

Allstate Fabrication



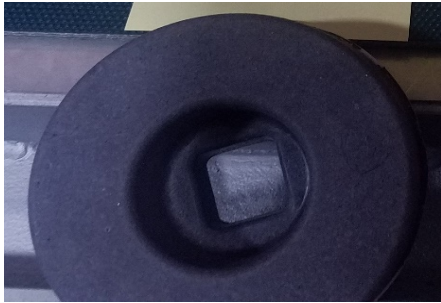
REVOLUTION

Edge Reference Guide

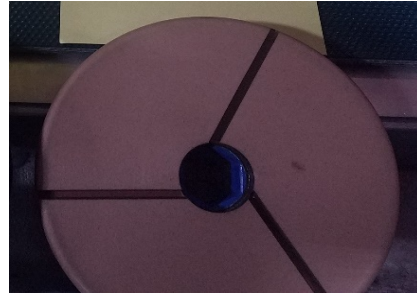


rev: 6/30/2017

Chamfer & Bevel Bricks



Cement



Copper

Flat Polish Bricks

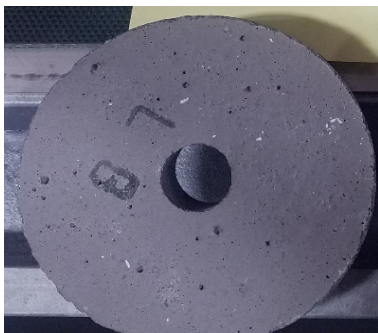


Resin

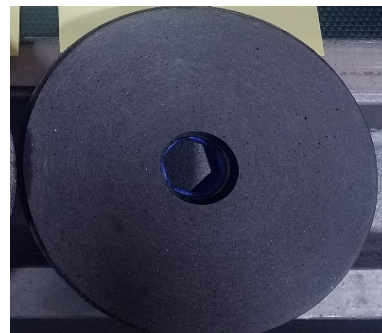


Cement

Bullnose Bricks



Cement



Resin



Selected Processing

00:49.49
16-02-17

Ca Bullnose 32 Half Bullnose -6 Waterfall



Flat Edge

Intermediate

Double Joint

Parameters

Data Machine

Production

Manuals

H Thickness of Material

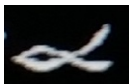


+ Upper Swing of Alpha Axis

R Center of Radius Axis (Half of thickness)



- Lower Swing of Alpha Axis



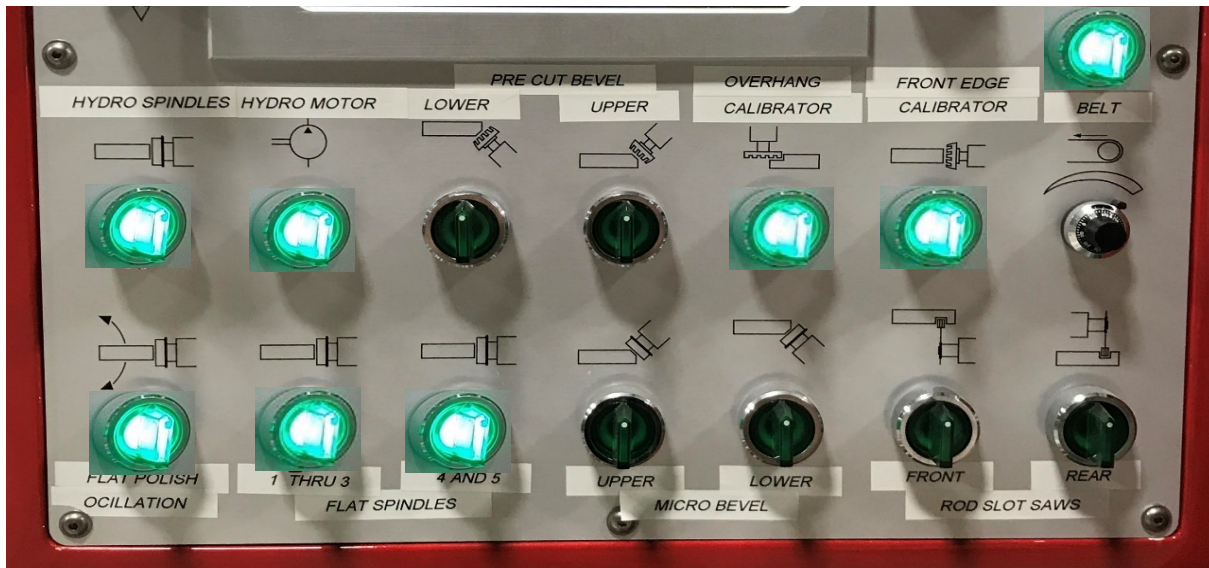
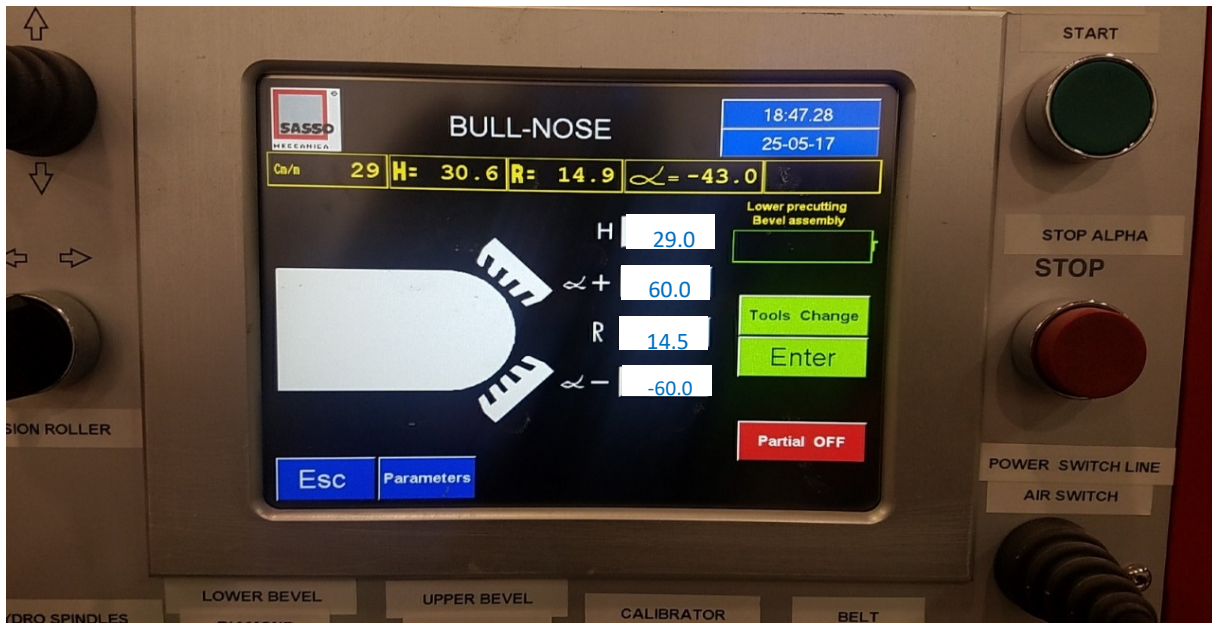
P Pause Position

