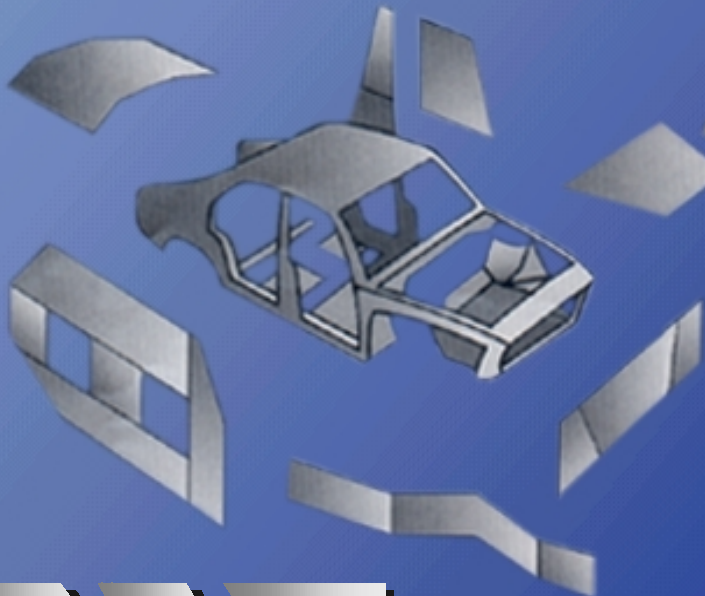


## NEAR NET SHAPE ADJUSTABLE SHEAR TOOLS

- OSCILLATING SHEAR
- 2 BLADE TRAP SHEARS
- ADJUSTABLE CHEVRON SHEARS
- ADJUSTABLE "Z" SHEARS
- 3-OUT BLANK SHUTTLE TOOL
- VARIABLE GAUGE SHEARS
- BOW TIE SHEARS



### SESCO PRODUCT GROUP'S ADJUSTABLE SHEARING TOOLS CAN SAVE TIME & MONEY BY:

- Reducing Scrap
- Minimize Die-Set Time
- Utilizing Economical Coil Widths
- Minimize Additional Tool Cost
- Increasing Production Rates
- Optimize Productivity
- Reduce Operator Workload

NEAR

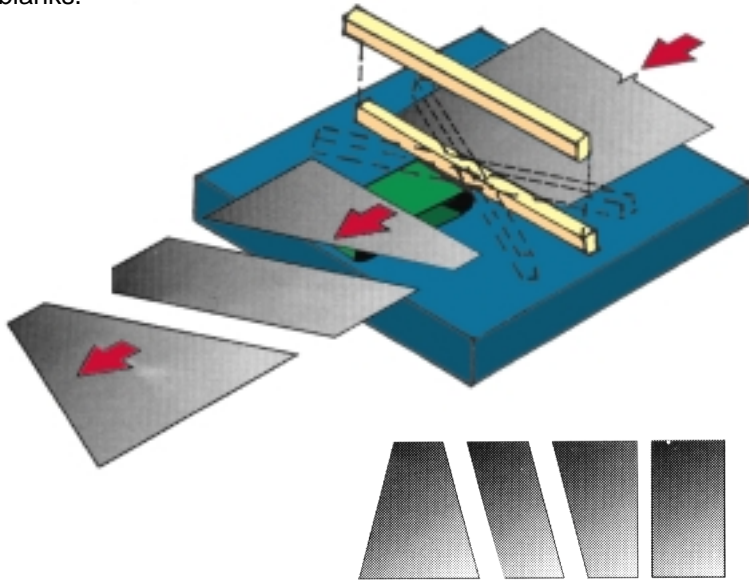
NET

SHAPE



# SPG PROGRAMMABLE OSCILLATING SHEARS

By using one of **Sesco Products Group's Programmable Oscillating Shears** convert your conventional blanking line into a trap shear line. A single pivoting straight cut shear oscillates on the fly with each press stroke to produce rectangular and trapezoidal shaped blanks.



