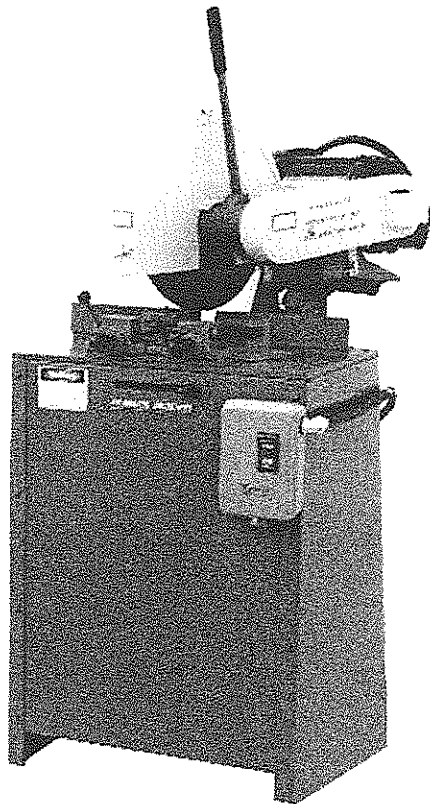


INSTRUCTION MANUAL

KM14



**KALAMAZOO
INDUSTRIES, INC.**

6856 East K Avenue

Kalamazoo, MI 49048

269-382-2050 PH

269-382-0790 FAX

www.kalamazooindustries.com

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

- DO always handle and store wheels in a careful manner.
- DO visually inspect all wheels before mounting for possible damage.
- DO check machine speed against the established maximum operating speed marked on the wheel.
- DO check mounting flanges for equal and correct diameter.
- DO use mounting blotters when supplied with wheels.
- DO always use a safety guard covering at least one-half of an abrasive wheel.
- DO allow newly mounted wheels to run at operating speed, with guard in place, for at least one minute before cutting.
- 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.

Basic Operation

The KM14 14" abrasive mitres 45 degrees left or right and any angle in between. Pre-set Holes have been drilled and pinned at 45 and 90 degrees. To swivel the saw head pull the index pin (7) on mitre base plate (5), loosen the table lock handle (3) rotate sawhead with trunnion pin (9). When desired angle is reached (45 deg or 90 deg.) replace index pin. With other angles there is no index pin hole. Use the table lock handle to lock the sawhead.

Two vises are provided for either left or right cuts. Typically only one vise is used depending on which way the sawhead is mitred. Dual vising can be used in the 90 degree position. Material must be straight to use both vises otherwise the workpiece may be straightened and will deform when cut pinching and breaking the abrasive wheel. Vise jaws swivel to mitre cut. If the workpiece is not as wide as the vise jaw use a shim on the other end of the jaw the same diameter/size as the workpiece to keep the jaw from swiveling. This will give even clamping. **BE SURE WORKPIECE IS SECURELY CLAMPED. ANY MOVEMENT DURING CUTTING WILL RESULT IN BLADE BREAKAGE!!**

Always use the correct abrasive wheel for the material being cut. Abrasive wheels come in different grades and bonds for specific materials. A good cut should be bright not blue or discolored. If discoloration occurs the wheel is not cutting and is heating up the material. Use enough pull down force to make the wheel cut and breakdown. Consult your dealer for abrasive blades.

Part Location can sometimes result in cutting problems. Be sure workpiece is slightly ahead of wheel center (towards operator). On small diameter parts shim out the workpiece to bring it towards the operator and slightly past wheel center. Keep wheel flanges clean and flat to ensure true running of the wheel.

