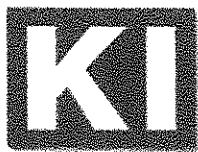
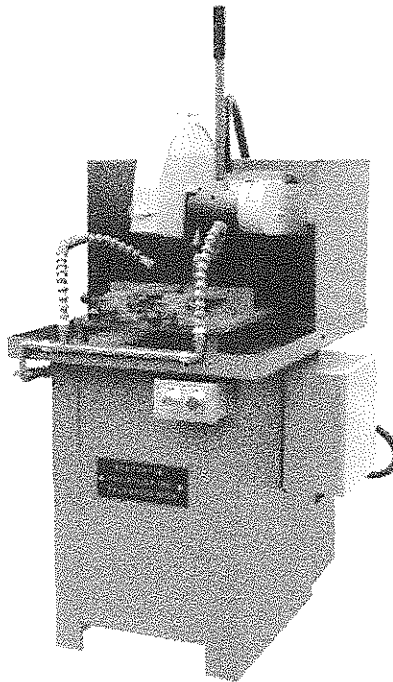


INSTRUCTION MANUAL K12-14W



**KALAMAZOO
INDUSTRIES, INC.**

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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.

READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE OPERATING UNIT

OPERATING INSTRUCTIONS

INSPECT YOUR NEW UNIT CAREFULLY FOR SIGNS OF SHIPPING DAMAGE. IF DAMAGED, PLEASE CONTACT CARRIER AND SUBMIT A CONCEALED DAMAGED REPORT. DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS. SEE BACK PAGE FOR RETURN POLICY AND WARRANTY.

BEFORE STARTING OR CONNECTING ELECTRICALS VERIFY THE PHASE AND VOLTAGE OF THE UNIT.

BE SURE MACHINE IS BALANCED CORRECTLY SO IT WILL NOT TIP OVER.

TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBSERVE UNIT FOR THE FIRST FEW MINUTES OF OPERATION. GUARDS MUST NEVER BE REMOVED.

ABRASIVE SAW SAFETY

NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS

ELECTRIC MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR STANDING ON A WET FLOOR.

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.

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.

ABRASIVE MACHINES ARE FOR ABRASIVE WHEELS NOT STEEL TOOTHED BLADES. DO NOT ATTEMPT TO USE STEEL BLADES UNLESS CORRECTLY GUARDED WITH AN ENCLOSED WHEEL GUARD. KEEP STEEL BLADES FULLY RETRACTED INTO WHEEL GUARD WHEN DONE CUTTING.

ALWAYS KEEP WHEEL GUARD IN 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 a careful manner.
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 at 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.

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, get one that will.
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 mounting 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 noticeably or work gets hot.
9. DON'T wear gloves when operating machine.



