

# RAZORGAGE

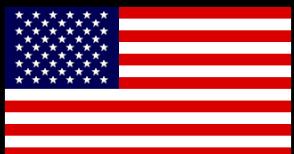
POSITIONERS • SOFTWARE • SYSTEMS



## AUTOPUSHER SAW SYSTEM

Proudly Made in Ames, Iowa, U.S.A.

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# RazorGage Automatic Pusher System

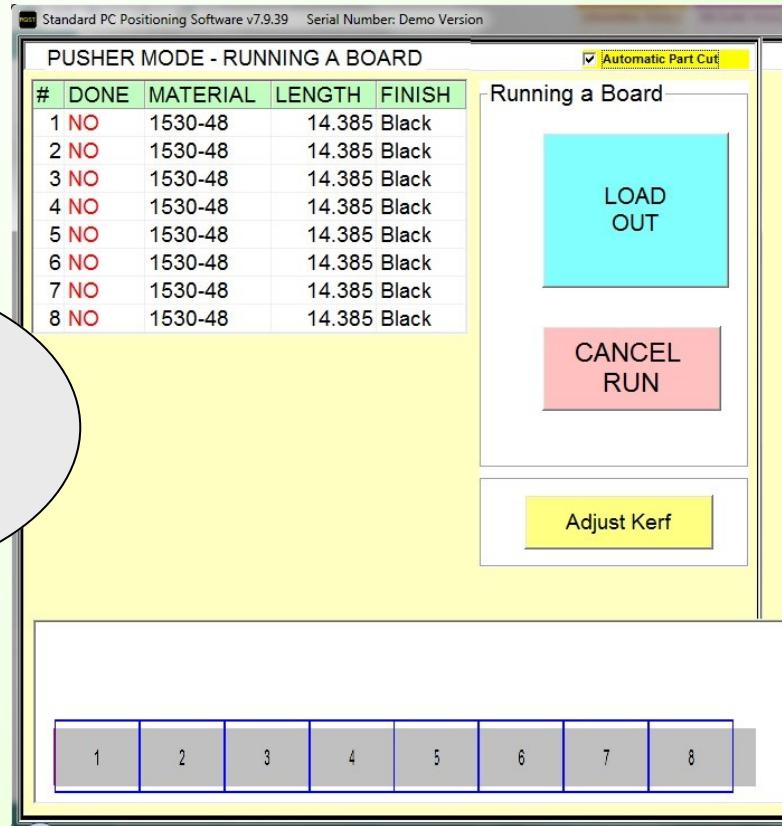
- Download cutlists directly to the RazorGage PC via Ethernet, WiFi or USB drive.
- Optimize at the machine or run pre-optimized lists from most popular software.
- Optionally print paper labels or inkjet print directly on the parts.
- Sort cutlists right at the machine.
- Includes the revolutionary Cyclone Upcut Saw made in America by RazorGage.
- Select solid PVC over steel table top, PVC rollers or steel rollers.
- RazorGage solid state PC - running Windows 8.1Pro
- Includes 21" Color LCD Multi-Touch Screen .
- Optional articulated pusher mounted gripper.
- Aluminum cutting option includes Dual Mist Blade Lubricator. Front to back adjustable top clamp accessory also available.

AutoList Package includes Parts List Processor cut list management software allowing you to map nearly any comma, semi-colon, or tab separated text file for downloading to the RazorGage. Cutlists from your design software can be merged, edited, or simply sent directly to the machine. You can even send different parts to different machines automatically! Once at the machine parts are sorted into groups for your operator to select. Pre-optimized cutlists are grouped according to bar number. As parts are cut their quantity is automatically decremented and are crossed off the list when their quantity reaches zero. The Qty+ button allows the operator to easily bring a part back alive or to simply adjust the quantity. The operator simply enters the length of clear material available and the AutoList finds the optimal cutting solution. Press GO, stand back, and watch the magic. Precision cut parts will begin queuing up on the outfeed table in no time flat! .

