

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



PH: (269) 382-2050

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

## S6MW WET BELT SANDER MANUAL



MADE IN USA

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



PH: (269) 382-2050

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

## **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.

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

PH: (269) 382-2050

www.kalamazooind.com

## **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 (28). No belt tension adjustment is required. The yoke assembly is spring loaded for constant belt tension. The tension lever (29) tightens and loosens belt tension.
3. To change belt **disconnect power**: open belt guard (45) and locate the tension lever (29) between the sander frame (27). 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 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 (40) on yoke assembly. Tightening knob (40) raises idler spindle and the belt moves toward the motor. Loosening the tracking knob drops the idler spindle (37) and the sanding belt moves away from the motor. When the belt is centered on the platen (34), 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.)

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



PH: (269) 382-2050

www.kalamazooind.com

**INSTRUCTIONS CONTINUED**

Sanding head position: sanding head can be positioned from vertical to horizontal with any angle in between. Remove v-belt guard (58). Loosen 5/16" socket head cap screws located above and below drive spindle (19) in base (17) 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 (41) 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.**

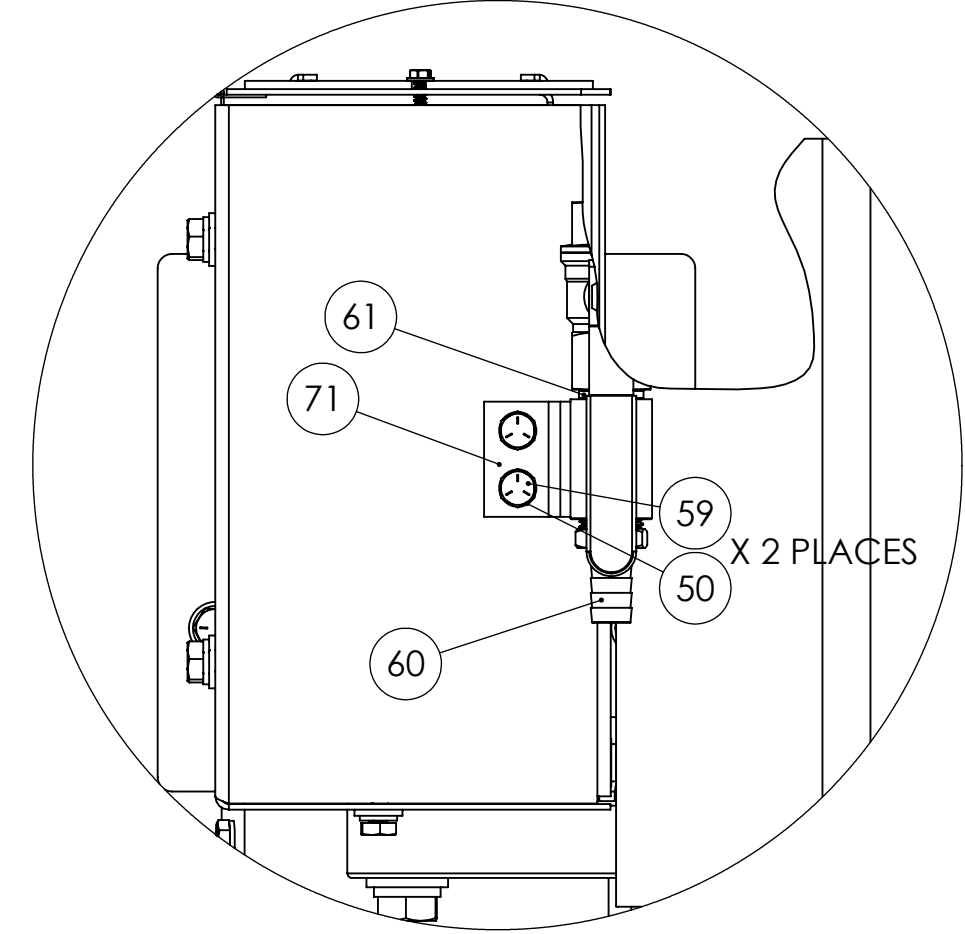
Worktable: the worktable has a slot for mounting fixtures and or a mitre gauge. Also, two mounting holes are provided on the side of the frame (27) to move the work table to different work heights

