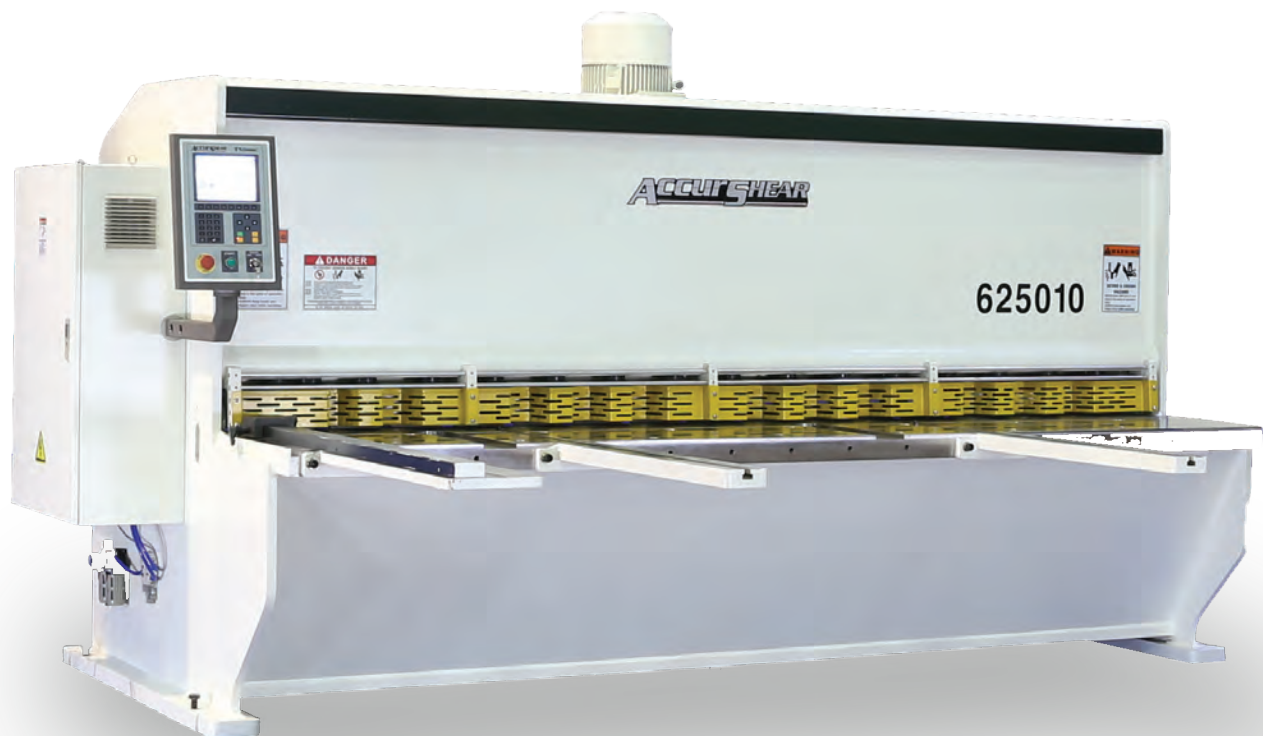




# PROVEN RELIABLE SHEARING

WITH THE HEAVY DUTY ACCURSHEAR



## Superior Design for Shearing Accuracy

### Unique Hydra-Mechanical Rocker Arm Drive System

This design, unique to the Accurshear, combines the best of both worlds. The swing link beam design delivers the strength, power and rigidity of the guillotine system.

The parallel movement of the blade produces a cutting motion that delivers superior blade life and permits the use of 4-edged blades top and bottom. It also allows easy blade clearance adjustment, not afforded by a traditional swing beam design.

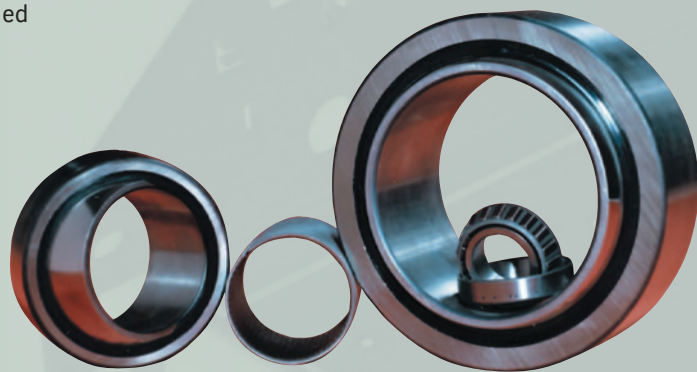
The hydra-mechanical design utilizes two hydraulic cylinders, interconnected by a thick-walled torque tube, to provide the shearing force



Electrical Cabinet

## World-class Bearings

For over 30 years, the unique Accurshear design coupled with high precision, spherical, self-aligning, maintenance-free bearings, zero clearance fitted on hard chrome shafts, have served to shear millions of pieces of metals in all types of shops from precision sheet metal to heavy plate fabricators.



## Highest Shearing Rating Capacities

All Accurshear models are rated to shear structural quality steel with typical mechanical properties up to 52 kg/mm<sup>2</sup> tensile and 31 kg/mm<sup>2</sup> yield strengths.



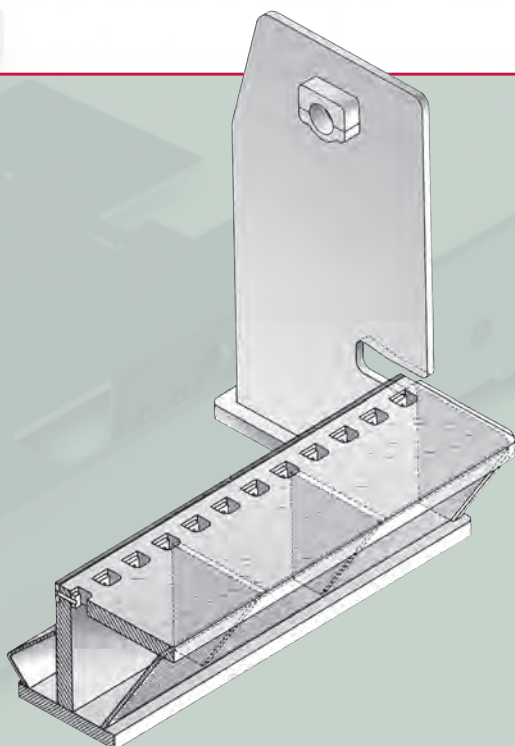
## Quality Shearing Blades

Sourced in USA, the Accurshear uses the highest quality shear blades specially developed to provide maximum longevity and to minimize re-sharpening. Depending on the shear capacity, either high carbon, high chrome, or high carbon/shock resisting blades are used for shearing a wide range of metals such as aluminum, A36 plate, stainless, and titanium. An optional D2 blade, which offers additional hardness, is available as an option on the 6135 and 6250 series.



## Lowest Fixed Rake Angles

The amount of bow and twist produced on a sheared piece of metal is directly related to the rake angle of the shear. Higher rake angles will produce greater amounts of these distortions in the metal. The Accurshear is manufactured with extremely low rake angles to ensure optimum shearing quality with minimum distortions in all material thicknesses.



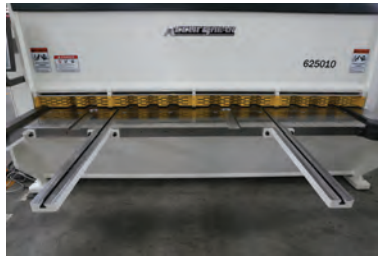
## Heavy-duty Frame Structure

The Accurshear is designed with a fully welded boxed-in table structure that has a high torsion stiffness to balance the torsion load from the cutting force. The high rigidity of the design, combined with the massive table design, ensures constant blade clearance during the shearing cycle. Blade clearances, as low as 0.05mm can be maintained throughout the entire cut, producing quality shearing on thin material. A machined table surface provides a generous, flat work area and features finger wells to aid in lifting sheets.

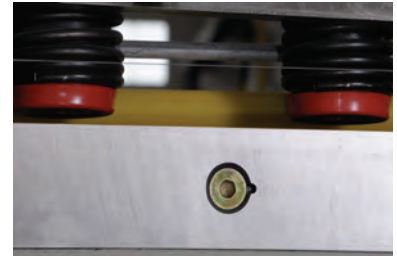


## Standard Features

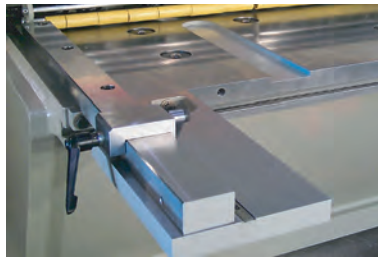
- Pendant mounted control
- 915mm backgauge travel with automatic swing-up at rear
- 4-edged blades, top and bottom modified high carbon, high chrome
- Footswitch with emergency stop
- Rear light curtains
- 1200mm squaring arm with 1mm increments
- Automatic, powered blade clearance adjustment
- Hold-down pads
- Hand slots in table
- Shadow light and line
- Oil cooler



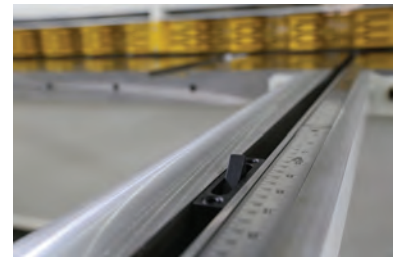
Front Sheet Support Arms



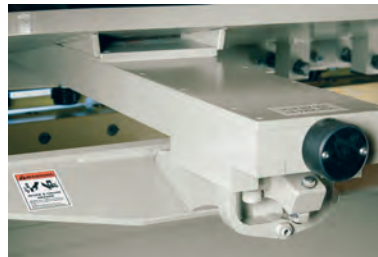
Holddown Pads



Squaring Assist Arm



Recessed Scale



Automatic Swing-up Backstop



Heavy-duty Backgauge Design

## Material Handling Options

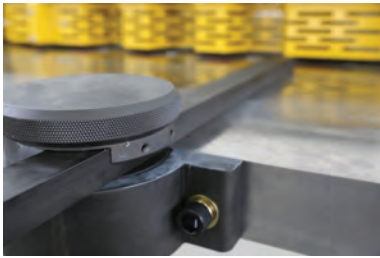
Reduce handling times, increase efficiency and throughput on the Accurshear with CNC Frontgauging, Conveyors and stacking units.

### Accurshear CNC Frontgauging System

Equipped with servo motors, precise ball screw, linear guides and pneumatic clamps.

- Positioning Accuracy:  $\pm 0.01\text{mm}$
- Cutting Accuracy:  $\pm 0.10\text{mm}$
- Feed Rate: 280mm/s
- Travel Distance: 2500mm, 3000mm, 3500mm, 4000mm
- Number of Grippers: 3 or 4
- Pressure of Air Supply: 0.6mpa
- Power: 1.8 kW





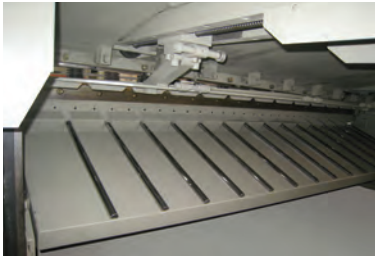
Optional Protractor allows specific angle cuts



Ball Transfers



Longer Squaring Arm



Type A Pneumatic Sheet Support



Type B Pneumatic Sheet Support

## Optional Features

- Protractor to allow accurate angled shearing
- Ball transfers to facilitate easy handling of material on the machine table
- Longer squaring arms to help support and process longer work pieces
- Front light curtains instead of mechanical guard

### Sheet Support

A sheet support system is a recommended option for providing an accurate dimension when supporting lighter gauge material. Light material will droop when pushed sufficiently far from the shear blade edge and consequently the length of the sheared material will differ from the backgauge setting.

Type A sheet support is recommended for very thin materials. It consists of a table which rises parallel to the bottom of the backgauge bar to support material for accurate measurements. The Type A sheet support is built to handle material up to 4mm thick.

Type B sheet support is recommended for material between 1mm and 6mm as lighter materials can sag between the support arms. The Type B sheet support is also compatible with the conveyor handling option.



Accurshear Conveyor and Stacking System

## Conveyor and Stacking

No details are overlooked in our handling systems. We integrate our sheet support, trim cuts and scrap removal in order to produce robust, labour reducing stacking systems. Accurpress tailors the systems to the customers' needs, and has many productivity options available. Please inquire for further information on how we can meet your unique needs.

# Control System

The control console, consisting of the AS7 (7 inch) or the optional AS10 (10 inch) touch screen controller, is mounted on an arm on the side of the Accurshear for maximum accessibility. An emergency stop and motor start button are also mounted on the console. The control is very intuitive and easy to operate, but also extremely powerful if complex jobs need to be programmed. The controller can store 400 programs with 10 different steps. 12 different materials with different properties can also be entered to be selected when programming.

## Program settings

- Program steps
- Material Type
- Material Thickness
- Blade Clearance, automatically calculated, depending on material type and thickness, or manual set
- X Correction
- Extension Program, allows more than one program to run in a sequence

## Step settings

- X Length
- Cut Repeats, repeats the current settings up to 9999 times
- Cut Length, controls the length of the cut depending on the width of the material
- Cut Start, the starting point for each cut
- Variable/Maximum Stroke, uses the cut length and start or does a complete length cut
- X Retract On/Off, the gauge will retract or not when the blade starts cutting

The controller has a batch counter that will stop the program running when the set point is reached.

The amount of material needed for the current program, as well as the total material required if a batch setting is entered, is displayed on the run screen.

The zoom screen shows the information needed while running the program in large, easy to read displays.

Constant messaging of the machine status is displayed on the run screens.

Full service information screens are included, minimizing downtime and making service quick and simple. The control will notify the operator when service is due.

The control can be connected to your local network to allow monitoring, or control, of the machine remotely.

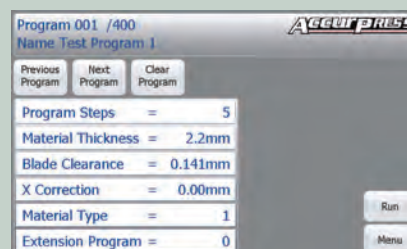
It can also be connected to the Accurshear frontgauge and load/unload systems for a fully automated solution.



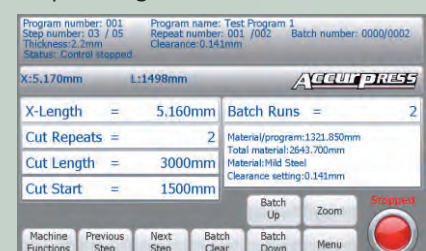
## Control System



## Program Settings



## Step Settings





## Fully Automated Systems

In addition to traditional production enhancers such as the Frontgauge and Conveyor, the Accurshear can also be equipped as a fully automated work cell.

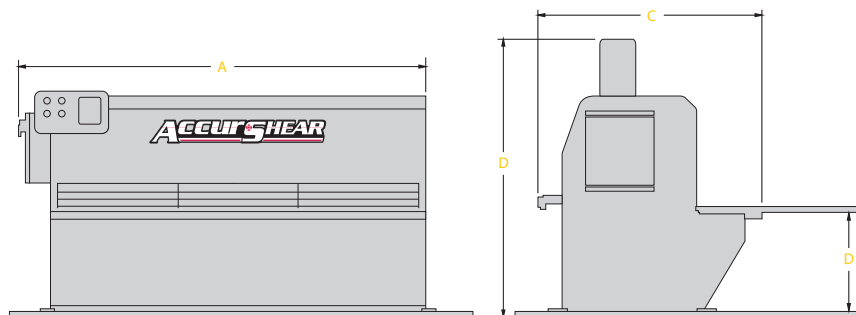
This gantry style loader and unloader allows blanks to be loaded, squared and rotated. It is suitable for any shearing application.



# ACCURSHEAR SPECIFICATIONS

MODEL NUMBER	MILD STEEL	SHEARING LENGTH (MM)	KNIFE SIZE (MM)	RAKE ANGLE (DEGREES)	FULL STROKE (PER MIN)	SHORT STROKE (PER MIN)	NUMBER OF HOLD DOWNS	HOLDING FORCE (KG)	X-AXIS LENGTH (MM)	MAIN MOTOR (KW)	OVERALL DIMENSIONS				APPROX. WEIGHT (kg)
	CUT CAPACITY (MM)										LENGTH A (MM)	HEIGHT TO TOP OF MOTOR B (MM)	WIDTH C (MM)	TABLE TOP D (MM)	
604012	4.00	1220	25x75	0.89	45	70	7	4700	915	7.5	1935	2065	1900	813	3300
604018	4.00	1830	25x75	0.89	38	65	10	5700	915	7.5	2550	2065	2085	813	4200
604025	4.00	2500	25x75	0.89	30	60	13	7400	915	7.5	3280	2065	2135	813	5400
604030	4.00	3050	25x75	0.89	26	55	16	9100	915	7.5	3785	2065	2146	813	6400
604060	4.00	4060	25x75	0.89	20	50	21	12000	915	7.5	4810	2100	2185	813	8900
606018	6.35	1830	25x75	1.19	42	66	10	9100	915	15	2575	2100	2085	813	4900
606025	6.35	2500	25x75	1.19	35	62	13	11800	915	15	3285	2120	2135	813	6800
606030	6.35	3050	25x75	1.19	30	57	16	14500	915	15	3795	2120	2160	813	7600
606036	6.35	3660	25x75	1.19	25	51	19	17200	915	15	4420	2150	2210	813	9500
606040	6.35	4060	25x75	1.19	23	48	21	19100	915	15	4825	2195	2260	838	11800
606050	6.35	5000	25x75	1.19	20	45	25	22800	915	15	5740	2195	2340	838	15500
606060	6.35	6000	25x75	1.19	12	30	30	27200	915	15	6775	2415	2415	863	24000
606070	6.35	7000	25x75	1.19	9	25	35	31800	915	15	7800	2540	2440	914	31000
610025	10.0	2500	25x75	1.49	20	42	13	11800	915	22	3310	2365	2160	813	8400
610030	10.0	3050	25x75	1.49	17	40	16	14500	915	22	4000	2365	2210	813	9500
610042	10.0	4270	25x75	1.49	13	36	22	20000	915	22	5070	2480	2340	838	16600
610050	10.0	5000	25x75	1.49	11	33	25	22800	915	22	5785	2545	2390	863	21000
610060	10.0	6000	25x75	1.49	10	27	30	27200	915	22	6850	2560	2440	914	30000
613025	13.0	2500	25x100	1.79	17	36	13	14400	915	30	3340	2505	2260	863	11700
613030	13.0	3050	25x100	1.79	15	34	16	17800	915	30	3850	2505	2315	863	13000
613042	13.0	4270	25x100	1.79	11	32	22	24500	915	30	5170	2550	2390	863	20400
613050	13.0	5000	25x100	1.79	10	30	25	27800	915	30	5885	2665	2415	914	26500
613060	13.0	6000	25x100	1.79	8	28	30	33400	915	30	6930	2760	2465	914	37500
616025	16.0	2500	32x125	1.79	13	27	13	23700	915	37	3370	2600	2285	914	14900
616030	16.0	3050	32x125	1.79	11	26	16	29100	915	37	3980	2600	2335	914	18300
616036	16.0	3660	32x125	1.79	10	25	19	34600	915	37	4590	2670	2365	914	20000
616042	16.0	4270	32x125	1.79	9	24	22	40000	915	37	5185	2690	2415	914	22800
616050	16.0	5000	32x125	1.79	7	23	25	45500	915	37	5895	2690	2440	914	31000
616061	16.0	6100	32x125	1.79	6	21	30	54600	915	37	6920	2795	2465	965	43200
620025	20.0	2500	32x125	2.09	11	21	13	28100	1200	45	3355	2690	2620	914	15900
620030	20.0	3050	32x125	2.09	9	21	16	34600	1200	45	3955	2690	2690	914	20000
620042	20.0	4270	32x125	2.09	7	20	22	47300	1200	45	5185	2690	2795	914	29500
620050	20.0	5000	32x125	2.09	6	19	25	54200	1200	45	5985	2690	2820	965	35500
620060	20.0	6000	38x140	2.09	5	18	30	65500	1200	45	7035	2795	2845	965	52300
625025	25.0	2500	38x140	2.38	7	13	13	34000	1200	55	3390	2920	2745	965	30000
625030	25.0	3050	38x140	2.38	6	13	16	42000	1200	55	4000	2920	2795	965	38600
625042	25.4	4270	38x140	2.38	7	18	22	57750	1200	55	5250	3050	2870	965	47500
625050	25.4	5000	38x140	2.38	6	17	26	68200	1200	55	6030	3050	2895	965	54600
625060	25.4	6000	38x140	2.38	4	12	31	82000	1200	55	7260	3150	2950	1016	75000
632030	32	3000	38x140	3.50	6	16	16	50000	1200	55	4300	3050	2950	965	40000

Specifications are subject to change without notice.



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