P Length of Pause

B Oscillation Degree

Sasso Edge Name
BULL-NOSE

Allstate Fab Edge Name
Eased Edge



Sasso Edge Name FLAT EDGE	Allstate Fabrication Edge Name Eased Edge
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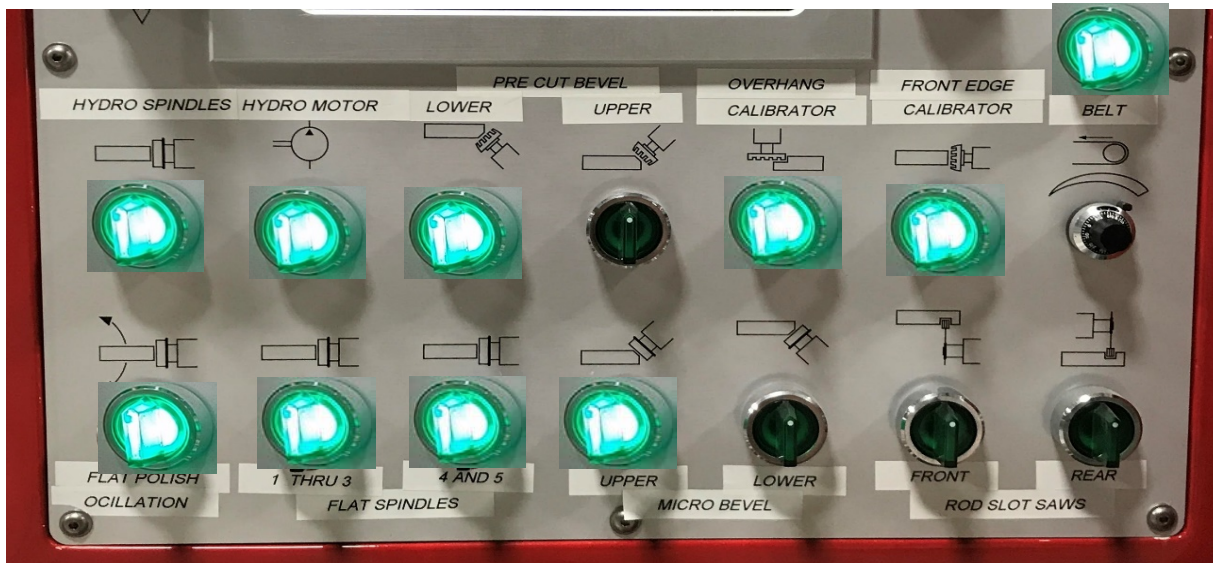
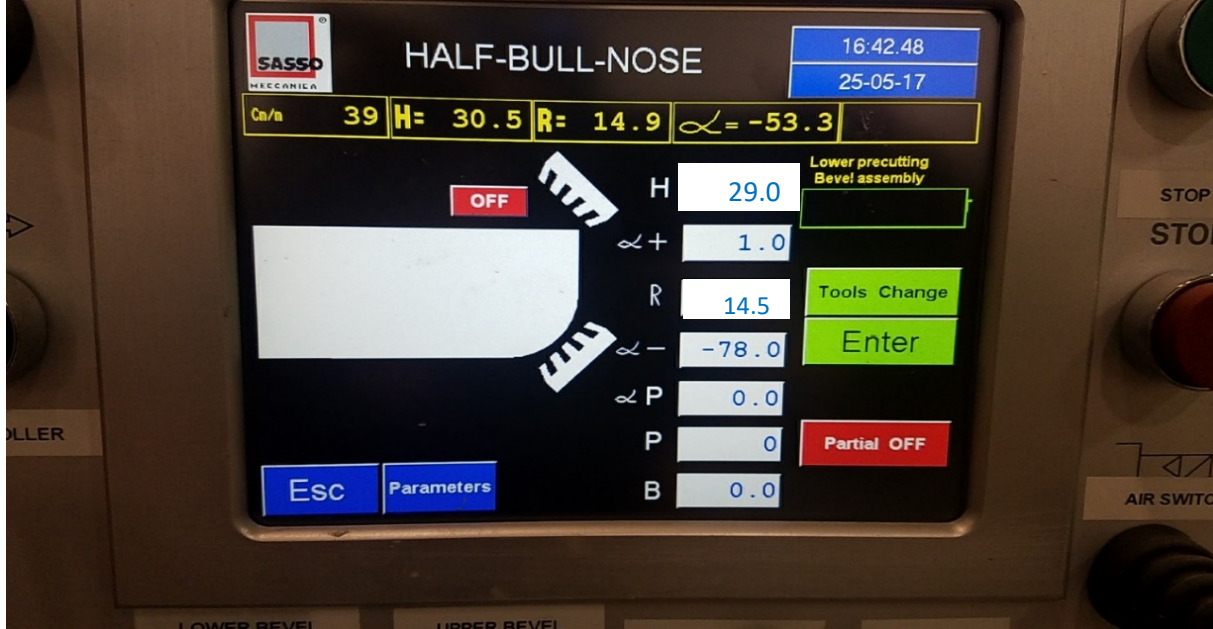
Belt Speed: 30

PRE-CUT			
		REGULATOR PSI	POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel			OFF
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	POSITION
#1	DIAMOND		OFF
#2		PSI	OFF
#3		PSI	OFF
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel			OFF
Lower Micro Bevel			OFF

Sasso Edge Name
HALF BULLNOSE

Allstate Fab Edge Name
Half Bullnose

#1 Spindle Diamond must be set 2mm behind white rollers in Alpha Axis after awaiting Start. Use Green Button by rear door to engage diamond forward. Be sure Air Switch at #1 Spindle is in ON position.



