

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

PH: (269) 382-2050

[www.kalamazooind.com](http://www.kalamazooind.com)

## **S612V COMBINATION BELT SANDER MANUAL**



**MADE IN USA**

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



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## **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.

## **BELT SANDER SAFETY**

- READ THE OPERATING INSTRUCTIONS BEFORE RUNNING MACHINE.
- ALWAYS WEAR SAFETY GLASSES OR A FULL FACE SHIELD FOR PROTECTION.
- KEEP HANDS CLEAR OF THE SANDING AREA.
- WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.
- ALWAYS KEEP HAIR TIED BACK OR COVERED.
- LET MACHINE ROTATION COME TO A FULL STOP BEFORE CHANGING BELT.
- KEEP SAFETY GUARDS IN PLACE. DO NOT ALTER GUARD OR MACHINE IN ANYWAY. ANY ALTERATIONS TO GUARDS OR MACHINE COULD CAUSE SERIOUS INJURY.
- ALL BELT SANDERS SHOULD BE OPERATED IN A WELL-VENTILATED AREA. THE DUST CREATED WHEN SOME MATERIALS ARE SANDED CAN BE HARMFUL. DUST MASKS ARE RECOMMEND AS A PRACTICAL MEAN OF MINIMIZING DUST INHALATION. FUMES FROM OTHER SOURCES CAN ALSO CAUSES FIRES WHEN INTACT WITH SANDING SPARK.
- SPARKS CREATED BY SANDING SHOULD BE DIRECTED DOWNWARD AND AWAY FROM THE FACE AND BODY. DON NOT GRIND NEAR FLAMMABLE MATERIAL.
- ELECTRIC SANDING MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR STANDING ON A WET FLOOR OR WORKING AROUND CONTAINERS OF WATER OR OTHER CONDUCTIVE LIQUIDS.
- S612V COMBINATION SANDER HAS A REPLACEABLE FILTER LOCATED IN THE UNITS BASE AND IS REPLACEABLE. **NOTE: ALWAYS SAND WITH LIKE MATERIAL. WHEN YOU SAND DIFFERENT MATERIAL THOROUGHLY CLEANOUT BASE AND FLITER SO A FIRE DOESN'T START.**

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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.

### **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.**

### **IMPORTANT**

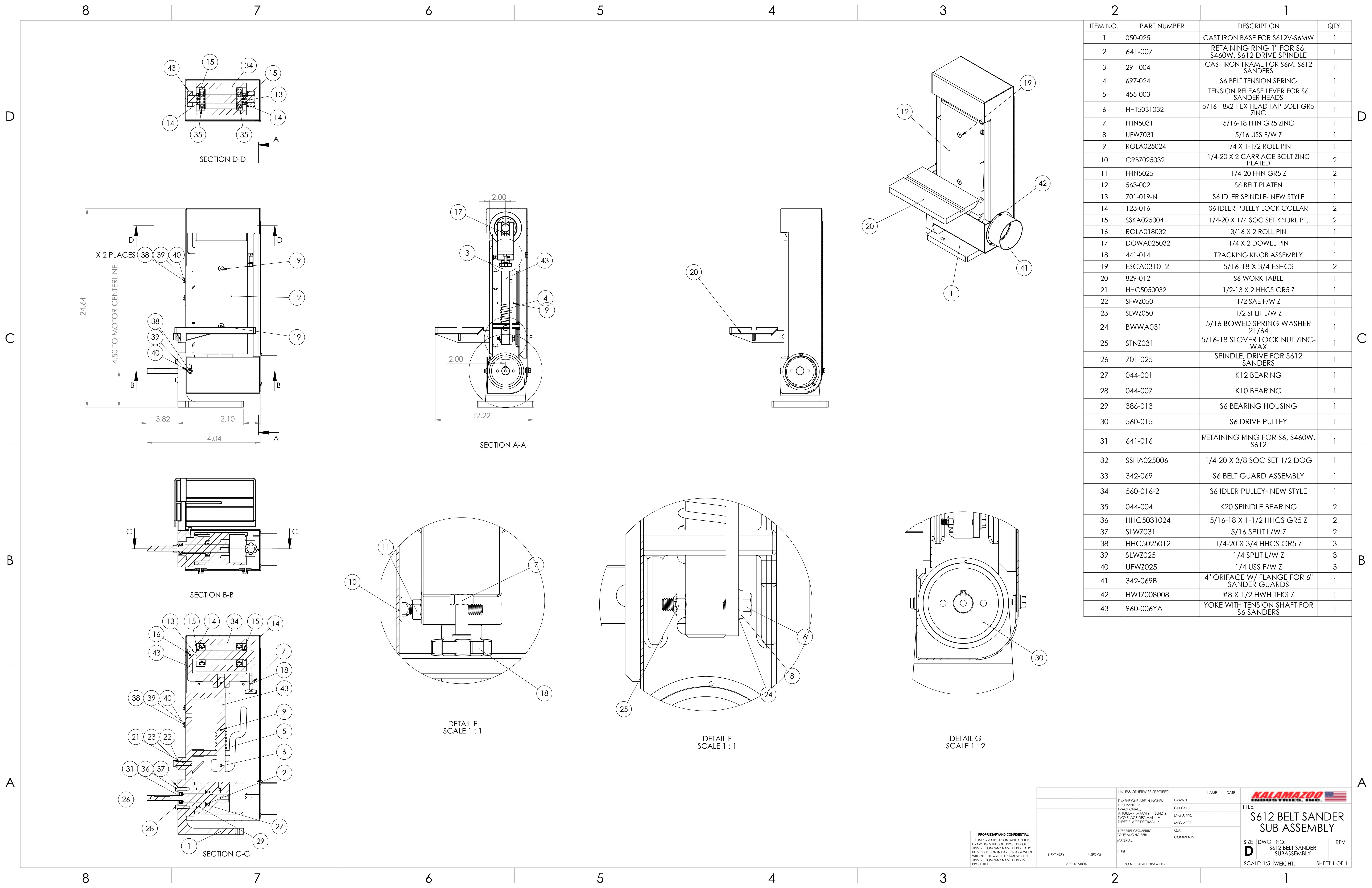
Read Operating Instructions before using equipment.

### **TROUBLE SHOOTING AND TRACKING PROBLEMS**

- Drive pulley lost its crown (curvature of pulley)
- Sanding belt are not spliced square.
- Upper pulley assembly not square to platen. (Use carriage bolts to square yoke with platen.)

