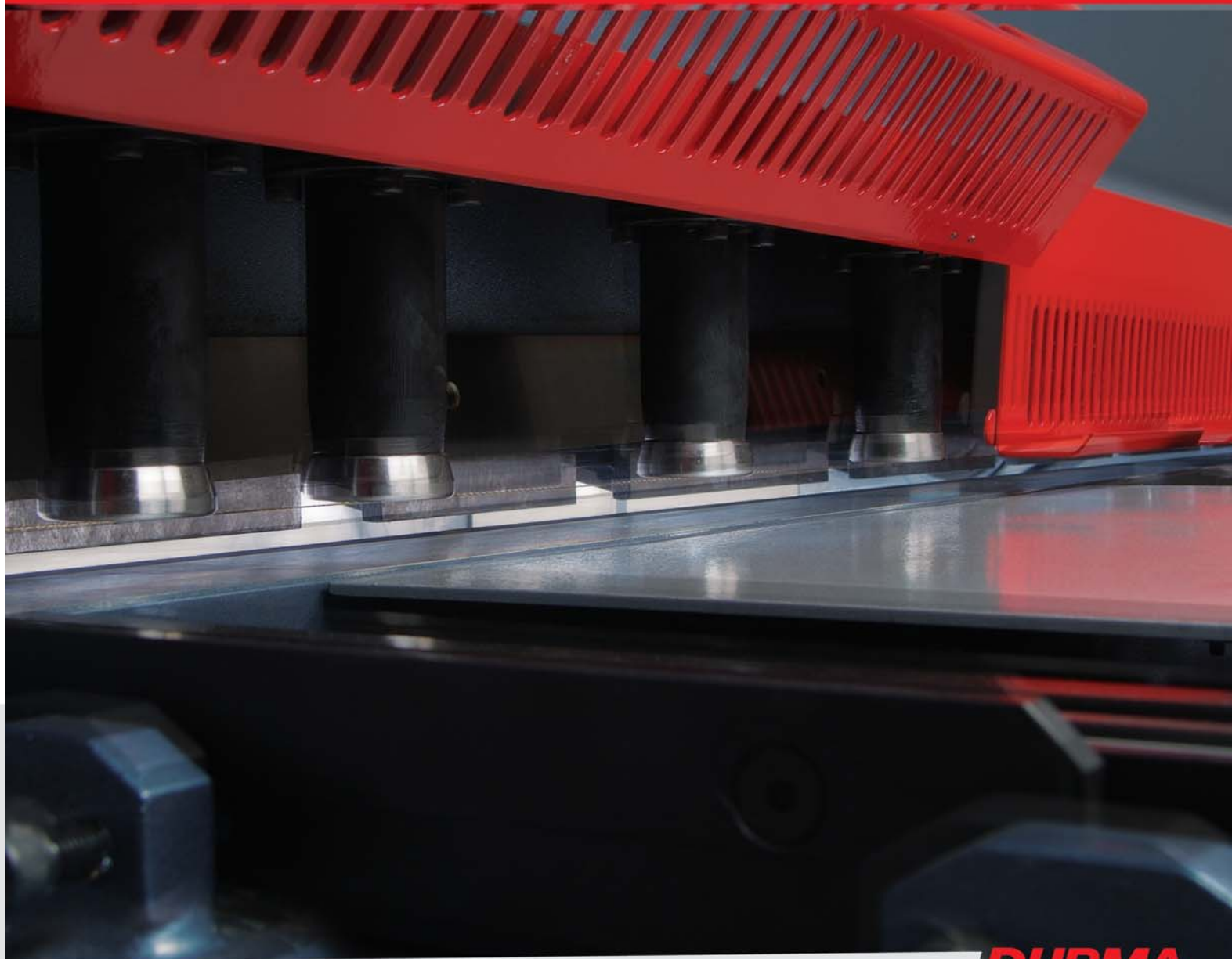


DURMA

SB SERIES

Swing Beam Shears



DURMA

SB SERIES

Swing Beam Shears

The SB Swingbeam Series Shears by design and construction provide for reliable, fast, and accurate shearing.

