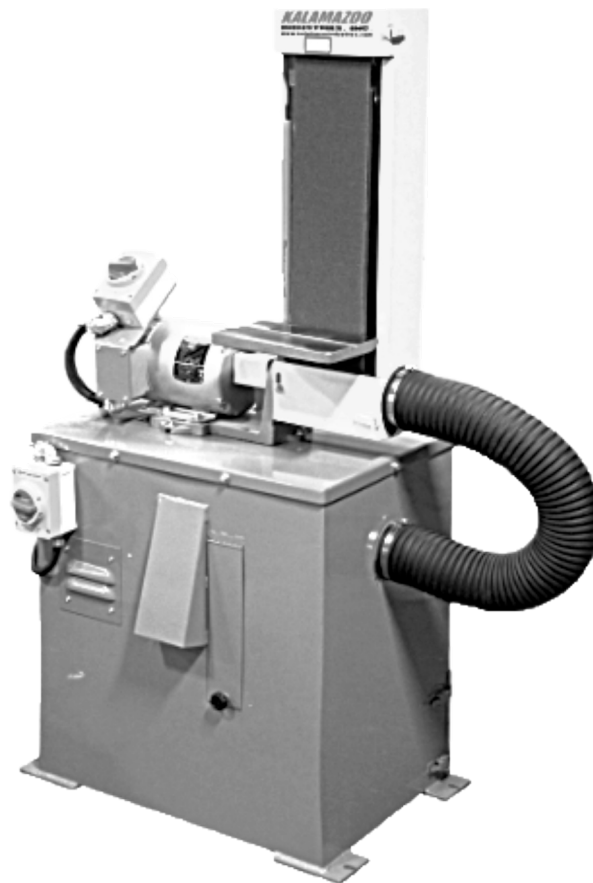


# INSTRUCTION MANUAL

## **S660MV 6" X 60" SANDER WITH VACUUM**



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

6856 East K Avenue

Kalamazoo, MI 49049

Phone: (269) 382-2050

Fax: (269) 382-0790

[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.

### **KALAMAZOO INDUSTRIES, INC.**

6856 E K AVENUE

KALAMAZOO, MI 49048

PHONE: (269) 382-2050

FAX: (269) 382-0790

WWW.KALAMAZOOIND.COM



**Kalamazoo Industries**  
**6856 East K Ave**  
**Kalamazoo, MI 49048**  
**Phone:(269) 382-2050 Fax: (269) 380-0790**  
**www.kalamazooind.com**

## **Instruction sheet for S660M AND S660MV belt sanders**

**Belt tensioning:** The 6” x 60” belt sander has a preset belt tension. The yoke assembly is spring loaded for constant belt tension. Tension lever (#29) tightens and loosens belt tension.

**Belt changing:** Open belt guard (#42) and locate the tension lever (#29) between the sander frame (#23). Pull down tension lever (#29) to compress tension spring and release belt tension. Remove and replace sanding belt. Be sure of correct belt rotation. Look inside belt for arrows showing you correct rotation. Lift tension lever (#29) to allow re-tensioning of the belt. Check tracking of belt 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.

**Belt tracking:** Tracking the sanding belt is done with the tracking knob (#35) on yoke assembly. Tightening knob (#35) raises idler spindle and the belt moves toward the motor. Loosening the tracking knob drops the idler spindle (#28) and the sanding belt moves away from the motor. When the belt is centered on the platen (#33), tighten jam nut on tracking knob to lock in belt position.

### **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.)

**Kalamazoo Industries**  
**6856 East K Ave**  
**Kalamazoo, MI 49048**  
**Phone:(269) 382-2050 Fax: (269) 380-0790**  
**www.kalamazooind.com**

### **Instructions continued**

**Sanding head position:** Sanding head can be positioned from vertical to horizontal with any angle in between. Loosen 5/16” socket head cap screws located above and below coupling (**#36**) in base (**#1**) while holding sander head firmly. Sanding head/frame is locked in position by squeezing bearing housing assembly against base. When desired position is reached, tighten 5/16” cap screws to lock in sanding head. **CAUTION: SANDING HEAD IS VERY HEAVY. SUPPORT THE SANDING HEAD WHEN LOOSING CAP SCREWS.**

