

KI **KALAMAZOO**
INDUSTRIES, INC.
KALAMAZOO, MI.



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K20SSF 20" ABRASIVE CHOP SAW
15HP & 20HP

MANUAL



MADE IN USA

WARNING!

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

INSPECTION

If these goods are damaged in transit, the **DELIVERING TRANSPORTATION COMPANY** is required by law to make notation of damages on the freight bill. If in your opinion, there may be concealed damage, they are required to make an inspection after goods are unpacked. Transportation rates are made in proportion to damage. Therefore, the carrier and **NOT** the shipper should be charged with any loss or damage. Any claim should be filed with the delivering Transportation Company. **PLEASE DO NOT RETURN GOODS TO US WITHOUT OUR RGA NUMBER AND SHIPPING INSTRUCTIONS.**

Electrical: CAUTION: Voltage changes require wiring changes at drive motor. **WARRANTY DOES NOT COVER** unauthorized wiring changes/failures. **Consult an electrician an electrician if your not familiar with electrics.**

K16-18 SETUP

- BEFORE STARTING OR CONNECTING ELECTRICAL VERIFY THE PHASE AND VOLTAGE OF THE UNIT.
- BE SURE MACHINE IS BALANCED CORRECTLY SO IT WILL TIP OVER.
- TO GUARD AGAINST CONCEALED DAMAGE, STAND CLEAR AND OBSERVE UNIT FOR THE FIRST FEW MINUTES OF OPERATION. GUARDS MUST NEVER BE REMOVED.
- BEFORE INSTALLING THE ABRASIVE WHEEL CONFIRM THAT THE CUTOFF WHEEL IS DESIGNED TO RUN AT 2500 SFPM (MOS). YOU CAN FIND THIS INFORMATION DIRECTLY ON THE THE SIDE OF YOUR CUTOFF WHEEL. IT

ABRASIVE SAW SAFETY

- NEVER REMOVE SAFETY GUARDS FROM MACHINE. DISCONNECT MACHINE FROM POWER SOURCE BEFORE MAKING ANY MACHINE ADJUSTMENTS.
- 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.
- DO NOT USE TOOTHED BLADE WITH THIS SAW AND DO NOT ATTEMPT TO USE STEEL BLADES ON THIS SAW.
- 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.
- MANUALLY TIGHTEN AND LOOSE SPINDLE NUT.
- DO NOT USE IMPACTED GUN TO LOOSEN OR TIGHTEN SPINDLE NUT.
- ALWAYS KEEP WHEEL GUARD IN THE 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 the vertical position.
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 a 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.
9. **DO** tie back hair.

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 fir the machine.
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 spindle 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 noticeable or work gets hot.
9. **DON'T** wear gloves and or have loose clothing when operating machine.
10. **DON'T** use tooth blade on saw.

BASIC K16-18 AND K20SSF OPERATION

1. Be sure of the correct electrical power (phase and voltage) for the motor. The motor has a wiring diagram with specifications on the outer motor case. Verify electrical power before operating. Connect incoming AC power to **L1, L2, and L3** on the contactor. **CAUTION: IF NOT FAMILIAR WITH ELECTRICAL, CONSULT AN ELECTRICIAN!!! FOLLOW ALL SAFETY PROCEDURES. SEE THE ABRASIVE SAFETY SHEET.**
2. Clamp the part securely. Wrap the chain around the piece over the back fence as tight as possible (with foot pad to lock pad). Slip the chain link into the clevis; step down and to the right on the foot pad to close the foot pad and tighten the chain around the part. The part that you need to cut can't move when clamped. Re-adjust the chain if necessary and re-clamp. **NOTE: THE PART CENTER LINE SHOULD BE AHEAD OF THE WHEEL CENTER LINE.** Use any available piece to lay against the back fence first, then the part you want to cut. (No need to cut through spacer/shim).
3. Select the correct abrasive wheel for your job. Abrasive wheels vary in hardness and grain, etc. incorrect wheels will result in nasty cuts. Good cuts are bright, not blue, and or discolored black. Please call an abrasive wheel manufacturer to select the correct wheel for your job.
4. As the abrasive wheel wears down, the down stop will need to be adjusted to allow the abrasive wheel to cut thru your part. Re-adjust the down stop when you put a new abrasive wheel on your machine. Be sure that you check to make sure that the abrasive wheel does not cut into the abrasive saw top
5. Use forceful, steady downward pressure when cutting your part. A good shower of sparks will result. Keep flammable material clear of your work and spark area.
6. Keep drive belts (4 V-belts) tight. 1/2" of slack when squeezed together. Loose drive belts result in loo of power and binding of the abrasive wheel. Carefully use a prybar to pry the motor mount back to tighten the v-belts. Re-tighten the threaded knob against the motor plate to fix belt tension.
7. Be sure to wear adequate safety protection. Safety glasses, face shield, etc. **NOTE: DO NOT OPERATE IN FLAMMABLE AREAS. DO NOT USE STEEL-TOOTHED BLADES.**

