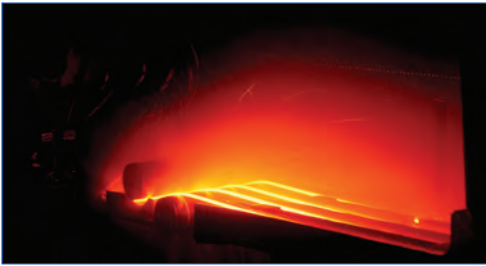


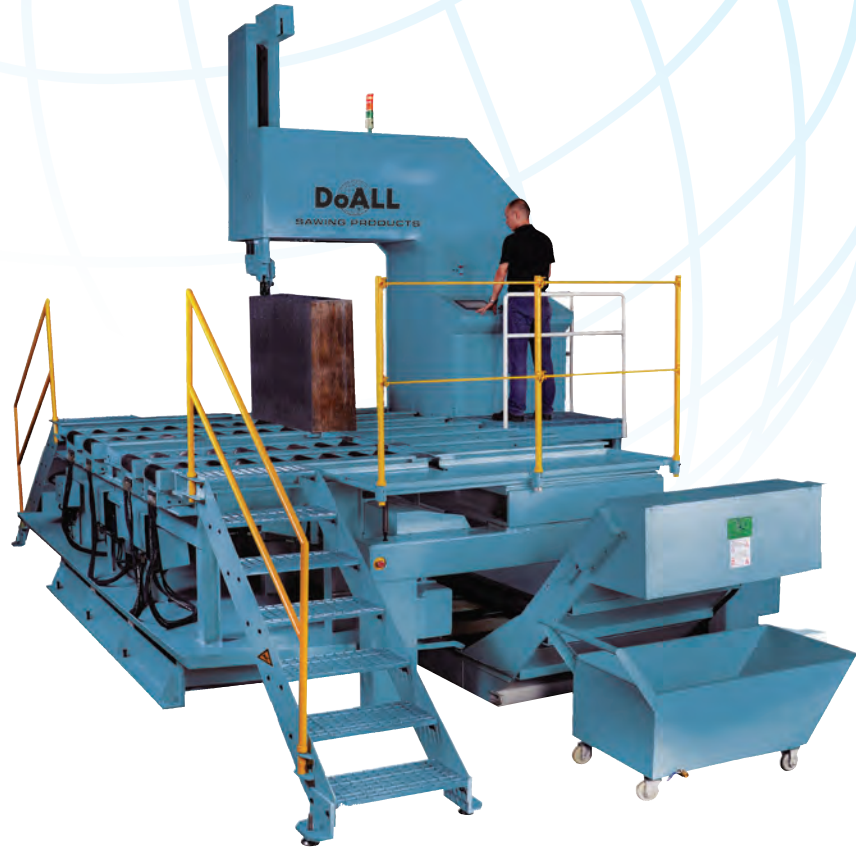


SAWING PRODUCTS

# Forging Saws



DoALL DC-1600CNC Hercules™



DoALL 4863-VPL Vertical Plate Saw

At DoALL we know that forged metal pieces are stronger than an equivalent casting or machined part. That is why we are introducing a full line of band saws ideal for anyone in the forging industry looking to efficiently cut and supply raw material. DoALL saws will keep your forging operations running at maximum production capacities and saws support the finest forged material with the tightest tolerances.

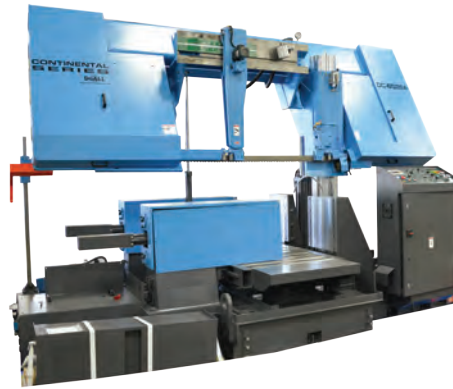
DoALL saws cut billet and stock material such as alloy steel, carbon steel, stainless steel, specialty steel, titanium, aluminum, tool steel, nickel alloys, high-temp alloys, corrosion resistant alloys, cobalt alloys and copper alloys. DoALL can support forging manufacturing facilities that process from 500 pounds (230kg) to 40,000 pounds (18,143kg) of round or hollow forging material.