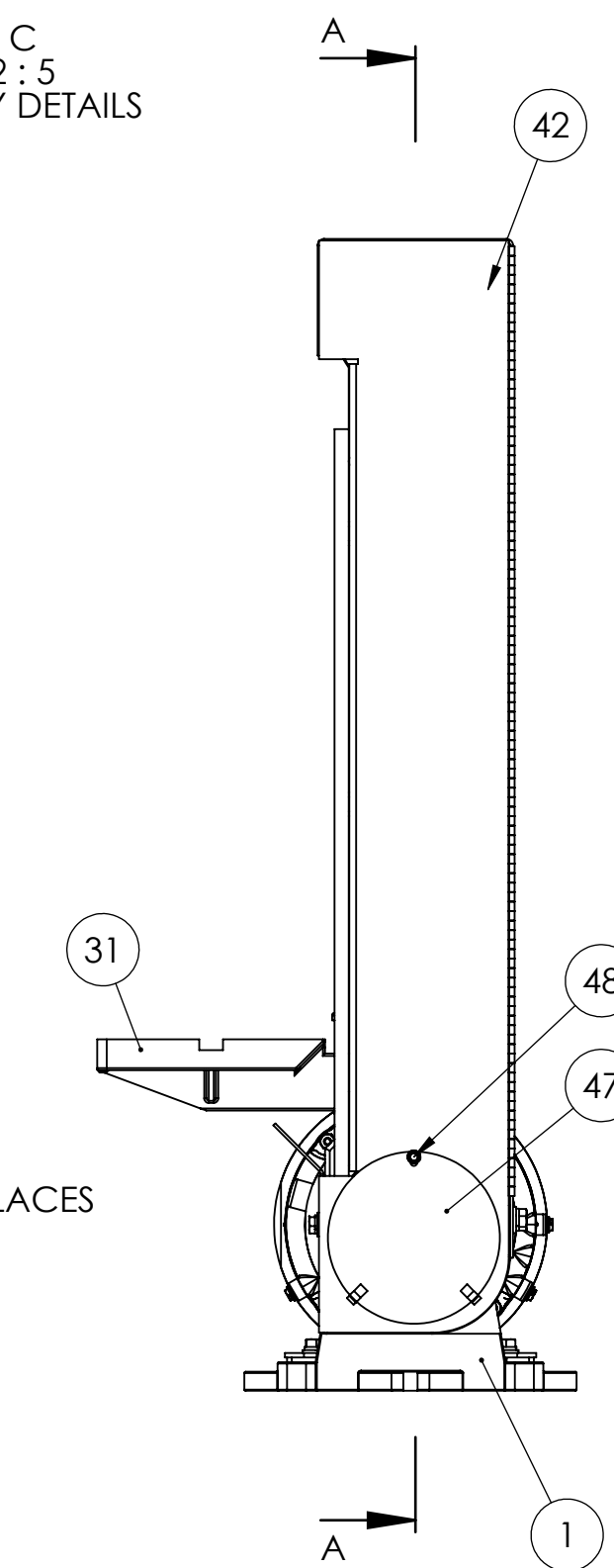
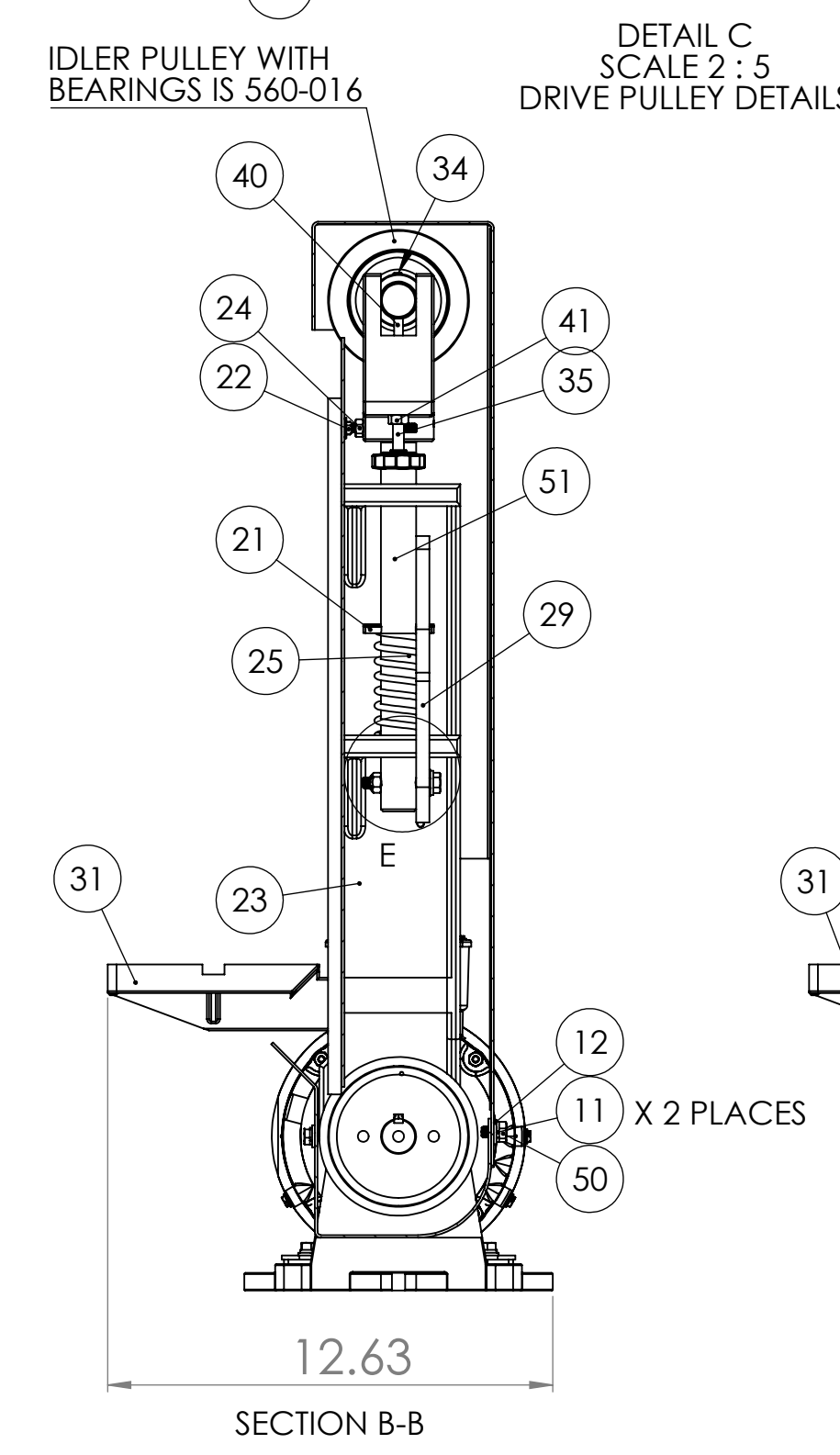
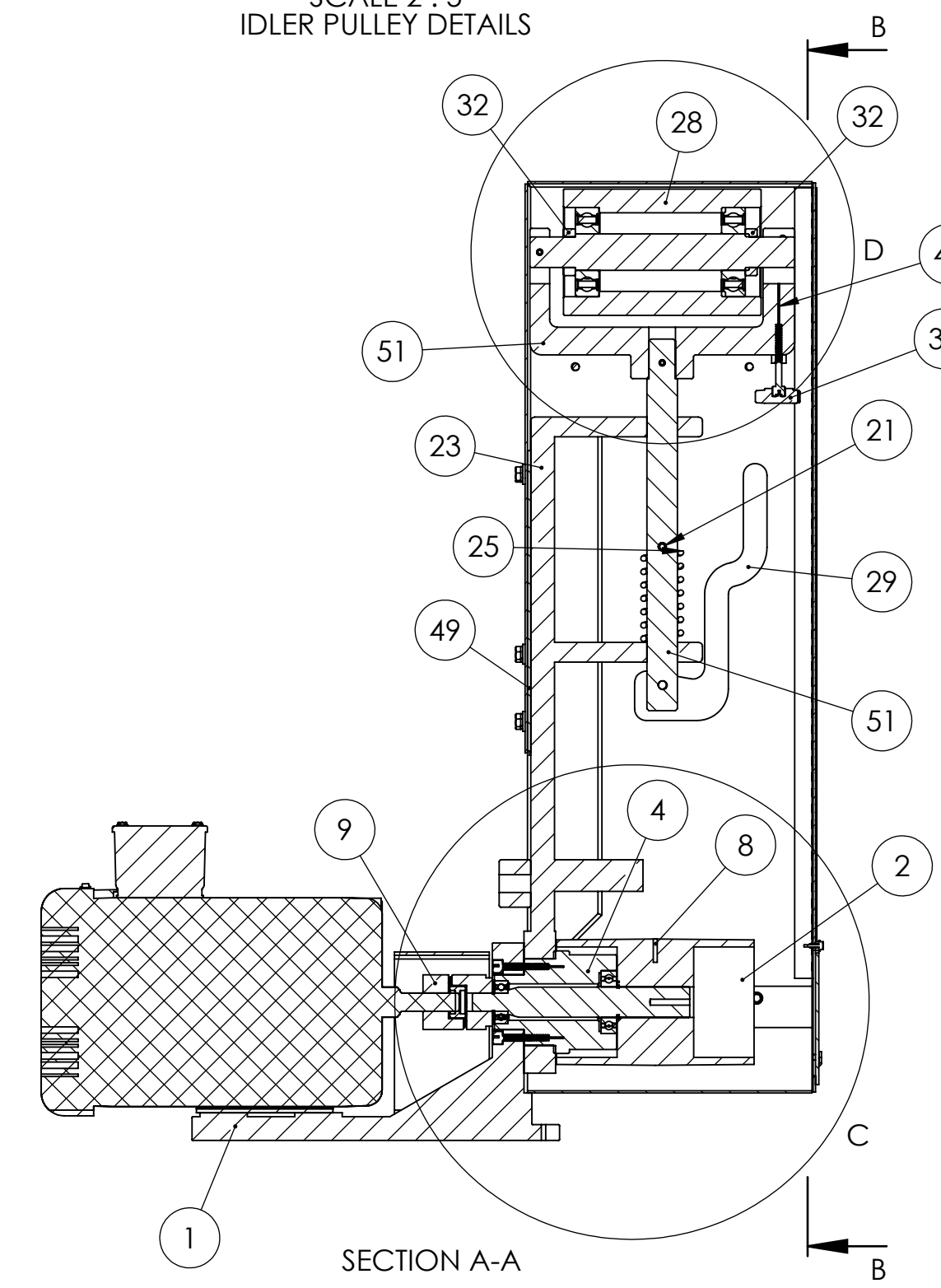
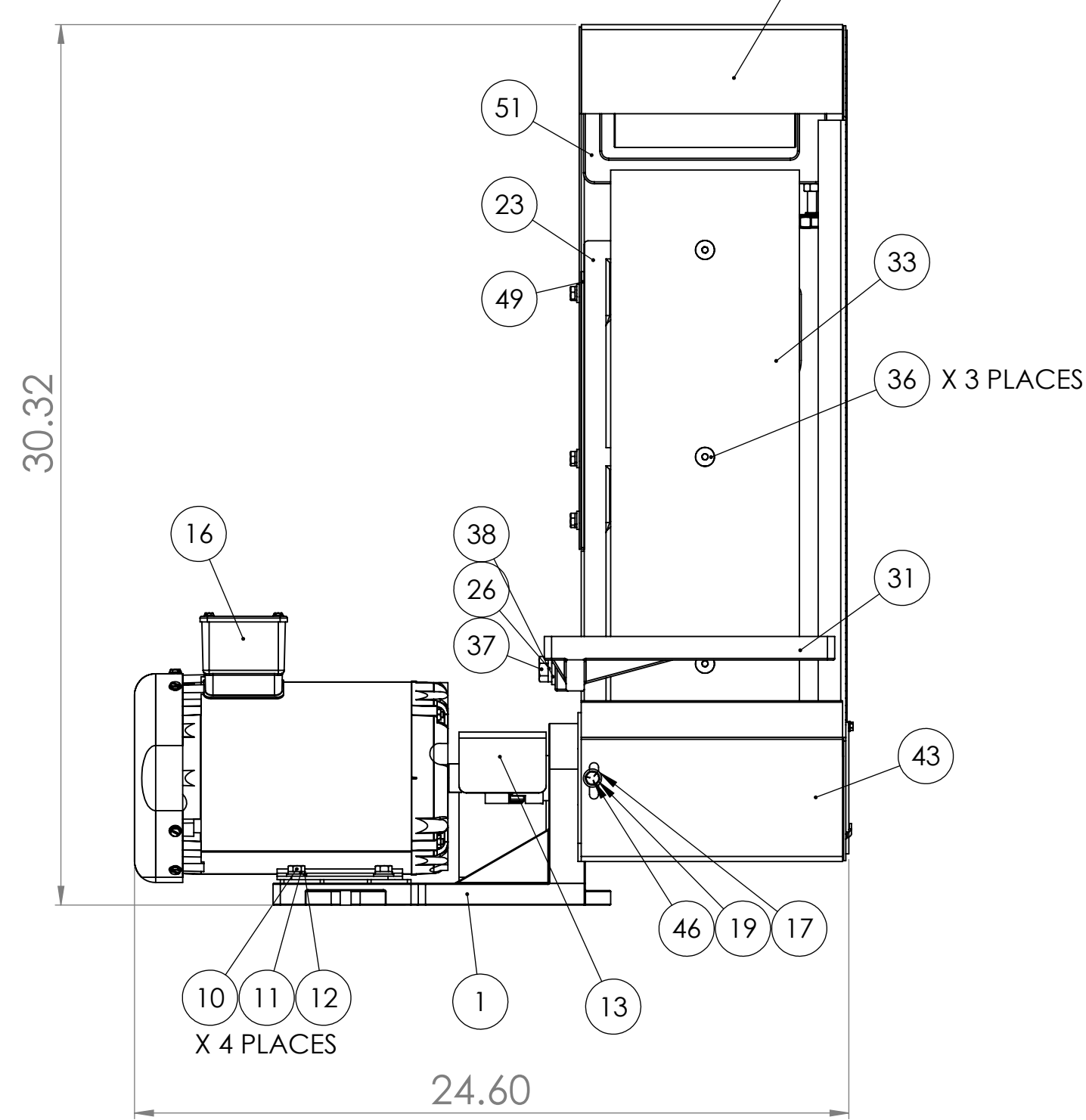
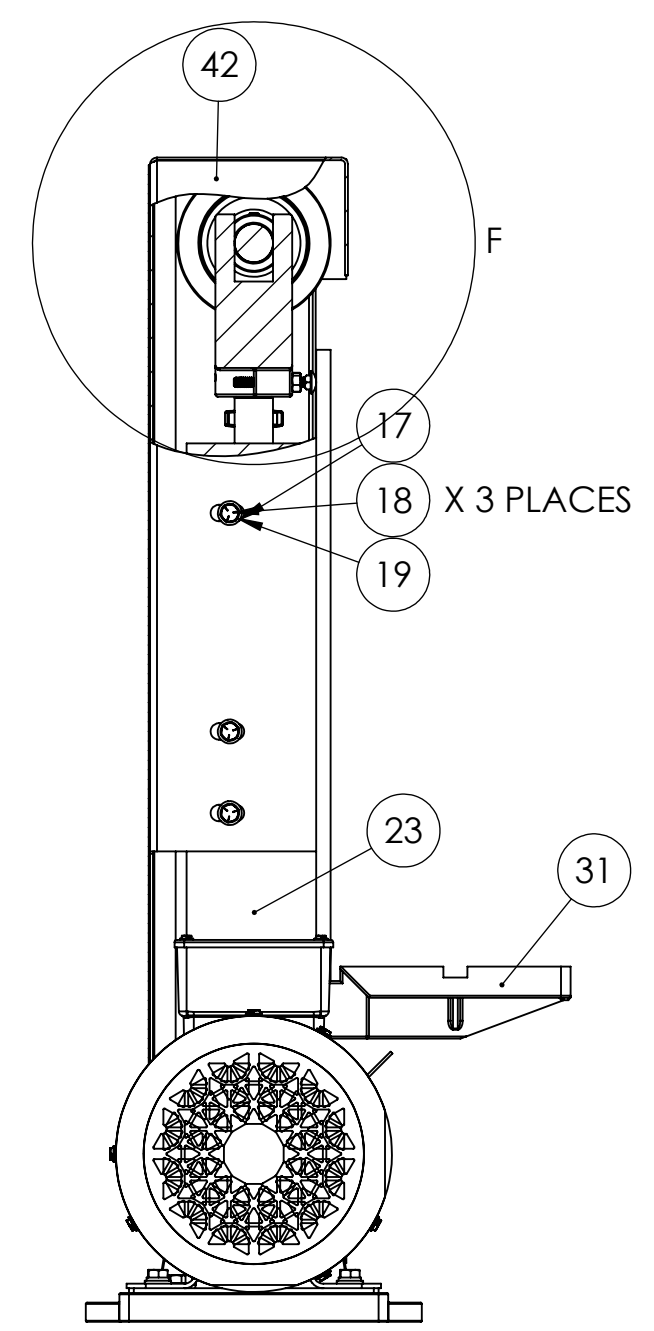
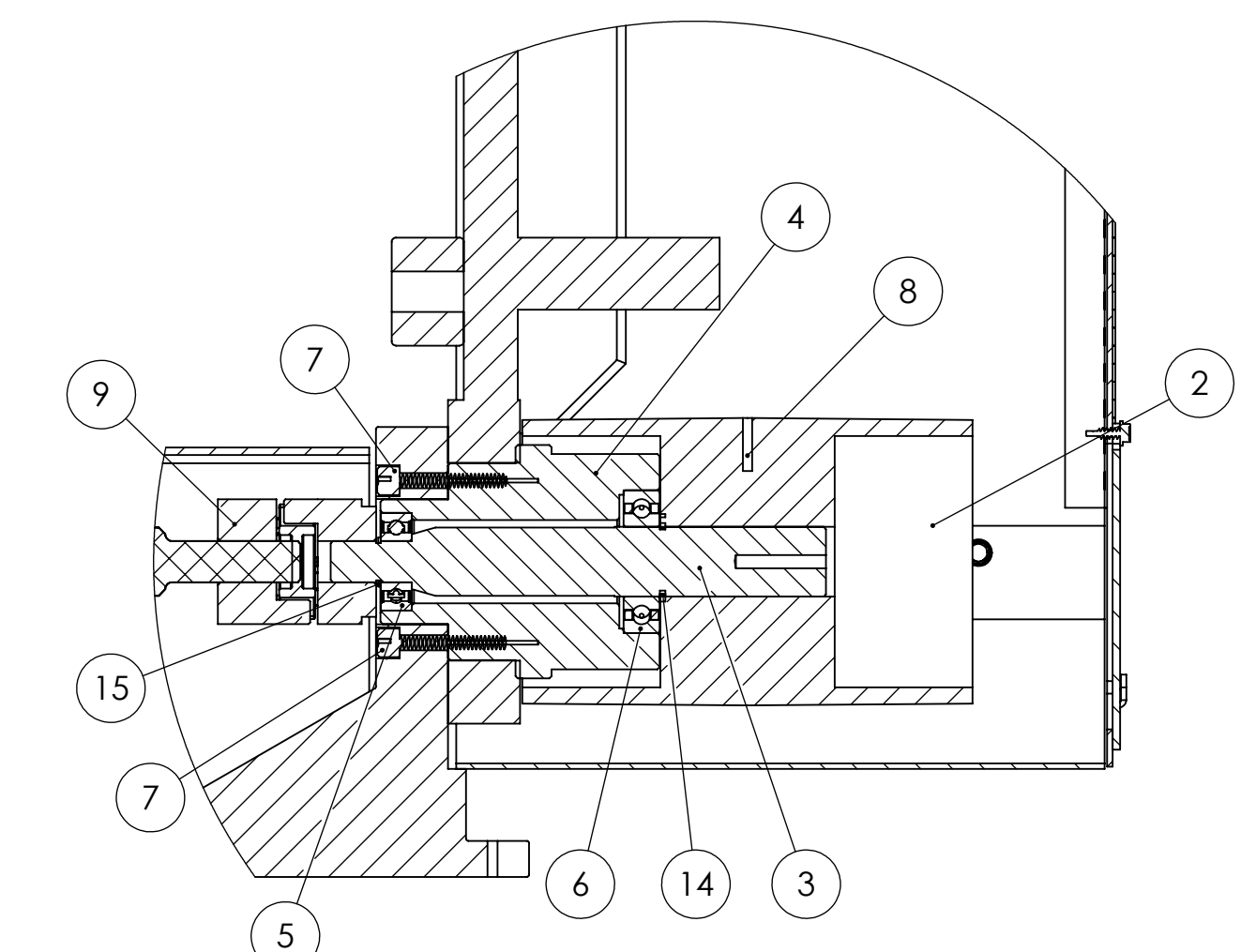
