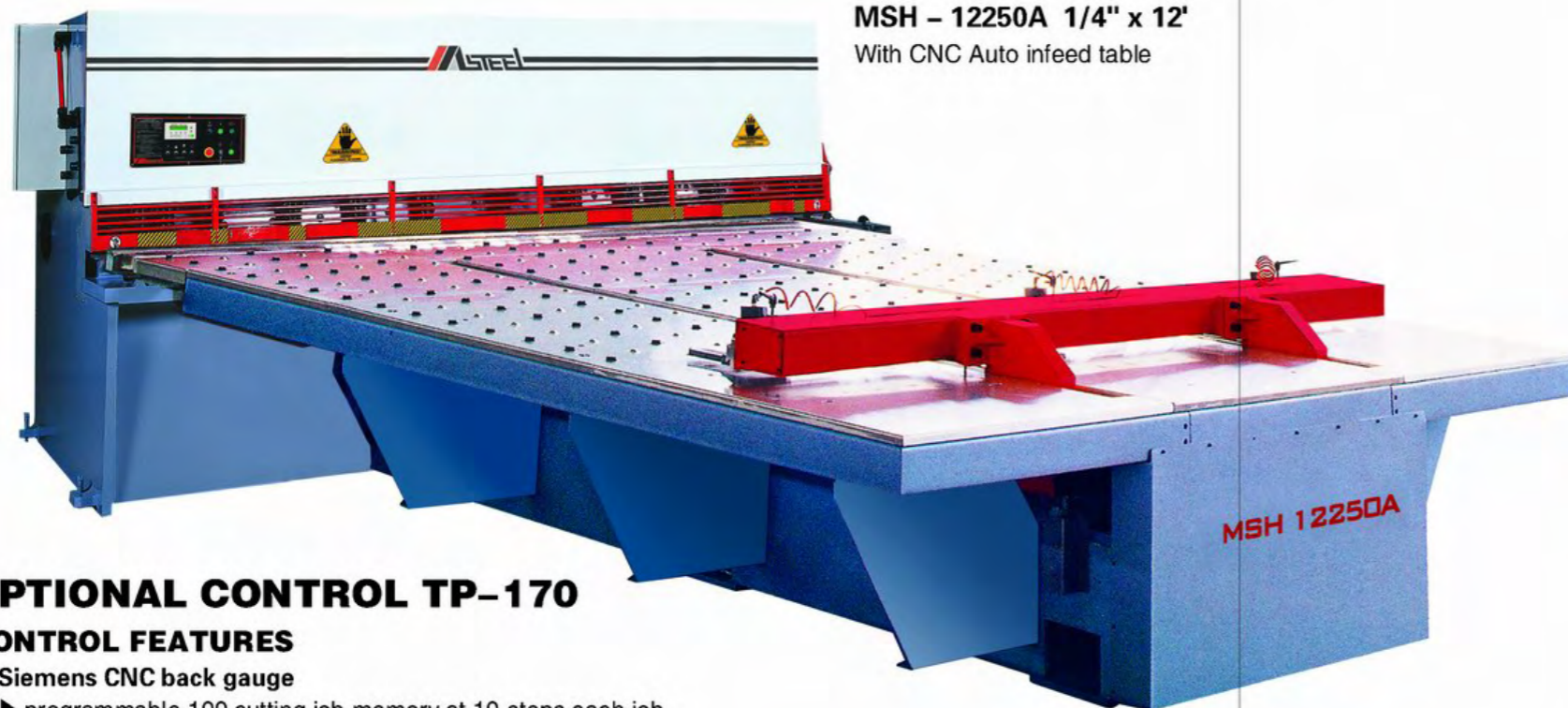


MASTEEL CNC HYDRAULIC SWING BEAM SHEARS



MSH – 12250A 1/4" x 12'
With CNC Auto infeed table

OPTIONAL CONTROL TP-170

CONTROL FEATURES

- **Siemens CNC back gauge**
 - ▶ programmable 100 cutting job memory at 10 steps each job
 - ▶ stroke counter control
 - ▶ cutting width control
 - ▶ accuracy at $\pm 0.002"$
- **6" Touch screen display**
- **Numeric Keypad for easy data input**
- **Simple Easy operating control console**
with all the manual control functions on only one screen
 - ▶ Back gauge Position display in .001" inch
 - ▶ one-step go-to position control on back gauge
 - ▶ Manual push button adjustment on back gauge
 - ▶ Programmable back gauge retract function on each cutting step
 - ▶ Numeric keypad for easy -data input
 - ▶ Operating hour meter
 - ▶ Auto-swing up back gauge at full travel
 - ▶ Programmable cutting width control
 - ▶ Programmable cutting stroke control
 - ▶ and all the features of the MSC-200 control



