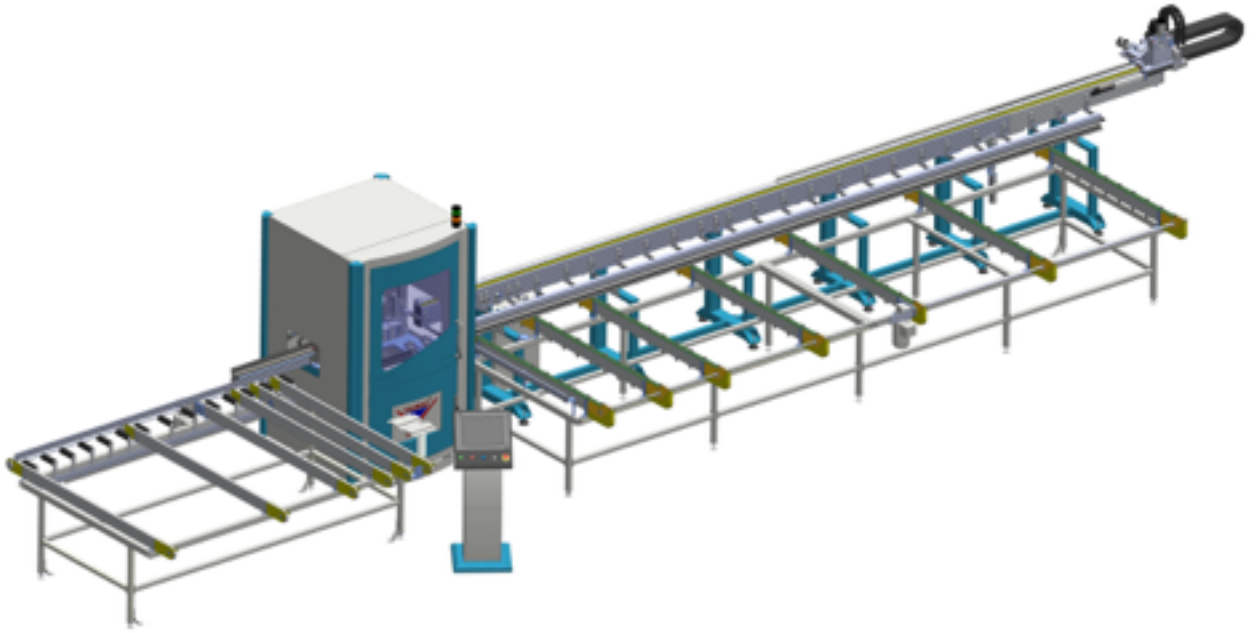


PCC 6505 PROFILE CUTTING LINE



1.DESRIPTION

PCC 6505 is a servo controlled machine which is specifically designed for the serial cutting of any kind of PVC and aluminum profiles in the market. The machine is able to cut PVC and aluminum profiles into required dimension. Operator places 10 pieces of profiles of maximum length of 6.5 m (21.3 ft) and minimum length of 0.7 m (28") on the feeding conveyor of the machine, and presses on start button. Machine start the cutting operation of the profiles by the help of high performance robot arm and saw unit as per the requested angle between the angle of 30°-150° then collocates on the outlet conveyor. Operator attaches barcodes on the processed parts to make them ready for the assembly.

2.GENERAL SPECIFICATIONS

- 500 mm (20") of down cutting saw blade



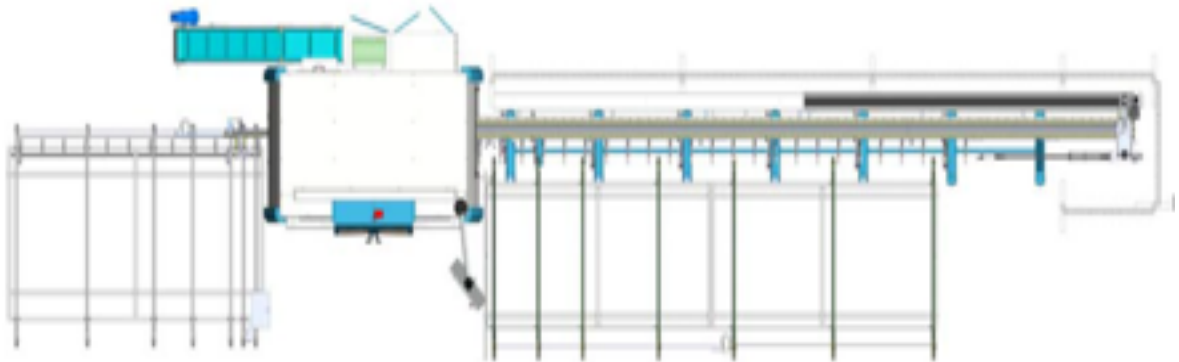
- YASKAWA/JAPAN servo control system ensuring movement at 5 axes
- Average time for single piece cut : 8-10 sec/pc.
- Processing capacity of 2600 -3000 running meters /8 hours
- Protection cabinet around cutting head



