

# INSTRUCTION MANUAL S460V BELT SANDER AND VACUUM



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

6856 East K Avenue

Kalamazoo, MI 49049

Phone: (269) 382-2050

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



**MADE IN USA**

## 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 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.
- 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.

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# BASIC OPERATION

**Belt chaning** - use lever **#33** to replease sanding belt tenion. Pull lever to compress spring, remove and replace sanding belt. Push lever back to tension sanding belt.

**Belt tracking** - use tracking knob **#43** to track/center the sanding belt. Rotate sanding belt by hand to be sure of sanding belt centering. When sanding belt remains centered on the steel platen **#348**tracking is complete. Connect AC power and “job” on/off switch to be sure sanding belt stays in the center of the platen and is tracked correctly.

**Platen** - steel plate “platen” is behind the sanding belt. It will wear over time and can be rotated and flipped over so you can use a new surface area. Remove cap screws on the platen to rotate platen.

**Work table** - always keep work table within 1/8<sup>th</sup> of sanding belt. Too large of a gap will allow work pieces and fingers to get pinched. **CAUTION: DO NOT WEAR GLOVES, LOOSE CLOTHES AND ALWAYS TIE BACK HAIR.**

**MAINTENANCE** - keep machine clean. Flip and or rotate platen when necessary. Never sand in one area so the platen will wear evenly. No grease is required. All bearings are sealed for the life of the bearing. Clean dust collector and sander at the end of every shift

**DUST COLLECTOR** - Clean dust collector after every shift and don't mix materials.

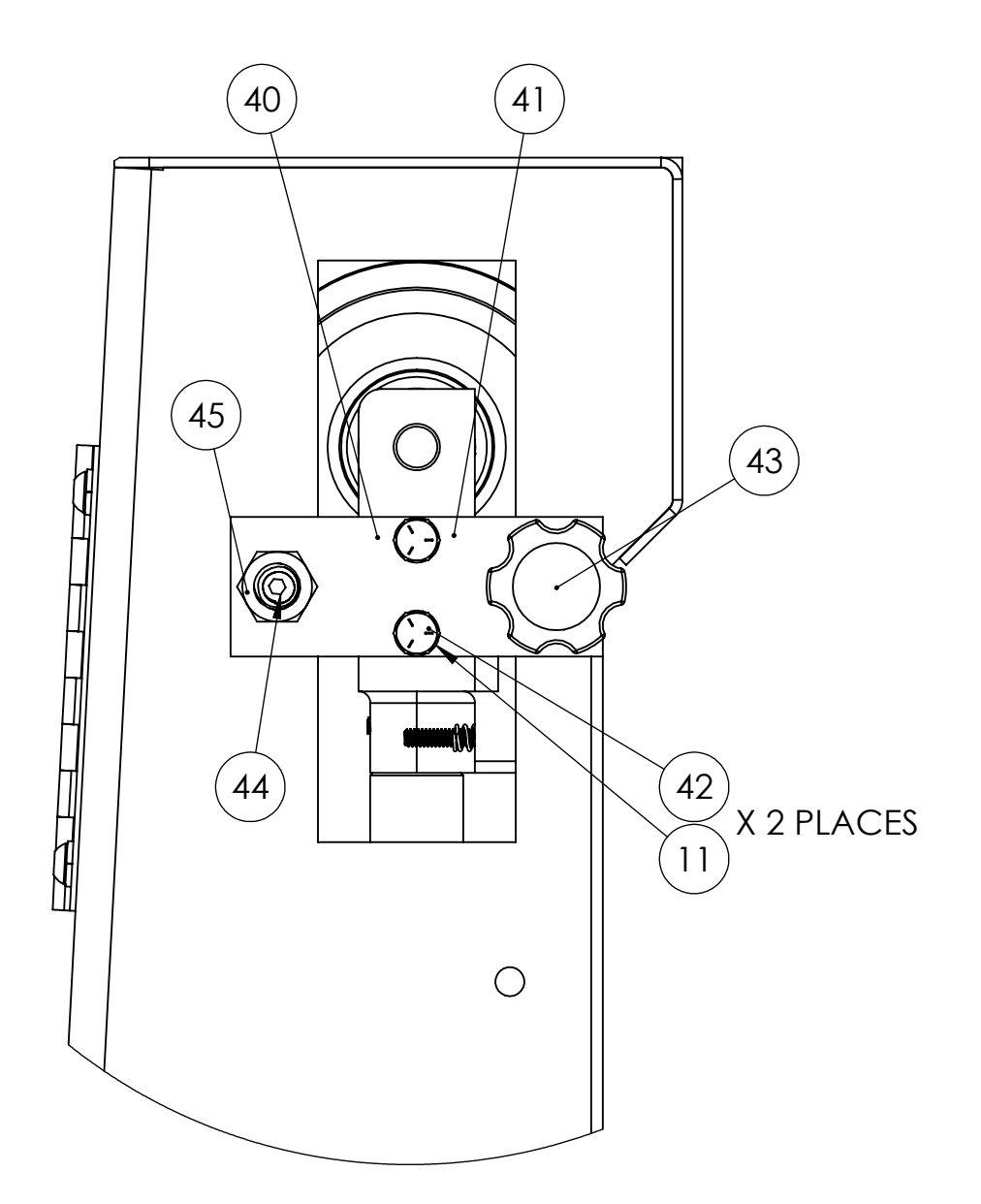
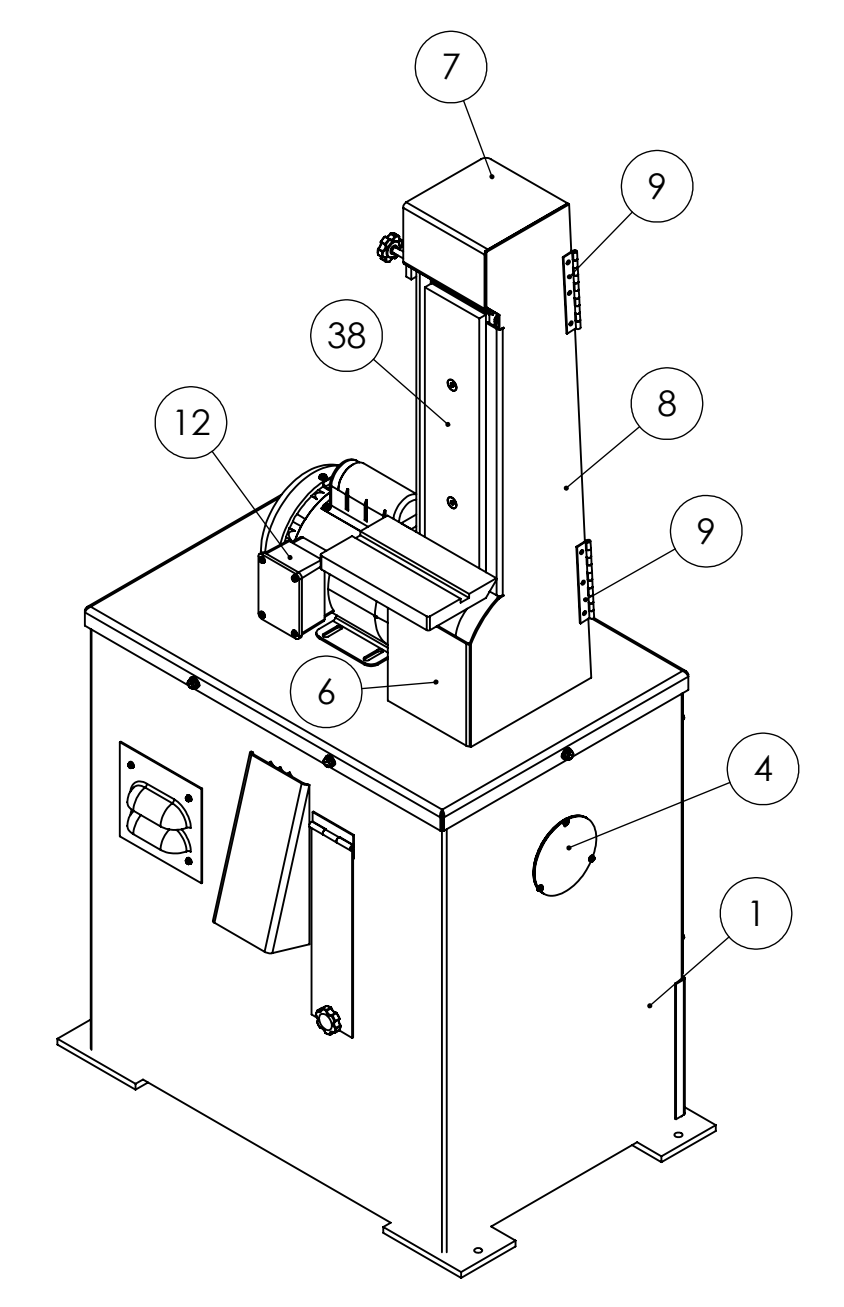
**Trouble shooting** - base machine needs very little maintenance other than tracking the sanding belt. If sanding belt does not stay tracked typically the drive pulley **#15** has lost its “crown” and requires replacement. The drive pulley is tapered down from the center out on both right/left edge slightly. This makes the sanding belt stay in the center or “tracked”.

