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ABOUT US

With over 40 years in the marketplace, Accurpress continues to build on its tested history to manufacture an innovative and complete line of press brakes and shears for every bending and shearing application. Proudly North American made, Accurpress leads the way with high tonnage machines, revolutionary pole bending technologies, tandem machines, and robot automation. With over 19,000 machines sold to thousands of satisfied customers, Accurpress continues to build press brakes and shears to meet the demands of today's manufacturing environments.

Steve Hilton President

"While 40 years has brought huge changes to the machine tool industry, all of us at Accurpress continue to stand firm on the original foundation of quality that the company was built on. Every Accurpress machine, including the one you'll buy, is made with 100% of our best efforts. Our business depends on it and so does yours."



ACCURSHEAR 6135 SERIES

10 GA. CAPACITY



Standard Features

- Shear capacity up to 80,000 tensile and 44,000 yield strength.
- Pendant control c/w on/off buttons, mode selector switch, and stroke control dial.
- Backgauge control includes LED display, inch or metric conversion, go-to-position function, 999 pre-select programs, hour meter and stroke counter.
- 36" backgauge travel with automatic swing up backstop at full extension.
- 4-edged blades, top and bottom, modified high carbon, high chrome.
- 3 position footswitch control.
- 4' squaring arm c/w steel rule with 1/16" and 1 mm increments.
- Shadow light and line.
- · Hand slots in table.
- Drilled and tapped holes in front of table.





MODEL	CAPACITY	LENGTH	KNIFE	NUMBER	HOLDDOWN	CYCLES PI	ER MINUTE	OPTIONAL	HI-SPEED	MOTOR		APPROX.					
NUMBER	INCHES	FEET	SIZE INCHES	OF HOLD DOWNS	TONNAGE	FULL STROKE	SHORT STROKE	FULL STROKE	SHORT STROKE	H.P.	A	В	С	D	E	F	WEIGHT LBS.
61356	10 ga	6	1x3x76	10	10	40	65	n/a	n/a	10	98	80	32	81	25	18	9,000
61358	10 ga	8	1x3x100	13	13	35	60	n/a	n/a	10	122	80	32	83	23	20	11,000
613510	10 ga	10	1x3x124	16	16	30	55	n/a	n/a	10	146	80	32	84	22	21	14,000
613512	10 ga	12	1x3x148	19	19	25	45	n/a	n/a	10	170	80	32	86	21	22	17,000
613514	10 ga	14	1x3x172	22	22	20	40	n/a	n/a	10	194	80	32	88	18	24	20,000
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Specifications are subject to change without notice. Capacities are based on 80,000 tensile/44,000 yield strength steel.



ACCURSHEAR 6250 SERIES

1/4" CAPACITY







Standard Features

- Shear capacity up to 80,000 tensile and 44,000 yield strength.
- Pendant control c/w on/off buttons, mode selector switch, and stroke control dial.
- Backgauge control includes LED display, inch or metric conversion, go-to-position function, 999 pre-select programs, hour meter and stroke counter.
- 36" backgauge travel with automatic swing up backstop at full extension.
- 4-edged blades, top and bottom, modified high carbon, high chrome.
- 3 position footswitch control.
- 4' squaring arm c/w steel rule with 1/16" and 1 mm increments.
- Manual quick blade clearance adjustment.
- Shadow light and line.
- · Hand slots in table.
- T-slot in front of table.
- Oil cooler.

MODEL	CAPACITY	LENGTH	KNIFE	NUMBER	HOLDDOWN	CYCLES PE	R MINUTE	OPTIONAL	HI-SPEED	MOTOR		OVE	RALL D	IMENSI	ONS		APPROX.
NUMBER	INCHES	FEET	SIZE INCHES	OF HOLD DOWNS	TONNAGE	FULL STROKE	SHORT STROKE	FULL STROKE	SHORT STROKE	H.P.	A	В	С	D	E	F	WEIGHT LBS.
62506	1/4	6	1x3x76	10	10	30	55	46	65	20	99	83	32	82	25	18	11,000
62508	1/4	8	1x3x100	13	13	26	50	42	65	20	123	83	32	84	23	20	14,000
625010	1/4	10	1x3x124	16	16	23	48	38	60	20	147	83	32	85	21	22	17,000
625012	1/4	12	1x3x148	19	19	20	46	32	60	20	171	83	32	87	20	23	21,000
625014	1/4	14	1x3x172	22	22	17	42	26	55	20	195	89	33	90	18	25	32,000
625016	1/4	16	1x3x196	25	25	14	38	21	55	20	219	89	33	92	15	28	39,000
625018	1/4	18	1x3x220	28	28	13	34	19	55	20	243	94	33	94	13	30	47,000
625020	1/4	20	1x3x244	31	31	12	30	17	50	20	267	94	33	96	11	32	57,000
625024	1/4	24	1x3x268	37	31	10	26	14	50	20	291	96	33	98	9	34	88,000
Specifications are subject to change without notice. Capacities are based on 80,000 tensile/44,000 yield strength steel.																	



ACCURSHEAR 6375 6500 SERIES

3/8" 1/2" CAPACITY







Standard Features

- Shear capacity up to 80,000 tensile and 44,000 yield strength.
- Pendant control c/w on/off buttons, mode selector switch, and stroke control dial.
- Backgauge control includes LED display, inch or metric conversion, go-to-position function, 999 pre-select programs, hour meter and stroke counter.
- 36" backgauge travel with automatic swing up backstop at full extension.
- 4-edged blades, top and bottom, modified high carbon, high chrome.
- 3 position footswitch control.
- 4' squaring arm c/w steel rule with 1/16" and 1 mm increments.
- Manual quick blade clearance adjustment on 63756 through 650012 models
- Power blade clearance on 650014 and larger models.
- Shadow light and line.
- · Hand slots in table.
- T-slot in front of table
- Ball transfers in table for 6500 Series (optional for 6375 Series).
- Oil cooler.

MODEL	CAPACITY	LENGTH	KNIFE	NUMBER	HOLDDOWN	CYCLES PI	ER MINUTE	OPTIONAL	. HI-SPEED	MOTOR		OVE	RALL C	IMENSI	ONS		APPROX.
NUMBER	INCHES	FEET	SIZE INCHES		TONNAGE	FULL STROKE	SHORT STROKE	FULL STROKE	SHORT STROKE	H.P.	A	В	с	D	E	F	WEIGHT LBS.
63756	3/8	6	1x3x76	10	11	26	46	33	55	30	100	88	32	85	22	21	16,000
63758	3/8	8	1x3x100	13	13	24	46	31	55	30	124	88	32	85	22	21	19,000
637510	3/8	10	1x3x124	16	16	21	44	29	50	30	148	88	32	87	20	23	21,000
637512	3/8	12	1x3x148	19	19	18	40	26	46	30	172	90	33	90	17	26	27,500
637514	3/8	14	1x3x172	22	22	15	36	23	40	30	196	90	33	95	12	31	36,000
637516	3/8	16	1x3x196	25	25	13	33	20	38	30	221	91	34	95	12	31	45,000
637520	3/8	20	1x3x244	31	31	11	25	16	28	30	269	93	36	96	11	32	71,000
65006	1/2	6	1x4x76	10	12	21	42	26	48	40	102	97	34	88	20	22	19,000
65008	1/2	8	1x4x100	13	16	20	42	25	48	40	126	97	34	88	20	22	22,000
650010	1/2	10	1x4x124	16	20	18	40	23	46	40	150	97	34	90	17	25	28,000
650012	1/2	12	1x4x148	19	24	16	38	21	44	40	174	97	34	94	13	28	33,000
650014	1/2	14	1x4x172	22	28	14	36	18	42	40	198	97	34	96	11	30	46,000
650016	1/2	16	1x4x196	25	31	12	34	15	40	40	222	100	36	98	9	32	61,000
650020	1/2	20	1x4x244	31	39	10	32	14	38	40	271	100	36	100	8	33	85,000
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Specifications are subject to change without notice. Capacities are based on 80,000 tensile/44,000 yield strength steel.



ACCURSHEAR 6625 6750 61000 SERIES

5/8" 3/4" 1" CAPACITY





Standard Features

- Shear capacity up to 80,000 tensile and 44,000 yield strength.
- Pendant control c/w on/off buttons, mode selector switch, and stroke control dial.
- Backgauge control includes LED display, inch or metric conversion, go-to-position function, 999 pre-select programs, hour meter and stroke counter.
- 48" backgauge travel with automatic swing up backstop at full extension.
- 4-edged blades, top and bottom, modified high carbon, high chrome.
- 3 position footswitch control.
- 4' squaring arm c/w steel rule with 1/16" and 1 mm increments.
- Power blade clearance adjustment.
- Shadow light and line.
- · Hand slots in table.
- T-slot in front of table.
- · Ball transfers in table.
- Oil cooler.

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MODEL	CAPACITY	LENGTH	KNIFE SIZE	NUMBER	HOLDDOWN	WN CYCLES PER MINUTE OPTIONAL HI-SPEED			MOTOR		APPROX.						
NUMBER	INCHES	FEET	INCHES	OF HOLD DOWNS	TONNAGE	FULL STROKE	SHORT STROKE	FULL STROKE	SHORT STROKE	H.P.	A	В	с	D	E	F	WEIGHT LBS.
662510	5/8	10	1 ⅓x5x124	16	32	14	35	18	40	50	153	105	36	105	16	24	38,000
662512	5/8	12	1 ⅓x5x148	19	38	12	32	16	37	50	177	105	36	107	14	26	45,000
662514	5/8	14	1 ⅓x5x172	22	44	11	29	14	34	50	201	105	36	109	12	28	59,000
662516	5/8	16	1 ⅓x5x196	26	52	9	25	12	31	50	225	106	36	110	11	29	68,000
662520	5/8	20	1 ⅓x5x24 4	30	60	7	21	9	27	50	274	110	38	111	10	30	90,000
675010	3/4	10	1 ¹ ⁄ ₈ x5 ¹ ⁄ ₂ x124	16	38	14	35	18	40	60	153	106	36	106	15	25	41,000
675012	3/4	12	1 ¹ / ₈ x5 ¹ / ₂ x148	19	45	12	32	16	37	60	177	106	36	108	13	27	47,000
675014	3/4	14	1 ¹ ⁄ ₈ x5 ¹ ⁄ ₂ x172	22	52	11	29	14	34	60	201	106	36	110	11	29	67,000
675016	3/4	16	1 ¹ / ₈ x5 ¹ / ₂ x196	26	62	9	25	12	31	60	225	106	38	111	10	30	78,000
675020	3/4	20	1 ¹ ⁄ ₈ x5 ¹ ⁄ ₂ x244	30	72	7	21	9	27	60	274	110	38	112	9	31	101,000
6100010	1	10	1½x5½x125	16	46	11	25	13	30	75	156	115	38	110	11	29	65,000
6100012	1	12	1½x5½x149	19	54	9	23	11	27	75	180	115	38	112	9	31	71,000
6100016	1	18	1½x5½x197	26	75	7	20	9	24	75	229	120	38	114	7	33	100,000

Specifications are subject to change without notice. Capacities are based on 80,000 tensile/44,000 yield strength steel.



BUILT WITH INTEGRITY

UNIQUE HYDRA-MECHANICAL ROCKER ARM DRIVE SYSTEM

This design, unique to the Accurshear, delivers the strength, power and rigidity of the guillotine system and produces the ease of blade clearance adjustment afforded by the swing link design. The hydra-mechanical design utilizes two hydraulic cylinders, interconnected by a thick-walled torque tube, to provide the shearing force of the ram. Like the guillotine design, the Accurshear produces a cutting motion through the material that allows the use of 4-edged blades and a 1-degree relief angle.

LOWEST FIXED RAKE ANGLES

The amount of bow and twist produced on a sheared piece of metal is directly related to the rake angle of the shear. Higher rake angles will produce greater amounts of these distortions in the metal. Accurshears are manufactured with extremely low rake angles to ensure optimum shearing quality with minimum distortions in all gauges of metal.

Model #	Rake Angle
6135	3/16" per ft.
6250	1/4" per ft.
6375	5/16" per ft.
6500	3/8" per ft.
6625	3/8" per ft.
6750	7/16" per ft.
61000	1/2" per ft.

HIGHEST SHEARING RATING CAPACITIES

All Accurshear models are rated to shear structural quality steel with typical mechanical properties up to 80,000 tensile and 44,000 yield strengths.

ULTRA-HEAVY FRAME STRUCTURE

The Accurshear is designed with a fully welded boxed-in bed table structure that has a high torsion stiffness to balance the torsion load from the cutting force. The maximum rigidity of the unique design, combined with the massive table design, ensures constant blade clearance during the shearing cycle. Blade clearances as low as



.002" can be maintained through the entire cut, producing quality shearing on light gauge material. A machined table surface provides a generous, flat work area, and features finger wells to aid in lifting sheets.



BUILT WITH WORLD RENOWNED COMPONENTS

MAINTENANCE-FREE BEARINGS

Bearings installed in the Accurshear are of the highest quality, spherical, self-aligning and are zero clearance fitted on hard chrome shafts. The bearings are there for the long term, helping to ensure that the Accurshear will be precisely cutting metal for several decades.



QUALITY HYDRAULICS

The hydraulic reservoir, fitted with motor, pump, valves, filters and cooler is designed for maximum efficiency and power. The unit



ELECTRICAL COMPONENTS

Schneider Electric and Sprecher & Schuh, both worldwide leaders in power systems, are the primary suppliers for the Accurshear when it comes to electrical components. Their products—relays, starters, switches, contractors—are designed to meet and exceed robust industrial environments,

providing the necessary key assurances for sustainability and long part life that is built into every Accurshear.



SHEAR BLADES

The Accurshear comes with the highest quality shear blades available, made of high carbon, high chrome and shock resisting composition, suited to shear a wide variety of materials. The OPTIONAL D2 blade is available and recommended for the 61356 through 625024 models when shearing higher tensile and yield materials up to and including 10-guage in thickness. Blade sharpness is maintained longer to ensure maximum shearing quality over an extended time.





PRODUCTIVITY FEATURES

MF MACHINE CONTROL CONSOLE



The Accurshear control buttons are located on the MF front control mounted on a pendant arm protruding from the side

mounted electrical cabinet. The console rotates on the arm to provide convenience for the machine operator. An OPTIONAL swing-away pendent arm is also available to provide more flexibility for shearing applications requiring the console to be positioned further to the side of the shear.



DISPLAY FEATURES

- 1 Machine ON Button
- 2 Mode Selector Switch: Jog, Manual, Auto
- Stroke Length Control
- 4 LED readout in .001" increments
- Stroke counter, Hour meter, Inch/metric conversion Backgauge Calibration
- 6 999 pre-select backgauge settings Programmable single-step, sequential shearing
- Go-to-Position Key
- 8 Go-to "pre-selected" backgauge position
- Backgauge retract—On/Hold

OPTIONAL TN2000C TOUCHSCREEN CONTROL CONSOLE

The TN2000 touchscreen features an LCD display with push-button navigation, and an interface for shear programming job selections and operation. The TN2000 control will automatically adjust the blade gap with the material thickness entered. (Power blade clearance option must be purchased for Accurshear 62506-650012 models for the automatic adjustment to operate).



HEAVY-DUTY MECHANICAL BACKGAUGE

Strength, rigidity and accuracy combine to produce a solid backgauge with a 36" travel length on Accurshear 6135xx-6500xx models. High accuracies are achieved via precision ACME lead screws, running on roller bearings that produce longevity and low friction. A 48" travel is available as an option on these same models, and is the standard length for the 6625xx-61000xx series.

AUTOMATIC SWING-UP BACKSTOP

This robust gauge also features an automatic swing-up backstop bar when the unit is selected to travel to full 36" or 48" distance. The bar will mechanically lift up to enable the shearing of longer pieces that may be pushed beyond the backgauge.





SQUARING ARM ASSISTS ACCURATE CUTTING





MANUAL BLADE CLEARANCE ADJUSTMENT

Blade clearance adjustment is an excellent and necessary feature to obtain high shearing quality. A manual adjustment is a standard feature on the Accurshear models beginning with the 62506 and extending to the 650012.

Adjustment is easily made via the hand lever on the side of the machine. The dial is numbered, and a corresponding chart is affixed to the shear to provide information for the most appropriate settings pending the thickness and grade of steel.

The 6135xx models have a fixed clearance due to the importance of a minimal distance of approximately 0.002" required for the lightest of sheet metal gauges.

A power blade clearance adjustment is standard on 650014 and larger models and is OPTIONAL for the 62506-650012 shears.





OPTIONAL FEATURES

BALL TRANSFERS IN TABLE

Ball transfers mounted in the table are a standard feature on all Accurshear models 6500 and larger. They assist the movement of heavy materials over the table surface and may be ordered as an option on 6135, 6250 and 6375 series models.



HOLDDOWN PRESSURE CONTROL



Some sensitive materials may experience marking under standard holddown pressures. This optional holddown pressure control provides pressure adjustment from 0 to 3,000 psi and is easily adjusted from the operator's normal work station.

HIGH SPEED HYDRAULIC PACKAGE

This system offers approximately 30% faster cycle times than the standard package. Horsepower and pump volumes increase with this option. This option is not available for the 6135 series models.

HOLDDOWN PADS

Holddowns can be equipped with urethane pads to reduce marking of aluminium or other sensitive materials.

PROTRACTOR ALLOWS SPECIFIC ANGLE CUTS

The protractor bolts to the face of the table and can be positioned anywhere along its length. This versatility assists in accurately cutting specific angles, and can serve as a mobile squaring arm.



FRONT ARMS

Front arms are available in 2', 4', and 6' lengths measured from the front of the shear table. Each arm is machined with a t-slot to accommodate a disappearing stop. Recessed scales may also be purchased for the front support arm to aid in front gauging. Ball transfers may be added to assist in the handeling of large plates.





SAFETY GUARDING RECOMMENDATIONS



LIGHT CURTAIN GUARDING

To enhance safety and allow an operator to position smaller pieces of metal into position for shearing, a light curtain may be purchased to replace the mechanical finger guard.

The Accurshear will not cycle, or will stop abruptly if a foreign object interferes with the light curtain beam. The safety light curtain system satisfies the appropriate OSHA and ANSI regulations for safe operating conditions.



REAR GUARDING

To facilitate safe operating conditions, Accurpress also offers guarding at the back of the shear. The mechanical guarding incorporates a light curtain beam, when interrupted will cause the shear to stop.

A mechanical rear guard with light curtain beams may also be purchased for Accurshears that include optional pneumatic Sheet Support systems or the Accurveyor/Stacker system. In such cases, the guarding extends beyond the furthest point of the OPTIONAL accessory to provide maximum safe operating conditions to adhere to OSHA and ANSI applicable standards.



