

INSTRUCTION MANUAL

K26S PH



**KALAMAZOO
INDUSTRIES, INC.**

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Basic Controls

K26S PH

20 hp, 3 phase, 1" arbor, 1800 RPM @ spindle

1. Down feed speed control - Rotate CW to slow down feed, CCW to increase down feed rate. NOTE: Closing valve completely during cycle will stop saw head position anywhere needed.
2. UP- Returns saw head to UP position. NOTE: May be engaged anytime during cycle.
3. DOWN- Brings saw head DOWN . Control feed rate with (1).
4. START- Starts motor for saw blade.
5. STOP- Stops saw blade.
6. E STOP- Pull out to engage , PUSH IN to stop all functions.
7. Vise- Use to open and close the air vises. Input pressure to suit.
8. NEMA elec- Drill/punch holes for incoming AC power. Use a seat tite fitting around incoming AC lines to seal the enclosure. Input AC power to L1, L2, L3 on the top of the contactor. NOTE; BE SURE INCOMING AC POWER MATCHES MACHINE WIRING. VOLTAGE CHANGE FAILURES ARE NOT WARRANTED.
9. Down Stop cam- Controls when the saw head returns. Rotate the cam to contact the air button to bring the saw head back to the up position. Lock the cam in position with the set screw on the side of the cam so it will not rotate out of position. If using a steel blade also adjust the Thd. Down stop so as not to allow the steel blade to contact the steel saw top.
10. Air IN: Dual regulators control the saw down feed pressure and vise pressure. Adjust the saw down feed pressure to no more than 55-65 PSI. Over pressure will cause the oil reservoirs to leak. Adjust the vise pressure to suit the work piece.
11. Oil reservoirs- Use DTE24 light hyd. oil. Maintain oil levels of $\frac{1}{4}$ full on one reservoir and $\frac{3}{4}$ full on the other. Oil levels will alternate with the down feed cycle. Re-fill oil levels by : disconnect air to machine, remove pipe plugs on top of the reservoirs, fill to correct levels (see above), re-place pipe plugs. Bleed out air bubbles in the reservoirs by disconnecting the cylinder clevis rod from the saw arm. Cycle the DOWN button to allow the cylinder rod to fully extend and retract until all air bubbles in the oil are gone. Re-connect the cylinder rod to the saw arm.

12. Maintenance- Keep machine clean. Grease trunnion pillow block bearings every week depending on useage. Do not over tighten cog belt drive.

Basic Operation

K26S PHV OSC

26" wheel, 20 hp, 3 phase

1" arbor, 1800 rpm @ spindle

DTE24 hydraulic oil

BE SURE OF CORRECT AC POWER TO MACHINE. DRILL NEMA BOX FOR SEALTITE FITTINGS AROUND INCOMING WIRE. CONNECT AC POWER TO L1, L2, L3 ON CONTACTOR. IF NOT FAMILIAR WITH ELECTRICS CONTACT AN ELECTRICIAN. !! FACTORY IS NOT RESPONSIBLE FOR ELEC. FAILURE.