### **OPERATING INSTRUCTIONS**


1. CHECK FOR CORRECT OF PHASE AND VOLTAGE BEFORE RUNNING THE MACHIN. **CAUTION: VOLTAGE CHANGES FROM FACTORY SETTING REQUIRE WIRING CHANGES IN ALL MOTOR JUNCTION BOXES AND CORRECT CONTACTOR AND OVERLOAD. IF UNFAMILIAR WITH ELECTRICAL WIRING PLEASE CONSULT AN ELECTRICIAN. ELECTRICAL FAILURES DUE TO INCORRECT VOLTAGE CHANGES ARE NOT COVERED UNDER WARRANTY.**
2. BELT TENSION: The 6" x 48" sanding belt has a preset tension. The yoke assembly (#43) is spring loaded for constant belt tension. Tension lever (#5) tightens and loosens belt tension
3. BELT TRACKING: Sanding belt tracking is done with tracking knob (#18) on yoke assembly. Tightening knob (#18) raises idler spindle (#13) and the belt moves toward the motor. Loosening tracking knob (#18) drops idler spindle and the sanding belt moves away from the motor. When belt is centered on platen (#12) tighten jam nut on tracking knob (#18) to lock in the belt position.
4. BELT CHANING: Open belt guard (#33), locate tension lever (#5) between sander frame and pulley down tension-lever to compress tension spring and release belt tension. Remove & replace sanding belt. Be sure of correct belt rotation usually indicated by direction arrow on inside of the sanding belt. Left tension lever (#5) to all re-tensioning of the belt. Check tracking of belt with short on/off jogs of motor before letting the machine run. Spinning the belt by hand with power off will also check rough tracking before running machine. Be sure sanding belt stays centered on platen (#12)
5. BELT SANDER WORK TABLE: (#20) worktable has a slot milled into the table for a fixture and or mitre gauge. Also two mounting holes are provided on the side of the frame (#3) to move worktable to different work heights. **NOTE: KEEP WORKTABLE WITHIN 1/18" SANDING BELT.**
6. DISC SANDER WORK TABLE: (#34) worktable has a slot milled into the table for a fixture and or mitre gauge. To adjust work table angle loosen table locking knobs (#38) adjust to desired position and retighten.
7. SANDING HEAD POSITION: sanding head can be positioned from vertical to horizontal with and any angle inbetween. Loosen (#36) hex bolts located in base (#1) while holding sanding head firmly. Sanding head/frame (#3) is locked in position by squeezing bearing housing assembly (#29) against the base (#1). When desired position is reached, tighten hex bolts (#36) to lock in sanding head.
8. PLATEN: the platen is located behind sanding belt and is reversible.