## **BELT SANDER SAFETY**

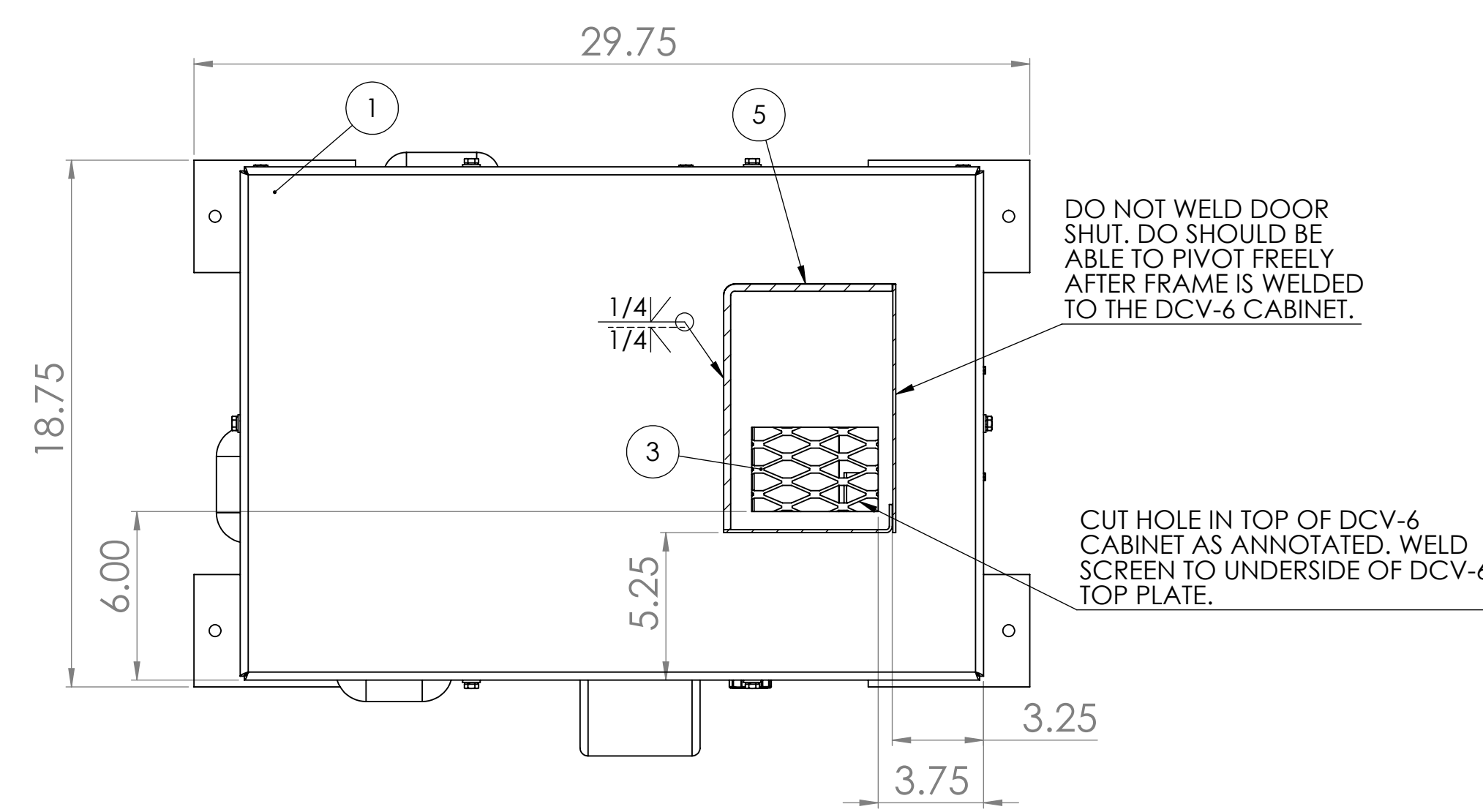
- **DO NOT WEAR GLOVES**
- **DO NOT WEAR LOOSE CLOTHING**
- **TIE HAIR BACK**
- **ALWAYS WEAR SAFETY GLASSES/SHIELD**
- **CLEAN DUST COLLECTOR AFTER EVERY SHIFT**
- **DON'T MIX MATERIALS.**