The "swing style" upper beam is a very rigid box frame construction. This allows the rake angle of the upper blade to be a very low angle, which is key to reducing distortion in the sheared piece.

The beam pivots on two large spherical bearings. These oversized bearings and box frame construction of the "swing beam", maintain a constant blade clearance along the full cutting edge. A capability normally associated with much more expensive machines. This design has proven itself over the last thirty to forty years as reliable approach to productive shearing.



With Pneumatic thin sheet support system





Rear Sheet Support System

When shearing long drop pieces of thin material the sheet can droop before it reaches the gauge bar, therefore making it impossible to gauge or, at least gauge accurately. In this system support arms which are pneumatically activated support the sheet while gauging and then automatically move away for shearing after the sheet is securely clamped and gauged. This also eliminates the need to front gauge and the need for the operator or additional personnel, to manually support the sheet from the rear side of the machine, which is not only costly, but unsafe.



Pneumatic thin sheet support system



(option)



Finger Guard, Ball Transfers & Holddowns

The first one meter of the finger guard can be flipped up out of the way for easy viewing of the work piece at the point of cut. Holddowns are provided to ensure that the plate is held firmly along the length of the cutting area. The holddowns are distributed in such a way that more are closer at each end of the table. This guarantees not only safer operation at the beginning and end of the cut but also the accuracy for narrow (short) plates at each end of the machine. Each independently acting holddown is capable of applying high pressure to hold the material being cut at the same time preventing thin and delicate materials from being marked.



Large Gap

Large gaps (minimum 350 mm) in the side frames allow shearing of sheets longer than the blade length.



Single Point Blade Clearance

A Quickset single point blade gap adjustment is conveniently located on the side frame of the machine. The operator can easily and quickly change this setting, as the material type and thickness demands, for a high quality blank.



Swing Up or Away Back Gauge

Back gauge can swing away at the end of its travel to allow the shearing of unlimited length drop pieces. Also available is a swing up style, which swings up and out of the way when the back gauge reaches the end of its range. Both styles allow shearing sheets of an unlimited length.



Programmable Control

The ENC 100 Controller provides both "multi-step" (50 programs) and "touch and go" programming features for the back gauge. Other features include; high speed back gauge positioning on ball screws, back bar retraction, programmable stroke length, and parts counter. Three modes of operation with key switch lockout for safety.

(option)



Protractor

This device allows easy and fast angle cutting of the sheet. Calibrated in degrees the operator can position the sheet at the angle of cut desired.

(option)

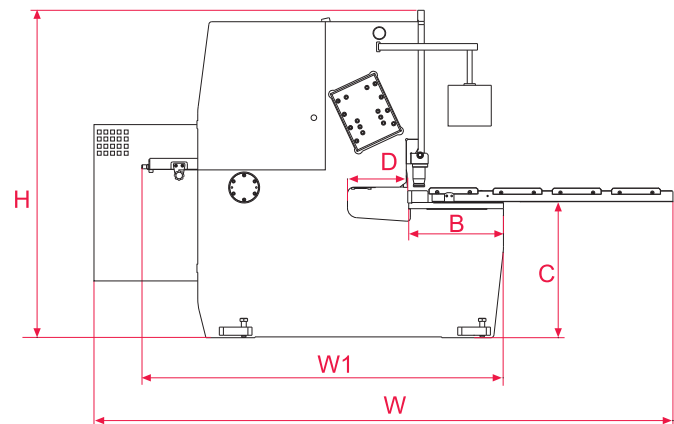
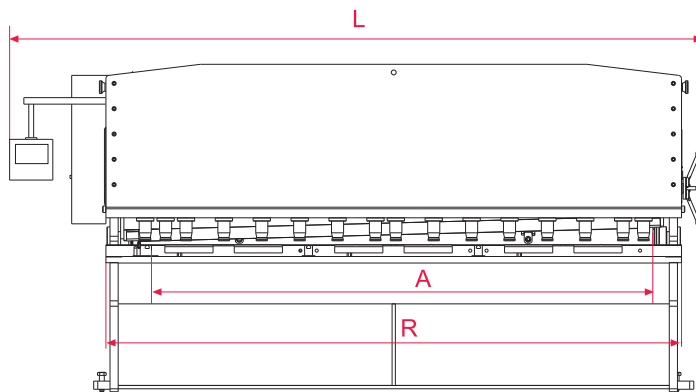
Standard equipment

