

OPERATING INSTRUCTIONS AUTOMATIC TRAVELING CUT OFF SAWS

IMPORTANT NOTICE

When installed, or when electric power and compressed air are connected, extreme care must be taken by personnel setting up and operating this saw. The operation of this saw is automatic, therefore, an accidental or intentional signal to cut will cause the saw to go through a complete cutting cycle. Under no conditions should the saw be cycled without the guard-clamp assembly in place. Do not place tools or other objects on the saw table. Keep hands clear of guard-clamp assembly and table when the saw is in operation.

SET-UP INSTRUCTIONS

Remove crating and shipping skid. Check saw for any damage that may have been incurred in transit. Raise leveling-height adjusting pads so saw can be moved if necessary. Move complete unit into production line. Align the saw table with the take-off equipment.

Adjust leveling screws so that movable table assembly is approximately 1/8 inch below the bottom of the section being cut. This distance will vary depending upon the rigidity of the section. On some sections it is advisable to elevate or lower the end further from the extrusion machine. When cutting large heavy sections, be certain that they are supported in a satisfactory manner before and after the saw table, thus eliminating binding of blade by the plastic.

Connect compressed air supply to air filters, 3/8 inch pipe. Fill air oiler with SAE number 10, non-detergent oil. Remove shipping bracket located at extrusion entrance end of unit. This shipping bracket should be saved and put in any time the saw is moved from one location to another. Turn on air. Adjust air pressure to 60 - 70 P.S.I.

Connect saw to electric power specified on your purchase order. Check motor for proper rotation. Saw blade should rotate counter clockwise when viewed from pulley end of the saw arbor. If saw does not have correct rotation, switch any two wires in saw plug except green ground wire. The saw control circuits are interlocked with the motor starter and will not operate if motor is not running. Air solenoid valves are single solenoid spring return type. In case of electric power failure, springs return valves to produce this condition: saw blade up and table at the rest position.

The two clamp pads are pneumatic. The pneumatic clamp cylinder is controlled by a separate air valve located right after the main filter-regulator-lubricator unit.

Start saw and push manual cut button. Do not hold button down. Push and release. Adjust travel speed valves on front panel for desired speeds and smooth operation. Snug up lock nuts after each adjustment, or accurate results can not be obtained.

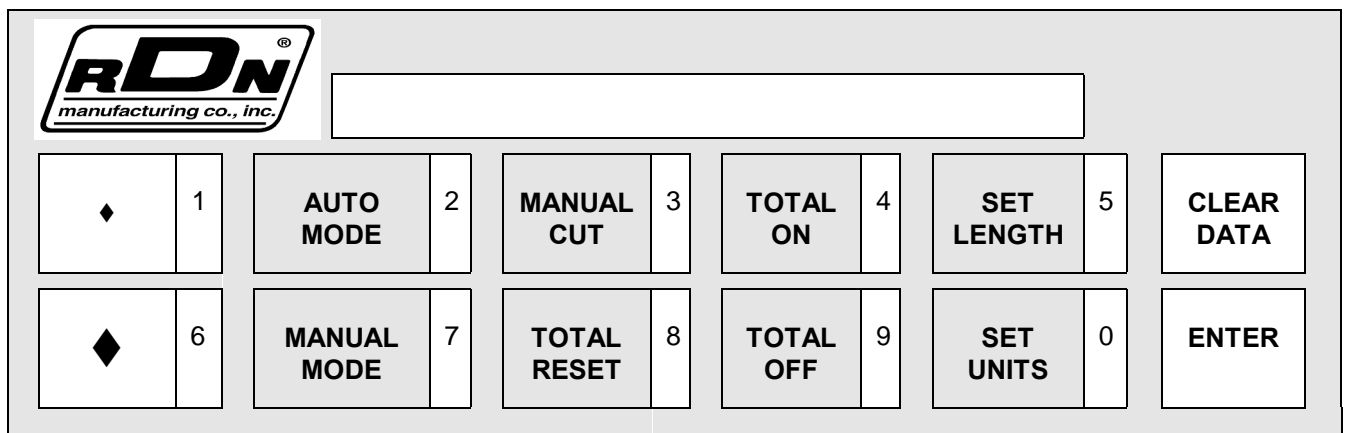
There are also air flow adjustments for the rate of blade travel. These are provided for adjusting this rate for cut quality.

