

WE22 Tricks of the trade for panel saw

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Are You Losing Time?

- Function
- Operator Efficiency
- Maintenance

**Getting the most out of
your panel saw**



Operating Missteps

Not getting the material to the saw in time?

- Material still in the rack
- Material not presorted
- No lift table to aid in loading sheets
- Operator has to setup the material
- Incorrect material at the saw

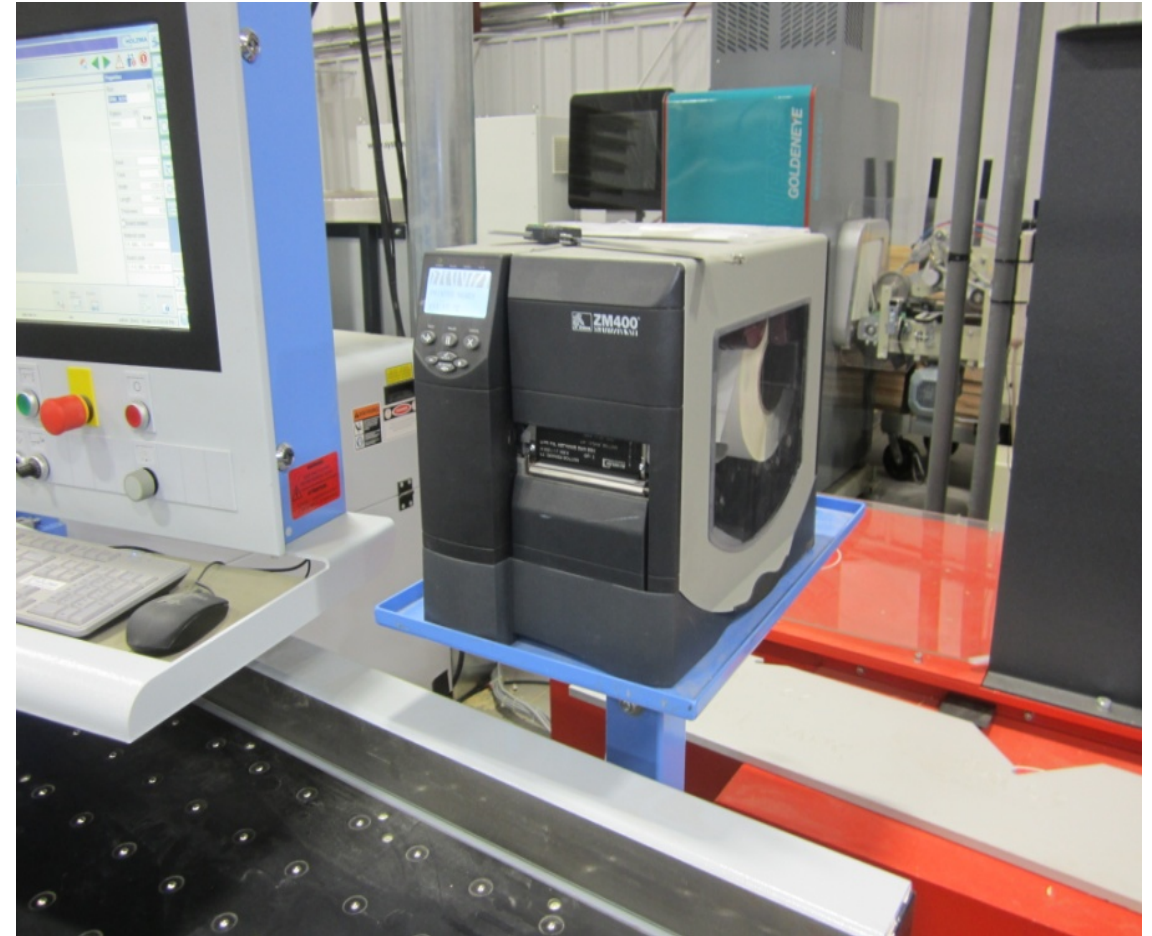
Manual Programming

Operator has to manually program the machine instead of downloading patterns from optimization = **lost throughput** and **increased potential for mistakes**.