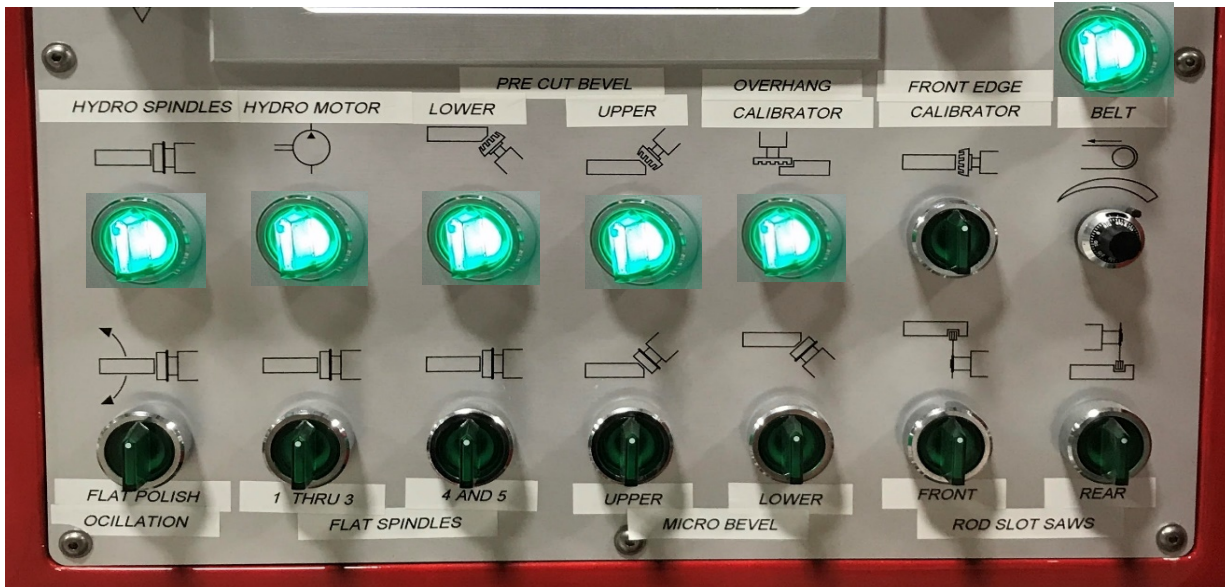
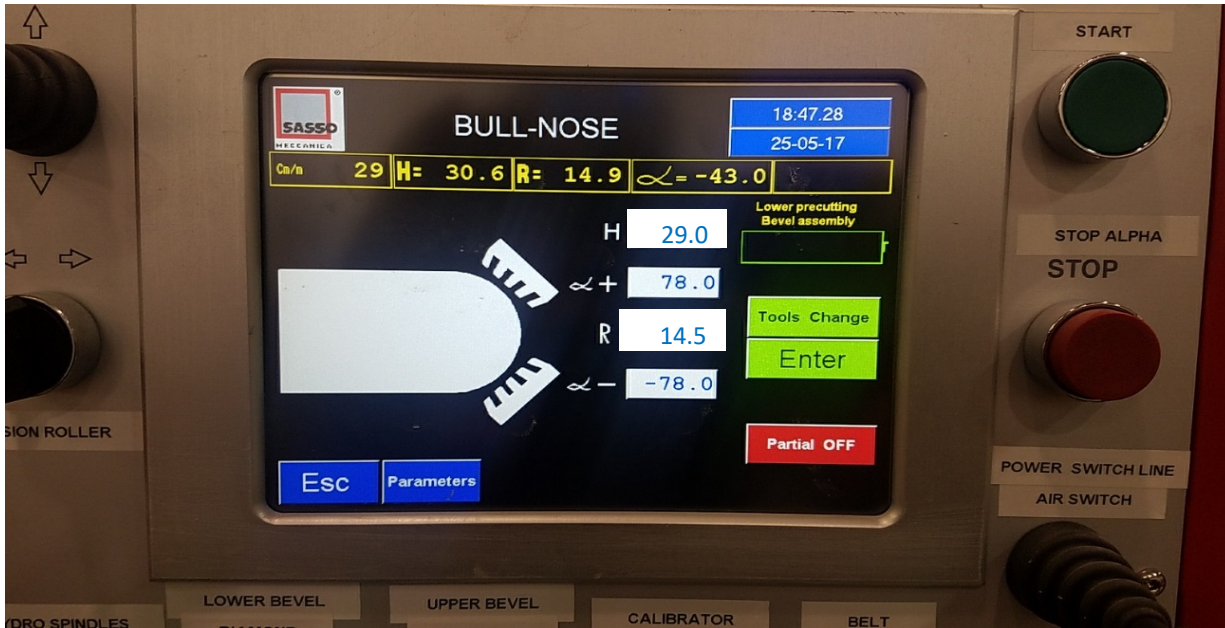
Sasso Edge Name HALF-BULL-NOSE	Allstate Fabrication Edge Name Half Bullnose
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Belt Speed: 35

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond	70 PSI	ON
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		40 PSI	AUTO
#2		40 PSI	AUTO
#3		40 PSI	AUTO
#4		40 PSI	AUTO
#5		40 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	ON
Lower Micro Bevel			OFF

