

# INSTRUCTION MANUAL

## K10WBT



**KALAMAZOO  
INDUSTRIES, INC.**

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

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## **WARNING!**

### **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

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**

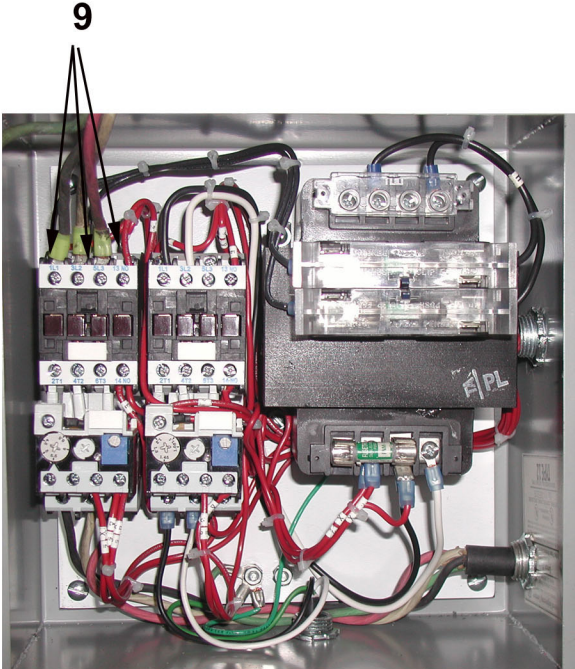
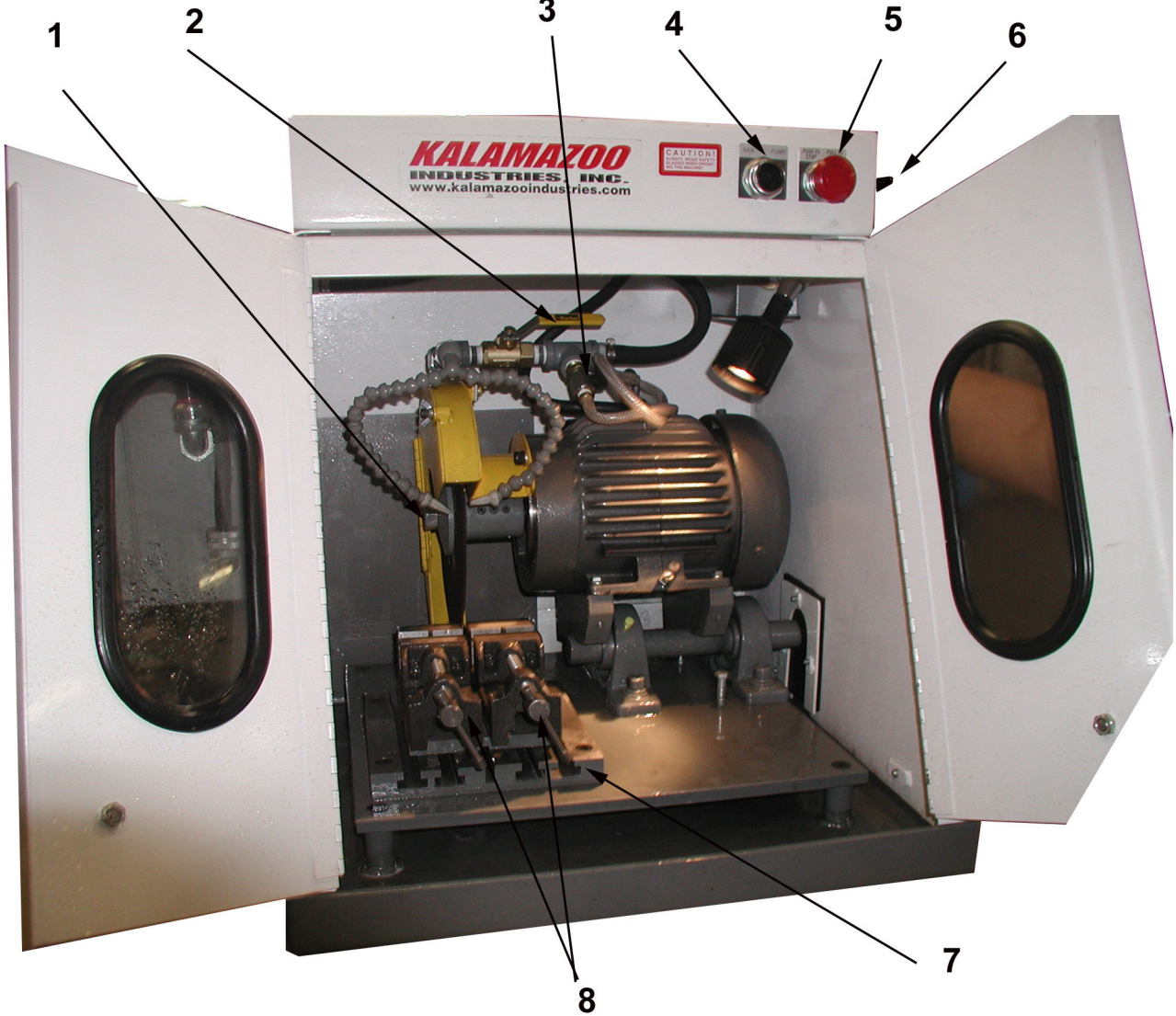
1. DO always handle and store wheels in a careful manner.
2. DO visually inspect all wheels before mounting for possible damage.
3. DO check machine speed against the established maximum safe operating speed marked on the wheel.
4. DO check mounting flanges for equal and correct diameter.
5. DO use mounting 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.