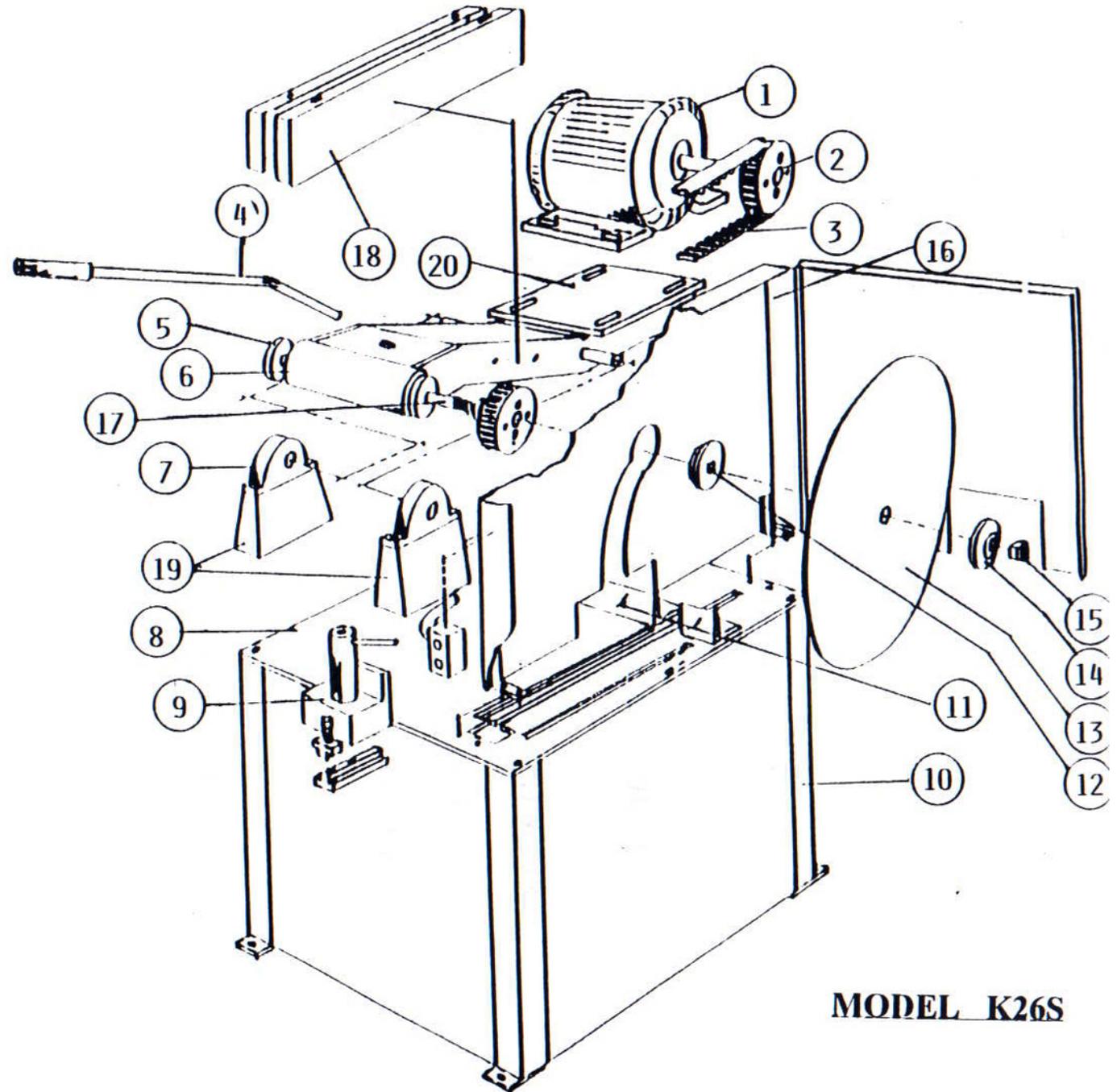
1. Start- Starts saw blade spindle.
2. Starts oscillation motor.
3. STOP- All stop.
4. Saw head UP- Engage to bring saw head UP. MAY BE ENGAGED ANYTIME DURING CYCLE TO BRING SAW HEAD UP.
5. DOWN- Engage to bring saw head DOWN.
6. Vise LOCK- Rotate handle /cam to tighten workpiece.
7. Vise opening adjustment- Loosen cap screw, slide vise up to workpiece, tighten cap screw to maintain adjustment, rotate handle /cam to tighten workpiece.
CAUTION: DO NOT ALLOW WORKPIECE TO MOVE DURING CUTTING! ABRASIVE WHEELS WILL BREAK!!!
8. Oscillation gear motor- Rotates arm to rock saw head back and forth to break the arc of contact of the abrasive wheel. Allows for faster cutting and better wheel life.
9. AIR IN- Connect DRY shop air to regulator. 0-55 PSI MAX.
10. Oil reservoirs- Dual oil reservoirs use DTE24 hyd. Oil. Maintain level of ¼ full on one reservoir and ¾ full on the other. Oil levels alternate with cycle.
11. Saw head return- Adjust plate to control depth of cut. When plate contacts air valve (13) saw head will return to top position.
12. Feed rate valve- Rotate valve to desired down feed speed. Rotate CW for slow feed rate, CCW for faster feed rate. Total closure of valve will stop down feed cycle.
13. Saw head return valve- Contacting this valve with plate (11) brings saw head back to top position. Adjust plate (13) to control depth of cut. Adjust as abrasive wheel wears. Re-adjust when replacing new abrasive wheel.
14. Maintenance- Grease all pillow block bearings on trunnions, oscillation shafts every 8 hrs.. Maintain oil levels in reservoirs. (see 10). Remove pipe plugs on top of the reservoirs with the air OFF to re-fill oil levels, replace plugs, connect air. To bleed air from reservoirs, remove cylinder rod clevis to allow full stroke of cylinder, cycle the cylinder back and forth fully as much as needed to allow air to escape.