The screenshot shows two overlapping windows of the Standard PC Positioning Software v7.9.39. The main window is titled "PART GROUPS" and displays a table of part groups. The table has columns: Group #, MATERIAL, QUANTITY, and LENGTH. Two rows are visible: one for part 1010-72 with 94 units and 265.4 length, and another for part 1530-48 with 94 units and 1,205.4 length. Below the table are two buttons: "SELECT" (highlighted in blue) and "CANCEL". To the right of the table is a small image of a metal part labeled "1010-72". The second window, titled "AutoList Pusher Mode", is overlaid on the first. It shows the current position as 0.000 and the mode as "AutoList Pusher Mode". It has buttons for OPEN FILE, QTY +, QTY -, ENTER QTY, CLOSE FILE, NEXT GROUP, PREV GROUP, and GROUPING LIST. It also shows the total quantity for all parts as 188 and the part grouping as 2 of 2. A table below shows the grouped parts with columns: MATERIAL, QUANTITY, LENGTH, and FINISH. The table lists 1530-48 parts with various quantities and lengths. To the right of the "AutoList Pusher Mode" window are four vertical icons: UP LINE, UP PAGE, DOWN PAGE, and DOWN LINE. At the bottom of the "AutoList Pusher Mode" window, there is a status bar with the path C:\Users\Dave\Desktop\Sample Cutlist\FabTechDemo.rdb and some customer information: 14.385 In., Elevation: FV2, Customer: FabTechDemo.

# RazorGage Automatic Pusher System

Be up and running in no time. Software is intuitive and setup & training are included.



## Defines how parts are sorted into categories

Select the fields used to define different feed stocks

Available fields

- UF\_8
- WIDTH
- THICKNESS
- PART
- MARK
- CABINET NUM
- UF\_5
- SEQ\_NUM
- UF\_7
- UF\_20
- HOLES FROM FRONT
- HOLES FROM TOP
- HOLES FROM BOTTOM
- DETAIL #
- UF\_15
- UF\_16
- UF\_17

Stock definition: Parts are sorted by first item, then second item, then third item, etc.

