

INSTRUCTION MANUAL

KM10, KM10HS



KI **KALAMAZOO
INDUSTRIES, INC.**

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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.

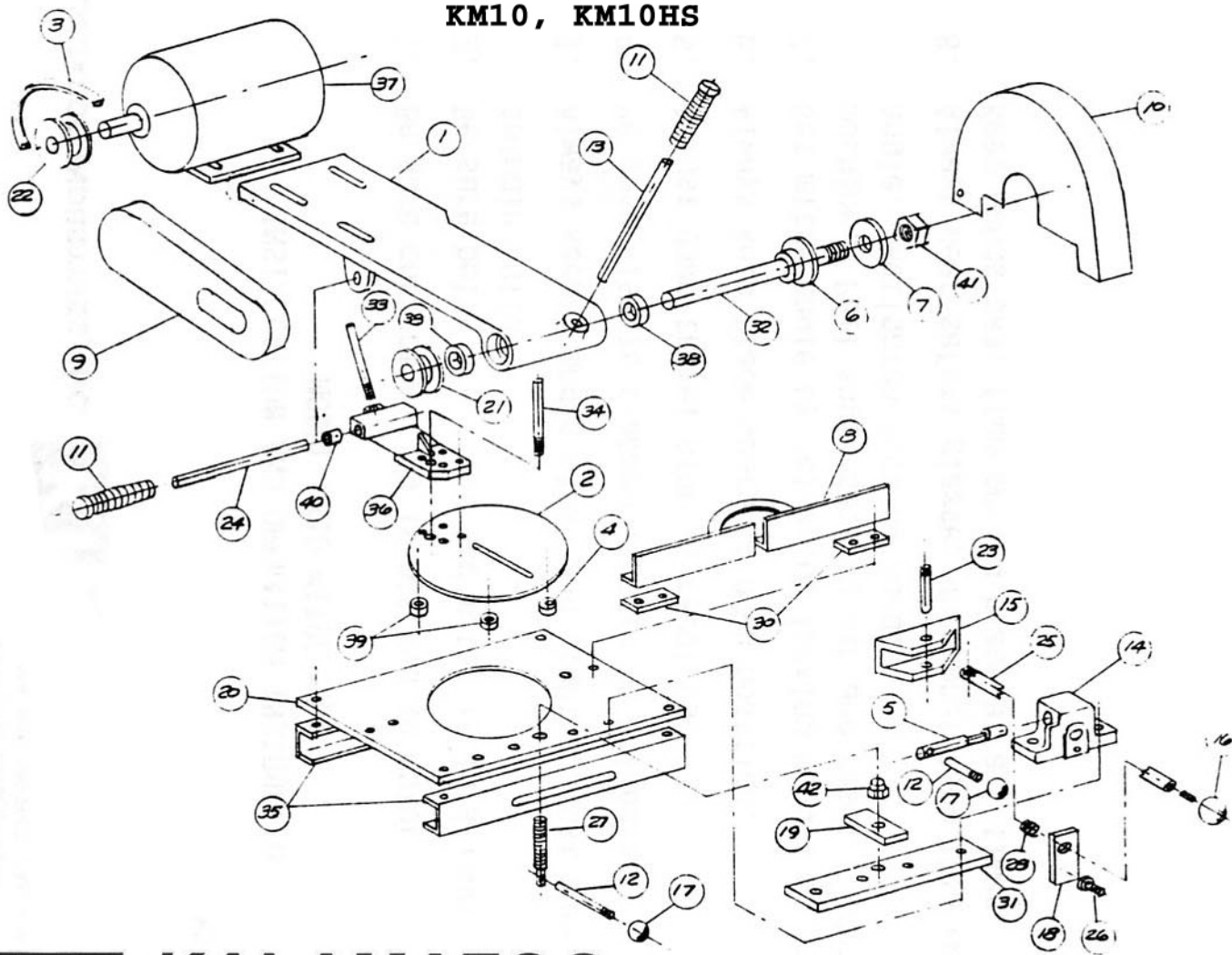
DO

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.

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NO.	PART NO.	DESCRIPTION
1.	002-006	SAW ARM
2.	050-013	MITRE PLATE BASE
3.	051-003	V-BELT 3V355
4.		ECCENTRIC BUSHING
5.	129-001	WISE LOCK CAM
6.	292-012	TIGHT FLANGE
7.	292-008	LOOSE FLANGE
8.	293-001	MITRE FENCE
9.	342-043	BELT GUARD
10.	342-006	WHEEL GUARD
	342-103	KM10HS clam grd
11.	347-001	HANDLE GRIP
12.	381-001	WISE LOCK HANDLE
13.	381-003	SAW HANDLE
14.	386-001	WISE HOUSING
15.	431-001	FRONT WISE JAW
16.	441-001	KNOB, WISE ROD
17.	441-002	KNOB, WISE HANDLE
18.	454-001	WISE LOCK
19.	454-004	TABLE LOCK
20.	556-008	MITRE PLATE
21.	560-045S	SPINDLE PULLEY
22.	560-045M	MOTOR PULLEY
23.	562-001	WISE JAW PIN
24.	562-008	TRUNNION PIN
25.	645-009	WISE ROD
26.	696-001	CAM WISE SCREW
27.	696-013	TABLE LOCK SCREW
28.	697-001	WISE ROD SPRING
29.	697-002	CAM WISE SPRING
30.	699-017	FENCE SPACER
31.	699-005	WISE SPACER
32.	701-003	SAW SPINDLE
33.	709-008	REAR ARM STOP
34.	709-007	FRONT ROD STOP
35.	711-002	PLATE SUPPORT
36.	831-013	TRUNNION
37.	MOTOR	3HP 1PH OR 3PH
38.	004-007	K10 BEARING
39.	38KTD	BEARING
40.	P-50-4	SLEEVE BEARING
41.	5/8-20	JAM NUT
42.	5/8-11	ACORN NUT

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Basic Operation

The KM10HS 10” abrasive mitres 45 degrees left or right and any angle in between.

Preset

Holes have been drilled and pinned at 45 and 90 degrees. To swivel the saw head pull the index pin (2) on mitre base plate (2) , loosen the table lock handle (12) rotate sawhead with trunnion pin (24). When desired angle is reached (45 deg or 90 deg.) replace index pin . With other angles there is no index pin hole. Use the table lock handle to lock the sawhead.

Two vises are provided for either left or right cuts. Typically only one vise is used depending on which way the sawhead is mitred. Dual vising can be used in the 90 degree position. Material must be straight to use both vises otherwise the workpiece may be straightened and will deform when cut pinching and breaking the abrasive wheel. Vise jaws swivel to mitre cut. If the workpiece is not as wide as the vise jaw use a shim on the other end of the jaw the same diameter/size as the workpiece to keep the jaw from swiveling . This will give even clamping. **BE SURE WORKPIECE IS SECURELY CLAMPED. ANY MOVEMENT DURING CUTTING WILL RESULT IN BLADE BREAKAGE!!**

Always use the correct abrasive wheel for the material being cut. Abrasive wheels come in different grades and bonds for specific materials. A good cut should be bright not blue or discolored. If discoloration occurs the wheel is not cutting and is heating up the material. Use enough pull down force to make the wheel cut and breakdown. Consult your dealer for abrasive blades.

Part Location can sometimes result in cutting problems. Be sure workpiece is slightly ahead of wheel center (towards operator). On small diameter parts shim out the workpiece to bring it towards the operator and slightly past wheel center. Keep wheel flanges clean and flat to ensure true running of the wheel.

Spindle can be locked to change the wheel by using one of the vise jaw pins in the hole in the spindle housing. The spindle nut is a LH thread. Do not hammer tighten.

Maintenance

Always check V belt drives for correct tension. Loose drive belts cause slipping and poor cutting. Tighten V belts by loosening motor bolts, use a belt tightener to spread the pulleys for tension. Approximately ½” of squeeze is needed on the V belts for good tension. Use a straight edge to keep both pulley faces parallel to eliminate V belt wear when tightening. Keep machine and work area CLEAN. Ball bearings are sealed and do not need greasing. Follow safety precautions. **WEAR SAFETY GLASSES, DO NOT WEAR GLOVES, LONG HAIR, LOOSE CLOTHING THAT CAN GET CAUGHT IN THE BLADE !!**