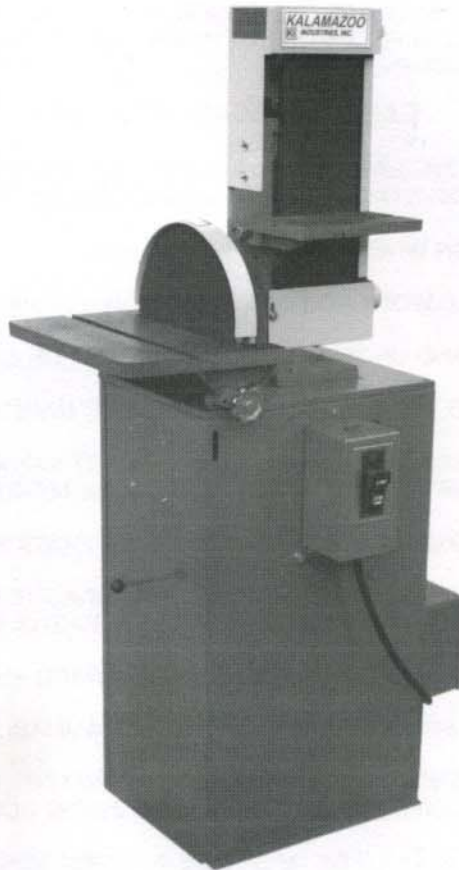


INSTRUCTION MANUAL MODEL NO. S612/S612V SANDER



KI **KALAMAZOO
INDUSTRIES, INC.**



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BELT TRACKING - SANDING BELT TRACKING IS DONE WITH TRACKING KNOB (#20) ON YOKE ASSEMBLY. TIGHTENING KNOB (#20) RAISES IDLER SPINDLE (#34) AND THE BELT MOVES TOWARD THE MOTOR. LOOSENING TRACKING KNOB (#20) DROPS IDLER SPINDLE AND THE SANDING BELT MOVES AWAY FROM THE MOTOR. WHEN BELT IS CENTERED ON PLATEN (#6) TIGHTEN JAM NUT ON TRACKING KNOB (#20) TO LOCK IN BELT POSITION.

IF YOUR SANDER IS NOT TRACKING, POSSIBLE CAUSES COULD BE...

DRIVE PULLEY LOST ITS CROWN (CURVATURE OF PULLEY).

SANDING BELTS ARE NOT SPLICED SQUARE.

UPPER PULLEY ASSEMBLY NOT SQUARED TO PLATEN.

(USE CARRIAGE BOLTS (#13) TO SQUARE YOKE WITH PLATEN.)

SANDING HEAD POSITION - SANDING HEAD CAN BE POSITIONED FROM VERTICAL TO HORIZONTAL WITH ANY ANGLE IN BETWEEN. LOOSEN 5/16" (#8) SOCKET HEAD CAP SCREWS LOCATED IN BASE (#4) WHILE HOLDING SANDING HEAD FIRMLY. SANDING HEAD/FRAME (#26) IS LOCKED IN POSITION BY SQUEEZING BEARING HOUSING ASSEMBLY (#28) AGAINST BASE (#4). WHEN DESIRED POSITION IS REACHED, TIGHTEN 5/16" CAP SCREWS TO LOCK IN SANDING HEAD.

PLATEN - LOCATED BEHIND SANDING BELT IS REVERSIBLE.

NORMAL WEAR WILL OCCUR AND PLATEN WILL NEED TO BE ROTATED OCCASIONALLY DEPENDING ON USAGE. REMOVE SANDING BELT, REMOVE PLATEN SCREWS (#7) AND ROTATE PLATE TO NEW POSITION.

