



PAT MOONEY, INC.

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PMI-CNC 4S 4 Axis Notching Saw System
PMI PRECISION UPCUT SAW FOR ALUMINUM EXTRUSIONS AND PROFILES

The PMI-CNC 4S is a 4-axis sawing machine designed to make complex cuts on ends of aluminum extrusions. The saw head position is controlled by servo motors to ensure accurate movements.





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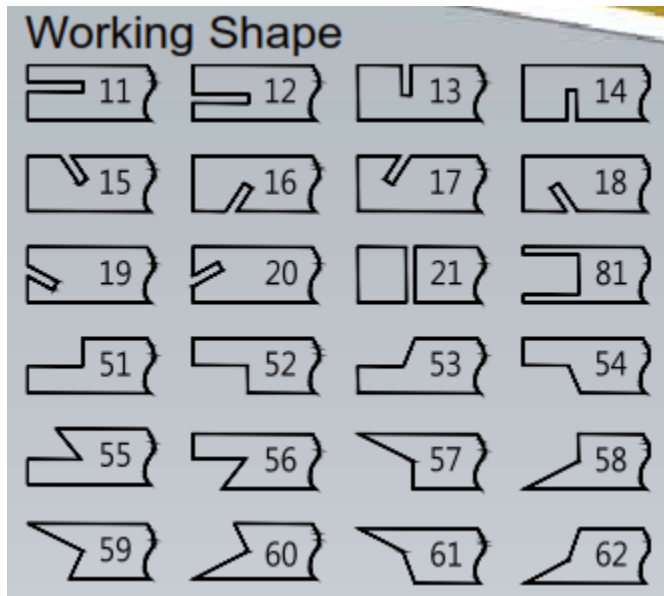
Machine Features:

Saw Head Positioning

The 4 axis saw head saw is driven by 4 servo motors. The X-axis, Y-axis, Z-axis, and A-axis are driven by 1KW servo motor. The saw head is capable of rotating 360 degrees (A-axis). X-Axis and Y-Axis have 400mm (15.75 in.) of travel. The Z-axis is able to move 600mm (23.62 in.). Maximum spindle center to table surface is 320mm (12.60 in.).

Cutting Capabilities

Below is a chart that shows cutting capabilities of PMI-CNC 4S 4th CNC sawing machine.





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HMI Touch Screen and machine programming:

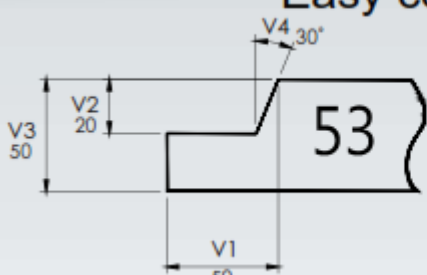
The touch screen is easy to use and operator friendly. The screen is 5.7" and easy to read.

PMI-CNC 4S Axis Saw is simple to program and easy to operate. The machine can store cut types by drawing number so the operator simply calls up the cut type by entering the drawing number, inputs material length and the saw is ready to run.

Sawing control way

Sawing list	drawing number	working condition
1	1234	
2	1234	
3	1234	
4	1234	
5	1234	
6	1234	
7	1234	
8	1234	
9	1234	
10	1234	

Easy conversion input



item	value(mm)
Drawing Number	53
Cutting Length(V1)	50
Cutting Depth (V2)	20
Material Width (V3)	50
Title Angle (V4)	30

5 HP Saw Motor:

The strong drive system via a 5 HP saw motor allows for maximum cutting force and chip removal. This additional power extends the life of the saw blade between regrinds. The saw blade speed is 3000 RPM.

Safety Cover:

The sawing area is enclosed with a safety cover to ensure safe operation.

Material Clamping:

Pneumatic clamping system has adjustable clamping pressure to prevent distortion of thin wall profiles. The saw comes standard with 4 horizontal clamps. The clamping system has adjustment according to the size of the work piece and ensures the part does not move during sawing operation.

Saw Table

The saw table is equipped with 4 horizontal clamps. The table is 800mm x 600mm (31.50 in. x 23.62 in.). The working height is 800mm (31.50 in.).

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**Saw Blade Feed:**

The saw blade is feed via a servo motor with ballscrew system. This allows for accurate cuts and long blade life. In addition, saw blade travel is controlled for fastest cycle time.

Precise Micro-Drip Blade Lubrication System:

The blade is lubricated via a micro-drip system. A small amount of lubricant is introduced to an air line at the point of discharge for control and economical distribution of saw lubricant.

Safety Features:**Safety Machine Enclosure:**

The saw safety cover is monitored by a limit switch. The cover must be closed for the saw to cycle.

Safety Limit Switch:

The blade access door is protected via a limit switch that will shut down the machine in case of an open door.

Technical Data:

X-Axis	400mm (15.75 in.)
Y-Axis	400mm (15.75 in.)
Z-Axis	600mm (23.62 in.)
A-Axis	360 degrees
Spindle Center to Table Surface	Max. 320mm (12.60 in.)
Cutting Depth	180 x 180mm (7 x 7 in.)
Clamps	4 Horizontal Clamps
Table Size	800 x 600mm (31.50 x 23.62 in.)
Table Work Height	800mm (31.50 in.)
Saw Motor	5 HP
Saw Blade Speed	3000 RPM
Saw Blade Size	500mm x 1" bore
X-Axis Servo Motor	1.3 KW
Y-Axis Servo Motor	1.3 KW
Z-Axis Servo Motor	2.9 KW
A-Axis	1.3 KW
Machine Weight	4,400 LBS
Dimensions	87 in. x 113 in. x 105 in.