



AMCOL Corporation

6000 Precision Applicators for Saws

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100
Years
1902-2002

General Description

The AMCOL 6000 Series Precision Applicator is an extremely accurate, positive displacement injection metering type, minimum quantity lubrication system for near dry machining of metals and alloys.

AMCOL now offers two 6000 Series Precision Applicators **designed just for sawing**; one for cold circular sawing and the other for vertical or horizontal band sawing.

The System Controls and Actuation for both systems are exactly the same.



- Two Injection Meters with Patented Positive Suction Design
- Pulse Frequency Generator in a 14 ga. Steel Enclosure
- Spray Pressure Regulated with Gauge Control at the Spray Box
- ½ Gallon Reservoir with 120 Mesh Strainer and Liquid Shut-off
- Biaxial Liquid and Air Dispensing from Controls to Spray Point
- 110V Electric/Air Solenoid for System Actuation During Cut Only
- Filtered and Regulated Air Inlet at ¼" NPT
- Push-to-connect Fittings on Hoses for Ease of Installation, Maintenance, and Repair

Liquid Dispensing at the Saw

Two highly specialized spray heads with mounting are available. One specific to a circular saw and the other for band sawing. Both convert the liquid and air mix to two spray points at the point of dispensing. Both also offer fixed position spray tips at specified angles with a repeatable mounting system so as to insure a top quality cut, maximum blade life, without mist or overspray.

Circular Saws – A B21 Manifold is mounted using the Compact Multifunctional Mount.



Spray tips are designed to allow for a high-pressure spray without misting or atomization of the fluid, with angles that lubricate the cutting edge, gullet and side of the blade.

Band Saws – Two transition blocks are connected to allow for a 90 degree spray head to be mounted from

the top of the blade and still achieve a direct hit on the gullet of the blade without changing of nozzle placement when changing a blade.





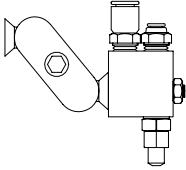
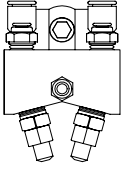
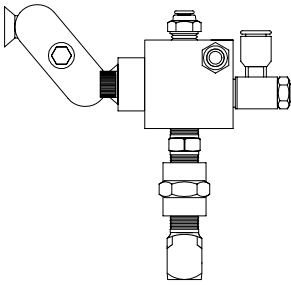
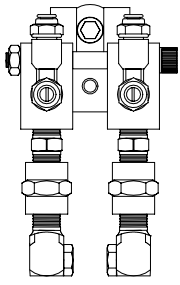
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Purchase Part Numbers

<i>Circular Saws</i>			<i>Band Saws</i>		
<i>Description</i>	<i>Qty.</i>	<i>Part Number</i>	<i>Description</i>	<i>Qty.</i>	<i>Part Number</i>
Precision Spray Applicator	1 ea.	6244-2B-10U-0-0-0-0-S	Precision Spray Applicator	1 ea.	6244-2B-10U-0-0-0-0-S
B21 Manifold with Air Propelled Wet Tips and Mounting	1 ea.	6000-B-B21-B1-C-22WT1-0	Band Saw Spray Nozzle Assembly-Extended	1 ea.	6000-B-BSSNA-EXT
 Side View		 Top View	 Side View		 Top View

System Installation

1. Warning: Always wear eye safety protection when working with or adjusting this equipment.
2. Warning: Deenergize saw and all related machinery or attachments prior to getting started.
3. Warning: Do not adjust or modify nozzle placement without saw deenergized.
4. Warning: Do not repair or modify pressurized hoses without first deenergizing air source to spray system.
5. Warning: Do not connect plant air source until system components are properly mounted to the machine and all hoses attached accordingly.
6. Mount Control Box where it can be accessed without intervening with machine function or guarding.
7. Mount Spray Assembly according to photos as shown on Page 1.
8. Connect Biaxial hose to T60 Injector Assembly and the Spray Assembly.
9. Connect system air supply; be sure a lock out type valve is available for proper system deenergizing prior to system maintenance or repair.
10. System may now be manually operated by actuating the three-way solenoid valve.
11. Attach and fill the liquid reservoir with fluid and open shut-off on bottom of reservoir.
12. Manually adjust system to provide acceptable spray. Starting point recommendation of 0.75 Setting on the Pulse Frequency Generator, Injector Setting at 1.5 Turns from Off, and the Spray Pressure Setting at 20 psi.
13. Manually operate system until the fluid reaches the spray point and the spray volume, pattern and location is acceptable.
14. Connect the electrical control to actuate only during cut.
15. Replace all machine guards and you are ready to operate.