K10WBT



## Basic Controls

K10WBT

10" abrasive wheel, 5/8" arbor, LH thd.

Coolant tank & pump @ 110 volt, control voltage is 24v.

Manual pull down.

1. 5/8" arbor, Left hand spindle nut. Use the correct abrasive wheel for the material being cut. Burned or discolored parts indicate the WRONG abrasive wheel. Consult your dealer for the correct wheel grade.

2. Coolant- On/Off, controls coolant flow. Close for more pressure on washout hose. Use a rust inhibiting coolant. DO NOT USE STRAIGHT WATER! CONSULT YOUR DEALER FOR COOLANT SPECIFICATIONS. A GOOD GRINDING COOLANT SHOULD WORK.

3. Washout hose- Close valve when cutting. Clean out- Open valve, rotate selector switch #4 to "pump" ( only pump runs, not blade). Close valve when machine is washed out. Leave cabinet doors open to dry out the cabinet.

4. Selector switch- Choose "Saw" or "pump". "Saw" position runs saw blade AND coolant pump. "pump" position runs just the coolant pump for wash out.

5. STOP- Push in to STOP. Pull out selector to re-set STOP.

6. Light- On/Off. 24 v halogen bulb # 457-002.

7. T-Slot table- Use T nuts to hold vises, clamps, etc.

8. Vises- Vises can be slid forward/backward for part positioning. Always cut ahead of wheel center on the front side of the abrasive wheel.

9. Electrical- Input line voltage into L1,L2,L3 on the contactor. Be sure incoming voltage matches machine set-up. IF NOT FAMILIAR WITH ELECTRICS CONSULT AN ELECTRICIAN. ELECTRICAL FAILURES DUE TO INCORRECT WIRING ARE NOT WARRANTED.

