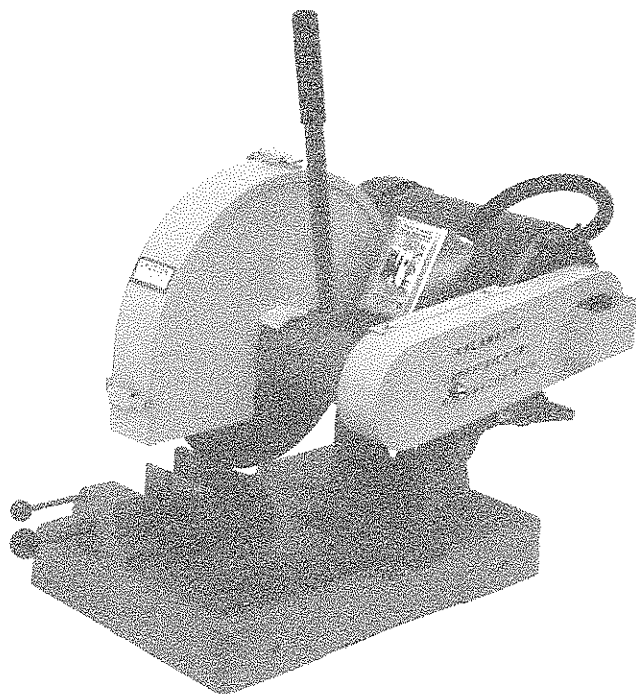


**INSTRUCTION
MANUAL
MODEL NO. K12B / K14B
SAW**



**KALAMAZOO
INDUSTRIES, INC.**

6856 East K Avenue
Kalamazoo, MI 49048
269-382-2050
269-382-0790

www.kalamazooindustries.com

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.



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INSTRUCTIONS FOR MODEL K12-K14 ABRASIVE SAWS

KALAMAZOO K12B & K14B 12" OR 14" ABRASIVE SAWS ARE DESIGNED FOR ABRASIVE CUT-OFF WHEELS. STEEL TOOTHED BLADES ARE NOT RECOMMENDED AND GUARDING IS NOT DESIGNED FOR STEEL BLADE OPERATION.

ABRASIVE WHEEL SELECTION IS VERY IMPORTANT. INCORRECT WHEEL SELECTION WILL RESULT IN POOR CUTTING PERFORMANCE, DISCOLORATION OF CUT PART AND OVERHEATING OF DRIVE MOTOR. PLEASE CONSULT YOUR LOCAL DISTRIBUTOR OF ABRASIVE WHEELS FOR PROPER WHEEL SELECTION. BE CERTAIN CORRECT WIRING IS MATCHED TO MOTOR.

OPERATION

K12B & K14B ARE MANUALLY OPERATED MACHINES. BEFORE CUTTING BE SURE TO CHECK THE FOLLOWING:

BE SURE THE PART IS CLAMPED SECURELY IN VISE/ CHAIN/ FIXTURE. ANY PART MOVEMENT WILL RESULT IN BROKEN BLADES. ALWAYS WEAR SAFETY GOGGLES.

CHECK PART LOCATION: PART CENTERLINE SHOULD BE AHEAD OF WHEEL CENTERLINE. DO NOT CLIMB CUT. USE SHIMS OR SPACERS TO MOVE PART OUT TOWARDS OPERATOR TO AVOID CLIMB CUTTING.

USE A SMOOTH STEADY PULLING ACTION WHEN CUTTING. IF NO SPARKS ARE PRESENT THE BLADE IS NOT WORKING CORRECTLY. FINISHED CUTS SHOULD BE BRIGHT NOT BLUE OR YELLOW. THIS INDICATES TOO MUCH HEAT IF PART IS DISCOLORED. CHECK WHEEL GRADE SELECTION, PART CENTERLINE LOCATION AND CUTTING RATE BEFORE PROCEEDING.

KEEP DOWNSTOP ADJUSTED CORRECTLY (5) SO AS NOT TO OVERCUT INTO THE SAW TABLE. DOWN STOP IS ADJUSTED BY USING THE ALLEN SCREW.

ALWAYS KEEP BLADE GUARD IN DOWN POSITION. ALWAYS WEAR SAFETY GLASSES AT ALL TIMES.

NEVER WEAR GLOVES OR LOOSE FITTING CLOTHING WHEN OPERATING MACHINE. KEEP LONG HAIR TIED BACK.

NEVER PUT HANDS DIRECTLY INTO SAWING AREA WHILE MACHINE IS IN OPERATION.

TO SET MITRE VISE TO PROPER ANGLE, RELEASE BACK UP FENCE PINS AND LOOSEN ALLEN CAP SCREWS ON TOP OF BACK UP FENCE. RESET ANGLE BY TIGHTENING CAP SCREWS ON BACK UP FENCE.

MAINTENANCE

KEEP V-BELTS TIGHT. NORMAL USE RESULTS IN STRETCHING. CHECK FREQUENTLY, DEPENDING ON THE USEAGE OF THE MACHINE.

MAKE SURE DRIVE PULLEY AND SPINDLE PULLEY REMAIN IN LINE. BOTH OUTER EDGES OF PULLEYS SHOULD BE IN GOOD ALIGNMENT.