SHEET SUPPORT SYSTEMS

PNEUMATIC SHEET SUPPORT

A sheet support system is a recommended option for providing an accurate cut dimension. Light gauge material will quickly droop once it is pushed very far from the shear knife edge—and consequently, the dimension on the drop off piece will not be consistent with the backgauge readout. Two styles are offered and both simply roll in under the shear ram, and are operated via pneumatic power and an electronic circuit.



Arm Style

This system incorporates three rows of arms which are in the "up" position prior to the shear cycle. They support the material parallel to the gauge bar for an accurate measurement with the exception of 20 gauge and lighter gauges (table style recommended). Once the holddowns clamp the material, just prior to the shear cycle, the arms fall, allowing the material to slide off the table. After the cut is completed, the arms immediately rise to the up position in preparation for the next cut. Either support system can be turned on or off at any time by using the select switch on the control console.



Table Style

The table style is recommended when support is necessary for very light gauge material and is offered on Accurshear 61356-625020 models. It consists of a table which rises parallel to the bottom of the backstop bar to support the material for accurate measurements. Once the holddowns clamp the metal, just prior to the shear cycle, the table automatically lowers itself, allowing the material to slide off. Once this is complete, the table rises to the "up" position again in preparation for the next cut.

ROLLER TABLE

The non-powered roller table is an excellent option to help in the removal of sheared metal. The table is manufactured in various lengths and is positioned under the Accurshear ram to enable sheared pieces to roll to the back of the shear via the heavy duty rollers for quick and easy access. Elimination of the awkward removal of sheared pieces that typically fall directly under the ram greatly increases shear efficiency and reduces cycle time.



ACCURVEYOR/STACKER SYSTEM



WORK SUPPORT ARMS

- Improves accuracy because the sheet is supported parallel to the table.
- 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.

TRIM CUT SEPARATOR

- Separates edge trim from production blanks.
- Opens via the conveyor 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

• Facilitates the stacking of sheared pieces.

URETHANE PROTECTION

- Urethane pads are available as an added OPTION, and secured to the top of the arms and the scrap door.
- Provides the most adequate protection for sensitive materials that may be prone to scratching during the conveying process.



ACCURSHEAR CNC FRONTGAUGE



ACCURACY

- +/- .003" positioning accuracy
- · High accuracies achieved with precision ball screws

PRODUCTIVITY ADVANTAGES

- Maximizes material usage
- · Reduces handling and thereby increases efficiency
- Substantially increases shearing accuracy
- Reduces personnel needs
- · Eliminate problems associated with sheet sag when measuring via a backgauge
- Drive system operates at over 900 in/min
- Easy mechanical adjustment for calibration



625012

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ACCURSHEAR AUTOMATION



AUTOMATION CONTROL

Accurshear touchscreen control allows for easy programing of all automation features and fast initializing of shearing production runs.

MAXIMIZE PRODUCTIVITY

This CNC frontgauge system will compliment high production shearing environments offering precision and durability for many years.

CLAMPING FINGERS

Heavy-duty clamping fingers position material for fast and accurate shearing. Clamping fingers can also be lowered below table height for convenience of material handling.

ACCURPRESS GAUGING SYSTEMS



ACCULTEREAR

S # 4



SPECIAL APPLICATIONS/SPECIAL MACHINES

From small shears to large, Accurpress can build a shear to suit your needs.

We specialize in producing equipment that will meet the shearing needs found within the vast array of sheet metal and heavy fabrication shops throughout North America. Whether you are shearing light gauge and sensitive metals or heavy steel—job shop to high production volume, the Accurshear is the answer.







No job is too big for Accurpress!



DEALER SUPPORT NETWORK

Accurpress Sales & Service is provided by an Authorized Dealer Network. All of our Dealers are factory trained and supported to provide you with knowledgeable, competent and local service.



For more information about our products, please refer to our comprehensive brochures or visit our site www.accurpress.com.