100% Owned, Operated and Manufactured in the U.S.A.

Rigging, Installation and Electrical Recommendations

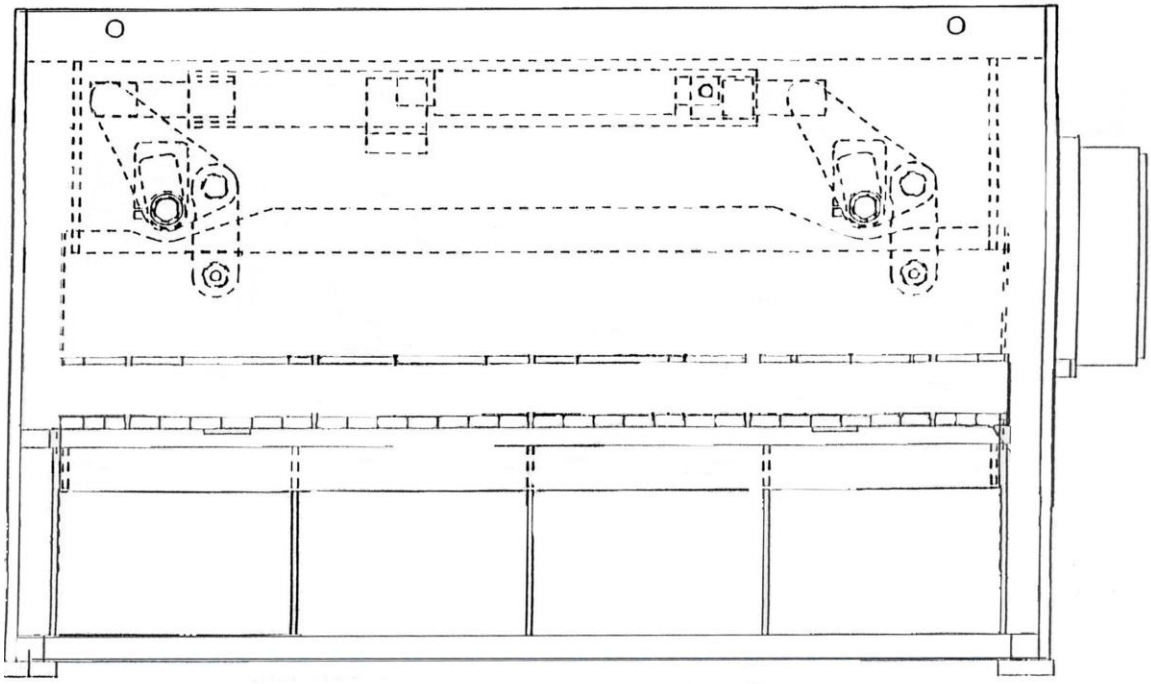
Please note that all aspects of rigging, including the cost of the rigging, the actual rigging itself and the timing of the truck delivery with the riggers is solely the responsibility of the customer and not that of Standard Industrial's.

Rigging

Standard Industrial strongly recommends the customer contract a professional millwright/rigger to rig, move and/or install any Standard Industrial machine.

Special precaution is needed to prevent tipping of this machine. ABSOLUTELY ALWAYS LIFT FROM THE 3" DIA. LIFTING HOLES LOCATED AT THE TOP OF THE MACHINE—NEVER FROM BELOW. There are (2) 3" diameter holes on the front frame (as shown) and (2) 3" diameter holes on each end frame (side frames). The machine must be professionally and precision leveled and securely bolted to the foundation. Please refer to the SIC Leveling Procedure page included with this manual. Failure to do so is in violation of O.S.H.A. stipulations and can cause performance problems on a press brake and could affect the blade clearance on a shear.

Simply level the machine as directed on a solid, reinforced foundation thick enough to withstand the weight of this machine and accompanying material.



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Electrical hook-up

When the mechanical installation is complete proceed with the electrical connection—all electrical connections are the responsibility of the customer and/or integrator and will not be performed by a Standard Industrial representative. All electrical work should be assigned to qualified electricians who follow all local and national codes which may be applicable. Do not assign this task to unskilled labor. The electrician should connect the incoming power to the input of the main disconnect switch and then carefully check for correct rotation of the main motor. If incorrect, reverse any two of the input leads to reverse. Change only the main input leads--Do not correct rotation by reversing leads at other locations in the machine electrical systems.

NOTE: Some electrical services have a "stinger" leg. One phase is higher voltage. If so, that phase must not be used to supply the transformer. Be sure the two wires supplying the transformer are not excess voltage to prevent damage to electronic components.

It is important to connect an earth ground to provide some protection for the electronic controls—FAILURE TO PROVIDE EARTH GROUND WILL VOID ELECTRONIC WARRANTY.

With the electric power off and the ram blocked, clean and lubricate the work surfaces, cylinder shaft and any backgauge or other option that may be included. Refer to the SIC Installation Checklists for full details for press brake and/or shear installation.

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PROCEDURE FOR SHEAR LEVELING

To achieve precision results, it is absolutely critical that the shear must be properly leveled with a precision leveling system and properly mounted/bolted to the foundation. Standard Industrial will not be able to guarantee any forming results unless this is done properly by professional millwrights. The machine must also be mounted to the floor to comply with O.S.H.A. standard.

Proper Bolt Down / Leveling Procedure

The table of the shear must be approximately level left to right; extreme precision in this direction is not required. Check the front to back level at the end of the bed—IN THIS CASE THE LEVEL SHOULD BE PRECISE TO WITHIN APPROX. .005". Just as important, the weight of the machine must be distributed on all 4 footpads.

A common condition which prevents precision results is to find one of the back footpads is "floating". To correct this condition carefully check each of the back footpads while the shear is under load to insure that the footpads are lifting or moving side to side. If this is happening that footpad is not carrying an equal load and must be shimmed to insure the load is evenly distributed. Once this is done firmly tighten the mounting bolts. In some cases the mounting bolts will have pulled loose from the foundation and will need to be replaced with bolts with adequate holding power to keep the frame secure to the foundation. The strength of the mounting bolts is critical to assure that all 4 bases are carrying a load. An improperly leveled shear can effect the blade clearance (gap) causing improper shearing.

Most models are equipped with set screws in the footpads. These screws are intended to ease the work of installing thin metal shims under the bases as required for leveling. **THE WEIGHT OF THE MACHINE SHOULD NOT BE LEFT ON THE SCREWS**. After installing the shims and before tightening the mounting bolts the set screws should be retracted. The shims under the footpads should be thin steel plates and not soft material.