CANRACK
METAL CENTER SYSTEMS

SHEAR AUTOMATION SYSTEMS

• INCREASE PRODUCTIVITY • IMPROVE QUALITY •
• PROVIDE SAFER OPERATION WITH YOUR EXISTING SHEARS •

SHEET HANDLERS: Canrack sheet handlers lift sheets up to 600lbs. in 12' radius from double articulated boom • One man operation • Sheets move easily to shears or CNC feed tables • Operates completely from plant air • Floor mounted • Free standing • No lifting required by operator • Fast 2 sheets per minute handling • Will keep up with CNC shear feed table.

CNC SHEAR FEEDERS: Canrack CNC feed table doubles shear output with fast 1100 inches per minute travel • Set-up time is virtually eliminated • Accurate shearing to ±.005" tolerance • 'Hands Off' movement of sheet through shear • Fits any mechanical or hydraulic shear • Will hold up to 800 standard programs or part numbers in memory.

SHEAR CONVEYORS: Canrack shear conveyors move blanks away from back of shear and raise to proper height for automatic or manual stacking • Material support arms or specialized "hump back" conveyors fully support material during shearing • Can be used with all shears, with or without CNC shear feed table • Special belts provide non-marking, scratch-free handling.

SHEET STACKERS: Canrack sheet stackers work with shear conveyors to safely stack blanks on wood skids or steel runners for pick-up • Scrap chutes available to separate trims • Can be operated automatically if connected with CNC shear feed table • Stackers are easy to adjust and portable with steel casters and quick disconnect cables.

FOR FREE ANALYSIS AND COMPUTER SIMULATION TO SHOW GUARANTEED PRODUCTIVITY GAINS FOR YOUR OPERATION -

CALL 1-800-890-6087

Canrack Storage Systems Inc.
5048 Dundas St West, Toronto, ON M9A 1B9
Tel: (905) 564-6250
E-mail: **info@canrack.com** Website: **www.canrack.com**

ACTUAL PERFORMANCE STANDARDS FROM SHEAR AUTOMATION SYSTEM USING CNC SHEAR FEEDER

PRODUCTIVITY

Example 1 ▪ Shear 750 pcs., 13.968" x 50.000" from 125 sheets 48" x 120"
Actual run time: 3 hours - 32 min.

Example 2 ▪ Shear 100 pcs., 18.562 x 37.000" from 17 sheets 48" x 120"
Actual run time: 37 min.

Example 3 ▪ Shear 400 pcs., 12.906" x 14.781" from 15 sheets 48" x 120"
Actual run time: 1 hour - 20 min.

Example 4 ▪ Shear 250 pcs., 17.750" x 18.687" from 21 sheets 48" x 120"
Actual run time: 1 hour - 14 min.

The above times are with one operator and includes time for loading and material handling.

TOLERANCES

Example 1 Blank 2.903" x 12.952" - 16 gauge C.R.S.
Cut 32 pieces 2.903" wide from 12.952" blank
Measure each end of piece - 2 measurements per piece

Measurements:

1)	2.903	2.901	2)	2.907	2.904	3)	2.900	2.900	4)	2.898	2.900
5)	2.906	2.903	6)	2.904	2.901	7)	2.905	2.902	8)	2.906	2.905
9)	2.900	2.898	10)	2.905	2.903	11)	2.905	2.903	12)	2.906	2.903
13)	2.906	2.905	14)	2.906	2.904	15)	2.905	2.903	16)	2.904	2.901
17)	2.904	2.901	18)	2.905	2.903	19)	2.905	2.903	20)	2.904	2.902
21)	2.906	2.904	22)	2.906	2.904	23)	2.905	2.902	24)	2.904	2.903
25)	2.904	2.902	26)	2.905	2.902	27)	2.905	2.902	28)	2.903	2.903
29)	2.905	2.905	30)	2.905	2.905	31)	2.903	2.904	32)	2.902	2.903

Example 2 Blank 3.120" x 6.000" - .060 galvanized steel
Cut 36 pieces 3.120" wide from 6" blank
Measure each end of piece - 2 measurements per piece

Measurements:

1)	3.124	3.123	2)	3.120	3.117	3)	3.118	3.119	4)	3.120	3.119
5)	3.117	3.117	6)	3.120	3.122	7)	3.124	3.123	8)	3.125	3.124
9)	3.124	3.122	10)	3.120	3.119	11)	3.119	3.120	12)	3.120	3.121
13)	3.124	3.123	14)	3.121	3.119	15)	3.118	3.117	16)	3.119	3.117
17)	3.118	3.117	18)	3.123	3.123	19)	3.120	3.118	20)	3.119	3.118
21)	3.117	3.116	22)	3.122	3.123	23)	3.119	3.116	24)	3.119	3.118
25)	3.118	3.118	26)	3.118	3.117	27)	3.124	3.120	28)	3.120	3.118
29)	3.120	3.120	30)	3.124	3.123	31)	3.118	3.119	32)	3.124	3.124
33)	3.120	3.122	34)	3.124	3.122	35)	3.120	3.120	36)	3.120	3.120

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