Sasso Edge Name
BULL-NOSE

Allstate Fab Edge Name
Full Bullnose



Sasso Edge Name BULL-NOSE	Allstate Fabrication Edge Name Full Bullnose
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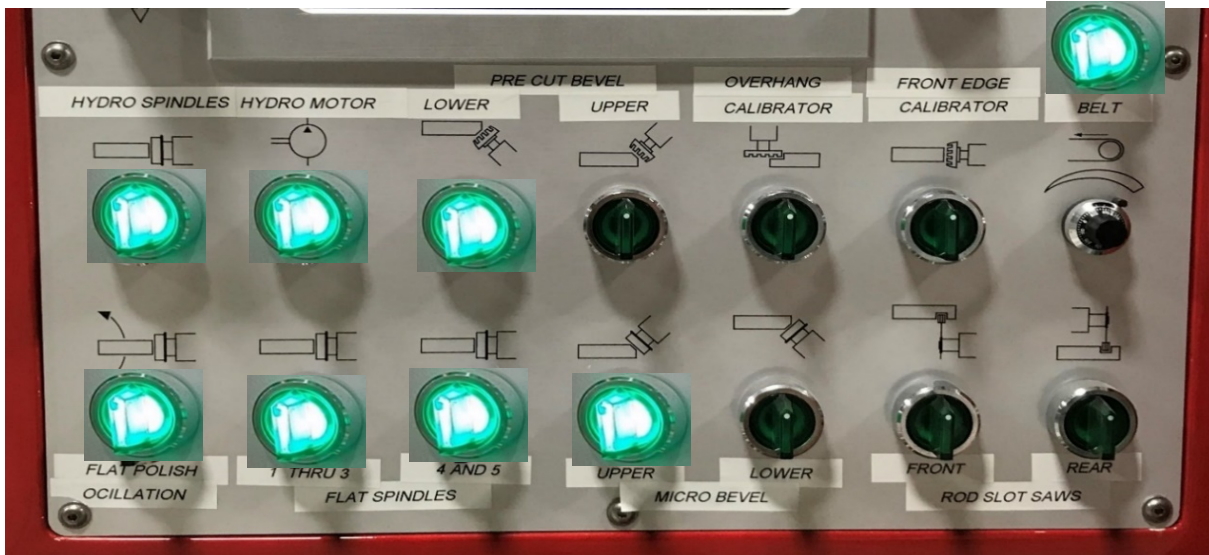
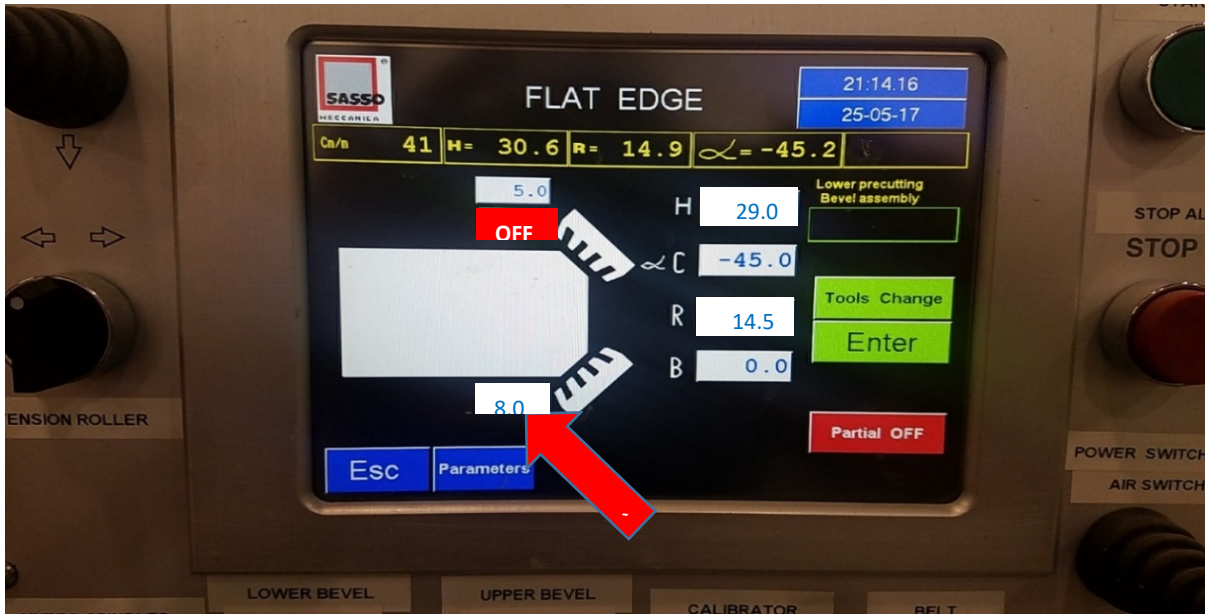
Belt Speed: 28

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel		70	ON
Lower Pre-Diamond Bevel		70	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond	70 PSI	ON
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1			OFF
#2			OFF
#3			OFF
#4			OFF
#5			OFF
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel			OFF
Lower Micro Bevel			OFF

Sasso Edge Name
FLAT EDGE

Allstate Fab Edge Name
1/4 Bevel

Change Lower Diamond Bevel size to determine bevel size. See red arrow below. 8mm bevel = 1/4 Bevel



Sasso Edge Name FLAT EDGE	Allstate Fabrication Edge Name 1/4 Bevel
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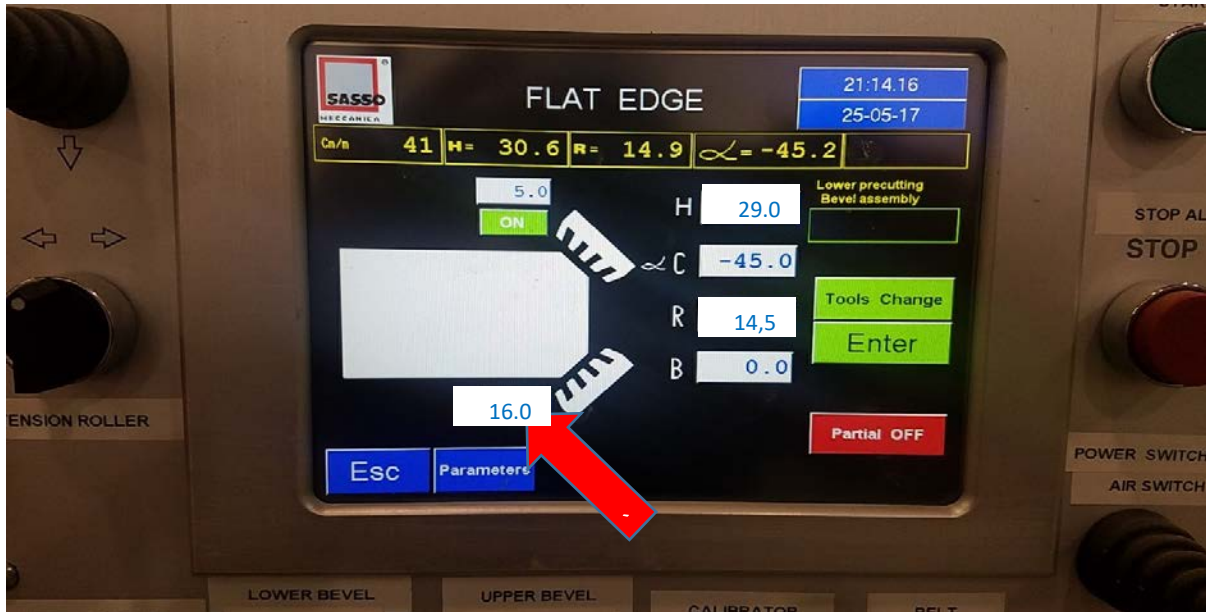
Belt Speed: 40

