



# MODEL K20FS

20" Industrial Abrasive  
Foundry Saw

## EQUIPMENT MANUAL

**KALAMAZOO INDUSTRIES, INC.**

Kalamazoo, Michigan  
Toll-Free: 1-800-592-2050  
[www.kalamazooind.com](http://www.kalamazooind.com)  
**Made in the USA**



## 1. Introduction

Thank you for choosing the Kalamazoo Industries K20FS 20-Inch Industrial Abrasive Foundry Saw. This heavy-duty cutting machine is designed for demanding industrial applications where power, precision, and durability are essential.

The K20FS features a powerful 15 HP or 20 HP motor operating at 2500 RPM, delivering exceptional cutting performance for tough materials. Built with a cast iron trunnion and saw arm, along with a steel top and base, this machine offers reliable operation in professional foundry and industrial environments.

Please read this manual thoroughly before operating the equipment. Proper understanding of the machine's features, safety requirements, and maintenance procedures will ensure optimal performance and longevity.

### 1.1 Intended Use

The K20FS is specifically designed for heavy-duty cutting applications including:

- Cutting gates and risers on gray cast iron parts
- Trimming excess material from castings
- Cutting ferrous metals including steel and iron
- Sectioning large castings for further processing
- Investment casting process applications

## 2. Safety Information

### **⚠ WARNING**

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

**Read all safety instructions before operating this equipment. Failure to follow safety guidelines may result in serious injury or death.**

### 2.1 General Safety Precautions

1. Always wear appropriate personal protective equipment (PPE) including safety glasses, hearing protection, face shield, and work gloves.
2. Keep the work area clean and well-lit. Cluttered or dark areas invite accidents.
3. Do not operate the saw under the influence of drugs, alcohol, or medication that may impair judgment.
4. Keep bystanders at a safe distance from the operating machine.
5. Never leave the machine running unattended.
6. Ensure proper ventilation when operating the machine.
7. Disconnect power before changing wheels or performing maintenance.
8. Securely position all workpieces before cutting.

### 2.2 Electrical Safety

- Ensure proper grounding of the machine before operation.
- Verify voltage requirements match your facility's electrical supply (220V/440V three phase).
- Use only qualified electricians for electrical connections and repairs.
- Check power cords, plugs, and switches regularly for damage.

### 3. Technical Specifications

#### 3.1 Motor and Performance

Specification	Details
Motor Power	15 HP or 20 HP
Voltage	3 Phase (220V/440V)
Spindle Speed	2500 RPM
Spindle	1" spindle with sealed ball bearings
Switch	Magnetic push button on/off switch

#### 3.2 Wheel Specifications

Specification	Details
Wheel Size	20" abrasive cutoff wheel
Wheel Type	Abrasive cutoff wheel (not included)
Arbor Size	1" bore

#### 3.3 Construction

Specification	Details
Trunnion	Cast iron trunnion
Saw Arm	Cast iron saw arm
Top and Base	Heavy-duty steel construction
Wheel Guard	Open front all-steel wheel guard
Design	Step-in front for easy access
Operation Style	Fixed saw arm position, chop style

#### 3.4 Dimensions and Weight

Specification	Details
Machine Dimensions	L 48" x W 48" x H 35"
Shipping Weight	2100 lbs (subject to change)
Country of Origin	Made in USA

## 4. Installation and Setup

### 4.1 Unpacking and Inspection

9. Carefully remove the saw from its shipping container using appropriate lifting equipment.
10. Inspect for any shipping damage before discarding packaging materials.
11. Verify all components are present according to the packing list.
12. Report any damage or missing items to Kalamazoo Industries immediately.
13. Remove any protective coatings from machined surfaces.

### 4.2 Location Requirements

- Place the machine on a stable, level floor capable of supporting the machine weight (approximately 2100 lbs).
- Ensure adequate clearance around all sides for operation and maintenance (minimum 48" recommended).
- Provide adequate lighting and ventilation.
- Consider spark and debris management when positioning the machine.
- Keep combustible materials away from the cutting area.

**CAUTION: Electrical connections must be performed by a qualified electrician in accordance with local electrical codes.**

### 4.3 Electrical Connection

14. Verify the voltage requirements match your facility's power supply (220V/440V three phase).
15. Connect to an appropriately rated circuit with proper overcurrent protection.
16. Ensure proper grounding according to electrical code requirements.
17. Check motor rotation direction before operating. The wheel should rotate in the correct direction as indicated by the arrow on the wheel guard.

## 5. Operation Instructions

### 5.1 Pre-Operation Checklist

- Inspect the abrasive wheel for damage, cracks, or excessive wear
- Verify the wheel is properly mounted and secured
- Ensure the wheel guard is securely in place
- Confirm the work area is clean and free of obstructions
- Put on required personal protective equipment (safety glasses, face shield, hearing protection, gloves)

### 5.2 Cutting Procedure

18. Position the workpiece securely on the work surface.
19. Stand to the side of the wheel (not directly in front).
20. Turn on the machine using the magnetic push button switch.
21. Allow the wheel to reach full operating speed before beginning the cut.
22. Lower the saw arm smoothly to engage the workpiece.
23. Apply consistent, moderate pressure; let the wheel do the work.
24. Keep sparks directed away from yourself, others, and combustibles.
25. Upon completion, turn off the machine and wait for the wheel to stop completely.

### 5.3 Tips for Best Results

- Use consistent, moderate pressure; excessive pressure reduces wheel life and cutting efficiency.
- Select the appropriate wheel type for your material.
- Allow the wheel to cut at its natural rate to prevent overheating.
- Secure workpieces properly to prevent movement during cutting.
- Keep hands and fingers clear of the cutting area at all times.

### 5.4 Wheel Replacement

To change the abrasive cutoff wheel:

26. Disconnect power from the machine.
27. Remove the wheel guard to access the wheel.
28. Remove the outer flange and arbor nut.
29. Carefully remove the old wheel.
30. Inspect the new wheel for cracks or damage before installation.
31. Install the new wheel ensuring proper seating on the inner flange.
32. Replace the outer flange and arbor nut.
33. **Hand tighten with wrench only.** Do not overtighten.
34. Replace the wheel guard securely.
35. Test run the machine briefly before cutting to ensure proper operation.

## 6. Maintenance

### 6.1 Daily Maintenance

- Inspect abrasive wheel for wear, damage, or cracks; replace if necessary
- Check that wheel guard is properly secured
- Clean dust and debris from around the saw, wheel guard, and motor vents
- Verify on/off switch operates properly
- Inspect electrical connections for signs of wear or damage

### 6.2 Weekly Maintenance

- Inspect wheel flanges for wear or damage; clean as needed
- Check fasteners and mounting bolts to ensure the machine is securely tightened
- Inspect V-belts for tension and signs of wear; replace if frayed or loose
- Check electrical connections for signs of corrosion or looseness

### 6.3 Monthly Maintenance

- Inspect motor ventilation openings and clean thoroughly to prevent overheating
- Examine machine frame and base for signs of vibration fatigue or loose hardware
- Check overall saw performance for unusual noise or vibration
- Inspect spindle bearings for noise or rough operation
- Full motor inspection - check for signs of overheating or unusual wear
- Inspect safety guards and stops; replace any worn or faulty components

### 6.4 Wheel Replacement

Replace wheels when they show signs of wear, visible damage, cracks, or reduced cutting performance. Follow the wheel installation procedure in Section 5.4. Always disconnect power before changing wheels.

**IMPORTANT: Hand tighten with wrench only.** Over-tightening the arbor nut can damage the wheel and create a safety hazard.

## 7. Troubleshooting

<b>Problem</b>	<b>Possible Cause</b>	<b>Solution</b>
Saw will not start	Power disconnected	Check power supply and connections
	Faulty switch	Replace magnetic switch
	Tripped circuit breaker	Reset breaker or replace fuse
Wheel slowing during cut	Dull or glazed wheel	Replace wheel
	Excessive pressure	Reduce cutting pressure
	Loose V-belt	Adjust belt tension
Poor cutting performance	Worn wheel	Replace wheel
	Wrong wheel type	Select appropriate wheel for material
	Excessive pressure	Reduce pressure on workpiece
Excessive vibration	Loose mounting hardware	Tighten all fasteners
	Worn spindle bearings	Replace bearings
	Damaged or unbalanced wheel	Replace wheel
Excessive noise	Worn bearings	Replace bearings
	Loose components	Tighten all fasteners
	Wheel damage	Inspect and replace wheel
Motor overheating	Blocked ventilation	Clean motor vents
	Overloading	Reduce cutting pressure/rate
	V-belt too tight	Adjust belt tension



## 8. Replacement Parts

Genuine Kalamazoo Industries replacement parts are kept in stock and shipped from Kalamazoo, Michigan. Using genuine parts ensures optimal machine performance and maintains warranty coverage.

### 8.1 Recommended Spare Parts

We recommend keeping the following parts on hand to minimize downtime:

Part Number	Description	Qty
KAB20R	20" Abrasive Cutoff Wheels	3-5
See Parts List	V-Belt for K20FS	1
044-004	Spindle Bearings	2
701-010	Spindle with Tight Flange	1
292-011	Loose Flange (Outer)	1
537-027	Spindle Nut	1

### 8.2 Ordering Parts

To order replacement parts, contact Kalamazoo Industries directly or visit the online parts store at [www.kalamazooind.com](http://www.kalamazooind.com). Have your machine model number (K20FS) and motor HP rating (15 HP or 20 HP) ready when ordering. Parts lists are available for download on the product page.



## 9. Warranty Information

### 9.1 Warranty Coverage

Parts warranty is guaranteed for one year from the original date of purchase by the original purchaser, covering defects in material or workmanship under normal use. This warranty covers the replacement of defective parts. Some exclusions may apply.

### 9.2 Warranty Exclusions

This warranty does not cover:

- Normal wear items including abrasive wheels and bearings
- Damage resulting from misuse, abuse, or improper maintenance
- Damage from processing inappropriate materials
- Modifications or alterations to the machine
- Damage from improper electrical connection
- Shipping damage (report immediately upon receipt)

### 9.3 Return Authorization

Obtain written authorization before returning any merchandise by contacting Customer Service at (269) 382-2050. Unauthorized returns may not be accepted.

## 10. Contact Information

### **KALAMAZOO INDUSTRIES, INC.**

Kalamazoo, Michigan

Toll-Free: 1-800-592-2050

Local: (269) 382-2050

Email: [info@kalamazooindustries.com](mailto:info@kalamazooindustries.com)

Website: [www.kalamazooind.com](http://www.kalamazooind.com)

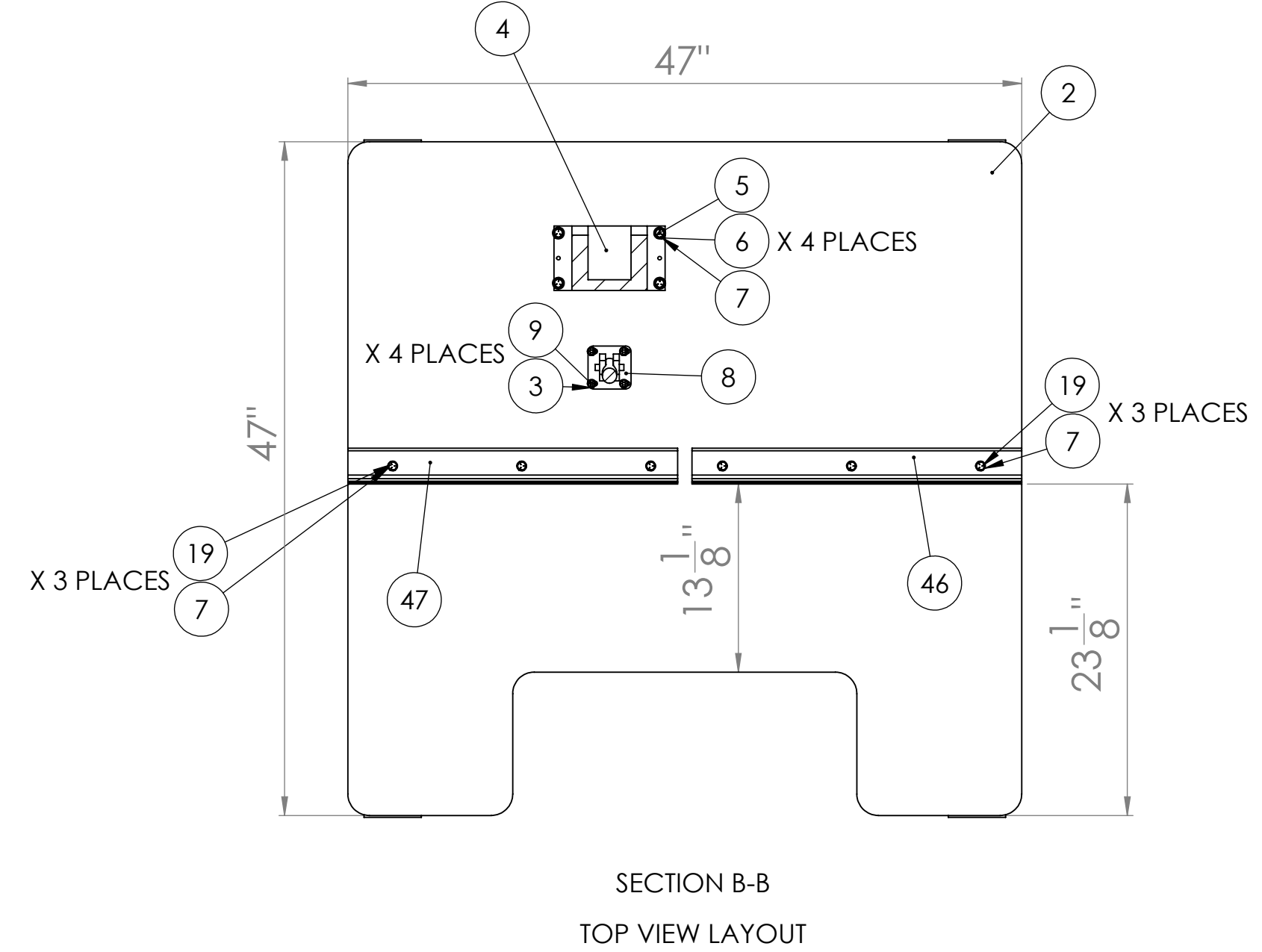
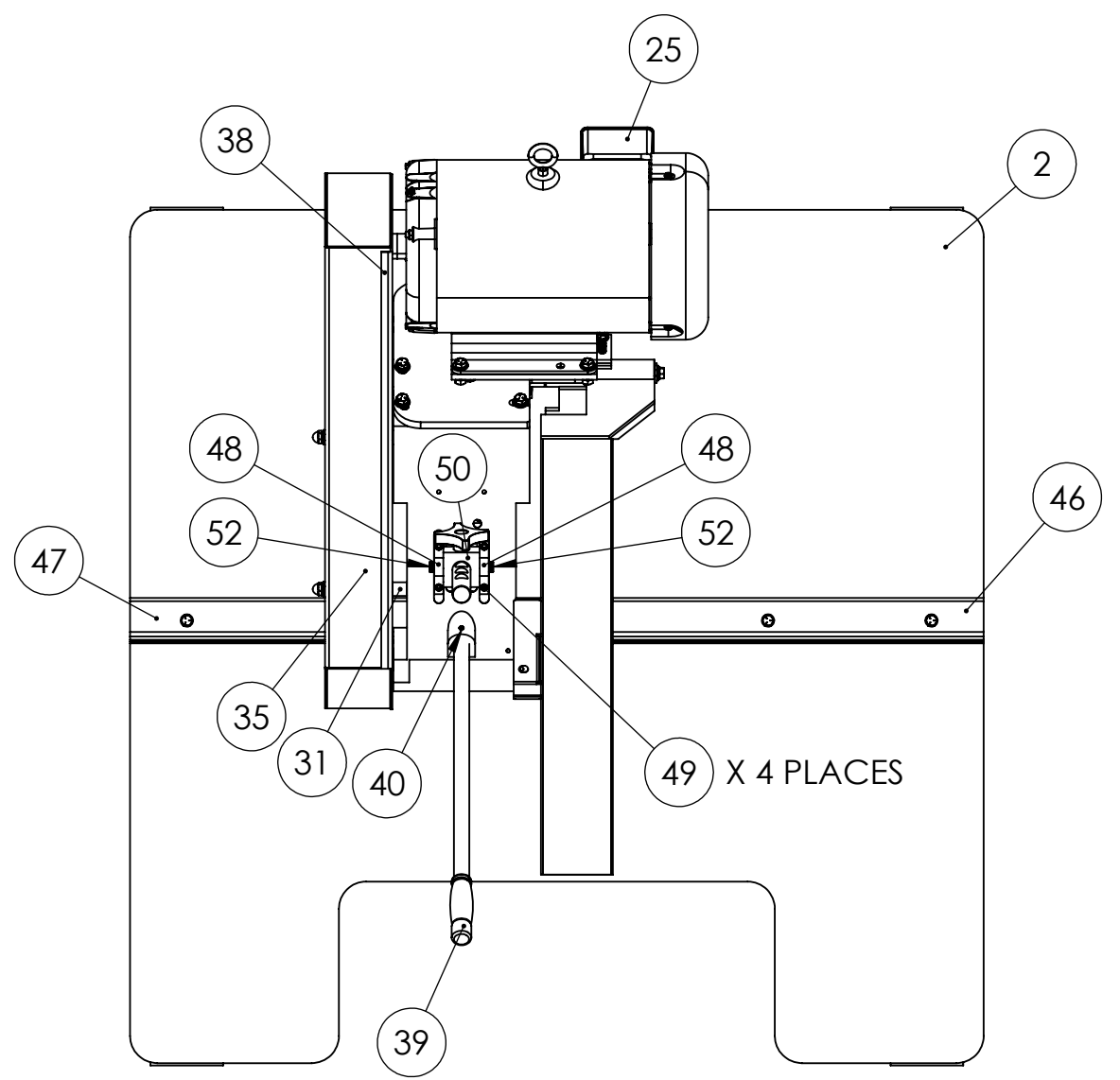
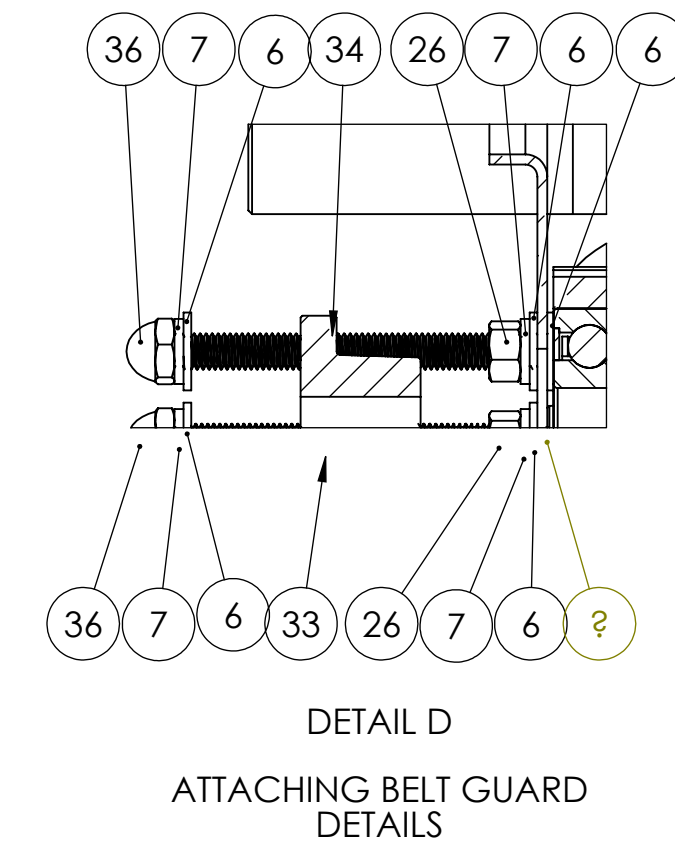
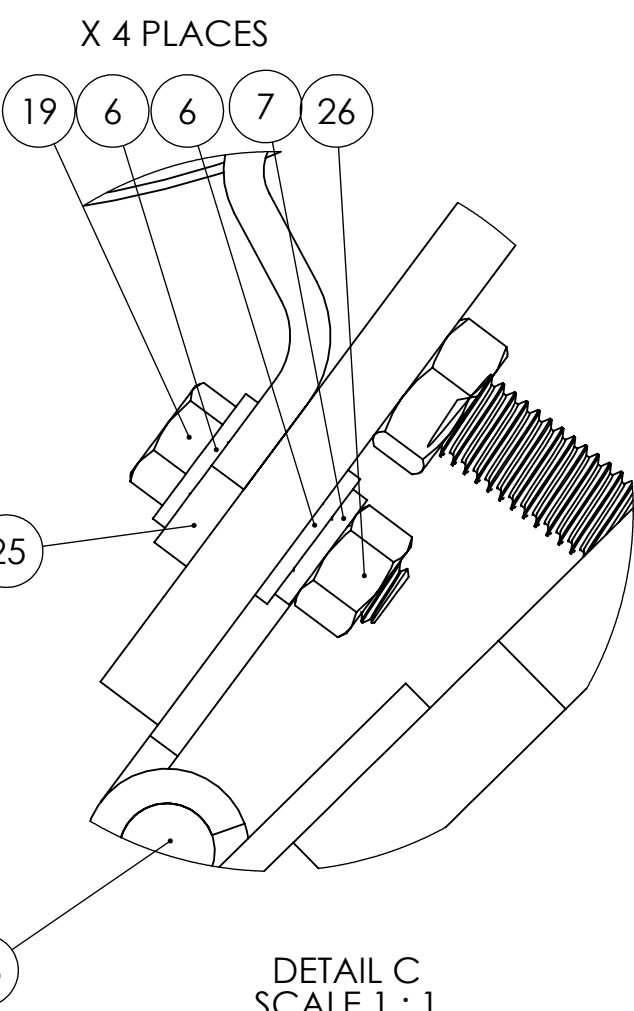
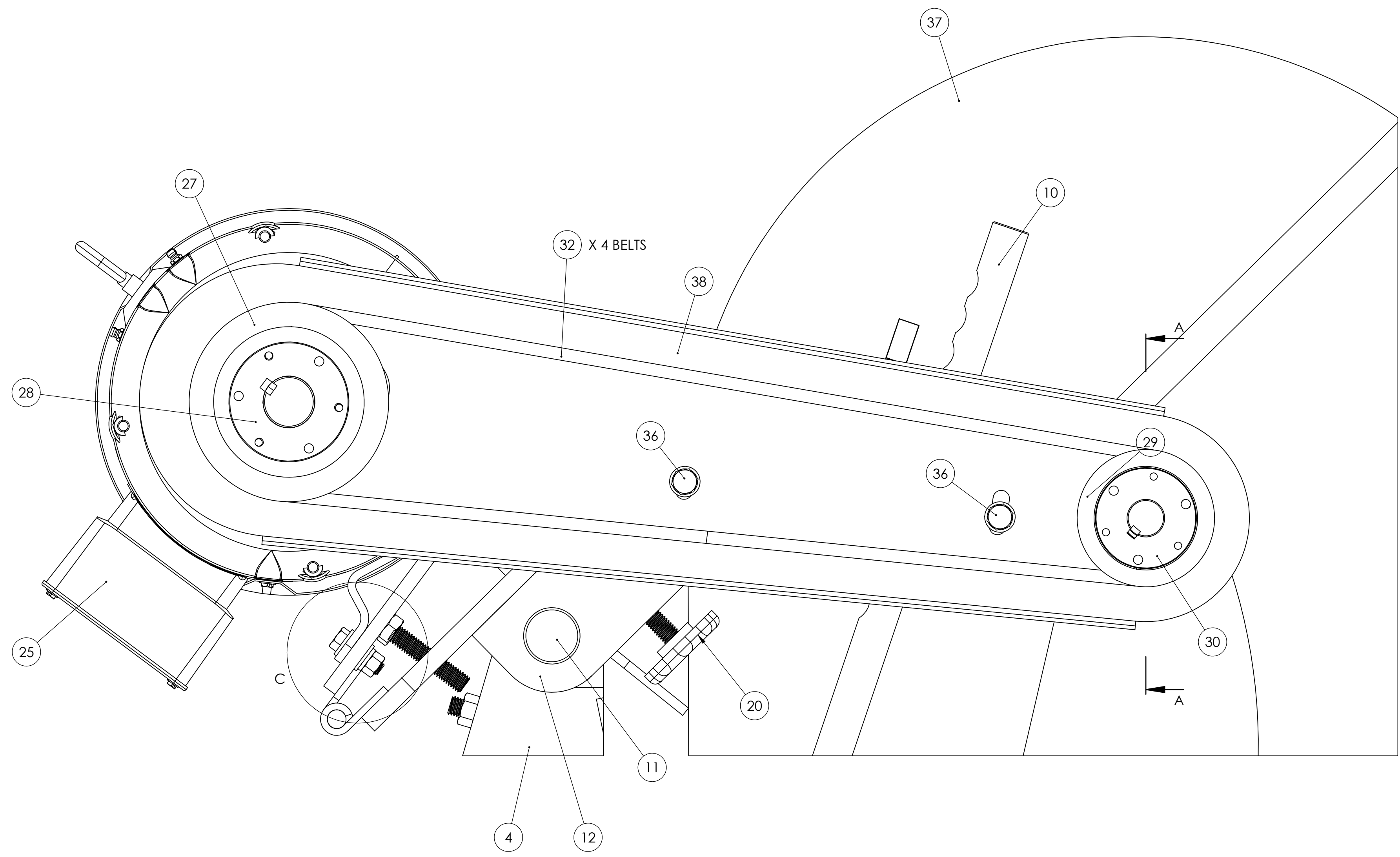
Office Hours: Monday – Friday, 8:00 AM – 4:30 PM EST

### **Online Resources**

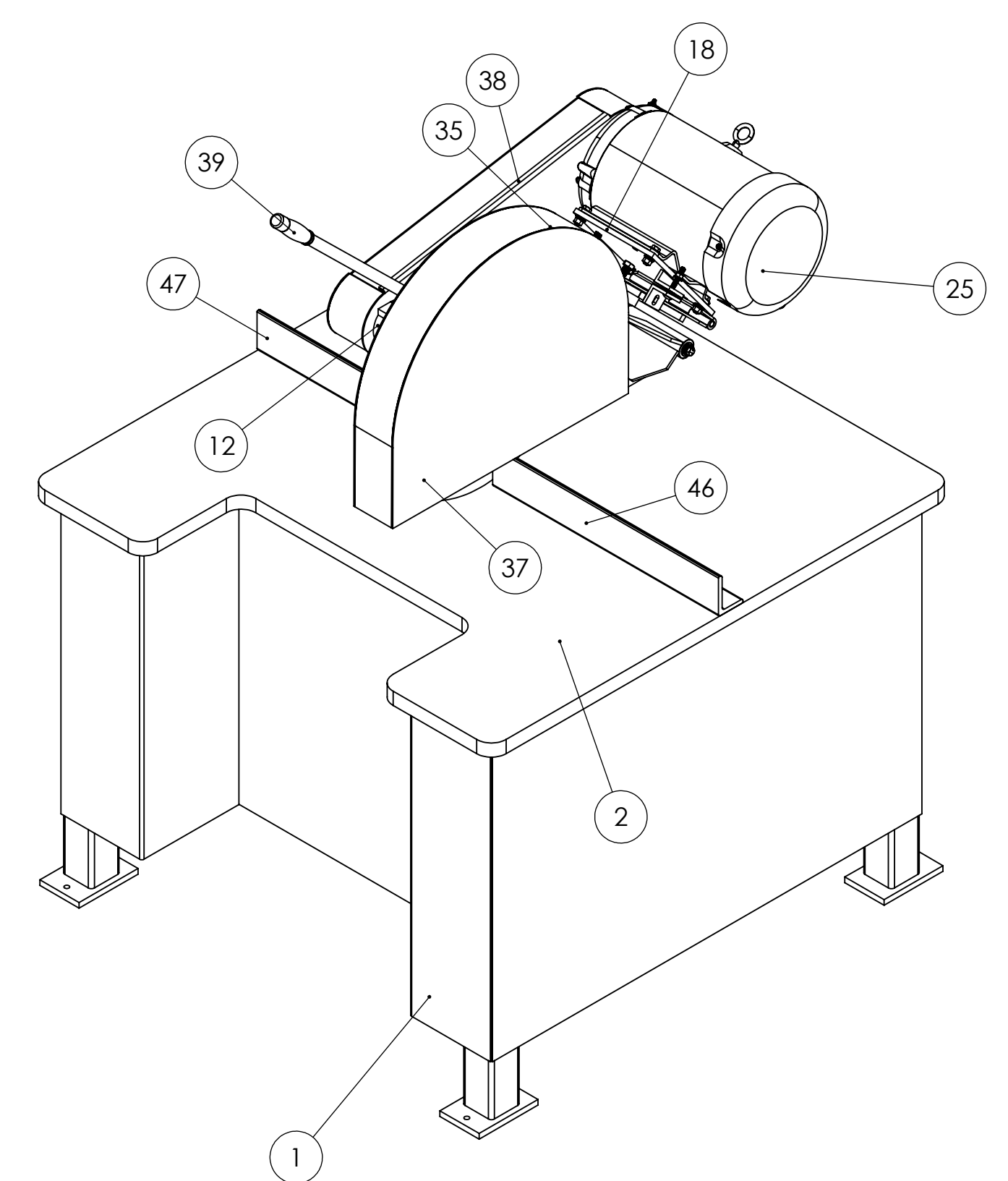
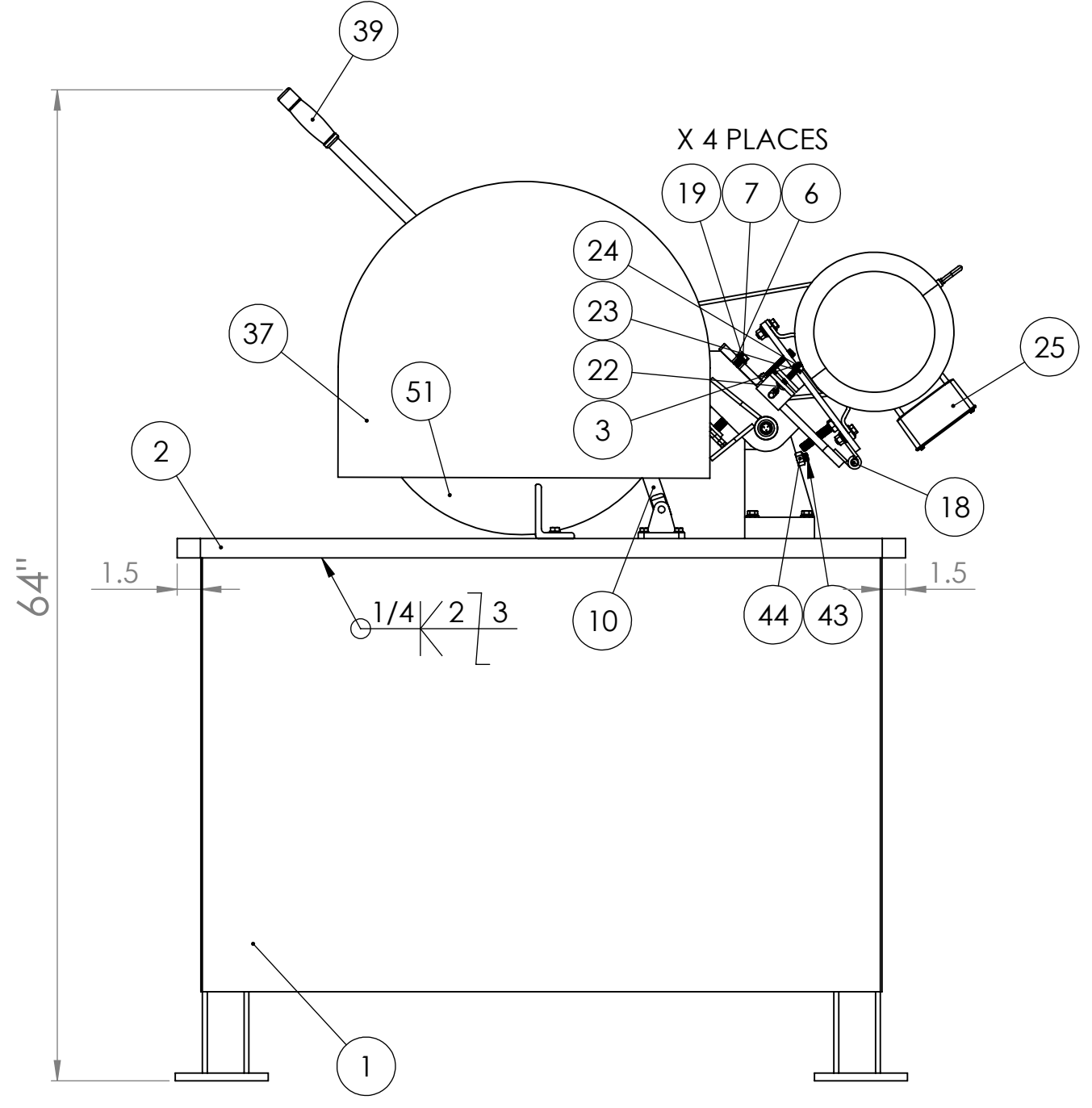
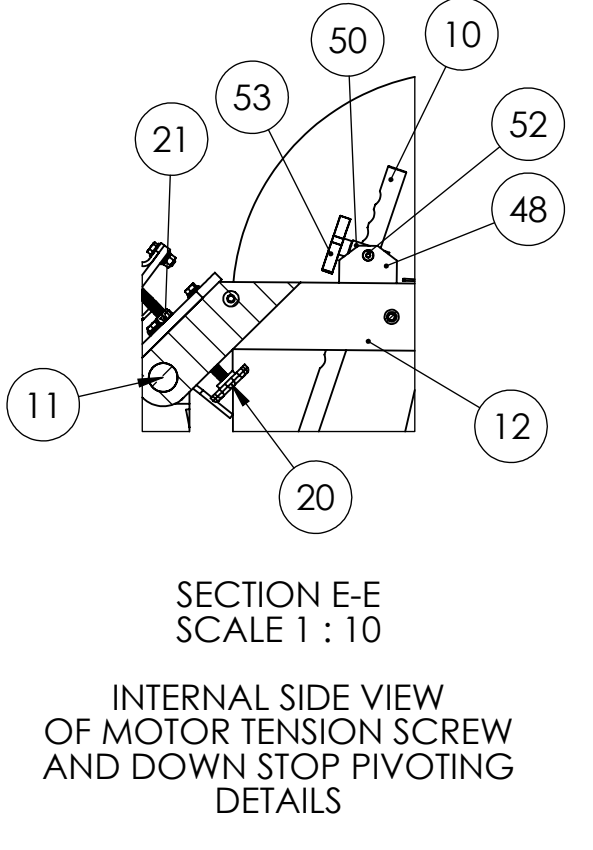
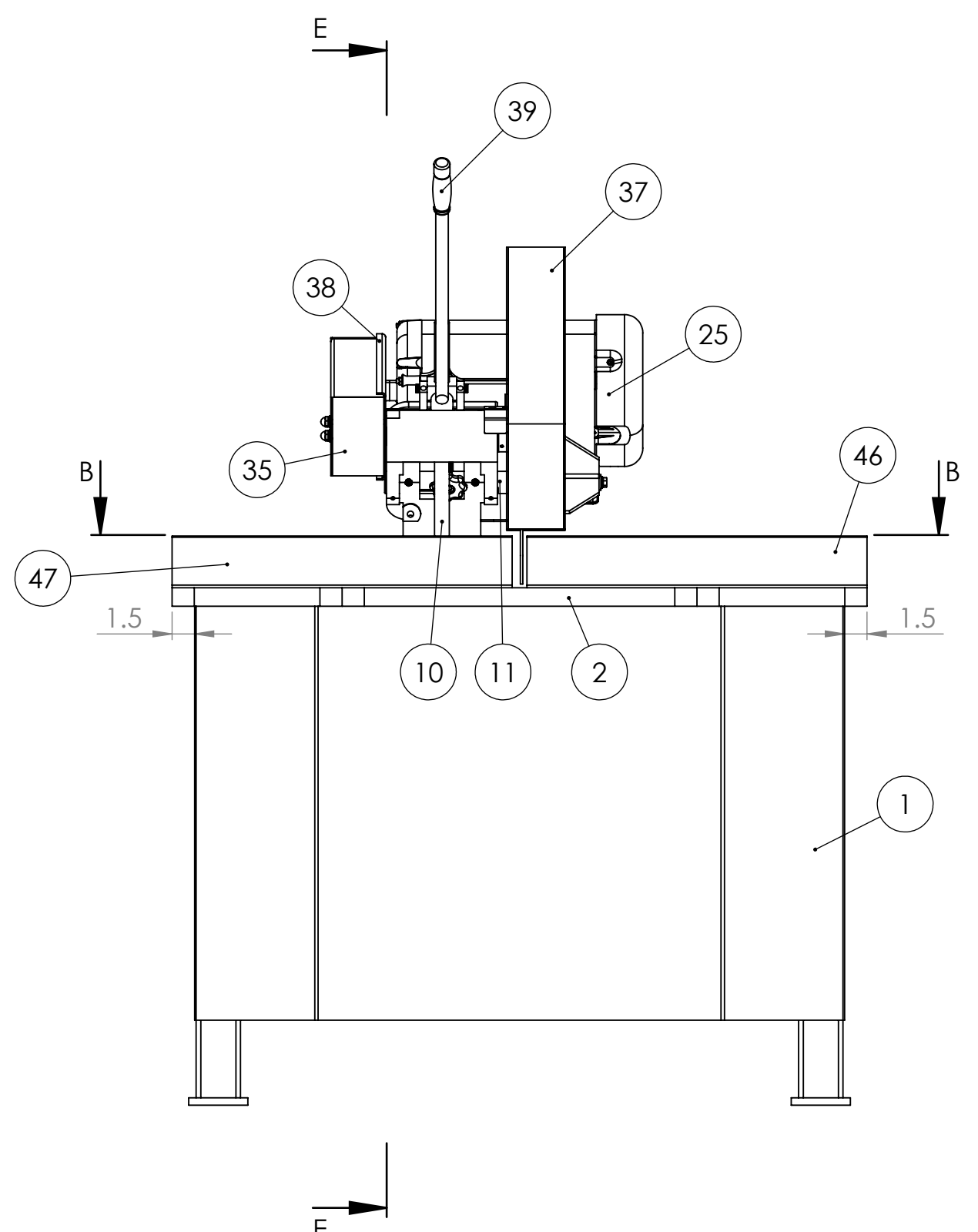
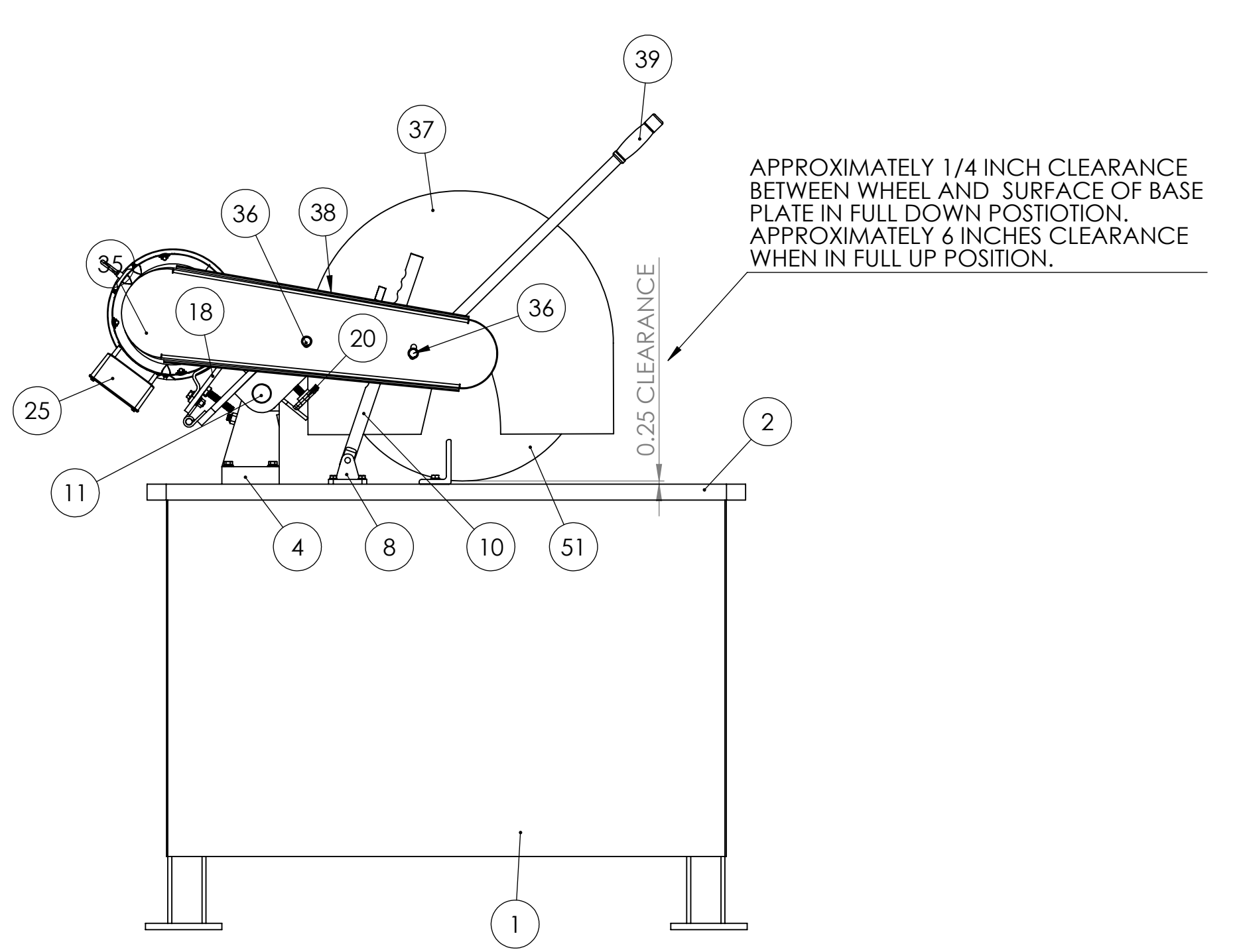
- **Product Registration:** [www.kalamazooind.com/product-registration](http://www.kalamazooind.com/product-registration)
- **Parts Orders:** [www.kalamazooind.com/parts-by-category](http://www.kalamazooind.com/parts-by-category)
- **Technical Videos:** [www.kalamazooind.com/videos](http://www.kalamazooind.com/videos)
- **Contact Form:** [www.kalamazooind.com/contact-us](http://www.kalamazooind.com/contact-us)

***Thank you for choosing Kalamazoo Industries!***

**Made in the USA**



SECTION A-A  
INTERNAL SPINDLE/ FRONT  
OF TRUNNION  
SCALE 1 : 2



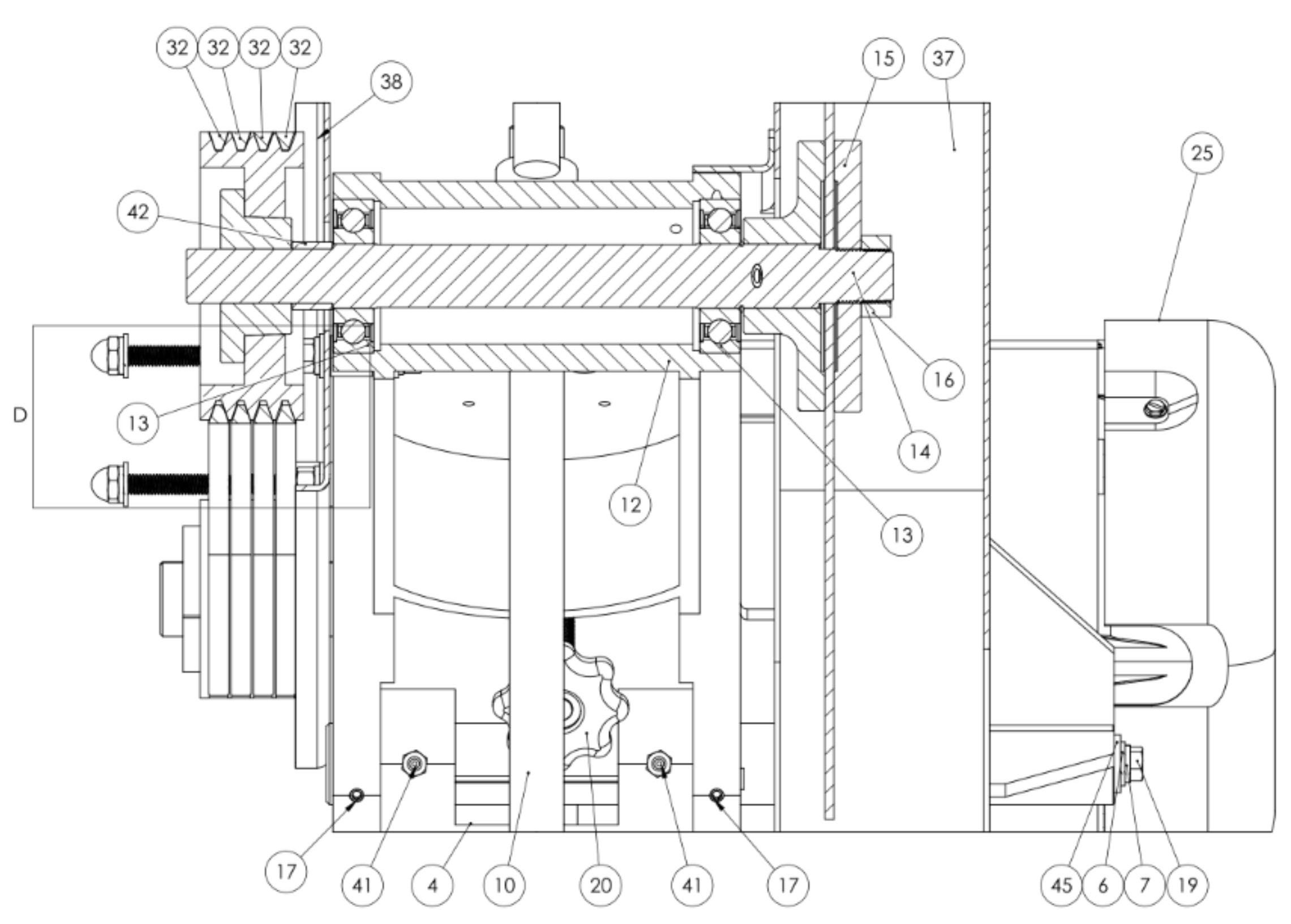
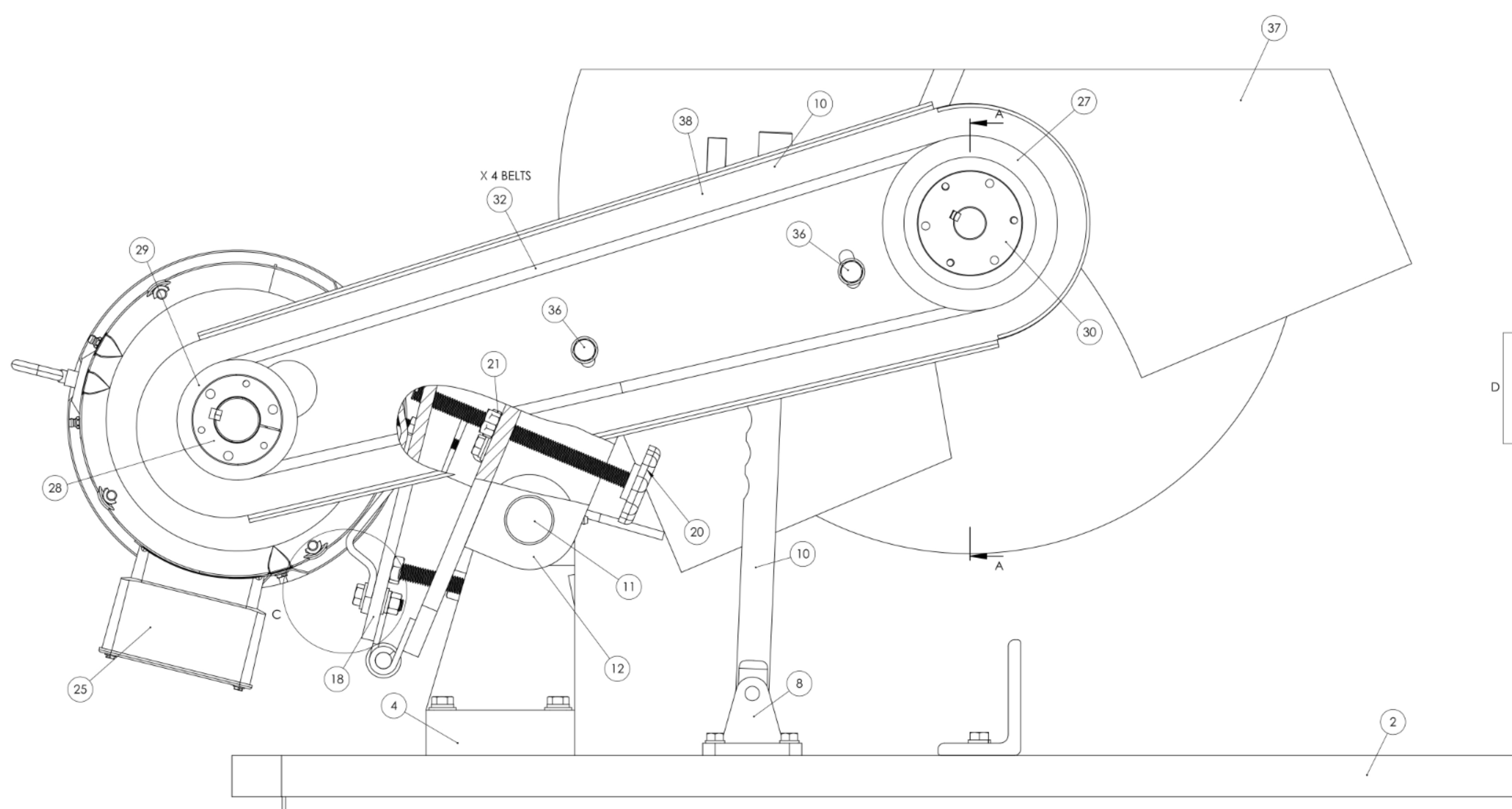
ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	716-033	STAND ASSEMBLY FOR K20FS	1
2	829-041	TOP PLATE FOR K20FS	1
3	SLWZ031	5/16 SPLIT L/W Z	5
4	831-021	TRUNNION FOR KM16-18, K16-18, K20SSF (NEW STYLE)	1
5	HHC5037036	3/8-16 X 2-1/4 HHC5 GR 5 Z	4
6	UFWZ037	3/8 USS F/W Z	23
7	SLWZ037	3/8 SPLIT L/W Z	24
8	1-34-4	SWIVEL BRACKET FOR 2 AND 2-1/2 CYLINDERS	1
9	HHC5031020	5/16-18 X 1-1/4 HHC5 GR 5 Z	4
10	709-013	STOP, ARM FOR K20FS SAW	1
11	562-050	PIN, TRUNNION FOR K20RS	1
12	002-005	SAW ARM FOR K16-18, KM16-18, AND K20SSF SAW	1
13	044-004	K20 SPINDLE BEARING	2
14	701-010	SPINDLE W TIGHT FLANGE FOR K16-18, K20SSF, K20E SAWS	1
15	292-011	LOOSE FLANGE FOR K16-20, KM16-18, KM20-22	1
16	537-027	SPINDLE NUT FOR K16-20	1
17	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
18	486-010	MOTOR MOUNT PLATE K16-20 ASSEMBLY	1
19	HHC5037020	3/8-16 X 1-1/4 HHC5 GR 5 Z	15
20	696-029	MOTOR PLATE TENSION SCREW FOR K16-K20 SAWS	1
21	FJNZ050	1/2-13 F H JAM NUT Z	1
22	CRBZ031040	5/16-18 X 2-1/2 CARRIAGE BOLT	1
23	UFWZ031	5/16 USS F/W Z	1
24	FHN5031	5/16-18 FHN GR 5 ZINC	1
25	486-020	15HP MOTOR FOR K20SSF-15, K20SW-15, KM20-22/15, K20FS, K20E	1
26	FHN5037	3/8-16 FHN GR 5 Z	7
27	560-046	MOTOR PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, KM20-22/15, KM20-22W/15 (K20SSF 7 1/2 HP), SPINDLE PULLEY SHEAVE FOR K20SW-15HP & 20HP	1
28	049-003	MOTOR PULLEY BUSHING FOR K16-18, KM16-18, K20SSF-15, K20RS-15, K20SW-15, KM20-22-15HP, KM20-22W-15, S10D	1
29	560-047	SPINDLE PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, K20RS, KM20-22/15, MOTOR PULLEY SHEAVE FOR K20SW-20HP	1
30	049-004	BUSHING FOR K16-18, K20SSF-15HP, K20RS-15, KM16-18, KM20-22-15HP SPINDLE PULLEY	1
31	123-003	COLLAR FOR S4/ SPACER FOR K20 BELT GUARD	1
32	051-005	V-BELT FOR K16-18, K20SSF, K20E, K20RS, K20SW, KM20AS	4
33	RND-0.375-16X6.25	6-1/4 INCHES OF 3/8-16 THREADED ROD	1
34	RND0.375-16X5.375	5-3/8 INCHES OF 3/8-16 THREADED ROD	1
35	342-039	OUTER GUARD, BELT FOR K16-18 AND K20SSF SAWS	1
36	CPNZ037	3/8-16 CAP NUT NICKEL	2
37	342-112	HALF ROUND GUARD FOR K20SSF	1
38	342-039A	GUARD, INNER BELT FOR K16-18, KM16-18, K20SSF SAWS	1
39	381-009	HANDLE WITH GRIP FOR K16-20 ABRASIVE SAW	1
40	SSKA025006	1/4-20 X 3/8 SOC SET KNURL PT.	1
41	ZERK012000	1/8-27 X 1 1/16 STRT LUBE FITTING	2
42	049-116	SPACER BUSHING FOR K20/15HP SERIES SPINDLE	1
43	RND-0.5-13 THRD	1-3/4 INCHES OF 1/2-13 THREADED ROD	1
44	FHN5050	1/2-13 FHN GR 5 Z	1
45	UFWZ050	1/2 USS F/W Z	1
46	293-010R	RIGHT SIDE FENCE FOR K20FS SAW	1
47	293-010L	LEFT SIDE FENCE FOR K20FS SAW	1
48	041-037	HSM14 UPPER CYLINDER BRACKET	2
49	SHCA025024	1/4-20 X 1-1/2 SHCS	4
50	053-035	PIVOTING BLOCK FOR K20FS DOWN STOP ROD	1
51	20INCHWHEEL		1
52	SSBA037008	3/8 X 1/2 SOC SHOULDER BOLT	2
53	441-011 K20FS	MODIFIED 2FS, 2FS72, 2FSM, 25K7 TRACKING KNOB FOR K20FS	1

UNLESS OTHERWISE SPECIFIED:  
DIMENSIONS ARE IN INCHES  
TOLERANCES:  
FRACTIONS ± .005  
ANGULAR ± .0315  
HOLE POSITION ± .005  
THREE PLACE DECIMAL ± .001  
INTERFERENCE GEOMETRIC TOLERANCES PER ASME Y14.5-2009  
SURFACE FINISH: SEE SURFACE FINISH SYMBOLS  
MATERIAL: SEE MATERIAL SPECIFICATIONS  
FINISH: SEE FINISH SYMBOLS  
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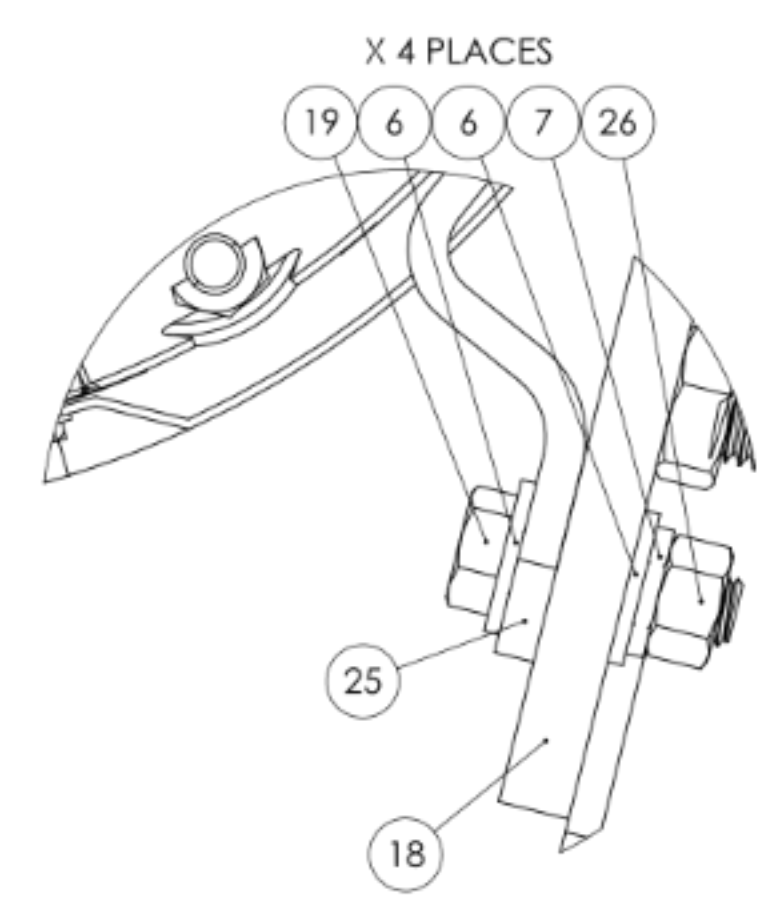
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CHECKED BY: \_\_\_\_\_  
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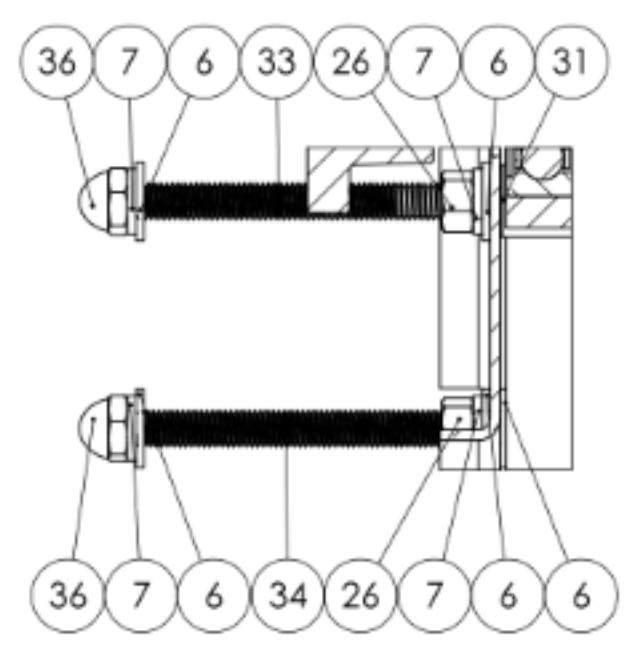
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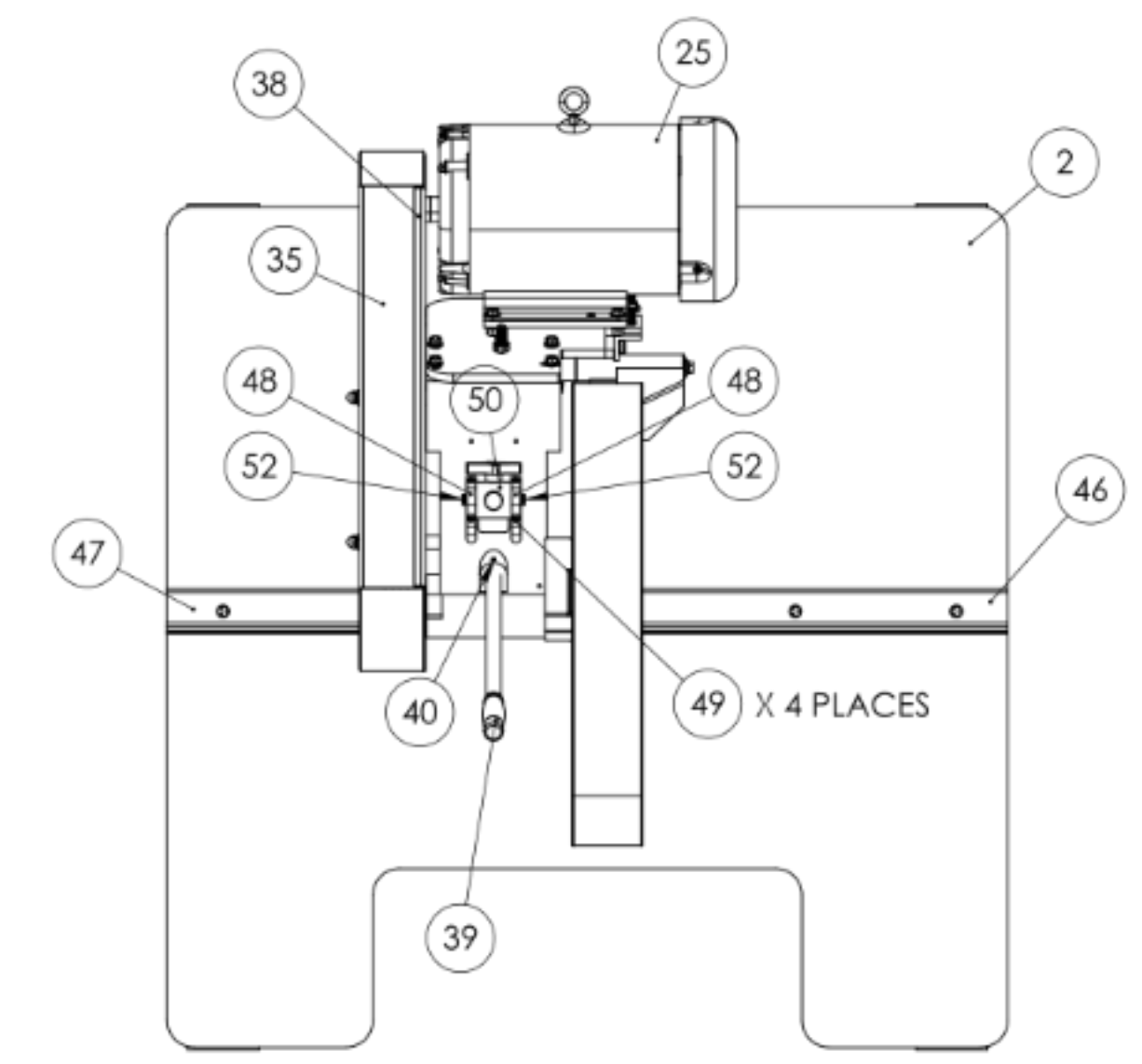
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INTERNAL SPINDLE/FRONT  
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SCALE 1:2



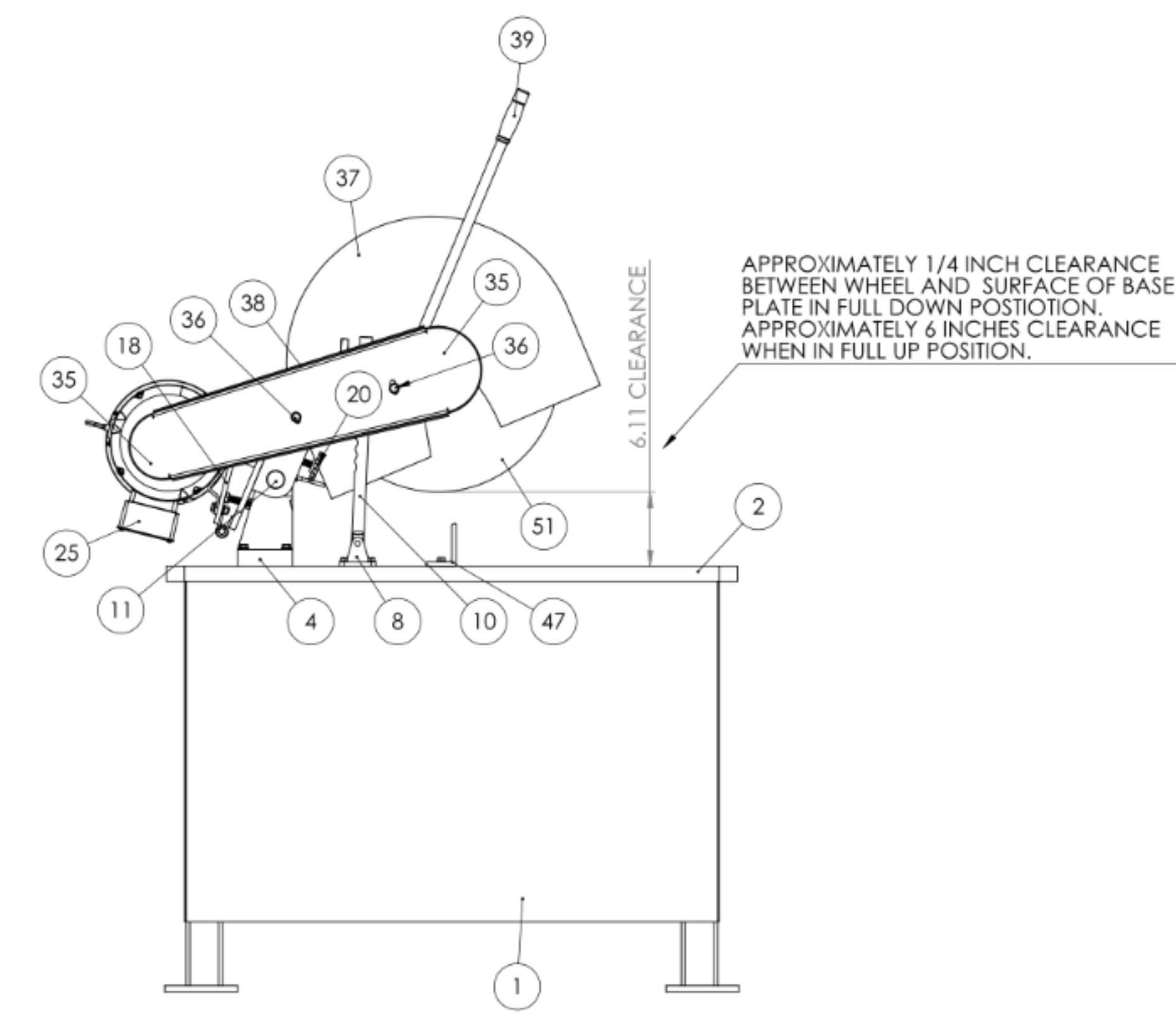
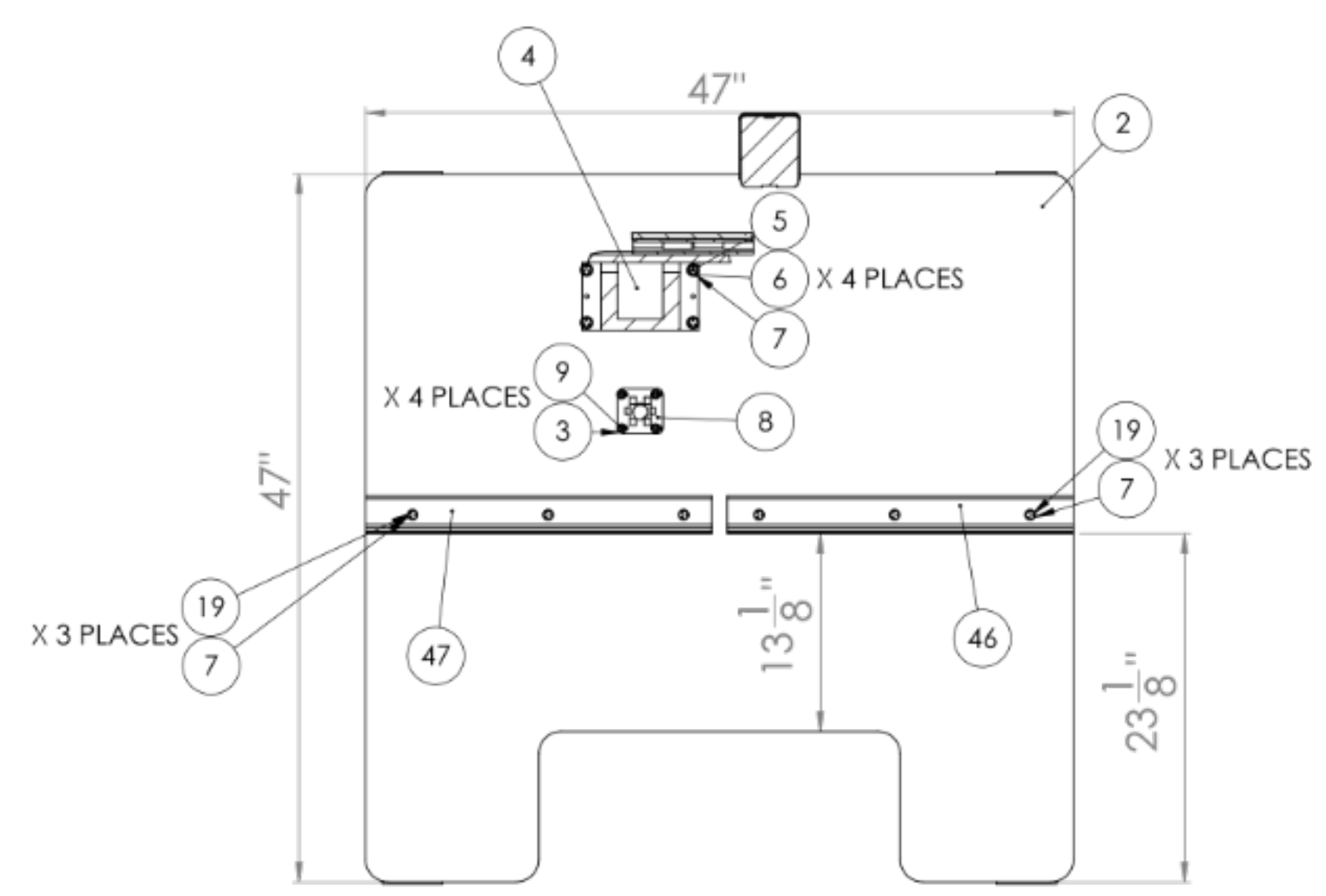
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SCALE 1:1  
MOTOR ATTACHMENT  
DETAILS



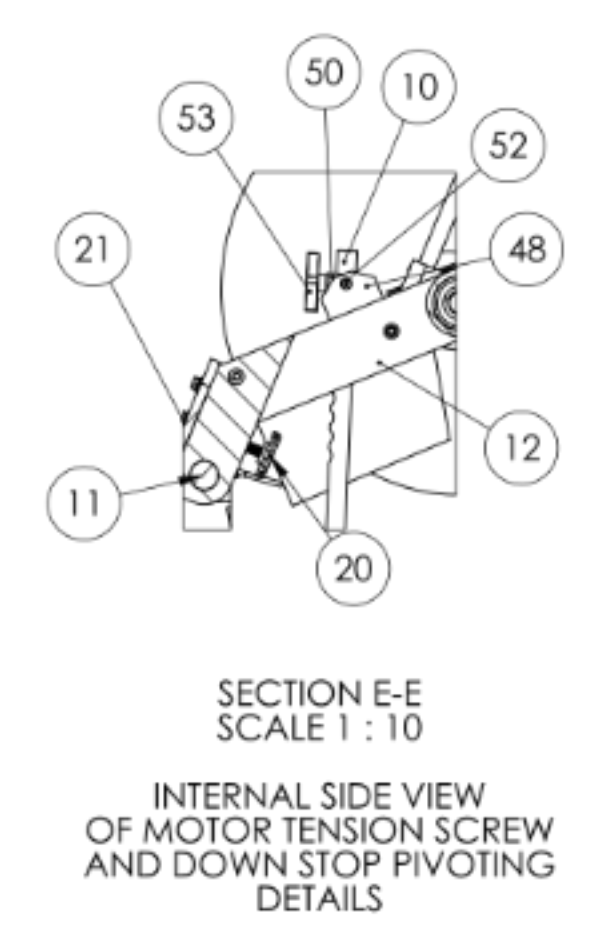
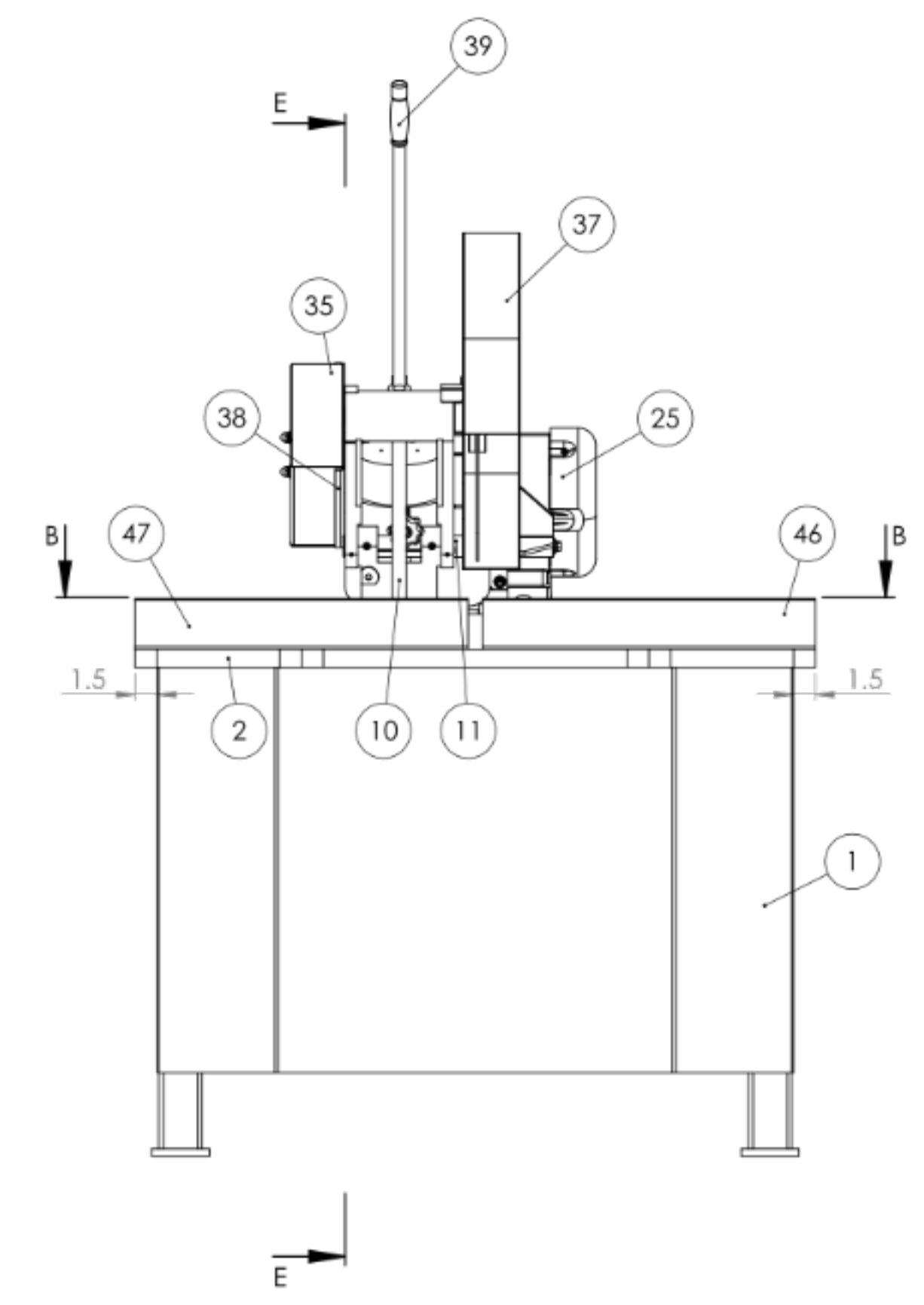
DETAIL D  
ATTACHING BELT GUARD  
DETAILS



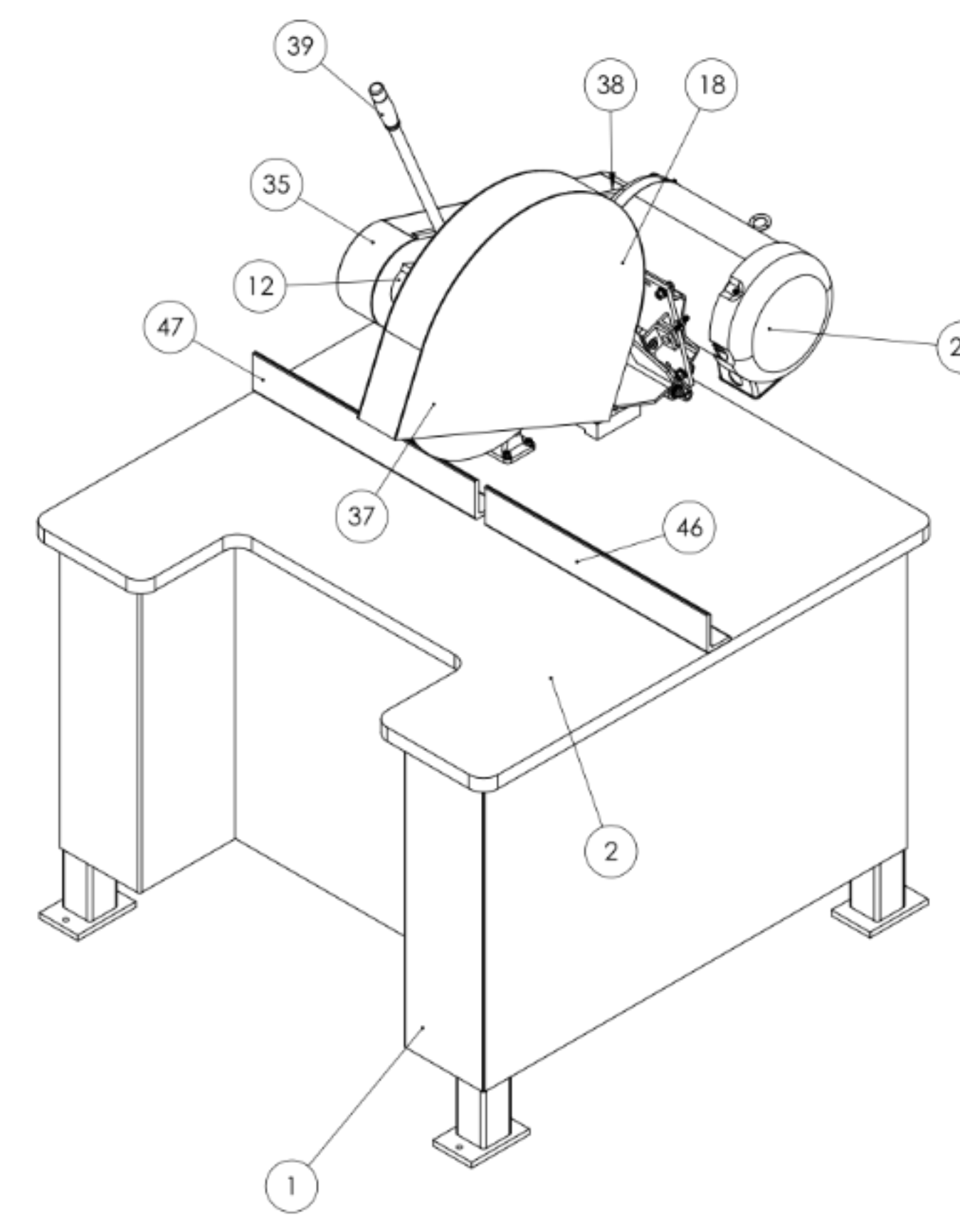
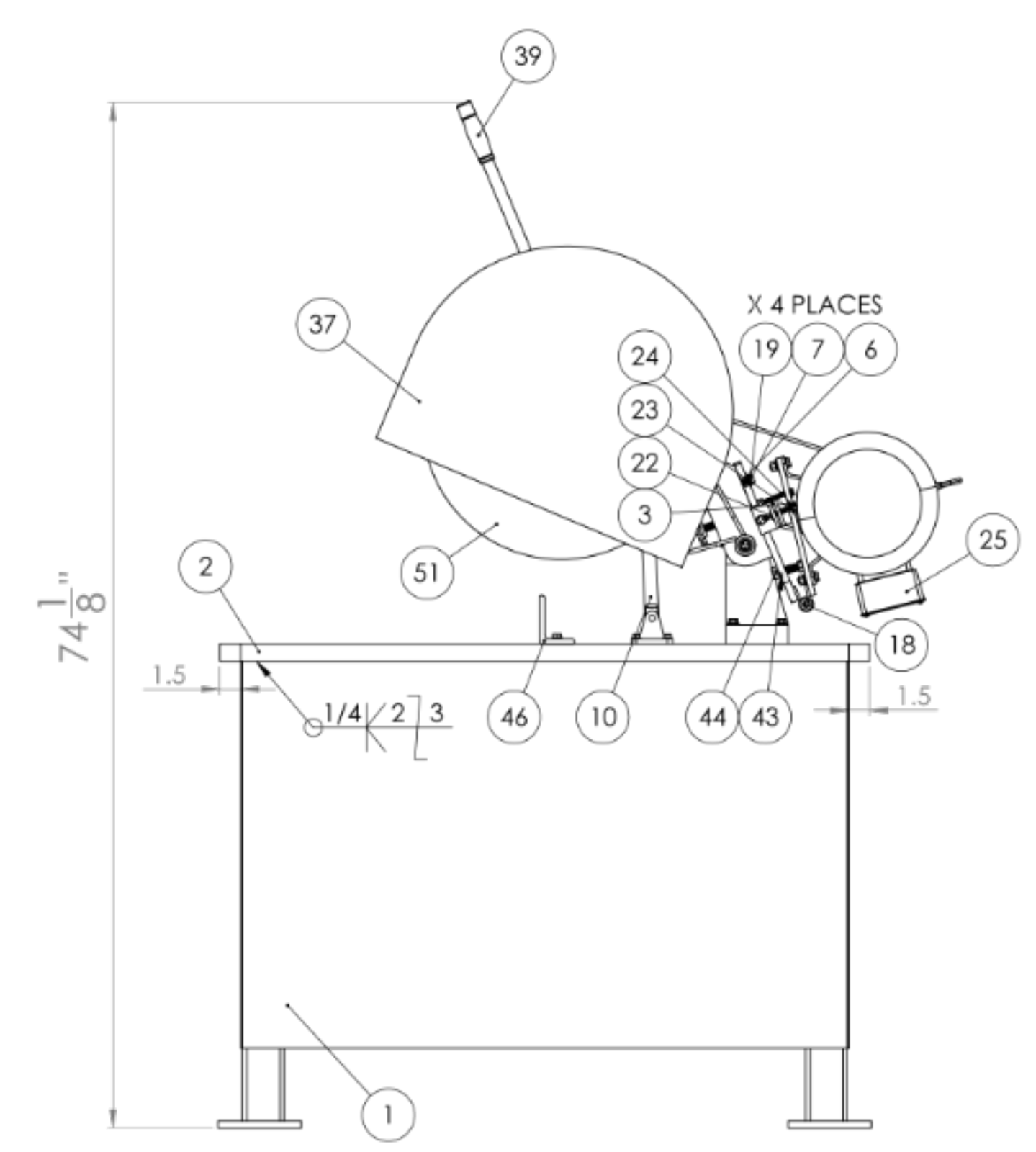
SECTION B-B  
TOP VIEW LAYOUT



APPROXIMATELY 1/4 INCH CLEARANCE  
BETWEEN WHEEL AND SURFACE OF BASE  
PLATE IN FULL DOWN POSITION.  
APPROXIMATELY 6 INCHES CLEARANCE  
WHEN IN FULL UP POSITION.



SECTION E-E  
SCALE 1:10  
INTERNAL SIDE VIEW  
OF MOTOR TENSION SCREW  
AND DOWN STOP PIVOTING  
DETAILS



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-033	STAND ASSEMBLY FOR K20FS	1
2	829-041	TOP PLATE FOR K20FS	1
3	SLWZ031	5/16 SPLIT L/W Z	5
4	831-021	TRUNNION FOR KM16-18, K16-18, K20SSF (NEW STYLE)	1
5	HHC5037036	3/8-16 X 2-1/4 HHC5 GR 5 Z	4
6	UFWZ037	3/8 USS F/W Z	23
7	SLWZ037	3/8 SPLIT L/W Z	24
8	1-34-4	SWIVEL BRACKET FOR 2 AND 2-1/2 CYLINDERS	1
9	HHC5031020	5/16-18 X 1-1/4 HHC5 GR 5 Z	4
10	709-013	STOP ARM FOR K20FS SAW	1
11	562-050	PIN, TRUNNION FOR K20RS	1
12	002-005	SAW ARM FOR K16-18, KM16-18, AND K20SSF SAW	1
13	044-004	K20 SPINDLE BEARING	2
14	701-010	SPINDLE W TIGHT FLANGE FOR K16-18, K20SSF, K20E SAWS	1
15	292-011	LOOSE FLANGE FOR K16-20, KM16-18, KM20-22	1
16	537-027	SPINDLE NUT FOR K16-20	1
17	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
18	486-010	MOTOR MOUNT PLATE K16-20 ASSEMBLY	1
19	HHC5037020	3/8-16 X 1-1/4 HHC5 GR 5 Z	15
20	696-029	MOTOR PLATE TENSION SCREW FOR K16-K20 SAWS	1
21	FJNZ050	1/2-13 F H JAM NUT Z	1
22	CRBZ031040	5/16-18 X 2-1/2 CARRIAGE BOLT Z	1
23	UFWZ031	5/16 USS F/W Z	1
24	FHN5031	5/16-18 FHN GR 5 ZINC	1
25	486-009	20HP MOTOR FOR K20SSF-20, K20SW-20, KM20-22/20	1
26	FHN5037	3/8-16 FHN GR 5 Z	7
27	560-046	MOTOR PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, KM20-22/15, KM20-22W/15 (K20SSF 7 1/2 HP), SPINDLE PULLEY SHEAVE FOR K20SW-15HP & 20HP	1
28	049-017	MOTOR PULLEY BUSHING FOR K20SSF-20HP, K20SW-20HP, K20E, KM20-22W-20HP	1
29	560-047	SPINDLE PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, K20RS, KM20-22/15, MOTOR PULLEY SHEAVE FOR K20SW-20HP	1
30	049-018	SPINDLE PULLEY BUSHING FOR K20SSF-20HP, K20SW-15 & 20HP, K20E, KM20-22 20HP, KM20-22W-15HP	1
31	123-003	COLLAR FOR S4- SPACER FOR K20 BELT GUARD	1
32	051-005	3V600 V-BELT FOR K16-18, K20SSF, K20E, K20RS, K20SW	4
33	RND-0.375-16X6.25	6-1/4 INCHES OF 3/8-16 THREADED ROD	1
34	RND0.375-16X5.375	5-3/8 INCHES OF 3/8-16 THREADED ROD	1
35	342-122	OUTER BELT GUARD (NEW STYLE) FOR K20E, K20SW, AND K20 SERIES 20HP SAWS	1
36	CPNZ037	3/8-16 CAP NUT NICKEL	2
37	342-112	HALF ROUND GUARD FOR K20SSF	1
38	342-121	INNER BELT GUARD (NEW STYLE) FOR K20E, K20SW, AND K20 SERIES 20HP SAWS	1
39	381-009	HANDLE WITH GRIP FOR K16-20 ABRASIVE SAW	1
40	SSKA025006	1/4-20 X 3/8 SOC SET KNURL PT.	1
41	ZERK012000	1/8-27 X 11/16 STRT LUBE FITTING	2
42	049-120	SPACER BUSHING FOR K20 SERIES 20HP SPINDLE	1
43	RND-0.5-13 THRD	1-3/4 INCHES OF 1/2-13 THREADED ROD	1
44	FHN5050	1/2-13 FHN GR 5 Z	1
45	UFWZ050	1/2 USS F/W Z	1
46	293-010R	RIGHT SIDE FENCE FOR K20FS SAW	1
47	293-010L	LEFT SIDE FENCE FOR K20FS SAW	1
48	041-037	HSM14 UPPER CYLINDER BRACKET	2
49	SHCA025024	1/4-20 X 1-1/2 SHCS	4
50	053-035	PIVOTING BLOCK FOR K20FS DOWN STOP ROD	1
51	20INCHWHEEL		1
52	SSBA037008	3/8 X 1/2 SOC SHOULDER BOLT	2
53	441-011K20FS	MODIFIED 2FS, 2FS72, 2FSM, 25K7 TRACKING KNOB FOR K20FS	1

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