

CANRACK

METAL CENTER SYSTEMS

SHEAR CONVEYORS AND STACKERS



SCRATCH FREE BELT CONVEYOR



**HEAVY MATERIAL
SUPPORT ARM CONVEYOR**

SAFETY

Canrack manufactures 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

QUALITY

PRODUCTIVITY

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.

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 to rear of shear housing _____
- Thickness of shear housing _____
- Stroke _____
- Distance from floor to bottom 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 _____
- Facing shear - What side is squaring arm? Left _____ Right _____
- What is maximum length of existing back gauge? _____
- Is present back gauge 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