MATERIAL  
FINISH  
BAR #  
**ELEVATION**

>

<

Shift Up

Shift Down

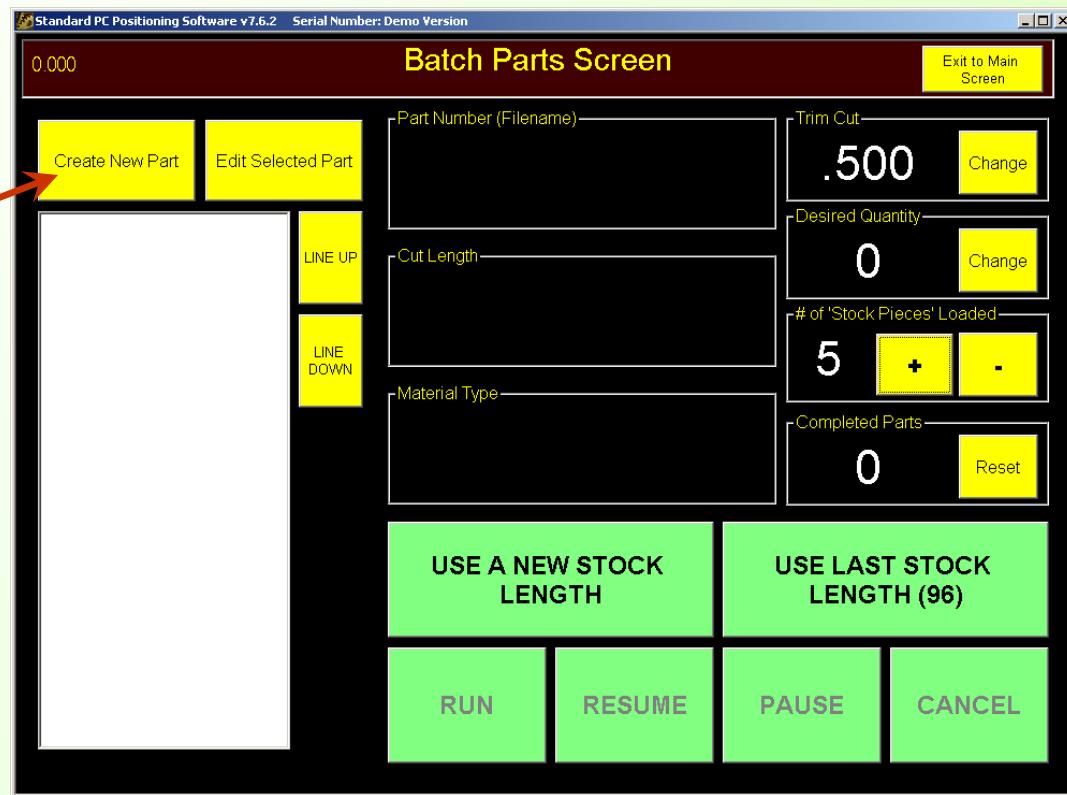
Update Stock Definition

DONE

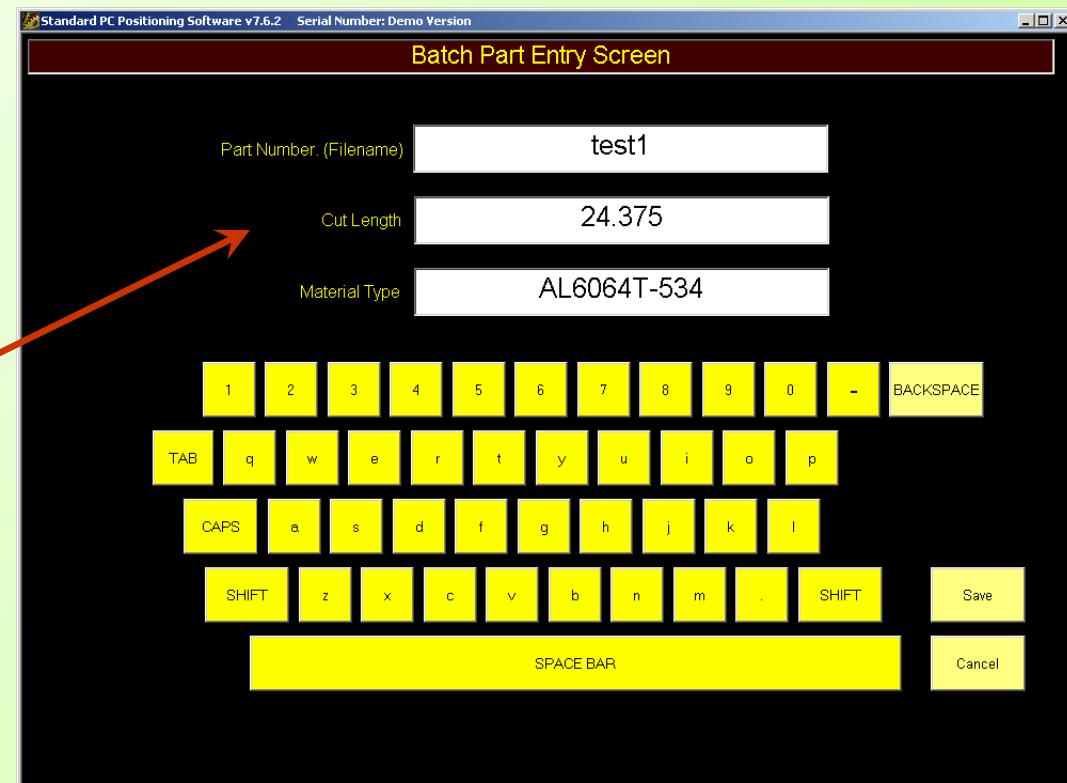
Sorting your cutlist into groups is easy. Change grouping mid-run right at the machine.

# RazorGage Automatic Pusher System

The Batch Screen is included with the Standard PC RazorGage software at no additional charge. It allows the operator to enter and save production runs as quick as can be. With the RazorGage Batch Screen you can define a run by a Part Number, Material Type & Part Length. Leading edge trim cuts, run quantity, number of sticks per run, and stock length can be changed independently of the saved run definition if needed.



To add a part/material configuration click CREATE NEW PART.



Enter a name for the part / material configuration, the length of the parts you want to cut, and the material designation that will tell the operator what kind of stock to use. Then press Save.

