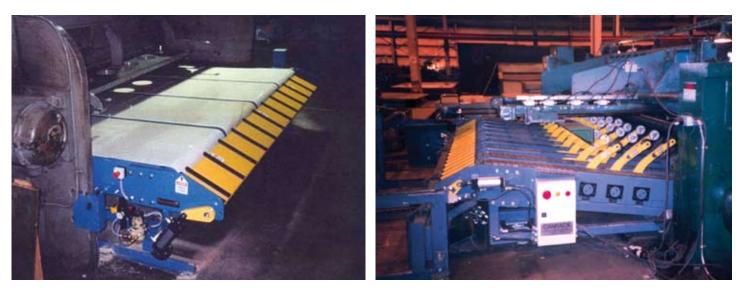


### SHEAR CONVEYORS AND STACKERS



SCRATCH FREE BELT CONVEYOR

## SAFETY

# QUALITY

# PRODUCTIVITY

Canrack manufacturers several styles of shear conveyors designed for different applications including scratch free, heavy plate and very thin sheet.

Scratch free belt conveyors use non-marking cut resistant belts with 'V' guidance for positive belt tracking. A special "hump back" belt conveyor is used with the CNC shear feeder that eliminates the need for a back gauge on the shear.

Material support arm conveyors are used when material is hand fed through the shear. The arms support the material with rows of wheels on 12" centers and eliminate sag of the material to the back gauge. This reduces the effort to push material through the shear and gives better dimensional tolerance on the blanks.

Support wheels can be non-marking for surface critical material or steel for carbon sheet and plate. Limit switches attached to the back gauge arm automatically raise or lower the rows of support arms based on the length of the blank and position of the back gauge. Variable timers on the limit

switches allow for different timing from the shear trip which raises the arms faster when only one or two rows of arms are being used. This feature can greatly increase production allowing the shear operator to shear the next blank at a faster pace.

HEAVY MATERIAL SUPPORT ARM CONVEYOR

Pneumatic operated scrap gates at the end of the conveyor separate trims from the blanks and are operated manually from a foot pedal or automatically if a CNC feeder is used. Trims fall into a removable scrap bin mounted under the conveyor.

Heavy duty stackers are often used when shearing non surface critical material that stack the blanks in a tight square pile. Accessories with the stackers allow multiple rows of blanks to be stacked on a pallet and a pneumatic tamper keeps the stacks straight and square.

Concave mirrors or closed circuit TV monitors give visual control to the shear operator when stackers are used.

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Plate shear stacker with crank adjustment and scale moving on roller bearings make fast and easy change for different blank sizes. A pneumatic tamper squares blanks in the stacker.

Plate shear material support arm conveyor with center conveyor on lift table used to convert 20' plate blanks into standard sizes.



#### Information Required For Shear Conveyors

Make of Shear Model No	Capacity
Paint Colour Electrical: Volts	Phase Cycle
DIMENSIONS REQUIRED	
Height from floor to top of shear table	Distance between shear housings
Distance from back of fixed blade	Thickness of shear housing
to rear of shear housing	Distance from floor to bottom
• Stroke	of back gauge - low end
GENERAL INFORMATION REQUIRED	
Facing shear - What side does operator normally stand on?	? Left Right
Facing shear - What side are shear electrical controls?	Left Right
<ul> <li>Facing shear - What side is squaring arm?</li> </ul>	Left Right
<ul> <li>What is maximum length of existing back gauge?</li> </ul>	
<ul> <li>Is present back gauge</li> </ul>	Manual Power
What is maximum length blank to be sheared - measured from blade to back gauge?	
• If stacker is required, what is method of removing stacks?	Ford Truck Crane Other
If scrap bucket required, will bucket be removed from:	End Front
Describe any obstruction at back of shear that could interfere with full width conveyor	

NOTE: Customer to provide 120v x 15amp dedicated power supply and minimum of 80psi of clean air