Solutions for ALL Your Sawing Needs



DoALL DC-800NC Continental Series™



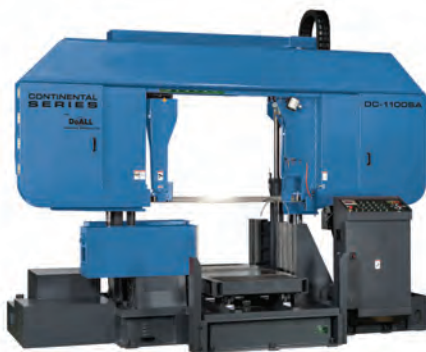
DoALL DC-800SA Continental Series™



DoALL DC-1400CNC Hercules™

## Dual Column Saws

DoALL Model Number	DC-800NC	DC-800SA	DC-1100SA	DC-1700SA	DC-1000CNC	DC-1400CNC
DoALL Product Line	Continental Series™	Continental Series™	Continental Series™	Continental Series™	Hercules™	Hercules™
General Description	Automatic	Semi-Automatic	Semi-Automatic	Semi-Automatic	Automatic	Automatic
Additional DoALL Group(s)	Dual Column	Dual Column	Dual Column	Dual Column	Dual Column	Dual Column
Warranty	Parts/Service	Parts/Service	Parts/Service	Parts/Service	Parts/Service	Parts/Service
Warranty Length	1 year standard	1 year standard	1 year standard	1 year standard	1 year standard	1 year standard
Capacity Rectangle at 90° HxW	31-1/2 x 39-1/2" (800x1000mm)	31-1/2 x 39-1/2" (800x1000mm)	43-1/2 x 43-1/2" (1100x1100mm)	51-1/4 x 67" (1300x1700mm)	33-1/2 x 40" (850x1000mm)	47-1/4 x 55" (1200x1400mm)
Capacity Round at 90°	31-1/2" (800mm)	31-1/2" (800mm)	43-1/2" (1100mm)	51-1/4" (1300mm)	33.5" (850mm)	47-1/4" (1200mm)
Blade Drive Motor	15 hp (11.1kW)	15 hp (11.2 kw)	15 hp (11.2 kw)	20 hp (15 kw)	15 hp (11.1kW)	15 hp (11.1kW)
Blade Speeds	52-275 fpm (16-85mpm)	85-279 FPM (16-85 m/min)	49-262 FPM (15-80 m/min)	39-246 FPM (12-75 m/min)	50-262 fpm (15-80mpm)	50-262 fpm (15-80mpm)
Maximum Blade Diameter	347" (8800mm)	347" (8800mm)	394" (10000mm)	512" (13000mm)	374" (9490mm)	458" (11650mm)
Blade Widths & Gage	2-5/8 x 0.063" (67x1.6mm)	2-5/8 x 0.063" (67x1.6 mm)	2-5/8 x 0.063" (67x1.6 mm)	3-3/20 x 0.063" (80x1.6 mm)	2-5/8 x 0.063" (67x1.6 mm)	3-3/20 x 0.063" (80x1.6 mm)
HMI Controller	Yes	Yes	Yes	Yes	Yes	Yes
Work Table Height	36.2" (920mm)	28.3" (720 mm)	26.8" (680 mm)	26.8" (680 mm)	24.4" (620mm)	31-1/2" (800mm)
Floor Space Required	171 x 94 x 108" (4350x2390x2750mm)	171 x 85 x 104" (4350x2160x2650mm)	95 x 181 x 128" (2400x4600x3250mm)	110 x 244 x 150" (2800x6200x3800mm)	246 x 161 x 128" (6230x4080x3250mm)	205 x 93 x 158" (5200x2350x4000mm)
Approximate Weight	25350 lbs (11500kg)	24251 lbs (11000 kg)	30865 lbs (14000 kg)	46297 lbs (21000 kg)	30204 lbs (13700kg)	55116 lbs (25000kg)
Hydraulic Pump	3 hp (2.23kW)	3 hp (2.23kW)	3 hp (2.23kW)	5 hp (3.7kW)	5.4 hp (4kW)	5.4 hp (4kW)
Hydraulic Tank Capacity	34 gal (130 L)	22.5 gal (85 L)	23.8 gal (90 L)	43.6 gal (165 L)	Info coming soon	Info coming soon
Coolant Pump	1/4 hp (0.2kW)	1/4 hp (0.2kW)	1/4 hp (0.2kW)	1/4 hp (0.2kW)	0.2 hp (0.155kW)	0.2 hp (0.155kW)
Coolant Tank Capacity	63 gal (240 lit)	58 gal (220 lit)	53 gal (200 lit)	74 gal (280 lit)	56.8 gal (215 lit)	61.8 gal (234 lit)
Bi-Directional Blade	No	No	No	No	No	No