STANDARD CONTROL MSC-200

CONTROL FEATURES:

- **SIEMENS CNC controlled 36" back gauge: accuracy to $\pm 0.002"$**
- **60 position programmable back gauge memory**
- **One-step go-to position control on back gauge**
- **Automatic swing up of back gauge at full travel**
- **Programmable cutting width control**
- **Easily operated control console:**
 - ▶ Prompting instructions for easy operation and service
 - ▶ Running status display on control console

Manual/Auto mode	Back gauge position
Cutting width	Number of cutting strokes
 - ▶ Blade gap setup operator prompt at start up

OPERATING FUNCTIONS:

- **Steady cutting speed and rapid back stroke for higher production efficiency**
- **Multi - control mode**
 - ▶ Console push button or foot switch control
 - ▶ Single cut/ continue cut mode
 - ▶ Multi-backgauge positioning and automatic multi-cut control mode
- **Auto clamping pressure control on padded holddown feet, auto-adjusted to material thickness**
- **Complete hydraulic and electrical overload protection**

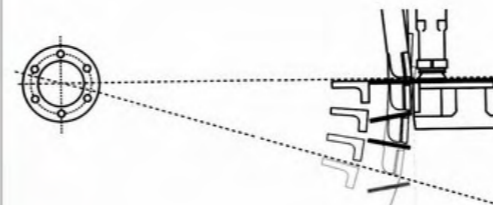
MASTEEL CNC SHEAR

MASTEEL CNC SHEAR

VALUE AND QUALITY STANDARD EQUIPMENT FOR MASTEEL CNC SHEAR



MSH - 12250 1/4" x 12'

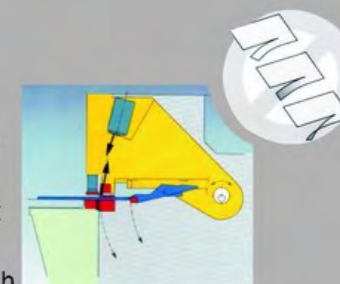


ACCURACY

Top blade and back gauge swing together allowing the material to remain perpendicular to bottom blade then swing away from the bottom blade after the cut thereby preventing jamming of the material between the blade and the back gauge.

RELIABILITY AND FUNCTIONABILITY

Masteel swing beam shears do not require a relief angle therefore the force created by the hydraulic cylinder is applied directly against cutting load. Cutting loads do not deflect the cutting blades or beam mechanism and therefore blade clearance gap remains consistent through the cut. This feature allows Masteel shears to cut strips narrower than the material thickness without damage to the blades or machine structure.



QUALITY AND HEAVY-DUTY STRUCTURES

Mono-block type, welded frame and blade beam construction are optimized by computer-aided engineering to guarantee maximum rigidity. Heavy-duty taper roller bearings are located at swing beam centers so that cutting load is always perpendicular to blade beam rotational radius. This avoids cutting loads being transferred to the support bearings thereby insuring longer life and consequently better accuracy over the long term.



MASTEEL CNC SHEAR

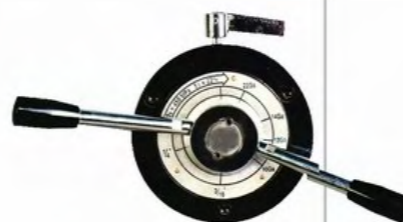
MASTEEL CNC SHEAR



Movable pedestal with foot control switch and emergency stop



Independent holddowns automatically adjust holddown-pressure to various material. More holddown-pressure for heavier cutting and less pressure for delicate thin material.



