

CONVEYOR/STACKER CONTROL

Accurshear system operates directly from the control panel



Conveyor stop/start Scrap door open/close Sheet support on/off

CONVEYOR/STACKER COST ANALYSIS

Satisfied customers report a significant reduction in labor costs with their new conveyor/stacker from Accurshear.

A time study showing a single shear operator, who shears the required material, then gathers the material from behind the shear, stacks the plates, and separates the trim cuts, produced the following time and cost breakdown (using a \$30.00 per hour labor cost).

- Infeed - time 30% (cost \$9.00)
- Actual Shearing - time 5% (cost \$1.50)
- Outfeeding and Stacking - time 65% (cost \$19.50)

Based on this time study, the shear is only operating 35% of the time. As a result, an automatic conveyor/stacker can deliver an excellent return on investment by reducing material handling costs.

HOW IT WORKS

The conveyor supports material between the bed and the backgauge by pneumatic cylinders at the shear table level. After the shear strokes, the material support arms drop out of the way, allowing the sheared material to fall on to the conveyor belts. After the material moves out of the shear housing, the support arms return to the up position. Depending on the position of the backgauge—1, 2 or 3 of the support arms are activated.

Trim Cuts are separated from the stack material by a door located at the discharge end of the conveyor. The operator can open the trim separator door by using the foot pedal, or via a switch on the backgauge control. The separator door remains open until the shear strokes, and the trim falls into the scrap container.

The stacker collects material discharged from the conveyor. Adjustable front and back stops keep the material stack square. There is also a movable squaring plate and a hinged tamper which square material from the sides.

OPERATOR EFFICIENCY

It is estimated that material handling consumes up to 95% of a shear operator's time. The Accurshear conveyor/stacker helps to eliminate much of this time by efficiently separating the trim cuts from the finished pieces, and then stacking them neatly at the rear of the machine. The payback time on this system is fast. Take a moment and consider some of the many benefits described below.

WORK SUPPORT ARMS

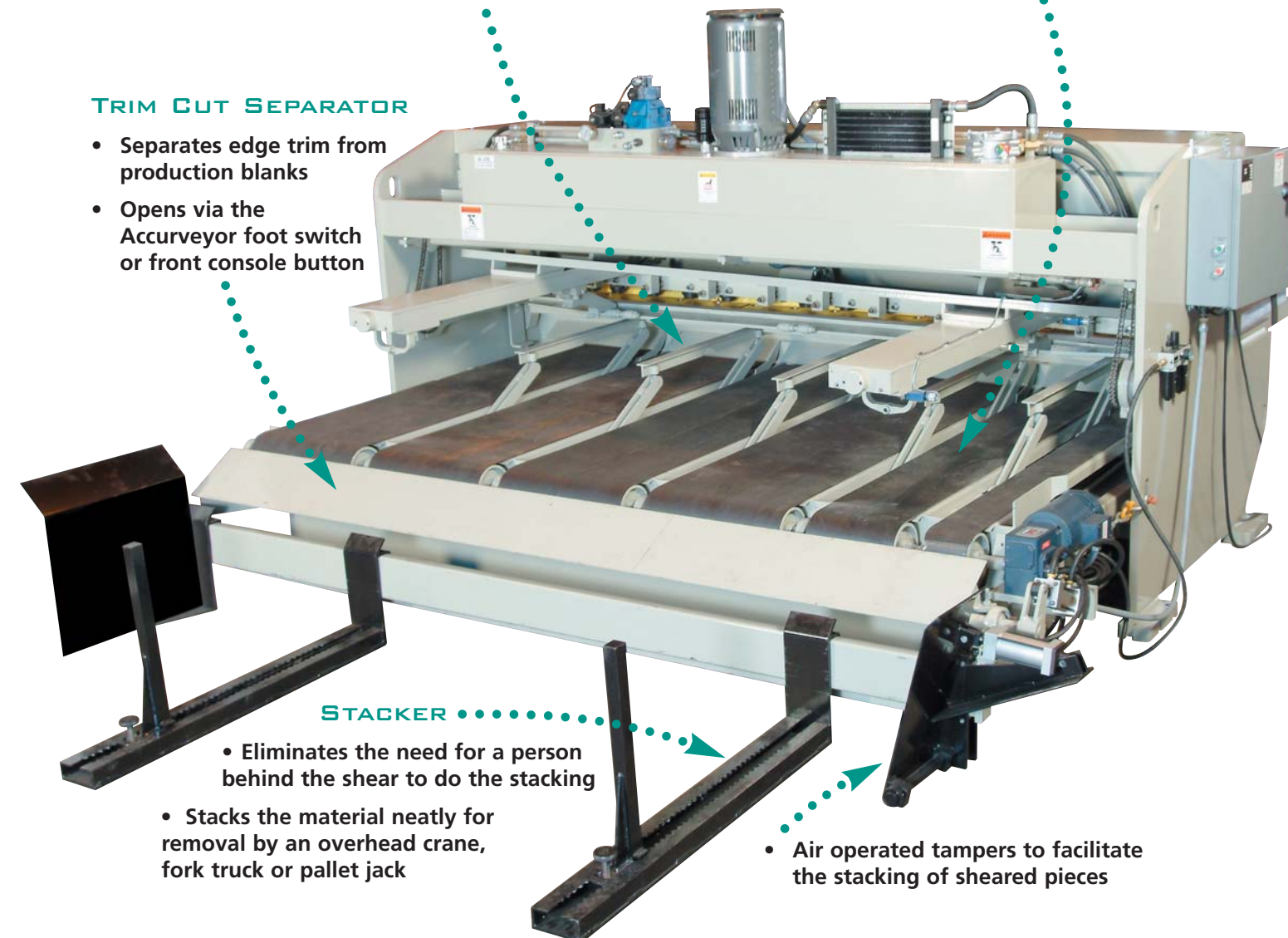
- Improves accuracy because the sheet is supported parallel
- Eliminates the need to manually support light gauge sheets from behind the machine
- Holding material level with the shear table enables accurate backgauge readings
- The supports drop systematically with the shear cycle thus holding the material and reducing plate tear

CONVEYOR

- Provides safer working conditions for operators and helpers
- Eliminates production slowdown due to fatigue
- Reduces backgauge damage from cut material

TRIM CUT SEPARATOR

- Separates edge trim from production blanks
- Opens via the Accurveyor foot switch or front console button



STACKER

- Eliminates the need for a person behind the shear to do the stacking
- Stacks the material neatly for removal by an overhead crane, fork truck or pallet jack
- Air operated tampers to facilitate the stacking of sheared pieces