

INSTRUCTION MANUAL

KM14HS



**KALAMAZOO
INDUSTRIES, INC.**

6856 East K Avenue

Kalamazoo, MI 49048

269-382-2050 PH

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www.kalamazooindustries.com

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KDM14



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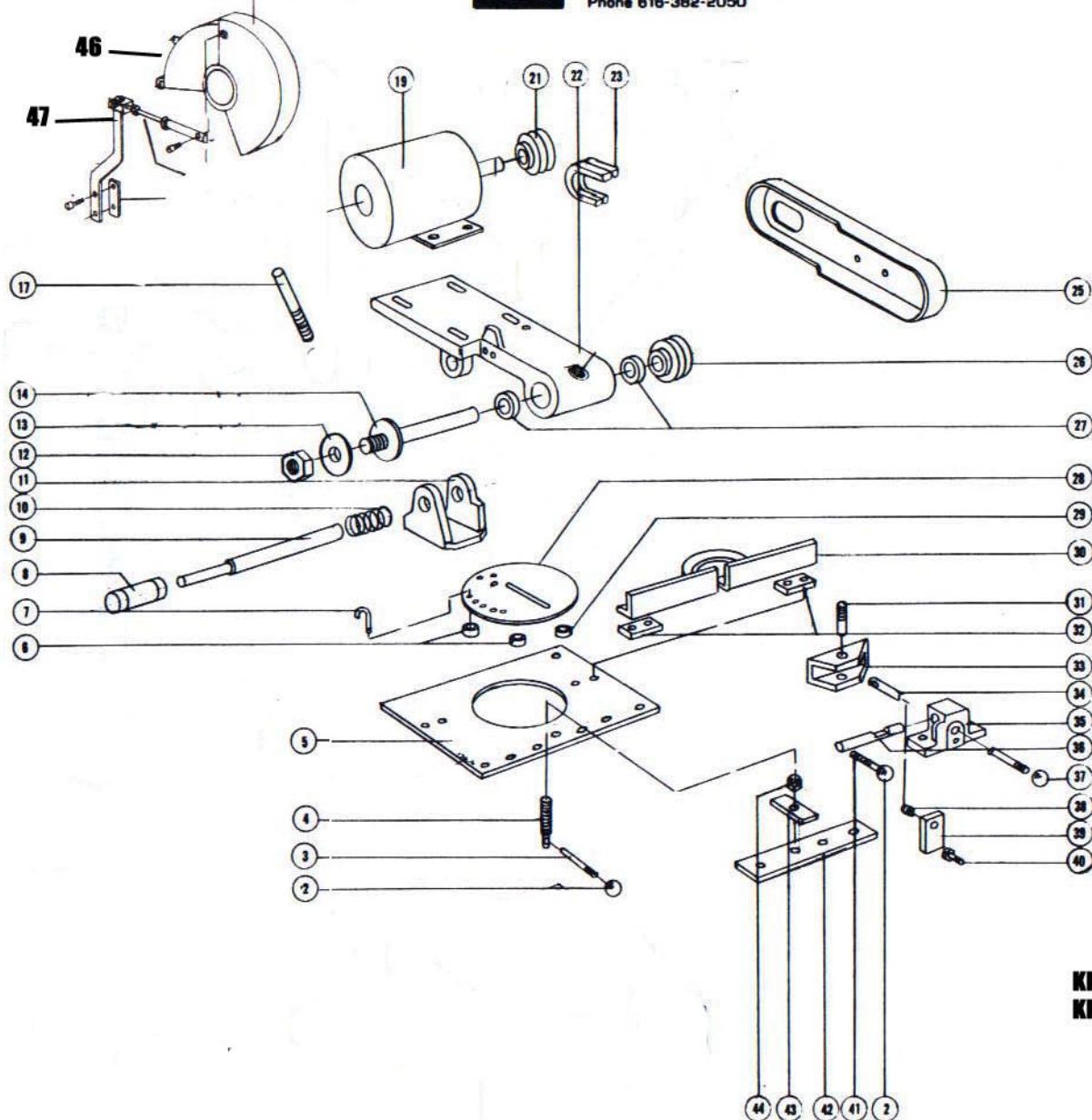
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KALAMAZOO INDUSTRIES



