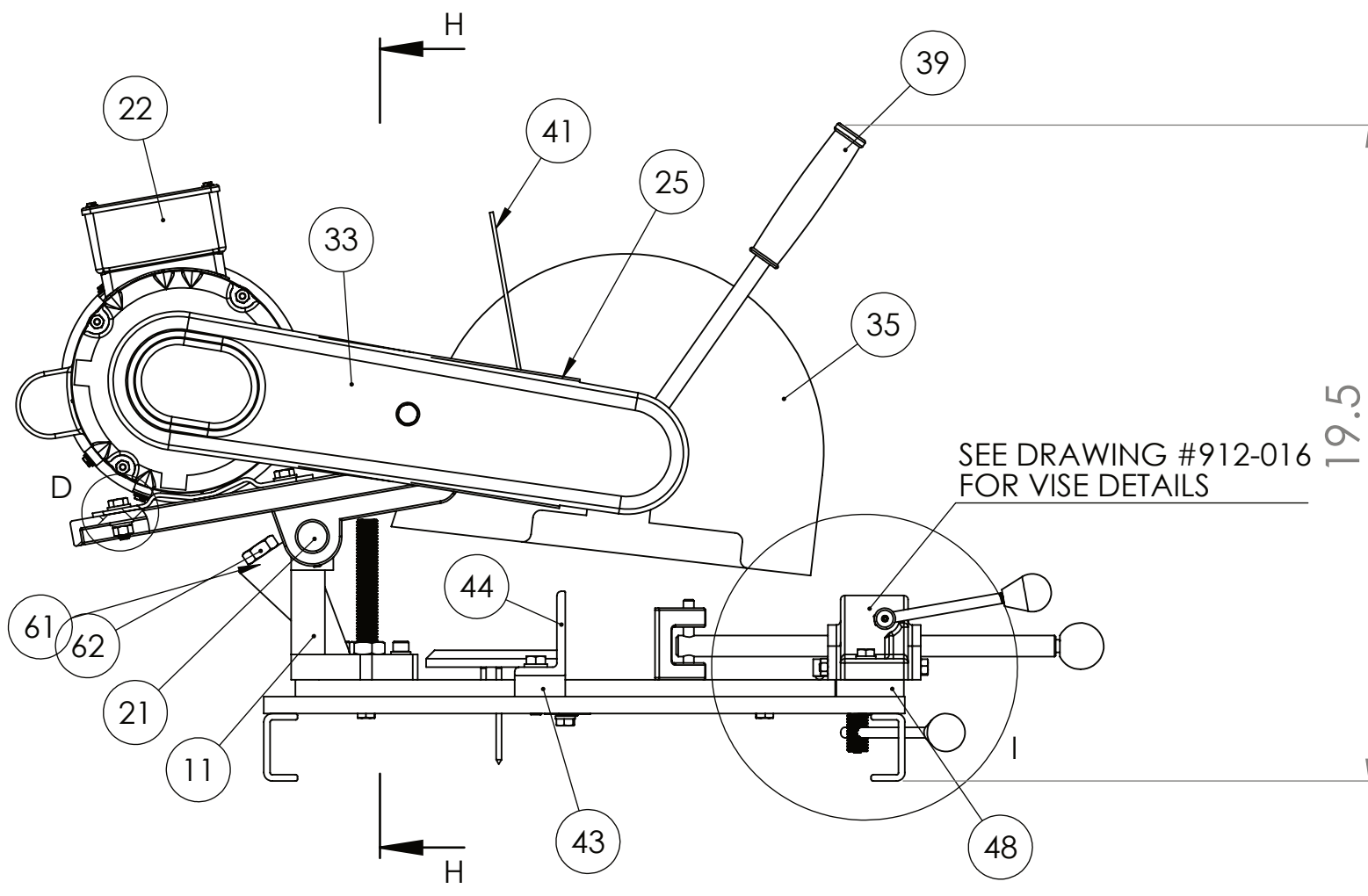
DETAIL E
WHEEL GUARD
DETAILS



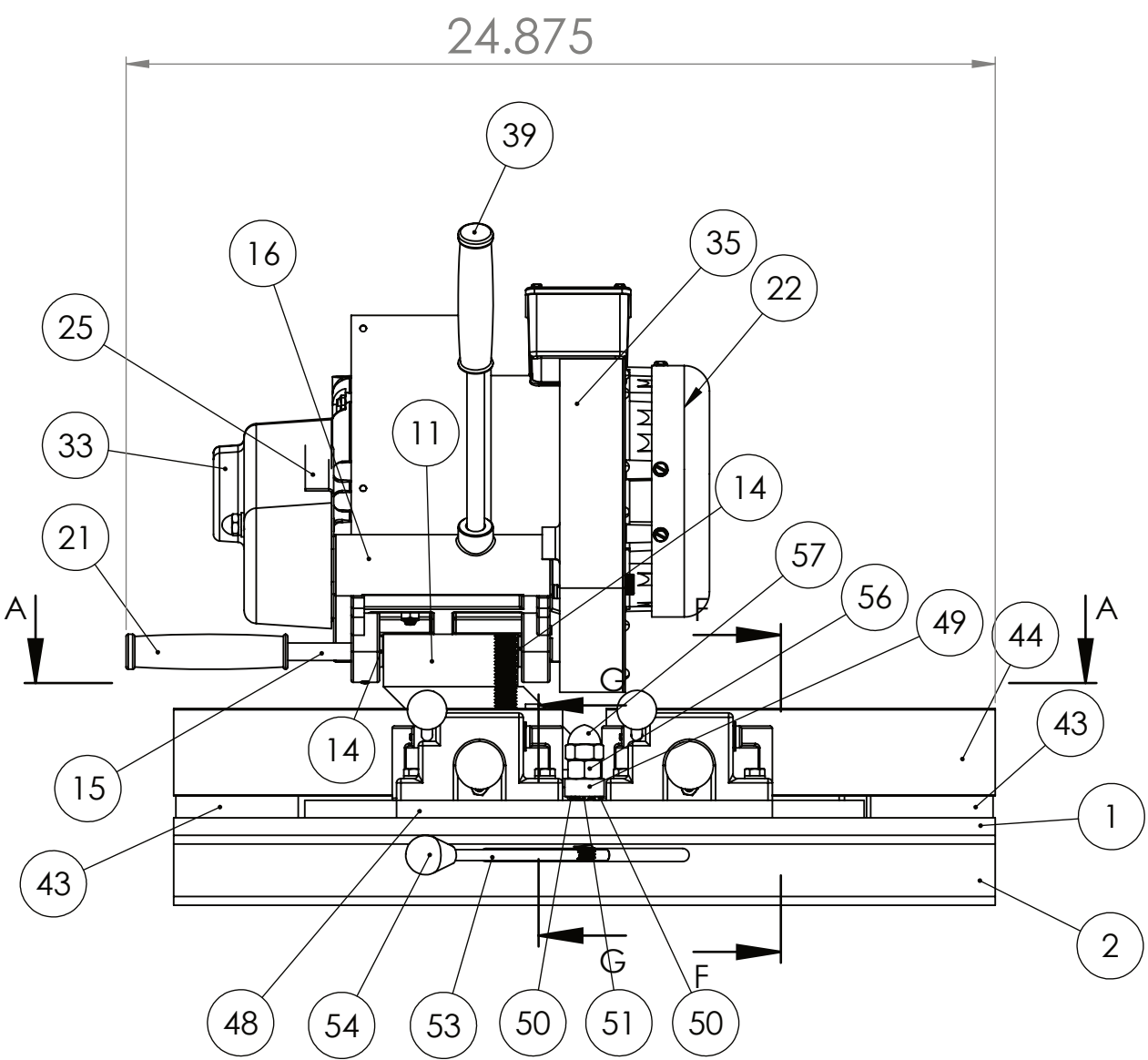
SECTION C-C
OUTER BELT GUARD
ATTACHMENT



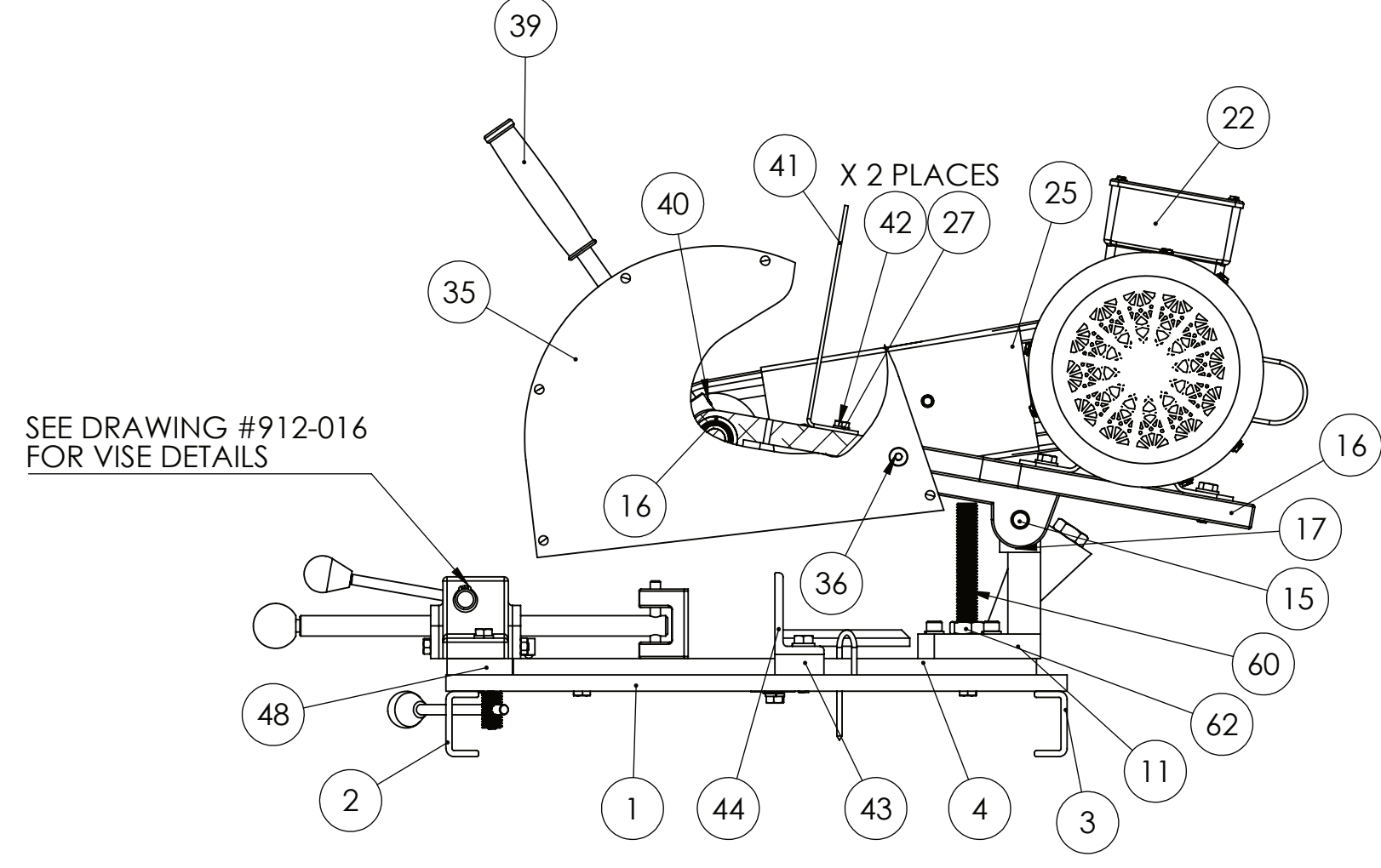
SECTION H-H
SCALE 1 : 5
FRONT OF
TRUNNION



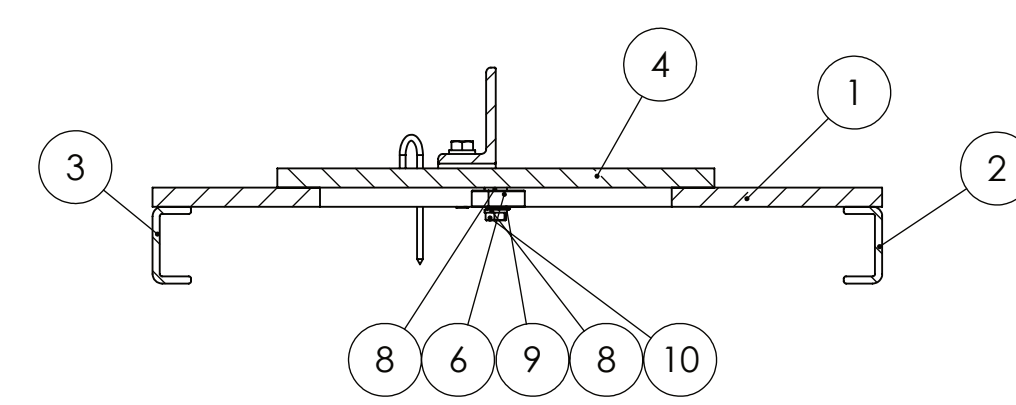
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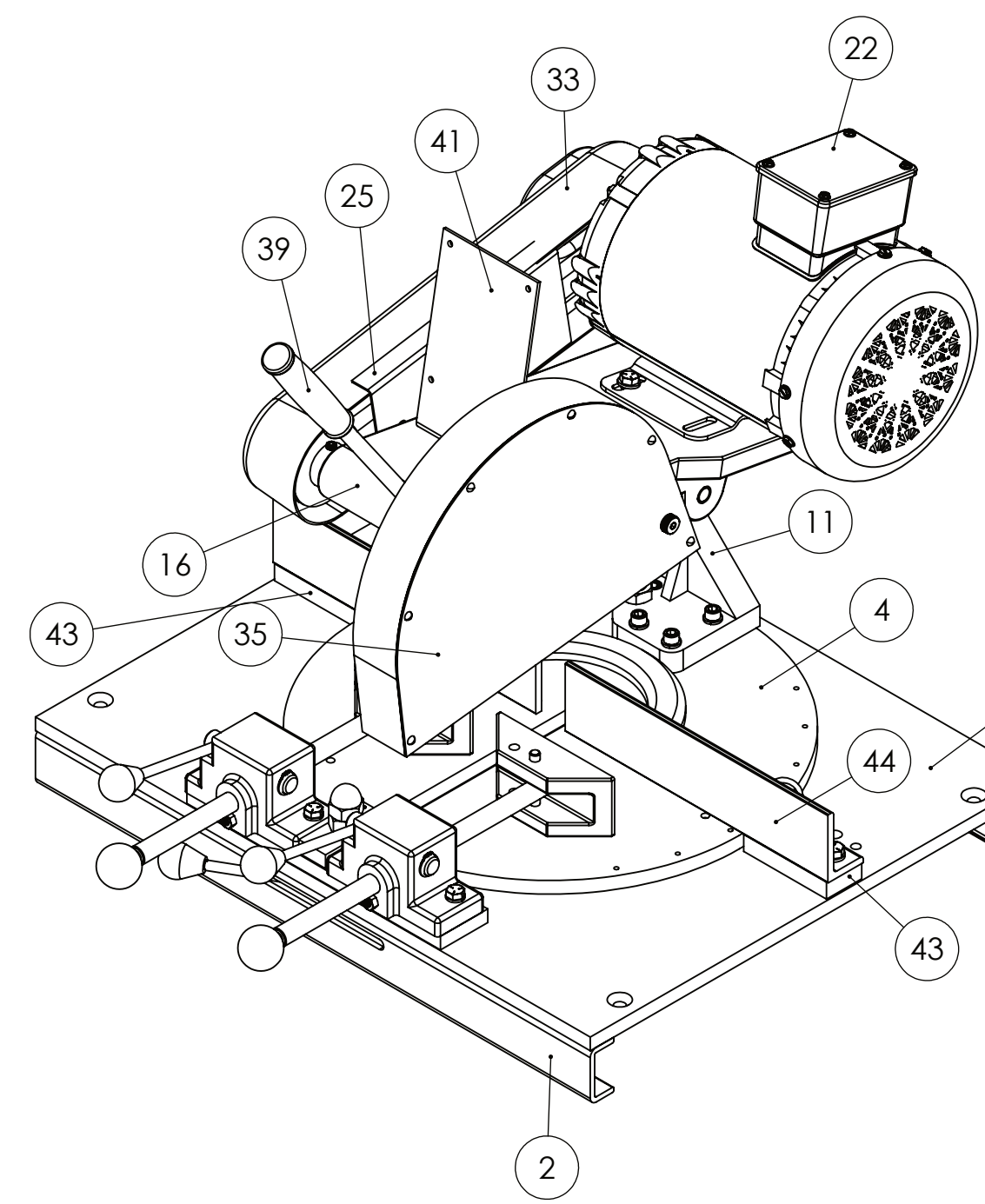
UNDERSIDE OF
MACHINE



SEE DRAWING #912-016
FOR VISE DETAILS



SECTION F-F
SCALE 1 : 5
ECCENTRIC
BUSHING DETAILS



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	556-008	PLATE, SQUARE FOR KM10-14	1
2	711-002FRONT	SUPPORT PLATE CHANNEL (WITH SLOT) FOR KM10	1
3	711-002BACK	SUPPORT PLATE CHANNEL (NO SLOT) FOR KM10	1
4	050-013	BASE (ROUND) TOP FOR KM10	1