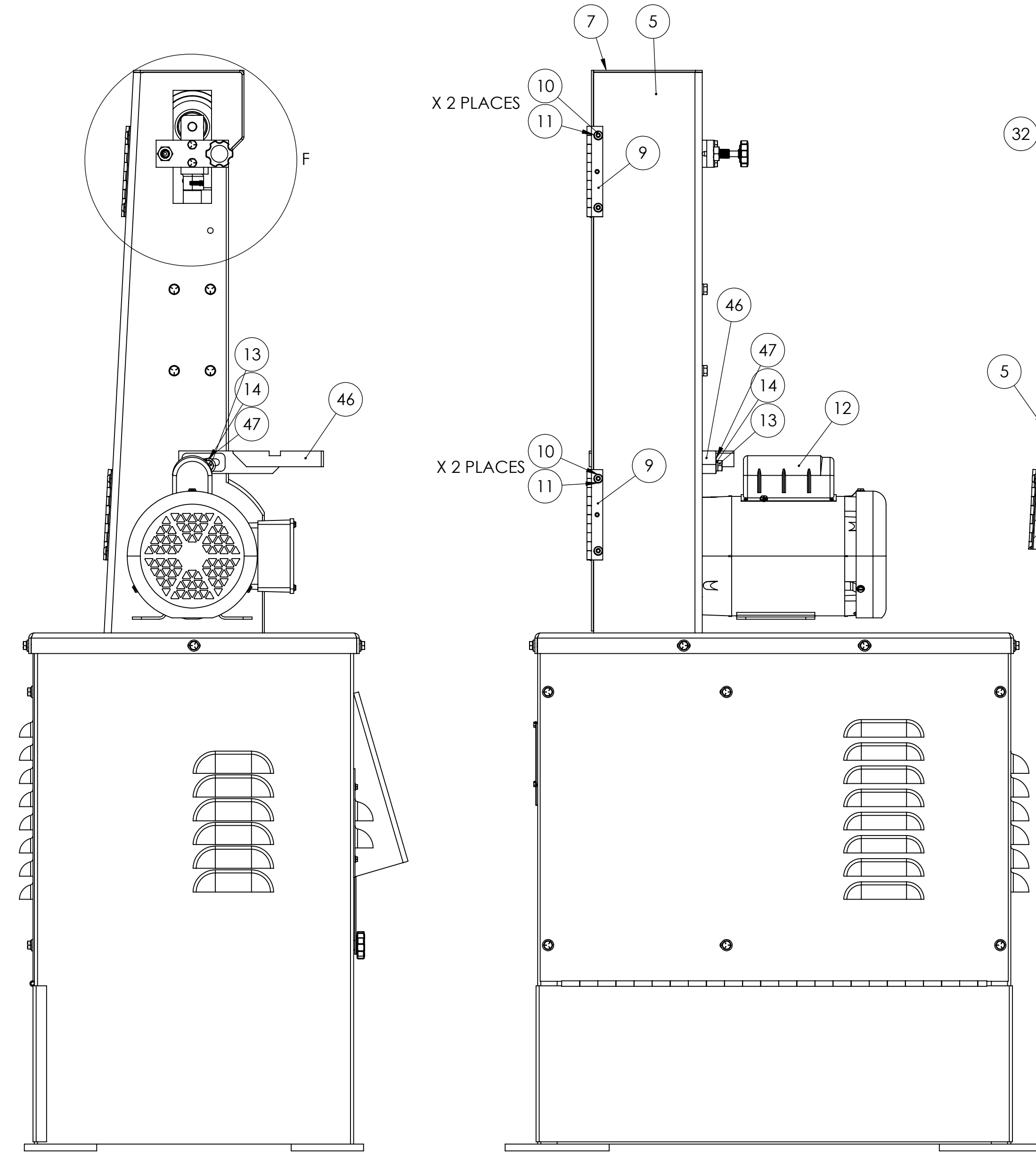
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	DCV-6	DCV-6 DUST COLLECTOR	1
2	S460V-BAFFLEPLATE	BAFFLE PLATE FOR DCV-6 CABINET/S460V APPLICATION	1
3	S460V-SCREEN	SCREEN FOR DCV-6 CABINET/S460V APPLICATION	1
4	342-069C	BLANK COVER FOR S6M SANDER OSHA GUARD	1
5	291-028BURNOUT	MAIN FRAME BURNOUT FOR S460 SANDER	1
6	291-028-A	FRONT GUARD FOR S460D SANDER	1
7	342-077	TOP BELT GUARD FOR S460D SANDER	1
8	291-028DOOR	FRAME DOOR FOR S460D, S460V, S460W SANDERS	1
9	291-028HINGE	HINGE FOR S460 DOOR	2
10	BSCA025008	1/4-20 X 1/2 BS HCS	4
11	SLW2025	1/4 SPLIT L/W Z	6
12	486-002	1 HP MOTOR FOR 2FSM-1HP, 2FS72M-1HP, S272, S45-1HP, S45WB, S460D, BG272, DCV-6, DCV-8	1
13	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	5
14	SLW2037	3/8 SPLIT L/W Z	5
15	560-005	PULLEY, DRIVE (ALUMINUM) FOR S4, S4S, S460D	1
16	SSKA025006	1/4-20 X 3/8 SOC SET KNURL PT.	1
17	291-018	CAST IRON FRAME FOR S460 DRY SANDERS	1
18	HHC5031016	5/16-18 X 1 HHCS GR5 Z	4
19	SLW2031	5/16 SPLIT L/W Z	4
20	700-022	TENSION SHAFT, IDLER YOKE, FOR S460 SANDER	1
21	ROLA025024	1/4 X 1-1/2 ROLL PIN	1
22	697-024	S6 BELT TENSION SPRING	1
23	960-002	YOKE FOR S4 SANDER	1
24	HHC5031020	5/16-18 X 1-1/4 HHCS GR5 Z	1
25	FHN5031	5/16-18 FHN GR5 ZINC	2
26	697-011	TRACKING SPRING FOR S4	1
27	CRMZ010024	10-24 X 1-1/2 COMBO ROUND M/S Z	1
28	701-008	SPINDLE, IDLER FOR S4, S460 SANDERS	1
29	560-006	IDLER PULLEY S4 W BEARINGS FOR S4S AND S460	1
30	123-003	COLLAR FOR S4	1
31	EERR0.5	EERR 1/2 1/2" E RETAINING RING	1
32	SSKA010004	10-24 X 1/4 SOC SET KNURL PT	2
33	455-003	TENSION RELEASE LEVER FOR S6 SANDER HEADS	1
34	HHT5031032	5/16-18X2 HEX HEAD TAP BOLT GR5 ZINC	1
35	UFWZ031	5/16 USS F/W Z	1
36	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
37	STNZ031	5/16-18 STOVER LOCK NUT ZINC-WAX	1
38	563-014	PLATEN FOR S460 SERIES	1
39	FSCA031016	5/16-18 X 1 FSHCS	2
40	048-019	TRACKING BAR FOR S460	1
41	699-028	TRACKING BAR SPACER FOR S460 SANDERS	1
42	HHC5025016	1/4-20 X 1 HHCS GR5 Z	2
43	441-014	TRACKING KNOB ASSEMBLY	1
44	SPPA050020	1/2-13 X 1-1/4 SPRING PLUNGER W BROWN DELRIN NOSE ALLOY	1
45	FJNZ050	1/2-13 F H JAM NUT Z	1
46	829-034	CAST IRON WORK TABLE FOR S272, S460, AND BG448	1
47	UFWZ037	3/8 USS F/W Z	1