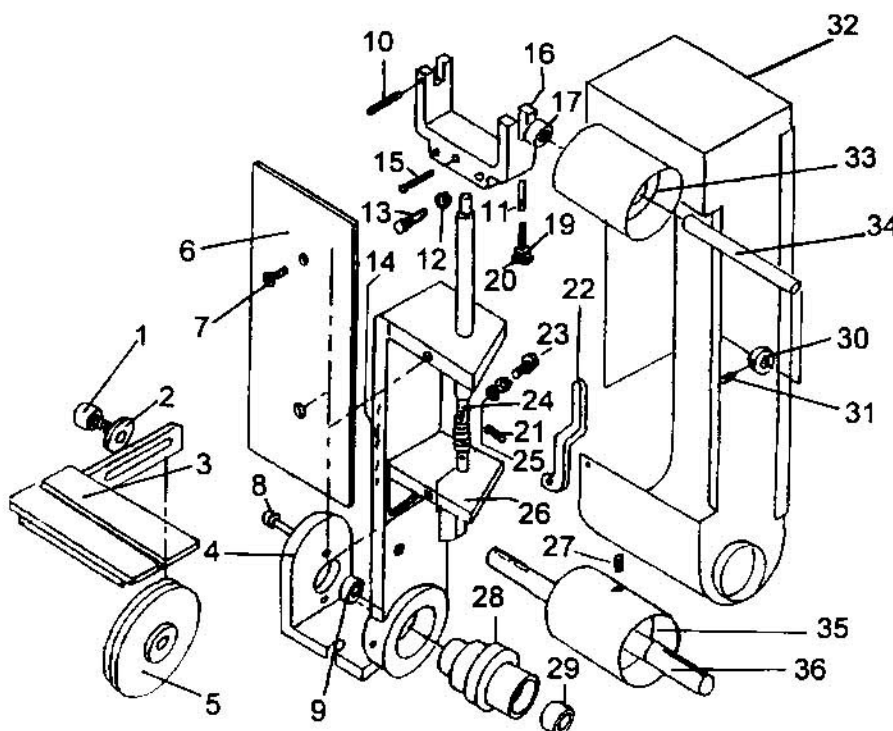
NOTE: CONTINUOUS SANDING ON THE SAME ARE OF PLATEN WILL RESULT IN PREMATURE BELT BREAKAGE.

MOVE WORK PIECE TO DIFFERENT AREAS OF PLATEN TO EXTEND PLATEN AND BELT LIFE.

WORK TABLE - (#3) WORKTABLE HAS KEYWAY FOR FIXTURE OR MITRE GAGE LOCATION. ALSO TWO MOUNTING HOLES ARE PROVIDED ON SIDE OF FRAME (#26) TO MOVE TABLE TO DIFFERENT WORK HEIGHTS FOR LONGER BELT OR PLATEN LIFE.

NOTE: KEEP WORKTABLE WITHIN 1/8" OF SANDING BELT.

BELT SANDER PARTS DIAGRAM

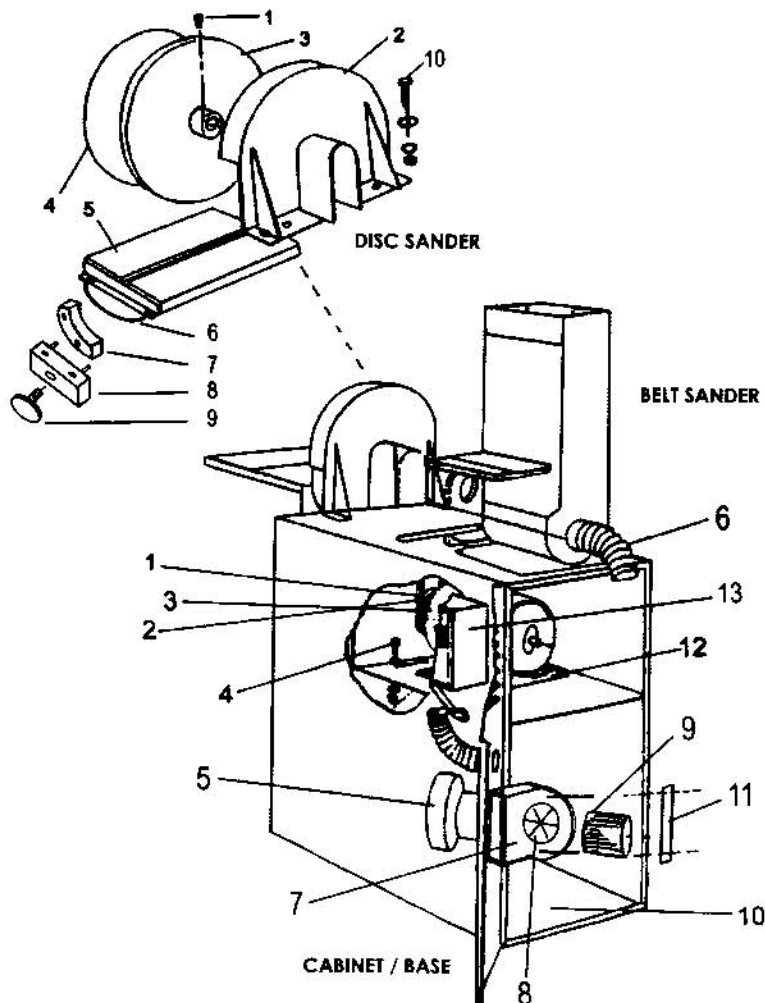


BELT SANDER

ITEM	PART NO	DESCRIPTION
1		1/2-13x1-1/2 SHCS
2		1/2" WASHER
3	829-012	CAST IRON WORK TABLE
4	050-025	BASE
5	560-051	2-GROOVE SPINDLE PULLEY
6	563-002	REVERSIBLE PLATEN
7		5/16-18x1 FHSCS
8		5/16-18-1/4 SHSS
9	044-007	K12 BEARING
10		3/16x2 ROLL PIN
11	562-018	PIN
12		NUT
13		1/4-20x2 CARRIAGE BOLT
14		SERIAL NUMBER LOCATION
15		3/16x2 ROLL PIN
16	960-006	YOKE
17	044-001	K12 BEARING
18		
19		LOCKING NUT
20	441-014	TRACKING KNOB
21		3/16x2 ROLL PIN
22	455-003	TENSION LEVER
23		STOVER BOLT
24	700-004	SHAFT
25	697-024	TENSION SPRING
26	291-004	FRAME
27		1/4-20x3/4 SSS
28	386-013	HOUSEING
29	044-001	K12 BEARING
30	123-009	LOCKING COLLAR
31		SET SCREW
32	342-069	OSHA GUARD
33	560-016	IDLER PULLEY W/BEARINGS
34	701-019	IDLER SPINDLE
35	560-015	DRIVE PULLEY
36	701-025	DRIVE SPINDLE

KALAMAZOO INDUSTRIES, INC. 6856 East K Ave. Kalamazoo, MI 49048
 269-382-2050 PH 269-382-0790 FAX www.kalamazooindustries.com

CABINET AND DISC SANDER PARTS DIAGRAM



DISC SANDER

ITEM	PART NO.	DESCRIPTION
1		SET SCREW
2	342-036	DISC GUARD
3	160-002	ALUMINUM DISC HOLDER
4		12" SANDING DISC
5	829-035	CAST IRON WORK TABLE
6	831-031	TRUNNION/BACKET
7	146-011	CLAMP
8	051-132	BLOCK
9	441-022	KNOB

CABINET/BASE

ITEM	PART NO.	DESCRIPTION
1	051-007	V-BELT (2 REQ)
2	560-052	2-GROOVE MOTOR PULLEY
3	486-006	3HP, 1PH SAW DUTY MOTOR
	486-007	3HP, 3PH SAW DUTY MOTOR
4		5/16-18x1-1/2 HHCS
5	486-022	1/2HP, 1PH VACUUM MOTOR
	486-030	1/2HP, 3PH VACUUM MOTOR
6	389-001	2" VACUUM HOSE (4FT REQ)
7	386-031	FAN HOUSING
8	296-003	FAN
9	294-006	FILTER CARTRIDGE
10	150-001	CABINET & BASE
11	041-063	BRACKET
12	050-026	MOTOR BASE ASSEMBLY
13	710-011	609AJW AB SWITCH

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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Made in U.S.A.

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. KEEP ALL SAFETY GUARDS, WORK TABLES ETC, IN PROPER ADJUSTMENT. WORK TABLE MUST BE KEPT WITHIN 1/8" FROM THE SANDING BELT.

SAFETY PRECAUTIONS

NEVER OPERATE WITH SAFETY GUARDS REMOVED FROM THE MACHINE. THE MACHINE SHOULD BE DISCONNECTED FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS OR CHANGING THE BELT

ALWAYS WEAR PROPER EYE/FACE PROTECTION WHEN OPERATING MACHINE.

NEVER WEAR LOOSE FITTING CLOTHING WHILE WORKING ON OR NEAR ANY MACHINERY.

KEEP LONG HAIR TIED BACK OR PLACE IT UP AND UNDER A TIGHT FITTING HAT OR CAP.

DUST COLLECTION BAGS SHOULD BE EMPTIED FREQUENTLY DURING USE TO MAINTAIN EFFICIENCY AND PREVENT BUILDUP OF COMBUSTIBLE MATERIAL.

SANDING AND GRINDING GENERATES DUST. EXCESSIVE INHALATION OF DUST MAY AFFECT YOUR BREATHING EFFICIENCY. ALWAYS USE DUST CONTROL EQUIPMENT APPROPRIATE FOR THE MATERIAL BEING SANDED.

NEVER USE AN ABRASIVE BELT WITH A NICKED OR CUT EDGE, A CREASE OR HANDLING DAMAGE.

ALWAYS USE AN UPWARD STROKE TO PRESENT THE WORKPIECE TO THE ABRASIVE BELT. THIS METHOD IMPROVES THE SANDING AND INCREASES SAFETY BY DRAWING HANDS AWAY FROM THE ABRASIVE BELT.

SPARKS CREATED BY GRINDING OR SANDING SHOULD BE DIRECTED DOWNWARD AND AWAY FROM THE FACE AND BODY.

DO NOT GRIND NEAR FLAMMABLE MATERIAL. SPARKS SCREENS OF NON-FLAMMABLE MATERIAL SHOULD ALWAYS BE USED.

ELECTRIC PORTABLE MACHINES ARE NOT INTENDED FOR USE IN OR NEAR WATER. THIS INCLUDES AN OPERATOR STANDING ON A WET FLOOR OR WORKING AROUND CONTAINERS OF WATER OR OTHER CONDUCTIVE LIQUIDS.

ALL GRINDING MACHINES AND POWER TOOLS SHOULD BE OPERATED IN A WELL VENTILATED AREA. THE DUST CREATED WHEN SOME MATERIALS ARE GROUND OR SANDED CAN BE HARMFUL. DUST MASKS ARE RECOMMENDED AS A PRACTICAL MEANS OF MINIMIZING DUST INHALATION. THE FUMES FROM OTHER SOURCES CAN ALSO CAUSE FIRES WHEN IN CONTACT WITH GRINDING SPARKS. E.G. FUMES FROM SOLVENTS. ETC.

INSTRUCTIONS FOR S612 & S612V COMBINATION SANDER

SANDING BELT TENSIONING - THE 6" x 48" SANDING BELT HAS PRESET TENSION. THE YOKE ASSEMBLY (#16) IS SPRING LOADED FOR CONSTANT BELT TENSION. TENSION LEVER (#22) TIGHTENS AND LOOSENS BELT TENSION.

BELT CHANGING - OPEN BELT GUARD (#32), LOCATE TENSION LEVER (#22) BETWEEN SANDER FRAME AND PULL DOWN TENSION LEVER TO COMPRESS TENSION SPRING AND RELEASE BELT TENSION. REMOVE & REPLACE SANDING BELT. BE SURE OF CORRECT BELT ROTATION USUALLY INDICATED BY DIRECTION ARROW ON INSIDE OF THE SANDING BELT. LIFT TENSION LEVER (#22) TO ALLOW RE-TENSIONING OF THE BELT. CHECK TRACKING OF BELT WITH SHORT ON/OFF JOGS OF MOTOR BEFORE LETTING THE MACHINE RUN. SPINNING THE BELT BY HAND WITH POWER OFF WILL ALSO CHECK ROUGH TRACKING BEFORE RUNNING MACHINE. BE SURE SANDING BELT STAYS CENTERED ON PLATEN (#6).

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