5	044-006	TABLE BEARING (38X30T) FOR KM10, KM14 MITRE SAWS	2
6	044-007	K10 BEARING	3
7	HHC5031012	5/16-18 X 3/4 HHCS GR5 Z	2
8	SLWZ031	5/16 SPLIT L/W Z	17
9	049-001	ECCENTRIC BUSHING FOR KM10 AND KM14 MITRE TOP	1
10	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
11	831-013	TRUNNION CASTING FOR KM10 MITRE SAW	1
12	SHCA031020	5/16-18 X 1-1/4 SHCS	3
13	SHCA031016	5/16-18 X 1 SHCS	1
14	RL8 F8-810-6MODIFIED	MODIFIED FLANGE BUSHING	2
15	562-008	TRUNNION PIN FOR KM10	1
16	002-001	ALUMINIUM SAW ARM FOR K7B, K8B, K10B (TAKES NEW 6202-2RS-1/2 BEARINGS)	1
17	SSKA025006	1/4-20 X 3/8 SOC SET KNURL PT.	1
18	701-003	K10 SPINDLE W TIGHT FLANGE	1
19	292-008	LOOSE FLANGE FOR K10B AND 23K7	1
20	FJNZ063	5/8-18 F H JAM NUT Z	1
21	347-001	HANDLE, GRIP FOR K7B, K8B, K10B SAWS	1
22	486-006	3 HP MOTOR FOR FOR K8B, K10B, KM10, BG260H AND S460W	1
23	UFWZ031	5/16 USS F/W Z	8
24	FHN5031	5/16-18 FHN GR5 ZINC	6
25	342-027	K10B INNER GUARD BELT BRACKET	1
26	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	2
27	SLWZ025	1/4 SPLIT L/W Z	4
28	UFWZ025	1/4 USS F/W Z	2
29	RND-0,31-18 THRD RODX	3 INCHES OF 5/16-18 THREADED ROD	1
30	560-045	K10B, K10SW, KM10 PULLEY	2
31	051-003	V-BELT FOR K10, KM10, S6MW, S460W	1
32	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
33	342-043	K10B, KM10 PLASTIC OUTER BELT GUARD	1
34	CPNZ031	5/16-18 CAP NUT NICKEL	1
35	342-006	WHEEL GUARD FOR K10B SAWS	1
36	SSBA031006	5/16 X 3/8 SOC SHOULDER BOLT	1
37	UFWZ037	3/8 USS F/W Z	2
