

INSTRUCTION MANUAL S272V



KI **KALAMAZOO**
Industries Inc.

6856 East K Ave - Kalamazoo, MI 49048-6042
www.kalamazooind.com

WARRANTY

All products are guaranteed for a period of one year to the original purchaser, against defects in material work workmanship, under normal use

Electric motors are warranted by the manufacturer and will be repaired by the nearest repair station or replaced. Defective motors are not be returned to Kalamazoo Industries. Please call for instructions (269) 382-2050. Written authorization must be obtained before returning merchandise.

RETURN POLICY

- Authorization must be obtained before returning merchandise. Please call our Customer Service Department to receive a return authorization number (269) 382-2050.
- Please include with your return a copy of your invoice or packing slip.
- All returns will be subject to a 10% restocking fee.
- Customer is responsible for paying for return freight.
- No returns will be accepted after one year of invoice date.

BELT GRINDER 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.
- NEVER WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.
- ALWAYS KEEP HAIR TIED BACK AND COVERED.
- LET MACHINE ROTATION COME TO A FULL STOP BEFORE CHANGING BELT.
- KEEP SAFETY GUARDS IN PLACE. DO NOT ALTER GUARDS OR MACHINE IN ANY WAY. ANY ALTERATIONS TO GUARDS AND MACHINE COULD CAUSE SERIOUS INJURY AND WILL VOID MACHINE WARRANTY.
- ALL BELT SANDERS SHOULD BE OPERATED IN A WELL-VENTILATED AREA. THE DUST CREATED WHEN SOME MATERIALS ARE SANDED CAN BE HARMFUL. DUST MASKS/RESPIRATORS ARE RECOMMENDED AS A PRACTICAL MEANS OF MINIMIZING DUST INHALATION. FUMES FROM OTHER SOURCES CAN ALSO CAUSE FIRES WHEN IN CONTACT WITH SANDING SPARKS.
- NEVER MIX MATERIALS.
- SPARKS CREATED BY SANDING SHOULD BE DIRECTED DOWNWARD AND AWAY FROM THE FACE AND BODY. DO NOT GRIND NEAR FLAMMABLE MATERIALS.
- ELECTRICAL 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.

KALAMAZOO INDUSTRIES, INC.

6856 E K AVENUE

KALAMAZOO, MI 49048

PHONE: (269) 382-2050

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BASIC S272 BELT GRINDER OPERATION

