

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

PH: (269) 382-2050

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

**S6MV BELT SANDER  
AND DUST COLLECTOR  
MANUAL**



MADE IN USA



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### **WARRANTY**

All products are guaranteed for a period of one year from receipt of order to the original purchaser, against defects in material workmanship under normal use. Electric motors are warranted by the motor manufacturer for a period of one year and will be repaired by the nearest motor repair station. If non-repairable, they will be replaced by Kalamazoo Industries. Please call for instructions (269) 382-2050.

### **RETURN POLICY**

Authorization must be obtained before returning merchandise. Please call our customer service department for a return authorization number (269) 382-2050. Please include with your return a copy of your invoice of packing slip. All material must be new and unused in the original packaging. Material must be sent back prepaid (unless otherwise indicated) by Kalamazoo Industries. Credit upon inspection at Kalamazoo Industries. All returns will be subject to a 10% restock charge. Used merchandise is non-returnable. 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.
- NEAR WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.
- ALWAYS KEEP HAIR TIED BACK OR COVERED.
- LET MACHINE ROTATION COME TO A FULL STOP BEFORE CHANGING BELT.
- KEEP SAFETY GUARDS IN PLACE. DO NOT ALTER GUARD OR MACHINE IN ANYWAY. ANY ALTERATIONS TO GUARDS OR MACHINE COULD CAUSE SERIOUS INJURY.
- ALL BELT SANDERS SHOULD BE OPERATED IN A WELL-VENTILATED AREA. THE DUST CREATED WHEN SOME MATERIALS ARE SANDED CAN BE HARMFUL. DUST MASKS ARE RECOMMEND AS A PRACTICAL MEAN OF MINIMIZING DUST INHALATION. FUMES FROM OTHER OTHER SOURCES CAN ALSO CAUSES FIRES WHEN INTACT WITH SANDING SPARK.
- SPARKS CREATED BY SANDING SHOULD BE DIRECTED DOWNWARD AND AWAY FROM THE FACE AND BODY. DON NOT GRIND NEAR FLAMMABLE MATERIAL.
- ELECTRIC 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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## **WARNING!**

TO REDUCE THE RISK OF FIRE OR SHOCK HAZARD,  
DO NOT EXPOSE THIS EQUIPMENT TO RAIN, ANY LIQUID OR MOISTURE.

## **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 filled with the delivering **TRANSPORTATION COMPANY. PLEASE DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS.**

**NOTE: SEE NEXT PAGE FOR RETURN POLICY AND WARRANTY.**

## **IMPORTANT**

Read Operating Instructions before using equipment.

## **OPERATING INSTRUCTIONS**

1. Abrasive belt rotation is counter-clockwise. If the abrasive belt is lap spliced be sure of the correct belt rotation. Butt spliced belts bi-directional.
2. Belt tension is pre-set with internal spring (9). No belt tension adjustment is required. The yoke assembly is spring loaded for constant belt tension. The tension lever (10) tightens and loosens belt tension.
3. To change belt **disconnect power**: open belt guard (43) and locate the tension lever (10) between the sander frame (7). Pull down tension lever (10) 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 (10) to allow re-tensioning of belt. Check tracking of belt short on/off 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.
4. Belt tracking: tracking the sanding belt is done with the tracking knob (22) on yoke assembly. Tightening knob (22) raises idler spindle and the belt moves toward the motor. Loosening the tracking knob drops the idler spindle (17) and the sanding belt moves away from the motor. When the belt is centered on the platen (16), 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.)

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**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 (28) 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 (23) to rotate platen to new position.

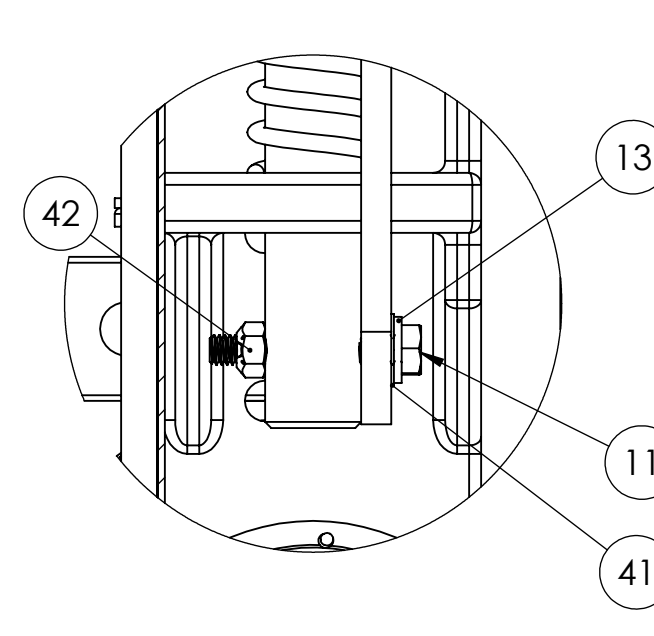
**NOTE: CONTINUOUS SANDING ON THE SAME SIDE OF PLATEN WILL RESULT IN PREMATURE PLATEN WEAR AND BELT BREAKAGE WILL OCCUR. MOVE WORK PIECE TO DIFFERENT AREAS OF PLATEN TO EXTEND PLATEN AND BELT LIFE.**

Worktable: the worktable has a slot for mounting fixtures and or a mitre gauge. Also, two mounting holes are provided on the side of the frame (7) to move the work table to different work heights

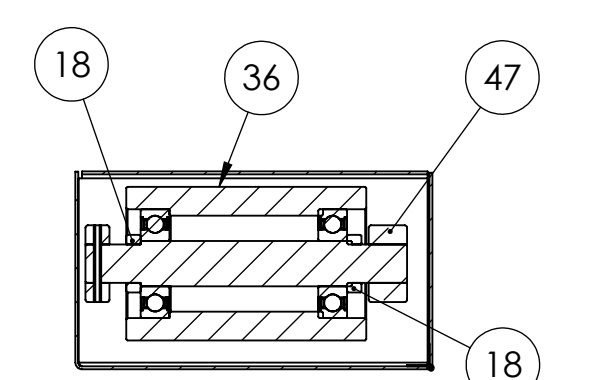
**NOTE: KEEP THE WORK TABLE WITH A 1/8TH GAP BETWEEN THE TABLE AND THE SANDING BELT.**