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

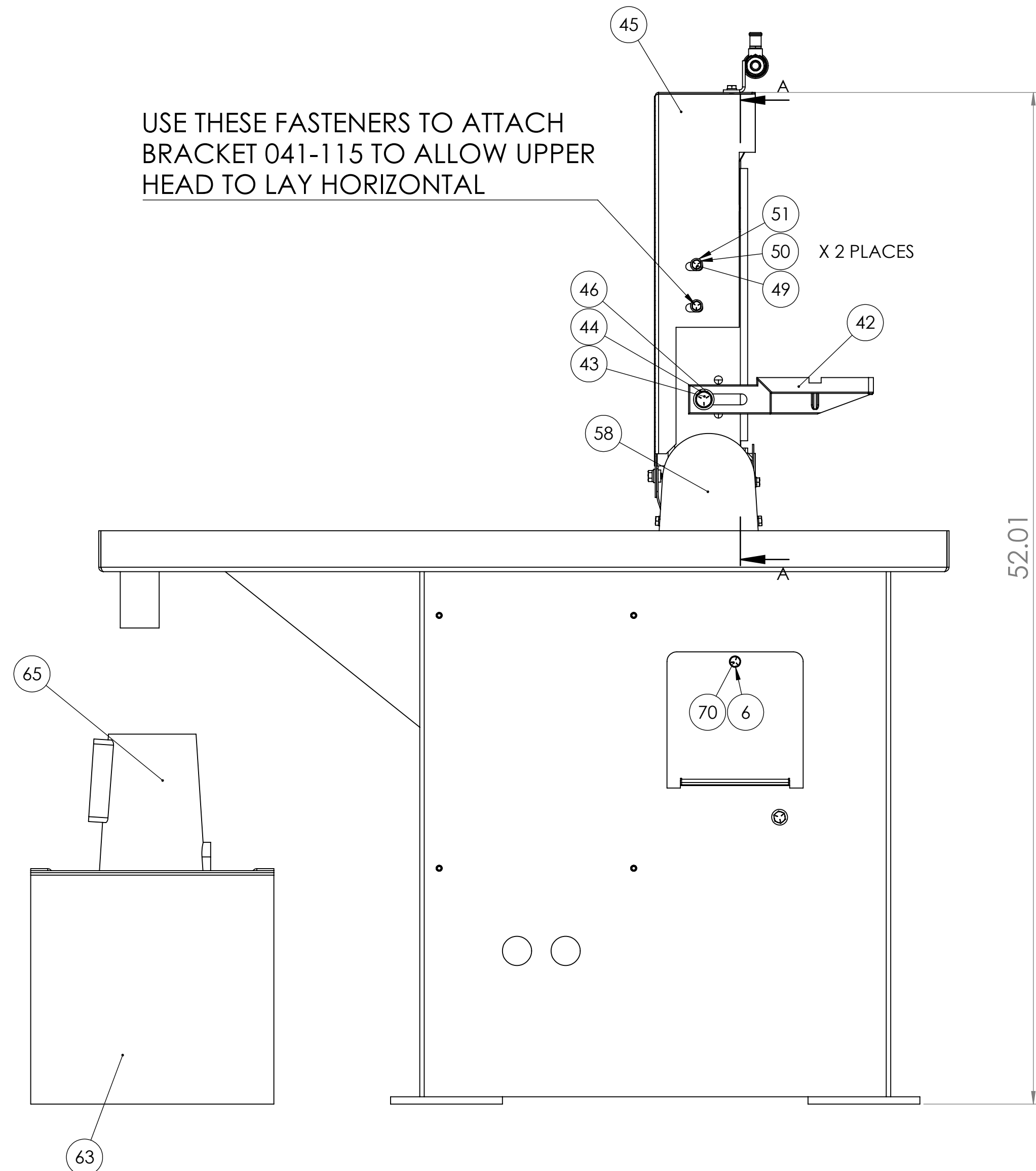
