

Product Name :
Variable Rake Angle Hydraulic Shears**Product Code :**
ss0002**Description :**

Variable Rake Angle Hydraulic Shears

Technical Specification :

Variable Rake Angle Hydraulic Shears.

The stable robust, all welded steel frame from ultrasonically tested plates are of top quality. Ram and table designed with special inclined member and box type structure for maximum strength..

The top beam is guided by three point roller with replaceable hardened liners for least wear. This eliminates lubrication of guides. Roller guide made of hardened & ground bearing steel to provide better quality of cutting for a long time. Rake angle can be varied to permit shearing of higher thickness than nominal capacity and facilitating distortion free shearing of thin sheets. The fastest and easiest way of blade clearance setting without need of feeler gauge, which helps Burr-free edges. Positive holding by hydraulic holddowns before shearing avoids slippage of sheets and independent operation of holddowns for clamping of sheet helps checking of mark without taking shear stroke. Front gauging by disappearing stoppers mounted on left squaring arm. Robust, heavy & accurate back gauging to set cutting width. Hydraulic cylinder are designed with both low and high pressure sealing, Hard chrome plated rod also with special type guide for long life

without leakage. Hydraulic components of international quality assembled in our own factory with specially designed compact manifold

Frame: Rigid steel frame of shears are optimally designed to avoid weak sections at load support and is of interlocked design. The table of frame is welded together with support of steel plates. The table top surface is machined with provision of a relief of facilities front gauge support. Ram assembly is welded with steel plate support.

Rake Angle (Variable): Rake angle selector switch is provided in control panel to vary the rake angle. It permits to shear higher thickness than its capacity. This shear can be cut with distortion.

Roller Guides: The upper beam is guided by three point roller guides. A replaceable hardened Liner is provided for minimum wear. It eliminates lubrication of guides.

Hyd Power Pack: Hydraulic system is mounted at top or rear side of machine. Hydraulic components are of internationally reputed make like Vicars, Dorey, Research etc. Valves are mounted on a compact manifold block minimizing piping and chances of leakages. For oil cooling sufficient size of oil reservoir is provided.

Cylinders: Cylinders are precisely honed and are fitted with hard chrome-plated rod with best quality sealing elements. Cylinders are connected with upper beam (cutting beam) with spherical bearings for higher capacity. Two cylinders are working on differential pressure principle for synchronization. This eliminates force on cutting edge.

Hyd Hold Down: Hydraulic hold down pads hold the sheet securely to avoid slipping & bowing resulting in clean square cut. Hold down units are provided for better clamping while cutting narrow strips.

Blade Clearance: Blade clearance can be adjusted manually by lever on each side of machine with calibration of clearance suitable for thickness.

Misreaded Back Gauge: Misreaded back gauge is operated from front of machine by push button. Back gauge travelled distance is displayed on electronic counter. Rest position can be preset and can run with auto stop arrangement. Back gauge automatically retract from bottom blade after shearing, to avoid trapping of cut strips.

Blades: shears are provided with High Quality. Single segment (BHC) blades for longer tool life. Ease in assembly of blades reduce down time. The blades are four sided.

Operation: Electric panel & operational console are provided at right side of the machine for easy operation by operator. Console & control panel is provided with on-off push-button, three phase indicator forward-reverse push-button for back gauge operation, lock push-button for individual hold down function emergency stop push-button. Foot switch is provided to carry out Shearing Operation. If foot switch is released at any point of shearing upper beam will return from that point.

Finger Guard: Fitted in front of hold down for operator's protection without obstructing viewing.

Cutt Shearing Capacity Thickness mm

ing Len gth mm	M.S.		S.S.	
	Nominal rake	Max. rake angle	Nominal rake	Max. rake angle
200 0	3.15	4	2	3.15
250 0	3.15	4	2	3.15
300 0	3.15	4	2	3.15
400 0	3.15	4	2	3.15
150 0	4	6	3	4
200	4	6	3	4

0				
250	4	6	3	4
0				
300	4	6	3	4
0				
400	4	6	3	46
0				

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