

Revised 14/11/18

NC Hydraulic Shearing Machine

1	Shearing Capacity (plate of tensile strength of 45 Kg/mm ²)	Up to 6 x 2500 mm
2	Shearing Length	2500 mm
3	Rake Angle Range	0.5 - 3
4	Stroke per Minute	20 (Max) – 8 (Min)
5	No.Of Hold	10 or more
6	Table Width	200 mm or more
7	Motor	20 HP min. (Siemens / ABB or equivalent)
8	Back Gauge	Motorized back gauge with DRO (with timer belt)
9.	Accuracy	Back Gauge: +/-0.1mm Cutting Accuracy: As per DIN standard Bow: As per DIN Standard CAMBER: As per Din standard
10	Console with ESSENTIAL ACCESSORIES	<ul style="list-style-type: none"> • Operational Consol. • Rake angle selection through selector switch • Lever operated Blade clearance with calibration. • Fine stroke adjustment rod with limit switch • Squaring arm with steel rule. • Hardened Transfer bars mounted on table • Hold down cylinders. • Cutting area illuminated for clear view of blades. • Four edge HCHCr Blade suitable to MS & SS. • Degree protector for angular cutting. • Stroke counter. • Design with throat depth. • Front & Rear Sheet Support • Centralized lubrication system with flow control valves for adequate lubrication • A SET OF ADDITIONAL BLADES (1 UPPER & 1 BOTTOM) • FIRST FILL OF HYDRAULIC OIL. <p>The OEM to provide catalogue / drawings of the items offered.</p>
11	Machine Construction Features	<ul style="list-style-type: none"> • Hydraulic Seals: Simrit/Sambhen/Equivalent • Padings: Simrit/Sambhen/Equivalent • Hydraulic Pumps: Integral gear Pump (Bosch/Rexoroth/Atos/Voith/equivalent) • Hydraulic valves; Bosch/Rexoroth/Atos • Timer Belt: Specify the Manufacturer • Ball Screw: THk /Hiwin • LM Guide: THk/Hiwin • A/C servo Motor: Schinder/Siemens/Fanuc/Fuji • PLC: Schinder/Siemens/Fuji • Electrical Elements: Siemens/L&T/Schinder

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		<ul style="list-style-type: none"> Optical Linear Scale: Hiedenhien/Givi/Equivalent
12	Optional Item (Quoted Separately)	<ul style="list-style-type: none"> Optional items if any for smooth operation of machine OEM has to be mentioned & Quote
13	PRE DESPATCH INSPECTION	<p>Before inspection of the machine at OEM's works, shearing of Test pieces will be carried out by the OEM. All the tooling, work holding devices & Standard test piece will be supplied by the OEM at free of cost.</p> <p>Accuracy:</p> <p>Back gauge: +/-0.1mm Cutting Accuracy: As per DIN standard Bow: As per DIN Standard CAMBER: As per Din standard</p>
14	INSTALLATION & COMMISSIONING OF THE MACHINE	<p>Installation, commissioning & proving of the machine to its desired capacity and complete at Customer site and will be done by the OEM's engineer. Commissioning work including acceptance test/component trial will be carried out by the OEM's Expert.</p> <p>During commissioning at least 10 nos. Of different thickness and materials test pieces will be produced on the machine and test pieces will be inspected for dimensional accuracy.</p> <p>The commissioning will be treated as complete when we issue the certificate of acceptance. Installation, commissioning & proving of the machine to its desired capacity and complete satisfaction</p>
15	TRAINING	The OEM shall have to provide training exclusively for min. four working days in the field of programming, operation, maintenance (mechanical/hydraulic/electrical) etc.
16	WARRANTY & SERVICE BACK UP	The complete machine must have comprehensive on site warranty from the date of successful commissioning as per below period: a) Machine: 12 months
17	DOCUMENTATION	Three sets of hardcopy in English language and one set of soft copy in English language Programming, Operating and Maintenance manual . a) Mechanical b) Electrical
18	IMPORTANT Notes	<ul style="list-style-type: none"> Vendors should provide in the technical document compliance sheet against the specification of CSIR-CMERI. Comments like yes, agreed, will be given at the time of supply, confirmed and will be completed ARE NOT ACCEPTABLE where numerical values

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	<p>1. Blade Length</p> <p>2. Blade Angle Range</p> <p>3. Stroke per Minute</p> <p>4. No. of Hold</p> <p>5. Table Width</p> <p>6. Motor</p> <p>7. Back Gauge</p> <p>8. Accuracy</p>	<p>are required to be quoted.</p> <ul style="list-style-type: none"> • THE MACHINE MODEL BEING OFFERED MUST BE A STANDARD LATEST MODEL. • THE DATE OF DISPATCH SHOULD BE WITHIN ONE YEAR FROM DATE OF MANUFACTURING. • THE OEM MUST HAVE AT LEAST 5 INSTALLATIONS OF THE OFFERED SYSTEM IN INDIA (DOCUMENTARY EVIDENCE MUST BE SUBMITTED).
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<p>10. Console with ESSENTIAL ACCESSORIES</p>		<p>Operational Console</p> <ul style="list-style-type: none"> • Blade angle selection through selector switch • Level adjustment blade clearance with calibration • Fine stroke adjustment rod with limit switch • Squaring arm with level rule • Hardened Transfer bars mounted on table • Hold down cylinders • Cutting area illuminated for clear view of blades • Four edge HMCQ 11.5mm suitable to MS & SS • Degree protractor for angular cutting • Stroke counter • Design with throat depth • Front & Rear Sheet Support • Centralized lubrication system with flow control valves for adequate lubrication • A SET OF ADDITIONAL BLADES (1 UPPER & 1 BOTTOM) • FIRST FILL OF HYDRAULIC OIL <p>The OEM to provide catalogue / drawing of the items offered.</p>
<p>11. Machine Construction Features</p>		<ul style="list-style-type: none"> • Hydraulic seals: Bosch/Rexroth/Equivalents • Bearings: SKF/Schaeffler/INA/VAPO • Hydraulic Pumps: Integral gear Pump (Bosch/Rexroth/ATOS/Volvo/equivalent) • Hydraulic valves: Bosch/Rexroth/Atos • Tank: upto specify the Manufacturer • Ball bearing: SKF/INA • Cast Gauge: THK/INA • A/C: upto Motor: Schneider/Siemens/Panuc/TD • P.C. : Schneider/Siemens/PLC • Electrical Elements: Siemens/L&T/Schneider

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