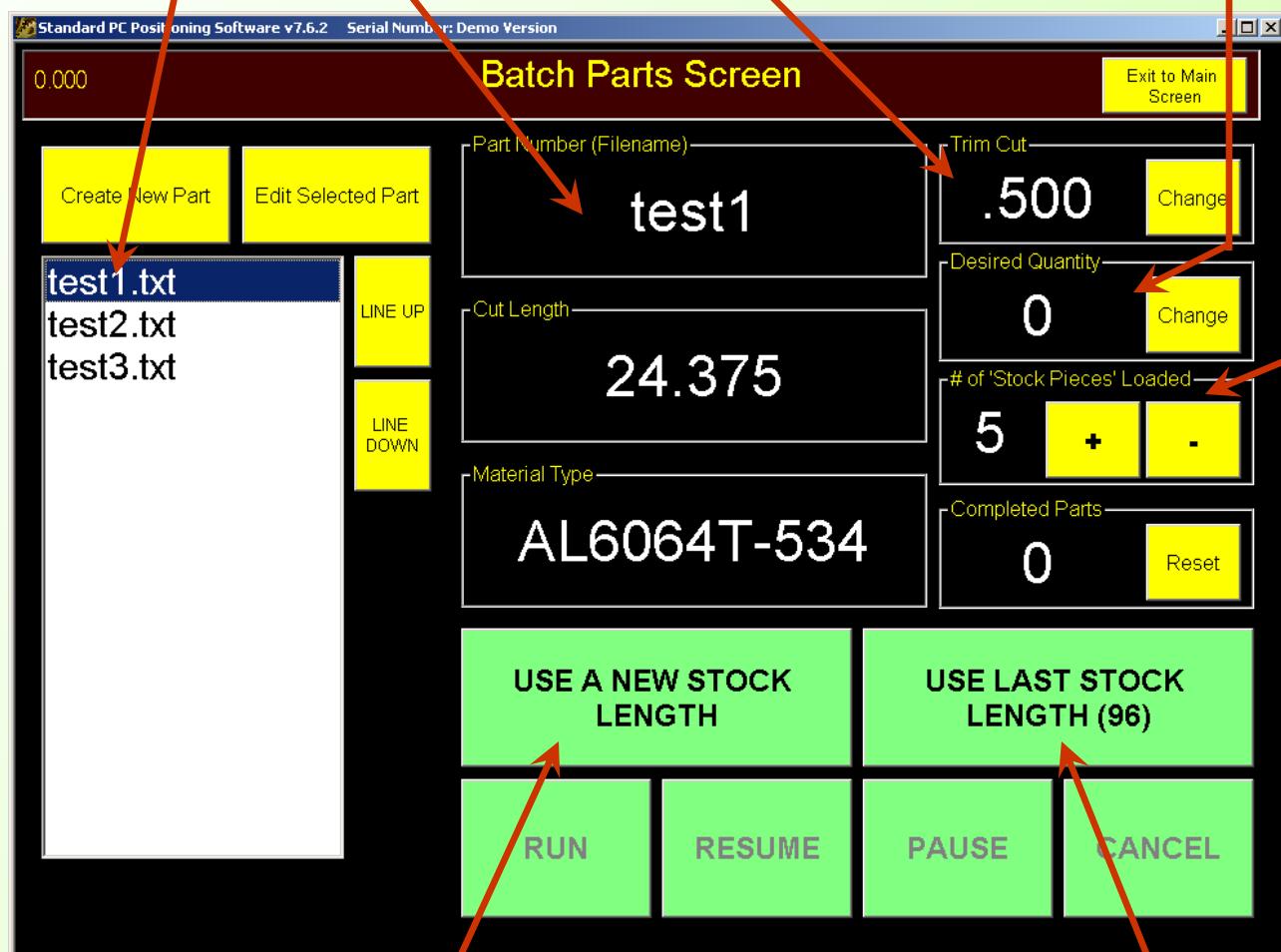
# RazorGage Automatic Pusher System

Once you have entered your part lengths and material types they will appear in the white box at the left of the Batch Parts Screen. Choose a part to bring up that part's information as shown below.

Enter the leading edge trim cut length here. This is a global variable that will stay constant regardless of which part you choose. It may be changed at any time by pressing the CHANGE button.

Press the + or - button to change the number of stock pieces you are going to push. This will enable the software to keep a count of how many finished pieces you've cut.

Enter the desired quantity for the current run here by pressing the CHANGE button.