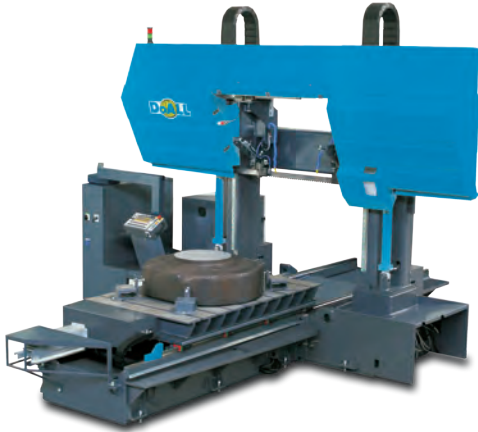
DoALL DC-1100SA Continental Series™



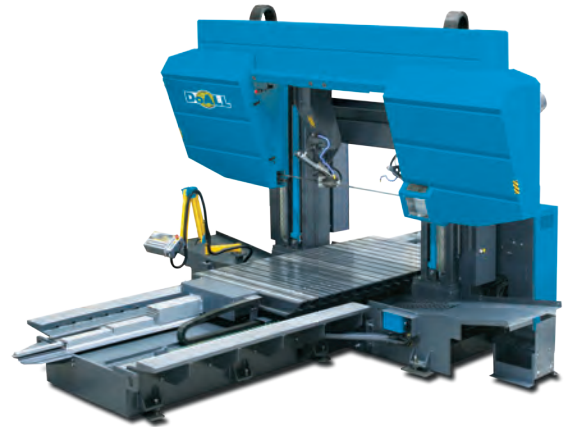
DoALL DC-1700SA Continental Series™



DoALL DC-1000CNC Hercules™



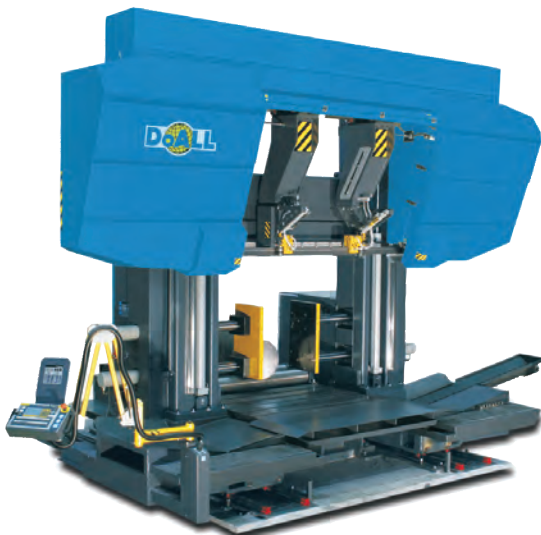
DoALL DC-850CNC Hercules™



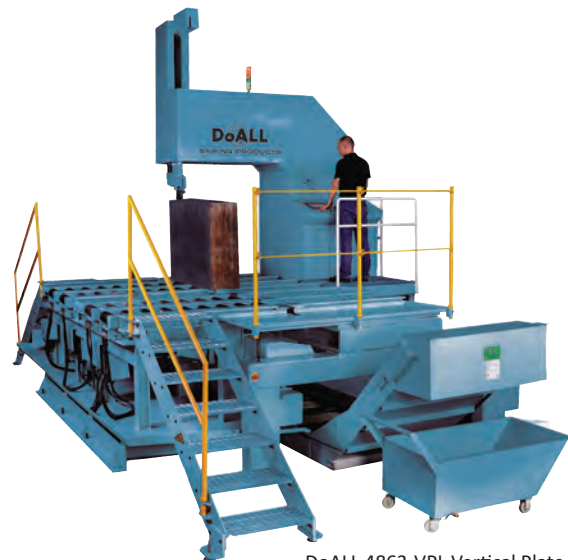
DoALL DC-1200CNC Hercules™

## Automatic CNC and Vertical Plate Saws

DoALL Model Number	DC-850CNC	DC-1200CNC	DC-1600CNC	4824-VPL	4848-VPL	4863-VPL
DoALL Product Line	Hercules™ with table	Hercules™ with table	Hercules™ with table	Plate or Block Saw	Plate or Block Saw	Plate or Block Saw
General Description	Moving Feed Table	Moving Feed Table	Large Portal Format	Vertical Plate	Vertical Plate	Vertical Plate
Additional DoALL Group(s)	Dual Column	Dual Column	Dual Column			
Warranty	Parts/Service	Parts/Service	Parts/Service	Parts/Service	Parts/Service	Parts/Service
Warranty Length	1 year standard	1 year standard	1 year standard	1 year standard	1 year standard	1 year standard
Capacity Rectangle at 90° HxW	33.5 x 40" (850x1000mm)	47-1/4 x 63" (1200x1600mm)	49.25 x 63" (1250x16000mm)	48 x 24" (1200x600mm)	48 x 48" (1200x1200mm)	48 x 63" (1200x1600mm)
Capacity Round at 90°	33.5" (850mm)	47-1/4" (1200mm)	49.25" (1250mm)	Info coming soon	Info coming soon	Info coming soon
Blade Drive Motor	15 hp (11.1kW)	15 hp (11.1kW)	16.75 hp (12.5kW)	10 hp (7.6kW)	15 hp (11.1kW)	15 hp (11.1kW)
Blade Speeds	50-262 fpm (15-80mpm)	50-262 fpm (15-80mpm)	50-262 fpm (15-80mpm)	40-279fpm (12-85mpm)	40-279fpm (12-85mpm)	40-279fpm (12-85mpm)
Maximum Blade Diameter	357.5" (9080mm)	458" (11650mm)	458" (11650mm)	288" (7320mm)	327" (8300mm)	346.5" (8800mm)
Blade Widths & Gage	2-5/8 x 0.063" (67x1.6mm)	3-3/20 x 0.063" (80x1.6 mm)	3-3/20 x 0.063" (80x1.6 mm)	2 x 0.063" (54x1.6mm)	2-5/8 x 0.063" (67x1.6 mm)	2-5/8 x 0.063" (67x1.6 mm)
HMI Controller	Yes	Yes	Yes	Yes	Yes	Yes