38	BWVA031	5/16 BOWED SPRING WASHER 21/64	2
39	381-003	HANDLE W GRIP FOR K7B, K8B, K10B SAWS	1
40	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	1
41	041-050	SWITCH BRACKET FOR K8B AND K10B	1
42	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	2
43	699-004	SPACER, FENCE FOR KM10 AND KM14 SAWS	2
44	293-001	MITRE FENCE FOR KM10 AND KM10HS	1
45	HHC5037024	3/8-16 X 1-1/2 HHCS GR5 Z	4
46	SLWZ037	3/8 SPLIT L/W Z	4
47	562-020	TABLE INDEX PIN FOR KM14	1
48	699-005	SPACER, VISE FOR KM10 AND KM14 SAWS	1
49	454-004	LOCK, TABLE MITRE FOR KM10, KM14	1
50	RHRA012008	1/8 ROUND HEAD RIVET	2
51	RUDZ007008	#7 X 1/2 RD U-DRIVE SCREW Z	1
52	696-013A	SCREW, TABLE LOCK FOR KM10 MITRE SAW (4-1/2 LONG)	1
53	381-012	HANDLE, TABLE LOCK FOR KM14	1
54	441-002	K10-16 VISE LOCK HANDLE KNOB	1
55	SSSA025006	1/4-20 X 3/8 SOC SET CUP PT	1
56	FHN5062	5/8-11 FHN GR5 Z	1
57	CPNZ062	5/8-11 CAP NUT Z	1
58	912-016	VISE ASSY K12-14W, KM10, KM14 LESS JAW AND PIN	2
59	HHC5031028	5/16-18 X 1-3/4 HHCS GR5 Z	4
60	709-007	FRONT STOP FOR KM10 SAW	1
61	709-008	BACK STOP FOR KM10 SAW	1
62	FJNZ062	5/8-11 F H JAM NUT Z	2

REFER TO DRAWING 912-016 FOR
COMPLETE VISE DETAILS

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NAME	DATE	TITLE
DESIGNED		MODEL KM10 10" MITRE SAW
CHECKED		SIZE: DWG. NO. E KM10
ENG. APPR.		SCALE: 1:2 WEIGHT: SHEET 1 OF 1
MFG. APPR.		
COMMENTS:		
INTERPRET GEOMETRIC TOLERANCES PER ASME Y14.5		
NEED ASST	USED ON	FINISH
APPLICATION		DO NOT SCALE DRAWING