

# RAZORGAGE

AUTOMATIC OPTIMIZING SAW SYSTEMS

## APS AUTOPUSHER OPTIMIZING SAW

BETTER  
BY  
DESIGN



Our optimizing saw systems are built to provide durable, easy-to-operate cutting systems that are powerful, safe and can improve operating efficiencies while reducing waste



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# APS Autopusher Saw *Automatic Optimizing Saw Systems*



The APS Automatic Optimizing Upcut Saw System is built around the powerful and highly accurate RazorGage RG3 Automatic Saw Measuring System & the durable, clean-cutting Cyclone 600 Upcut Saw.

The APS optimizes your cuts but the main feature is the Automatic Pusher System which allows you to push "Go" and stand back. The automatic saw does the work and allows one person to both feed the saw and stack the finished parts, with no interruption.

The Intelligent Clamping System eliminates the dangerous condition caused by half clamping the leading or trailing edge of your material, which leads to scrapped parts. The accuracy and efficiency of the cutting process eliminates mistakes which further optimizes the production flow to minimize the time required to complete the job.

Great for cutting Wood, Aluminum or nearly any non-ferrous metal. Aluminum cutting option includes aluminum cutting blade and left and right mist blade lubrication.

## FEATURES

- ◆ Download cutlists directly to the RazorGage PC via Ethernet, USB drive or Wifi
- ◆ Optimize at the machine or run pre-optimized lists from your design software
- ◆ Sort cutlists into almost unlimited groups of like material, color, job & more, right at the machine
- ◆ Part length accuracy varies with application but  $\pm .005"$  is possible
- ◆ Push 200 lb at 50" per second
- ◆ Print paper labels or inkjet print directly on the parts
- ◆ Table surface options include solid PVC, PVC rollers or steel rollers
- ◆ Windows Tower PC operation on a large, color touch-screen monitor
- ◆ Optional articulated pusher mounted gripper

# APS Autopusher Saw *Better Software*

The automated saw software on this optimizing industrial upcut saw system gives you the ability to download your cutlists and use multiple criteria to sort lists into hundreds of groups. Our RazorGage software is flexible, allowing you to import

pre-made lists or edit and create cutlists right at the saw. Our software solutions are designed to be intuitive and able to adapt to all types of projects and applications.

## Pusher Screen - Repeating Pattern

LIST: REPEATING PATTERN  
Repeating Pattern Test 4.rfp

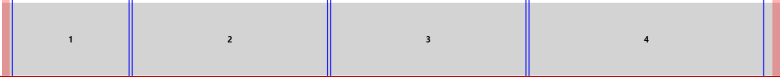
Close The File (.rfp) Create New (.rfp)

Stock Length: 80 Load Position: 85 Lead Trim: 1 Saw Kerf: 0.219 Home Offset: 1.5

INDEX #	LENGTH
1	12
2	20
3	20
4	24

READY FOR LOAD

LOAD



## Pusher Screen - Simple List

LIST: REPEATING PATTERN  
C:\RG3\Cutlists\Test Cut List 1.csv

Close the File Create New Cutlist

Start Trim 1 End Trim 1 Stock Length 70

INDEX#	LENGTH	ORIG. QTY	REM. QTY
1	6	5	0
2	8	5	0
3	10	5	1
4	15	5	2
5	20	5	5
6	40	5	2
7	60	5	5

Optimize ☐

GO

Rem. Qty +1

Rem. Qty -1

All Rem. Qty

## AutoList Optimizing Screen

RG3 v1.9.6.0 Serial Number: 20220000

3-4 Quatersawn Oak(All Parts).r3d SAW STOP Current Pos: 1.500 Switch to PUSHER Mode