Precision quick blade adjustment ensures proper blade clearance, variable position to suit for material thickness and properties in order to achieve quality cutting



American-made hydraulics Simple hydraulic system for reliable performance Quality American-made components: Valves, pump, hoses and fittings



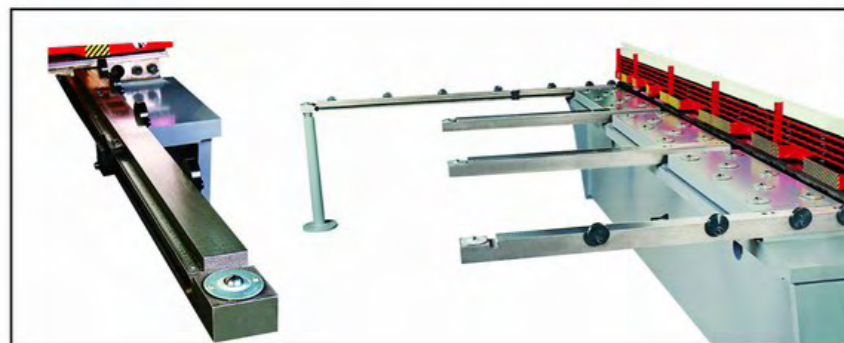
Siemens Compact Control System integrates CNC backgauge, hydraulics and electric control in one. Simple and less complicated control ensures years of quality performance on Masteel Shears

STANDARD EQUIPMENT:

- Two squaring arms c/w stainless steel rule (metric and standard scales) and disappearing stops
 - ▶ 7 Ft on left side to facilitate squaring of long sheet material
 - ▶ 4 Ft arm on right to provide even service life across full length of blades
- 4 Ft front support arms
- Ball transfers in table for ease of handling heavier materials
- Ball transfers on front support arms, front gauge bar and right squaring arm
- Shadow light and line for positioning on scribed line
- Rear sliding tray for ease of collecting cutoff materials
- Full length cage type safety guard
- Nylon padded pressure controlled material hold downs
- Movable pedestal with foot control switch and emergency stop
- Rapid precision manual blade clearance adjustment

QUALITY COMPONENTS AND STRUCTURAL DESIGN:

- SIEMENS programmable logic controller integrates hydraulic, electrical and CNC controls in one compact module for long-lasting reliable performance
- SIEMENS display screen with foil button controls
- SIEMENS frequency back gauge drive controller
- North-American made pump and back gauge control motors
- North-American standard hydraulic fittings, couplings and hoses
- Field serviceable hydraulic and electric systems
- Swing beam design for consistent precision cutting quality with low maintenance
- Fully hardened sectional upper and lower cutting blades. Bottom blade has four cutting edges, top blade has two
- Low-rake cutting angle for minimum material distortion
- Heavy-duty design, rigid stress relieved box construction


SPECIFICATIONS

Models	Capacity Mild steel	Cutting Length	Throat Depth	Back Gauge	Front Gauge	Rake Angle	Motor	Weight Lbs.	Dimensions L x W x H
MSH-08250	1/4"	8'4"	5-13/16"	36"	48"	1° 30'	15HP	14,200	122" x 64" x 65"
MSH-10250	1/4"	10'6"	5-13/16"	36"	48"	1° 30'	15HP	16,100	154" x 68" x 70"
MSH-12250	1/4"	12'	5-13/16"	36"	48"	1° 30'	15HP	22,000	175" x 70" x 71"
MSH-14250	1/4"	14'	4"	36"	48"	1° 30'	15HP	30,500	160" x 82" x 80"
MSH-16250	1/4"	16'	4"	36"	48"	1° 30'	20HP	39,600	235" x 92" x 80"
MSH-10375	3/8"	10'6"	4"	36"	48"	1° 30'	25HP	25,600	160" x 82" x 81"
MSH-12375	3/8"	12'	4"	36"	48"	1° 30'	25HP	28,500	194" x 82" x 81"
MSH-10500	1/2"	10'6"	8"	36"	48"	1° 30'	25HP	29,500	160" x 82" x 84"
MSH-12500	1/2"	12'	8"	36"	48"	1° 30'	30HP	35,200	194" x 96" x 84"
MSH-14500	1/2"	14'	8"	36"	48"	2°	30HP	39,500	160" x 82" x 84"
MSH-16500	1/2"	16'	8"	36"	48"	2°	40HP	61,600	235" x 104" x 100"
MSH-10625	5/8"	10'	8"	36"	48"	2°	50HP	53,000	164" x 94" x 108"
MSH-12625	5/8"	12'	8"	36"	48"	2°	40HP	46,600	196" x 86" x 86"
MSH-10750	3/4"	10'	8"	36"	48"	2° 30'	50HP	53,000	164" x 94" x 108"
MSH-12750	3/4"	12'	8"	36"	48"	2° 30'	50HP	61,000	196" x 96" x 111"

>Specifications subject to change without notice <