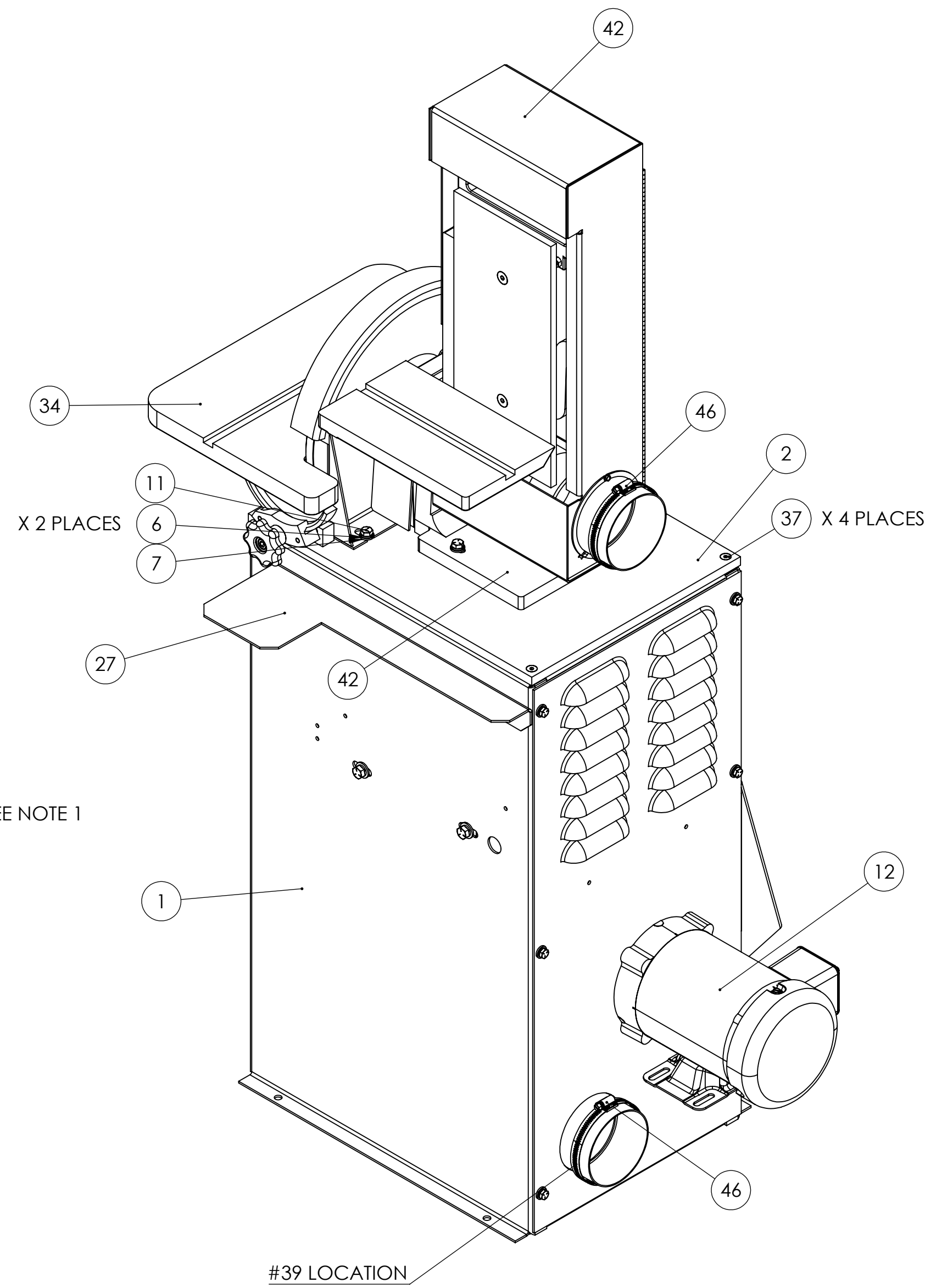
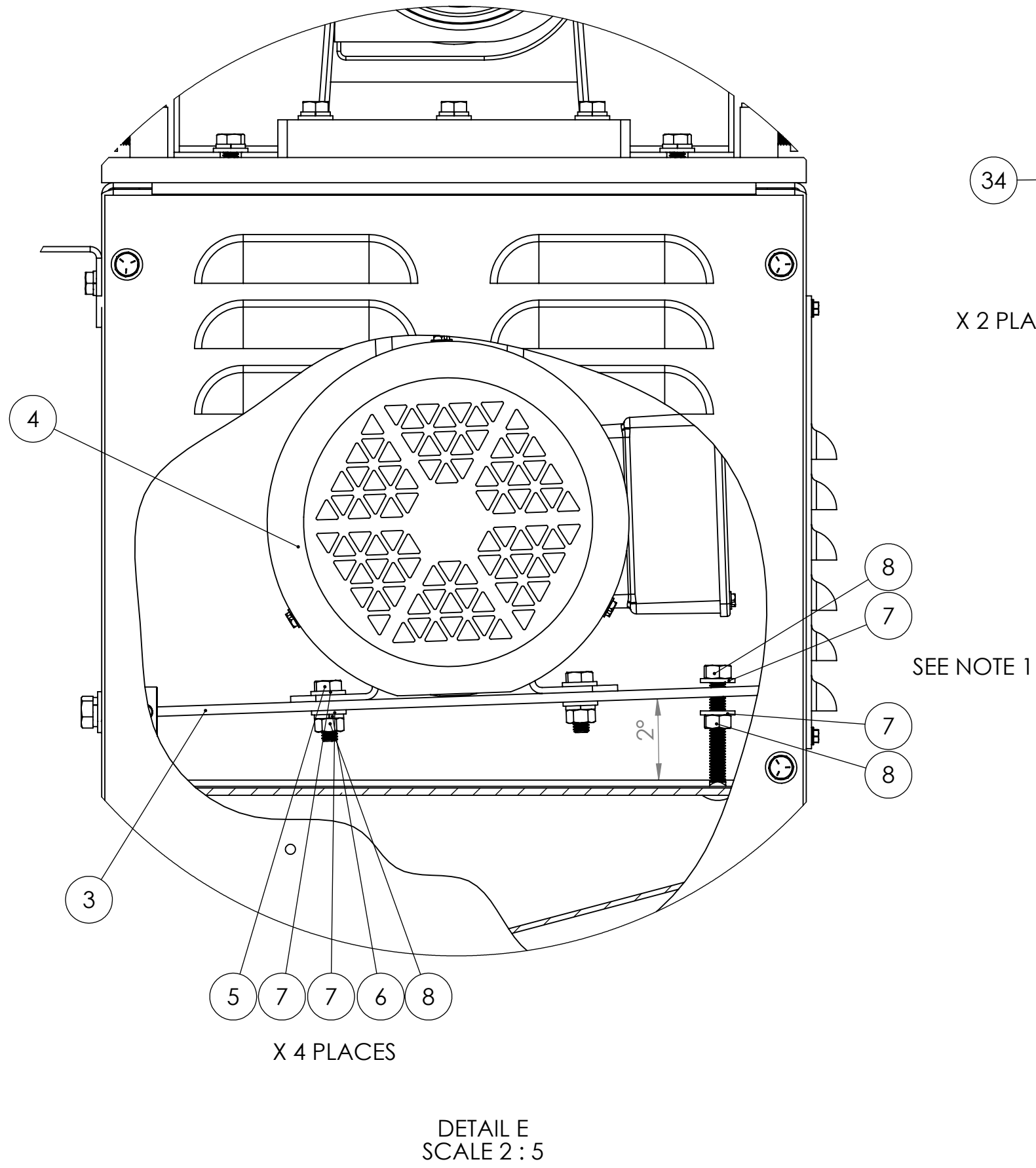
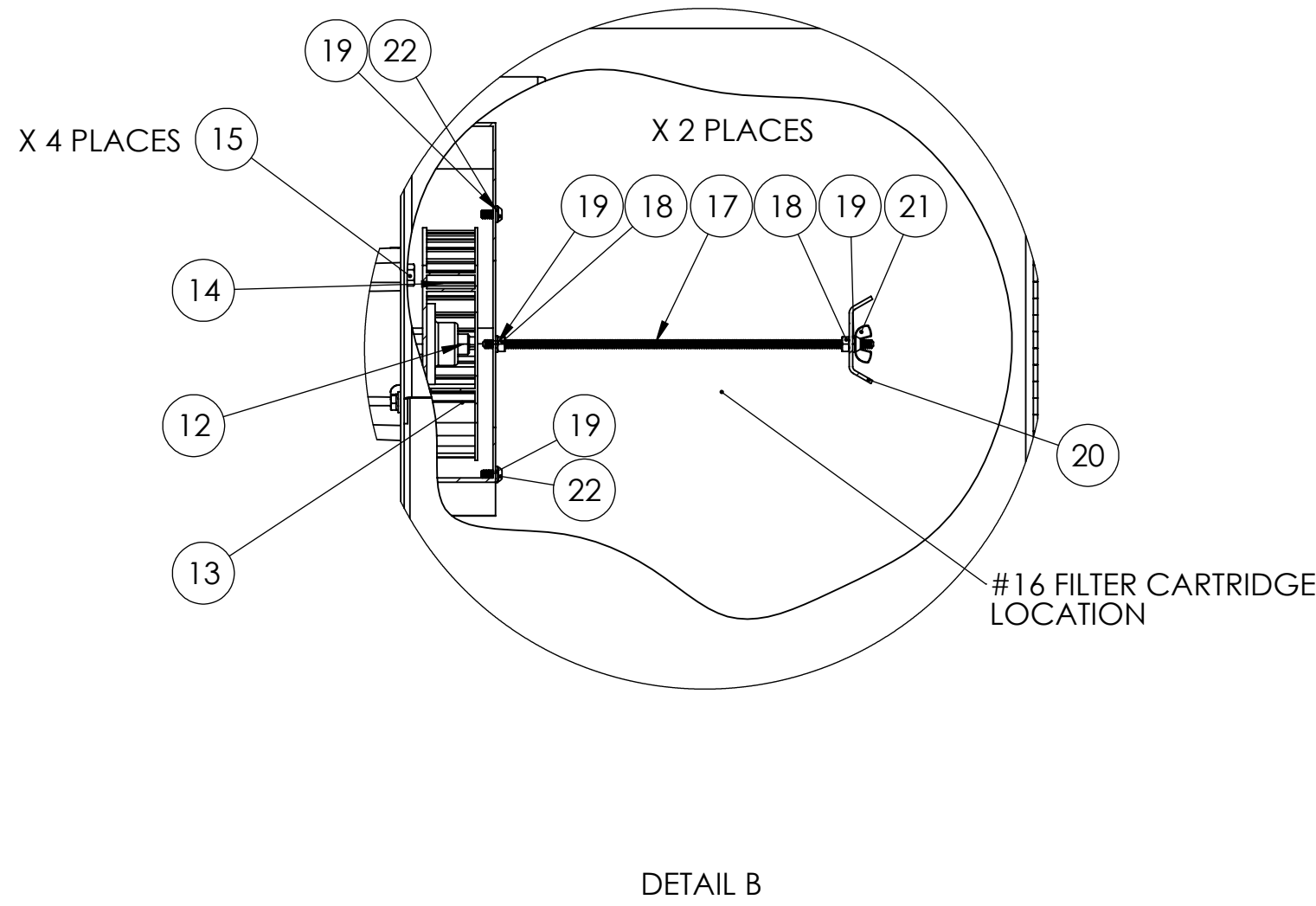
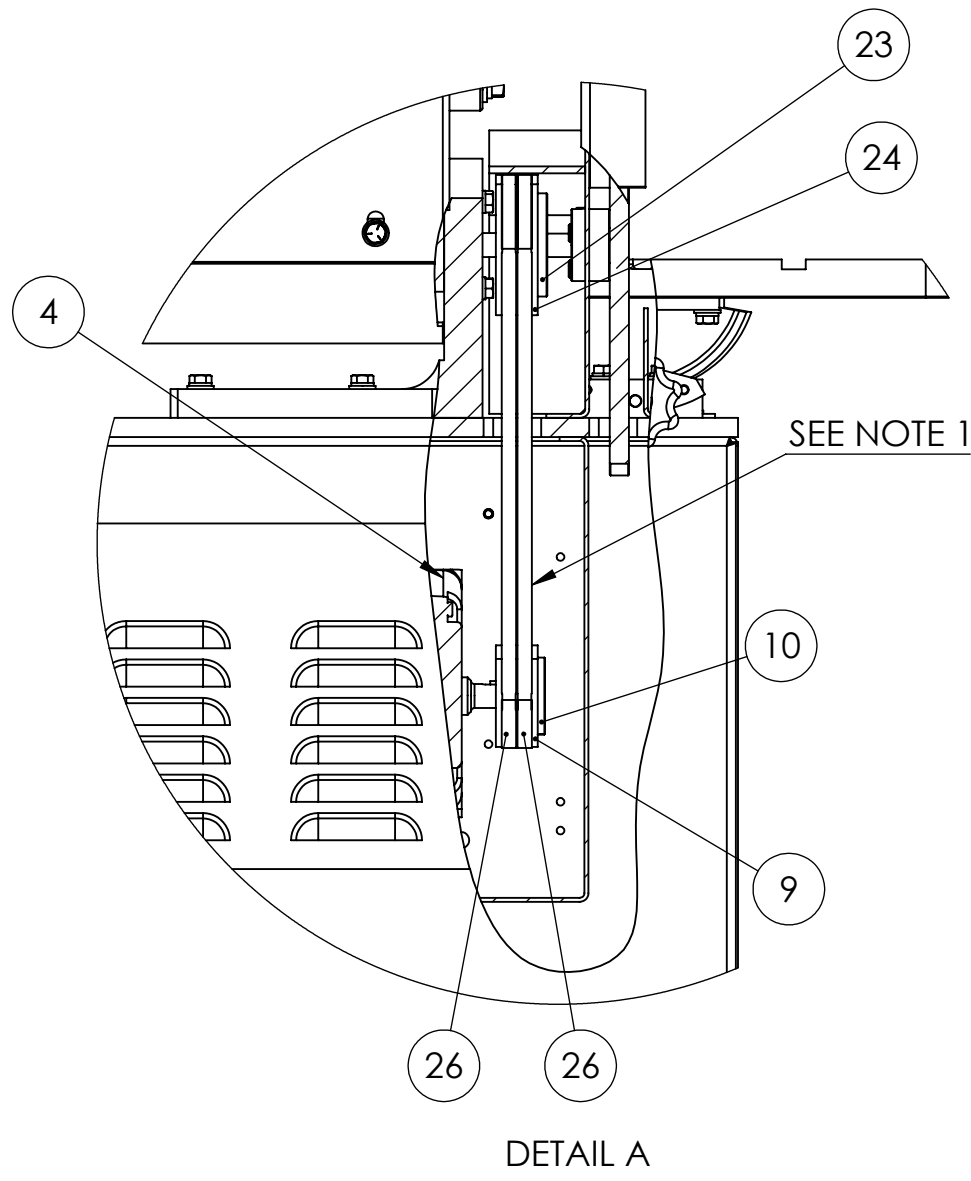
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	050-025	CAST IRON BASE FOR S612V-S6MW	1
2	641-007	RETAINING RING 1" FOR S6, S460W, S612 DRIVE SPINDLE	1
3	291-004	CAST IRON FRAME FOR S6M, S612 SANDERS	1
4	697-024	S6 BELT TENSION SPRING	1
5	455-003	TENSION RELEASE LEVER FOR S6 SANDER HEADS	1
6	HHT5031032	5/16-18x2 HEX HEAD TAP BOLT GR5 ZINC	1
7	FHN5031	5/16-18 FHN GR5 ZINC	1
8	UFWZ031	5/16 USS F/W Z	1
9	ROLA025024	1/4 X 1-1/2 ROLL PIN	1
10	CRBZ025032	1/4-20 X 2 CARRIAGE BOLT ZINC PLATED	2
11	FHN5025	1/4-20 FHN GR5 Z	2
12	563-002	S6 BELT PLATEN	1
13	701-019-N	S6 IDLER SPINDLE- NEW STYLE	1
14	123-016	S6 IDLER PULLEY LOCK COLLAR	2
15	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	2
16	ROLA018032	3/16 X 2 ROLL PIN	1
17	DOWA025032	1/4 X 2 DOWEL PIN	1
18	441-014	TRACKING KNOB ASSEMBLY	1