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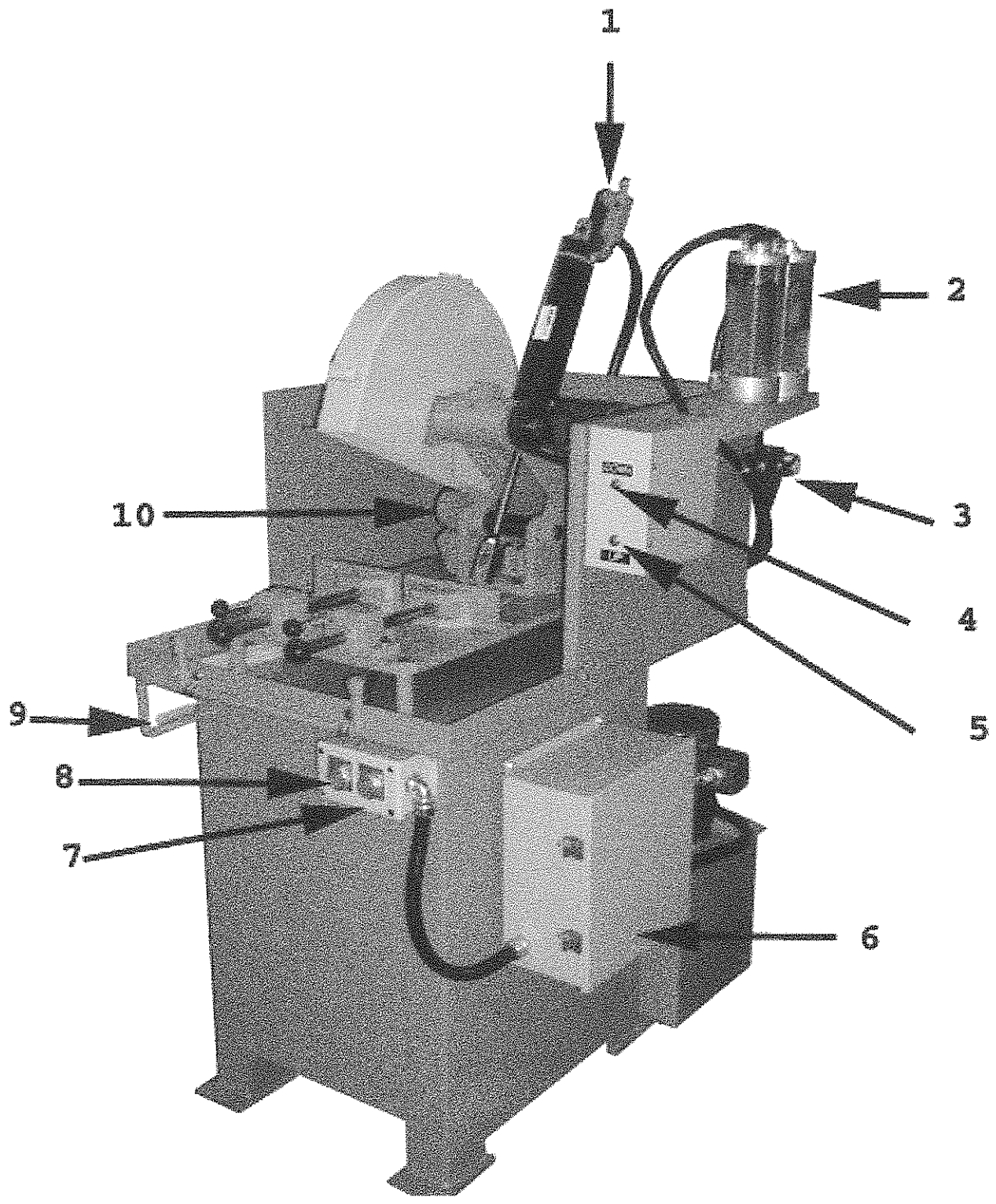
K12-14W