DETAIL F  
SCALE 1 : 2  
BELT TRACKING DETAILS

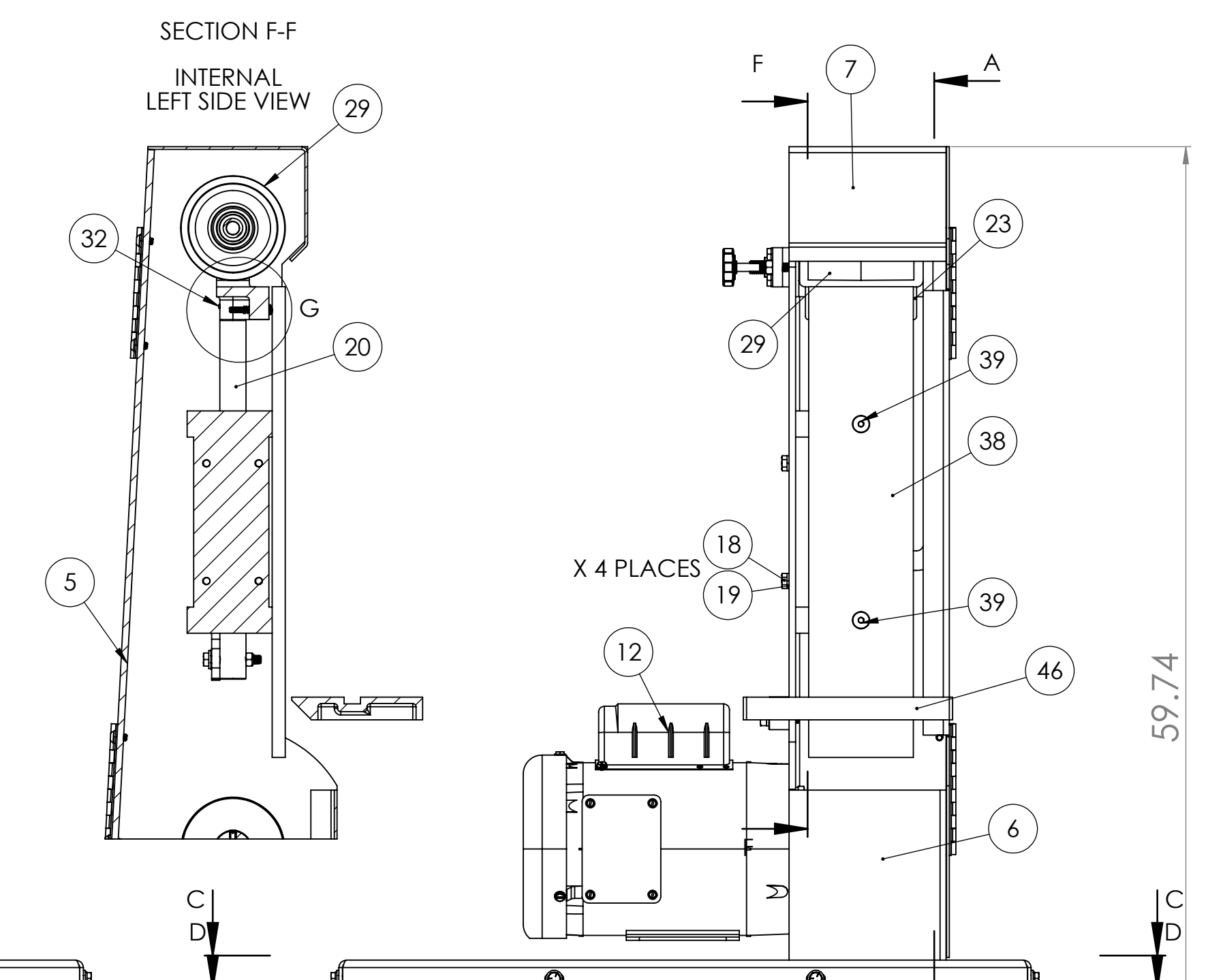


SECTION C-C  
DCV-6 TOP PLATE MODIFICATION AND FRAME LOCATION.