Work Table Height	31.1" (790mm)	31-1/2" (800mm)	31-1/2" (800mm)	Info coming soon	Info coming soon	Info coming soon
Floor Space Required	164 x 205 x 124" (4150x5200x3150mm)	205 x 158 x 300" (5200x4000x7653mm)	205 x 138 x 162" (5200x3500x4100mm)	161x252x154" (4100x6400x3900mm)	161 x 252 x 178" (4100x6400x4500mm)	161x252x193" (4100x6400x4900mm)
Approximate Weight	32122 lbs (14570kg)	66910 lbs (30350kg)	88185 lbs (40000kg)	Info coming soon	Info coming soon	Info coming soon
Bi-Directional Blade	Yes	Yes	Yes	No	No	No



DoALL DC-1600CNC Hercules™



DoALL 4863-VPL Vertical Plate Saw

Whether you're manufacturing raw forgings or providing finished products such as open die forgings, seamless rolled rings, and contoured rolled rings, discs, hubs, blocks, shafts, sleeves, cylinders, flats, rounds or custom shapes, DoALL can save time and money in the processing of raw materials.

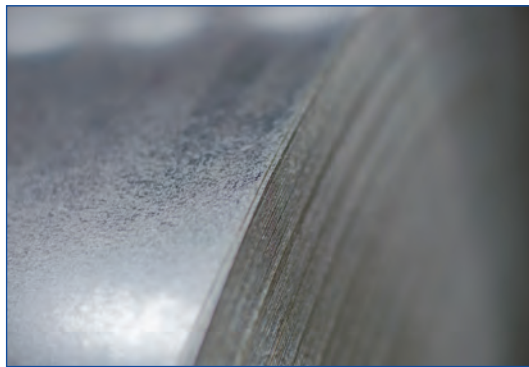
### Standard equipment on most models:

- Complimentary DoALL cutting fluids package
- One (1) DoALL bi-metal saw blade
- HMI saw control
- Work light
- Hydraulic band tension
- Feed rate indicator
- Band brush
- Instructions and parts manuals on CD
- Safety covers
- Tool kit

Visit [www.DoALLsaws.com](http://www.DoALLsaws.com) for most accurate information on standard equipment and accessories

### Raw materials ideal for DoALL band saws:

- Stainless Steel  
F-304, F-216, F-321, F-347
- Carbon Steel  
SA 105 or A-105, LF-1, LF-2, F-11, F-22, 1018, 1020, 1026, 1141, EN-8, EN-9
- Low Temperature Steel  
A-350, LF-1, LF-2
- Tool Steel  
A, D, H, L, M, O, P, S T, Tylex
- Alloy Steel  
A-182, F-1, F-5, F-9, F-11, F-22, F-91, 4140, 4150, 4340, 8640, 8620
- Duplex Steel  
F-44, F-51, F-53, F-55, F-60
- Exotic Metals  
Nickel based steel, Brass, Incoloy, Monel, Haselloy, Waspaloy, Inconel



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