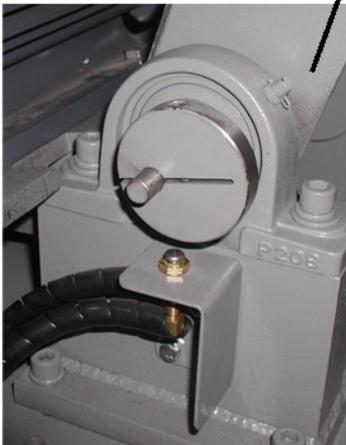
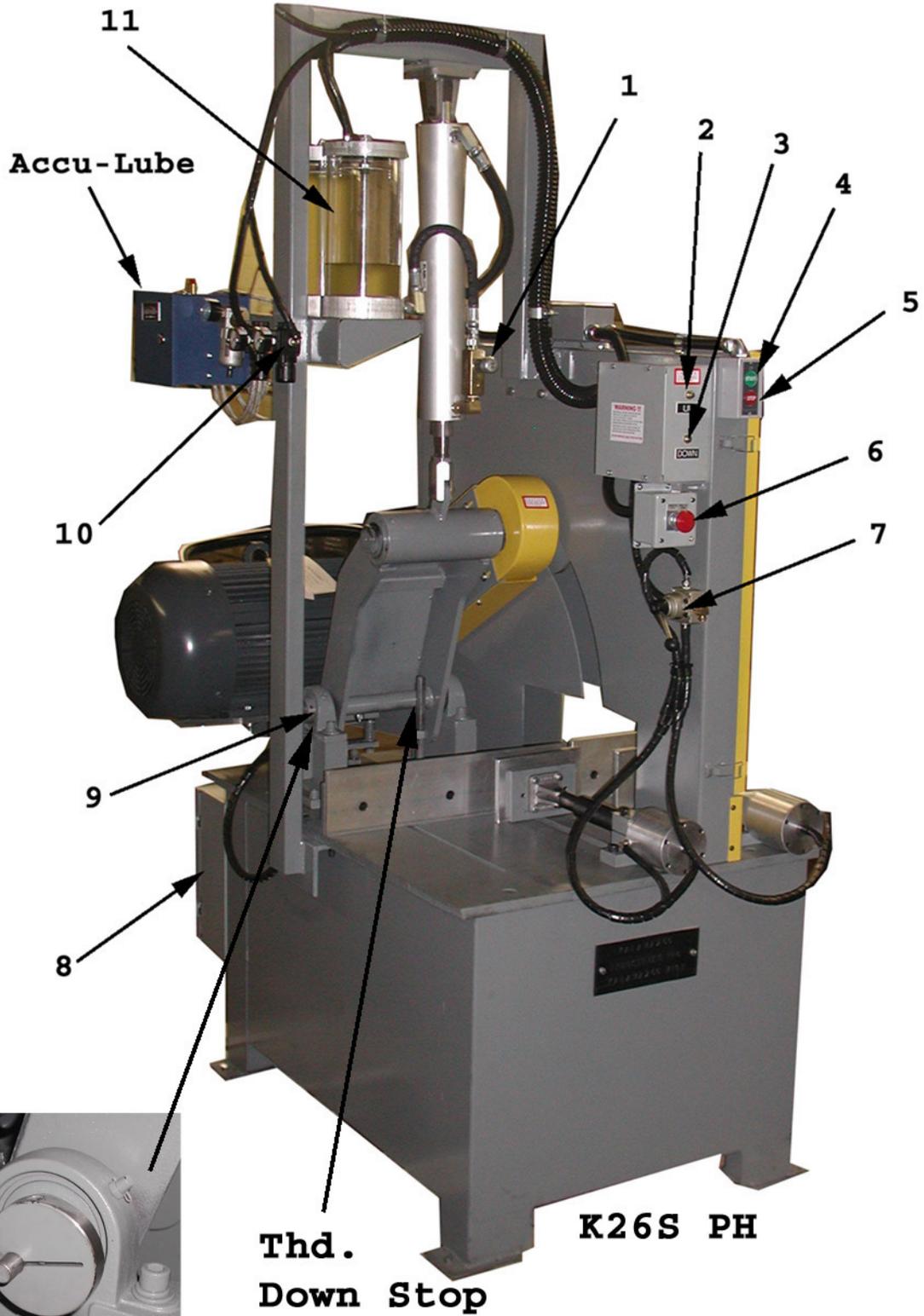
PART NO. DESCRIPTION QTY