INSPECTION

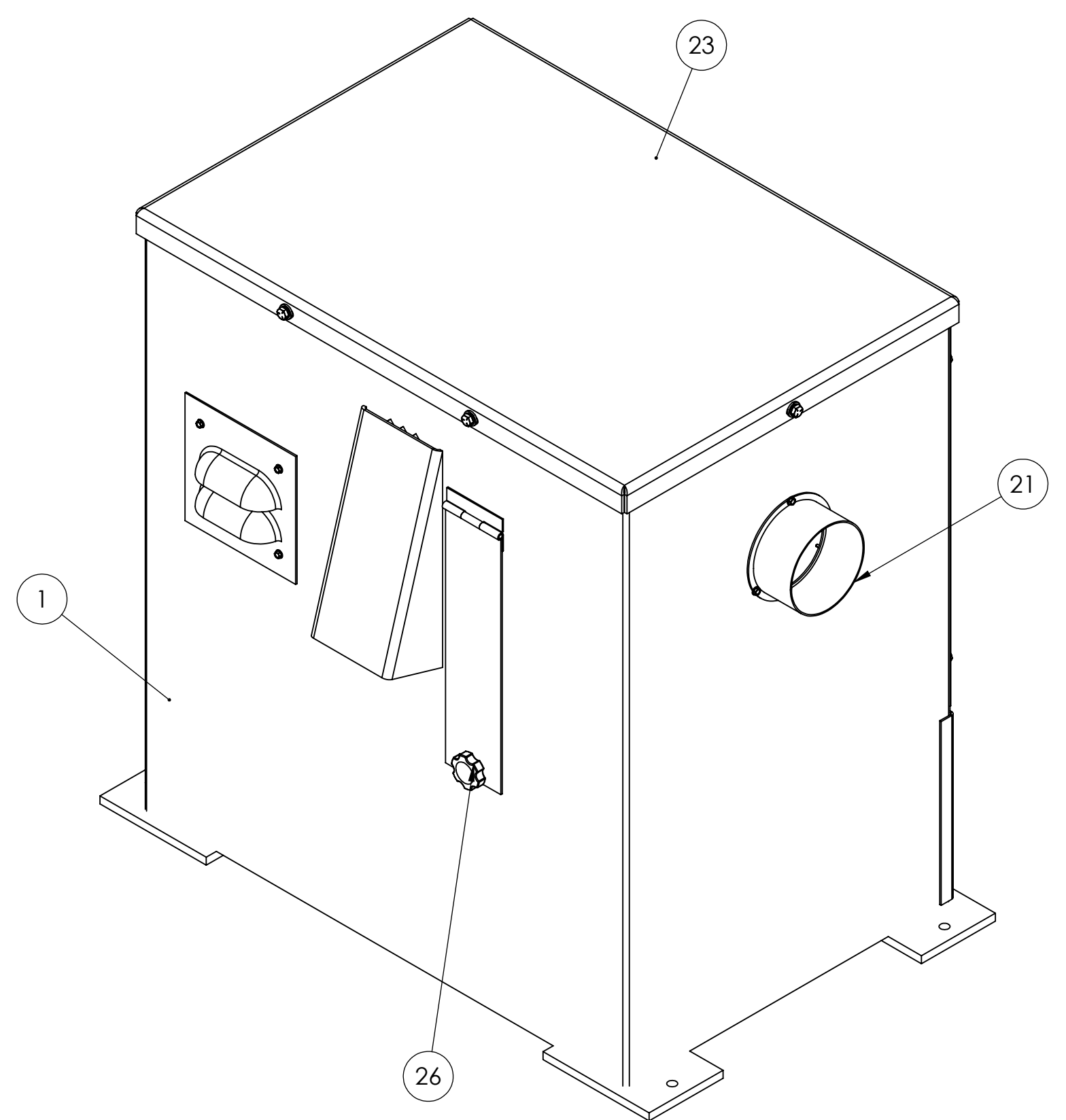
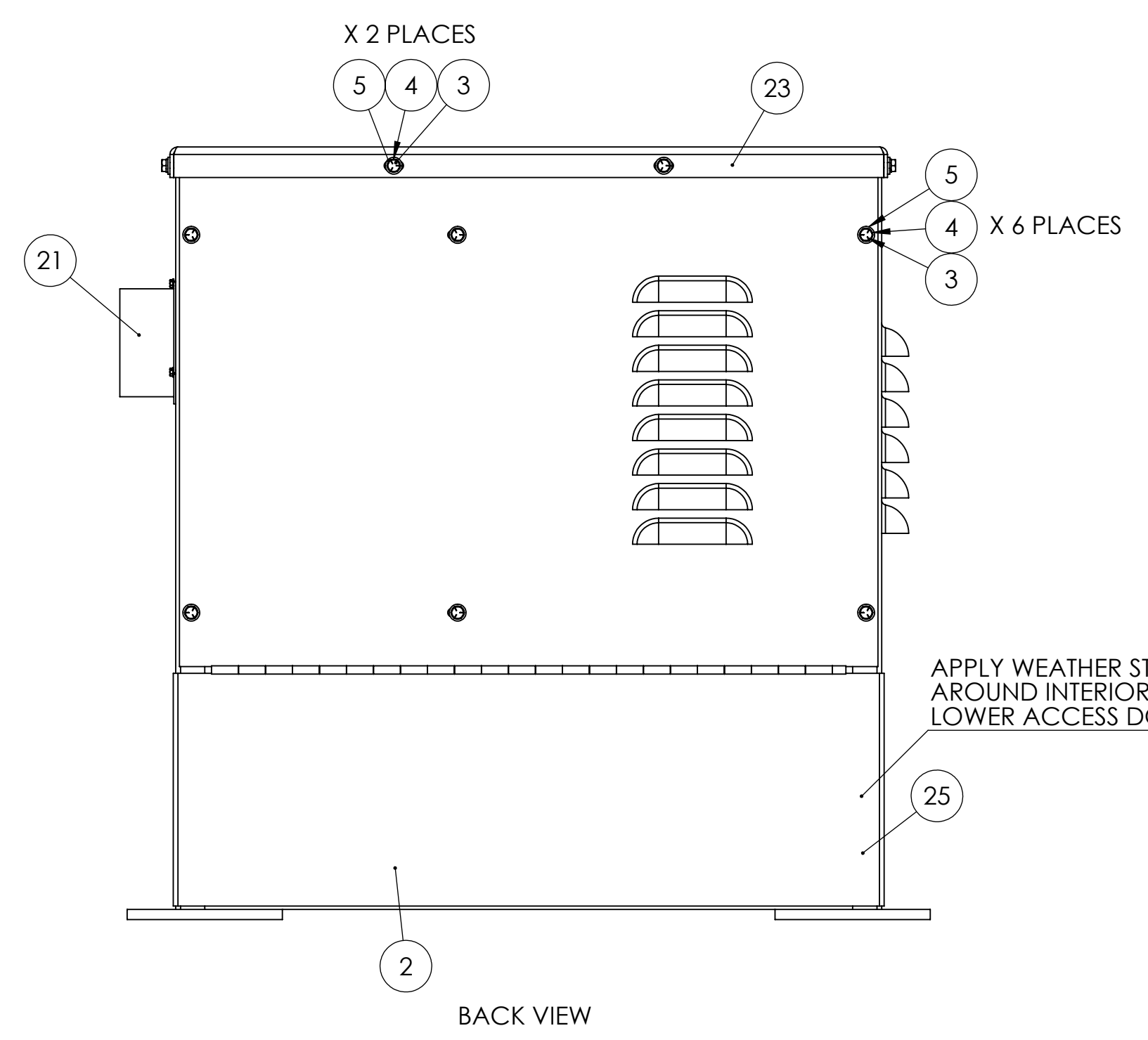
If these goods are damaged in transit, the **DELIVERING TRANSPORTATION COMPANY** is required by law to make notation of damages on the freight bill. If in your opinion, there may be concealed damage, they are required to make an inspection after goods are unpacked. Transportation rates are made in proportion 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.**

