

# **INSTRUCTION MANUAL K7B, K8B**



**KALAMAZOO  
INDUSTRIES, INC.**

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# Kalamazoo Industries Inc.

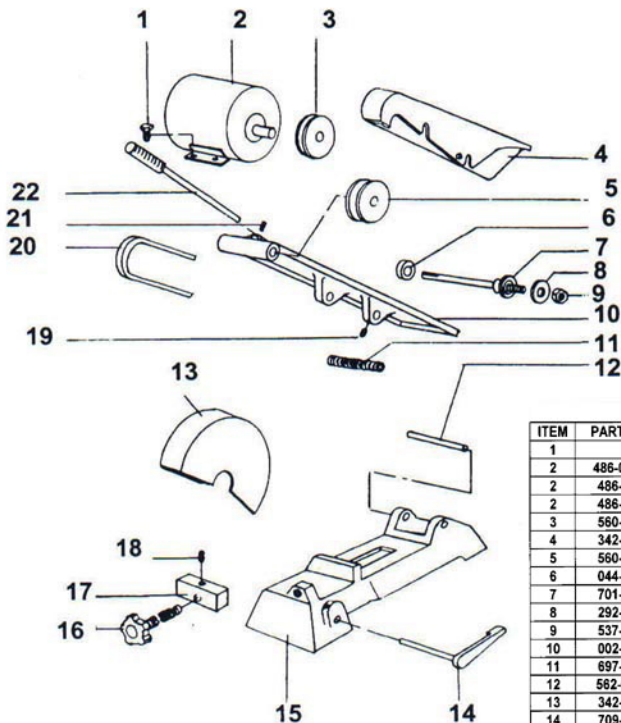
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## MODEL K7B & K8B ABRASIVE SAW



ITEM	PART NO.	DESCRIPTION	QTY
1		H.C.S.	4
2	486-002A	1HP, 1PH MOTOR - K7B	1
2	486-006	3HP, 1PH MOTOR - K8B	1
2	486-007	3HP, 3PH MOTOR - K8B	1
3	560-004	5/8" MOTOR PULLEY	1
4	342-002	BELT GUARD	1
5	560-003	1/2" SPINDLE PULLEY	1
6	044-012	77110X BEARING	2
7	701-001	SPINDLE W/TIGHT FLANGE	1
8	292-002	LOOSE FLANGE	1
9	537-024	SPINDLE NUT	1
10	002-001	SAW ARM	1
11	697-005	TRUNNION SPRING	1
12	562-004	TRUNNION PIN	1
13	342-001	WHEEL GUARD	1
14	709-001	STOP ASSEMBLY	1
15	050-001	SAW BASE	1
16	696-002	SCREW VISE ASSY	1
17	431-003	VISE BLOCK	1
18		1/4-20 S.S.S.	1
19		1/4-20 S.S.S.	1
20	051-001	4L-330 V-BELT	1
21		1/4-20 S.S.S.	1
22	381-003	SAW HANDLE W/GRIP	1

	702-001	SPINDLE ASSEMBLY-OPTIONAL	1
		INCLUDES SPINDLE, TIGHT FLANGE,	
		LOOSE FLANGE, BEARING AND NUT	

### Basic Operation:

1. Be sure work piece is held securely. Any part movement will break abrasive blades.
2. Abrasive wheel grades vary. Use Kalamazoo Ind. non-reinforced 7" or 8" abrasive wheels. 7" # KAB7N or 8" KAB8N, 1/2" arbor. Heavy reinforced wheels in this diameter do not cut. Good cuts are bright, not burned or discolored.
3. Keep V belts tight (1/2" squeeze) and pulleys lined up straight. Use a v belt tensioner to tension belts.
4. DO NOT USE STEEL TOOTHED BLADES!! GUARDING IS FOR ABRASIVE ONLY!!

## **WARNING!**

TO REDUCE THE RISK OF FIRE OR SHOCK HAZARD,  
DO NOT EXPOSE THIS EQUIPMENT TO RAIN, ANY LIQUID OR MOISTURE.

### **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

ELECTRIC MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR STANDING ON A WET FLOOR.

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.



## Basic Operation

K7B , 7" wheel, ½" arbor, 1 hp. K8B, 8" wheel, ½" arbor, 3 hp.

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. Work piece movement during cutting will result in broken abrasive blades.
4. Down stop screw located on saw base (15) under the saw arm (10) must be adjusted so the abrasive wheel 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 wears 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 STANDARDS.**
6. Select the correct abrasive wheel for the material. Every abrasive wheel performs differently. With low HP motors a free cutting wheel like the Kalamazoo Industries, Inc. # KAB7N or KAB8N non-reinforced wheels give free cutting on most materials. Good cuts are bright like the material, not burned or discolored. If burning occurs then select another grade of abrasive wheel. Consult your dealer or the factory for wheel grade selection. It may take many test cuts on different wheels to obtain the wheel that works the best. Use enough cutting force to make the wheel wear or "break down".
7. Always follow safety procedures. Wear safety glasses, never wear gloves or loose fitting clothing that can get caught in the moving parts. Keep hands out of sawing area when cutting. See safety sheet.
8. V belts stretch with use over time. Keep V belts tight with ½" of "squeeze" . Use a V belt tensioner to tighten V belt. Keep both faces of spindle and motor pulley aligned in the same plane with a straight edge. Check pulley set screws to be sure they are tight.

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