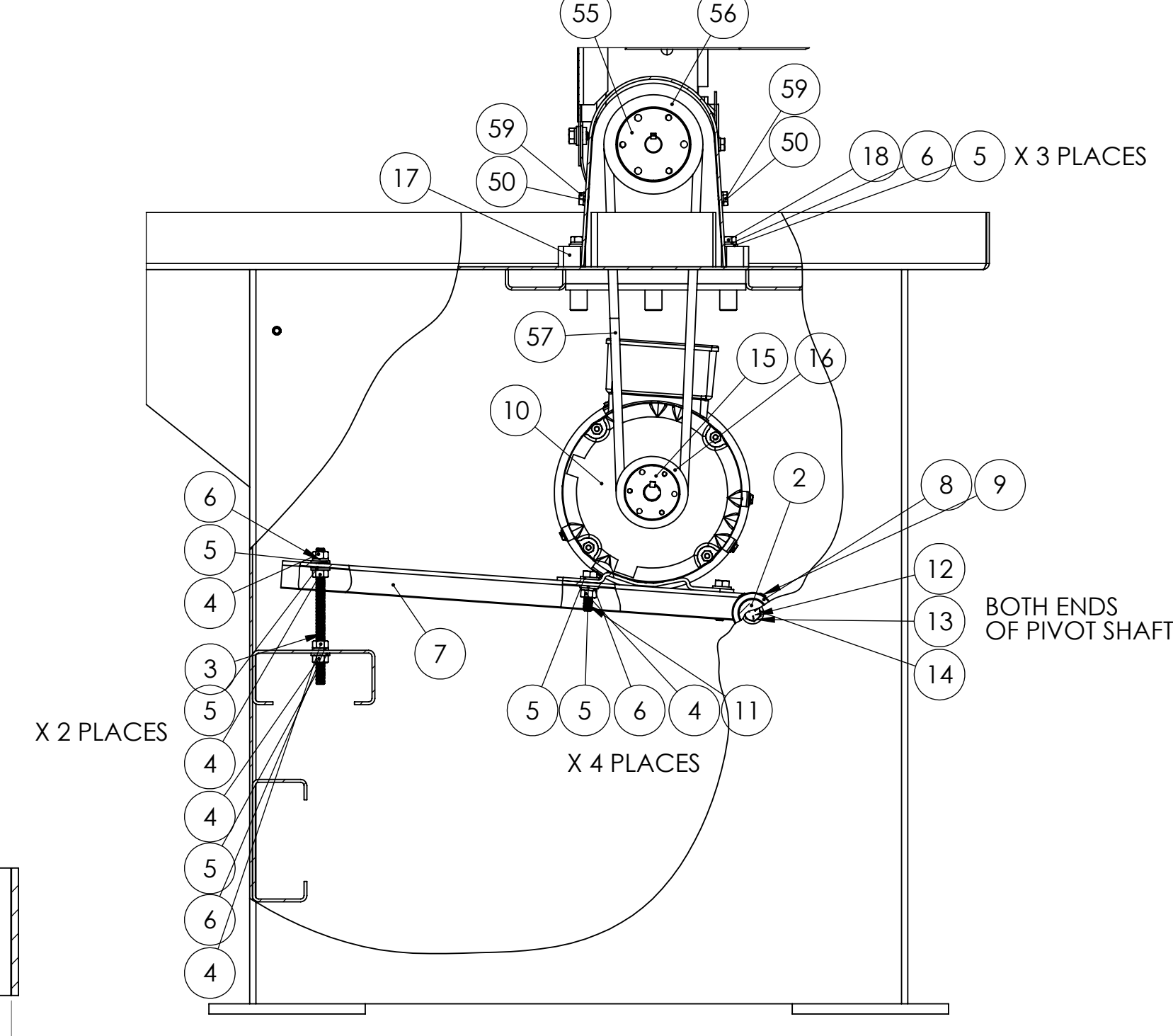
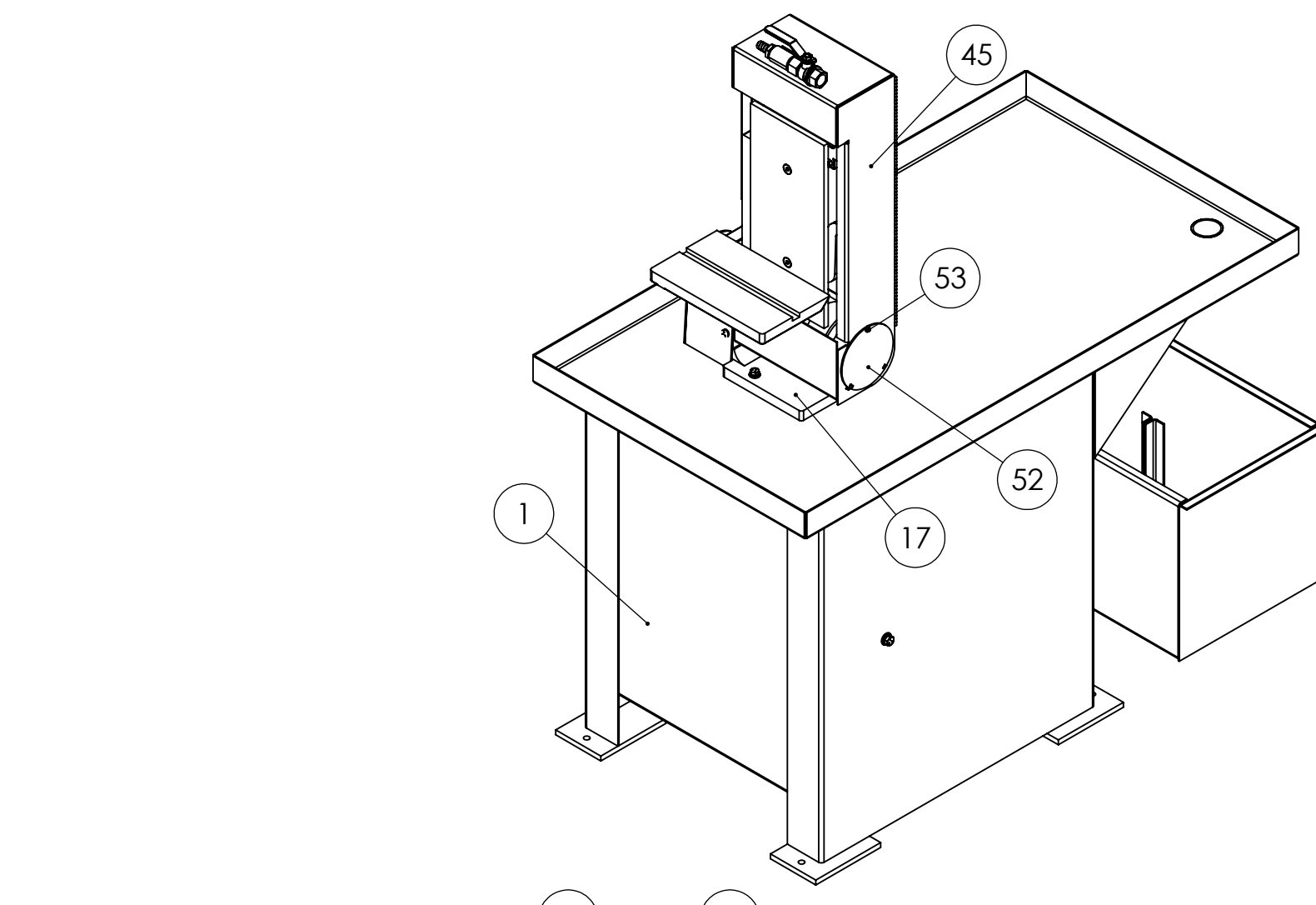
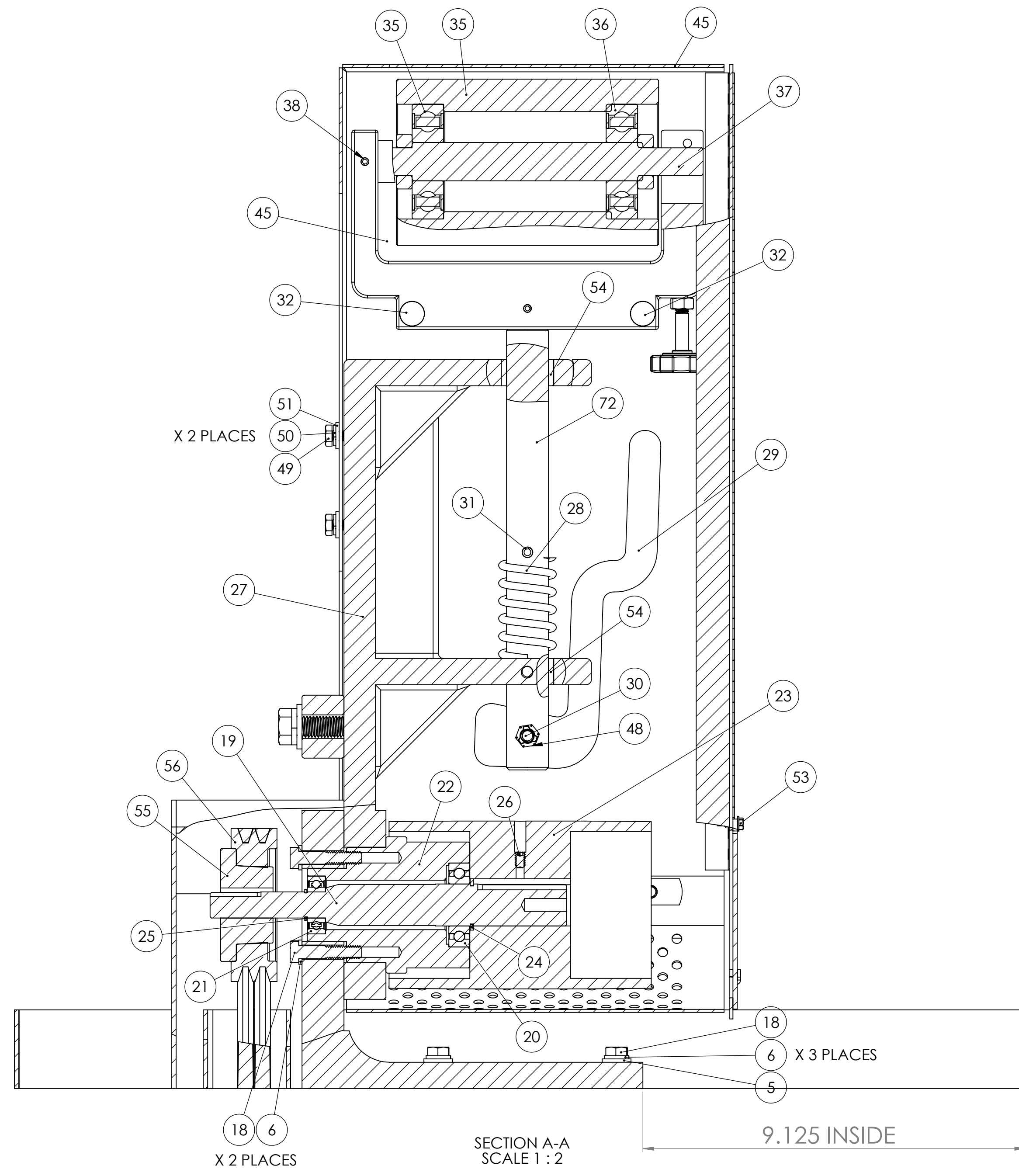