OPERATING INSTRUCTIONS

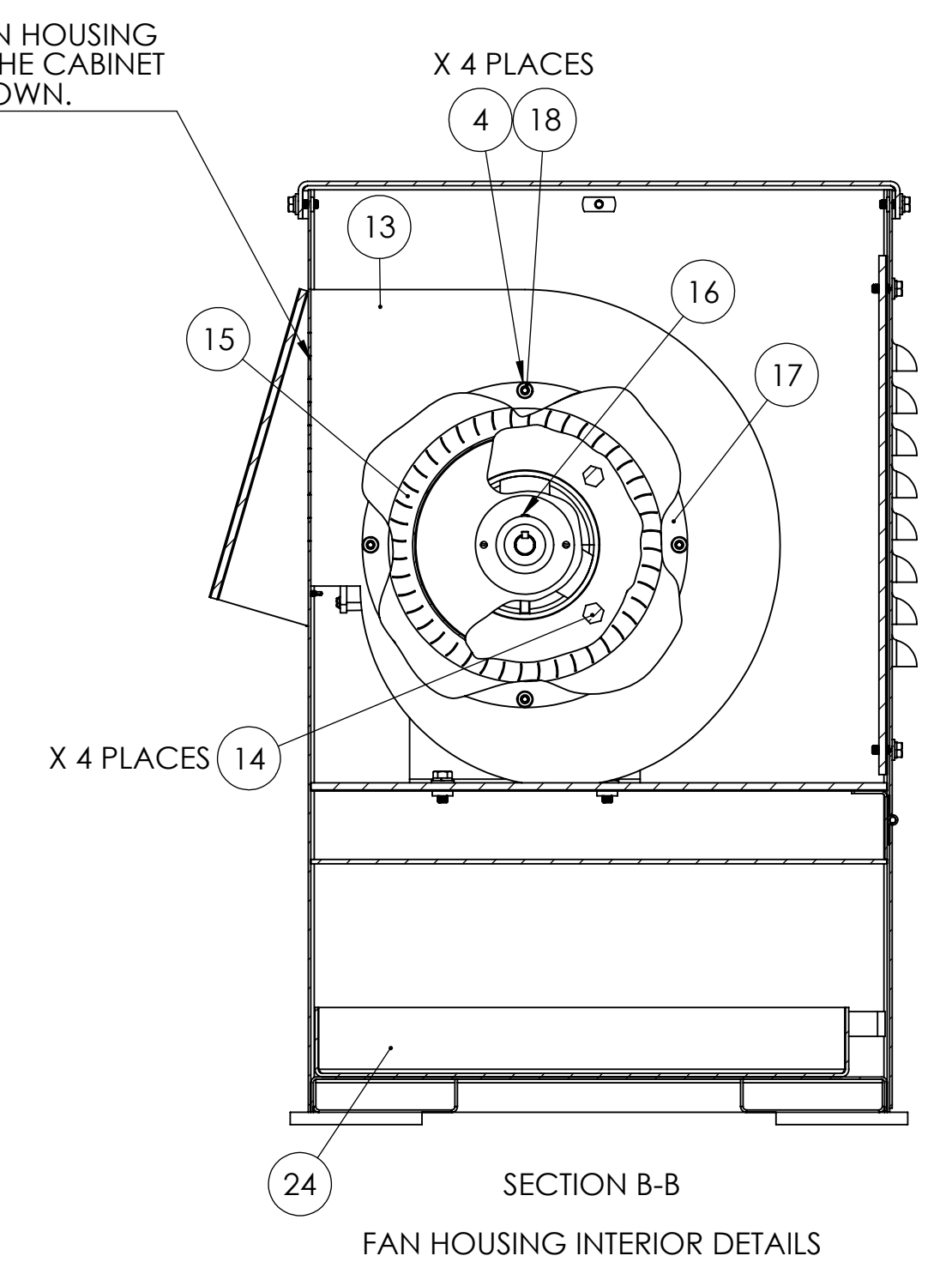
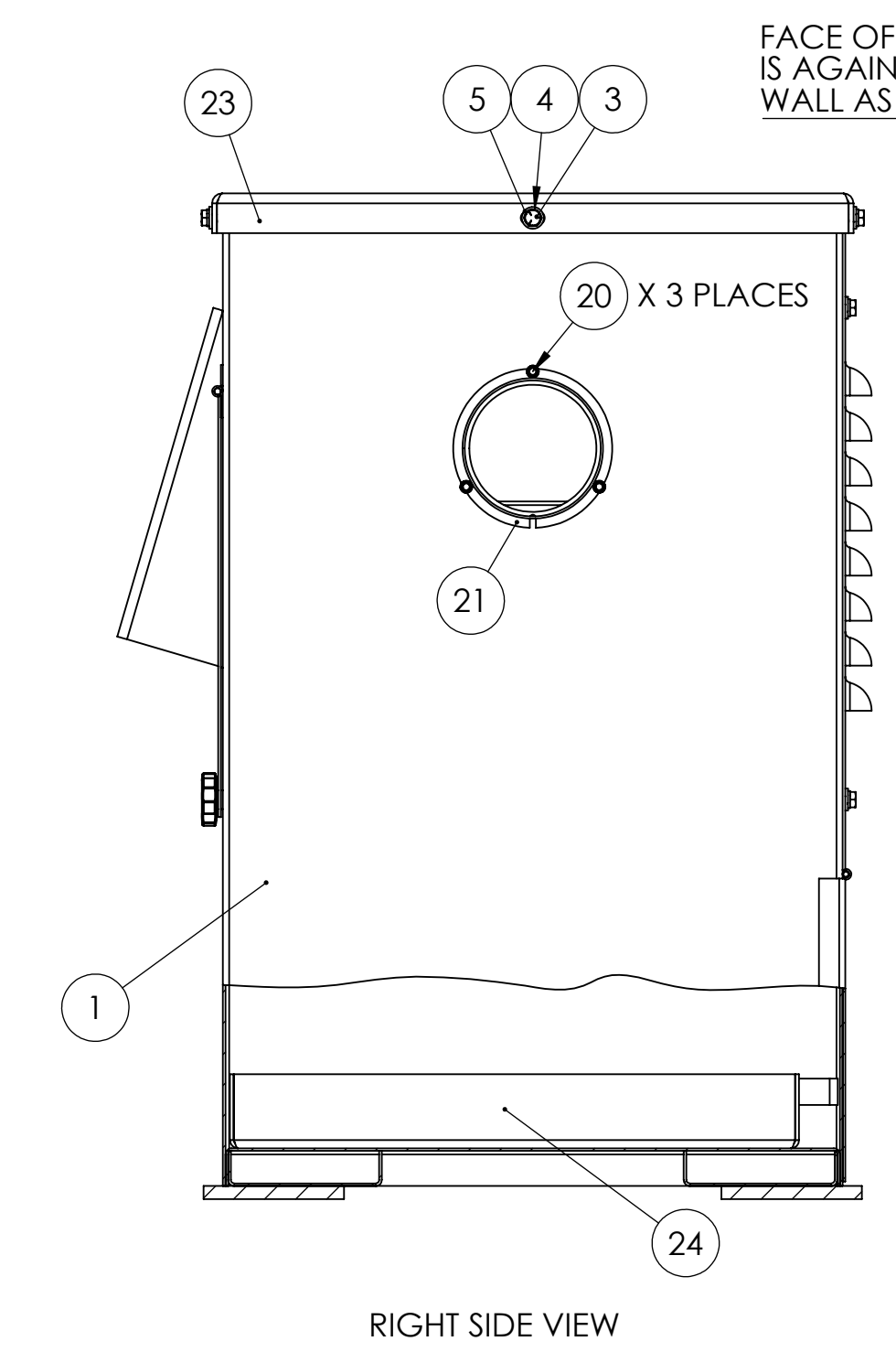
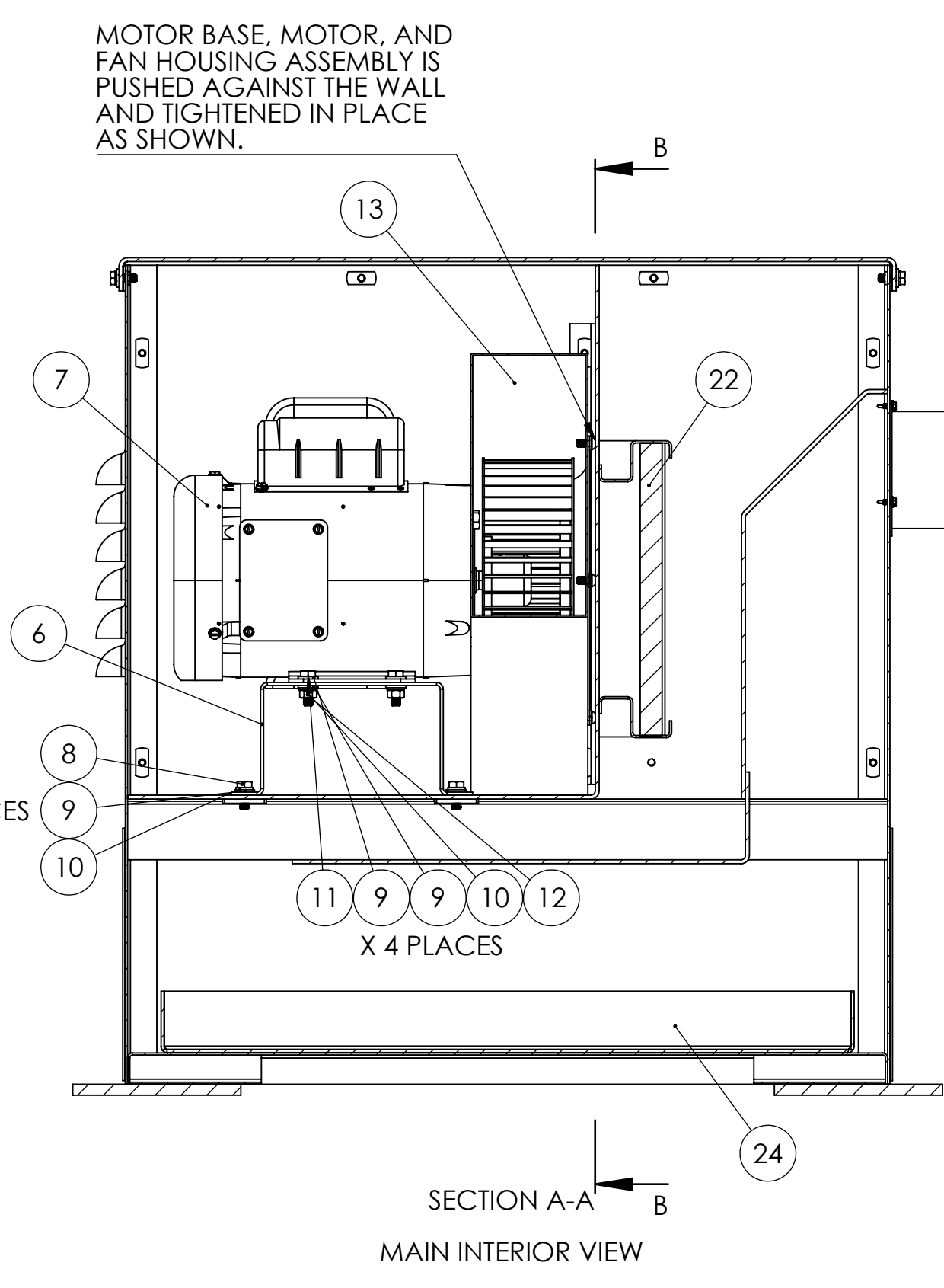
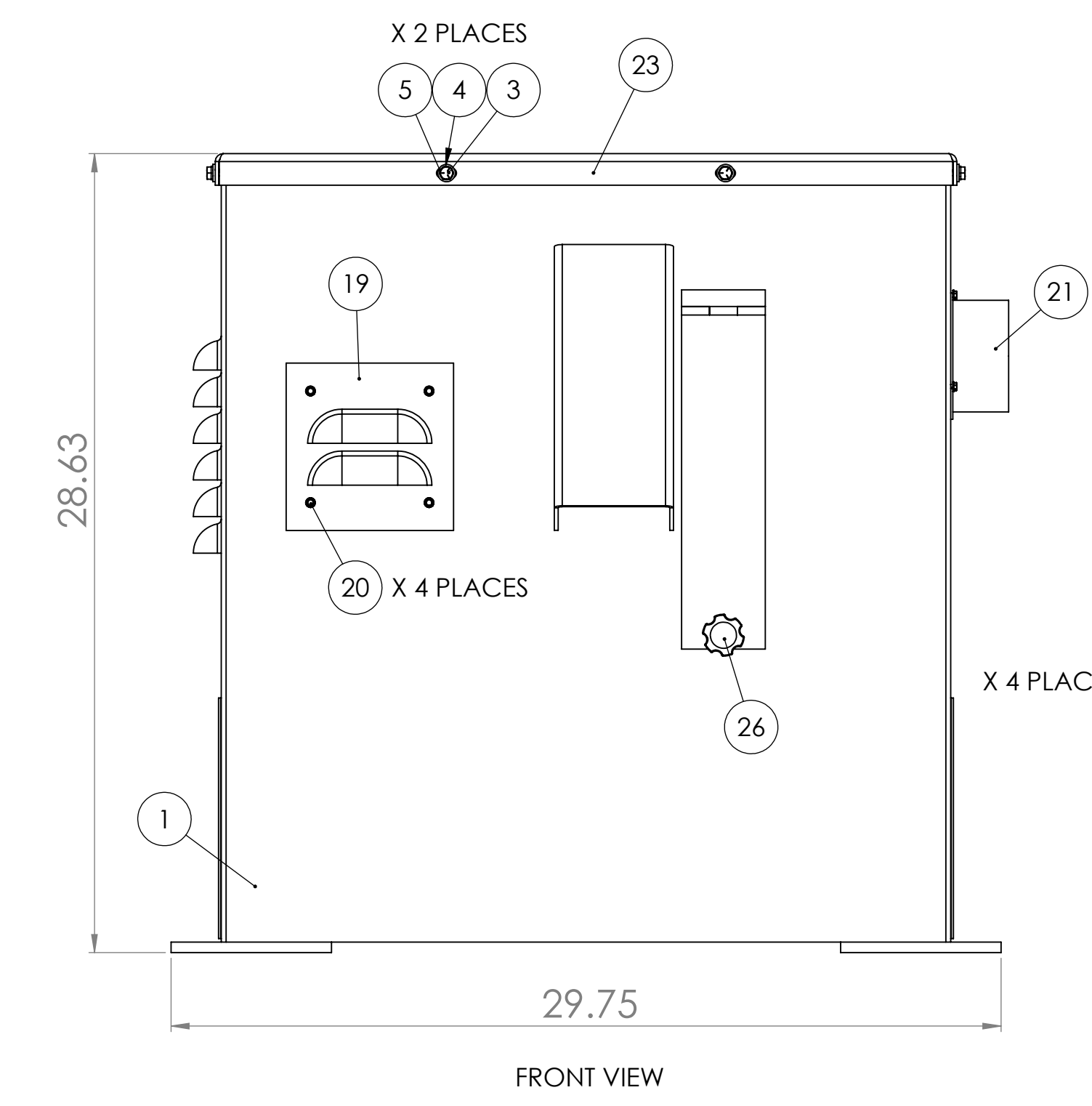
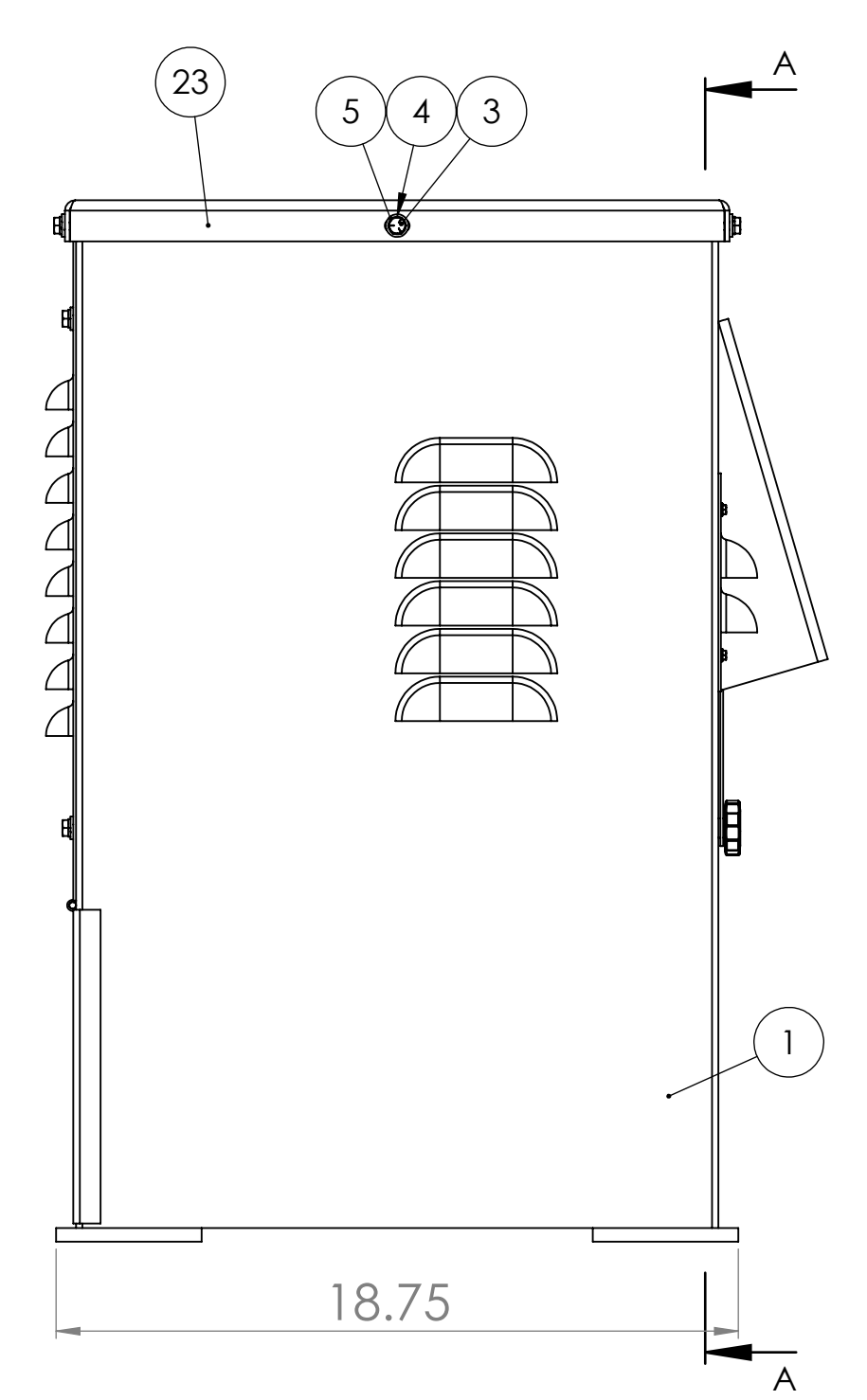
1. **Electrical:** Remove from crate and be sure to check that incoming voltage matches units voltage. If your not sure how to wire your grinder to the