**DUST COLLECTOR**

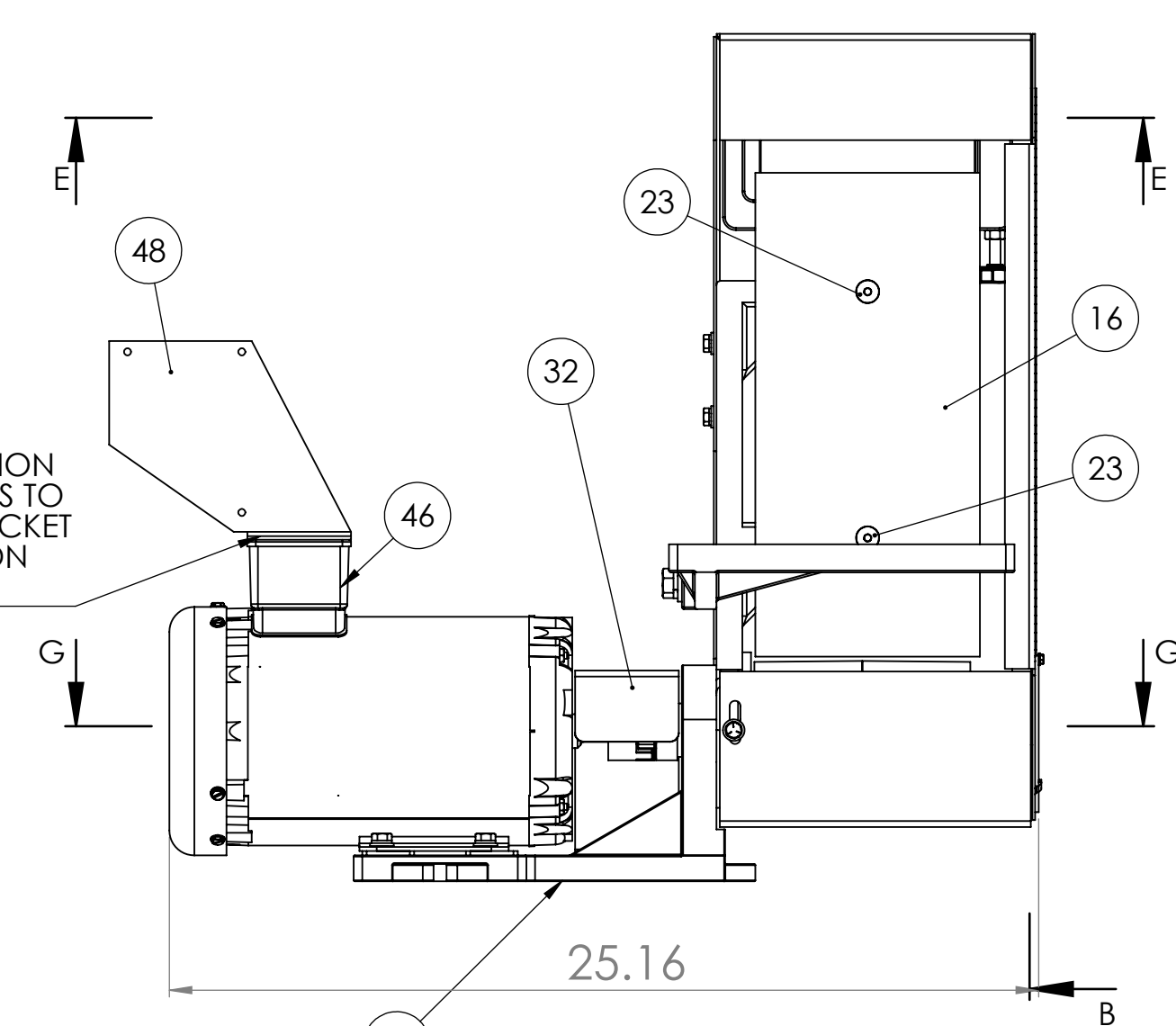
Clean out dust collector after every shift and don't mix materials.



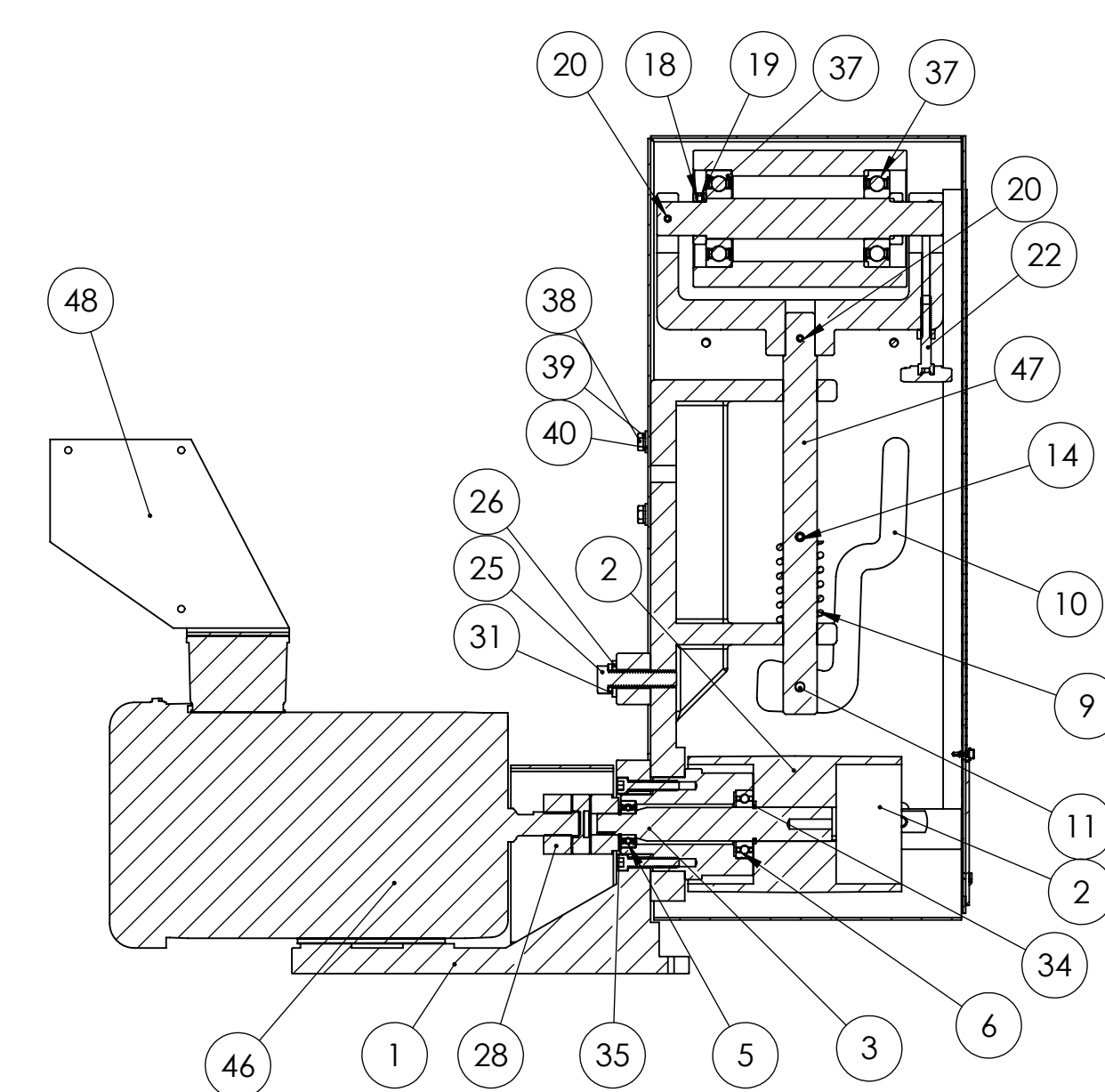
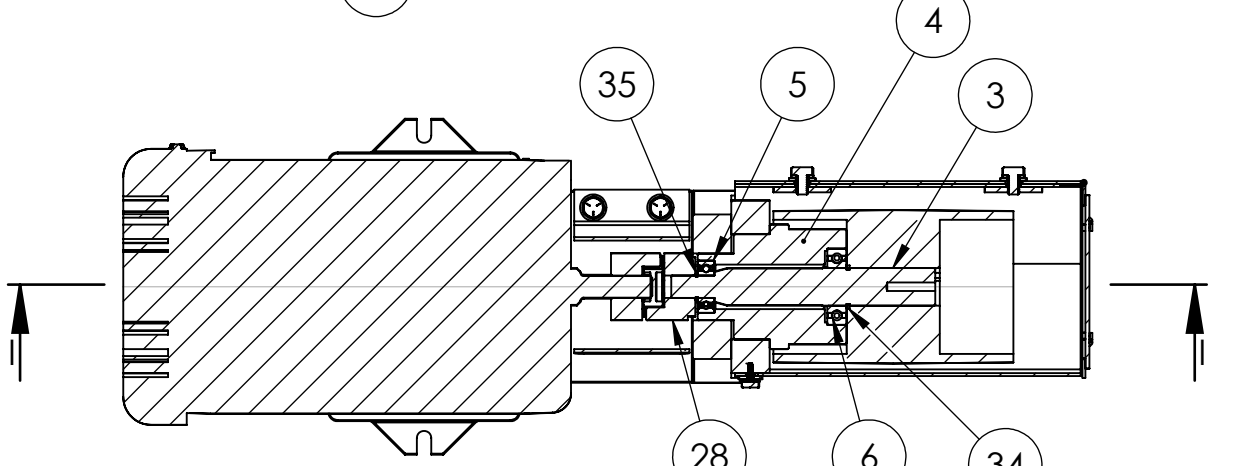
DETAIL D  
SCALE 1 : 2



