

INSTRUCTION MANUAL

K20RS



KI **KALAMAZOO
INDUSTRIES, INC.**

6856 East K Avenue

Kalamazoo, MI 49048

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www.kalamazooindustries.com

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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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K20RS, 20" abrasivewheel

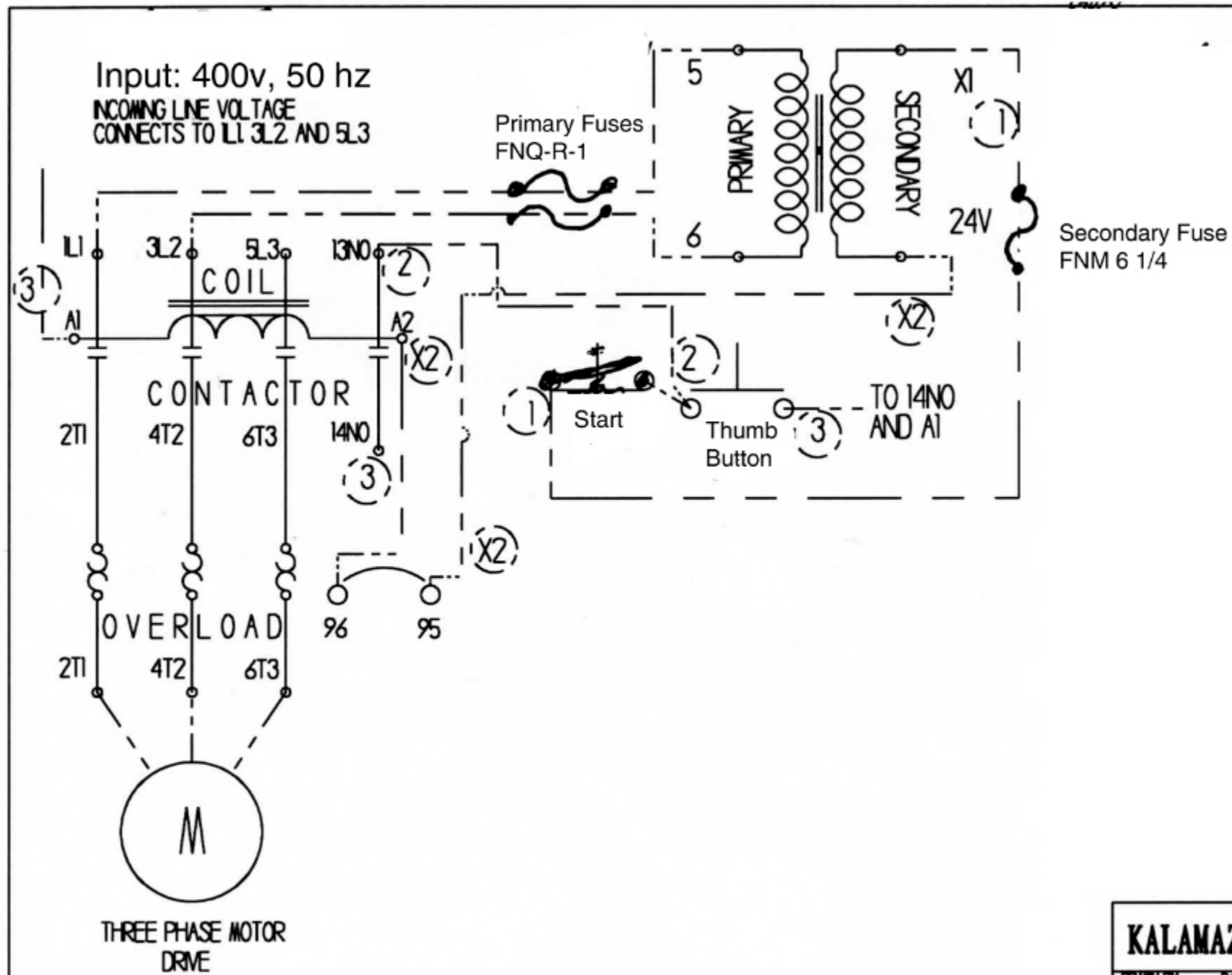
Basic Operation

1" arbor, RH thd.

15 hp, 3 phase

1. AC in- Be sure incoming AC power matches machine AC power. Drill/punch NEMA enclosure for seal tight fitting around incoming wiring. Input incoming AC power to L1, L2, L3 on the contactor. CAUTION: IF NOT FAMILIAR WITH ELECTRIC CONSULT AN ELECTRICIAN.
2. Chain vise- Drape chain over work piece as tight as possible, secure chain link into clevis, depress foot pedal to tighten chain on work piece. CAUTION: BE SURE WORK PIECE IS SECURE AND DOES NOT MOVE DURING CUTTING OR ABRASIVE WHEELS WILL BREAK!
3. Clean out- Open door and rake out swarf in base of machine.
4. On/Off- Hold thumb switch on T handle and depress ON to start the wheel. Thumb switch must be held to keep abrasivewheel running. RELEASE thumb switch to stop.
5. Down stop- Controls depth of cut of the abrasivewheel. Adjust as needed for wheel wear. CAUTION: DO NOT ALLOW ABRASIVE WHEEL TO CUT INTO SAW TABLE. ADJUST DOWN STOP WHEN INSTALLING A NEW ABRASIVE WHEEL AND ADJUST AS WHEEL WEARS DOWN.
6. Saw head LOCK - Locks saw head in a fixed position for non radial movement. Use the saw in either "radial" mode or "fixed saw head" mode for cutting. In "Radial" mode begin cutting by pushing or pulling the saw head through the work piece. BE SURE WORK PIECE IS SECURE WHEN CUTTING.

Maintenance- Keep machine cleaned out. V belts will stretch and need to be adjusted over time. 1/2" of "squeeze". DO NOT OVERTIGHTEN!
Spindle bearings are "sealed ball" bearings and do not need lubrication.
Bolt machine to floor if needed. Follow all Safety procedures. SEE SAFETY SHEET !! ALWAYS WEAR SAFETY GLASSES !!!!



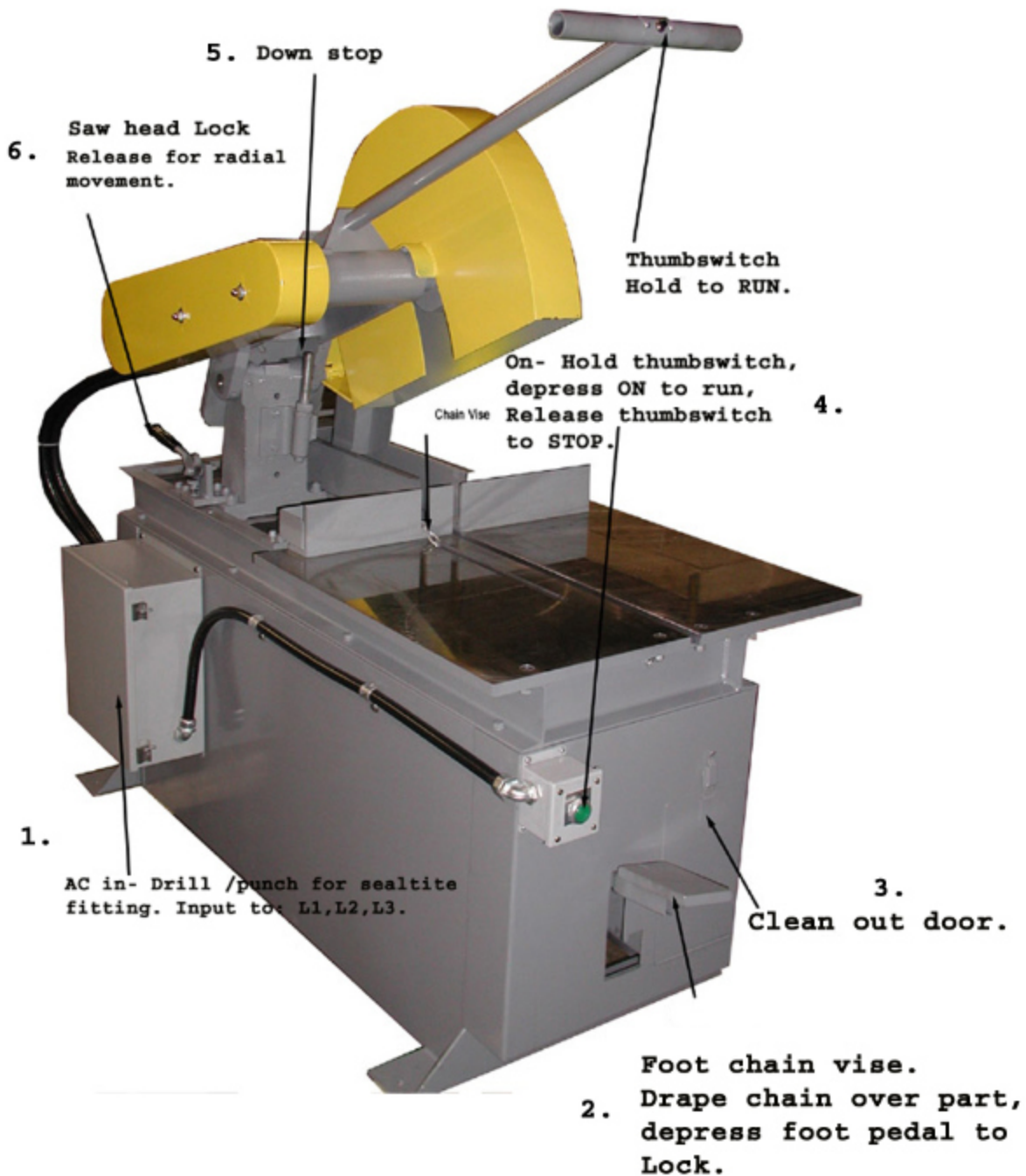
KALAMAZOO INDUSTRIES INC.		
DRAWN BY	DATE	DESCRIPTION
ASHLEY	05/27/22	ELEC. SCHEMATIC
REVISED BY	DATE	PART #
MATERIAL		

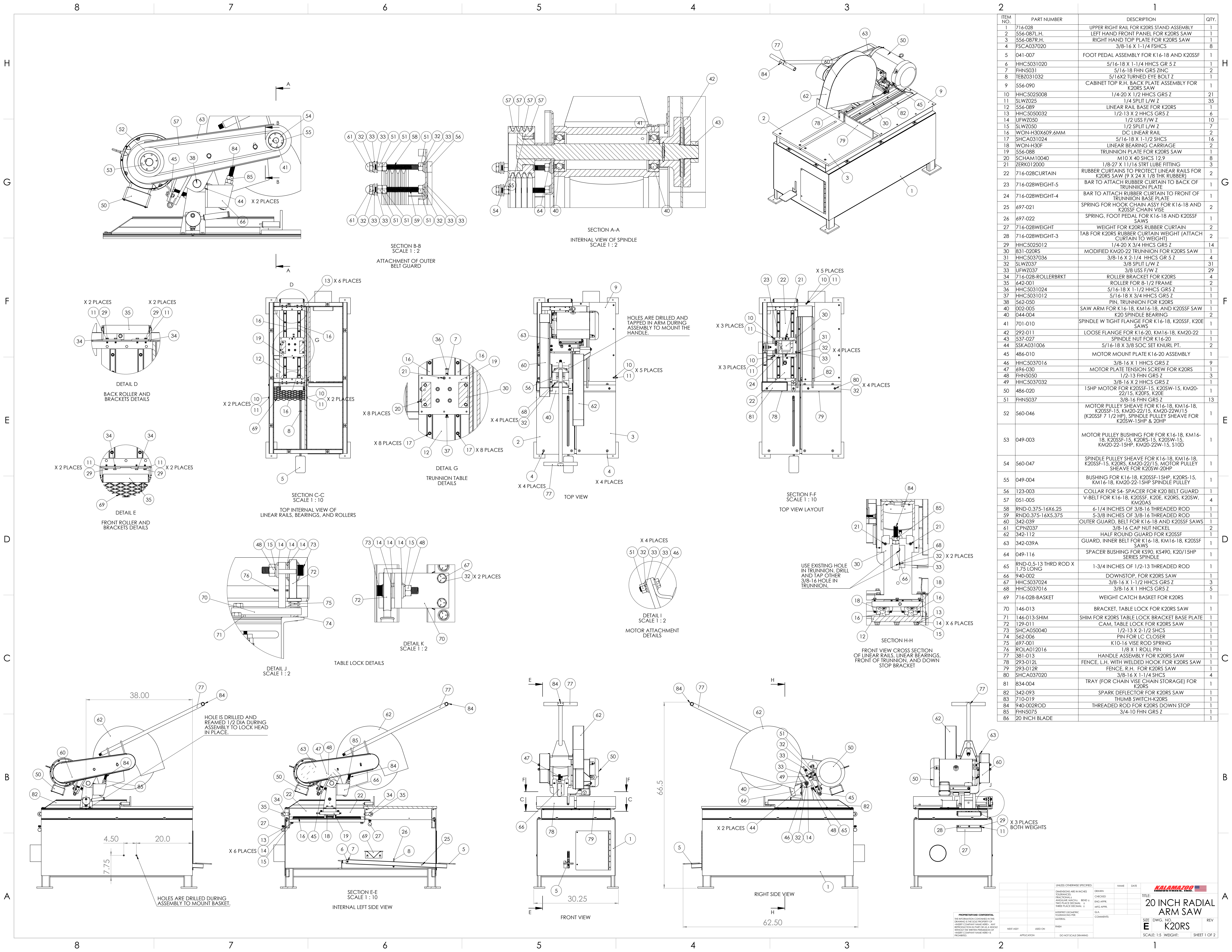


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**K20RS, 20" radial abrasive saw
1" arbor, 15 hp, 3 phase.**