5 hp, 1" arbor, coolant

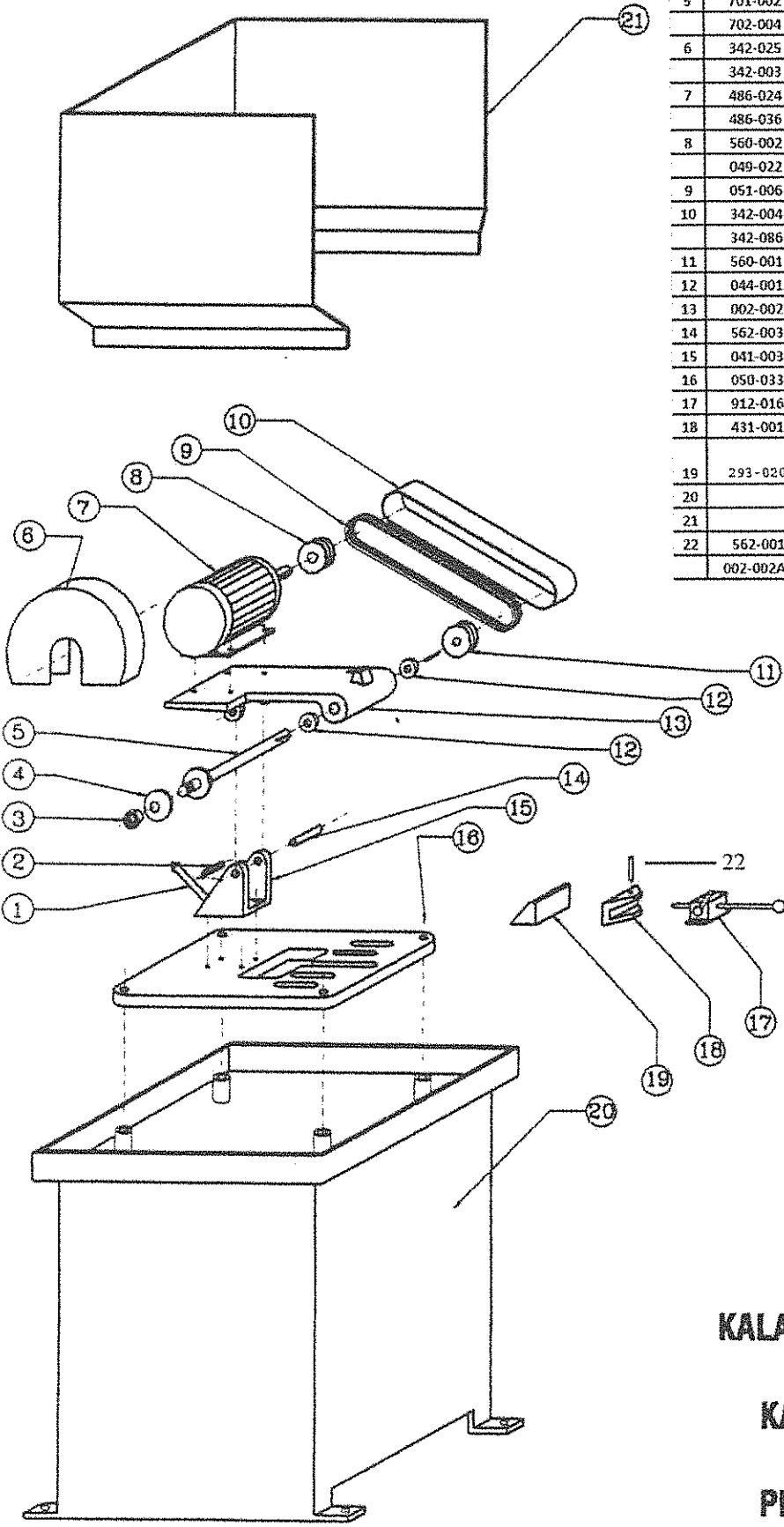
Optional: Air/oil power down feed

Basic Operation

1. Down feed flow control- Controls saw head down feed speed. CW rotation slows down feed and CCW rotation speeds down feed. Closing flow control valve stops down feed for set-up during cycle.
2. Oil reservoirs- Oil levels alternate with down feed cycle. DTE 24 hydraulic oil fills one reservoir $\frac{3}{4}$ full and the other $\frac{1}{4}$ full. Maintain oil levels. Re-fill oil at the top reservoir pipe plugs. Cycle down feed to remove air bubbles.
3. Air In- Regulator controls air pressure. Input DRY shop air into regulator. Max. air pressure 55 PSI .
4. Down- Controls down feed.
5. Up- Controls saw head return cycle. NOTE: UP MAY BE ENGAGED ANYTIME DURING CYCLE TO BRING SAW HEAD UP!
6. Electrical enclosure- Holds contactor, transformer. Drill enclosure to suit. Use seal tite fitting around incoming AC line . Input power to L1 L2 L3 on the top of the contactor. Be sure of correct incoming voltage, phase and wire size before operation.
7. Off- All stop.
8. ON- Turns saw motor ON.
9. Coolant- Coolant on/off.. Use rust inhibiting coolant only.!
10. Saw head return cam- Saw head engages air button to bring saw head back to top. Keep setscrews in cam snug enough to rotate cam for adjustment. Adjust cam as abrasive wheel wears.
11. Follow safety procedures- Safety glasses, no loose clothing, long hair, etc. See safety data sheets.



No.	Part No.	Description	QTY
1	645-004	Stop Assembly	1
2	697-018	Trunnion Spring	1
3	537-026	Spindle Nut	1
4	292-004	Loose Flange	1
5	701-002	Spindle W/ Loose Flange	1
	702-004	Spindle Assembly W/ Bearings (optional)	1
6	342-025	14" Wheel Guard	1
	342-003	12" Wheel Guard (optional)	1
7	486-024	5Hp 3Ph 1800 RPM	1
	486-036	5Hp 1Ph 1750 RPM (optional)	1
8	560-002	Motor Pulley (Bushing Sold Separately)	1
	049-022	Motor Pulley Bushing	1
9	051-006	V-Belts	2
10	342-004	Belt Guard	1
	342-086	Inner Belt Guard	1
11	560-001	Spindle Pulley	1
12	044-001	K-12 Bearings	2
13	002-002	Saw Arm	1
14	562-003	Trunnion Pin	1
15	041-003	Trunnion	1
16	050-033	Top Plate	1
17	912-016	Vise Assemblies (less jaws and pins)	2
18	431-001	Front Jaw	2
19	293-020	Fence	1
20		Base	1
21		Splash Guard	1
22	562-001	Vise Jaw Pins	2
	002-002A5	Arm Assembly (Arm and Spindle Assembly)	1



K12-14 W
5 hp, 1" arbor

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