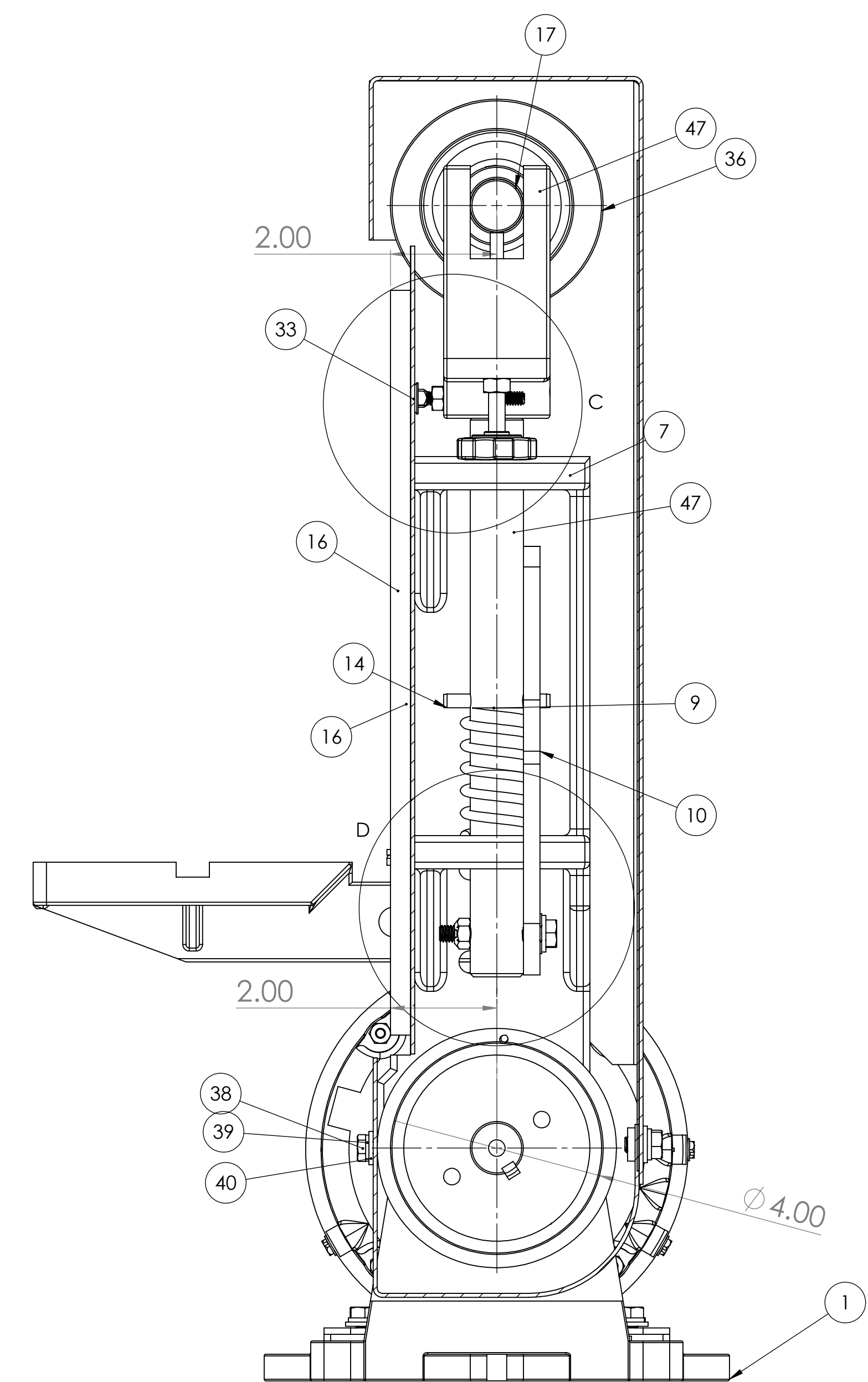
SECTION E-E



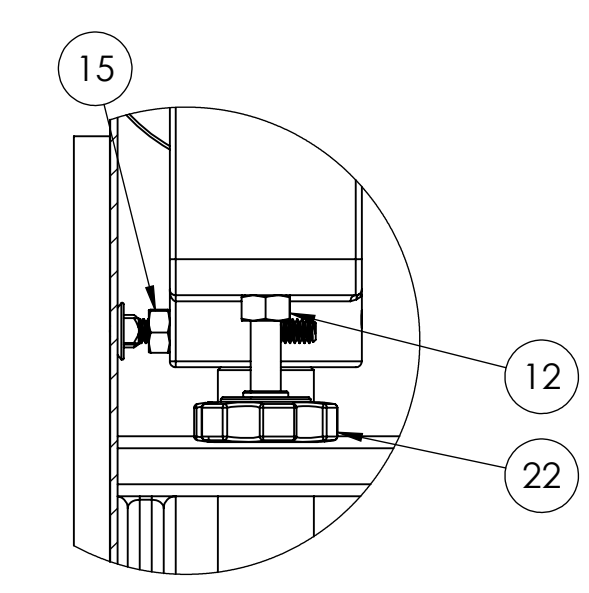
SECTION G-G



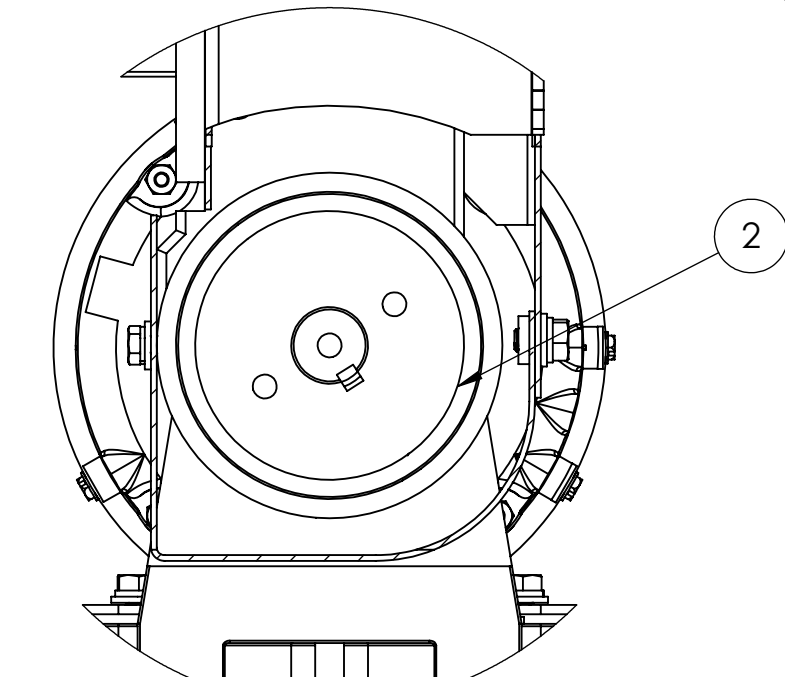
SECTION H



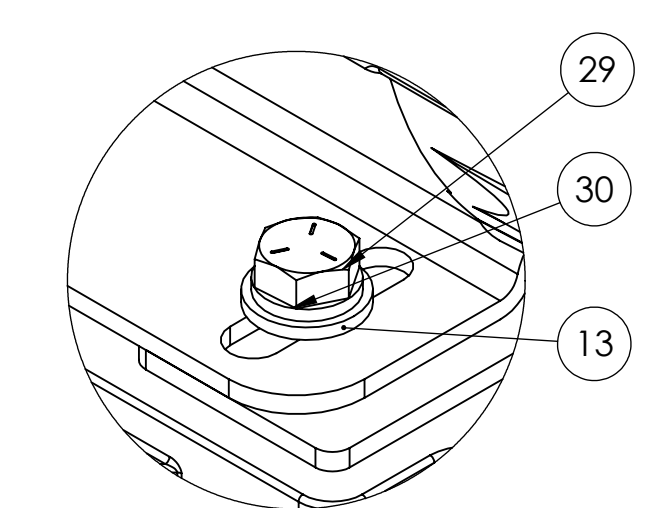
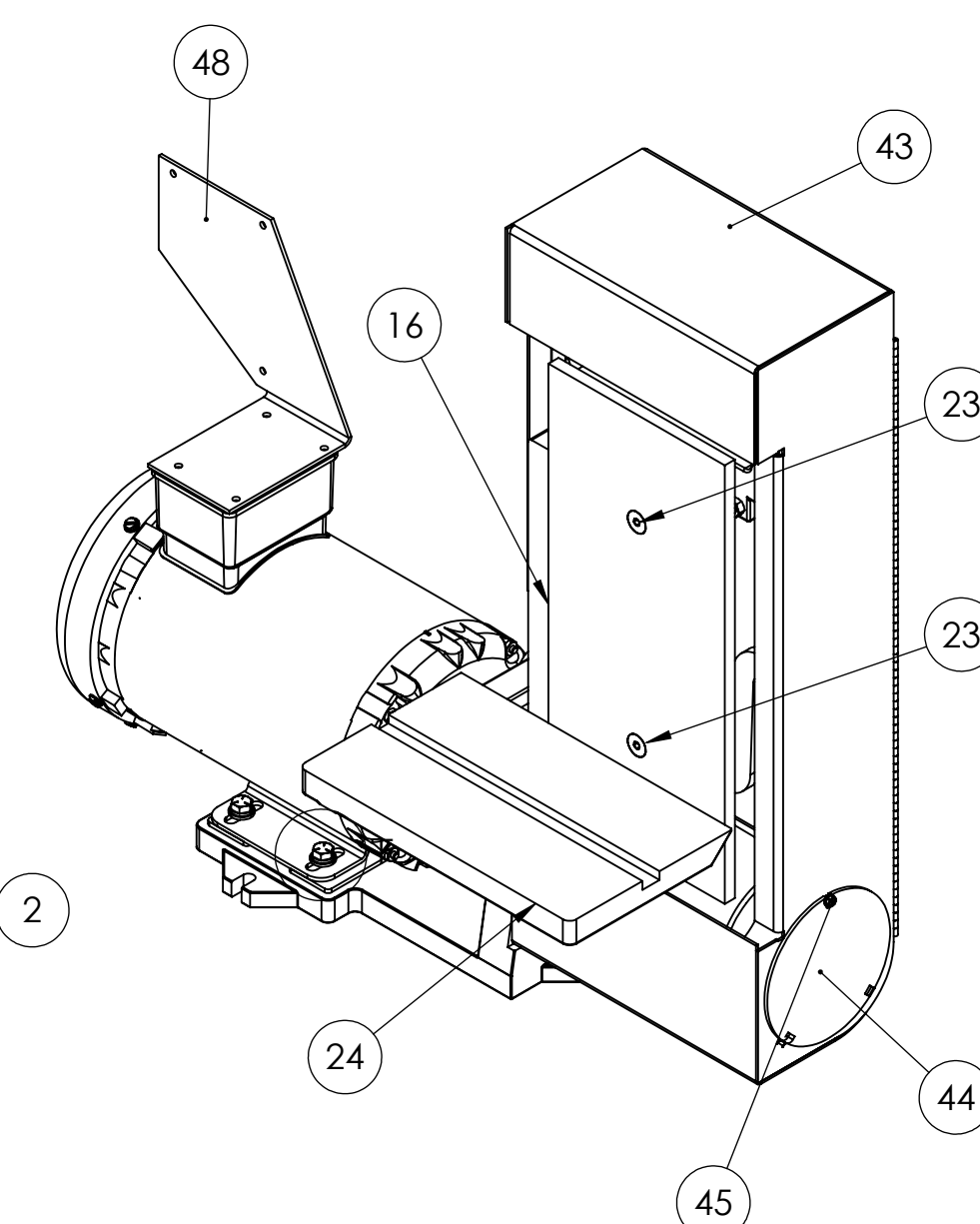
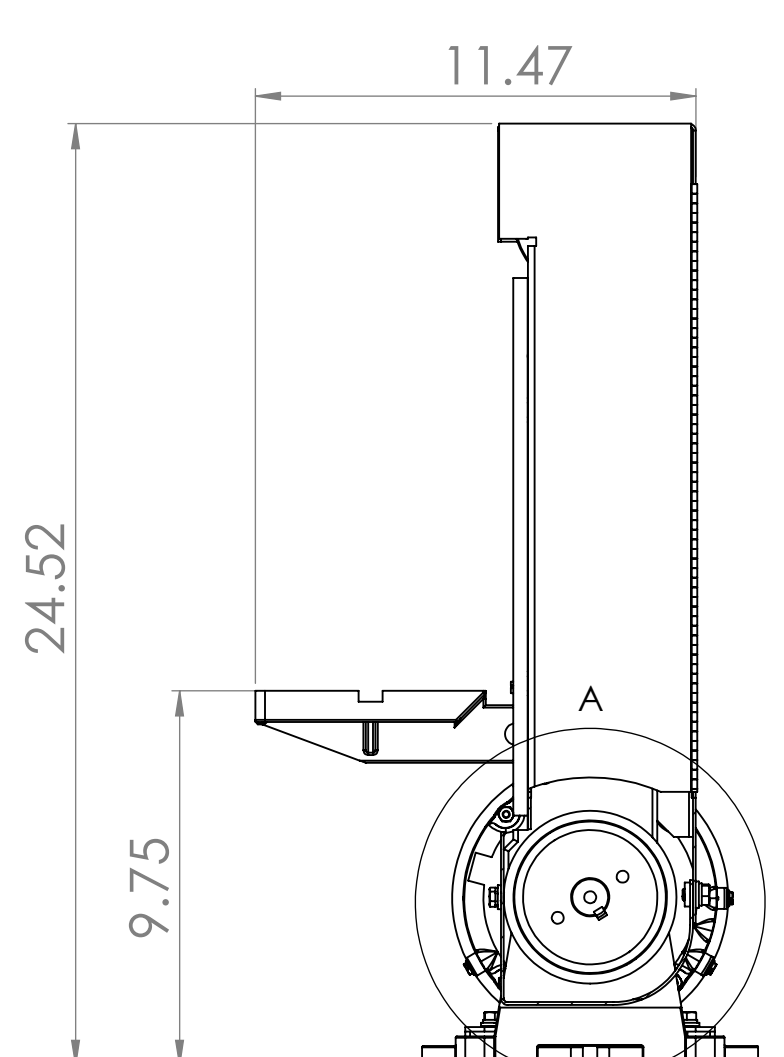
SECTION B-B  
SCALE 1 : 2



DETAIL C  
SCALE 1 : 2



DETAIL A  
SCALE 2 : 5



DETAIL F  
SCALE 1 : 1

| 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        | 291-004     | CAST IRON FRAME FOR S6M, S612 SANDERS                      | 1    |
| 8        | SHCA031024  | 5/16-18 X 1-1/2 SHCS                                       | 2    |
| 9        | 697-024     | S6 BELT TENSION SPRING                                     | 1    |
| 10       | 455-003     | TENSION RELEASE LEVER FOR S6 SANDER HEADS                  | 1    |
| 11       | HHT5031032  | 5/16-18x2 HEX HEAD TAP BOLT GR5 ZINC                       | 1    |
| 12       | FHN5031     | 5/16-18 FHN GR5 ZINC                                       | 1    |
| 13       | UFWZ031     | 5/16 USS F/W Z   | 7    |
| 14       | ROLA025024  | 1/4 X 1-1/2 ROLL PIN                                       | 1    |
| 15       | FHN5025     | 1/4-20 FHN GR5 Z   | 2    |
| 16       | 563-002     | S6 BELT PLATEN   | 1    |
| 17       |             | S6 IDLER SPINDLE- NEW STYLE                                | 1    |
| 18       |             | S6 IDLER PULLEY LOCK COLLAR                                | 2    |
| 19       | SSKA025004  | 1/4-20 X 1/4 SOC SET KNURL PT.                             | 2    |
| 20       | ROLA018032  | 3/16 X 2 ROLL PIN  | 2    |
| 21       | DOWA025032  | 1/4 X 2 DOWEL PIN  | 1    |
| 22       | 441-014     | TRACKING KNOB ASSEMBLY                                     | 1    |
| 23       | FSCA031012  | 5/16-18 X 3/4 FSHCS  | 2    |
| 24       | 829-012     | S6 WORK TABLE  | 1    |
| 25       | HHC5050032  | 1/2-13 X 2 HHCS GR5 Z                                      | 1    |
| 26       | SFWZ050     | 1/2 SAE F/W Z  | 1    |
| 27       | SSHA025006  | 1/4-20 X 3/8 SOC SET 1/2 DOG                               | 1    |
| 28       | 148-001     | S6 COUPLING ASSEMBLY                                       | 1    |
| 29       | HHC5031012  | 5/16-18 X 3/4 HHCS GR5 Z                                   | 6    |
| 30       | SLWZ031     | 5/16 SPLIT L/W Z   | 6    |
| 31       | SLWZ050     | 1/2 SPLIT L/W Z  | 1    |
| 32       | 342-023     | S6 COUPLING GUARD  | 1    |
| 33       | CRBZ025032  | 1/4-20 X 2 CARRIAGE BOLT ZINC PLATED                       | 2    |
| 34       | 641-007     | RETAINING RING 1" FOR S6, S460W, S612 DRIVE SPINDLE        | 1    |
| 35       | 641-016     | RETAINING RING FOR S6, S460W, S612                         | 1    |
| 36       | 560-016IPA  | S6 IDLER PULLEY ASSEMBLY                                   | 1    |
| 37       |             | K20 SPINDLE BEARING  | 2    |
| 38       | HHC5025008  | 1/4-20 X 1/2 HHCS GR5 Z                                    | 3    |
| 39       | SLWZ025     | 1/4 SPLIT L/W Z  | 3    |
| 40       | UFWZ025     | 1/4 USS F/W Z  | 3    |
| 41       | BWWA031     | 5/16 BOWED SPRING WASHER 21/64                             | 1    |
| 42       | STNZ031     | 5/16-18 STOVER LOCK NUT ZINC-WAX                           | 1    |
| 43       | 342-069     | S6 BELT GUARD ASSEMBLY                                     | 1    |
| 44       | 342-069C    | BLANK COVER FOR S6M SANDER OSHA GUARD                      | 1    |
| 45       | HWTZ008008  | #8 X 1/2 HWH TEKS Z  | 1    |
| 46       | 486-007     | 3HP MOTOR FOR K8B, K10B, KM10, BG260H, S460W, S6M AND S612 | 1    |
| 47       | 960-006YA   | YOKE WITH TENSION SHAFT FOR S6 SANDERS                     | 1    |
| 48       | 041-091     | BRACKET FOR S6M WITH ROTARY SWITCH                         | 1    |

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

|            |                                |              |
|------------|--------------------------------|--------------|
| TITLE:     | <b>S6 BELT SANDER ASSEMBLY</b> |              |
| SIZE:      | DWG. NO.                       | REV          |
| D          | S6 BELT SANDER ASSEMBLY        |              |
| SCALE: 1:5 | WEIGHT:                        | SHEET 1 OF 1 |