CLOSE THE FILE Stock Length: 80 FIT PARTS RG3Mapper

Filtered Parts All Parts Update Qty

Group Parts Groups All Parts Printing

QTY LEFT: 45 LENGTH LEFT: 1572.875

ID	QTY	LENGTH	MATERIAL	MATERIAL ID	PART DESC	WIDTH	THICKNESS	ROOM NAME	ROOM#	CABINET NAME	CABINET#	SCRIBES	POCKET HOLES	PANEL	WI
6	1	18	3/4 Quatersawn Oak	0	BR	1.5	0.75	living room	1	Wall Single	5		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
7	1	18	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Wall Single	5		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
8	1	60	3/4 Quatersawn Oak	0	LS	1.5	0.75	living room	1	Wall Single	5	4 46.5 1.5 6.5	<input type="checkbox"/>	<input type="checkbox"/>	0
9	1	60	3/4 Quatersawn Oak	0	RS	1.5	0.75	living room	1	Wall Single	5	1.5 6.5 1.5 46.5	<input type="checkbox"/>	<input type="checkbox"/>	0
21	1	18	3/4 Quatersawn Oak	0	BR	1.5	0.75	living room	1	Wall Single	3		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
22	1	18	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Wall Single	3		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
23	1	60	3/4 Quatersawn Oak	0	LS	1.5	0.75	living room	1	Wall Single	3	4 46.5 1.5 6.5	<input type="checkbox"/>	<input type="checkbox"/>	0
24	1	60	3/4 Quatersawn Oak	0	RS	1.5	0.75	living room	1	Wall Single	3	1.5 6.5 1.5 46.5	<input type="checkbox"/>	<input type="checkbox"/>	0
43	1	31.25	3/4 Quatersawn Oak	0	LS	1.5	0.75	living room	1	Base Open	1	1.5 5 1.5 10.125 1.5 10.125	<input type="checkbox"/>	<input type="checkbox"/>	0
44	1	31.25	3/4 Quatersawn Oak	0	RS	1.5	0.75	living room	1	Base Open	1	1.5 10.125 1.5 10.125 1.5 5	<input type="checkbox"/>	<input type="checkbox"/>	0
45	1	33	3/4 Quatersawn Oak	0	BR	1.5	0.75	living room	1	Base Open	1		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
46	1	33	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Base Open	1		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
47	1	33	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Base Open	1		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
48	1	33	3/4 Quatersawn Oak	0	TR	1.5	0.75	living room	1	Base Open	1		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
60	1	31.25	3/4 Quatersawn Oak	0	LS	1.5	0.75	living room	1	Base Open	2	1.5 5 1.5 10.125 1.5 10.125	<input type="checkbox"/>	<input type="checkbox"/>	0
61	1	31.25	3/4 Quatersawn Oak	0	RS	1.5	0.75	living room	1	Base Open	2	1.5 10.125 1.5 10.125 1.5 5	<input type="checkbox"/>	<input type="checkbox"/>	0
62	1	33	3/4 Quatersawn Oak	0	BR	1.5	0.75	living room	1	Base Open	2		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
63	1	33	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Base Open	2		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
64	1	33	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Base Open	2		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
65	1	33	3/4 Quatersawn Oak	0	CR	1.5	0.75	living room	1	Base Open	2		<input checked="" type="checkbox"/>	<input type="checkbox"/>	0
82	1	18.5	3/4 Quatersawn Oak	0	LS	1.5	0.75	living room	1	Base Open	4		<input type="checkbox"/>	<input type="checkbox"/>	0