- Pneumatic gripper for accurate positioning of the profiles



- Property of full automatic feeding, carrying, positioning, cutting and transferring the profiles



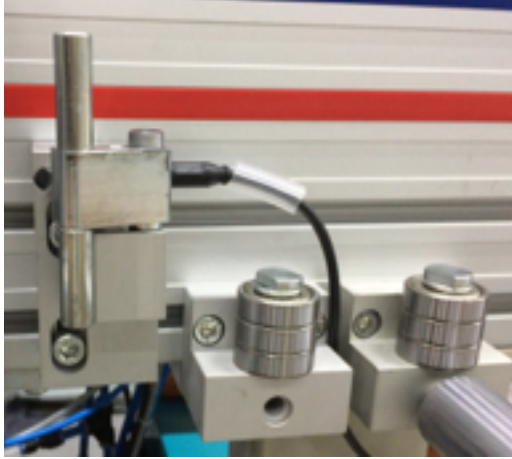
- Automatic conveyor unit able to feed 10 pcs of profiles



- Automatic servo saw blade unit rotating between the range of 30° and 150° with accuracy of $\pm 0.1^\circ$.
- Windows based PC and 15" LCD industrial touch screen color monitor



- Remote connection and providing technical support
- Interface program easily integrated to all the drawing programs
- Frame and sash recognition system



- Profile width and height dimension control system



- Flat type of scrap conveyor



- Automatic lubrication system

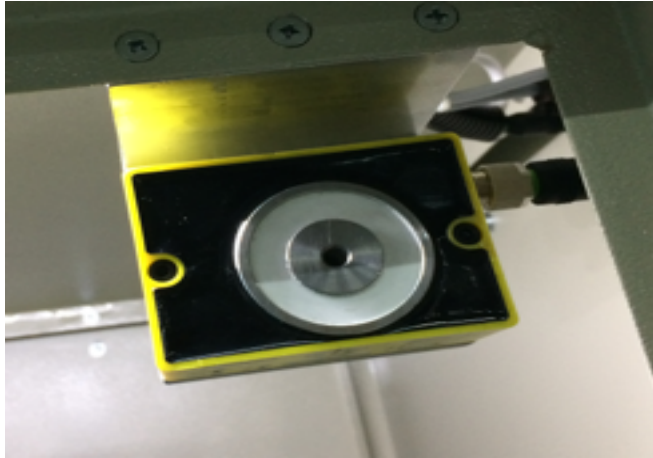


- Spray mist saw blade lubrication

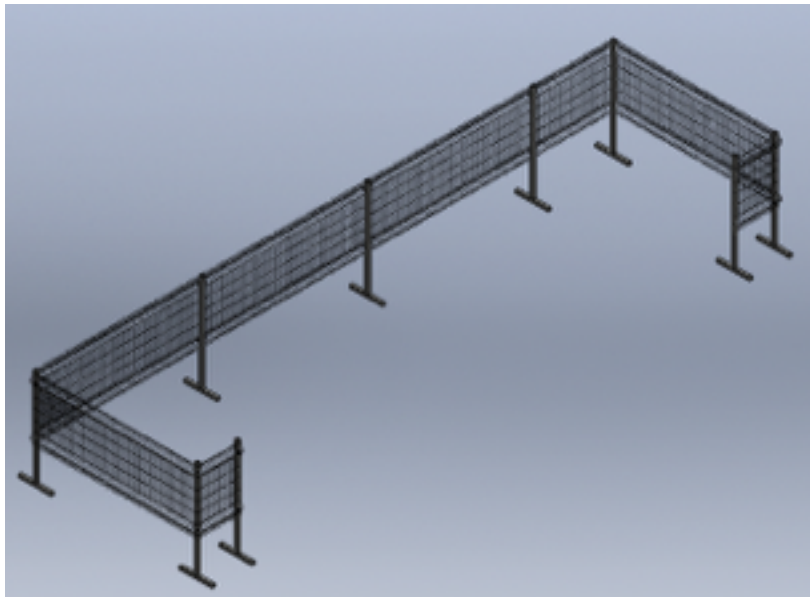


- Low pressure control for saw blade safety operation

- Door safety switch

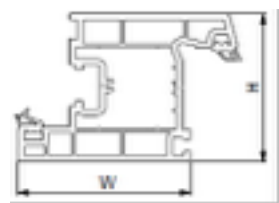
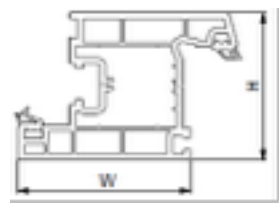


- LED interior lighting with very low energy consumption
- Safety fence around the machine