Label Printing

- Labels are printed just in time
- Sticking label on parts is quicker than writing on the edge of the part
- Easy to identify part else where in the factory
- Barcode for scanning secondary operation
- Part history if damaged



Taking full advantage of all machine features

Not Using the Full Potential of the Machine Control

program sequencing

single parts

Using the best mode for the application



fixed positioning

manual pattern

cut to length

Advanced features to enhance productivity

Operator Guidance through the cutting sequence

- High-definition graphics flow
- LED Guidance

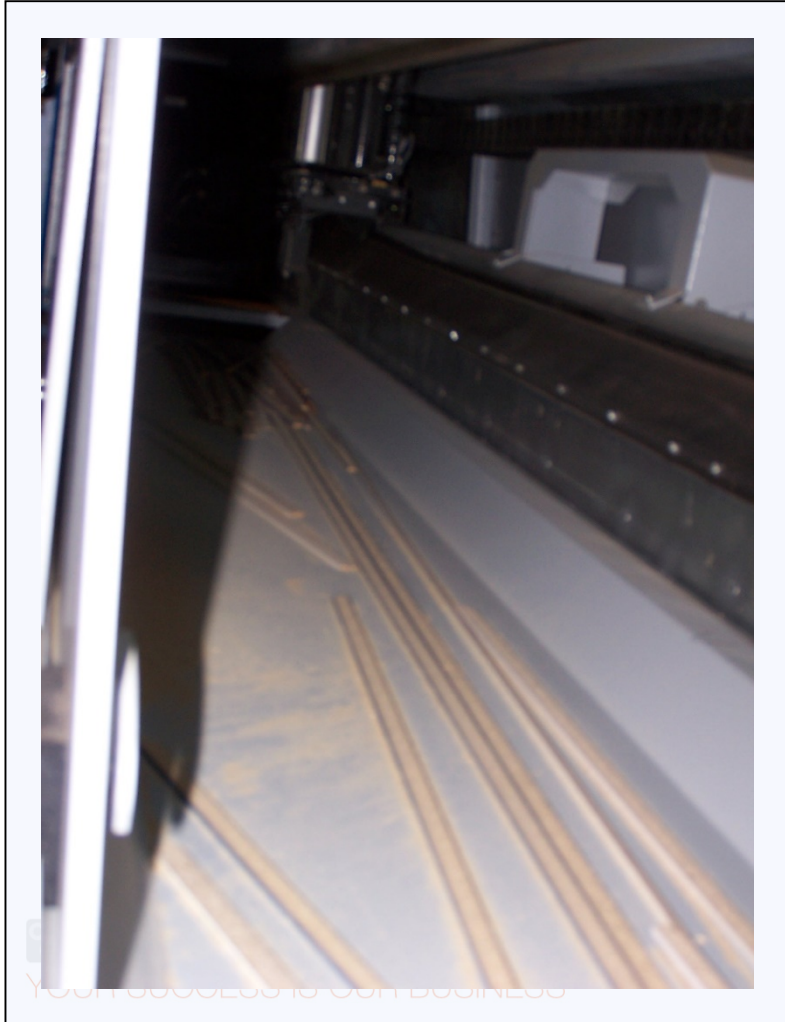


More than squares and rectangles

- Automatic Grooving
- Angle Cutting
- Mitered Panels
- Sink Cutout



Not Adjusting the Trim Cut Sizes



- **to prevent** trims from falling into the saw carriage area
- **to prevent** saw blade deflection
- **to reduce** house keeping

Not Using the Auto Cutting Speed Features



Panel Positioning

- Not positioning the new panel opposite the angular fence
- Not turning the first strip during the rip cycle
- Not positioning the cross cut strip tight against the angular fence
- Not processing the waste during the machine operation
- Not having an effective waste removal apparatus
- Not having a place to conveniently off stack parts
- Not off stacking during the rip cycle

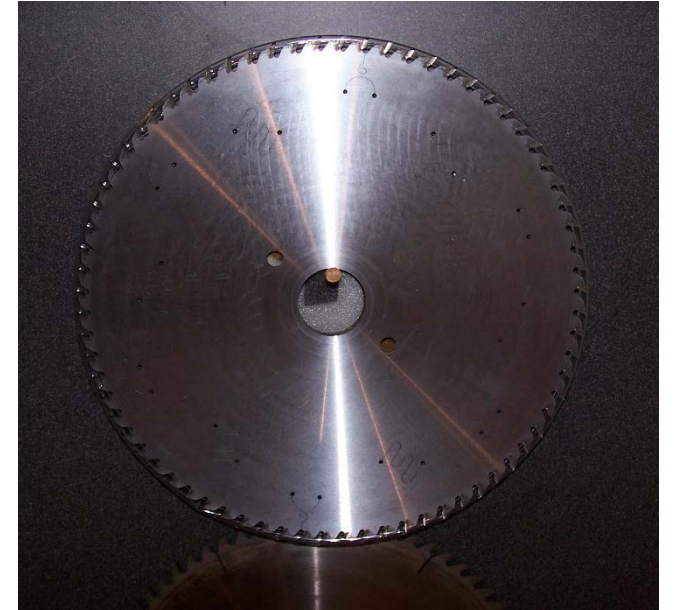
Settings issues after changing saw blade