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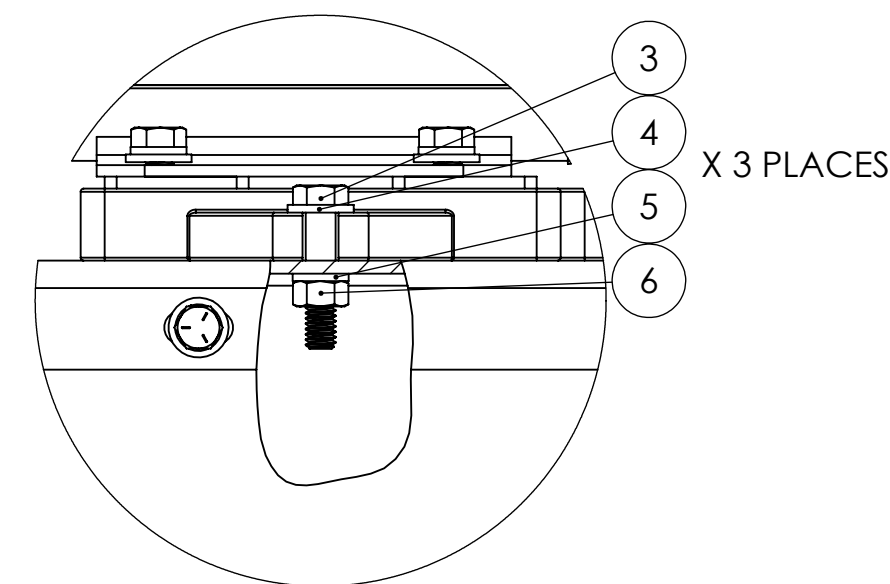
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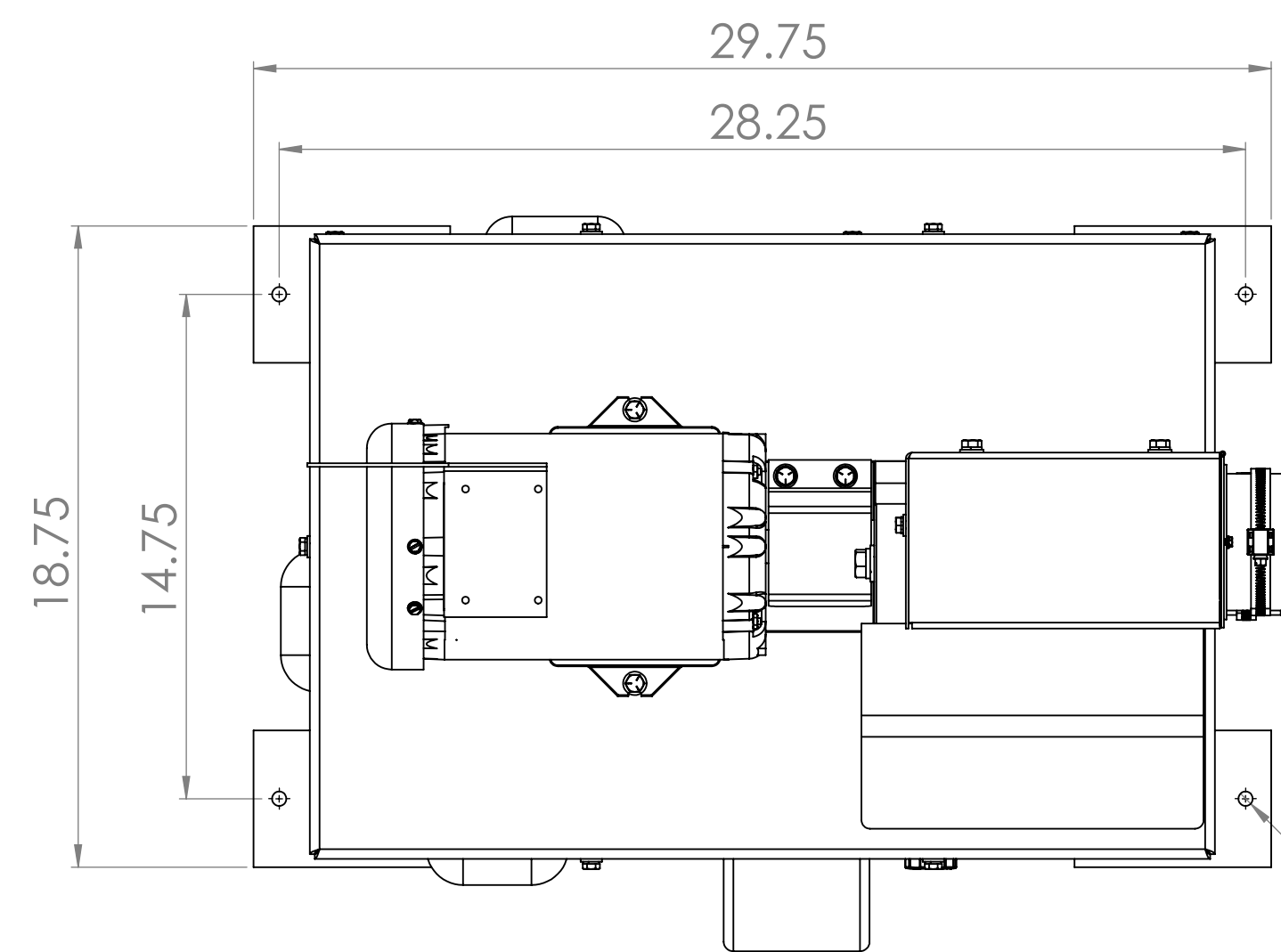
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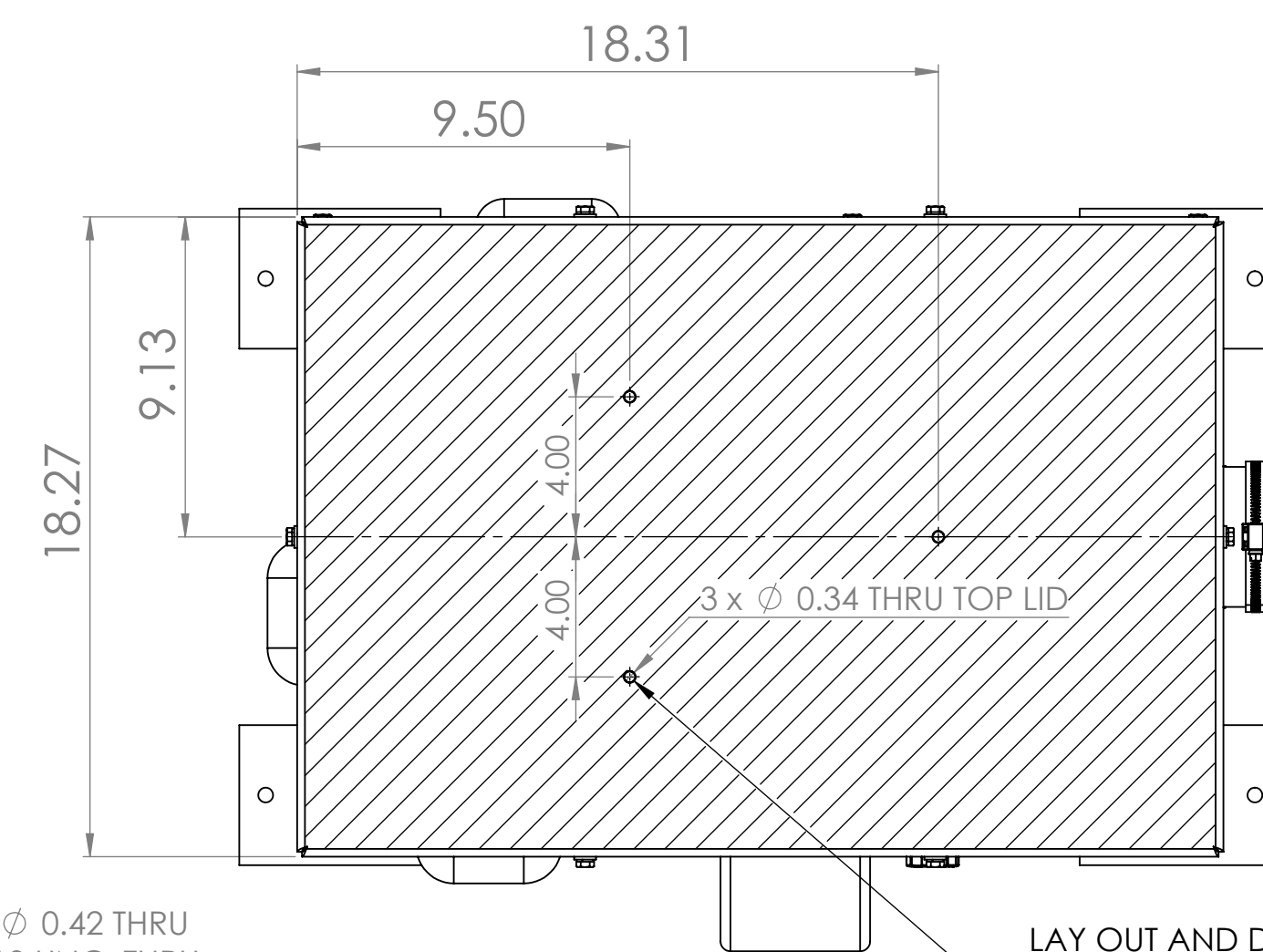
| ITEM NO. | PART NUMBER             | DESCRIPTION                               | QTY. |
|----------|-------------------------|---|------|
| 1        | DCV-6                   | DCV-6 DUST COLLECTOR                      | 1    |
| 2        | S6 BELT SANDER ASSEMBLY | S6 BELT SANDER ASSEMBLY                   | 1    |
| 3        | HHC5031024              | 5/16-18 X 1-1/2 HHCS GR5 Z                | 3    |
| 4        | UFWZ031                 | 5/16 USS F/W Z                            | 3    |
| 5        | SLWZ031                 | 5/16 SPLIT L/W Z                          | 3    |
| 6        | FHN5031                 | 5/16-18 FHN GR5 ZINC                      | 3    |
| 7        | 342-069B                | 4" ORIFACE W/ FLANGE FOR 6" SANDER GUARDS | 1    |
| 8        | 389-002X55 INCHES       | 55 INCHES OF 4" DIA HOSE                  | 1    |
| 9        | HS64                    | 4 INCH HOSE CLAMP                         | 2    |