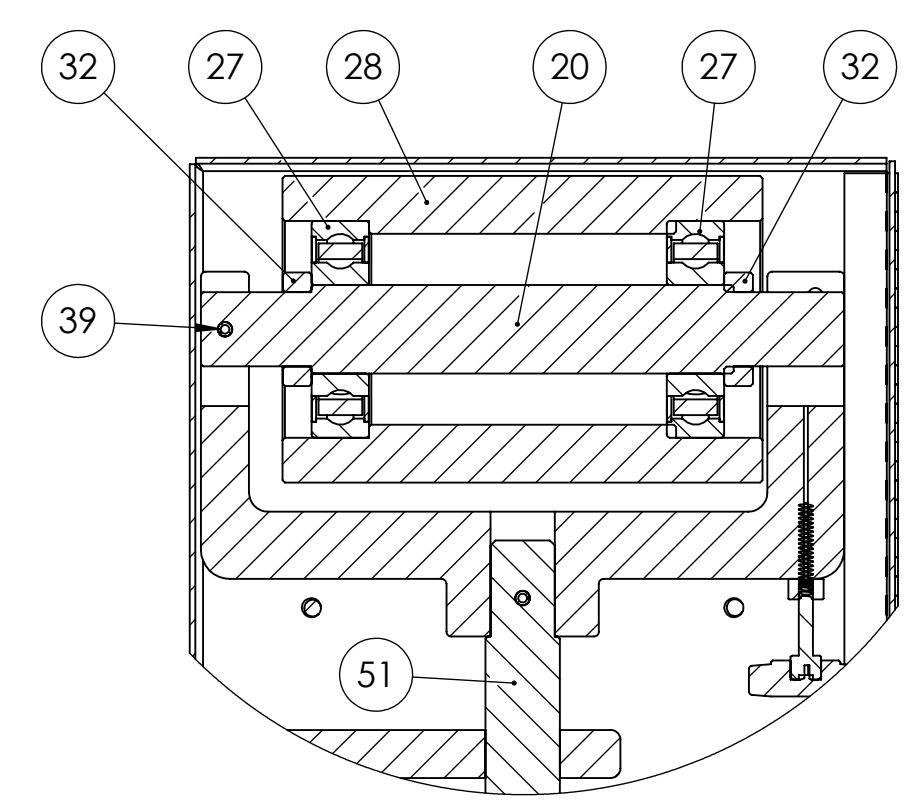
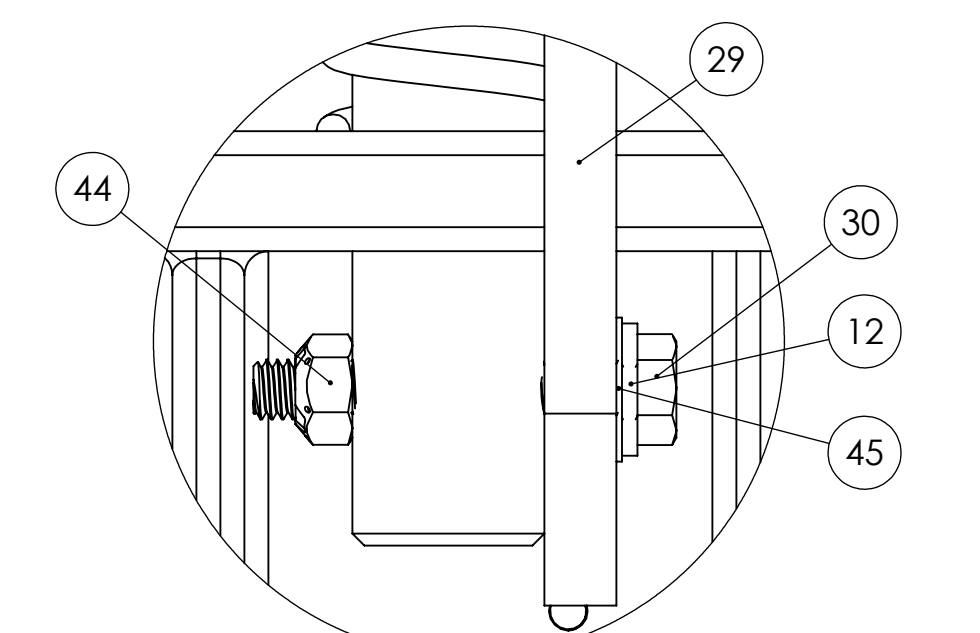
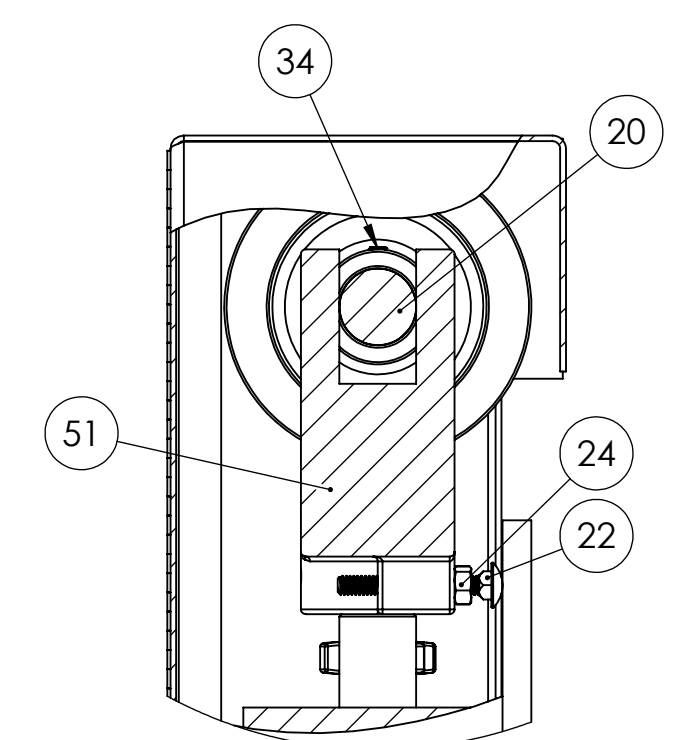
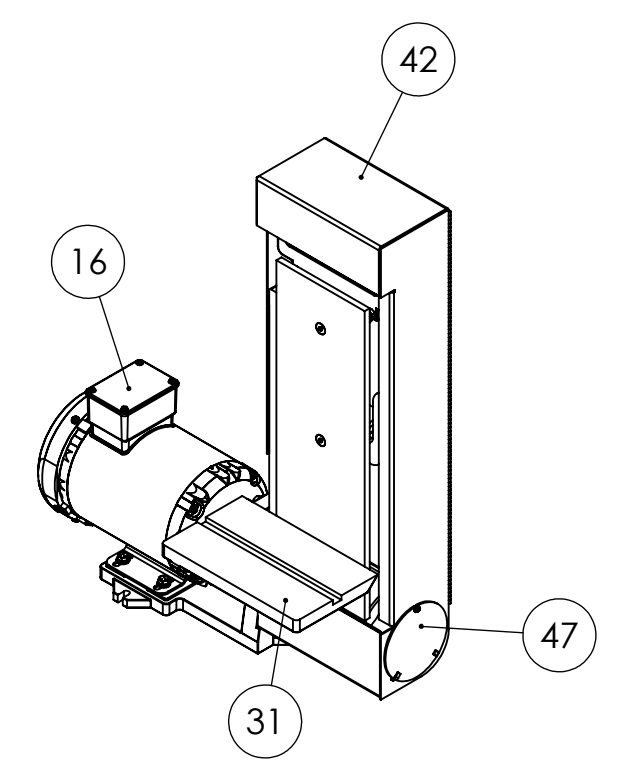
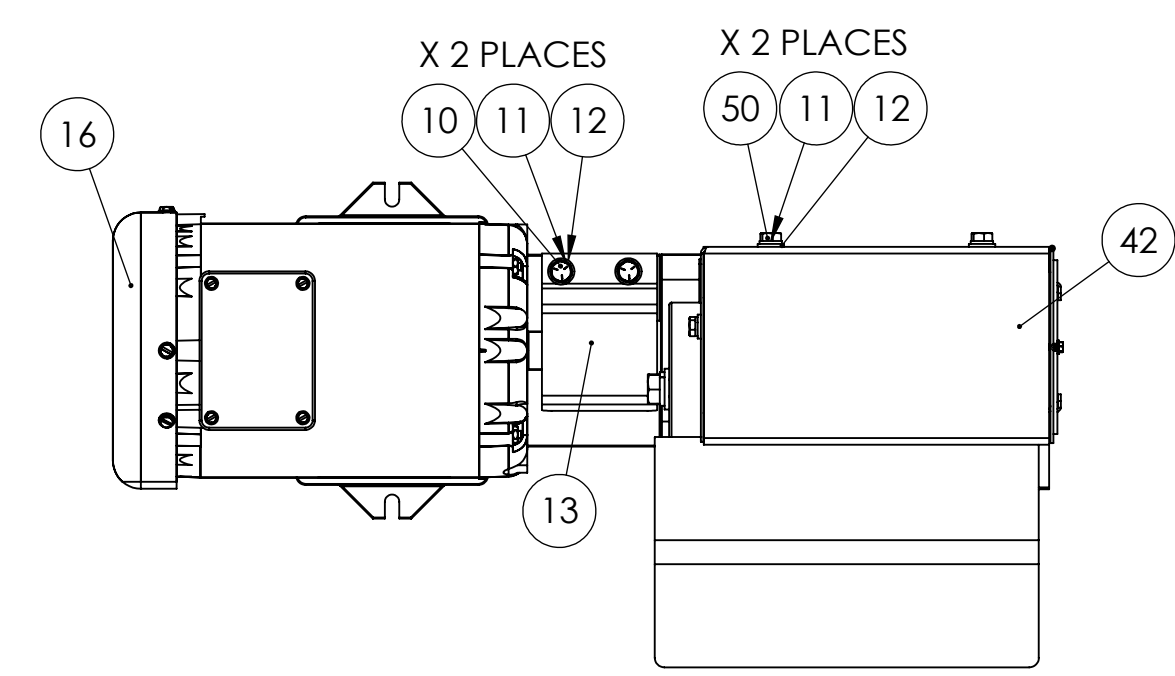
**PLATEN:** The platen is located behind sanding belt. The platen can be reversed and flipped to give four sanding areas. Normal wear will occur and platen will need to be rotated occasionally depending on usage. Remove sanding belt and platen screws (**#33**) to rotate platen to new position.