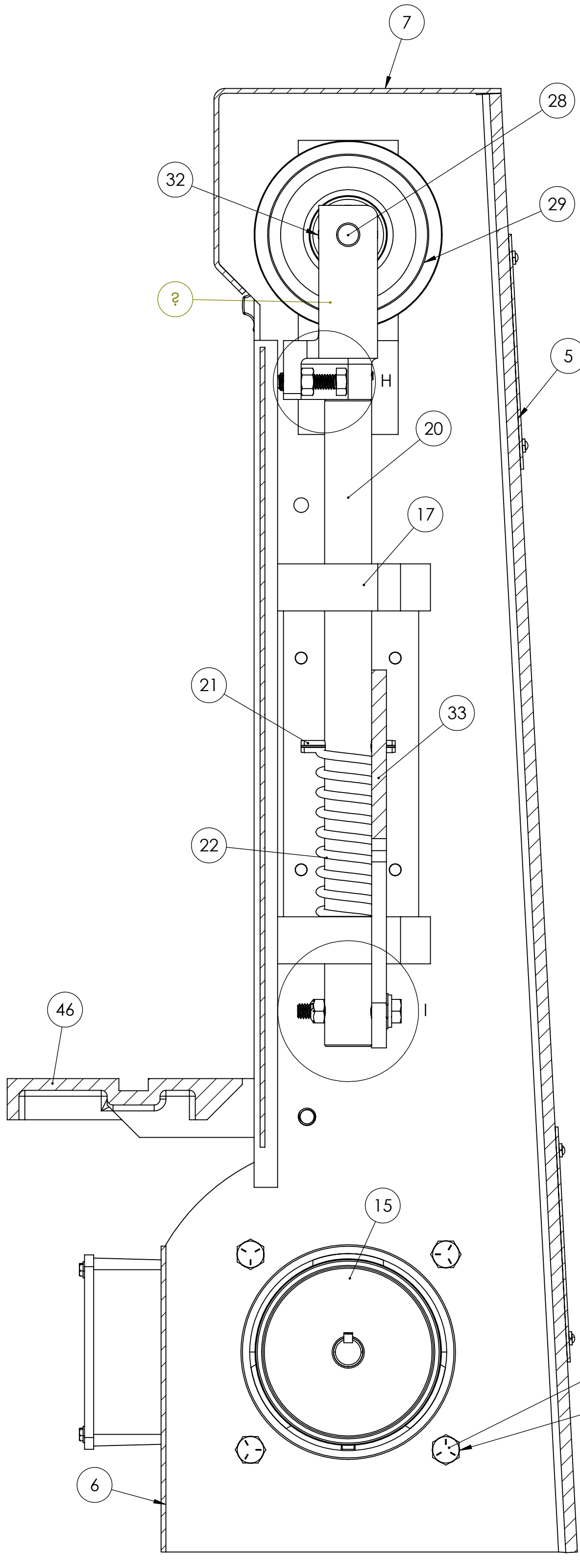


BACK VIEW

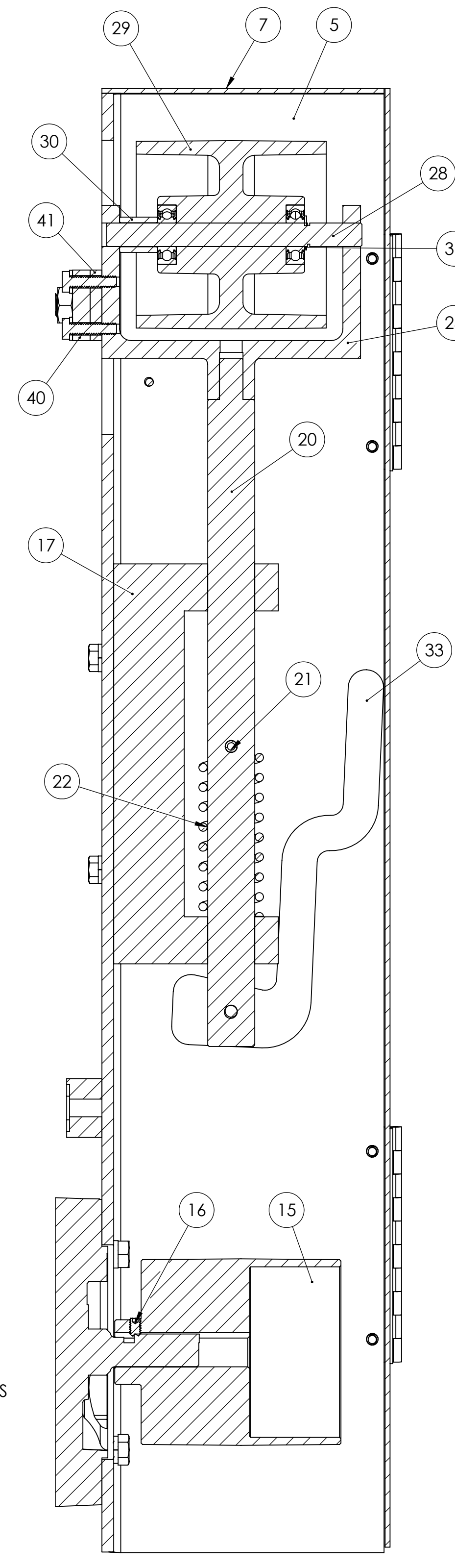
FRONT VIEW



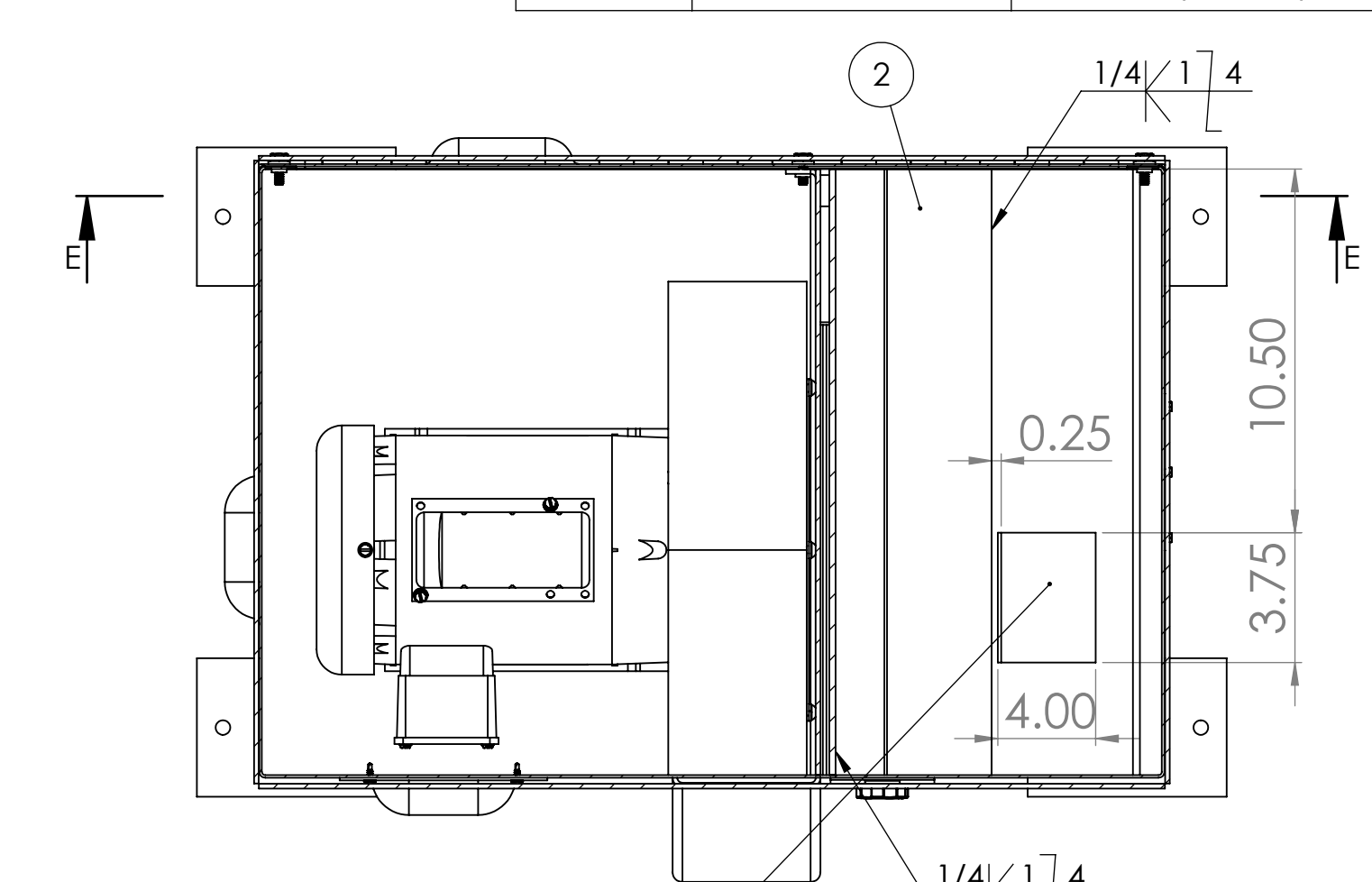
SECTION F-F  
INTERNAL LEFT SIDE VIEW