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond		OFF
#2			OFF
#3			OFF
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	AUTO
Lower Micro Bevel			OFF

Sasso Edge Name
FLAT EDGE

Allstate Fab Edge Name
1/2 Bevel

Change Lower Diamond Bevel size to determine bevel size. See red arrow below. 16mm = 1/2 Bevel



Sasso Edge Name FLAT EDGE	Allstate Fabrication Edge Name 1/2 Bevel
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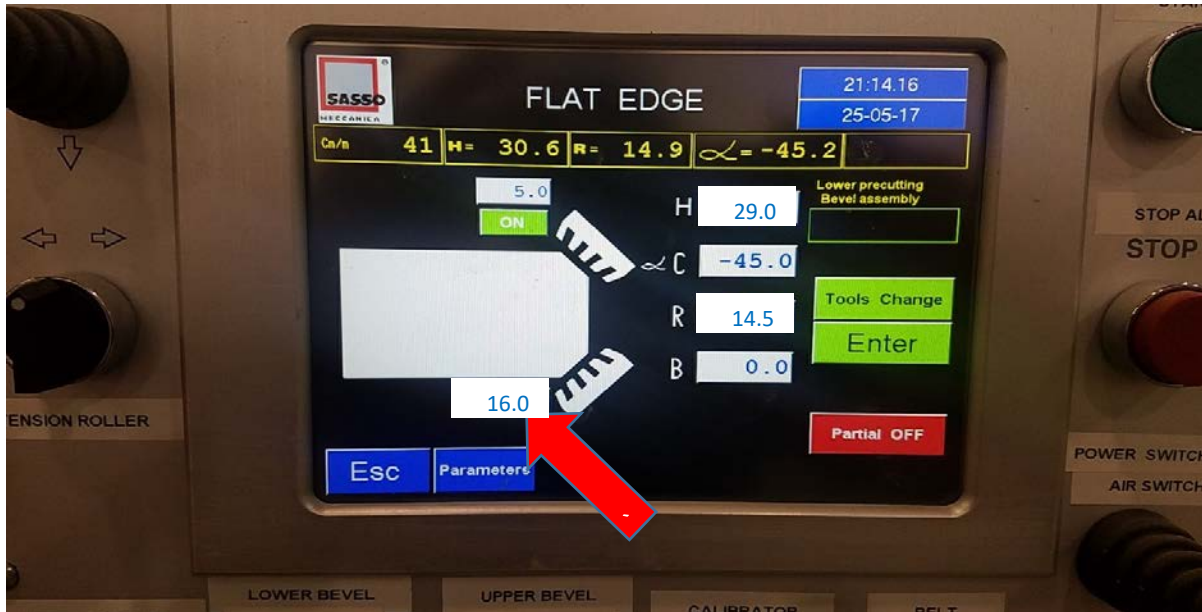
Belt Speed: 35

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond		OFF
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	AUTO
Lower Micro Bevel			OFF

Sasso Edge Name
FLAT EDGE

Allstate Fab Edge Name
1" Bevel

Change Lower Diamond Bevel size to determine bevel size. See red arrow below. 16mm = 1/2 Bevel



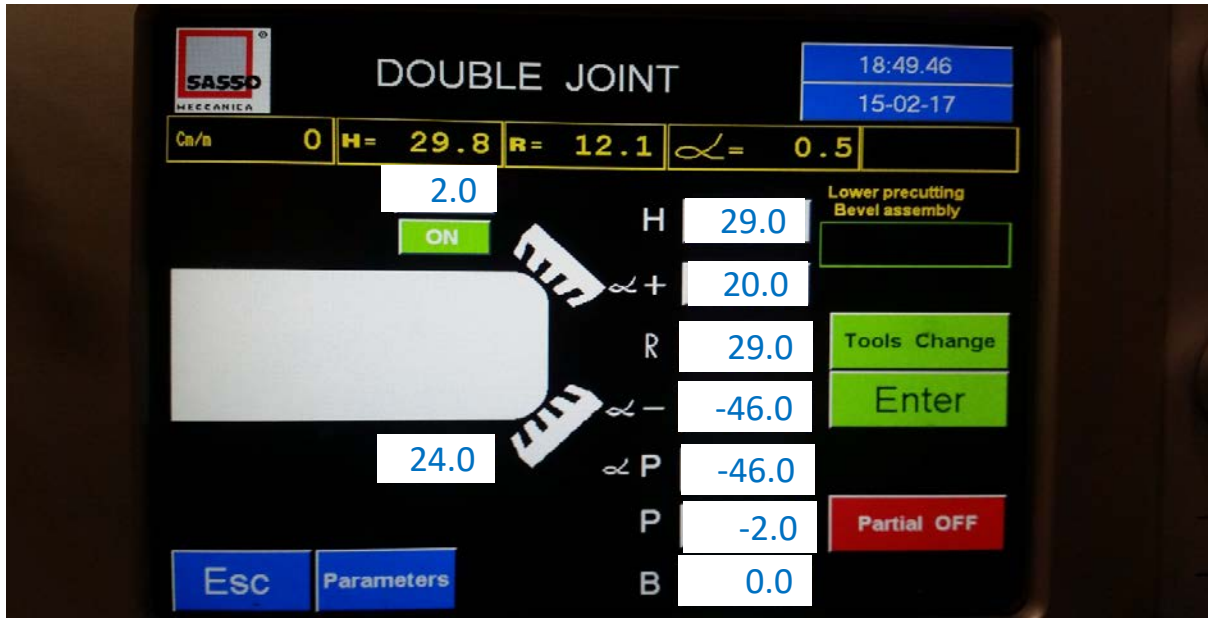
Sasso Edge Name FLAT EDGE	Allstate Fabrication Edge Name 1" Bevel
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Belt Speed: 35

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond		OFF
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	OFF
Lower Micro Bevel			OFF