**NOTE: continuous sanding on the same side of platen will result in premature platen wear and belt breakage will occur . Move work piece to different areas of platen to extend platen and belt life.**

**Work table:** The worktable has a slot of mounting fixtures and or mitre gauge. Also, two mounting holes are provided on the side of the frame (**#23**) to move table to different work heights.

**Note: Keep work table 1/8” from sanding belt.**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	050-020	S6 BASE	1
2	560-015	S6 DRIVE PULLEY	1
3	701-018	S6 DRIVE SPINDLE	1
4	386-013	S6 BEARING HOUSING	1
5	044-007	K10 BEARING	1
6	044-001	K12 BEARING	1
7	SHCA031024	5/16-18 X 1-1/2 SHCS	2
8	SSHA025006	1/4-20 X 3/8 SOC SET 1/2 DOG	1
9	148-001	S6 COUPLING ASSEMBLY	1
10	HHC5031012	5/16-18 X 3/4 HCS GR5 Z	6
11	SLWZ031	5/16 SPLIT L/W Z	8
12	UFWZ031	5/16 USS F/W Z	9
13	342-023	S6 COUPLING GUARD	1
14	641-007	RETAINING RING 1" FOR S6, S460W, S612 DRIVE SPINDLE	1
15	641-016	RETAINING RING SHR-62 ST PA 5/8	1
16	486-007	3HP FOR K8B, K10B, KM10, BG260H, S460W, S6M AND S6T2	1
17	UFWZ025	1/4 USS F/W Z	4
18	HHC5025016	1/4-20 X 1 HHCS GR5 Z	3
19	SLWZ025	1/4 SPLIT L/W Z	4
20	701-019N	S6 IDLER SPINDLE- NEW STYLE	1
21	ROLA025024	1/4 X 1-1/2 ROLL PIN	1
22	CRBZ025032	1/4-20 X 2 CARRIAGE BOLT ZINC PLATED	2
23	291-030	CAST IRON FRAME FOR S660 DRY SANDERS	1
24	FHN5025	1/4-20 FHN GR5 Z	2
25	697-024	S6 BELT TENSION SPRING	1
26	SLWZ050	1/2 SPLIT L/W Z	1
27	044-004	K20 SPINDLE BEARING	2
28	560-016-2	S6 IDLER PULLEY- NEW STYLE	1
29	455-003A	TENSION RELEASE LEVER FOR S660 SANDER HEADS	1
30	HHT5031032	5/16-18X2 HEX HEAD TAP BOLT GR5 ZINC	1
31	829-012	S6 WORK TABLE	1
32	123-016	S6 IDLER PULLEY LOCK COLLAR	2
33	563-023	PLATEN FOR S660 SERIES SANDERS	1
34	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	2
35	441-014	TRACKING KNOB ASSEMBLY	1
36	FSCA031012	5/16-18 X 3/4 FSHCS	3
37	HHC5050032	1/2-13 X 2 HHCS GR5 Z	1
38	SFWZ050	1/2 SAE F/W Z	1
39	ROLA018032	3/16 X 2 ROLL PIN	1
40	DOWA025032	1/4 X 2 DOWEL PIN	1
41	FHN5031	5/16-18 FHN GR5 ZINC	1
42	342-085	S660 GUARD, FULL BOXED OSHA, FOR S660M, S660MW SANDERS	1
43	342-069-E	S6 BELT GUARD BOTTOM PLATE	1
44	STNZ031	5/16-18 STOVER LOCK NUT ZINC-WAX	1
45	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
46	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	1
47	342-069C	BLANK COVER FOR S6M SANDER OSHA GUARD	1
48	HWTZ008008	#8 X 1/2 HWH TEKS Z	1
49	699-050	S660 SERIES OSHA GUARD TO FRAME SPACER	1
50	HHC5031008	5/16-18 X 1/2 HHCS GR5 Z	2
51	960-006YA	YOKE WITH TENSION SHAFT FOR S6 SANDERS	1