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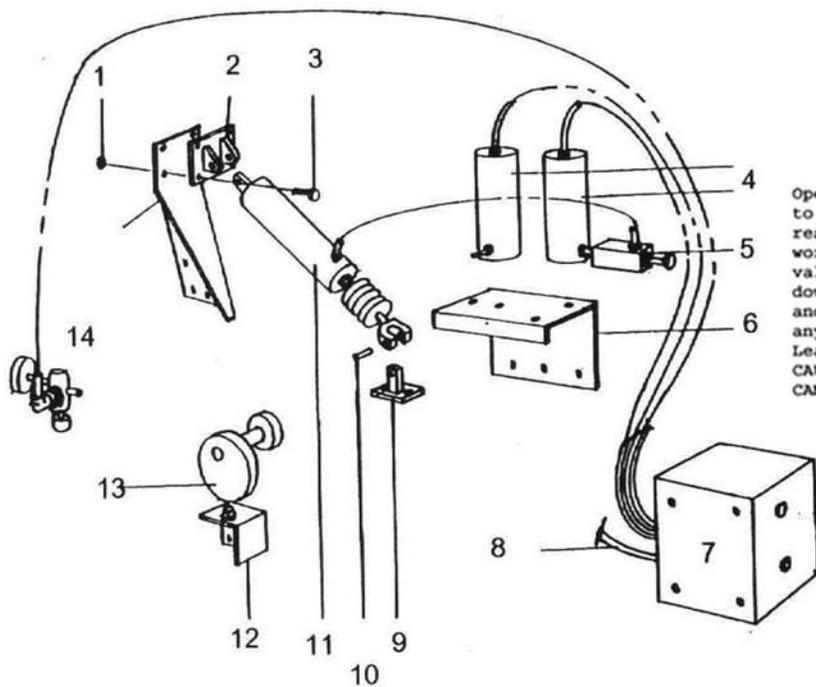
1	20HP MOTOR	1
2	560-027 PULLEY	2
3	051-008 TIMING BELT	1
4	381-008 SAW HANDLE W/GRIP	1
5	044-009 SPINDLE BEARING	2
6	002-013 SAW ARM	1
7	044-008 PILLOW BLOCK BRG	2
8	556-026 TOP PLATE	1
9	CV-26 VISE	1
10	716-004 SAW BASE	1
11	296-005 FENCE-LEFT	1
	296-006 FENCE -RIGHT	1
12	292-021 TIGHT FLANGE	1
13	26-R ABR WHEEL-NOT INCL.	1
14	292-013 LOOSE FLANGE	1
15	1-14" R.H. SPINDLE NUT	1
16	342-040 WHEEL GUARD	1
17	701-026 SPINDLE	1
18	342-041 BELT GUARD	1
19	053-015 TRUNNION BLOCK	2
	562-029 TRUNNION PIN	1
20	MOTOR MOUNT	1



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POWER DOWN FEED SYSTEM



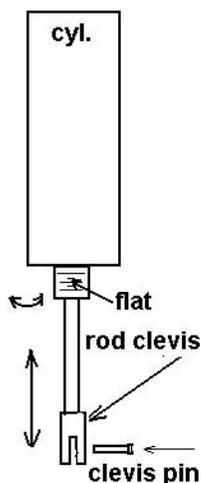
Operation: Input air into regulator. Set gage PSI to 55-60 Max.. (Over pressure will cause leaking reservoirs). Initially adjust saw downfeed WITHOUT workpiece to get used to the system. Use Flowcontrol valve (5) to set the downfeed speed. START button begins downfeed. At end of stroke cam (13)contacts bracket (12) and returns sawhead.NOTE: STOP button returns sawhead anytime during cutting cycle. Adjust Cam (13) as wheel wears. Leave cam (13) snug on shaft for easy adjustment. CAUTION: DO NOT ALLOW WHEEL TO CUT INTO SAW TOP. RE-ADJUST CAM WHEN A NEW WHEEL IS INSTALLED

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NO.	PART NO.	DESCRIPTION	QTY
1		3/8-16 NUT	4
2	041-033	BRACKET-SWIVEL	1
3		3/8-16 H.H.C.S. 1-1/2	4
4	641-010	OIL RESERVOIR	2
5	294-016	FLOW CONTROL	1
6	041-036	BRACKET-RESERVOIR	1
7		HYDRO CRONTOL BOX	1
8		POWER SUPPLY	1
9	041-034	BRACKET-TRUNNION	1
10	645-023	ROD, CLEVIS	1
11	131-006	CYLINDER	1
12	041-035	BRACKET-CAM	1
13	129-005	CAM	1
14	1000-37	AIR REGULATOR ASSY	1
15	041-024	BRACKET-CYLINDER	1

Bleeding the system of air



1. set air regulator to 50 psi MAX
2. remove clevis pin
3. remove rod clevis from cylinder.
4. push cycle START button , allow cyl. rod to pull back fully into cylinder.
5. Look at oil reservoir and check oil level. Oil Level should be just below deflector plate inside reservoir.
6. If Oil is needed (DTE24 oil) unplug airline, remove pipe plug from reservoir and add Oil just below plate.
7. Replace pipe plug in reservoir, re-connect air and cycle the START button several times to bleed air from system.

Note: be sure cylinder mounting threads are not tight in mounting bracket. The cylinder should twist left and right a small amount. If the cyl. threads are bound to tight with the bracket mounting screws, it will bind the cyl. rod. The flat on the cyl. threads should be visible through the bracket mounting screw holes.

Note: If air bubbles appear in oil when the saw head is up, there are bad seals in the cylinder. Wet air causes rust inside the air cylinder and creates rust rings inside the cyl. bore .

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.

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.

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.