FULLY AUTOMATIC
CIRCULAR SAWING MACHINES

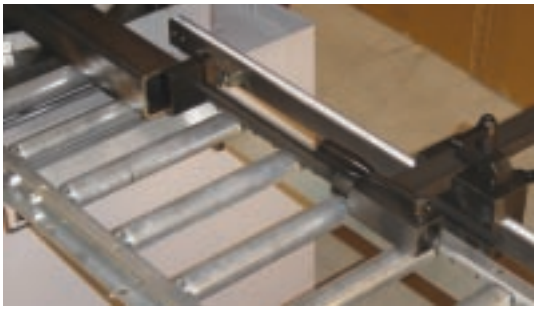
KMT Saw imet

Kalamazoo
Machine Tool

C 370 A-NC
CT 350 A-NC

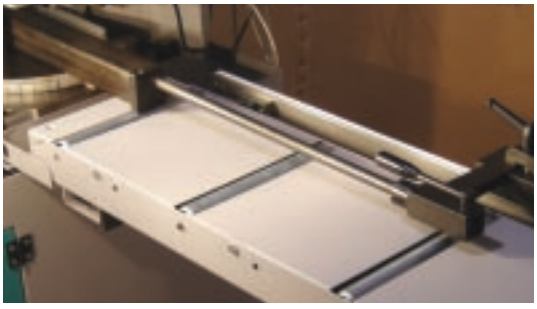
ACCESSORIES

Custom Roller Conveyor w/micro-adjustable legs, mounted to machine, 5' and 10' lengths available.



Accu-cut custom length system
Stop with scale, micro-adjustable legs.

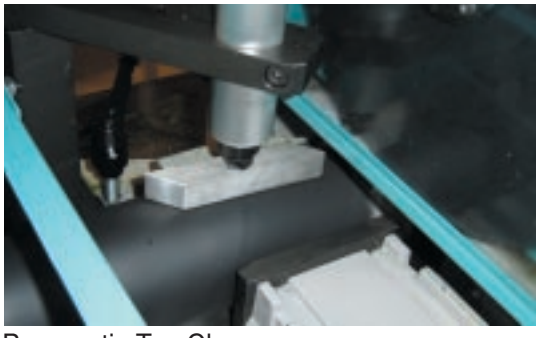
Custom worktable/conveyor w/micro-adjustable legs, mounted to machine.
Cover plates between rollers provide worktable surface 72" and 144" lengths available



Custom worktable/conveyor with Accu-cut custom length system Stop with scale, micro-adjustable legs 72" and 144" lengths available

Vertical Side Guide Rollers
For Custom conveyors only

Freestanding Roller Conveyors 5' and 10' lengths available



Pneumatic Top Clamp
Semi-automatic models only

Footswitch
Semi-automatic models only

FULLY AUTOMATIC COLD SAW

For Ferrous Materials

The **C370A-NC** is a rugged, heavy-duty vertical column circular sawing machine. Vertical column constructions provides extremely stable saw frame guidance and stability with vibration free sawing!

Infinitely variable blade speeds offer flexibility to fine tune the settings for sawing even the most difficult materials.

The **C370A-NC** operators control is the easiest to use programmable saw control on the market.

See basic operation on back page.

Model C 370 A-NC AUTOMATIC CIRCULAR COLD SAW

Specifications

RECOMMENDED CAPACITIES

Round	.4.5"
@45° right	.4.5"
@45° left	.4"
@60° right	.4"
Square	.4"
@45° right	.4"
@45° left	.4"
@60° right	.3.5"
Rectangular	.3.5" x 7" wide
@45° right	.4.75" x 3.5"
@45° left	.4.75" x 3.5"
@60° right	.3.5" x 3.5"