incoming power hire an electrical. **If the machine wired incorrectly and the electrical components are destroyed the warranty is voided.**
2. **Belt changing:** Turn off machine power, open the side door of the machine to expose the sanding belt. Release lever (#29) from rack (#30). This releases belt tension. Remove sanding belt and replace with a new belt. Re-tension the sanding belt by pulling up on lever (#29) and locking it into the rack (#30). Only moderate pressure is needed.
3. **Belt tracking:** Track or “center on the pulleys” the sanding belt with knob (#28). This moves the sanding belt left or right. The belt should stay centered or “tracked”.
4. **Platen:** S272 has two serrated 70 duro contact wheels on either end of the platen (#13). You can position the platen and contact wheels in any configuration needed. Loosen the center bolt on the platen (#13) and rotate to the position desired. Use either contact wheel or just the flat platen area. The adjusting bar (#9) may need to be loosened and pulled tight to get correct belt tension for the platen position. Re-tighten all belts and cap screws to maintain platen/contact wheel position.
5. **Work table:** When using the work table keep the table within 1/8” of the sanding belt to prevent “pinching” the work piece between the belt and the table.
6. **Belt guard:** Keep the belt guard (#34) down.
7. **Safety:** Always follow correct safety procedures. **SEE SAFETY SHEET.**
8. **DUST COLLECT: DO NOT MIX MATERIAL. CLEAN SYSTEM OUT DAILY.**

