KALAMAZOO
INDUSTRIES INC.

K10HS

INSTRUCTION MANUAL

MADE IN USA

WARNING!

TO REDUCE THE RICK 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 filed with the delivering Transportation Company. **PLEASE DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS.**

Electrical: CAUTION: Voltage changes require wiring changes at drive motor. **WARRANTY DOES NOT COVER** unauthorized wiring changes/failures. **Consult an electrician an electrician if your not familiar with electrics.**

K10HS SETUP

- BEFORE STARTING OR CONNECTING ELECTRICAL VERIFY THE PHASE AND VOLTAGE OF THE UNIT.
- BE SURE MACHINE IS BALANCED CORRECTLY SO IT WILL TIP OVER.
- TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBSERVE UNIT FOR THE FIRST FEW MINUTES OF OPERATION. GUARDS MUST NEVER BE REMOVED.
- BEFORE INSTALLING THE ABRASIVE WHEEL CONFIRM THAT THE CUTOFF WHEEL IS DESIGNED TO RUN AT 4800 SFPM (MOS). YOU CAN FIND THIS INFORMATION DIRECTLY ON THE THE SIDE OF YOUR CUTOFF WHEEL. IT

NON-FERROUS SAW SAFETY

- NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT MACHINE FROM POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS.
- 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.
- ALWAYS CONSULT BLADE MANUFACTURE FOR CORRECT HIGH SPEED CARBIDE BLADE.
- 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.
- MANUALLY TIGHTEN AND LOOSE SPINDLE NUT.
- DO NOT USE IMPACTED GUN TO LOOSEN OR TIGHTEN SPINDLE NUT.
- ALWAYS KEEP WHEEL GUARD IN THE DOWN POSITION.
- BE SURE WORK PIECE IS CLAMPED SECURELY IN VISE BEFORE CUTTING.

WARNING!!!!

IMPROPER USE MAY CAUSE BREAKAGE AND SERIOUS INJURY.

DO

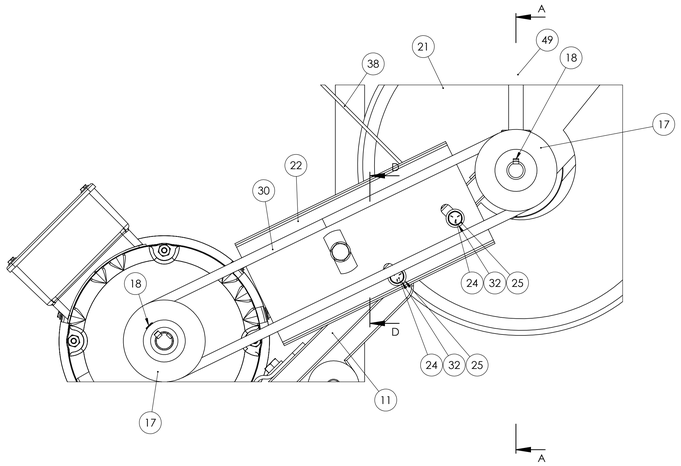
1. **DO always handle and store wheels in the vertical position.**
2. **DO visually inspect all wheels before mounting for possible damage.**
3. **DO check machine speed against the established maximum safe operating speed marked on the wheel.**
4. **DO check mounting flanges for equal and correct diameter.**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

DON'T

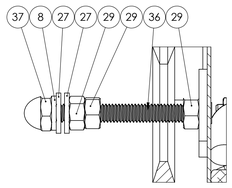
1. **DON'T use a broken wheel or one that has been dropped or has become damaged.**
2. **DON'T force a wheel onto the machine or alter the size of the mounting hole if wheel won't fir the machine.**
3. **DON'T ever exceed maximum operating speed established for the wheel.**
4. **DON'T use mounting flanges on which the bearing surfaces are not clean, flat and free of burrs.**
5. **DON'T tighten the spindle 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 noticeable or work gets hot.**
9. **DON'T wear gloves and or have loose clothing when operating machine.**
10. **DON'T use tooth blade on saw.**

BASIC OPERATION

1. Be certain correct wiring is matched to motor.
2. Always keep flanges clean and tight against the abrasive wheel.
3. Be certain work piece is securely clamped in the vise. Any movement in the work piece during cutting will result in broken abrasive cutoff blades.
4. Down stop screw located on saw base **(#1)** under the saw arm **(#11)** must be adjusted so the blade does not cut into the saw base. Adjust the screw up when installing a new wheel so as not to allow the wheel to cut into the saw base. Keep adjusting the screw down as the wheel ears so you can cut thru the work piece.
5. Keep the blade guard in the down position at all times. Guarding is designed for abrasive blades only. **DO NOT USE STEEL TOOTHED BLADES!!! GUARDING IS NOT DESIGNED FOR STEEL TOOTHED BLADES PER OSHA AND ANSI STANDARDS.**
6. Select the correct high speed carbide blade for the material. Every wheel performs differently. Consult your dealer or wheel manufacturer for wheel blade selection. Use enough cutting force to make the wheel wear or "break down".
7. **Saw spindle speed is set at 3,450 SPFM select cutoff wheel that's designed to run at 3,450 SPFM or greater. Using cutoff wheel's designed to run under 3,450 SPM could cause wheel failure and could cause serious injury to operator. Contact the blade manufacturer for the correct wheel.**
8. Always follow safety procedures. Wear safety glasses, never wear gloves or loose fitting clothing that can get caught in the moving parts and tie back loose hair. Always keep hands out of sawing area when cutting. See attached safety sheet.
9. V-belts will stretch with use over time. Keep v-belts tight with 1/2" of "squeeze". Use a v-belt tensioner to tighten v-belt belt. Keep both faces of spindle and motor pulley aligned in the same plan with a straight edge. Check motor and spindle pulleys set set prior to operating the machine.

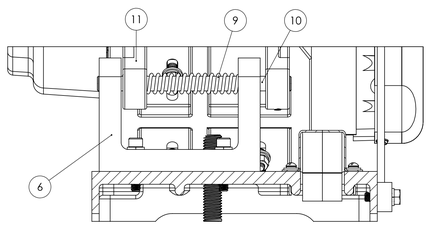


INTERNAL BELT GUARD
VIEW



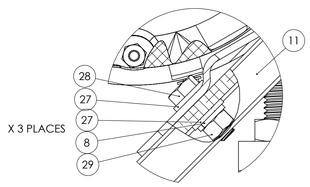
SECTION D-D
SCALE 1 : 1

ATTACHMENT OF
OUTER PLASTIC BELT GUARD



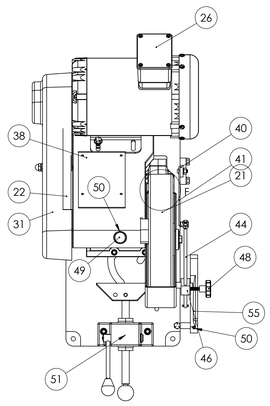
SECTION C-C

FRONT VIEW OF
TRUNNION, TRUNNION
PIN, AND SPRING

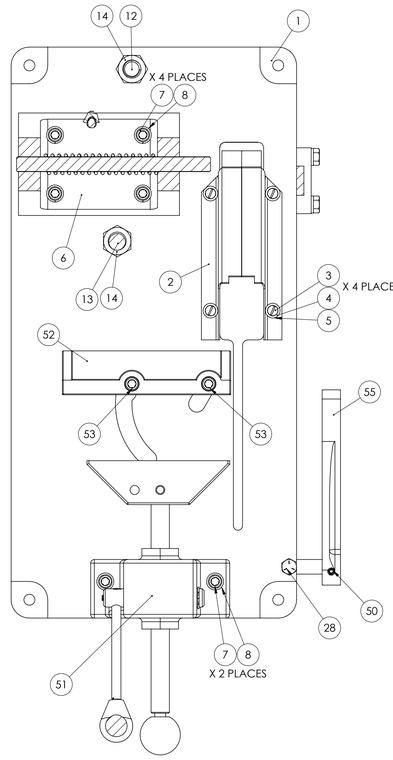


DETAIL E

MOTOR MOUNT
DETAILS
SCALE 1 : 1

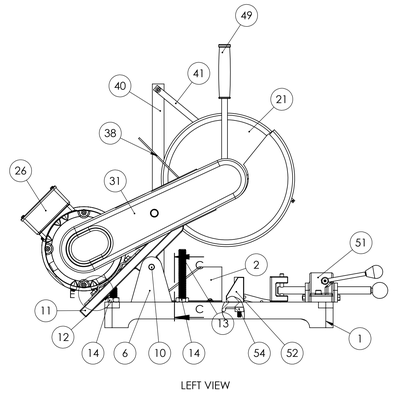


TOP VIEW

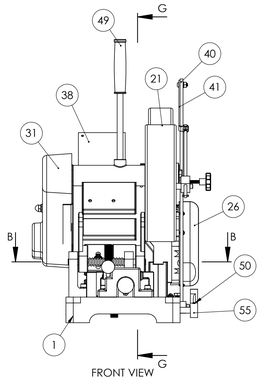


SECTION B-B

TOP VIEW OF
LAYOUT



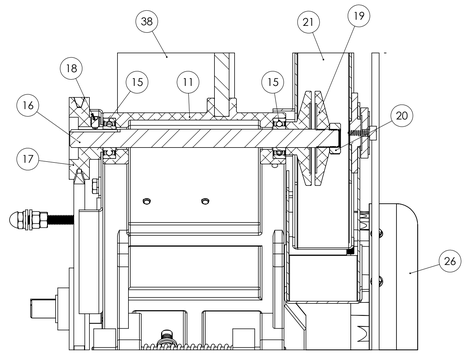
LEFT VIEW



FRONT VIEW

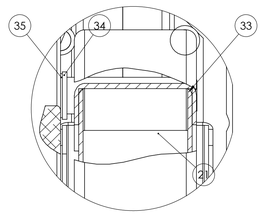
3PH MOTOR AND SWITCH

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
28	486-007	3HP 3PH	1
	710-071	3PH SWITCH	1



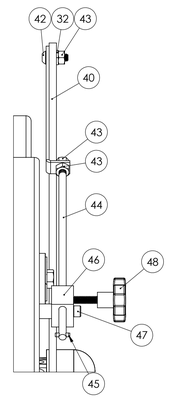
SECTION A-A

SPINDLE HALF SECTION
VIEW

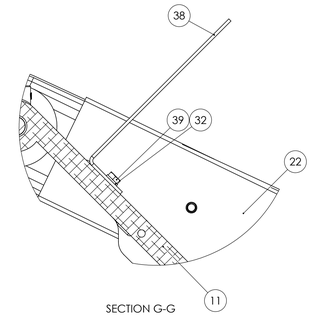


DETAIL F

CLAMSHELL GUARD
ATTACHMENT DETAILS
SCALE 1 : 1

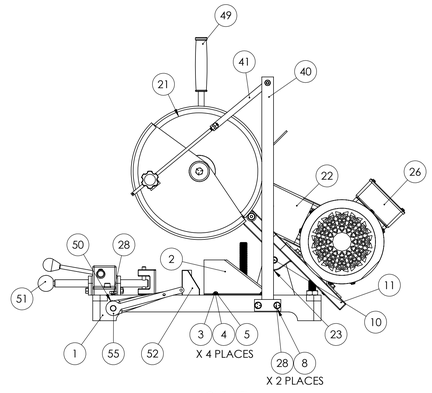


FRONT VIEW OF
CLAMSHELL VEVER
MECHANISM

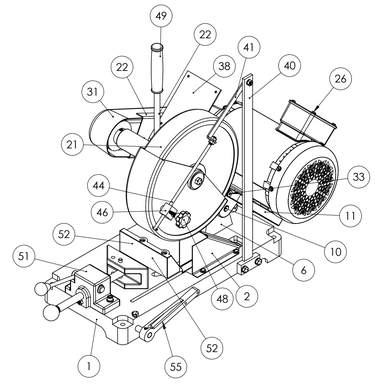


SECTION G-G

SWITCH BRACKET
DETAILS



RIGHT VIEW



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	050-008	K10 BASE	1
2	342-008MOD	MODIFIED GUARD, SPARK DEFLECTOR FOR K10HS SAW	1
3	SRMZ011008	10-24 X 1/2 SLT ROUND MS Z	4
4	MSWZ010	#10 M.S. F/W Z	4
5	SLWZ010	#10 SPLIT L/W Z	4
6	041-006	TRUNNION BRACKET FOR K10	1
7	SHCA031024	5/16-18 X 1-1/2 SHCS	6
8	SLWZ031	5/16 SPLIT L/W Z	12
9	697-013	TENSION SPRING FOR 2FS, 2FS72, 2FSM, BG142, 2FS72M, K12-14B	1
10	562-004	TRUNNION PIN FOR K7B, K8B, K10B	1
11	002-001	ALUMINUM SAW ARM FOR K7B, K8B, K10B (TAKES NEW 6202-2RS-1/2 BEARINGS	1
12	RND-5/8-11 THRD RODX4.	4 INCHES OF 5/8-11 THREADED ROD	1
13	RND-0.625-11 THRD RODX5.	5-1/2 INCHES OF 5/8-11 THREADED ROD	1
14	FJNZ062	5/8-11 F H JAM NUT Z	2
15	044-007	K10 BEARING	2
16	701-003	K10 SPINDLE W TIGHT FLANGE	1
17	560-045	K10B, K10SW, KM10 PULLEY	2
18	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
19	292-008	LOOSE FLANGE FOR K10B AND 2SK7	1
20	FJNZ063	5/8-18 F H JAM NUT Z	1
21	342-103	K10HS CLAMSHELL WHEEL GUARD ASSEMBLY	1
22	342-027	K10B INNER GUARD BELT BRACKET	1
23	SSKA025008	1/4-20 X 1/2 SOC SET KNURL PT.	1
24	HHC5025012	1/4-20 X 3/4 HHCS GR5 Z	2
25	UFWZ025	1/4 USS F/W Z	2
26	486-006	3 HP MOTOR FOR FOR K8B, K10B, KM10, BG260H AND S460W	1
27	UFWZ031	5/16 USS F/W Z	8
28	HHC5031016	5/16-18 X 1 HHCS GR5 Z	6
29	FHN5031	5/16-18 FHN GR5 ZINC	6
30	051-003	V-BELT FOR K10, KM10, S6MW, S460W	1
31	342-043	K10B, KM10 PLASTIC OUTER BELT GUARD	1
32	SLWZ025	1/4 SPLIT L/W Z	5
33	SSBA031006	5/16 X 3/8 SOC SHOULDER BOLT	1
34	UFWZ037	3/8 USS F/W Z	1
35	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
36	RND-0.31-18 THRD RODX	3 INCHES OF 5/16-18 THREADED ROD	1
37	CPNZ031	5/16-18 CAP NUT NICKEL	1
38	041-050	SWITCH BRACKET FOR K8B AND K10B	1
39	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	2
40	455-005POST	POST FOR K10HS CLAMSHELL WHEEL GUARD LEVER ASSEMBLY	1
41	455-005BRACKET	TENSION BRACKET (LONG) FOR K10HS AND KM10HS CLAMSHELL GUARD	1
42	BSCA025012	1/4-20 X 3/4 BSHCS	1
43	FHN5025	1/4-20 FHN GR5 Z	3
44	455-007ROD	GUIDE ROD FOR K10 AND K14 SERIES CLAMSHELL WHEEL GUARD LEVER ASSEMBLY	1
45	ROLA012008	1/8 X 1/2 ROLL PIN	1
46	053-047	BLOCK, WHEEL GUARD FOR K10 AND K14 SERIES CLAMSHELL GUARD	1
47	SHCA025016	1/4-20 X 1 SHCS	1
48	441-015	9078-2500-1.00S 1/4 THUMBSCREW 1-1/2 DIA	1
49	381-003	HANDLE W GRIP FOR K7B, K8B, K10B SAWS	1
50	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	2
51	912-015	K10- 14 VISE ASSEMBLY	1
52	431-002	K10- 14 REAR VISE JAW	1
53	SHCA031048	5/16-18 X 3 SHCS	2
54	537-014	K10-14 FENCE NUT	1
55	709-002	WORK STOP FOR K10B	1

SEE DRAWING #912-015 FOR COMPLETE
VISE DETAILS.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ±
ANGULAR: MACH ± BEND ±
TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±
INTERPRET GEOMETRIC TOLERANCING PER:
MATERIAL
FINISH
NEXT ASSY | USED ON
APPLICATION | DO NOT SCALE DRAWING

	NAME	DATE
DRAWN		
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

KALAMAZOO INDUSTRIES, INC.

TITLE:
K10HS 10" HIGH SPEED
NON-FERROUS SAW

SIZE E | DWG. NO. K10HS | REV

SCALE: 1:2 WEIGHT: | SHEET 1 OF 1