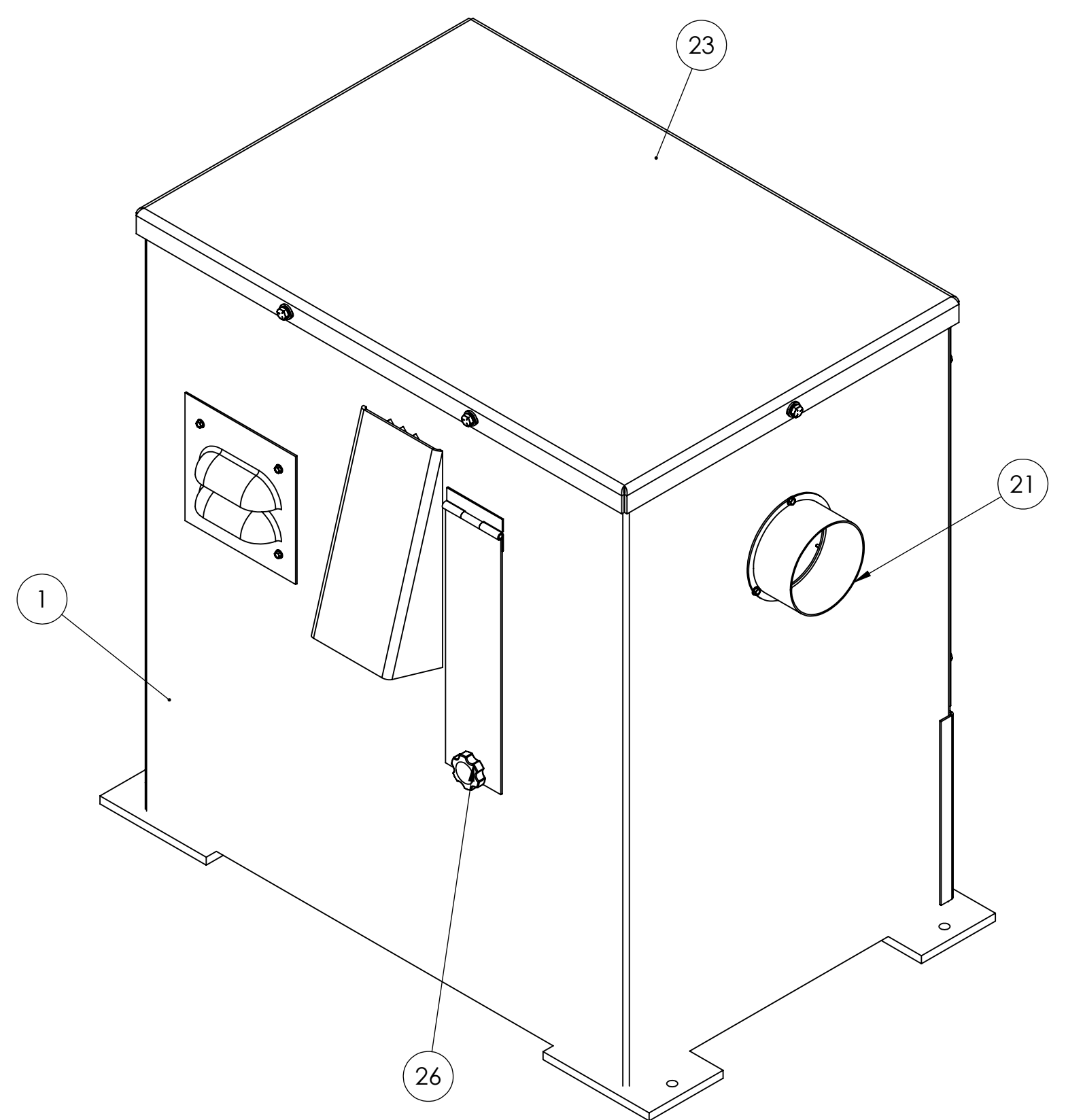
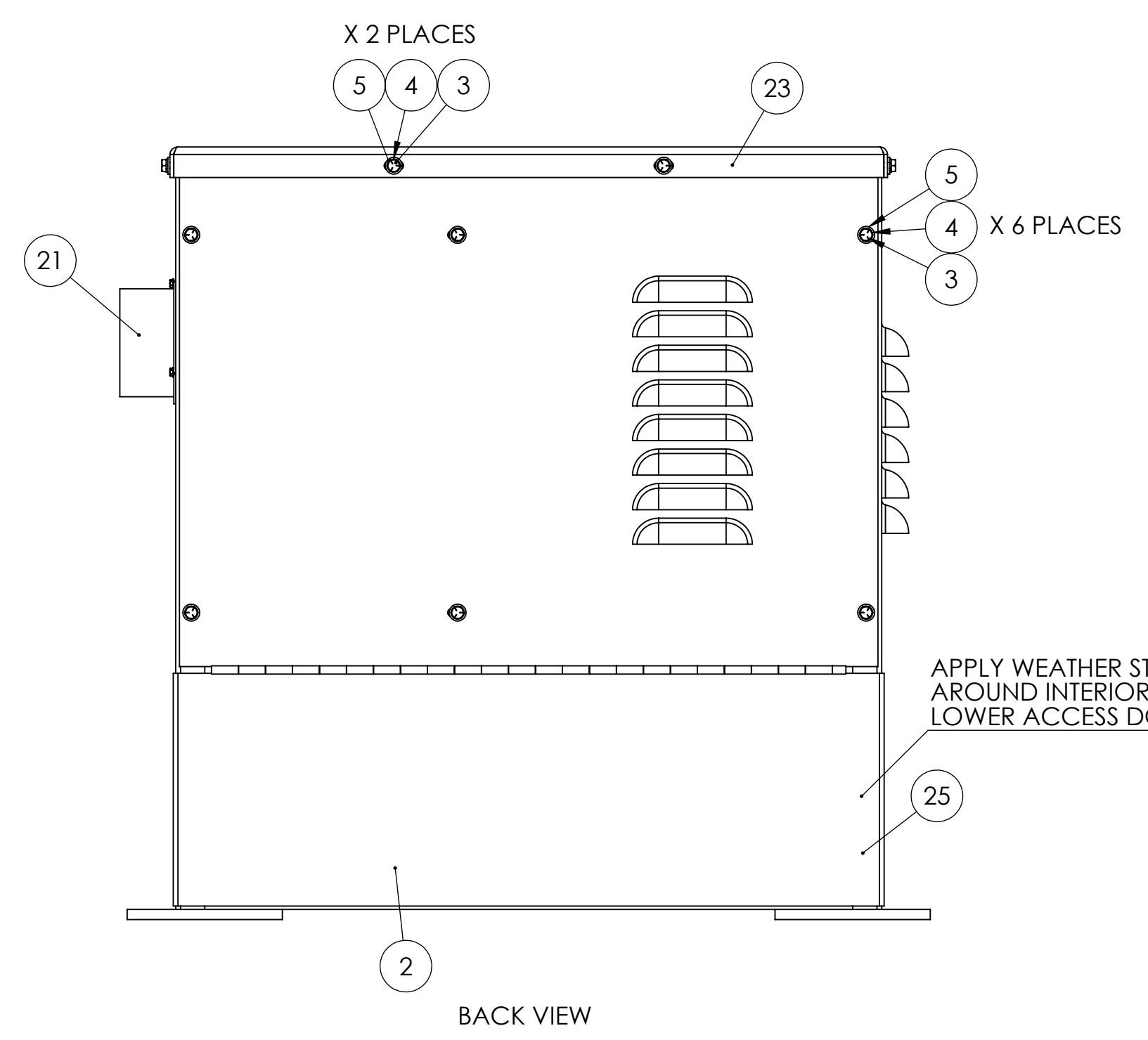


PROPRIETARY AND CONFIDENTIAL  
 THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF KALAMAZOO INDUSTRIES, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF KALAMAZOO INDUSTRIES, INC. IS PROHIBITED.