- Ballscrew back gauge 1000 mm
- Digital readout
- Extension arm, 1500 mm long , with scale & T-slot
- Two squaring arms 1000 mm long & with T slot
- Ball Transfer Tables
- 350 mm throat depth
- Stroke Length Control
- Single Point Blade Clearance Adjustment
- Blades for mild and stainless steel
- Shadow line
- Automatic flip-up back gauge
- Remote foot control
- 1000 mm flip-up finger guards

Optional equipment

- CE-Norm
- NC Control
- Light curtains for finger protection
- 0-180° protractor for angle shearing
- Rear pneumatic thin sheet support system
- Oil Cooler
- Conveyor Stacker
- Longer Squaring and Support Arms
- Laser cutting line
- Special Throat depth
- Power Blade gap adjustment

SB SERIES			Without throat depth										
			2506	3006	3010	3013	3016	3020	4006	4013	3006 NT	3010 NT	3013 NT
Cutting length	(A)	mm.	2550	3100	3100	3100	3100	3100	4100	4100	3100	3100	3100
Cutting capacity	MS (450 N/mm ²)	mm.	6	6	10	13	16	20	6	13	6	10	13
		SS (700 N/mm ²)	mm.	4	4	6	8	10	13	4	8	4	6
Throat depth	(D)	mm.	350	350	350	350	350	350	350	350	-	-	-
Stroke per min		1/dk.	18	15	13	13	10	6	12	8	17	14	13
Rake angle		derece	1°15'	1°15'	1°30'	1°45'	2°	2°	1°15'	1°45'	1°30'	1°30'	1°45'
Blade gap adjustment		min/mm	0.05	0.05	0.05	0.05	0.07	0.09	0.05	0.05	0.05	0.05	0.05
		max/mm	0.75	0.75	1.05	1.45	1.80	2.20	0.75	1.45	0.75	1.05	1.45
Table height	(C)	mm.	770	770	900	818	818	886	920	818	900	900	900
Table width	(B)	mm	510	490	580	550	550	570	490	550	500	580	600
Table length	(R)	mm.	2880	3430	3525	3520	3580	3670	4440	4520	3495	3495	3525
Number of holddowns		adet	12	14	16	14	14	14	18	18	16	16	16
Holddown force		ton	15	17	54	48	61	77	22	62	10	22	37
Back gauge range		mm.	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000
Back gauge power		kw.	0.75	0.75	0.75	1.1	1.5	1.5	1.1	1.1	0.75	0.75	1.1
Back gauge speed		mm/sec	120	120	120	120	120	120	120	120	120	120	120
Motor power		kw.	15	15	22	30	37	45	15	30	15	22	30
Oil capacity		lt.	170	170	200	330	410	450	280	330	170	200	330
Number of sheet supports		adet	2	2	2	2	2	2	3	3	2	2	2
Length	(L)	mm.	3300	3850	4300	4150	4550	4450	5000	5350	4180	4225	4250
Width	(W1)	mm.	2200	2200	2250	2250	2250	2260	2200	2250	2150	2250	2250
Total width	(W)	mm.	3100	3100	3650	3850	3825	3400	3650	3850	3650	3600	3850
Height	(H)	mm.	1900	1950	2200	2250	2250	2450	2150	2250	2000	2090	2180
Weight approx.		kg.	6200	7000	10350	12500	15000	21700	9920	16300	6950	9000	11800



DURMA

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