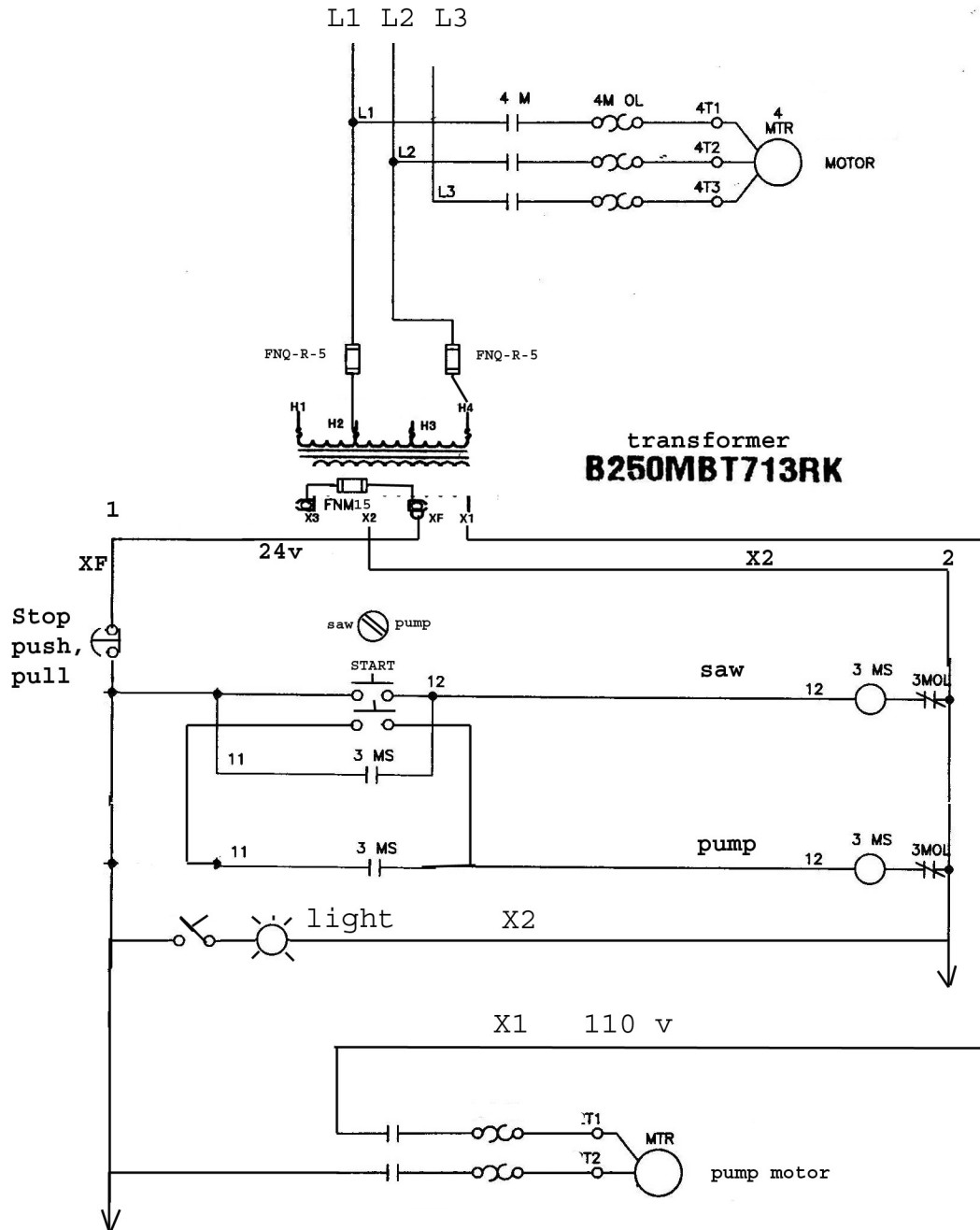
10. Spindle lock- Use 3/8" rod to lock spindle to remove spindle nut ( LH thread).

Maintenance- Keep machine cleaned out with the wash down hose. Leave cabinet doors open to dry out the machine after clean out. Always follow safety procedures. ( see safety sheet).