## STANDARD FEATURES

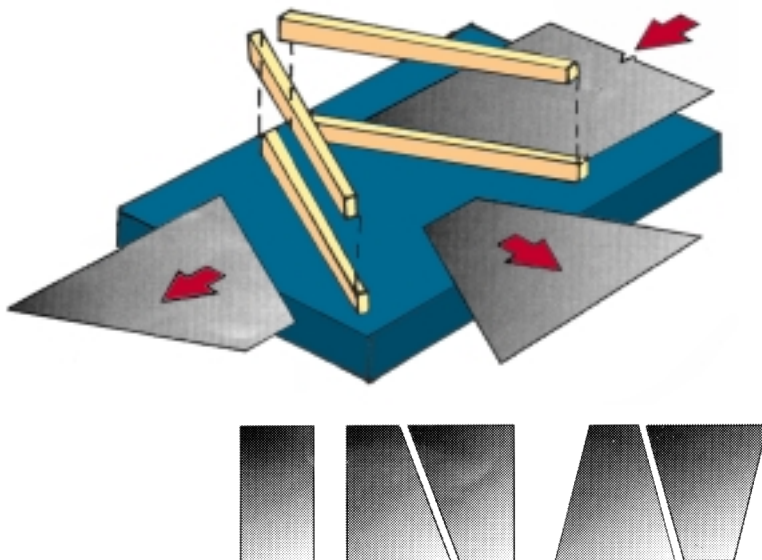
- Each press stroke produces one symmetrically opposed blank.
- Hardened trim steels have 4 cutting edges for easy sharpening.
- Wear surfaces feature lube-less bearings for low maintenance.
- Oscillating sub-die floats on a cushion of air for reduced friction.
- Oscillating sub-die is designed as a "Bump-Die" (upper not attached to press ram).

## AVAILABLE OPTIONS

- Power source determines cost of overall performance, Electro-servo/Hydraulic/Pneumatic.
- Up to  $\pm 45^\circ$  of angular rotation.
- Eliminate "bump-die" feature for increased performance.
- Motor driven stock guide for automated set-up.
- Exit conveyors can be designed to accommodate your existing system.
- Bow-tie shear promotes self-centering.
- Self-centering adjustable stock guide, for set-up purposes, centers all coil widths.

# SPG DUAL BLADE TRAP SHEARS

Convert your conventional blanking line into a trap shear line by using one of **Sesco Products Group's Dual Blade Trap Shears**. Within minutes two pivoting sub-dies are positioned to produce rectangular and trapezoidal shaped blanks.



## STANDARD FEATURES

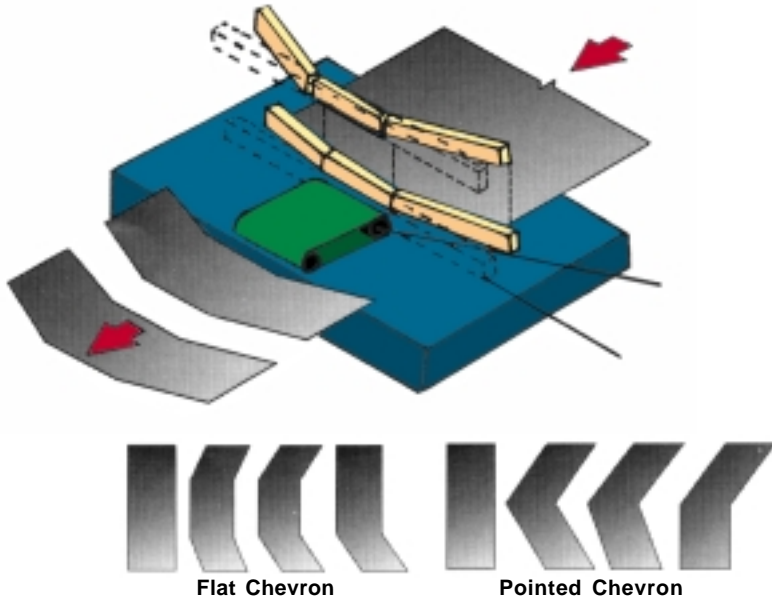
- Each press stroke produces **TWO** symmetrically opposed blanks.
- Hardened trim steels have 4 cutting edges for easy sharpening.
- Wear surfaces feature lube-less bearings for low maintenance.
- Sub-dies are designed as "Bump Dies" (upper not attached to the press ram.)
- Coil support rollers are uniquely positionable to accommodate angle and width of material set-ups.
- Angle changes are made in minutes.

## AVAILABLE OPTIONS

- Angle adjustments can be automated with a variety of drive packages.
- Coil support rollers can be designed for self adjustment.
- Motor driven stock guide for automated set-up adjustments.
- Exit conveyors can be designed to accommodate your existing system.
- Bow-tie shear promotes self-centering.
- Self-centering adjustable stock guide, for set-up purposes, centers all coil widths.
- Power clamping.