Trouble shooting/tracking problems

1. Drive pulley lost its crown (curvature of pulley).
2. Sanding belts are not spliced/glued correctly.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	124-005	CABINET FOR DCV-6 DUST COLLECTOR	1
2	124-005-BACKPANEL	BACK PANEL ASSEMBLY FOR DCV-6 CABINET	1
3	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	12
4	SLWZ025	1/4 SPLIT L/W Z	16
5	UFWZ025	1/4 USS F/W Z	12
6	041-015	DCV-6 VACUUM MOTOR MOUNT BRACKET	1
7	486-002	1HP, 1PH, 3450RPM, 56F, 115/230 FOR 2FSM-1HP, 2FS72M-1HP, S272, S4S-1HP, S4SWB, S460	1
8	HHC5031012	5/16-18 X 3/4 HHCS GR5 Z	4
9	UFWZ031	5/16 USS F/W Z	12
10	SLWZ031	5/16 SPLIT L/W Z	8
11	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
12	FHN5031	5/16-18 FHN GR5 ZINC	4
13	386-026	HOUSING FAN FOR DCV-6	1
14	HHC5037016	3/8-16 X 1 HHCS GR5 Z	4
15	296-001	FAN, SQUIRREL CAGE FOR DCV-6	1
16	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	1
17	004-005	ADAPTOR, INLET CONE FOR DCV-6	1
18	BSCA025008	1/4-20 X 1/2 BSHCS	4
19	455-018	SMALL LOUVER PANEL FOR DCV-6 DUST COLLECTOR	1
20	HWZ008008	#8 X 1/2 HWH TEKS Z	7
21	342-069B	4" ORIFACE W/ FLANGE FOR 6" SANDER GUARDS	1
22	294-003	FILTER FOR DCV-6	1
23	124-006	VACUUM CABINET TOP FOR DCV-6	1
24	834-002	DUST TRAY FOR DCV-6	1
25	933-001 X 65 INCHES	65 INCHES OF WEATHER STRIPPING AROUND CABINET LOWER ACCESS DOOR	1
26	441-015	907B-2500-1.00S 1/4 THUMBSCREW 1-1/2 DIA	1



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UNLESS OTHERWISE SPECIFIED:		NAME	DATE	KALAMAZOO INDUSTRIES, INC.
DIMENSIONS ARE IN INCHES				
FRACTIONAL: ±		DRAWN		TITLE: DCV-6 DUST COLLECTOR
ANGULAR: MATCH ±	BEND ±	CHECKED		SIZE DWG. NO. D DCV-6
TWO PLACE DECIMAL: ±	THREE PLACE DECIMAL: ±	ENG APPR.		SCALE: 1:5 WEIGHT: SHEET 1 OF 1
INTERPRET GEOMETRIC TOLERANCING PER:		Q.A.		
MATERIAL		COMMENTS:		
FINISH				
APPLICATION	DO NOT SCALE DRAWING			