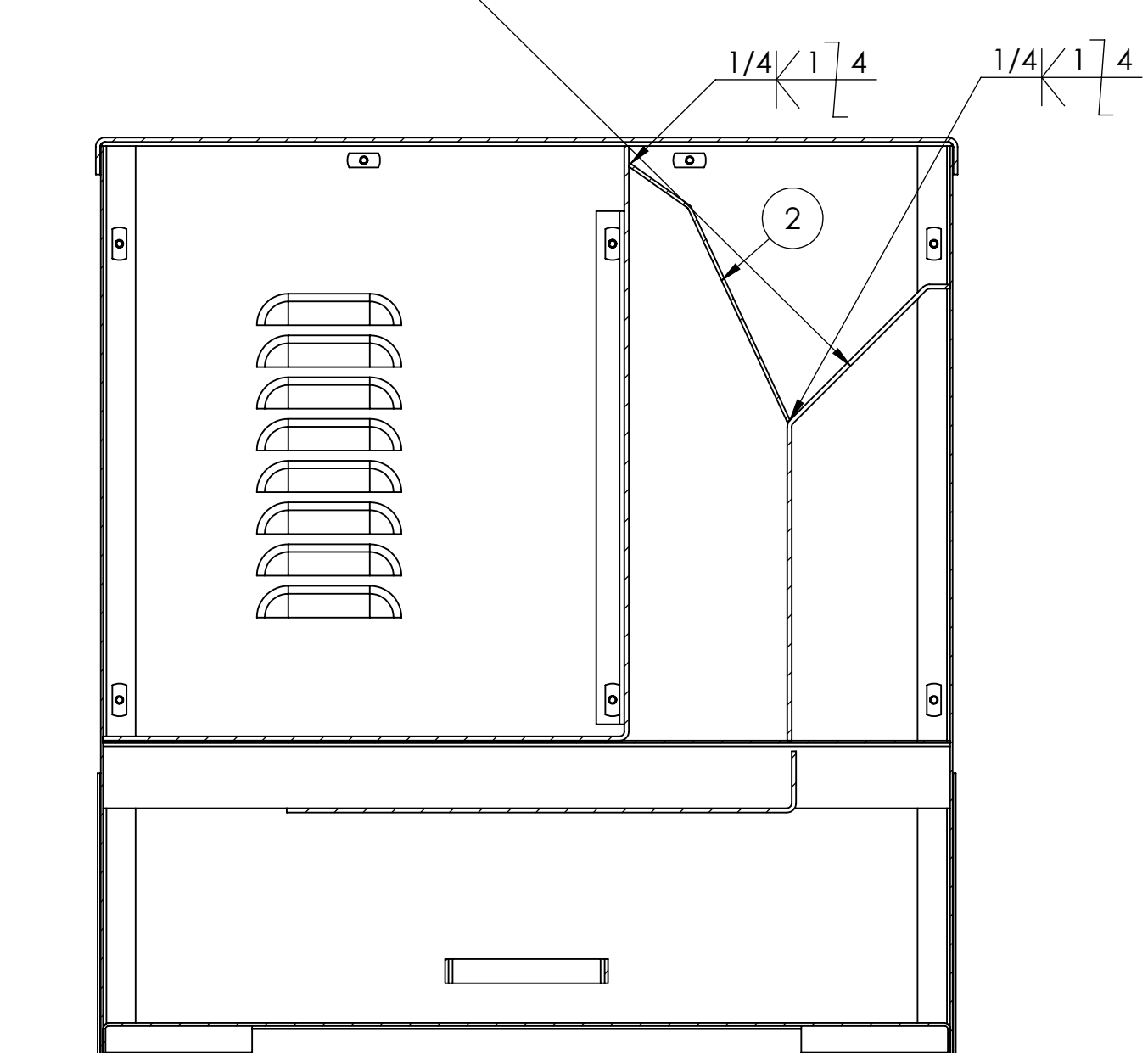
SECTION A-A  
INTERNAL RIGHT SIDE VIEW  
SCALE 1 : 2



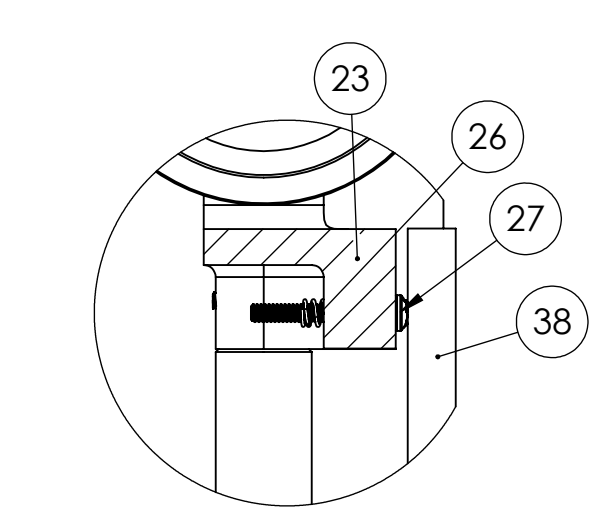
SECTION B-B  
INTERNAL FRONT VIEW  
SCALE 1 : 2