- Not changing the saw blade thickness parameter after changing the blade leads to finished parts inaccuracy
- Not adjusting the scoring saw to the main saw after changing blades leads to poor cut quality on the bottom sheet

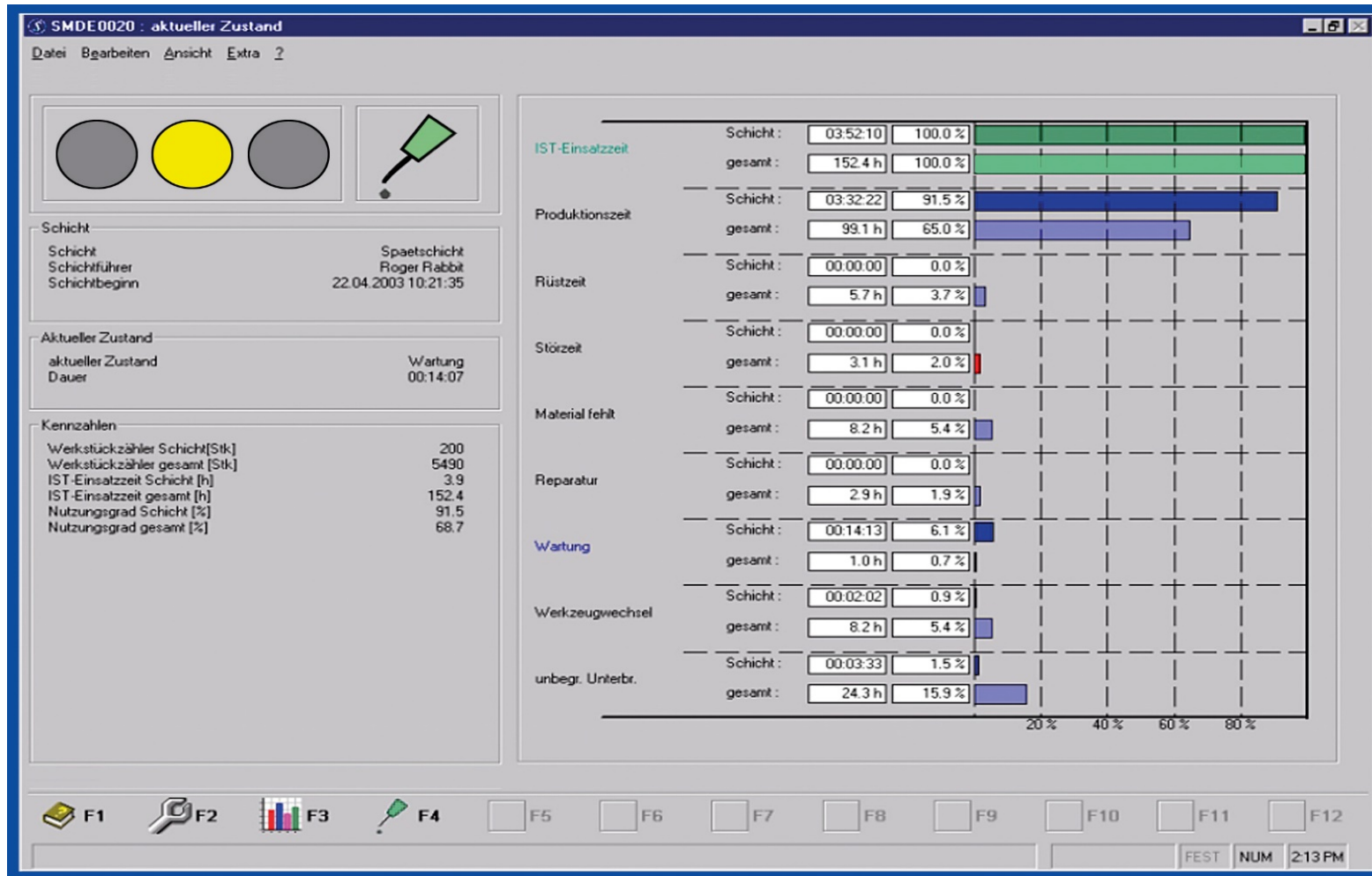


Tooling and Tool Tracking

- Not using high quality tooling
- Not knowing when to change the blades
- Not discarding blades after the original tips are beyond serviceability
- Not having sharp tooling available
- Not tracking tool life between sharpening's