# SPG ADJUSTABLE CHEVRON SHEARS

Create a variety of blank shapes with one of **Sesco Product Group's Adjustable Chevron Shears**. Two or three connected sub-dies can be rotated in minutes to produce the following blank shapes from one of these standard shears.



## STANDARD FEATURES

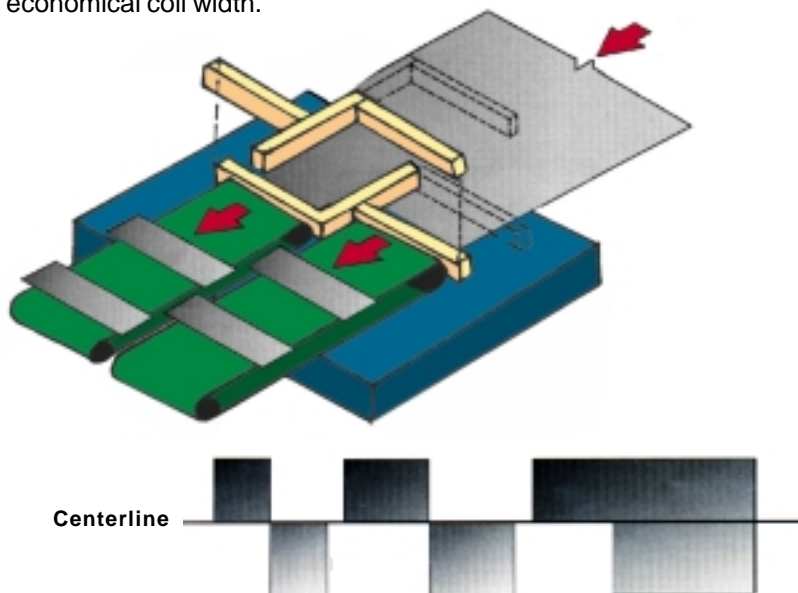
- Pointed Chevron Shears have up to 20° angular adjustment.
- Positive locking power clamps hold adjustable sub-dies in place.
- Flat Chevron Shears have up to 30° angular adjustment.
- Hardened trim steels have **two** cutting edges.
- Angle adjustments are made manually with hand wheels.

## AVAILABLE OPTIONS

- Adjustments can be motor driven for an automated system.
- Upper shoe can be designed as a "Bump-Die" (unattached to the press ram).
- An exit conveyor can be designed for your system.
- Self-centering adjustable stock guide, for set-up purposes, centers all coil widths.
- Power Clamping.

# SPG ADJUSTABLE CHEVRON SHEARS

From one coil, this unique shearing tool splits and cuts two rectangular shaped blanks per press stroke with two independent cut-off blades, one stationary the other adjustable, for various part pitches at any coil width. **Sesco Products Group's Adjustable Chevron Shears** enable you to double your production rate with a more economical coil width.



## STANDARD FEATURES

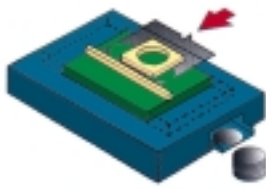
- Two blanks are produced per press stroke.
- Pitch is adjustable for any part.
- Hardened trim steels have **4** cutting edges for easy sharpening.
- Positive locking clamps lock adjustable blades in place.
- Pitch adjustment can be made in **2-4** minutes.

## AVAILABLE OPTIONS

- Adjustments can be motor driven for a totally automated system.
- Belt driven exit conveyors can be mounted on tool for stacker interface.
- Self-centering adjustable stock guide, for set-up purposes, centers all coil widths.
- Upper shoe can be designed as a "Bump-Die" (unattached to the press ram).
- Offset adjustment  $\pm$  from centerline enables dissimilar width blanks to be cut.
- Power Clamping.

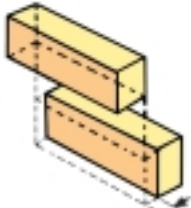
# OTHER SHEARING TOOLS, OPTIONS & ACCESSORIES:

## 3-OUT BLANK SHUTTLE TOOL



**Universal Three Out Shuttle Tool** punches out a variety of blank diameters with one insert. A master die-set shuttles across the coil to pre-determined positions to produce round blanks forming a three out circle pattern. This tool is excellent for low volume jobs requiring round or profile nested blanks. The three out pattern minimizes scrap.