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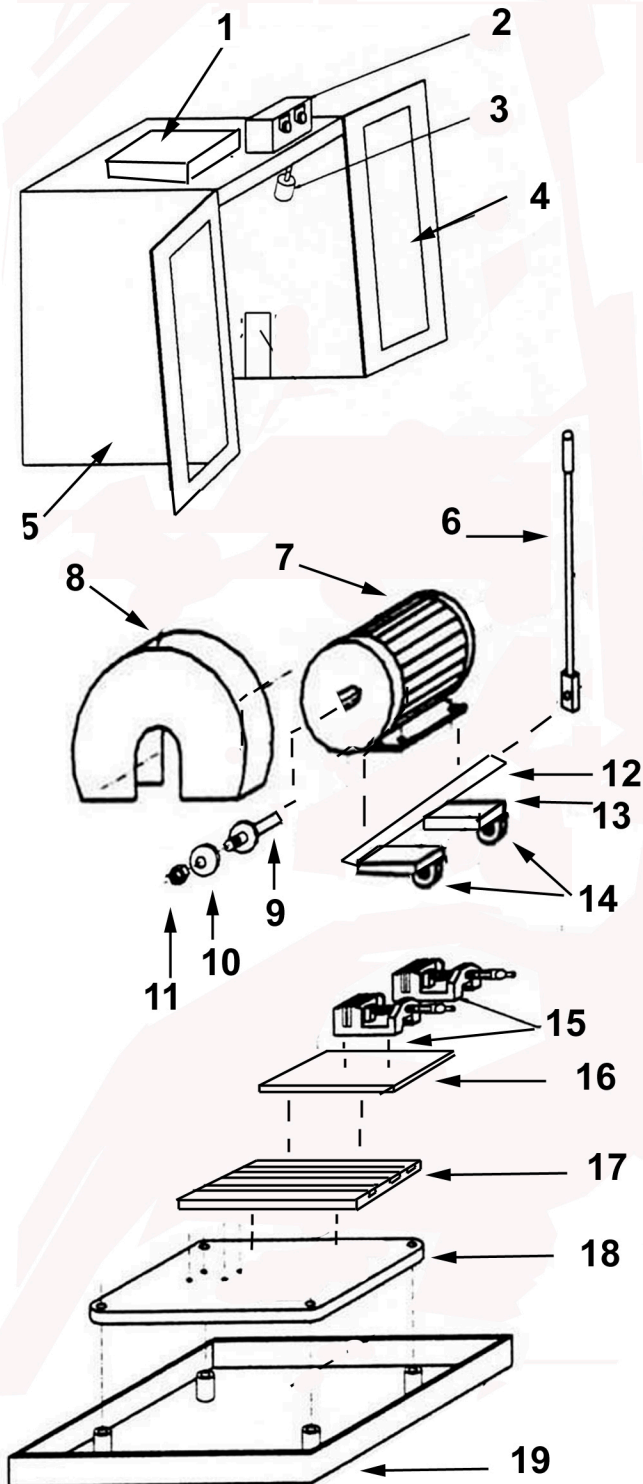
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Model: K10WBT  
 10" blade

No.	PART NO.	DESCRIPTION
1	710-023	NEMA BOX
2	710-030	SWITCH BOX
3	457-001	SPOTLIGHT
	457-002	24V/20W BULB
4	934-003	PLEXIGLASS WINDOW
5	124-008	CABINET, HOOD
6	381-008	HANDLE WITH GRIP
7	486-063	2HP, 3PH MOTOR
8	342-107	WHEEL GUARD
9	292-047	TIGHT FLANGE
10	292-008	LOOSE FLANGE
11		NUT
12	562-046	TRUNNION PIN
13	041-085	TRUNNION BRACKET (2)
14	044-032	PIVOT BEARINGS (2)
15	912-034	VISES (2)
16	556-130	VISE PLATE
17	829-052	T-SLOT TABLE
18	556-129	PLATE
19	050-052	BASE
	486-050	SUBMERSIBLE PUMP