RazorGage
POSITIONERS • SOFTWARE • SYSTEMS

RazorOptimal Saw
Timer Explanation

To access the SAW TIMERS on the RazorOptimal software, click MORE on the MAIN SCREEN, then click PARAMETERS, and then click SAW. The SAW parameter screen allows access to saw KERF & TIMER settings. The SAW CLAMP TIMER is the time that will elapse between the activation of the front clamps and the activation of the SAW EXTEND signal. Usually this timer can be made quite small without causing any ill effects. If no values are entered in the SAW TIMER & SAW UNCLAMP TIMER, then the saw will operate using the SAW UP & SAW DOWN sensors. In this mode, the SAW EXTEND signal will be activated, the saw will extend until the extended sensor is made, and then the saw will return to it's home position. The clamps will not release until the saw home sensor is detected. If a value is present in either the SAW TIMER or the SAW UN-CLAMP timer fields, then the saw position sensors will be ignored. This feature is handy if a sensor fails or if one wants to limit the saw travel in order to speed up operation. The SAW TIMER describes the time elapsed from when the SAW EXTEND signal is activated to when the SAW RETRACT signal is activated. So basically this is the amount of time the controller is telling the saw blade to extend. The SAW UNCLAMP TIMER describes the time elapsed from when the SAW RETRACT signal is sent to when the CLAMP RETRACT signal is sent. Keep in mind that if you decide to operate the saw cycle according to timers instead of the sensors, that changes in the saw feed rate will affect the saw's extension height.