Not scheduling downtime for routine maintenance



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Not Performing Routine Scheduled Maintenance

- Check the clamps
- Check the pneumatic lubricator
- Check the pressure beam rubber
- Check the roller tension
- Check the saw belt tension
- Check the wipers on guideways



Not cleaning the machine routinely

- Trims from under the saw bed
- Electrical Cabinet Filters
- Debris from Pressure Beam
- Debris from Program fence
- Debris from Saw Carriage
- Makes up 85% of maintenance

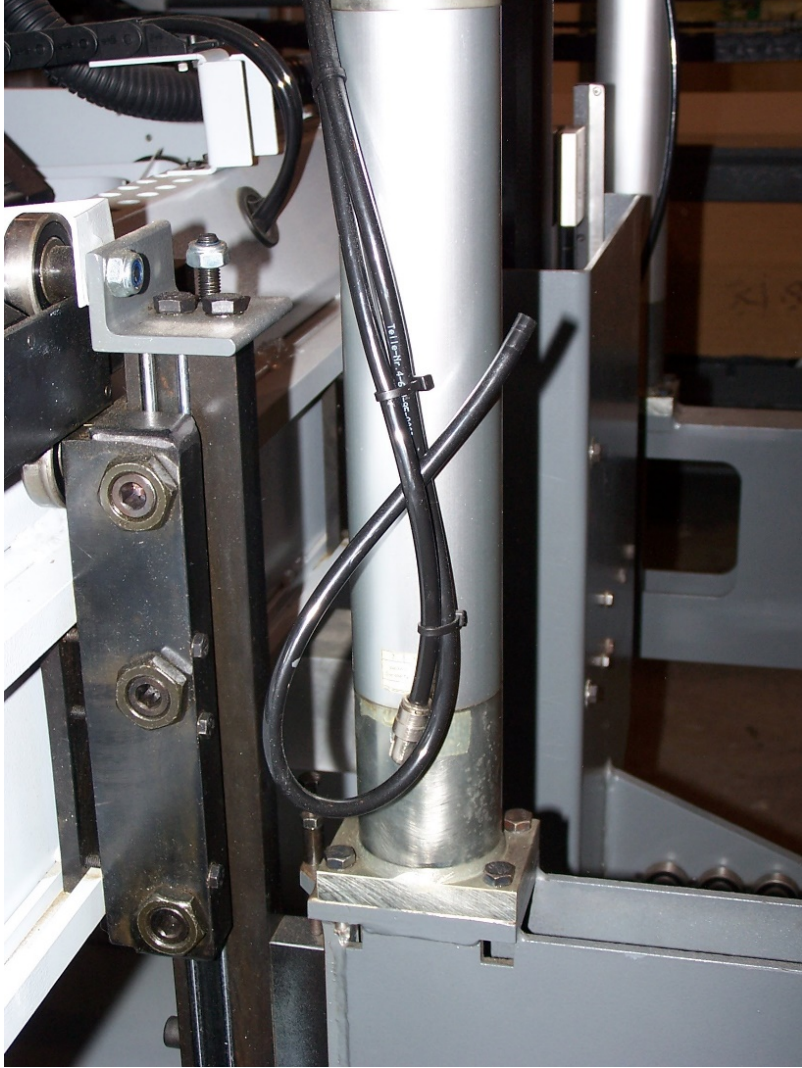


Dust Collection

- Not having adequate dust collection causes excessive house keeping



Proper repairs



- Maintains “uptime”
- Keeps operator confidence
- Predictive throughput
- Less costly to repair along the way rather than major rebuilds

Not utilizing built in diagnostics for quick fixes

CADmatic 4
CADmatic Views Functions Extras Help

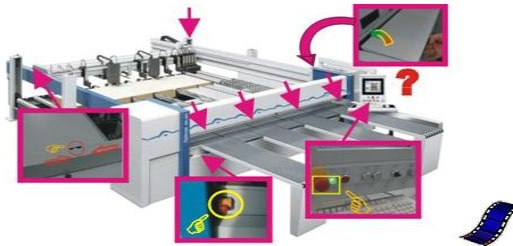
Scoring saw not down

Alarm overview

Alarm ID	Status	Description
Alarm7	Active	Scoring saw not down
Alarm40	Active	EMERGENCY STOP chain broken
Alarm45	Active	Machine not initialized
Alarm3	Active	Pressure beam not up
Alarm224	Active	PLC bus error !!
Alarm197	Active	SPD not down
Alarm151	Active	Saw cover not closed !