DETAIL A  
SCALE 1:2

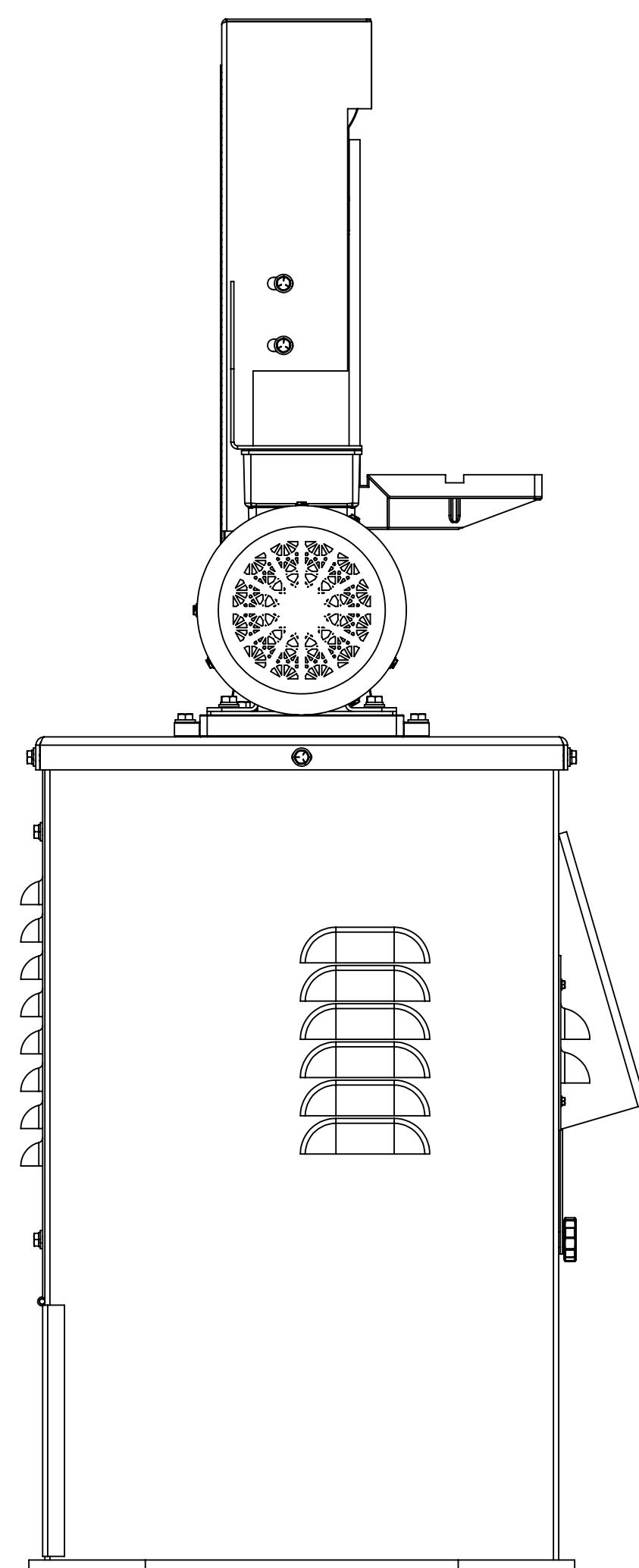
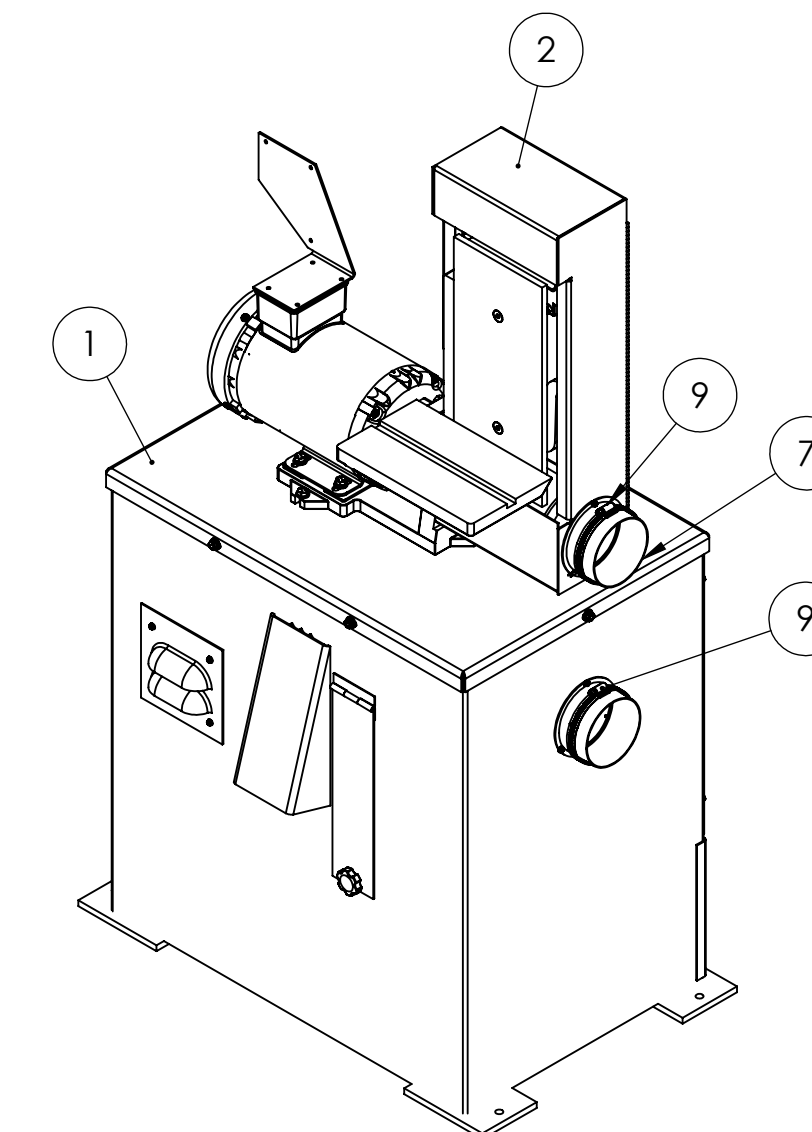