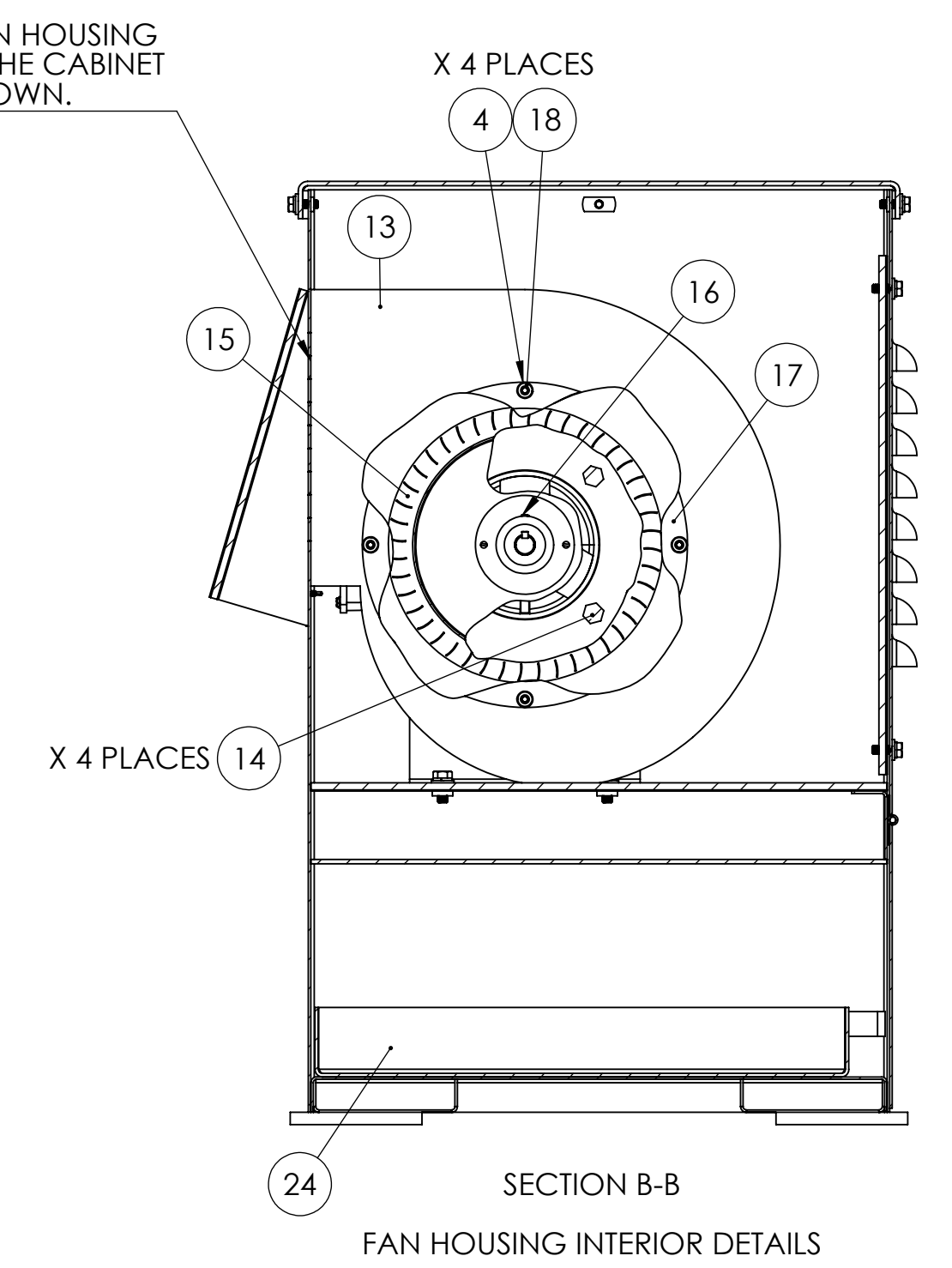
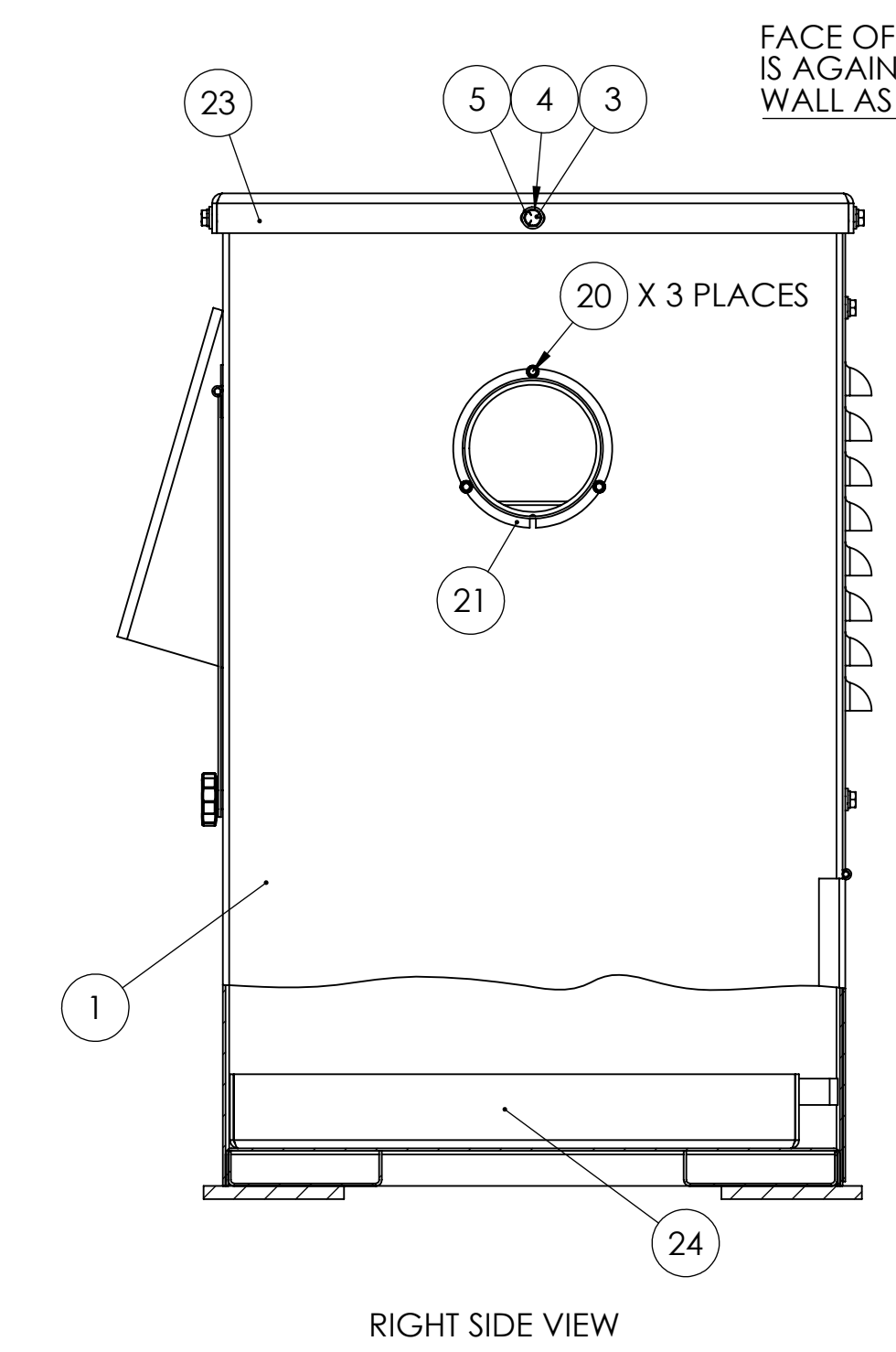
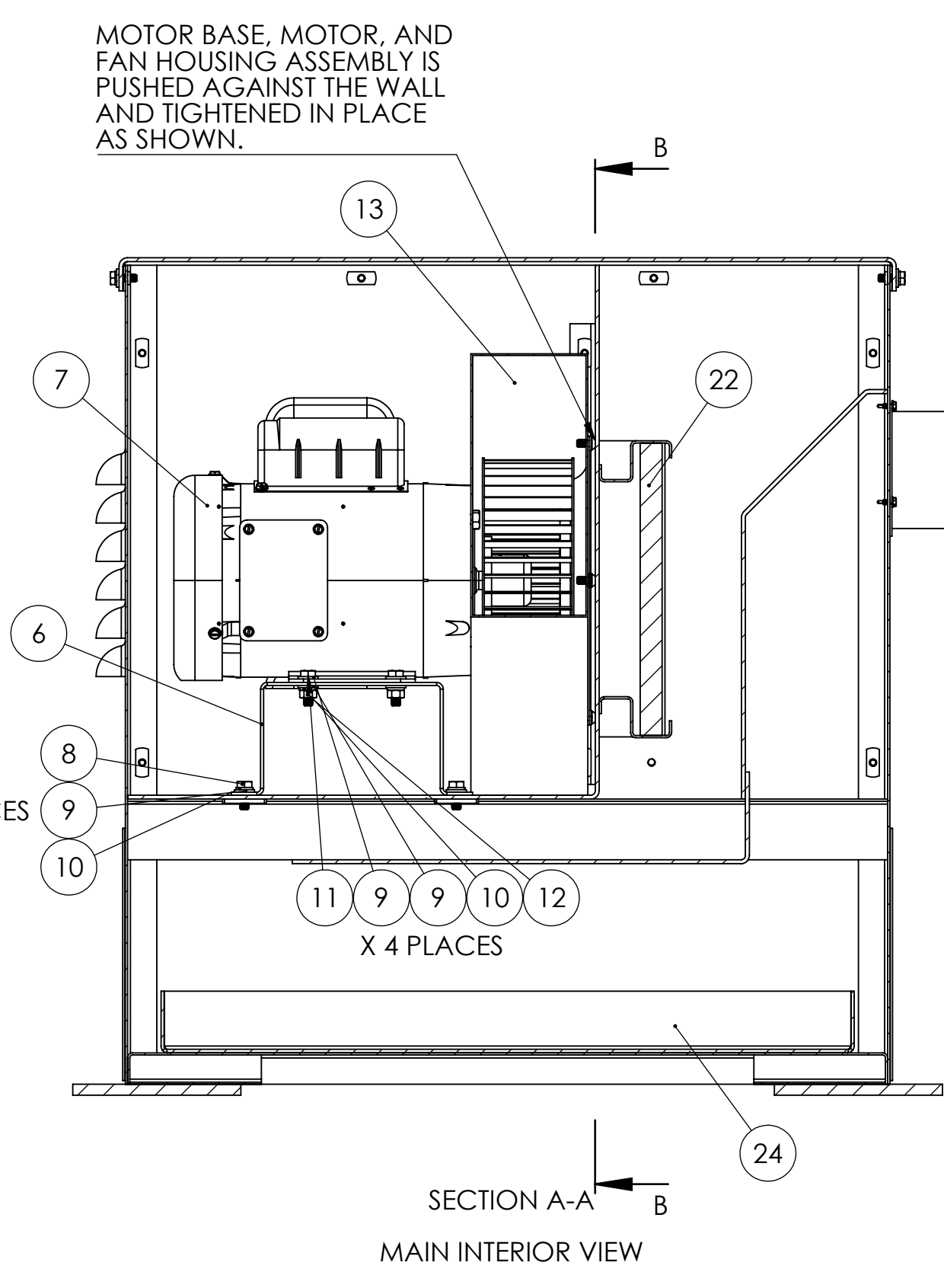
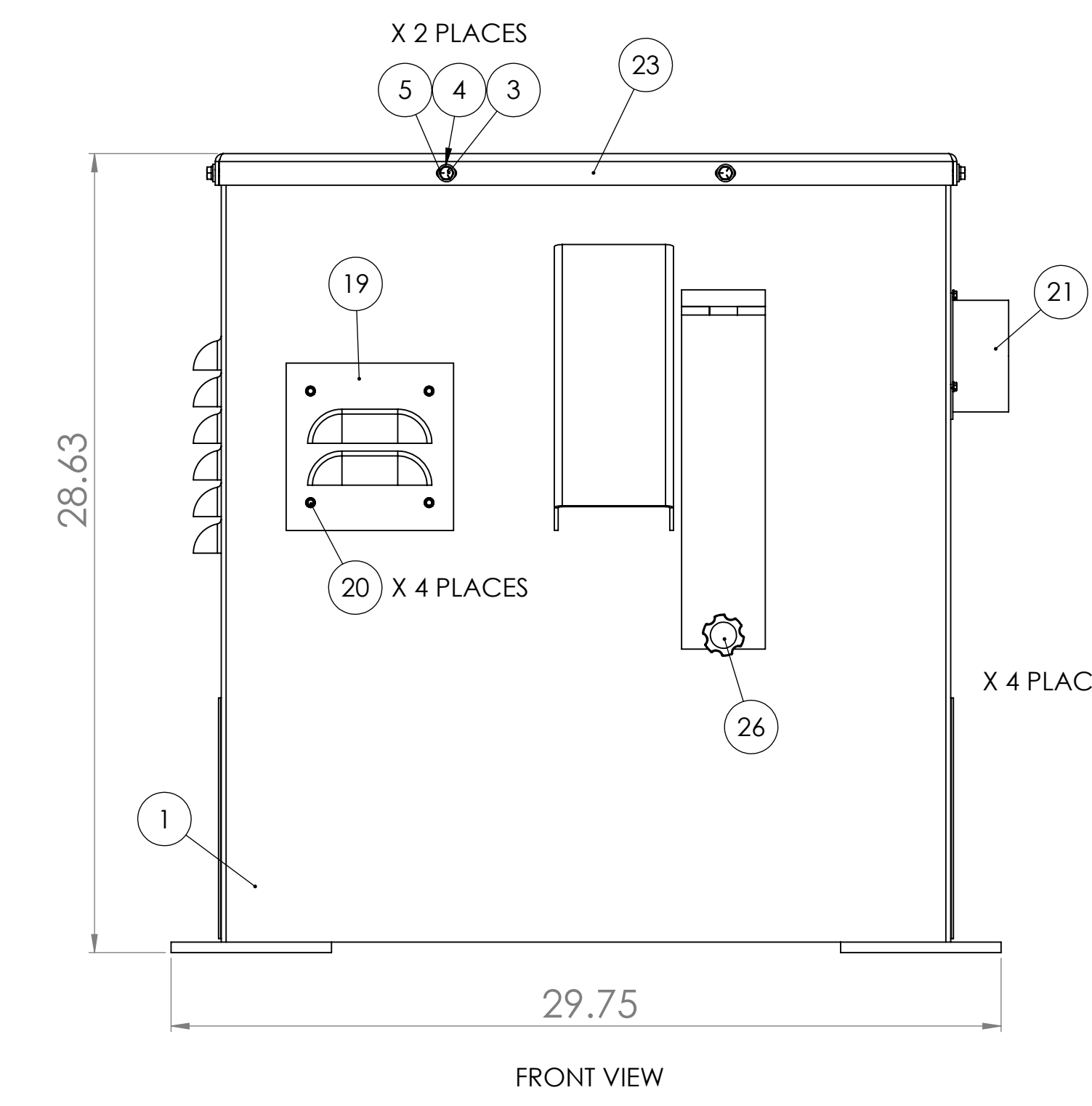
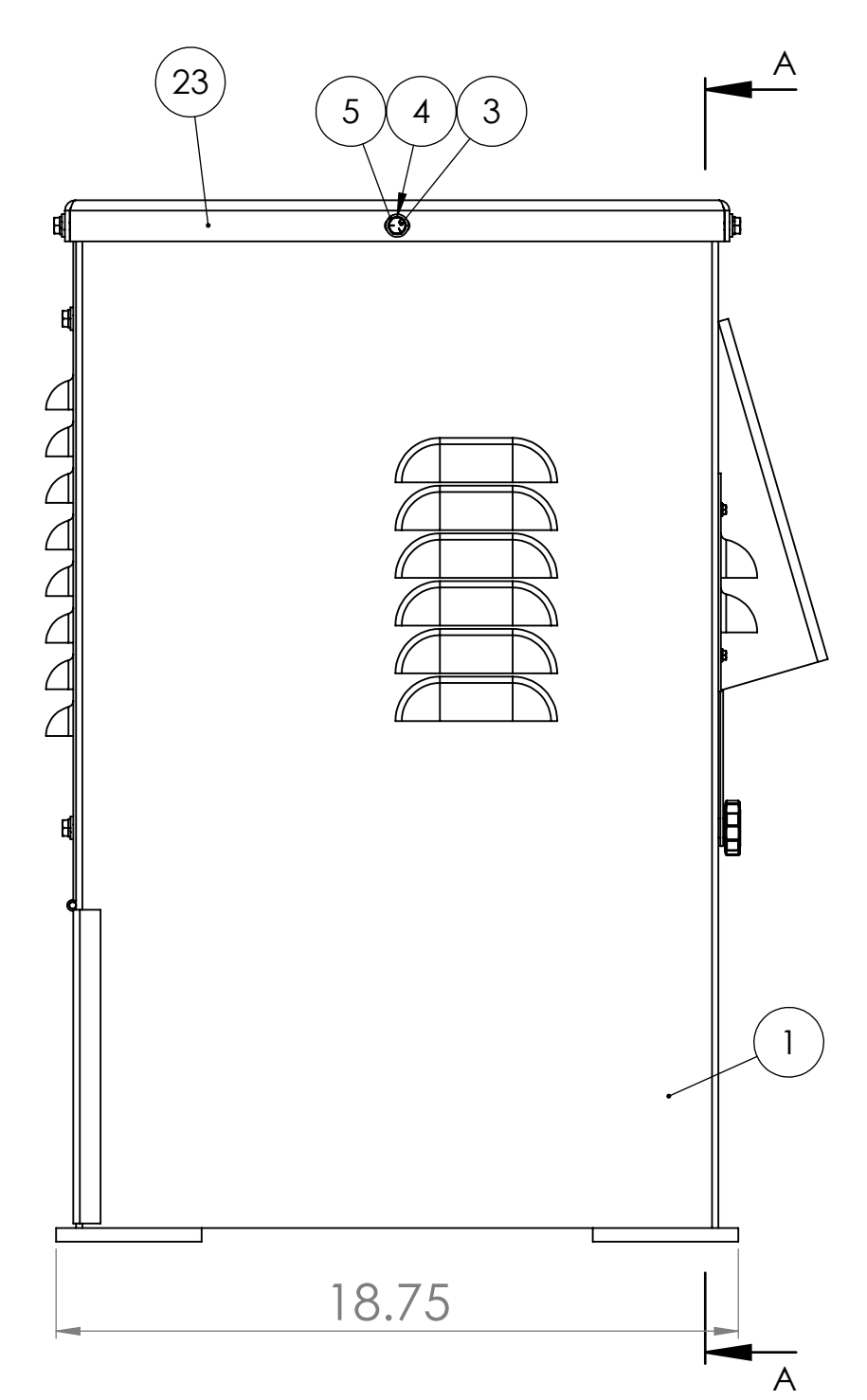
UNLESS OTHERWISE SPECIFIED:	DRAWN	NAME	DATE
DIMENSIONS ARE IN INCHES	CHECKED		
FRACTIONAL ±	ENG APPR.		
ANGULAR ±	MFG APPR.		
TWO PLACE DECIMAL ±			
THREE PLACE DECIMAL ±			
INTERPRET GEOMETRIC TOLERANCING PER:			
MATERIAL			
FINISH			
APPLICATION			
DO NOT SCALE DRAWING			

TITLE:	<b>S660M BELT SANDER ASSEMBLY</b>
SIZE DWG. NO.	D S660M
SCALE: 1:5 WEIGHT:	SHEET 1 OF 1



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



PROPRIETARY AND CONFIDENTIAL  
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF KALAMAZOO INDUSTRIES, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF KALAMAZOO INDUSTRIES, INC. IS PROHIBITED.

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