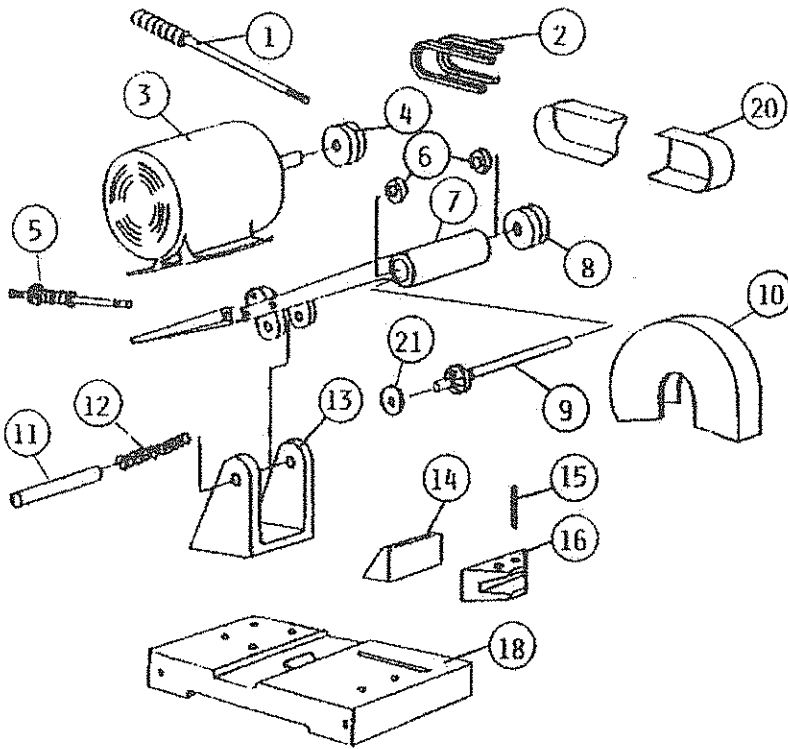
KEEP SPINDLE FLANGES CLEAN, SMOOTH AND FREE OF ABRASIVE DUST. KEEP WORK AREA CLEAN.



Made in U.S.A.

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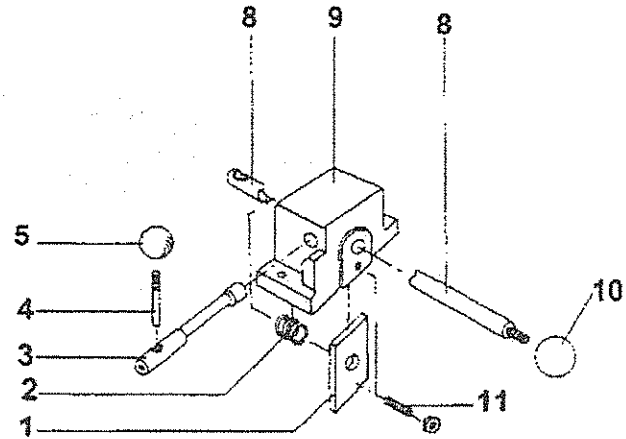
MODEL K12B & K14B PARTS DIAGRAM



No.	Part No.	Description	QTY
1	381-002	Handle W/Grip	1
2	051-006	V-Belts	2
3	486-001	5Hp 3Ph 3450 RPM	1
	486-023	5Hp 1Ph 3450 RPM (optional)	1
4	560-002	Motor Pulley (Bushing Soid Separately)	1
	049-022	Bushing For Motor Pulley	1
5	645-004	Stop Assembly	1
6	044-001	Bearings	2
7	002-002	Saw Arm	1
8	560-001	Spindle Pulley	1
9	701-002	Spindle W/Flange	1
10	342-025	14" Wheel Guard	1
	342-003	12" Wheel Guard (optional)	
11	562-003	Trunnion Pin	1
12	697-018	Trunnion Spring	1
13	041-003	Trunnion	1
14	431-002	Rear Vise Jaw	1
15	562-001	Vise Jaw Pin	1
16	431-001	Front Vise Jaw	1
17	386-001	Vise Housing	1
18	050-002	Saw Base	1
19	645-001	Vise Rod W/Knob	1
20	342-004	Belt Guard	1
21	292-004	Loose Flange	1
	912-015	Vise Assembly/Less Jaws	1
	702-004	Spindle Assembly (Spindle, Bearings, Loose Flange and nut) (All K12B-K14B Units.) (Optional)	1
	041-007	Foot Pedal ONLY (For K12SSF-14SSF Only)	1
	041-007B	Foot Pedal/Chain Vise Assy (K12SSF-K14SSF Only)	1
	912-001	V-Block, Chain Vise (K12SSF-K14SSF Only)	1
	342-086	Inner Belt Guard (For all models)	1
	002-002AS	Arm Assembly (Arm and Spindle Assembly)	1

WISE ASSEMBLY PARTS DIAGRAM

NO.	PART NO.	DESCRIPTION
1	454-001	LOCK, VISE
2	697-001	SPRING, VISE ROD
3	129-001	CAM, VISE LOCK
4	381-001	HANDLE, VISE LOCK
5	441-002	KNOB, VISE LOCK HANDLE
8	645-001	ROD, VISE (SHORT)
9	386-001	VISE HOUSING
10	441-001	KNOB, VISE ROD
11	696-001	SCREW, VISE CAM
	912-015	COMPLETE VISE ASSY LESS JAW



WARRANTY

All products are guaranteed for a period of one year to the original purchaser, against defects in material workmanship under normal use. Electric motors are warranted by the motor manufacturer and will be repaired by the nearest motor repair station. If non-repairable, they will be replaced by Kalamazoo Industries. Please call for instructions 269-382-2050.

RETURN POLICY

Authorization must be obtained before returning merchandise. Please call our customer service department for a return authorization number at 269-382-2050. Please include with your return a copy of your invoice or packing slip. Materials must be sent back prepaid. (Unless otherwise indicated). All returns will be subject to a 10% restocking charge. No returns will be accepted after one year of invoice date.

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