6855 E. Michigan Ave./Box 2558
 Kalamazoo, Michigan 49003
 Phone 616-382-2050



NO.	PART NO.	DESCRIPTION	QTY
1.	716-001	STAND	1
2.	441-002	KNOB, VISE & TABLE LOCK HANDLE	3
3.	381-012	TABLE LOCK HANDLE	1
4.	696-013	TABLE LOCK SCREW	1
5.	556-008	MITRE PLATE STAND TOP	1
6.	38KDT	BALL BEARING	2
7.	562-020	TABLE INDEX PIN	1
8.	347-003	HANDLE GRIP	2
9.	562-019	TRUNNION PIN	1
10.	697-018	TRUNNION SPRING	1
11.	831-010	TRUNNION	1
12.		1-14 L.H. SPINDLE NUT	1
13.	292-004	LOOSE FLANGE	1
14.	701-002	SPINDLE W/TIGHT FLANGE	1
17.	645-013	STOP ROD	1
19.		5HP MOTOR	1
21.	560-002	MOTOR PULLEY	1
22.	002-002	SAW ARM	1
23.	051-006	V-BELT	2
24.	381-002	SAW HANDLE	1
25.	342-004	BELT GUARD	1
26.	560-001	SPINDLE PULLEY	1
27.	044-001	K12 BEARING	2
28.	050-013	MITRE PLATE BASE	1
29.	053-001	ECCENTRIC BUSHING (W/044-007)	1
30.	293-001	MITRE FENCE	1
31.	562-002	VISE JAW PIN	2
32.	699-014	FENCE SPACER	2
33.	431-001	VISE JAW	2
34.	645-009	VISE ROD	2
35.	386-001	VISE HOUSING	2
36.	129-001	VISE LOCK CAM	2
37.	441-001	KNOB, VISE ROD	2
38.	697-001	VISE ROD SPRING	2
39.	454-001	VISE LOCK	2
40.	696-001	VISE CAM SCREW	2
41.	381-001	VISE LOCK HANDLE	2
42.	699-005	VISE SPACER	1
43.	454-004	TABLE LOCK	1
44.		5/8-11 TABLE NUT	1
45.		MANUAL STARTER	1

46. 342-072 clam guard
47. 455-007 lever

**KM14Sc&
 KM14HS Only**

KDM14 HEAD ASSY.

SCALE:	APPROVED BY:	DRAWN BY:
DATE:		REVISED:
		DRAWING NUMBER:

Basic Operation - Non Ferrous Mitre Saw

The KM14HS 14" non-ferrous saw mitres 45 degrees left or right and any angle in between. Pre-set index holes have been drilled and pinned at 45 and 90 degrees. To swivel the saw head pull the index pin (7) on mitre base plate (5), loosen the table lock handle (3) rotate sawhead with trunnion pin (9). 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 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 blade for the material being cut. Blades come in different tooth counts and bonds for specific materials. Consult your dealer for carbide tipped 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.