This saw is designed to cycle by momentarily closing the saw cycle circuit. The duration of the closure must be less than time required for saw blade to exit the extrudate after cutting. Normally a pulse type limit switch is used for this closure.

ELECTRONIC CUT TO LENGTH CONTROL - OPTION

For this option a 5 digit electronic counter and encoder provide control of cut length. The encoder should be mounted on the puller so the drive wheel is driven by the puller belt or it can be mounted so that the wheel is driven directly by the extrudate.

Note: Encoder must be rotating clockwise when viewing face of wheel.



CUT LENGTHS ARE SET AS FOLLOWS:

1. Press **⇩SET LENGTH**
Units display current cut length.
2. To change cut length:
Press **⇩CLEAR DATA**
Note: If **⇩CLEAR DATA** is not pressed the keys will function as if a new command is being set. Example: You want to set cut length to 8.00. The key pad will recognize the 8 as the command for **⇩TOTAL RESET**.
The push buttons shift to number values.
Enter desired length.
3. Press **⇩ENTER**
Unit enters new cut length and returns to the Encoder Count.

The largest value that can be set is 655.35 inches or 6553.5 feet.

TOTAL PRODUCT COUNTER

- To view Product Counter press **⇩♦**
 - To return to Encoder Count press **⇩♦**
- Note:* you can turn ON/OFF and RESET in any screen
- To turn on the counter press **⇩TOTAL ON**
 - To turn off the product counter press **⇩TOTAL OFF**
 - To reset the product counter to 0 press **⇩TOTAL RESET**
 - The lower line of the display shows whether the counter is on or off.

AUTO/MANUAL MODE

The display will count when the encoder is turning whether the saw is running or not. When the saw is running the pre-set length will cause the saw to cycle when the Auto Mode is selected. If Manual Mode is selected the unit will count to the pre-set number and re-set, the saw will not cycle and the product count will not increase.

DISPLAY UNITS 'INCHES OR FEET' ARE SET AS FOLLOWS:

1. Press **MANUAL MODE**
2. Press **SET UNITS**
3. Press **CLEAR DATA**
Select units desired
1 = inches
2 = feet
4. Press **ENTER**
The set length will now be re-set to 0
5. Press **SET LENGTH**
Units display current cut length
6. To change cut length:
Press **CLEAR DATA**
The push buttons shift to number values.
Enter desired length.
7. Press **ENTER**
Unit enters new cut length and returns to the encoder count.
8. Press **AUTO MODE**

MAINTENANCE OF SAW**LUBRICATION**

Maintain oil level in air oiler unit. Recommended oil is Mobil DTE® Oil Light ISO VG 32 or equivalent. Set oil flow to about one drop in every fifteen cycles. Grease saw pivot bearings once every 3 months. Grease horizontal travel rod bearings once every month. Grease saw arbor bearings once weekly.

GENERAL

Keep saw head clear. Do not allow chips to pile up under saw. They could obstruct travel of table. Clean and drain air filter unit as required for proper operation of this saw. Check and adjust as necessary the saw blade drive belt.

Keep saw blade in good condition. A dull blade will not produce a good clean cut.

To change saw blade, turn off electric power and air. Remove saw blade guard. Remove nut from saw arbor. Note right hand threads. Remove washer and remove saw blade. Install new or re-sharpened saw blade so it will cut when rotated counter clockwise when viewed from pulley end of arbor. Install washer. Important - washer must be installed as marked. Tighten nut to approximately 110 ft/lbs. Replace guard assembly.

Drain the accumulator inside the saw cabinet by opening the valve on the bottom of the accumulator as required.