

OPERATING INSTRUCTIONS AUTOMATIC TRAVELING 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 bolted 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 incurred in transit. If necessary raise leveling height adjusting pads so saw can be moved. 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 extrudate. 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.

AUTOMATIC SAW INSTRUCTIONS

Connect compressed air supply to air filter, regulator, lubricator, 3/8" npt pipe. Note: air oiler is filled with SAE number 10, non-detergent oil. Turn on air. Adjust air pressure to 70-80 P.S.I.

Before connecting saw to electric power check for correct voltage as specified on your purchase order or the RDN serial tag. Check motor for proper rotation, press start button then stop. Saw blade should rotate clockwise when viewed from pulley end of the saw arbor. If saw does not have correct rotation, Unplug from power source and switch any two wires in saw plug **except green ground wire**. The saw control circuits are interlocked with the motor starter and will operate if motor is 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 down and table at the rest (home) position and clamps in the up position.

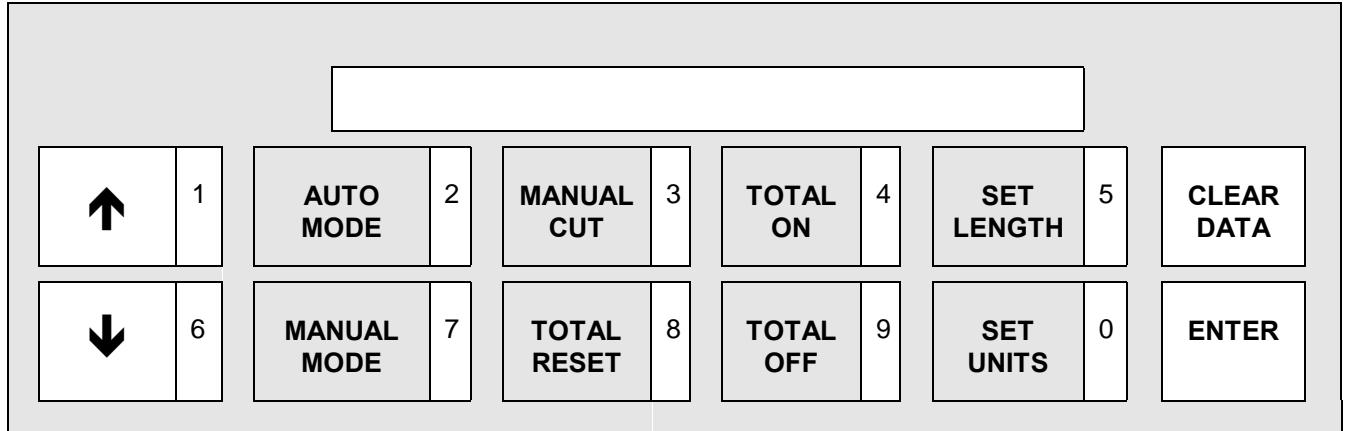
With air on, start saw then push and release manual cut button. Adjust travel out speed valve, located on front panel, to match the speed of the extrusion. Adjust travel return speed valve on front panel to return the table home (to insure an accurate cut length the return speed should be set so the table is at the home position at least 1 second before the next cycle). Using scrap piece of material to be cut, adjust clamping pressure regulator, located in the front of cabinet, so the clamps firmly hold material to be cut. When properly set for material to be cut, push in regulator knob to lock. Using the scrap piece, adjust saw height switch, a knob located on the table top near the saw guard, so saw blade just cuts through material. Clockwise rotation increases height - counter clockwise rotation decreases height. Ten revolutions of knob changes height one inch. When properly set for material to be cut **Lightly** snug up lock nut. After setting height, if necessary, reset and lock table speed adjusting screws.

This saw is designed to cycle by momentarily tripping the remote signal unit (limit switch). The duration of this closure must be less than time required for the saw to cycle through material being cut.

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 \emptyset
Units display current cut length.
2. To change cut length:
Press -CLEAR DATA \emptyset
Note: If -CLEAR DATA \emptyset 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. \emptyset
The push buttons shift to number values.
Enter desired length.
3. Press -ENTER \emptyset
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 \emptyset ↓ \emptyset
 - To return to Encoder Count press \emptyset ↑ \emptyset
- Note: you can turn ON/OFF and RESET in any screen*
- To turn on the counter press -TOTAL ON. \emptyset
 - To turn off the product counter press -TOTAL OFF. \emptyset
 - To reset the product counter to \emptyset press -TOTAL RESET. \emptyset
 - 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

Grease the (4) table travel and (4) saw travel bearings monthly. Gain access to the (4) table travel bearings by the following procedure: Turn off air. Turn off electric power. Bleed air from saw. Manually push table to either end and remove the (2) cover plates to access grease fittings. Then push table to opposite end and repeat.
Grease saw arbor bearing (2) monthly.

Maintain oil level in air oiler unit with SAE number 10, non-detergent oil. Adjust air pressure to 70-80 P.S.I. Check oil flow, about one drop in fifteen cycles.

CHANGING SAW BLADE

To change saw blade, turn off electric power and air. Open rear door and remove the side saw guard assembly. Use the milled wrench flats on the saw arbor shaft while removing or replacing arbor nut to hold the shaft from rotating. Remove nut from saw arbor. Note right hand threads. Remove collar and remove saw blade. Install new or re-sharpened saw blade so it will cut when rotated clockwise when viewed from the pulley end of arbor. Install collar. Tighten nut to approximately 110 ft/lbs. Replace saw guard assembly to table. Close rear door.

GENERAL

Keep saw clear. Do not allow chips to pile up under saw. They could obstruct travel of table. Remove the chip pan and clean out daily. 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.