Maximum Vise Opening	.7.125"
Vises	.Pneumatic, infinitely variable clamping pressure
Weight Capacity	.1000 lbs
Blade Spindle Speeds	.13-89 rpm, infinitely variable
Blade Specifications	.12½" (315mm) thru 14.5" (370mm)
Blade Mounting Specifications	.40mm Arbor, with 2 pins, 10mm on 63mm bolt circle
Sawing Force	.Infinitely adjustable
Motors	.Blade Drive 4 HP/Coolant 200 watt
Work Height	.35.25 inches
Automatic Feed Lengths	.⅛" to 20" (with 1 feed) ⅛" to infinite (with multiple feeds)
Barfeed Accuracy	.±0.005"
Leftover Material Length	.5"
Coolant Capacity	.5 gallons
Net Weight	.1875 lbs
Machine Dimensions	.across front, 98"; front to back, 36"; height, 64"

Note: Design specifications subject to change without notice

STANDARD

TEFC MOTORS

LOW VOLT CONTR

FULL GUARDING

FULL COOLANT

DISCONNECT SWI

PRESSURE REGUL

VARIABLE VISE CL

PNEUMATIC TOP C

6' OF INFEED CON

OPERATOR MANU

FULLY AUTOMATIC HIGH SPEED CIRCULAR SAW

For Non-ferrous Materials

The **CT 350 A-NC** is a high speed circular sawing machine designed for high production rates of aluminum extrusions, small aluminum solids, and other non-ferrous materials. A carbide tipped sawblade and spray mist coolant routinely yield rms 50 quality cuts. Double vising provide safety and quality.

See basic operation on back page.

Model CT 350 A-NC AUTOMATIC HIGH SPEED CIRCULAR SAW

MT Saw imet

D EQUIPMENT

ROL

ITCH

ULATOR/OILER-WATER SEPARATOR

LAMPING

CLAMP

NVEYOR

UAL/PARTS LIST

Specifications

RECOMMENDED CAPACITIES

Round . . . . . .4.75"
@45° right . . . . . .4.5"
@45° left . . . . . .4.5"
@60° right . . . . . .3.0"

Square . . . . . .4.5"
@45° right . . . . . .4.0"
@45° left . . . . . .4.0"
@60° right . . . . . .2.75"

Rectangular . . . .7.5" x 3.5" wide
@45° right . . . . . .5.9" x 2.75"
@45° left . . . . . .5.9" x 2.75"
@60° right . . . . . .7.0" x 2.25"

Maximum Vise Opening . . . . . .8.0"
Vises . . . . . .Pneumatic, infinitely variable clamping pressure
Weight Capacity . . . . . .880 lbs
Blade Speeds . . . . . .3600 RPM
Blade Specifications . . . . . .14" (350MM)
Sawing Force . . . . . .Infinitely variably adjustable
Saw Frame Cycle Time . . . . . .raise, full stroke in 4 seconds; lower in 4 seconds
Barfeed Cycle Time . . . . . .full stroke, 6 seconds
Motors . . . . . .Blade Drive 3 HP
Work Height . . . . . .39.75 inches
Automatic Feed Lengths . . . .1/8" to 20" (with 1 feed) 1/8" to infinite (with multiple feeds)
Barfeed Accuracy . . . . . .±0.005"
Leftover Material Length . . . . . .8"
Coolant Capacity . . . . . .5 gallons
Net Weight . . . . . .1600 lbs
Machine Dimensions . . . . . .across front, 98" front to back, 52" height, 77"

Note: Design specifications subject to change without notice

Basic Operation

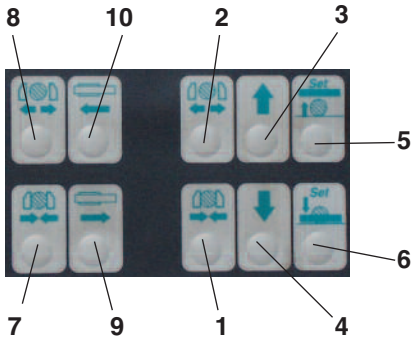
Overview of Controls

The group on the RH side are as follows:

Sawvise clamp (1)
Sawvise unclamp (2)
Sawframe raise (3)
Sawframe lower (4)
Memory point (SET) for upper travel of sawblade (material height) (5)
Memory point (SET) for lower travel of sawblade (cutoff point) (6)

The group of four buttons at the LH side are as follows:

Feeder vise clamp (7)
Feeder unclamp (8)
Feeder vise travel forward (9)
Feeder vise travel reverse (10)



Semi-Automatic Operation

Setting Saw Vise

- Push vise unclamp button
- Place material in vise, close handwheel to material, then open again about 1/8”
- Push vise clamp button to clamp material in vise

Setting Material Height

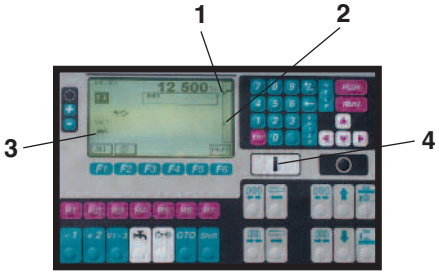
- Push “raise’ button until sawframe is at desired height for material to be cut
- Push & hold memorize button. You will see the arrow adjacent to it jump to the same position as the sawblade (1)

Setting Material Depth (cutoff point)

- Push lower button until sawframe is at desired cutoff point
- Push & hold memorize button. You will see the arrow adjacent to it jump to the same position as the sawblade (2)

Setting Blade Speed

The blade speed is set in accordance with the material you wish to cut (3)



Cycle Control

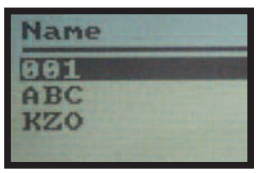
Cycle start button (4) initiates one complete sawing cycle. The sawframe begins the cut at the top SET point, completes the cut, and returns to the same top SET point. The coolant will automatically come on during the sawing cycle and automatically shut off at the end of a cycle.

Fully Automatic Operation

PushF2 (Library of programs)
On the following screen, you can see 3 programs.
The first one is 001, the second one is ABC, and the third one is KZO.

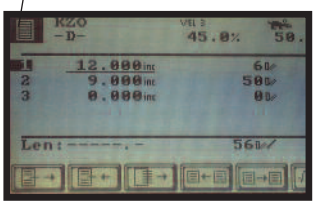
Once you are in the library of programs, you can do one of the following:

- F1 - Create a new program
- F2 - Delete an existing program
- F3 - Delete all programs
- F4 - Move to end of list (your list will eventually get quite long)
- F5 - Move to the beginning of list



Scroll through to the program KZO, then press **PGM**. Following is an example of a program KZO displayed. You can see that you are in **PGM** mode, as the icon in the upper left hand corner is a single page (1)
The information shown, from left to right is as follows:

- KZO - The name of the program
- VEL 3 - The speed of the barfeeder
- -D- not used at this time



- 45% - a reference to the position of lower SET point
- 50% - a reference to the position of upper SET point

The following numbers:

1 12.000 6
2 9.000 50

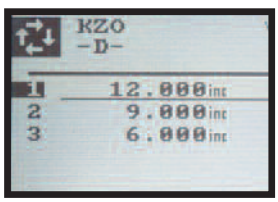
Mean that this program will cut 6 pieces 12” long, followed by 50 pieces, 9” long

Automatic Startup

- Go to F2 (Library)
- Scroll to job desired
- Push PGM (to call up job), and inspect parameters **OR**
- Push RUN (to prepare to start)

Note: after you enter RUN you will see the symbol in the upper left hand corner that indicates ready for fully automatic operation, and it will not be possible to enter any more data without going back to previous screen.

When ready, push Cycle Start.



The next message you will receive is to ask you if you want a **Face Cut**; **Yes or No**. If you want to make a trim cut on the end of your bar, push **F1 (YES).**