19	FSCA031012	5/16-18 X 3/4 FSHCS	2
20	829-012	S6 WORK TABLE	1
21	HHC5050032	1/2-13 X 2 HHCS GR5 Z	1
22	SFWZ050	1/2 SAE F/W Z	1
23	SLWZ050	1/2 SPLIT L/W Z	1
24	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
25	STNZ031	5/16-18 STOVER LOCK NUT ZINC-WAX	1
26	701-025	SPINDLE, DRIVE FOR S612 SANDERS	1
27	044-001	K12 BEARING	1
28	044-007	K10 BEARING	1
29	386-013	S6 BEARING HOUSING	1
30	560-015	S6 DRIVE PULLEY	1
31	641-016	RETAINING RING FOR S6, S460W, S612	1
32	SSHA025006	1/4-20 X 3/8 SOC SET 1/2 DOG	1
33	342-069	S6 BELT GUARD ASSEMBLY	1
34	560-016-2	S6 IDLER PULLEY- NEW STYLE	1
35	044-004	K20 SPINDLE BEARING	2
36	HHC5031024	5/16-18 X 1-1/2 HHCS GR5 Z	2
37	SLWZ031	5/16 SPLIT L/W Z	2
38	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	3
39	SLWZ025	1/4 SPLIT L/W Z	3
40	UFWZ025	1/4 USS F/W Z	3
41	342-069B	4" ORIFACE W/ FLANGE FOR 6" SANDER GUARDS	1
42	HWTZ008008	#8 X 1/2 HWH TEKS Z	1
43	960-006YA	YOKE WITH TENSION SHAFT FOR S6 SANDERS	1