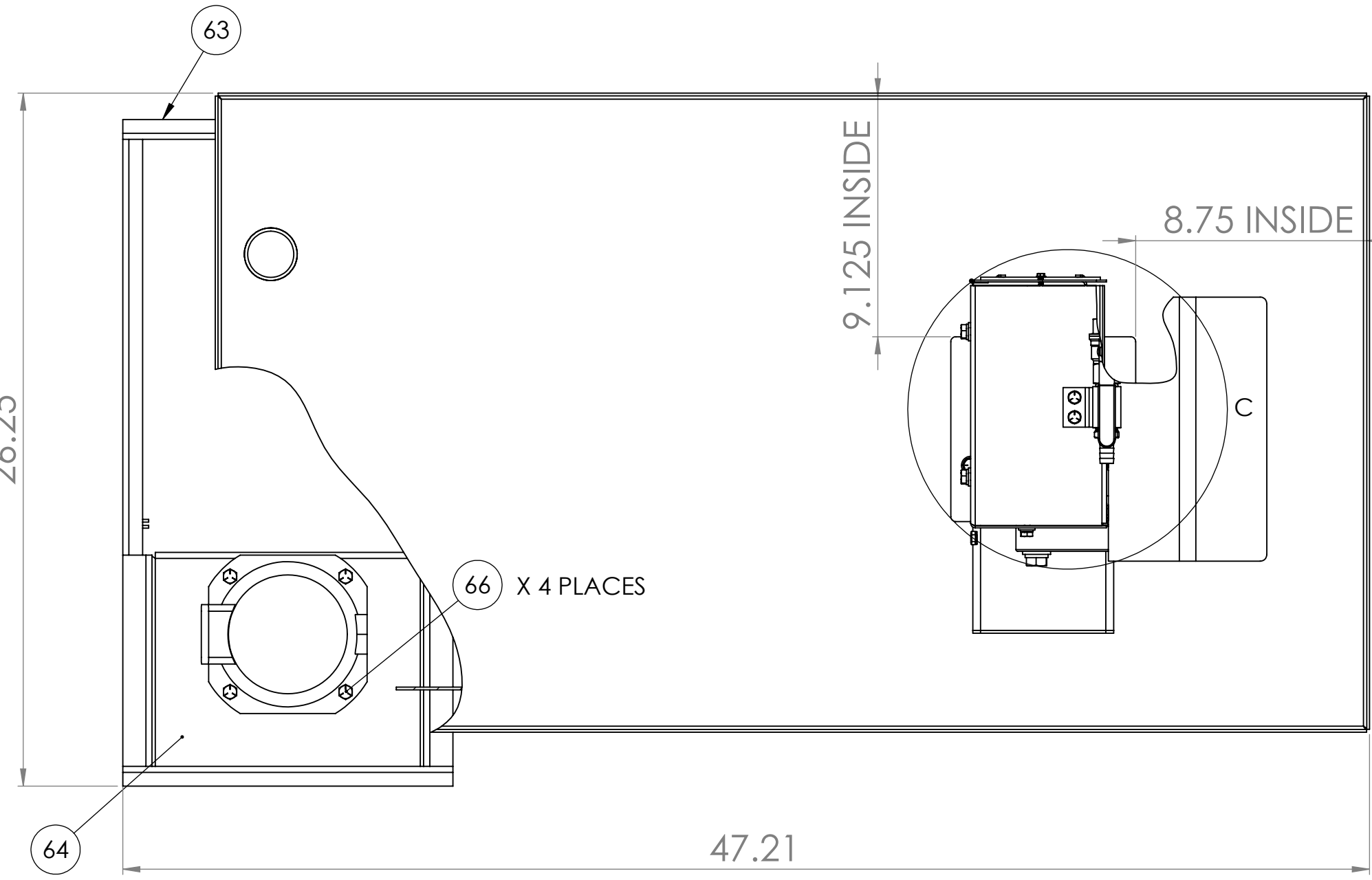
**Coolant:** use rust inhibiting coolant. **Using straight water will rust sander components and will void machine warranty.** Consult your coolant dealer for proper coolant selection.

**Electrical:** be sure incoming power matches machine wiring. NEMA enclosure must be punched for sealite fittings for incoming wire (**DRILL/PUNCH to suite**). AC voltage is 24 voltage at switch.

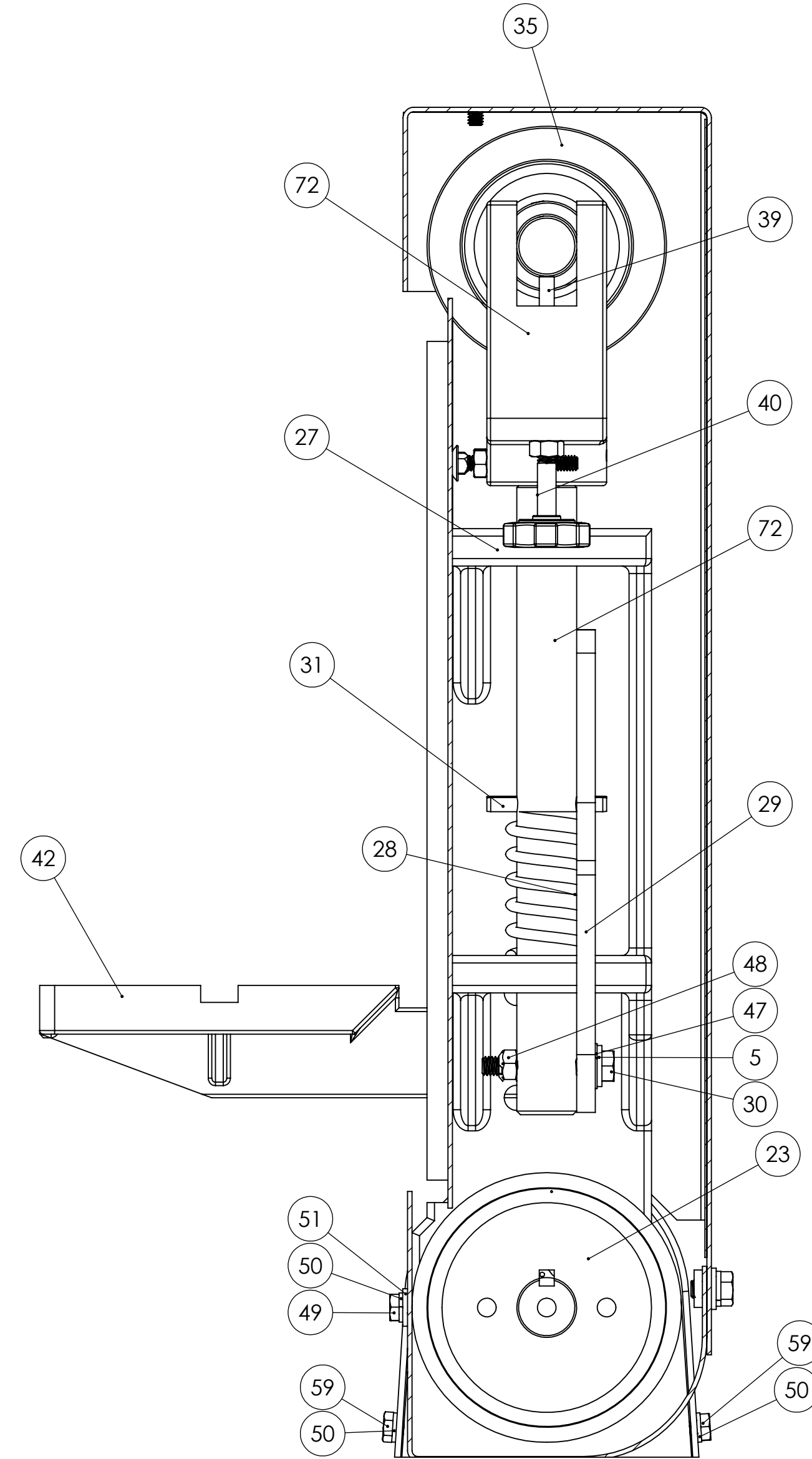
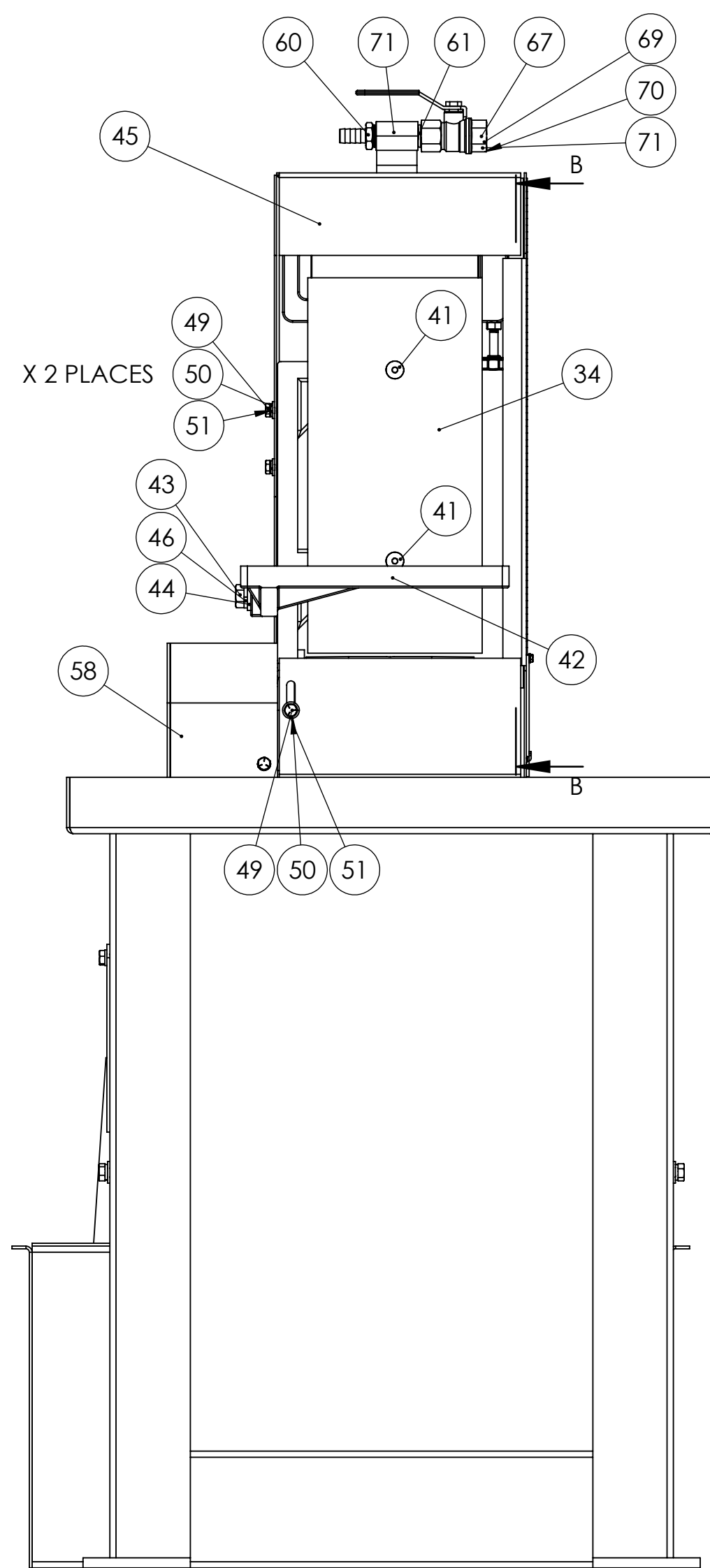
**CAUTION:** Voltage changes require wiring changes and setting at drive motor & pump motor, transformer and overloads. **WARRANTY DOES NOT COVER** unauthorized wiring changes/failures. **Consult and electrician if your motor familiar with electrics.**



DETAIL C  
SCALE 2 : 5  
ATTACHMENT OF COOLANT  
VALVE BRACKET



USE THESE FASTENERS TO ATTACH  
BRACKET 041-115 TO ALLOW UPPER  
HEAD TO LAY HORIZONTAL



SECTION B-B  
SCALE 1 : 2

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-014W	STAND ASSEMBLY FOR S6MW AND S660MW	1
2	700-046	S6MW, S660MW MOTOR MOUNT PIVOT SHAFT	1
3	RND-0.313-18X5	5 INCHES OF 5/16-18 THREADED ROD	2
4	FHN5031	5/16-18 FHN GR5 ZINC	17
5	UFW2031	5/16 USS F/W Z	18
6	SLW2031	5/16 SPLIT L/W Z	18
7	690-014	RAIL, MOTOR MOUNT FOR S 460, S6, S8 SANDERS	2
8	123-016	S6 IDLER PULLEY LOCK COLLAR	4
9	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	4
10	SEE NOTE BELOW	3HP MOTOR FOR K8B, K10B, KM10, BG260H, S460W, S6M AND S612	1
11	HHC5031020	5/16-18 X 1-1/4 HHCS GR 5 Z	4
12	HHC5037020	3/8-16 X 1-1/4 HHCS GR 5 Z	2
13	SLW2037	3/8 SPLIT L/W Z	2
14	UFW2037	3/8 USS F/W Z	2
15	049-020	MOTOR PULLEY BUSHING FOR S460W, S6MW & S612	1
16	560-052	MOTOR PULLEY SHEAVE FOR S6MW, S612 AND S460W	1
17	050-025	CAST IRON BASE FOR S612V-S6MW	1
18	HHC5031024	5/16-18 X 1-1/2 HHCS GR 5 Z	5
19	701-041	K10 BEARING	1
20	044-001	K12 BEARING	1
21	044-007	K10 BEARING	1
22	384-013	S6 BEARING HOUSING	1
23	560-015	S6 DRIVE PULLEY	1
24	641-007	RETAINING RING 1" FOR S6, S460W, S612 DRIVE SPINDLE	1
25	641-016	RETAINING RING FOR S6, S460W, S612	1
26	SSHA025006	1/4-20 X 3/8 SOC SET 1/2 DOG	1
27	291-004 WET	CAST IRON FRAME FOR S6MW SANDERS	1
28	697-024	S6 BELT TENSION SPRING	1
29	455-003	TENSION RELEASE LEVER FOR S6 SANDER HEADS	1
30	HHT5031032	5/16-18x2 HEX HEAD TAP BOLT GR5 ZINC	1
31	ROLA025024	1/4 X 1-1/2 ROLL PIN	1
32	CRB2025032	1/4-20 X 2 CARRIAGE BOLT ZINC PLATED	2
33	FHN5025	1/4-20 FHN GR 5 Z	2
34	563-002	S6 BELT PLATEN	1
35	560-016PA	S6 IDLER PULLEY ASSEMBLY	1
36		K20 SPINDLE BEARING	2
37		S6 IDLER SPINDLE- NEW STYLE	1
38	ROLA18032	3/16 X 2 ROLL PIN	1
39	DOWA025032	1/4 X 2 DOWEL PIN	1
40	441-014	TRACKING KNOB ASSEMBLY	1
41	FSCA031012	5/16-18 X 3/4 FSHCS	2
42	829-012	S6 WORK TABLE	1
43	HHC5050032	1/2-13 X 2 HHCS GR 5 Z	1
44	SPW2050	1/2 SAE F/W Z	1
45	342-069W	GUARD, FULL BOXED OSHA FOR S6MW SANDERS	1
46	SLW2050	1/2 SPLIT L/W Z	1
47	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
48	STN2031	5/16-18 STOVER LOCK NUT ZINC-WAX	1
49	HHC5025012	1/4-20 X 3/4 HHCS GR 5 Z	3
50	SLW2025	1/4 SPLIT L/W Z	7
51	UFW2025	1/4 USS F/W Z	3
52	342-069C	BLANK COVER FOR S6M SANDER OSHA GUARD	1
53	HWTZ008008	#8 X 1/2 HWH TEKS Z	1
54	049-064	RLB AA-1232-4 OILTITE STRAIGHT BUSHING 1 X 1-1/4 X 3/4	2
55	049-019	SPINDLE PULLEY BUSHING FOR S460W, S6MW, S612 & BG272	1
56	560-051	SPINDLE PULLEY SHEAVE FOR S6MW, S612 & S460W	1
57	051-003	3VX335 V-BELT (2 REQUIRED) FOR S612 SANDER	2
58	342-134	V-BELT GUARD FOR S6MW AND S660MW SANDERS	1
59	HHC5025008	1/4-20 X 1/2 HHCS GR 5 Z	4
60	BN44	HOSE BARB 1/2H X 1/2MNTP	1
61	050CL40BLN	050CL40BLN 1/2 BLACK CLOSE NIPPLE	1
62	912-030	JOM 100-703 BRONZE BALL VALVE FULL PORT-1/2	1
63	716-011	COOLANT TANK ASSEMBLY FOR S460W, S6MW, S660W, K12-14MS, K12-14W	1
64	041-114	1/4 TO 1/2 H.P. COOLANT PUMP MOUNTING BRACKET FOR WET SANDERS	1
65	SEE NOTE BELOW	1/4HP COOLANT PUMP AND MOTOR	1
66	HHC5031016	5/16-18 X 1 HHCS GR 5 Z	4
67	8450-22	1/2" LINE-LOC HOSE SEGMENT- 12IN LONG	1
68	8450-27	CONNECTOR FOR 1/2" LINE-LOC HOSE	1
69	8550-225	2" GRAY FLARE NOZZLE FOR 1/2" LINE-LOC HOSE	1
70	HHC5031008	5/16-18 X 1/2 HHCS GR 5 Z	1
71	389-004	COOLANT HOSE MOUNTING BRACKET ASSEMBLY W FLEXIBLE HOSE & FITTINGS	1
72	960-006W	YOKE WITH TENSION SHAFT FOR S6 WET SANDERS	1

**IMPORTANT NOTES**

- #35 560-016PA INCLUDES:**  
PULLEY, BEARINGS, COLLARS AND IDLER SPINDLE
- #10 MAIN MOTOR PART NUMBERS**  
1PH: 486-006S  
3PH: 486-007
- #65 PUMP MOTORS PART NUMBERS**  
1PH: 577-001  
3PH: 577-002

PROPRIETARY AND CONFIDENTIAL  
THIS DRAWING IS THE PROPERTY OF KALAMAZOO  
REPRODUCTION IN PART OR AS A WHOLE  
WITHOUT THE WRITTEN PERMISSION OF  
KALAMAZOO IS PROHIBITED.

UNLESS OTHERWISE SPECIFIED:	NAME	DATE
DIMENSIONS ARE IN INCHES	DESIGNED	
FRACTIONS ARE IN 16THS	CHECKED	
ANGULAR DIMENSIONS ARE IN DEGREES	ENG APPR	
THREE PLACE DECIMALS	MFG APPR	
INTERFERENCE FITS	D.A.	
TOLERANCES PER ASME	COMMENTS:	
NEATNESS		
USED ON		
APPLICATION		

**KALAMAZOO**  
TITLE: **S6MW WET BELT SANDER**  
SCALE: 1:5 WEIGHT: SHEET 1 OF 1