

# Cutting Incorrect Profile Angle

What to do if the saw is not cutting the correct "hand" of saw cuts

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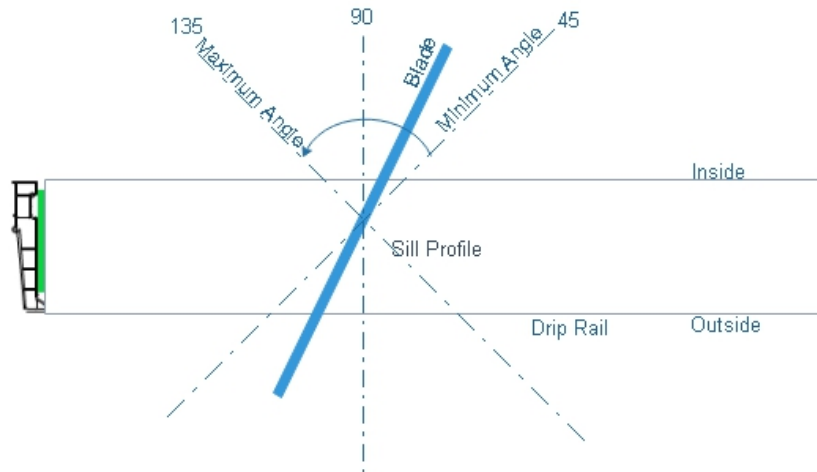
## Problem

The saw cut angles are opposite angles to expected, or square when they should be mitred, or vice versa. Particularly an issue on sill saws where the 45 / 135 angles should generally be the opposite to a standard frame or sash. See Saw Variable Angle Cutting Specification for details of standard sill cuts

The problem arises because the software link company fails to send the correct combination of character codes "\", "/" alongside the angles. This is critically important. By default, the software uses the prep characters (., /, ], \, <, etc) to define the angle. This was simple when the saw only cut 45 / 90 / 135 degrees. However, this has become much more complex with the introduction of variable angles.

### Saw Angle Diagram

Note: This diagram is the same no matter the feed direction of the saw



It is common to get incorrect data in the angle fields such as:

### Angles completely incorrect or not specified

P,08130,V,01,05, v6139/005 2 Sash SU:Bottom ,0001,0001,000000000002

P,18100,V,01,03, v6140/002 2 Sash DM:Top ,0000,0000,000000000005

Angle is the wrong hand or sense to the prep character ( "/" should be 0450,1350)

P,32980,\,00,02,757700/S2 Unit 1 Acr 2 ,1350,0450,000000000002

# Solution

There is a parameter in the profile setup which forces the software to use the defined angle rather than the prep characters.

The screenshot shows the 'Machine Settings' window with the 'Profile' tab selected. The interface includes a list of profiles on the left, a central diagram of a profile with a saw cut, and various configuration panels on the right. The 'Angle Not Character' checkbox in the 'Other' section is highlighted with a red box.

Profile ID	Profile Name
ALLPRFS	Common Tooling Co ^
2097	85mm Sill
2098	150mm Sill
2099	180mm Sill
0204	15mm Frame Extens
0210	25mm Frame Extens

**General Profile Settings**

- Std Length: 6500
- Opt Tolerance: 50
- Width Tolerance +/-: 1.0
- Rebate Offset: 22.0
- Invert Colour:

**Special Cut Speed**

- Top: 25
- Bottom: 25
- Reinforcing: 25
- EuroGroove: 25

**Other**

- Reverse Measure on Reverse Loaded:
- Skip trim on Trim Cut:
- Skip End Stop:
- Max Cut Speed:
- Square Trim Cut:
- VS Tilt:
- Half Triangl:
- Chunk Default: 90
- Throwaway DfIt: 700
- Trim Default:
- SmlGrip Default:
- Angle Not Character:

**Sawing Parameters**

- ClampPos:
- Eject Home B4 Push:
- Skip Load Clear:
- Profile Block: Green
- Pusher Block: Green
- Flip: N
- Z Turret: 1

**i** ...This parameter was a global parameter introduced in version 6.4.65.0 (feb 21). However, this created problems where the link file had different issues with different profiles, so was changed to a profile specific parameter in version 6.4.98.2 (Apr 22)