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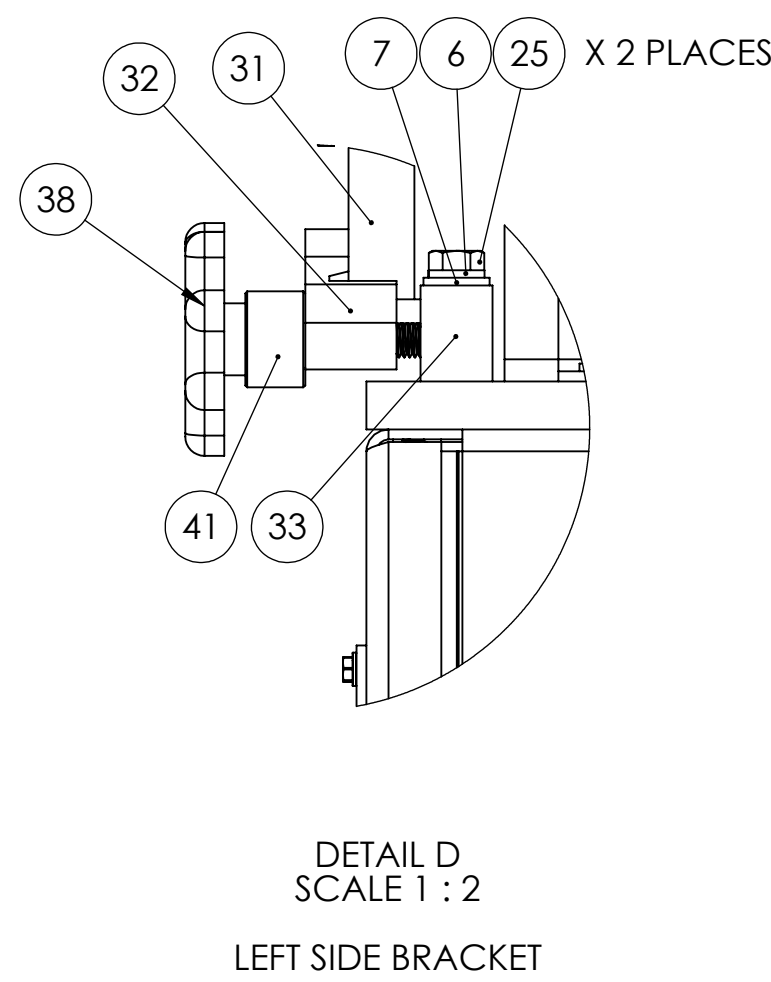
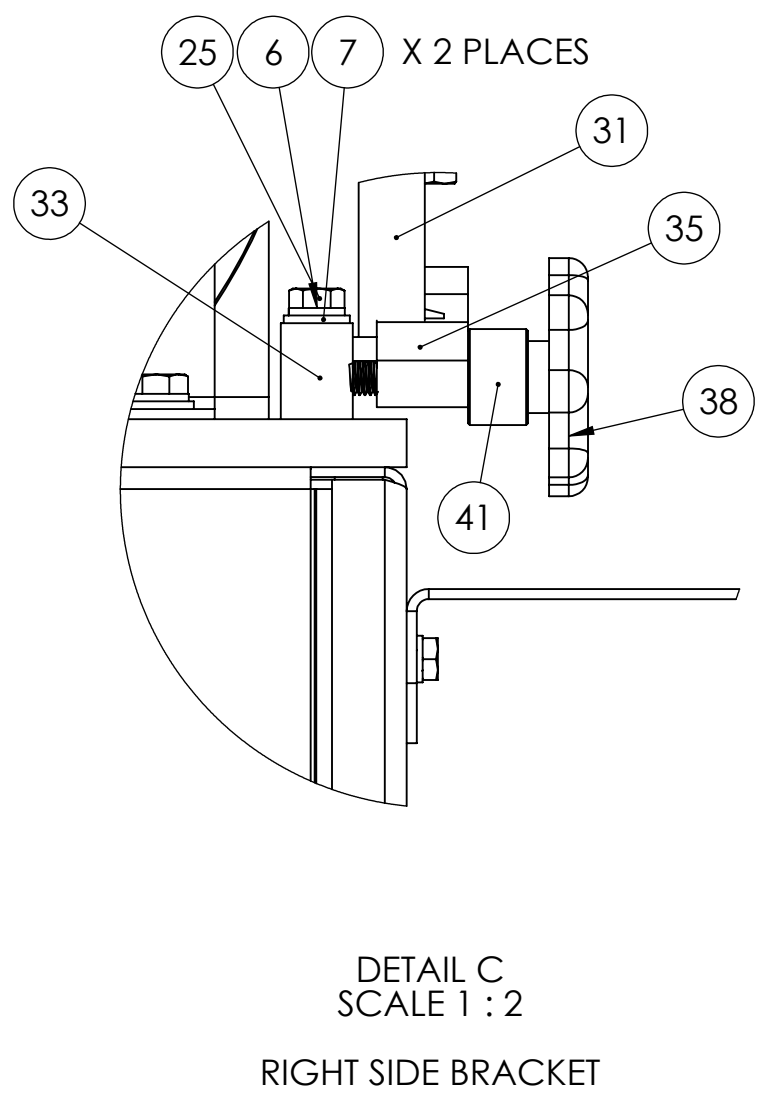
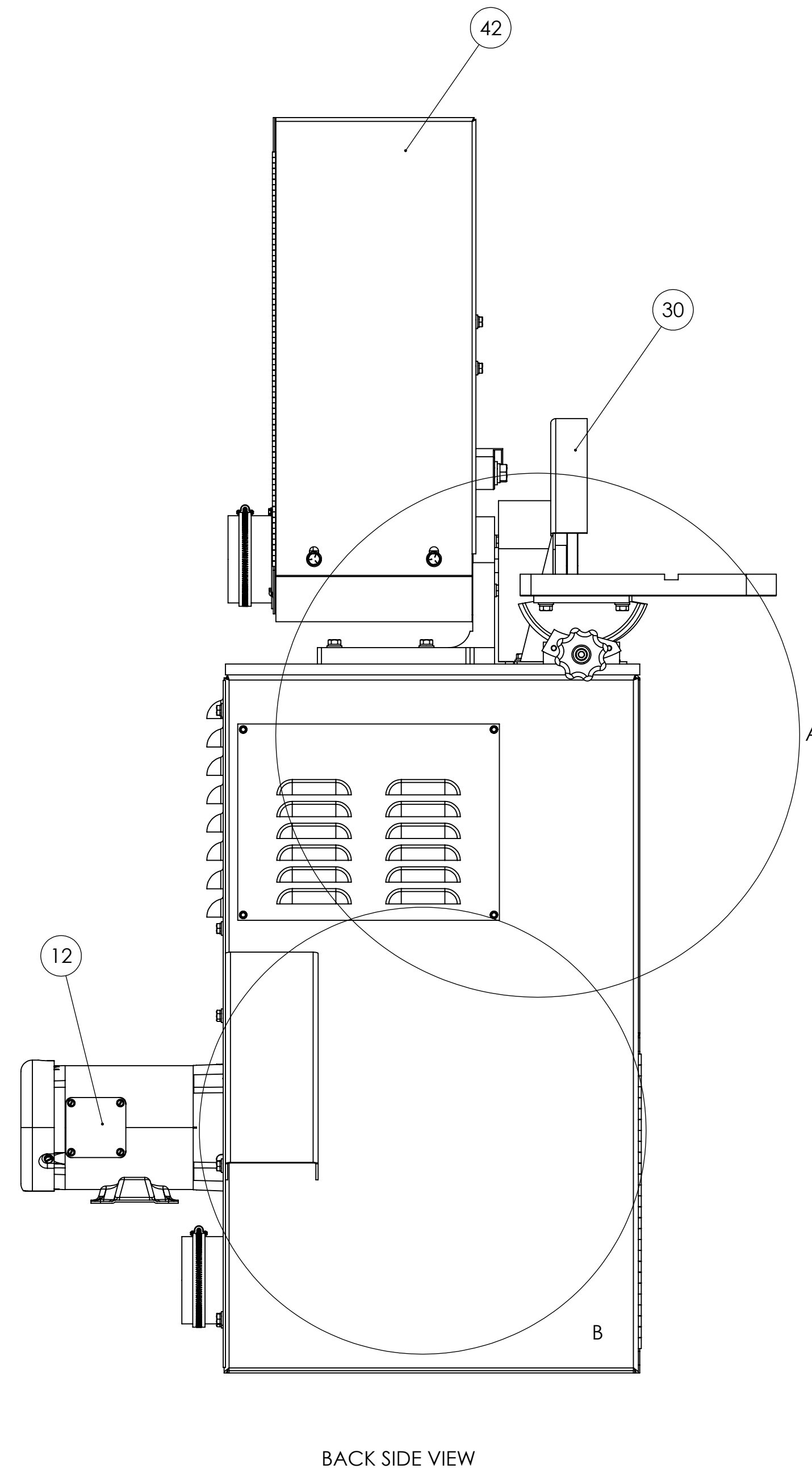
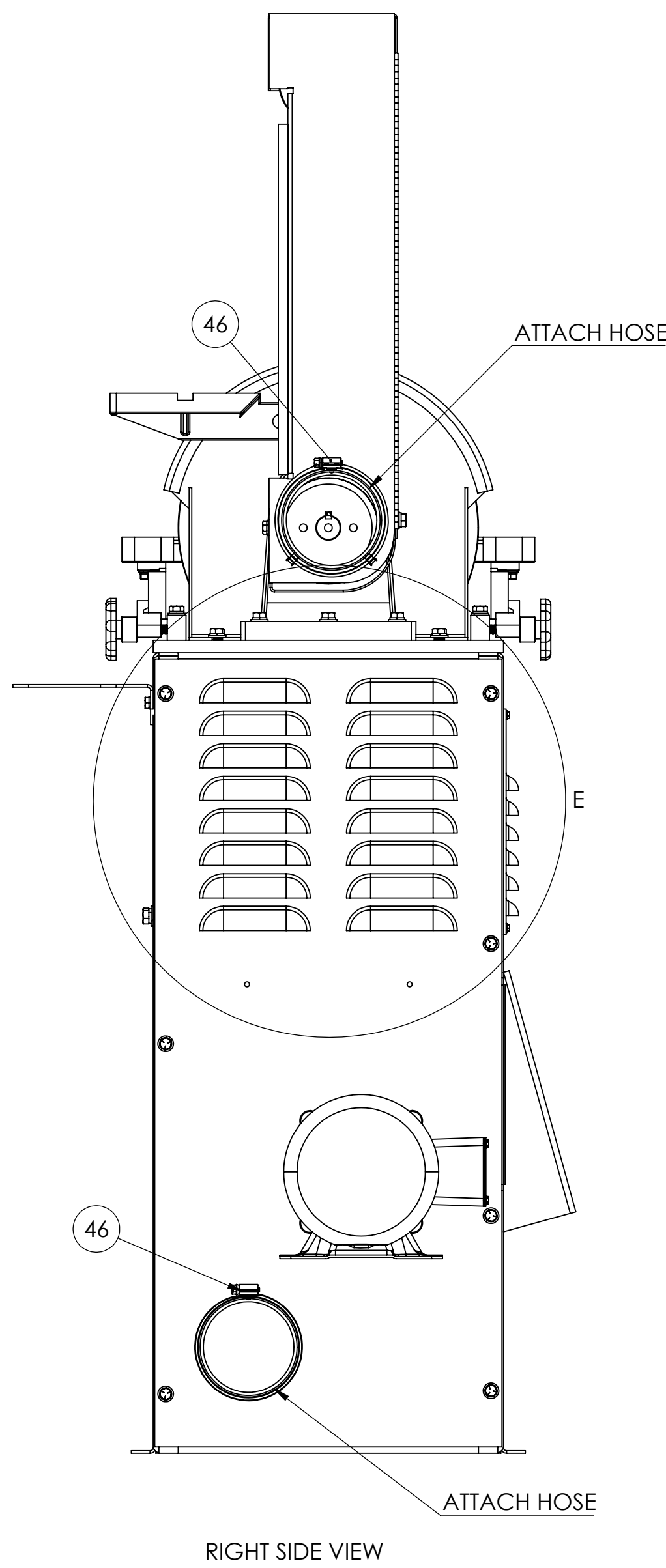