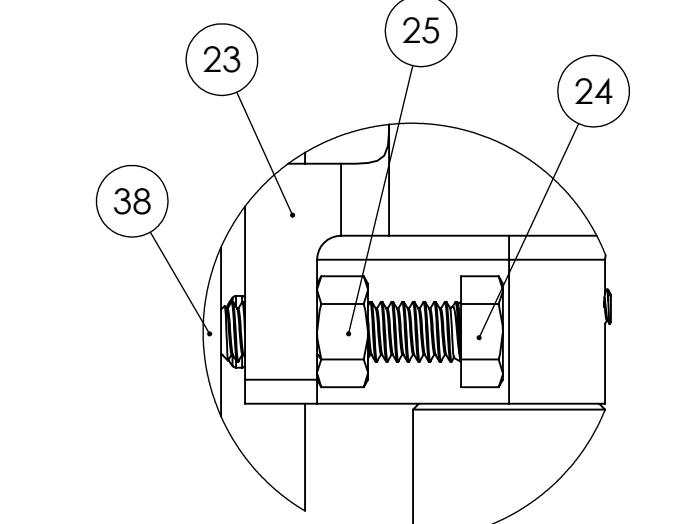
SECTION D-D  
TOP VIEW OF DCV-6 MODIFICATION AND INSTALLATION OF BAFFLE PLATE



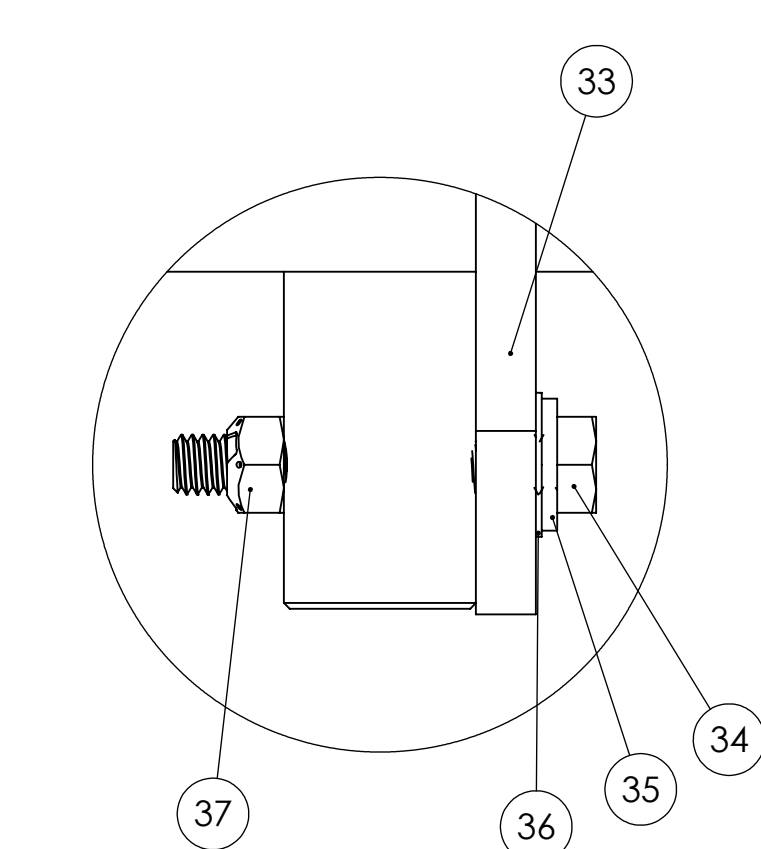
SECTION E-E  
FRONT VIEW OF DCV-6 MODIFICATION AND INSTALLATION OF BAFFLE PLATE



DETAIL G



DETAIL H



DETAIL I  
SCALE 1 : 1  
BELT TENSION LEVER FASTENERS

CONSULT DCV-6 DRAWING FOR ADDITION DCV-6 DETAILS.  
CLEAN UP AND GRIND ALL EXTERIOR WELDS  
PAINT DCV-6/ FRAME WELDMENT BEFORE FINAL ASSEMBLY.

UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES	TOLERANCES:	DRAWN:	CHECKED:
FRACTIONS: 1/8, 1/4, 3/8, 1/2	DECIMALS: .1, .05, .01	ENG APPR:	ENG APPR:
THREE PLACE DECIMAL: .001	FOUR PLACE DECIMAL: .0001	DATE:	DATE:
INTERFERE GEOMETRIC TOLERANCES PER ASME Y14.5	FINISH:	COMMENTS:	
NEATNESS	USED ON:		
APPLICATION	DO NOT SCALE DRAWING		

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TITLE: **S460 WITH DCV-6 VACUUM**

SIZE: **E S460V**

SCALE: 1:5 WEIGHT: SHEET 1 OF 1