Sasso Edge Name
DOUBLE JOINT

Allstate Fab Edge Name
Reverse Bevel



Sasso Edge Name DOUBLE JOINT	Allstate Fabrication Edge Name Reverse Bevel
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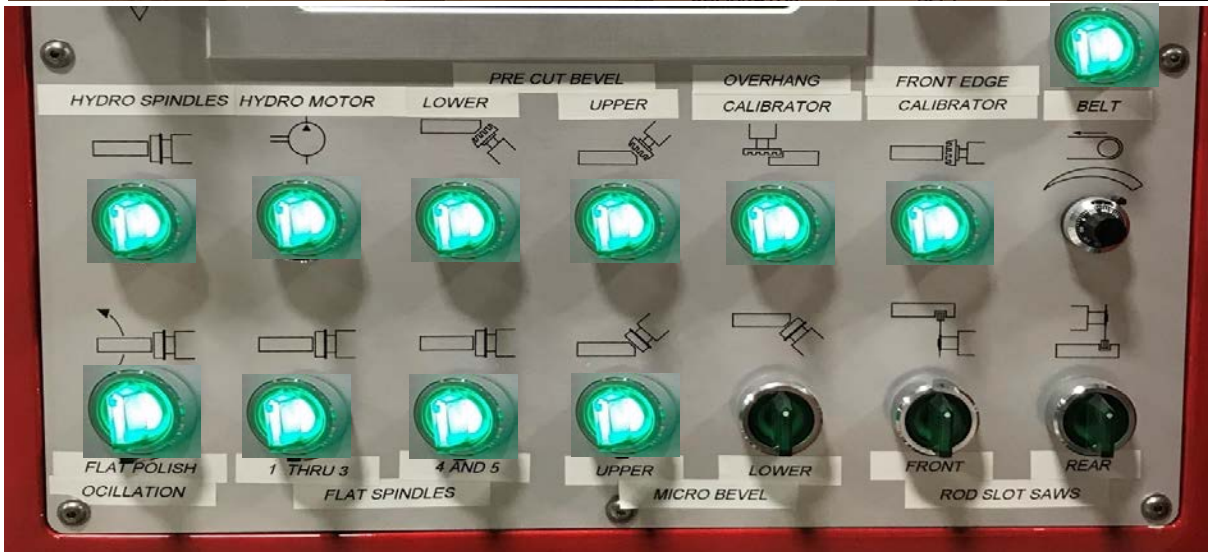
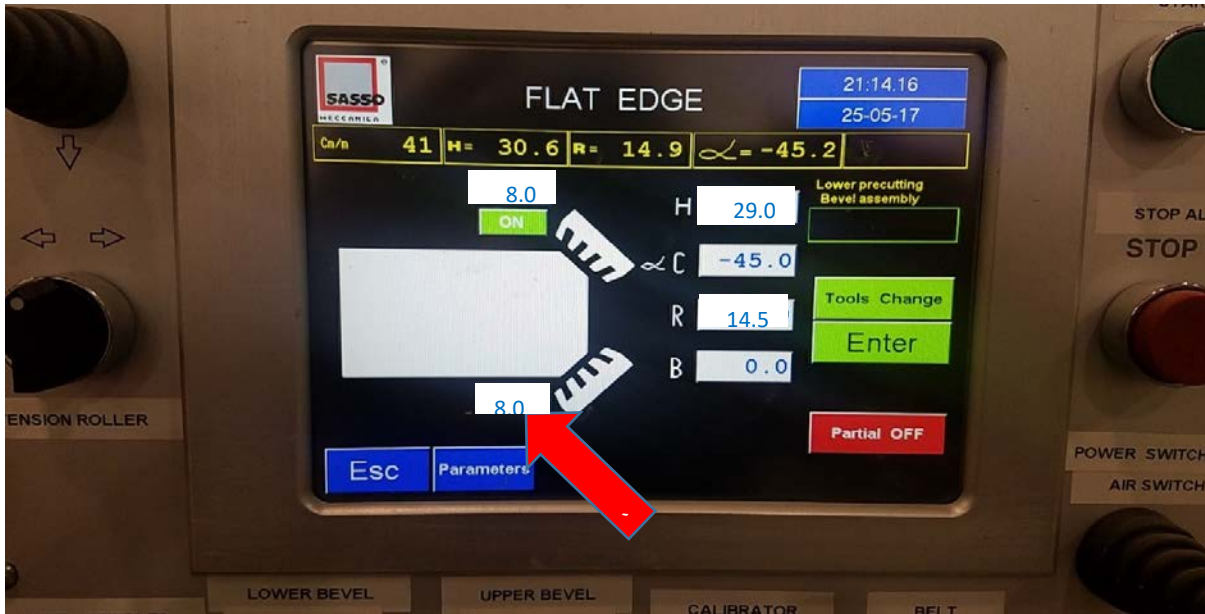
Belt Speed: 24

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel		70 PSI	ON
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond	70 PSI	ON
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel			OFF
Lower Micro Bevel		45 PSI	ON

Sasso Edge Name
FLAT EDGE

Allstate Fab Edge Name
Bevel Top & Bottom

Change Lower Diamond Bevel size to determine bevel size. See red arrow below. 8mm bevel = 1/4 Bevel



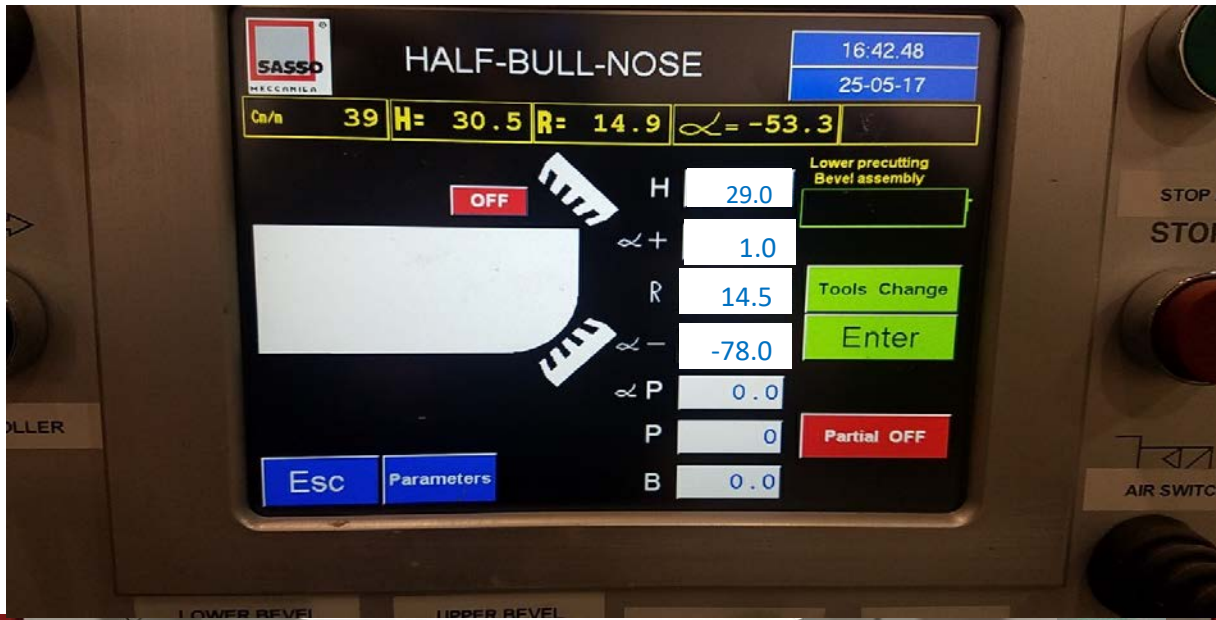
Sasso Edge Name FLAT EDGE	Allstate Fabrication Edge Name Bevel Top & Bottom
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Belt Speed: 40

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel		70 PSI	ON
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond		OFF
#2			OFF
#3			OFF
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	ON
Lower Micro Bevel			OFF

Sasso Edge Name
HALF-BULL-NOSE

Allstate Fab Edge Name
1/4 Round



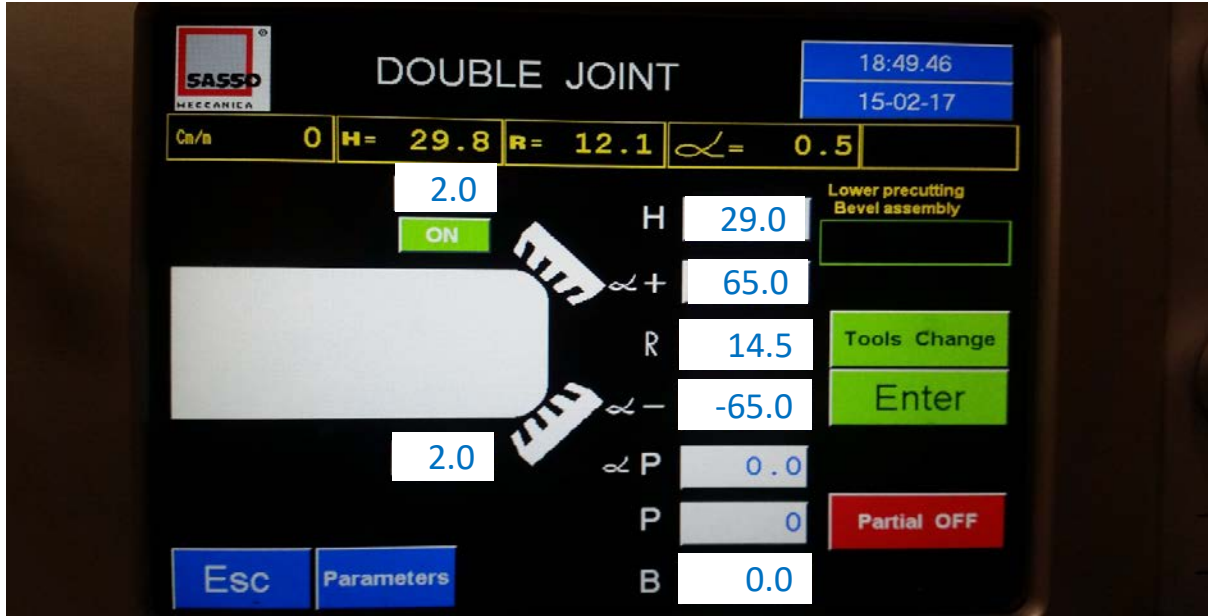
Sasso Edge Name HALF-BULL-NOSE	Allstate Fabrication Edge Name 1/4 Round
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Belt Speed:

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel			OFF
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		PSI	OFF
#2		35 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	AUTO
Lower Micro Bevel			OFF

Sasso Edge Name
DOUBLE JOINT

Allstate Fab Edge Name
1/4 Round Top & Bottom



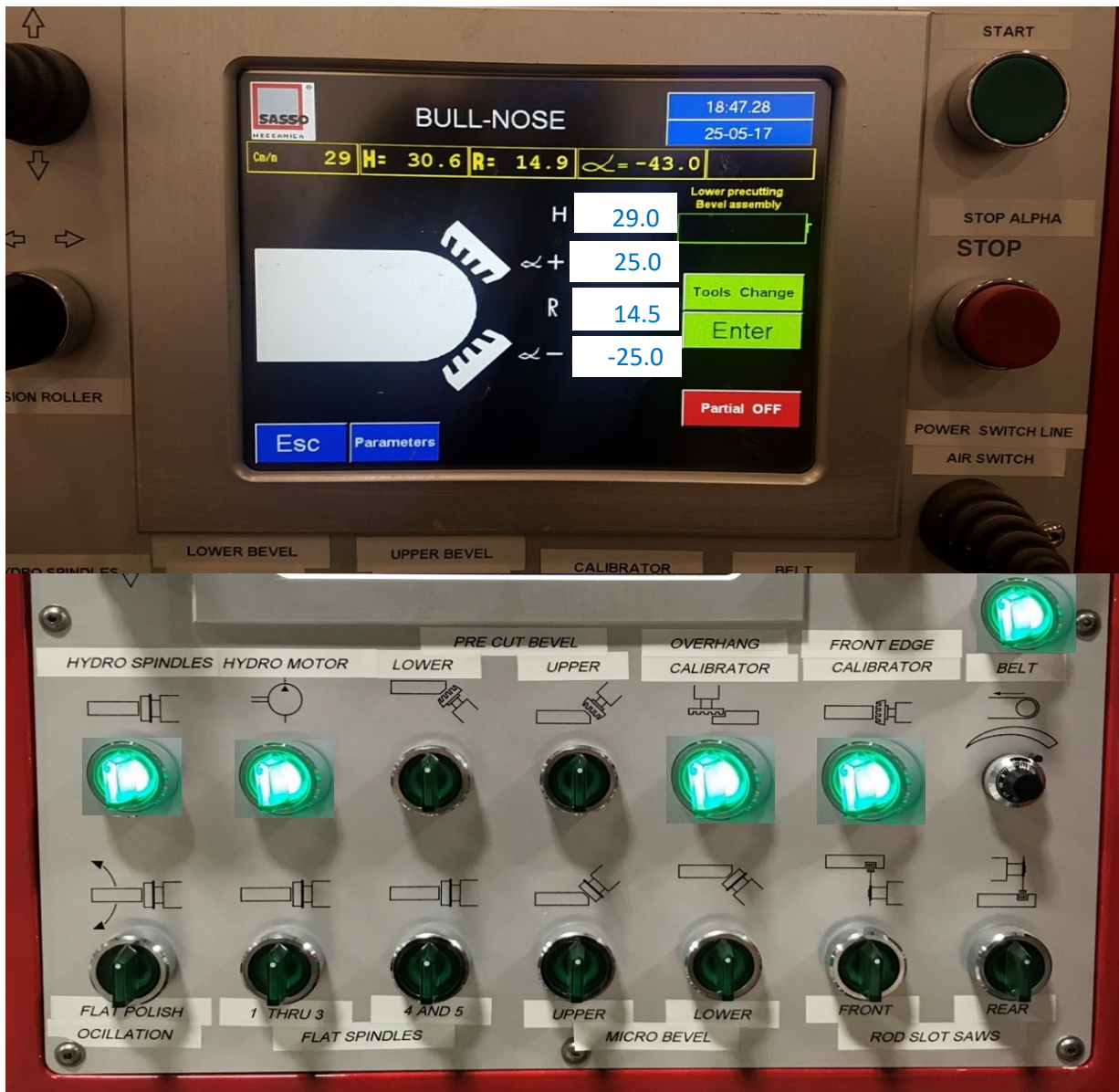
Sasso Edge Name DOUBLE JOINT	Allstate Fabrication Edge Name 1/4 Round Top & Bottom
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Belt Speed:

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel		70 PSI	ON
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		PSI	OFF
#2		35 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1		45 PSI	AUTO
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
 			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel			OFF
Lower Micro Bevel			OFF

Sasso Edge Name
BULL -NOSE

Allstate Fab Edge Name
Thumbnail



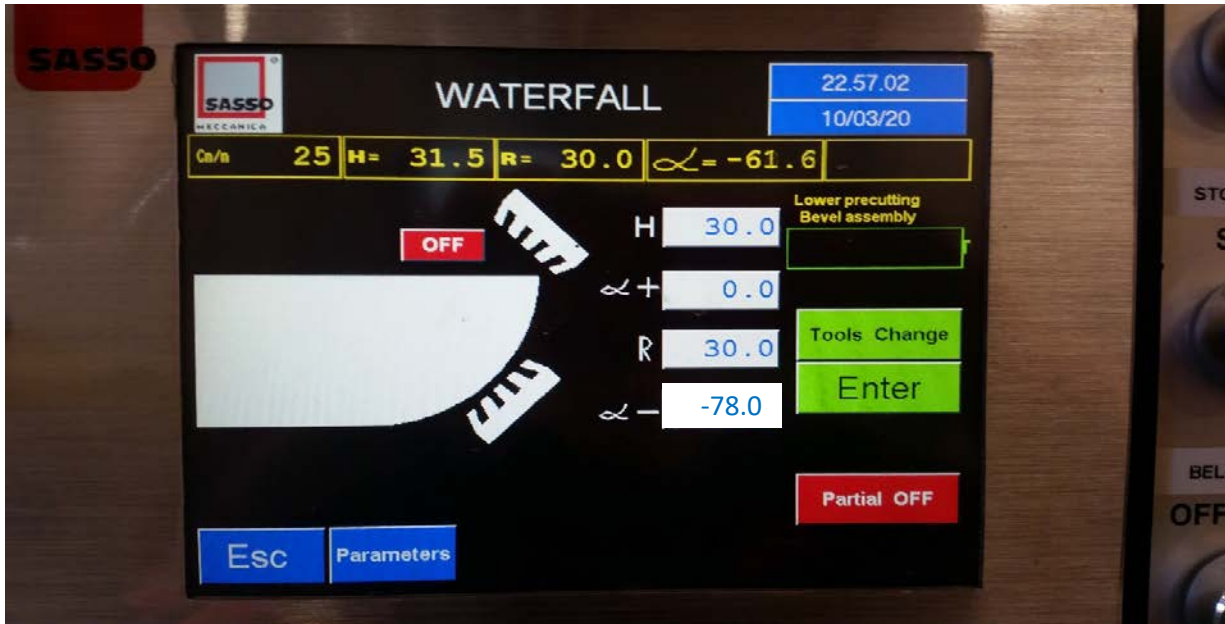
Sasso Edge Name BULL-NOSE	Allstate Fabrication Edge Name Thumbnail
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Belt Speed: 30

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel			OFF
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond	70 PSI	ON
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1			OFF
#2			OFF
#3			OFF
#4			OFF
#5			OFF
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel			OFF
Lower Micro Bevel			OFF

Sasso Edge Name
WATERFALL

Allstate Fab Edge Name
Demi-Bullnose



Sasso Edge Name WATERFALL	Allstate Fabrication Edge Name DEMI-BULLNOSE
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Belt Speed: 25

PRE-CUT			
		REGULATOR PSI	SWITCH POSITION
Upper Pre-Diamond Bevel			OFF
Lower Pre-Diamond Bevel		70 PSI	ON
ALPHA AXIS - RADIUS POLISH AREA			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1	Diamond	70 PSI	ON
#2		45 PSI	AUTO
#3		45 PSI	AUTO
#4		45 PSI	AUTO
#5		45 PSI	AUTO
#6		45 PSI	AUTO
FLAT POLISH WITH OSCILLATION			
SPINDLE #	GRIT OR #	REGULATOR PSI	SWITCH POSITION
#1			OFF
#2			OFF
#3			OFF
#4			OFF
#5			OFF
MICRO-BEVEL			
		REGULATOR PSI	SWITCH POSITION
Upper Micro Bevel		45 PSI	AUTO
Lower Micro Bevel			OFF

Questions?

Call Joe Connolly

224-200-8004

email: jconnollysassocusa@gmail.com