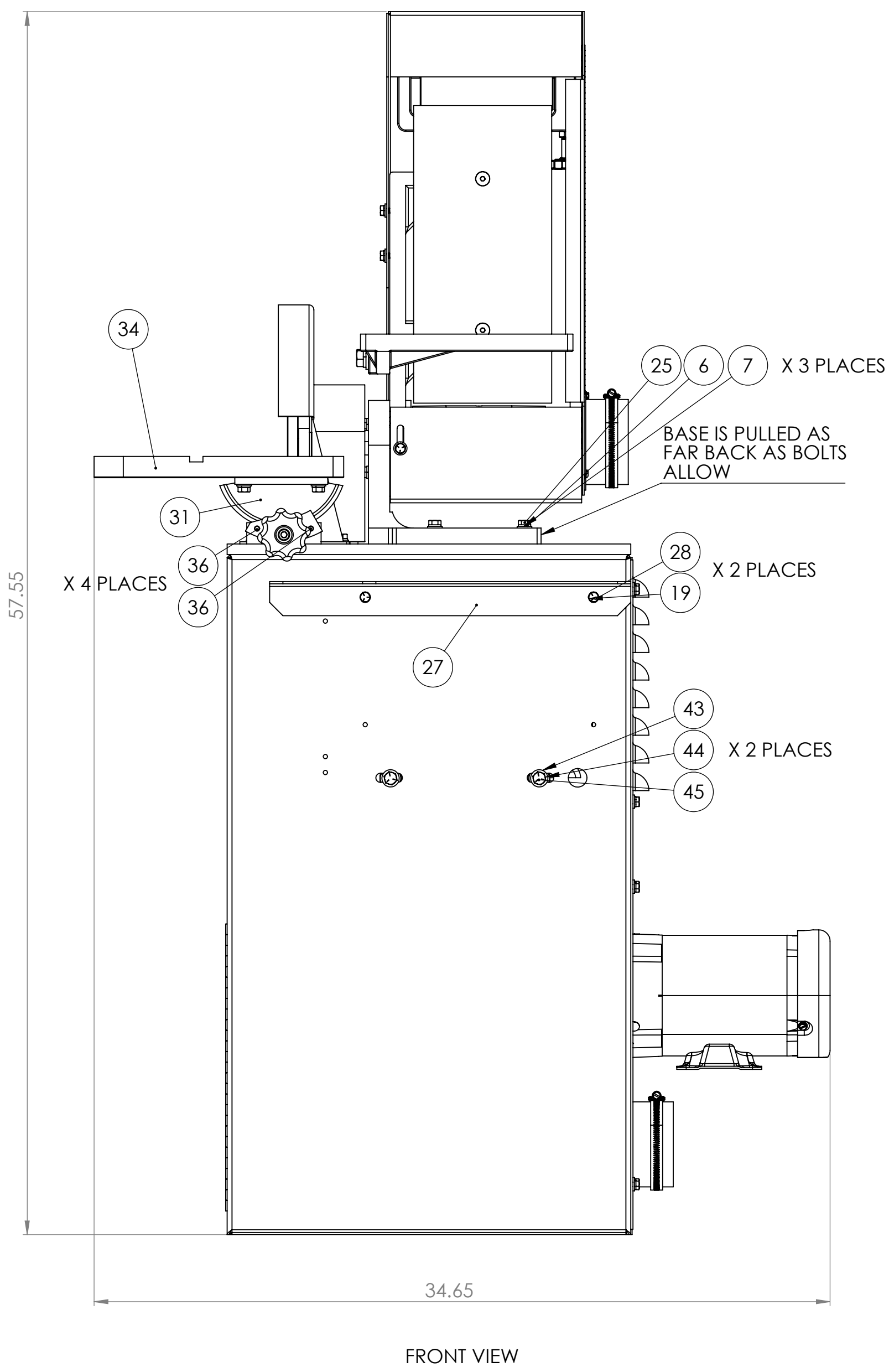
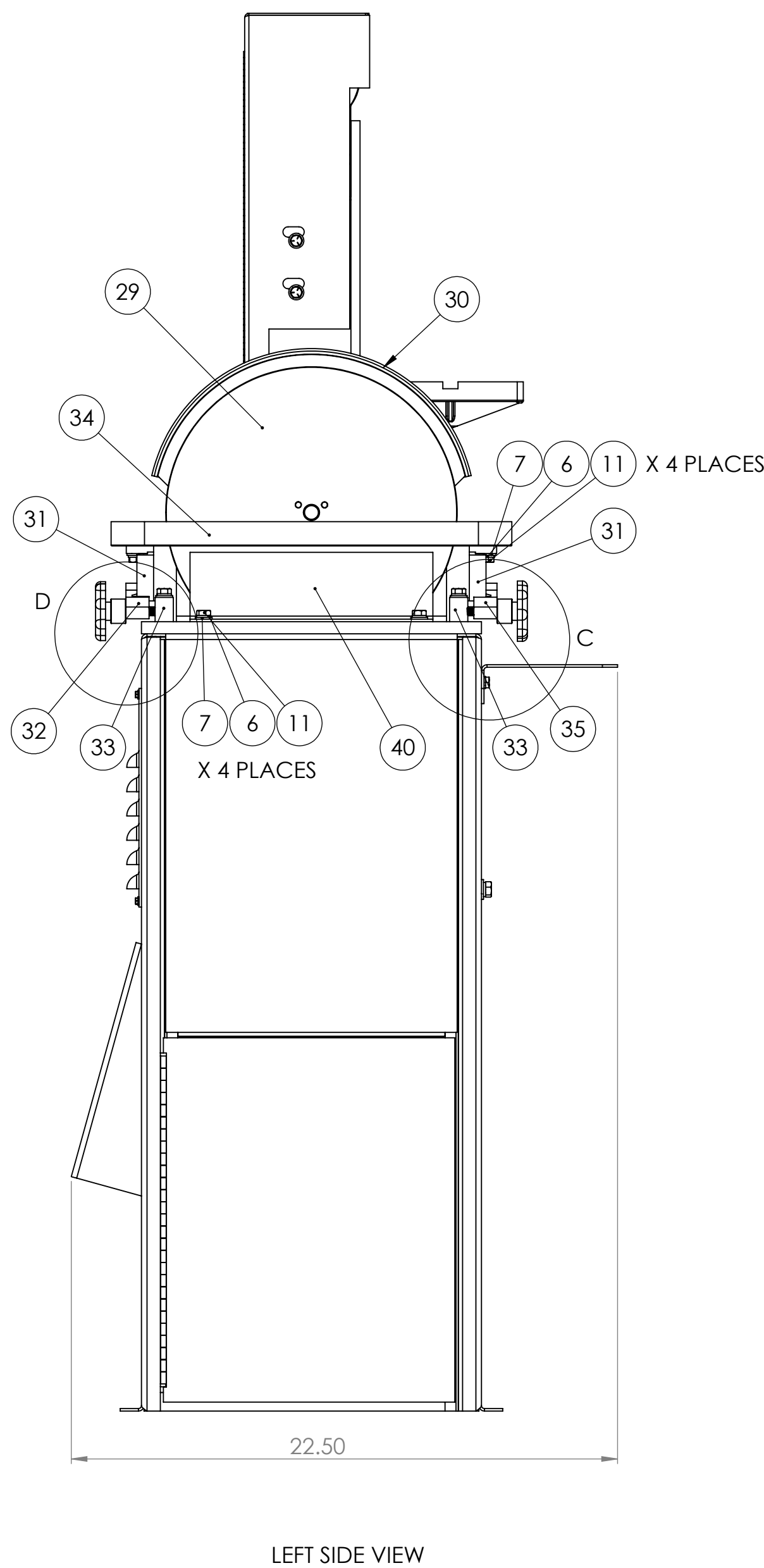
UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES	DRAWN		
TOLERANCES:	CHECKED		
FRACTIONAL: ±	ENG APPR.		
ANGULAR: MACH ±	MFG APPR.		
TWO PLACE DECIMAL: ±			
THREE PLACE DECIMAL: ±			
INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
MATERIAL	COMMENTS:		
FINISH			
NEXT ASSY	USED ON		
APPLICATION	DO NOT SCALE DRAWING		

TITLE:		KALAMAZOO INDUSTRIES, INC. 	
S612 BELT SANDER SUB ASSEMBLY			
SIZE	DWG. NO.	REV	
D	S612 BELT SANDER SUBASSEMBLY		
SCALE: 1:5	WEIGHT:	SHEET 1 OF 1	





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	150-001	S612V-1, S612V-3 CABINET	1
2	556-021	TOP PLATE FOR S612 COMBO	1
3	050-026	S612V MOTOR BASE ASSEMBLY	1
4	486-007S	3HP MOTOR FOR S612, S612V SANDERS	1
5	HHCS031016	5/16-18 X 1 HHCS GR5 Z	4
6	SLWZ031	5/16 SPLIT L/W Z	21
7	UFWZ031	5/16 USS F/W Z	27
8	FHN5031	5/16-18 FHN GR5 ZINC	8
9	560-052	MOTOR PULLEY SHEAVE FOR S6MW, S612 AND S460W	1
10	049-020	MOTOR PULLEY BUSHING FOR S460W, S6MW & S612	1
11	HHCS031012	5/16-18 X 3/4 HHCS GR5 Z	8
12	486-030	1/2HP MOTOR FOR 2FSM-3PH, S4S-3PH, S612V VAC MOTOR CM	1
13	386-031	HOUSING FAN FOR S612V	1
14	296-003	FAN, SQUIRREL CAGE FOR S612V (NEW STYLE)	1
15	HHCS037016	3/8-16 X 1 HHCS GR5 Z	4
16	294-006	FILTER CARTRIDGE FOR S612V (NEW STYLE)	1
17	RND-025-20THRDROD11.75	ROD FOR FILTER	2
18	FHN5025	1/4-20 FHN GR5 Z	4
19	SLWZ025	1/4 SPLIT L/W Z	8
20	041-063	BRACKET FOR FILTER CARTRIDGE FOR S612V	1
21	WGN02025	1/4-20 FORGED WING NUT Z	2
22	BSCA025008	1/4-20 X 1/2 BSHCS	2
23	049-019	SPINDLE PULLEY BUSHING FOR S460W, S6MW, S612 & BG272	1
24	560-051	SPINDLE PULLEY SHEAVE FOR S6MW, S612 & S460W	1
25	HHCS031024	5/16-18 X 1-1/2 HHCS GR5 Z	7
26	051-007	3VX335 V-BELT (2 REQUIRED) FOR S612 SANDER	2
27	342-119	SWITCH GUARD PLATE FOR S612 SANDER	1
28	HHCS025012	1/4-20 X 3/4 HHCS GR5 Z	2
29	160-002	DS12, DS12V, S612V 12" DISC HOLDER ASSEMBLY	1
30	342-036	S612, S612V DISK GUARD	1
31	831-031	S612 DISC TABLE TRUNNION BRACKET	2
32	144-009A	S612 L.H. TABLE CLAMP	1
33	053-132	S612 PIVOT TABLE BLOCK	2
34	829-035	S612, S612V DISC SANDER WORK TABLE, DISK SIDE	1
35	144-009B	S612 R.H. TABLE CLAMP	1
36	DOWA025024	1/4 X 1-1/2 DOWEL PIN	4
37	FSCA025016	1/4-20 X 1 FSHCS	4
38	441-022	TABLE LOCK KNOB FOR S612 DISC SIDE	2
39	389-	54 INCHES OF RAW HOSE 389-002	1
40	342-113	LOWER DISC GUARD FOR S612 WHEEL	1
41	00203200 X 0.625	5/8 OF 00203200-1 RND CF 1018- 12 FT	2
42	S612 BELT SANDER SUBASSEMBLY	S612 BELT SANDER SUB ASSEMBLY	1
43	UFWZ037	3/8 USS F/W Z	2
44	SLWZ037	3/8 SPLIT L/W Z	2
45	HHCS037012	3/8-16 X 3/4 HHCS GR5 Z	2
46	HS64	4 INCH HOSE CLAMP	2



NOTE 1: TIGHTEN MOTOR MOUNT BOLTS TO APPLY BELT TENSION. ENSURE THAT BELTS ARE VERTICAL AND MOTOR TURNS FREELY AND SMOOTHLY.