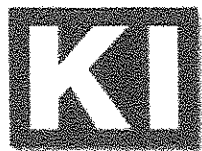
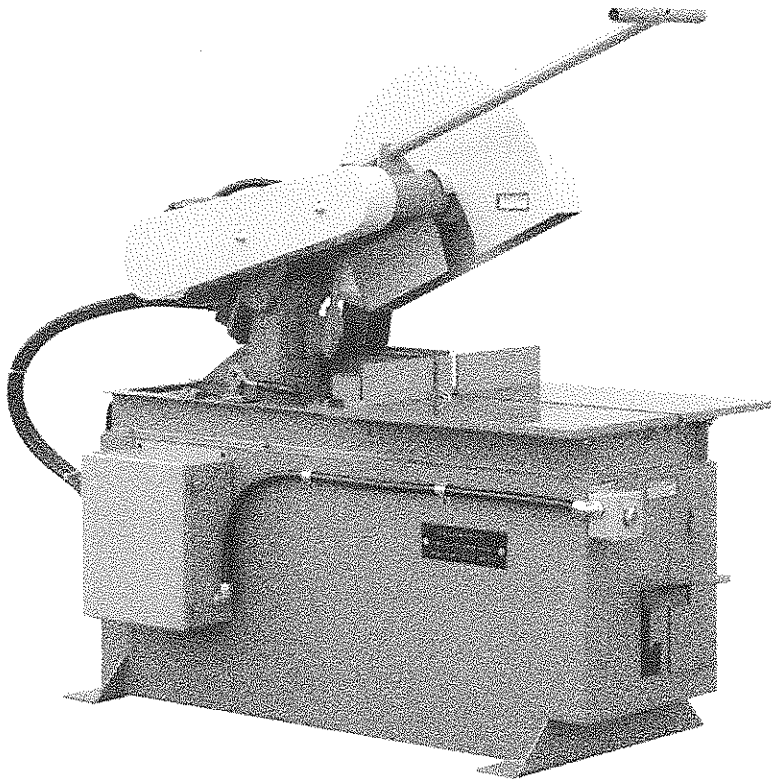


# INSTRUCTION MANUAL

**K20RS**



**KALAMAZOO  
INDUSTRIES, INC.**

6856 East K Avenue

Kalamazoo, MI 49048

269-382-2050 PH

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

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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.

### **READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE OPERATING UNIT**

#### **OPERATING INSTRUCTIONS**

INSPECT YOUR NEW UNIT CAREFULLY FOR SIGNS OF SHIPPING DAMAGE. IF DAMAGED, PLEASE CONTACT CARRIER AND SUBMIT A CONCEALED DAMAGED REPORT. DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS. SEE BACK PAGE FOR RETURN POLICY AND WARRANTY.

BEFORE STARTING OR CONNECTING ELECTRICALS VERIFY THE PHASE AND VOLTAGE OF THE UNIT.

BE SURE MACHINE IS BALANCED CORRECTLY SO IT WILL NOT TIP OVER.

TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBSERVE UNIT FOR THE FIRST FEW MINUTES OF OPERATION. GUARDS MUST NEVER BE REMOVED.

#### **ABRASIVE SAW SAFETY**

NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS

ELECTRIC MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR STANDING ON A WET FLOOR.

DO NOT USE AROUND FLAMMABLE MATERIALS OR LIQUIDS.

MACHINES SHOULD BE OPERATED IN VENTILATED AREAS.

ALWAYS WEAR SAFETY GLASSES OR A FULL FACE SHIELD FOR PROTECTION.

KEEP HANDS CLEAR OF THE CUTTING AREA.

DO NOT WEAR GLOVES OR LOOSE FITTING CLOTHES WHEN OPERATING THIS MACHINE.

ALWAYS KEEP HAIR TIED BACK OR COVERED.

ALWAYS KEEP FLANGES CLEAN AND TIGHT AGAINST CUTTING WHEEL.

ABRASIVE MACHINES ARE FOR ABRASIVE WHEELS NOT STEEL TOOTHED BLADES. DO NOT ATTEMPT TO USE STEEL BLADES UNLESS CORRECTLY GUARDED WITH AN ENCLOSED WHEEL GUARD. KEEP STEEL BLADES FULLY RETRACTED INTO WHEEL GUARD WHEN DONE CUTTING.

ALWAYS KEEP WHEEL GUARD IN DOWN POSITION.

BE SURE WORK PIECE IS CLAMPED SECURELY IN VISE BEFORE CUTTING.

#### **WARNING!!!**

IMPROPER USE MAY CAUSE BREAKAGE AND SERIOUS INJURY.

##### **DO**

1. DO always handle and store wheels in a careful manner.
2. DO visually inspect all wheels before mounting for possible damage.
3. DO check machine speed against the established maximum safe operating speed marked on the wheel.
4. DO check mounting flanges for equal and correct diameter.
5. DO use mounting blotters when supplied with wheels.
6. DO always use a safety guard covering at least one-half of the abrasive wheel.
7. DO allow newly mounted wheels to run at operating speed, with guard in place, for at least one minute before cutting.
8. DO always wear safety glasses or some type of eye protection when cutting.

##### **DON'T**

1. DON'T use a cracked wheel or one that has been dropped or has become damaged.
2. DON'T force a wheel onto the machine or alter the size of the mounting hole-if wheel won't fit the machine, get one that will.
3. DON'T ever exceed maximum operating speed established for the wheel.
4. DON'T use mounting flanges on which the bearing surfaces are not clean, flat and free of burrs.
5. DON'T tighten the mounting nut excessively.
6. DON'T start the machine until the wheel guard is in place.
7. DON'T jam work into wheel.
8. DON'T force cutting so that motor slows noticeably or work gets hot.
9. DON'T wear gloves when operating machine.

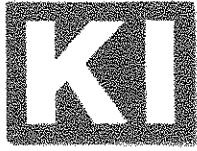


6856 East K Avenue - Kalamazoo, MI 49048-6042  
Phone 269-382-2050 Fax 269-382-0790  
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K20RS, 20" abrasive wheel  
Basic Operation  
1" arbor, RH thd.  
15 hp, 3 phase

1. AC in- Be sure incoming AC power matches machine AC power. Drill/punch NEMA enclosure for seal tite fitting around incoming wiring. Input incoming AC power to L1, L2, L3 on the contactor. CAUTION: IF NOT FAMILIAR WITH ELECTRICS CONSULT AN ELECTRICIAN.
2. Chain vise- Drape chain over work piece as tight as possible, secure chain link into clevis , depress foot pedal to tighten chain on work piece. CAUTION: BE SURE WORK PIECE IS SECURE AND DOES NOT MOVE DURING CUTTING OR ABRASIVE WHEELS WILL BREAK!
3. Clean out- Open door and rake out swarf in base of machine.
4. On/Off- Hold thumb switch on T handle and depress ON to start the wheel. Thumb switch must be held to keep abrasive wheel running. RELEASE thumb switch to stop.
5. Down stop- Controls depth of cut of the abrasive wheel. Adjust as needed for wheel wear . CAUTION: DO NOT ALLOW ABRASIVE WHEEL TO CUT INTO SAW TABLE. ADJUST DOWN STOP WHEN INSTALLING A NEW ABRASIVE WHEEL AND ADJUST AS WHEEL WEARS DOWN.
6. Saw head LOCK- Locks saw head in a fixed position for non radial movement. Use the saw in either "radial" mode or "fixed saw head" mode for cutting. In "Radial" mode begin cutting by pushing or pulling the saw head thru the work piece. BE SURE WORK PIECE IS SECURE WHEN CUTTING.

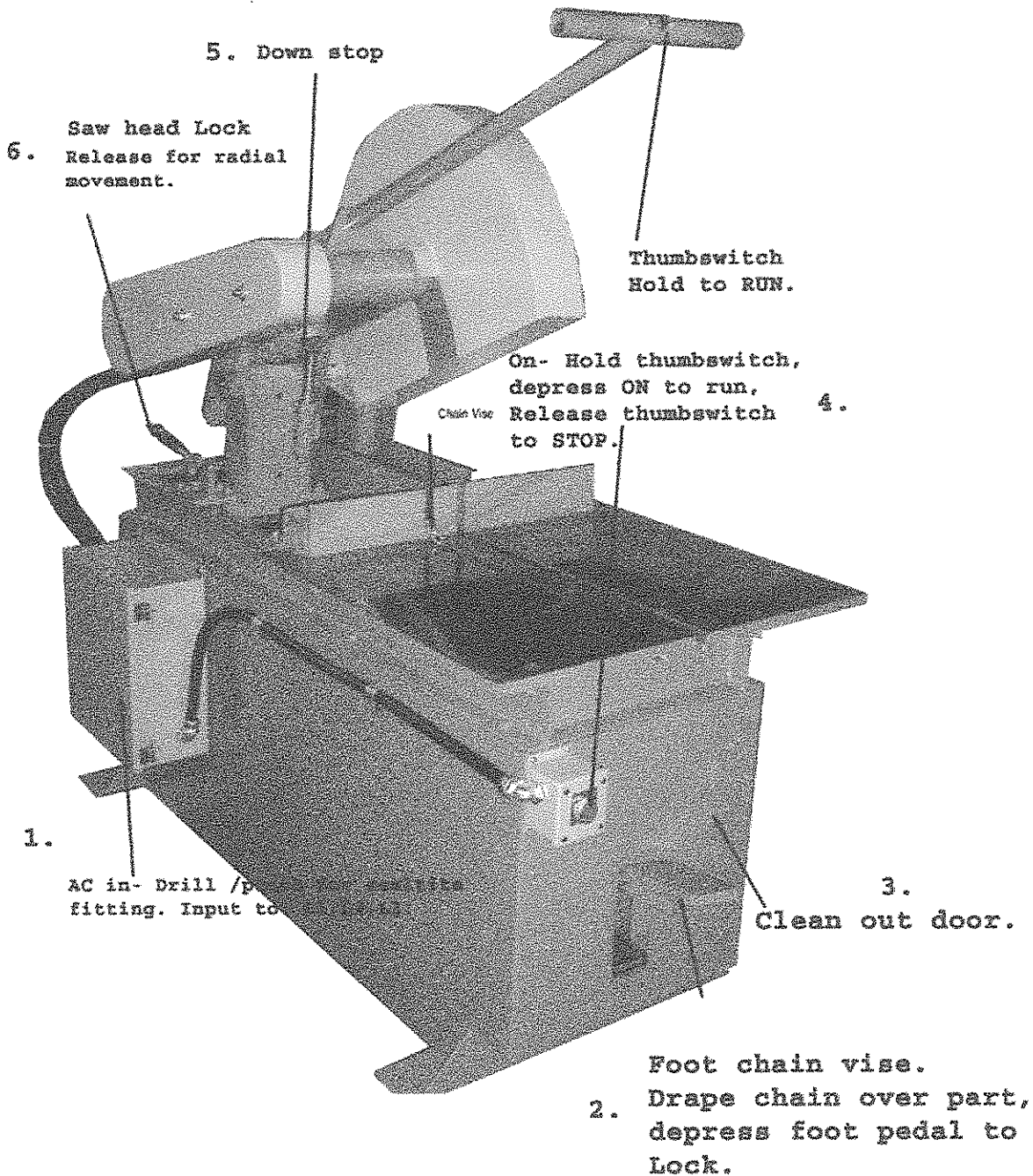
Maintenance- Keep machine cleaned out. V belts will stretch and need to be adjusted over time. ½" of "squeeze". DO NOT OVERTIGHTEN!  
Spindle bearings are "sealed ball" bearings and do not need lubrication.  
Bolt machine to floor if needed. Follow all Safety procedures. SEE SAFETY SHEET !! ALWAYS WEAR SAFETY GLASSES !!!!



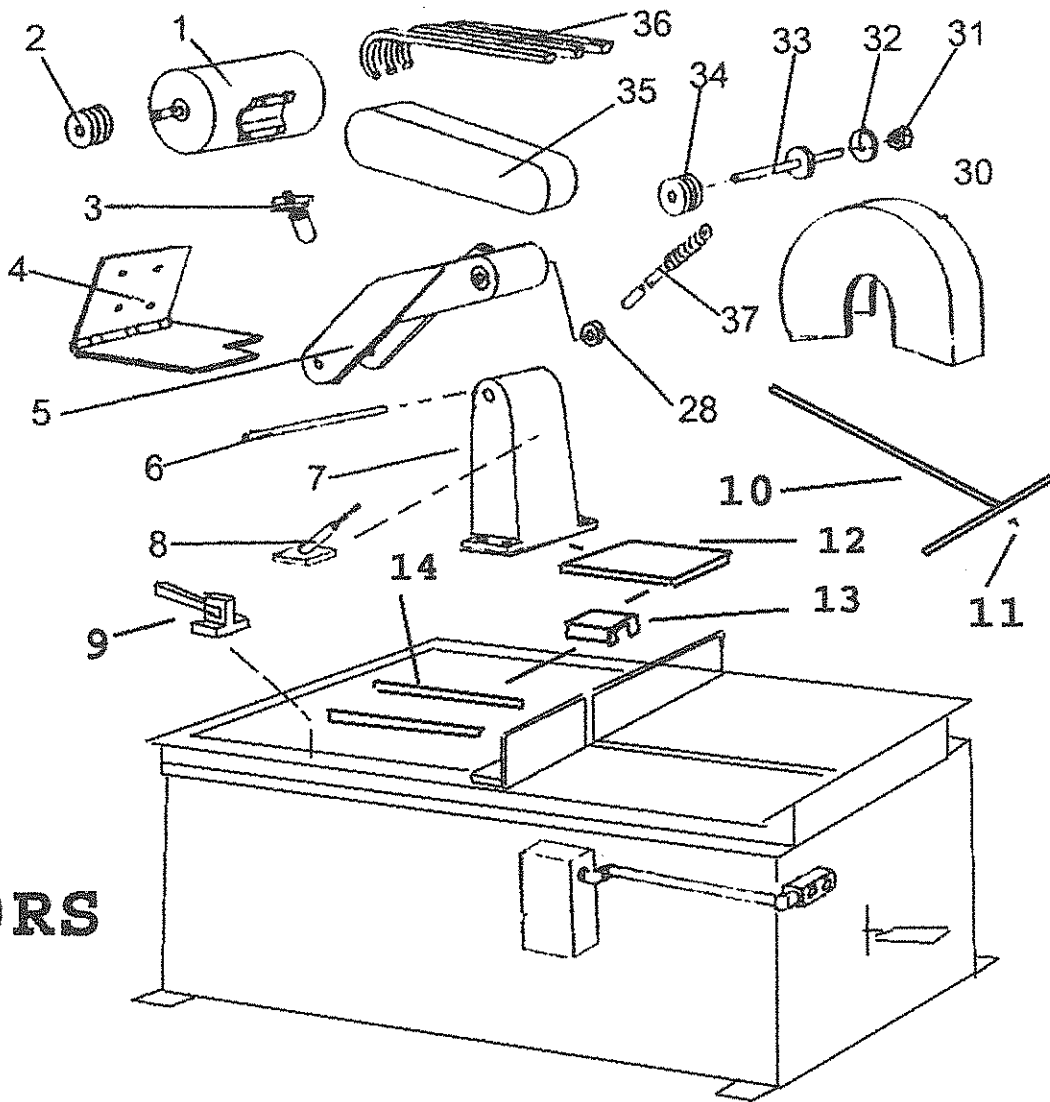
# KALAMAZOO INDUSTRIES, INC.

6856 East K Avenue  
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**K20RS, 20" radial abrasive saw  
1" arbor, 15 hp, 3 phase.**



# K20RS



NO.	PART NO.	DESCRIPTION	QTY
1	486-009	20HP, 3PH, 1725RMP	1
	486-020	15HP SAW DUTY, 3PH, 1725RPM	1
2	560-046	MOTOR PULLEY, 15HP	1
	560-057	MOTOR PULLEY, 20HP	1
3	575-011	POST, MOTOR TENSION	1
4	486-010	MOTOR MOUNT PLATE	1
5	002-016	ARM, SAW	1
6	563-023	PIN, TRUNNION	1
7	831-020	TRUNNION	1
8	940-001W	ARM STOP ASSY	1
9		BLOCK	2
10		Handle	1
11	250-3241	Switch Allied	1
12	556-088	Plate	1
13	044-019	Linear bearings	1
14	690-019	Linear rails 24"	1

28	044-004	Z99066 BEARING	2
29	1000-38	COOLANT HOSE ASSY	1
30	342-067	GUARD, WHEEL	1
31	537-027	SPINDLE NUT	1
32	292-011	LOOSE FLANGE	1
33	701-010	SPINDLE W/TIGHT FLANGE	1
34	560-047	SPINDLE PULLEY, 15HP	1
	560-058	SPINDLE PULLEY, 20HP	1
35	342-039	GUARD, BELT	1
36	051-012	V-BELT 3V630 15HP	3
	051-012	V-BELT 3V630 20HP	4
37	381-002	HANDLE W/GRIP	1

716-028 Stand Assy  
829-041 Table Plate

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130-019 Cap-for Linear Rail  
B