PART CUT

Sort your cut list into hundreds of groups by multiple criteria

Optimize at the machine or run pre-optimized lists according to a cutting plan

Create unlimited cut list mappings

Accommodates secondary operations

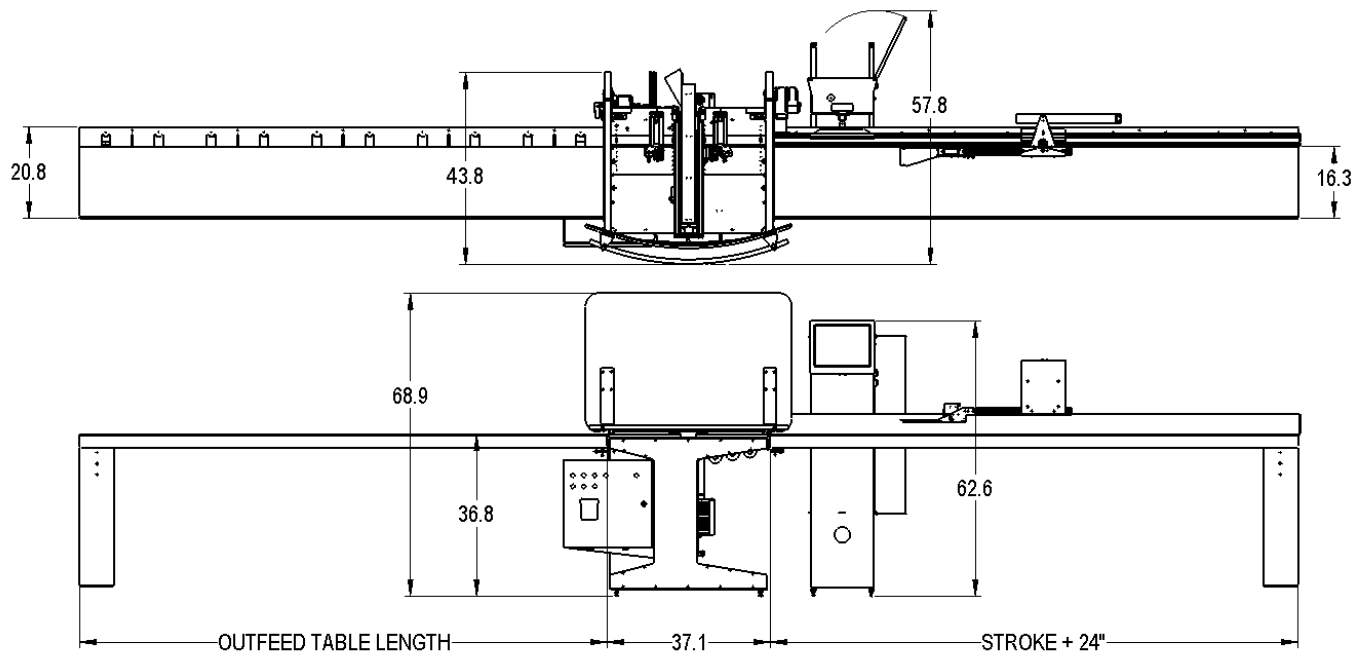
Print custom labels



# APS Autopusher Saw *Specifications*

APS Autopusher Saw System Specifications	
<b>Power Requirements</b>	Positioner - 120 VAC, 10Amp Saw (7.5hp) - 208-230VAC, 3-phase, 30 Amp -or- 460VAC, 3-phase, 20Amp
<b>Dust Collection</b>	Two 4" diameter (102mm) requiring 600 cfm (17m³) minimum for dry light materials. Other material may need higher velocity/pressure.
<b>Compressed Air</b>	Requires 80 psi (5.5 bar) at 5 cfm (0.14m³) 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.
<b>Motor RPM</b>	Variable from 2200 to 3450
<b>20" Blade for Wood</b>	120T x 1" Bore
<b>20" Blade for Aluminum</b>	140T x 1" Bore
<b>24" Blade for Wood</b>	144T x 1" Bore
<b>24" Blade for Aluminum</b>	200T x 1" Bore
<b>Push Force</b>	200 lbs at 40 inches per second
<b>Maximum Push Speed</b>	50 inches per second
<b>Stock Length Capacity</b>	Up to 60 feet

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



## *System Options & Accessories*

- ♦ Ink Jet Printer
- ♦ Basic or Gang Stop Extension
- ♦ Standard or Heavy Duty Gripper
- ♦ Rolling Pin Canted Roller
- ♦ Tables – Heavy Gauge, Powder Coated Steel
  - Height adjusts from 34.5" to 44.5"
  - Surfaces – 1/4" Solid PVC, PVC Rollers, Steel Rollers