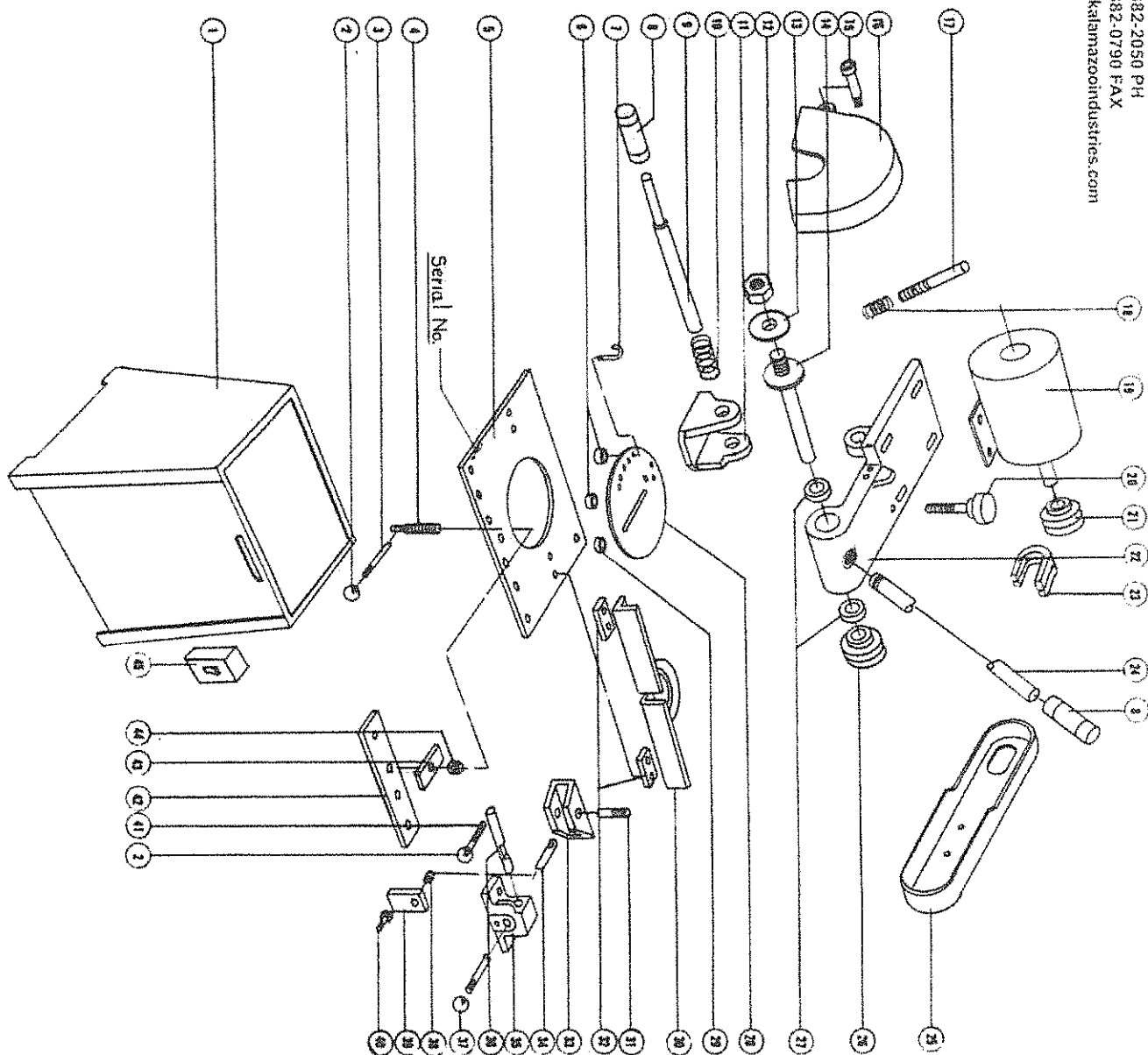
Spindle can be locked to change the wheel by using one of the vise jaw pins in the hole in the spindle housing. The spindle nut is a LH thread. Do not hammer tighten.

Maintenance

Always check V belt drives for correct tension. Loose drive belts cause slipping and poor cutting. Tighten V belts by loosening motor bolts, use a belt tightener to spread the pulleys for tension. Approximately 1/2" of squeeze is needed on the V belts for good tension. Use a straight edge to keep both pulley faces parallel to eliminate V belt wear when tightening. Keep machine and work area CLEAN. Ball bearings are sealed and do not need greasing. Follow safety precautions. **WEAR SAFETY GLASSES, DO NOT WEAR GLOVES, LONG HAIR, LOOSE CLOTHING THAT CAN GET CAUGHT IN THE BLADE !!**

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No.	Part No.	Description	Qty
1	716-001	Stand	1
2	441-002	Table Lock Knob	3
3	331-012	Table Lock Handle	1
4	656-013	Table Lock Screw	1
5	556-008	Mitre Plate Stand Top	1
6	044-006	Ball Bearings	2
7	562-020	Table Index Pin	1
8	347-003	Handle Grip	1
9	562-019	Turntion Pin	1
10	697-018	Turntion Spring	1
11	831-016	Turntion	1
12	537-026	1-1/4 L.H. Spindle Nut	1
13	292-004	Loose Flange	1
14	701-002	Spindle With Tight Flange	1
15	702-005	Spindle Assembly (Bearings, Spindle W/ Tight Flange Loose, Spindle Nut) Option	1
16	342-025	Wheel Guard	1
17	645-013	Stop Rod	1
18	697-027	Stop	1
19	486-001	5HP 3PH 3450RPM	1
20	486-023	5HP 1PH 3450RPM	1
21	696-014	Stop Screw W/ Knob	1
22	049-022	Motor Pulley (Bushing Sold Separately)	1
23	002-002	Motor Pulley Bushing (Not Shown)	1
24	051-006	Saw Arm	1
25	381-001	V-Belts	2
26	342-004	Saw Handle	1
27	566-001	Belt Guard	1
28	044-001	Spindle Pulley	1
29	050-013	K12 Spindle Bearings	2
30	053-001	Mitre Base Plate	1
31	293-001	Eccentric Bushing (W/044-007)	1
32	562-001	Mitre Fence	1
33	431-001	Vise Jaw Pins	2
34	645-009	Fence Spacers	2
35	386-001	Vise Jaw	2
36	129-001	Vise House (Only)	2
37	441-001	Vise Lock Cam	2
38	697-001	Vise Lock Knob	2
39	454-001	Vise Rod Spring	2
40	696-001	Vise Lock	2
41	381-001	Vise Cam Screw	2
42	699-005	Vise Lock Handle	2
43	454-004	Vise Spacer	1
44	912-016	Table Lock	1
45	002-002AS	5/8-11 Table Nut	1
		Vise Assembly (Less Jaws and Pin)	1
		Arm Assembly (Arm and Spindle Assembly)	2

KM14

APPROVED BY:	DATE:	DESIGNED BY:	REVISIONS: