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.
2077 Dundas St East Suite 201, Mississauga, Ont.
L4X 1M2 Tel: (905) 564-6250 Fax: (905) 564-6253
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 |

Canrack Storage Systems Inc.
2077 Dundas St East Suite 201, Mississauga, Ont. L4X 1M2
Tel: (905) 564-6250 Fax: (905) 564-6253
E-mail: **info@canrack.com** Website: **www.canrack.com**