TOP VIEW

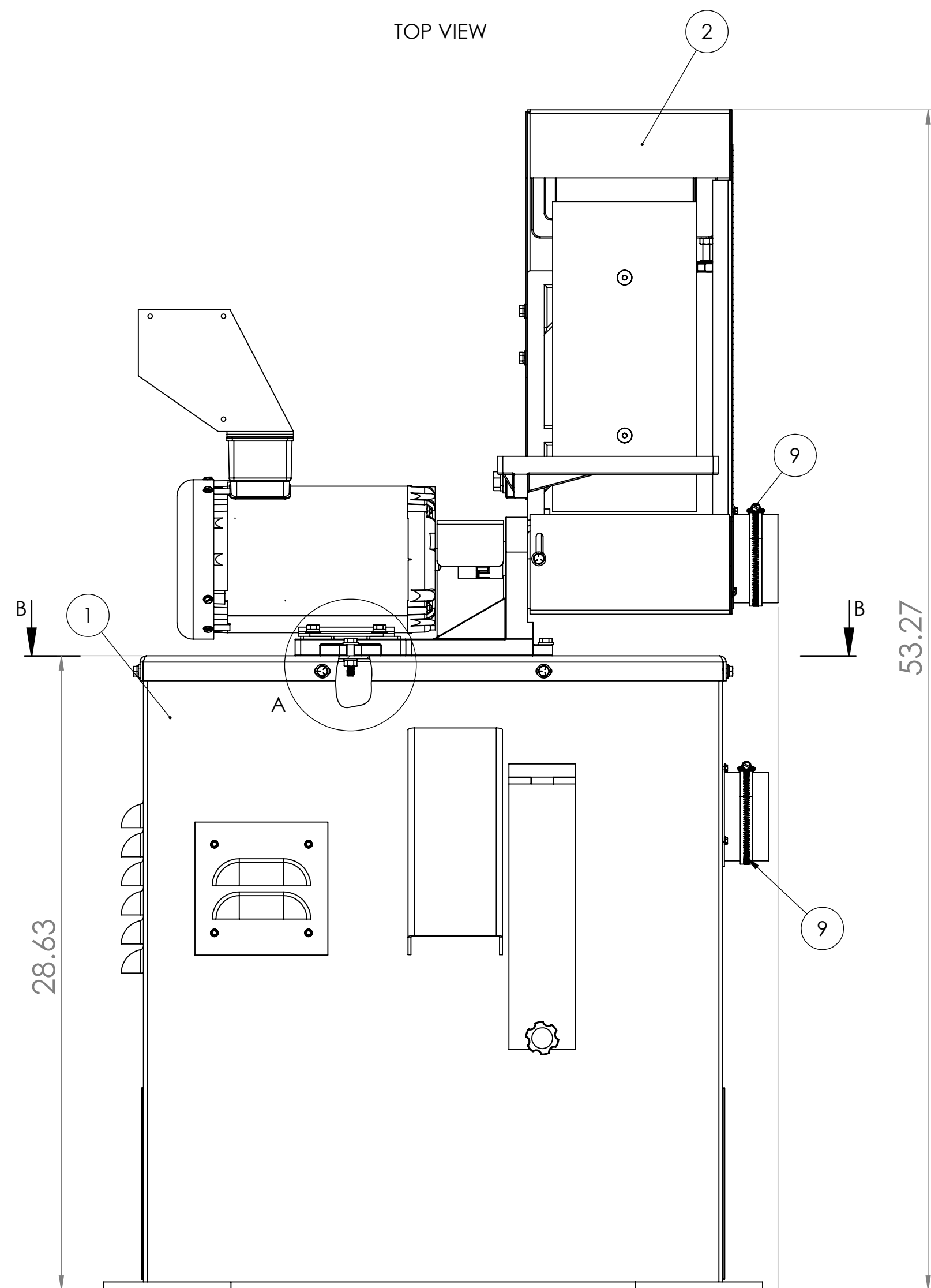


SECTION B-B

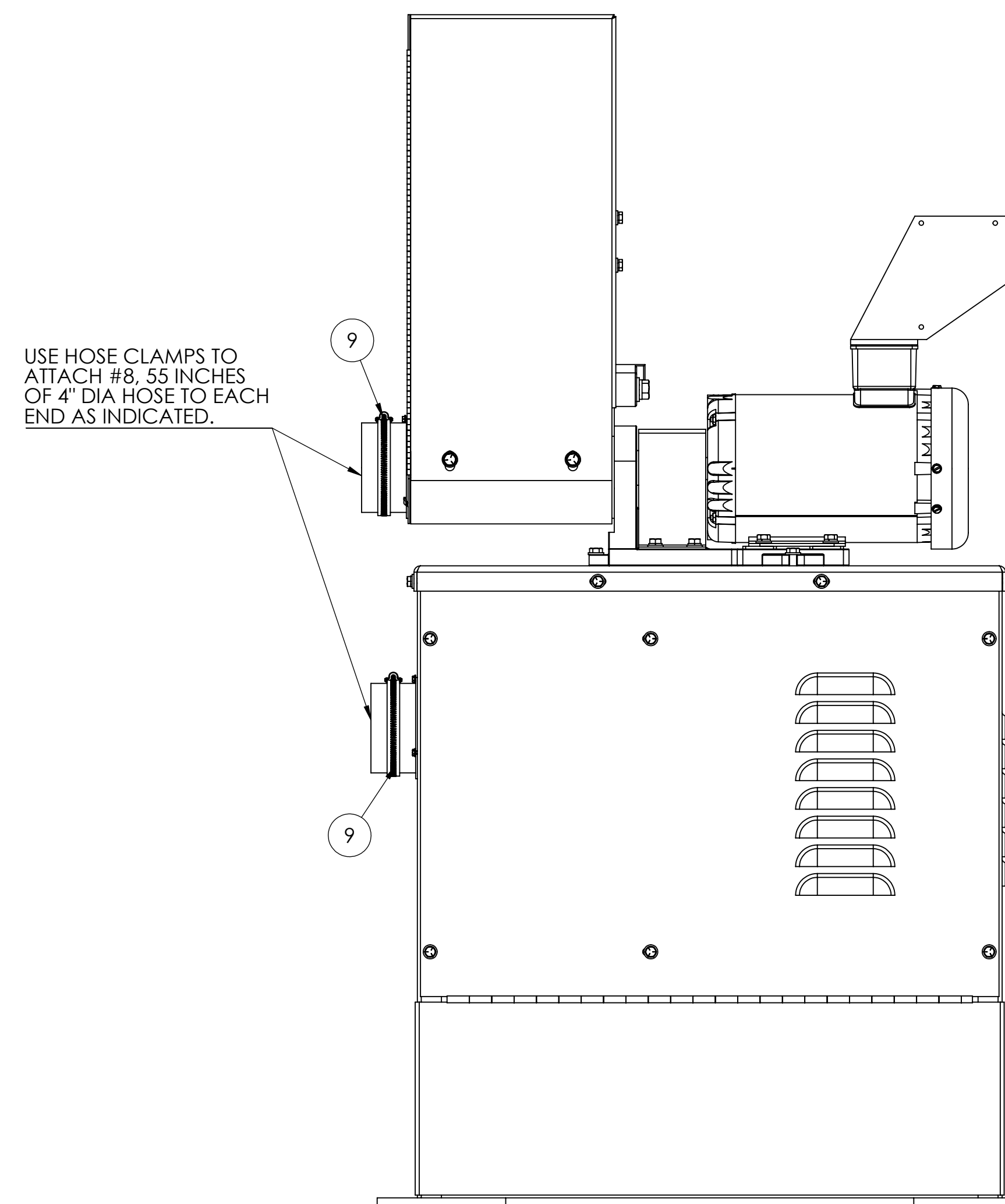
LAY OUT AND DRILL PATTERN AS SHOWN TO ATTACH S6 BELT SANDER ASSEMBLY TO DCV-6 DUST COLLECTOR CABINET.



LEFT SIDE VIEW



FRONT VIEW



BACK VIEW

USE HOSE CLAMPS TO ATTACH #8, 55 INCHES OF 4" DIA HOSE TO EACH END AS INDICATED.

SEE S6 DRAWING FOR S6 BELT SANDER DETAILS

SEE DCV-6 DRAWING FOR DCV-6 DUST COLLECTOR DETAILS

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|                                      |           |      |      |                                 |
|--------------------------------------|-----------|------|------|---------------------------------|
| UNLESS OTHERWISE SPECIFIED:          | DRAWN     | NAME | DATE |                                 |
| DIMENSIONS ARE IN INCHES             | CHECKED   |      |      |                                 |
| TOLERANCES:                          | ENG APPR. |      |      |                                 |
| FRACTIONAL ±                         | MFG APPR. |      |      |                                 |
| ANGULAR ± MATCH ± BEND ±             | Q.A.      |      |      | TITLE: MODEL S6MV ASSEMBLY      |
| TWO PLACE DECIMAL ±                  | COMMENTS: |      |      | SIZE DWG. NO. D S6MV            |
| THREE PLACE DECIMAL ±                |           |      |      | SCALE: 1:5 WEIGHT: SHEET 1 OF 1 |
| INTERPRET GEOMETRIC TOLERANCING PER: |           |      |      |                                 |
| MATERIAL                             |           |      |      |                                 |
| FINISH                               |           |      |      |                                 |
| APPLICATION                          |           |      |      |                                 |

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