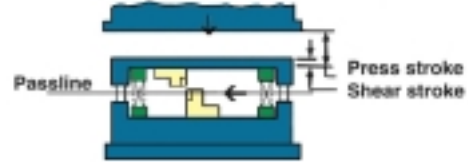
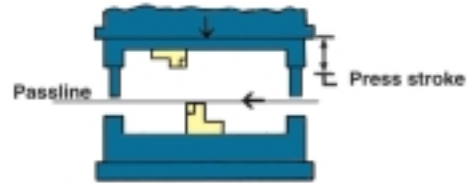
## VARIABLE GAUGE SHEARS



Adjustable

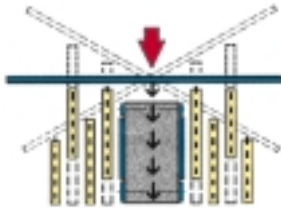
**Variable Gauge Shear** cuts a variety of metal thicknesses by adjusting the gap clearance between the upper and lower trim steels. Adjustments are made in minutes via wedge and screw arrangements including set-up blocks. Trim steels have four cutting edges. Options include power clamps and motorized adjustments.

## BUMP VS. CONVENTIONAL DIES



**Bump-Die Feature** requires no clamping of upper shoe to ram of press during operation. This reduces die-set time and maximizes run speeds depending on tool type. Conventional tools are limited only by equipment capabilities.

## BLANK EJECT CONVEYORS



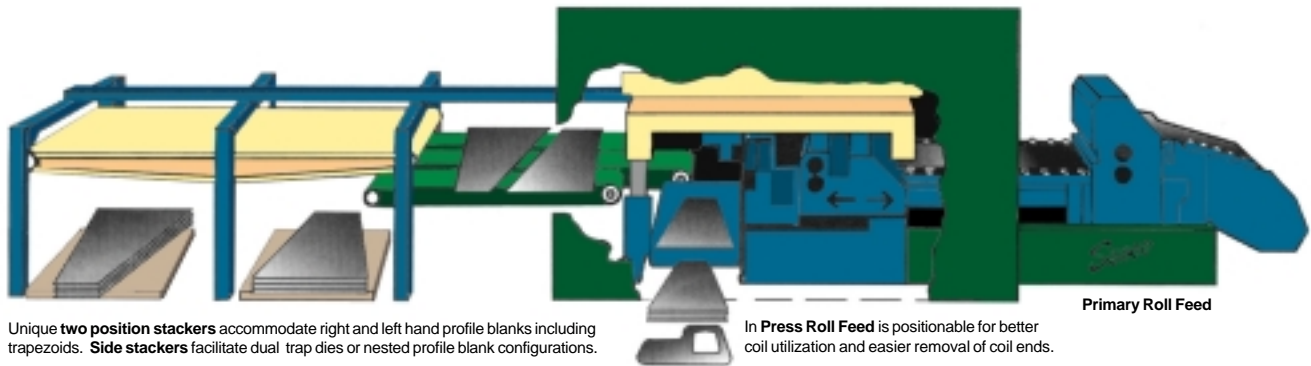
**Blank Eject Conveyors** are custom designed for each tool and can include belt conveyors with magnetic beds and idler pulleys. Skate conveyors are available with non-marking rollers and are self-adjusting with tool steel adjustments.

## BOW-TIE SHEAR

**Bow-Tie Shears** reduce overall die height and press stroke travel while promoting self-centering by shearing from both edges toward the center compared to a single rake angle shearing from one edge only.



## COMPLETE FEED/SHEAR/STACK ARRANGEMENTS



Unique **two position stackers** accommodate right and left hand profile blanks including trapezoids. **Side stackers** facilitate dual trap dies or nested profile blank configurations.

In **Press Roll Feed** is positionable for better coil utilization and easier removal of coil ends.

Sesco Products Group can design and build a variety of adjustable shearing tools to fit your specific needs. If the tool you are looking for is not outlined in this brochure, please contact us at **810-979-4400** and we will investigate the feasibility of building a tool for your application.

Sesco Products Group is a full service flat metal coil processing manufacturer and can also provide you with complete cut-to-length, progressive feed and blanking lines. Please contact us at **810-979-4400** for our full line of coil processing ideas catalog.



Press Equipment Corporation



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