KALAMAZOO INDUSTRIES, INC.

MAINTENANCE CHECKLIST

KM10HS 10 Inch High Speed Non-Ferrous Mitre Saw

Kalamazoo Industries, Inc. • Kalamazoo, Michigan

Machine Model:		**Serial Number:**	
Technician:		**Date:**	
Location / Dept:		**Shift:**	

⚠ **SAFETY:** Disconnect and lock out power before any blade change, belt work, or maintenance. Always wear safety glasses, hearing protection, and an appropriate dust mask. Never operate the machine without blade guard properly seated. The KM10HS is for non-ferrous materials only — do not cut steel or ferrous metals.

✓	Maintenance Task	Initials
DAILY MAINTENANCE		
☐	Inspect blade for missing or damaged carbide tips, cracks, or any visible defects — replace immediately if any are found	
☐	Remove accumulated chips, aluminum dust, and debris from machine surfaces, vises, table, and surrounding work area after each use	
☐	Inspect both cam-lock vises for secure operation and correct clamping force; adjust if loose or inconsistent	
☐	Verify that the retractable clamshell blade guard retracts smoothly and returns fully to the closed position after each cut	
WEEKLY MAINTENANCE		
Machine must be thoroughly cleaned at minimum once per week		
☐	Thoroughly clean all machine surfaces using a brush or vacuum — pay particular attention to chip buildup on the table, base, and vise mechanisms	
☐	Inspect cam-lock vise mechanisms for smooth, consistent operation; clean and lightly lubricate with a compatible machine oil if stiff or binding	
☐	Inspect and tighten all accessible fasteners, including those securing the saw arm, vises, and motor mount	
☐	Inspect V-belt for wear, cracking, fraying, or glazing — replace immediately if belt condition is compromised	
☐	Check V-belt tension: apply firm thumb pressure at belt midpoint — correct deflection is approximately 1/4" under ~10 lbs of force	
☐	Inspect the lever-lock table locking mechanism for proper, secure engagement at all mitre positions	
☐	Verify control switch operates correctly with no sticking or hesitation	
MONTHLY MAINTENANCE		
☐	Inspect motor housing for dust accumulation; clean as necessary to prevent overheating	
☐	Inspect all wiring and electrical connections for signs of wear, damage, or loosening	
☐	Inspect the spindle arbor for wear or damage; verify arbor nut is torqued correctly	

☐	Inspect sealed ball bearings for noise or roughness during operation — replace bearings showing signs of wear or contamination	
☐	Inspect cast aluminum arm and trunnion for cracks or play in the mitre pivot; tighten or adjust as required	
☐	Inspect eccentric bushing and trunnion pin for wear or looseness; replace if play is detected	
☐	Inspect positive index holes and locking pin for the preset mitre angles — verify pin engages cleanly	
☐	Inspect clamshell guard pivot, return spring, and lever assembly for wear or chip obstruction; clean and verify proper function	

V-BELT SERVICE

Inspect tension weekly; replace when worn — disconnect power before any belt work

☐	Disconnect power at source and open or remove the V-belt guard to expose belt and pulleys	
☐	Check belt deflection at midpoint of longest span: target ~1/4" under moderate thumb pressure (~10 lbs)	
☐	If too loose: loosen motor mounting bolts and slide motor away from spindle pulley in small increments	
☐	If too tight: slide motor toward spindle pulley; re-check deflection after each adjustment	
☐	Verify motor pulleys are properly aligned — belt must run straight and centered on both pulleys with no side load	
☐	Tighten all motor mounting bolts securely and evenly; re-check belt tension after tightening	
☐	Reinstall and secure belt guard before restoring power	
☐	Replace belt if cracking, fraying, splitting, glazing, cord separation, or excessive stretch are observed	

BLADE REPLACEMENT

Replace when carbide tips are worn, chipped, or cut quality degrades — disconnect power first

☐	Disconnect unit from power at the source	
☐	Open retractable clamshell blade guard and secure in open position	
☐	Verify replacement blade is a 10" carbide-tipped blade with 5/8" arbor bore, rated for 3,450 RPM	
☐	Remove arbor nut and loose flange; remove worn blade from spindle	
☐	Inspect spindle arbor and flanges for wear or damage before installing new blade	
☐	Install new blade — ensure blade rotation arrow (if present) matches intended direction of travel	
☐	Install arbor flange and tighten arbor nut securely using appropriate wrenches	
☐	Close clamshell guard and verify proper seating before energizing the unit	
☐	Energize unit and allow blade to reach full speed; verify smooth operation with no vibration before cutting	

PERIODIC ELECTRICAL INSPECTION

Every 6 months or per facility requirements — qualified electrician only

☐	Inspect starter contacts for wear or pitting; replace if necessary	
☐	Verify grounding connections are secure and comply with applicable electrical codes	
☐	Confirm facility voltage matches unit configuration: 1PH 115V, 1PH 230V, 3PH 230V, or 3PH 460V	
☐	Inspect power supply cord for damage, fraying, or tripping hazards; reroute or replace as needed	
☐	Test on/off switch for reliable operation with no hesitation or intermittent behavior	

NOTES / OBSERVATIONS

REPLACEMENT PARTS REFERENCE

Part Number	Description
381-003	Handle with Grip — replacement 1/2" handle with grip, fits 7–10" saws
053-001	Eccentric Bushing with Bearing — mitre saw top eccentric bushing
431-001	Vise Front Jaw — replacement front jaw for cam-lock vise
701-003	K10 Spindle with Tight Flange
292-008	Loose Flange for K10B and 2SK7
048-001	V-Belt for K10, KM10, S6MW, S460W

Order genuine parts at www.kalamazooind.com/parts-by-category or call 1-800-592-2050. Have model number KM10HS ready when ordering.