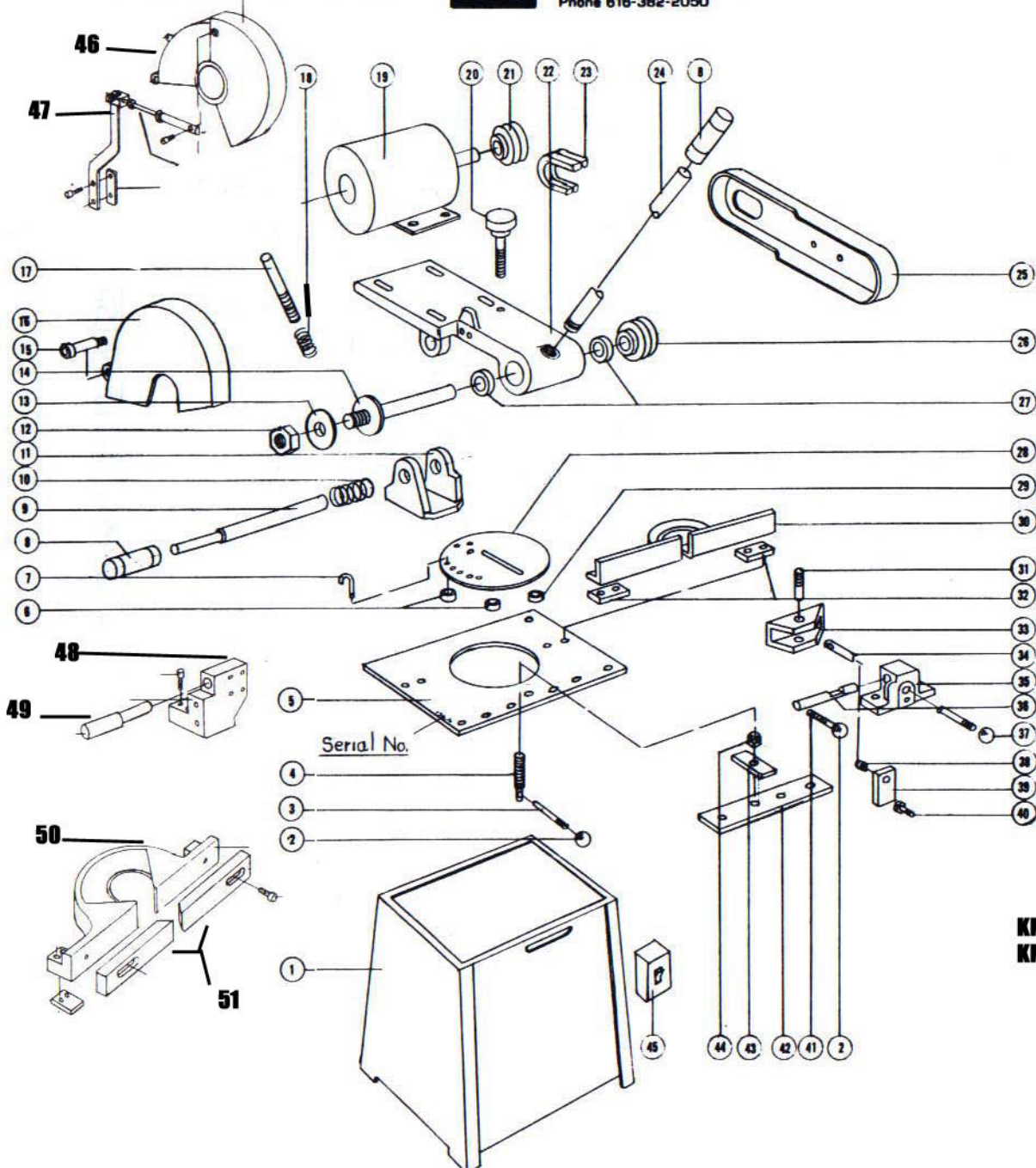
Maintenance

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 1/2" 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 !!**

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5.	556-008	MITRE PLATE STAND TOP	1
6.	044-006	BALL BEARING	2
7.	562-020	TABLE INDEX PIN	1
8.	347-003	HANDLE GRIP	2
9.	562-019	TRUNNION PIN	1
10.	697-018	TRUNNION SPRING	1
11.	831-010	TRUNNION	1
12.		1-14 L.H. SPINDLE NUT	1
13.	292-004	LOOSE FLANGE	1
14.	701-002	SPINDLE W/TIGHT FLANGE	1
15.		5/8" SHOULDER BOLT	1
16.	342-025	WHEEL GUARD	1
17.	645-013	STOP ROD	1
18.	9-1608-11	STOP SPRING (DANLY)	1
19.		5HP MOTOR	1
20.	696-014	STOP SCREW (W/441-004 KNOB)	1
21.	560-002	MOTOR PULLEY	1
22.	002-002	SAW ARM	1
23.	051-006	V-BELT	2
24.	381-002	SAW HANDLE	1
25.	342-004	BELT GUARD	1
26.	560-001	SPINDLE PULLEY	1
27.	044-001	K12 BEARING	2
28.	050-036	MITRE PLATE BASE	1
29.	053-001	ECCENTRIC BUSHING (W/044-007)	1
30.	293-001	MITRE FENCE	1
31.	562-002	VISE JAW PIN	2
32.	699-014	FENCE SPACER	2
33.	431-001	VISE JAW	2
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40.	696-001	VISE CAM SCREW	2
41.	381-001	VISE LOCK HANDLE	2
42.	699-005	VISE SPACER	1
43.	454-004	TABLE LOCK	1
44.		5/8-11 TABLE NUT	1
45.		MANUAL STARTER	1

- 46. 342-072 clam guard**
- 47. 455-007 lever**
- 48. 831-022 trunnion**
- 49. 562-019 Trunnion Pin**
- 50. 294-017 Fence**
- 51. 556-046 Alum.Fence Plate**

**KM14SC &
 KM14HS Only**

KMI4 , KM14HS, KM14SC		
SCALE:	APPROVED BY:	DRAWN BY:
DATE:		REVISED:
		DRAWING NUMBER: