



1. TECHNICAL DATA

1.1 Shear

Shearing force	max.	8500 kN
Throat opening width	max.	800 mm
Throat opening height		880 / 1050 mm
Knife stroke		1100 mm
Upper knife angle		12 °

1.2 Hold-down ram

Hold-down ram force		2500 kN
Ram stroke		970 mm
Inlet heights	max.	1375 / 1100 / 950 mm

1.3 Feed bed with angle adjustable pre-compression

Width available for loading	max.	2100 / 2770 mm
Length available for loading		6000 mm
Loading depth		1685 mm
Height of compression wing		800 mm
Compression wing cylinder stroke (2 x)	each	1680 mm
Compression wing cylinder force	each	1250 kN
Pressure lid stroke	max.	1320 mm
Pressure lid cylinder force		2500 kN
Feed ram force		800 kN
Feed ram stroke		7800 mm



1.4 Hydraulic system

1.4.1 Main circuit

Operating pressure	max.	320 bar
Pumps	a.	Rapid traverse pumps 4 vane-cell pumps
Delivery		$Q = 4 \times 420 \text{ l} = 1680 \text{ l/min}$
	b.	High pressure pumps 4 x axial piston pumps
Delivery		$Q = 4 \times 375 \text{ l} = 1500 \text{ l/min}$
Delivery each pump unit		$Q = 795 \text{ l/min}$
Total delivery		$Q = 3180 \text{ l/min}$
Valves		Poppet type, electrohydraulically operated, with internal pilot oil supply
Motor		4 three-phase motors 400 V ; 50 Hz $n = 1500 \text{ U/min}$ $N = 90 \text{ kW}$ type of protection IP 54
Filter		Return filter 50 my nominal
Hydraulic oil		High pressure grade type: HVLP viscosity: ISO VG 46
Oil quantity		ca. 10 000 l on commissioning (tank capacity 8500 l)



1.4.2 Control circuit

Driving pump	1 axial piston pump
Delivery	Q = 1 x 65 l/min
Motor	1 three-phase motor 400 V; 50 Hz n = 1500 Hz N = 5,5 kW type of protection IP 54
Filter	20 my absolute



1.4.3 Filtration / Cooling

Cooling blocks

2 oil air coolers
with 1 fan motor each

400 V; 50 Hz
N = 3,0 kW
n = 1000 U/min
type of protection IP 54

Pumps

2 cellular vane pumps

Delivery

Q = 2 x 275 = 550 l/min

Motor

1 three-phase motor
400 V; 50 Hz
N = 18,5 kW
n = 1500 U/min
type of protection IP 54

Filter

1 Return filter,
20 my absolute

1.4.4 Heating

8 Immersion heater
with + without thermostat

1 temperature regulator
installed in the oil tank.
(4 circuits)

heating
cooling
overheating
control on.



1.5 Knife slide lubrication

Lubricator		Forced feed lubrication, separate oil tank with pump unit and low oil level shut-down stopping knife slide movement.
Lubricating oil		Type: CLP
Oil quantity	ca.	7 l

1.6 Cutting capacity of the shear

max.		Structural steel plate 105 x 720 mm □ 150 o 170 $G_z = 441 \text{ N / mm}^2$
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1.7 Loading dimensions of the machine:

Length	ca.	19 040 mm
	+ scrap chute	<u>1 165 mm</u>
	ca.	20 205 mm
Width	ca.	6 200 mm
Height	ca.	7 130 mm



1.8 Electrical installation

Main voltage 400 V; 50 Hz

Control voltage 230 V; 50 Hz

Control voltage for
programmable control system
and hydraulic valves 24 V DC

1.9 Operating systems

Manufacturer	Programmable control system
Type	SIEMENS S5-115 U

1.10 Total weight:

(without supplies) ca. **187 t**