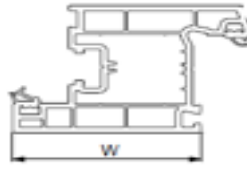
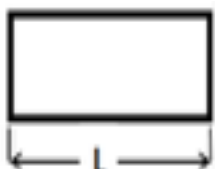


3. TECHNICAL FEATURES

AXIS	
Total axis	5
POSITIONING SPEED	
X-Axis (robot positioning) speed	130 (m/min)
Y-Axis (down-cutting) speed	80 (m/min)
AUTOMATIC CUTTING UNIT	

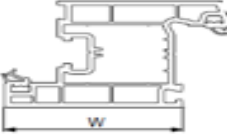
Saw blade diameter ($\varnothing$)	500 mm (20")
Saw blade cutting angle range	30 °- 150°
Min. cutting length at 90°	See item 3.1
Min. cutting length at 45°	See item 3.2
Cutting accuracy	+/- 0.1 mm
GENERAL	
Minimum profile dimensions, (Width, Height)	 W min : 40 mm H min : 40 mm
Maximum profile dimensions (Width, Height)	 W max :130 mm H max : 180 mm
Maximum loadable profile length	6500 mm
Saw blade power	2.2 kW
Power	230/400V 3P-50/60Hz, 208-220-440V 60Hz
Total power	7 kW

3.1. Technical Details for 90° Cutting Operation

Cutting degree	Profile width (W)	Cutting Length	Important notes
			
90 °	40 – 130 mm	10 - 99 mm	- With 450 mm of waste at the end of profile - Cut pieces are taken out by flat type of scrap conveyor

90°	40 - 50 mm	Min. 100 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
90°	50 - 60 mm	Min. 130 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
90°	60 - 130 mm	Min 220 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically

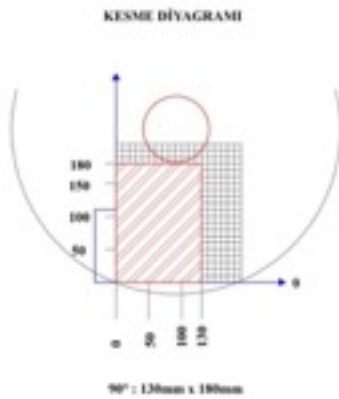
3.2. Technical Details for 45° Cutting Operation

Cutting degree	Profile width (W) 	Cutting Length (L) 	Important notes
45°	40 mm	Min. 230 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	41 - 50 mm	Min. 250 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	51 - 60 mm	Min. 270 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	61 – 70 mm	Min 290 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	71 – 80 mm	Min 310 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	81 - 90 mm	Min 330 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically

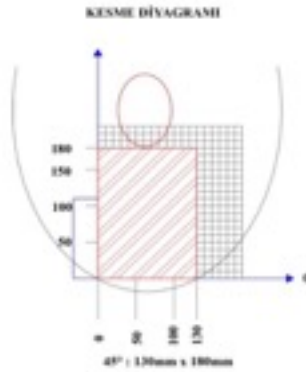
45°	91 - 100 mm	Min 350 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	101 - 110 mm	Min 370 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	111 - 121 mm	Min 390 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically
45°	121 - 130 mm	Min 410 mm	- With 450 mm of waste at the end of profile -Parts are taken out automatically

							kg	kg
PCC 6505	1x3 kW-50/60Hz 2x0.37 kW servo 1x0.55 kW servo	2450 R.P.M	D=500 mm d=30 mm	6 Bar	50 lt.	W= 380 H= 250 L= 1250	1950 (4,290 lbs)	2170 (4,774 lbs)

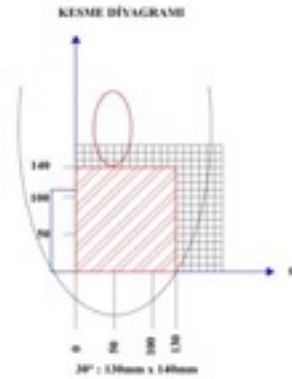
CUTTING DIAGRAM (90°)



CUTTING DIAGRAM (45°)



CUTTING DIAGRAM (30°)



4.OPTIONAL EQUIPMENT

ITEM #	PICTURE	STOCK CODE	PART NAME
1		1HM010000-0008	ANGLED TYPE OF SCRAP CON- VEYOR Handling chip and scrap profiles by using conveyor and storage
2		3UA880030-0101	GODEX EZ 1105 LABELLING MACHINE
3		1HM020000-0020	CHIP VACUUM EXTRACTOR Motor power: 3kw 4 HP Speed: 3000 RPM Flow rate: 3500 m3/h Pipe extractor : 4 x Ø125 Dimen- sions: W 660x L2000x H 1350 mm
4		4UN400030-0004	VP 1000 VERTICAL PROFILE TROLLEY
5		4UN400030-0005	HP 1000 HORIZONTAL PROFILE TROLLEY

6		1SK010000-0106	ADDITIONAL SAW BLADE (Ø500 mm / d: 30mm)
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