

- 1 On/Off Machine Buttons
- 2 Mode Selector Switch: Jog, Manual, Auto
- 3 Stroke Length Control
- 4 LED readout in .001" increments
- 5 Stroke counter, Hour meter, Inch/metric conversion
- 6 Backgauge Calibration
- 7 99 pre-select backgauge settings Programmable single-step, sequential shearing
- 8 Go-to-Position Key
- 9 Backgauge motor—Off/On Backgauge retract—On/Hold



HEAVY DUTY BACKGAUGE DESIGN

Strength, rigidity and accuracy combine to produce a solid backgauge with a 36" travel (48" on larger models and optional on smaller models).

High accuracies are achieved via precision ACME lead screws, running on roller bearings, producing longevity and low friction.

AUTOMATIC SWING-UP BACKSTOP

The Accurshear also features an automatic swing-up backstop. When the backstop is run back to the full travel distance it will mechanically lift up, enabling the shearing of longer pieces.



PUSH BUTTON CONTROL FOR BASIC OPERATION AND BACKGAUGE

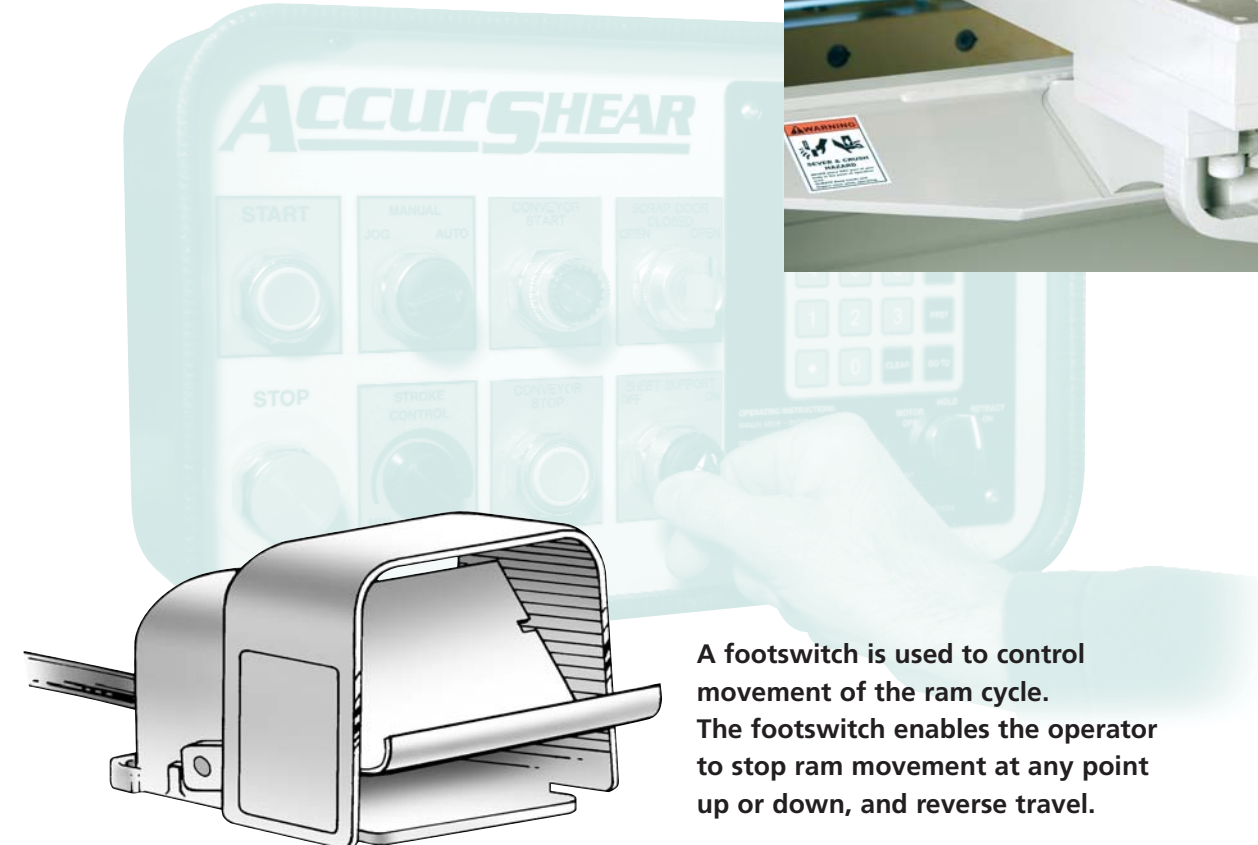
All of the Accurshear's control buttons—including Start/Stop, Mode selector, Stroke control, Stroke counter, and Backgauge selects are located on a front console. To make it readily accessible, the console is mounted to a swing arm pendant from the side of the Accurshear. The three mode selects are useful for various shearing applications.

- **Jog Mode** allows the ram to move downward and stay in position when the footswitch is released. This mode is used primarily when setting and checking clearances along the length of the shear knives.
- **Manual Mode** allows the ram to move down to the bottom limit setting...completing the cut... then stopping... and only returning upon the release of the footswitch.
- **Auto Cycle** allows the ram to continuously cycle while the footswitch is engaged.

The backgauge control features a keypad display, LED readout, and ninety-nine pre-select programmable positions. Under normal use, the operator keys in the desired backgauge setting, presses the "Go To" key, and the backstop bar moves to position. The Accurshear may also be programmed for single-step, or sequential shearing. To eliminate the need of resetting backgauge dimensions between shearing cycles the sequential CNC mode permits the operator to set a series of preset dimensions. In this mode, the backgauge will automatically index to the next preset location after each cut.

To accommodate high accuracy, the backstop bar actually moves slightly beyond the desired position and then comes forward to eliminate any clearance between the lead screws and nuts.

The shear operator may also choose the backgauge retract feature via the key switch. This retracts the stop bar once the holddowns clamp the material just prior to the shear cycle to avoid material wedging between the shear knives and stop bar.



A footswitch is used to control movement of the ram cycle. The footswitch enables the operator to stop ram movement at any point up or down, and reverse travel.