E040-EMERGENCY STOP chain broken

- Machine has been stopped by an 'emergency stop' switch
- or the pressure control device in the compressed-air conditioner has cut the control voltage due to a pressure drop (option)



Machine operator

- reset all 'emergency stop' switches on the machine
- Switch on compressor
- Check seals, connections, hoses
- Adjust pressure to 6 bar => see document Compressed air system 9-482-53-1012

Service team

F1 F2 F3 F4 F5 Control lists F6 Axes diagnostic F7 Control diagnosis F8 F9 F10 F11 F12 Additional keys

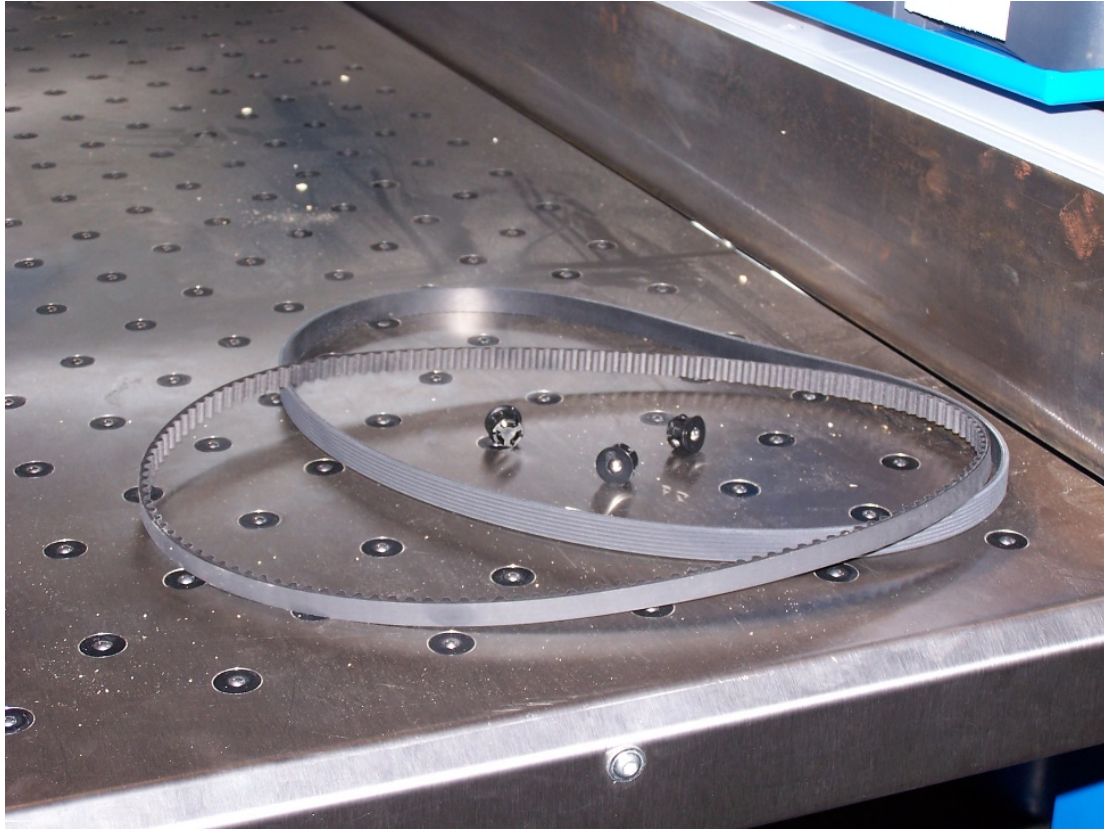
Load alarm overview | Idle | admin | [Metric] | 2/3/2006 9:37:18 AM



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Not Having Minor Spare Parts on Hand



Not having proper utilities (Power/Air/Extraction)

- Large enough pneumatic supply lines to deliver the volume needed
- Need for dry air
- Proper Power Amperage supplied to the machine
- Proper dust extraction connected



In Summary

The following simple operation and maintenance guidelines will:

- Increase throughput
- Improve work flow
- Increase machine runtime
- Reduce downtime
- Improve house keeping
- Reduce part defects

WE22 Tricks of the trade for panel saws

PANEL SAWS HAVE A LOT MORE CAPABILITIES THAN CUTTING SQUARES AND RECTANGLES.

SAVING TIME WITH YOUR PANEL SAW THAT SAVES 30-45 MINUTES MORE PER SHIFT?

PANEL SAW HAVE THREE AREAS:

- 1) *MATERIAL HANDLING OF SHEETS FOR LOADING*
- 2) *CUTTING THE PARTS*
- 3) *HANDLING CUT PARTS COMING OFF THE SAW*

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