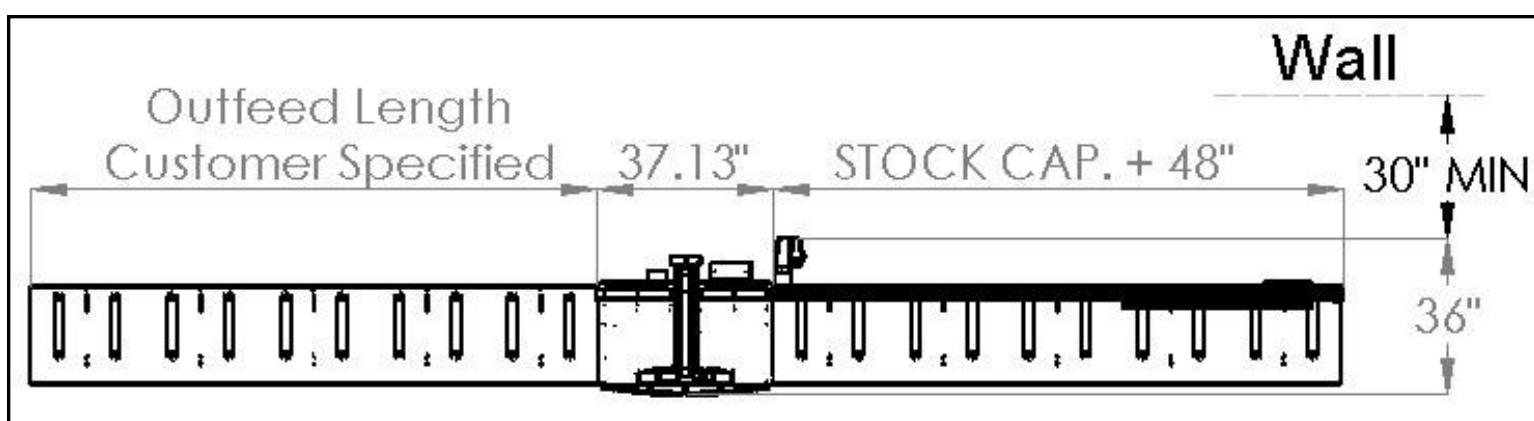
Press the USE A NEW STOCK LENGTH to tell the RazorGage how long of a piece you will be introducing to the machine.

Press the USE LAST STOCK LENGTH to tell the machine that you will be feeding the same size stock that you had previously entered.

# Specifications

Motor Specs	7.5 hp (enclosed fan cooled) available in 208-230-460VAC 3-phase
Power Source	230 VAC, 3 phase, 30 Amps 460 VAC, 3 phase, 20 Amps
Exhaust Port	Two 4" diameter (102 mm) requiring 600 cfm (17 m <sup>3</sup> ) minimum for dry light materials. Other material may need higher velocity/pressure
Compressed Air	Requires 80 psi (5.5 bar) at 5 cfm (0.14 m <sup>3</sup> ) air filtered to 2.5 microns (oil and moisture free). Use industrial air dryer, rated for cfm (CM) flow. No lubrication required for air components. Air must be lubricant free.
Motor RPM	Adjustable up to 3450
Arbor	1.000 inch
500 mm Blade for Wood	500mm x 120T x 1" Bore x 23°ATB/5°ASF x Plate .128 x Kerf .172
500mm Blade for Aluminum	O/D 500mm or 19.68" x Kerf 3.5mm or .137" x Plate 3.0mm or .118" x Bore 25.4mm or 1.00" x Teeth 140 D Type Tip Grade Sash Pro X Expansion Slots Five.
24" Blade for Wood	24" Dia. x 144T x 1" Bore x 23°ATB/5°ASF x Hook 22° Plate.138 x Kerf.186
24" Blade for Aluminum	24" Dia. x 200 Teeth x 1" Bore x TCG x Hook 6° Plate.138 x Kerf.174

Material Thickness	Cyclone 600 Width Capacity for Common Blade Diameters					
	14" Blade	16" Blade	18" Blade	500mm Blade	22" Blade	24" Blade
0.5	6.97	10.38	13.23	15.42	18.27	20.62
0.75	6.04	9.77	12.76	15.02	17.93	20.32
1	4.89	9.10	12.25	14.59	17.57	20.00
1.25	3.32	8.35	11.70	14.13	17.19	19.67
1.5		7.49	11.10	13.64	16.79	19.32
1.75		6.49	10.44	13.11	16.36	18.95
2		5.25	9.72	12.54	15.90	18.55
2.25		3.56	8.91	11.92	15.42	18.14
2.5			7.98	11.24	14.90	17.70
2.75			6.90	10.50	14.35	17.24
3			5.58	9.68	13.75	16.74
3.25			3.78	8.75	13.11	16.22
3.5				7.68	12.42	15.67
3.75				6.40	11.67	15.08
4				4.75	10.84	14.45
4.25				1.99	9.92	13.77
4.5					8.88	13.03
4.75					7.68	12.24
5					6.20	11.37
5.25					4.20	10.40
5.5						9.30
5.75						8.03
6						6.49



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