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-028	UPPER RIGHT RAIL FOR K20RS STAND ASSEMBLY	1
2	556-087L.H.	LEFT HAND FRONT PANEL FOR K20RS SAW	1
3	556-087R.H.	RIGHT HAND TOP PLATE FOR K20RS SAW	1
4	FSCA037020	3/8-16 X 1-1/4 FSHCS	8
5	041-007	FOOT PEDAL ASSEMBLY FOR K16-18 AND K20SSF	1
6	HHC5031020	5/16-18 X 1-1/4 HHC5 GR 5 Z	1
7	FHN5031	5/16-18 FHN GR5 ZINC	2
8	TEBZ031032	5/16X2 TURNED EYE BOLT Z	1
9	556-090	CABINET TOP R.H. BACK PLATE ASSEMBLY FOR K20RS SAW	1
10	HHC5025008	1/4-20 X 1/2 HHC5 GR5 Z	21
11	SLWZ025	1/4 SPLIT L/W Z	35
12	556-089	LINEAR RAIL BASE FOR K20RS	1
13	HHC5050032	1/2-13 X 2 HHC5 GR5 Z	6
14	UFWZ050	1/2 USS F/W Z	10
15	SLWZ050	1/2 SPLIT L/W Z	7
16	WON-H30X609.6MM	DC LINEAR RAIL	2
17	SHCA031024	5/16-18 X 1-1/2 SHCS	16
18	WON-H30F	LINEAR BEARING CARRIAGE	2
19	556-088	TRUNNION PLATE FOR K20RS SAW	1
20	SCHAM10040	M10 X 40 SHCS 12.9	8
21	ZERK012000	1/8-27 X 11/16 STIRT LUBE FITTING	3
22	716-028CURTAIN	RUBBER CURTAINS TO PROTECT LINEAR RAILS FOR K20RS SAW (9 X 24 X 1/8 THK RUBBER)	2
23	716-028WEIGHT-5	BAR TO ATTACH RUBBER CURTAIN TO BACK OF TRUNNION PLATE	1
24	716-028WEIGHT-4	BAR TO ATTACH RUBBER CURTAIN TO FRONT OF TRUNNION BASE PLATE	1
25	697-021	SPRING FOR HOOK CHAIN ASSY FOR K16-18 AND K20SSF CHAIN VISE	2
26	697-022	SPRING, FOOT PEDAL FOR K16-18 AND K20SSF SAWS	1
27	716-028WEIGHT	WEIGHT FOR K20RS RUBBER CURTAIN	2
28	716-028WEIGHT-3	TAB FOR K20RS RUBBER CURTAIN WEIGHT (ATTACH CURTAIN TO WEIGHT)	2
29	HHC5025012	1/4-20 X 3/4 HHC5 GR5 Z	14
30	831-020RS	MODIFIED KM20-22 TRUNNION FOR K20RS SAW	1
31	HHC5037036	3/8-16 X 2-1/4 HHC5 GR 5 Z	4
32	SLWZ037	3/8 SPLIT L/W Z	31
33	UFWZ037	3/8 USS F/W Z	29
34	716-028-ROLLERBRKT	ROLLER BRACKET FOR K20RS	4
35	642-001	ROLLER FOR 8-1/2 FRAME	2
36	HHC5031024	5/16-18 X 1-1/2 HHC5 GR5 Z	1
37	HHC5031012	5/16-18 X 3/4 HHC5 GR5 Z	1
38	562-050	PIN, TRUNNION FOR K20RS	1
40	002-005	SAW ARM FOR K16-18, KM16-18, AND K20SSF SAW	1
40	044-004	K20 SPINDLE BEARING	2
41	701-010	SPINDLE W TIGHT FLANGE FOR K16-18, K20SSF, K20E SAWS	1
42	292-011	LOOSE FLANGE FOR K16-20, KM16-18, KM20-22	1
43	537-027	SPINDLE NUT FOR K16-20	1
44	SSKA031006	5/16-18 X 3/8 SOC SET KNURL PT.	2
45	486-010	MOTOR MOUNT PLATE K16-20 ASSEMBLY	1
46	HHC5037016	3/8-16 X 1 HHC5 GR5 Z	9
47	696-030	MOTOR PLATE TENSION SCREW FOR K20RS	1
48	FHN5050	1/2-13 FHN GR5 Z	3
49	HHC5037032	3/8-16 X 2 HHC5 GR5 Z	1
50	486-020	15HP MOTOR FOR K20SSF-15, K20SW-15, KM20-22/15, K20RS, K20E	1
51	FHN5037	3/8-16 FHN GR5 Z	13
52	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
53	049-003	MOTOR PULLEY BUSHING FOR FOR K16-18, KM16-18, K20SSF-15, K20RS-15, K20SW-15, KM20-22-15HP, KM20-22W-15, S10D	1
54	560-047	SPINDLE PULLEY SHEAVE FOR K16-18, KM16-18, K20SSF-15, K20RS, KM20-22/15, MOTOR PULLEY SHEAVE FOR K20SW-15HP	1
55	049-004	BUSHING FOR K16-18, K20SSF-15HP, K20RS-15, KM16-18, KM20-22-15HP SPINDLE PULLEY	1
56	123-003	COLLAR FOR S4- SPACER FOR K20 BELT GUARD	1
57	051-005	V-BELT FOR K16-18, K20SSF, K20E, K20RS, K20SW, KM20AS	4
58	RND-0.375-16X6.25	6-1/4 INCHES OF 3/8-16 THREADED ROD	1
59	RND0.375-16X5.375	5-3/8 INCHES OF 3/8-16 THREADED ROD	1
60	342-039	OUTER GUARD, BELT FOR K16-18 AND K20SSF SAWS	1
61	CPNZ037	3/8-16 CAP NUT NICKEL	2
62	342-112	HALF ROUND GUARD FOR K20SSF	1
63	342-039A	GUARD, INNER BELT FOR K16-18, KM16-18, K20SSF SAWS	1
64	049-116	SPACER BUSHING FOR KS90, KS490, K20/15HP SERIES SPINDLE	1
65	RND-0.5-13 THRD ROD X 1.75 LONG	1-3/4 INCHES OF 1/2-13 THREADED ROD	1
66	940-002	DOWNSTOP, FOR K20RS SAW	1
67	HHC5037024	3/8-16 X 1-1/2 HHC5 GR5 Z	3
68	HHC5037016	3/8-16 X 1 HHC5 GR5 Z	5
69	716-028-BASKET	WEIGHT CATCH BASKET FOR K20RS	1
70	146-013	BRACKET, TABLE LOCK FOR K20RS SAW	1
71	146-013-SHIM	SHIM FOR K20RS TABLE LOCK BRACKET BASE PLATE	1
72	129-011	CAM, TABLE LOCK FOR K20RS SAW	1
73	SHCA050040	1/2-13 X 2-1/2 SHCS	1
74	562-006	PIN FOR LC CLOSER	1
75	697-001	K10-16 VISE ROD SPRING	1
76	ROLA012016	1/8 X 1 ROLL PIN	1
77	381-013	HANDLE ASSEMBLY FOR K20RS SAW	1
78	293-012L	FENCE, L.H. WITH WELDED HOOK FOR K20RS SAW	1
79	293-012R	FENCE, R.H. FOR K20RS SAW	1
80	SHCA037020	3/8-16 X 1-1/4 SHCS	4
81	834-004	TRAY (FOR CHAIN VISE CHAIN STORAGE) FOR K20RS	1
82	342-093	SPARK DEFLECTOR FOR K20RS SAW	1
83	710-019	THUMB SWITCH-K20RS	1
84	940-002ROD	THREADED ROD FOR K20RS DOWN STOP	1
85	FHN5075	3/4-10 FHN GR5 Z	1
86	20 INCH BLADE		1

UNLESS OTHERWISE SPECIFIED:	NAME	DATE
DRAWN BY: []		
CHECKED BY: []		
ENG APPR: []		
AWG APPR: []		
DATE: []		
COMMENTS:		

KALAMAZOR
20 INCH RADIAL ARM SAW
 E K20RS
 SCALE: 1:5 WEIGHT: SHEET 1 OF 2