



EV PRESS BRAKES • AB PRESS BRAKES • **SHEARS** • PRESSES



GUILLOTINE SHEARS



PROCESS LINE SHEARS



CONVENTIONAL MODEL AB BRAKES



Y1-Y2 MODEL EV PRECISION BRAKES



4 COLUMN PRESS



C-FRAME PRESS



STRAIGHTENING PRESS



STRAIGHT SIDE PRESSES

# AS Guillotine Shears

Standard Industrial Corporation  
1410 Industrial Park Dr.  
Clarksdale, MS 38614  
**United States of America**

- The most precision shearing system available, made in the USA with unmatched warranty, service and parts availability.
- State of the art controls giving the ability to manage all aspects of shearing including gap adjustment, rake adjustment, stroke length, gauge depth, job programmability plus much more.
- Standard features include our unmatched 5 year parts/ 1 year CNC and 5 year limited onsite labor warranty.
- Off the shelf, non-proprietary components means no more over-priced, single source buying from one manufacturer.
- With service all over the United States and multiple parts sources all over the world, you will never again have to wonder where your support is coming from.



A66o bronze bearings guaranteed for 5 years based on 24 hour workday. These bearings easily last 15-20 years and the bronze material is always readily available.

80,000 P.S.I. Rated Steel Capacity.



Extremely heavy-duty hold downs. Fewer hold downs = less maintenance. Hold down pressure is adjustable for your sensitive material.



Incredibly strong gusseted table providing decades of reliable performance.



Extremely heavy-duty, precision tables designed to provide the least amount of deflection and to last generations.

# SIMPLE MATH

Standard Industrial 5 Year Parts Warranty is based on a 24 Hour workday which equals:

**43,800 HOURS OF WARRANTY**

Compared to a typical 1 year warranty we exceed them by:

**35,040 HOURS**

Compared to a 2 year parts warranty based on an 8 hour work day we exceed them by:

**37,960 HOURS**

NO OTHER SHEAR CAN MATCH OUR DEPENDABILITY **OR** OUR WARRANTY

Complete O.S.H.A. and ANSI B11.4 Compliance.



Shadow light for precise shearing line.

#### LIFETIME PARTS AVAILABILITY:

Every component on machine is available from your local suppliers giving you a lifetime of productivity and parts

Incredibly simple, easy to troubleshoot hydraulic system is fully covered by our 5 year warranty and is comprised of all readily available components.

# Guillotine Drive vs. Swingbeam/Rocker Arm Drive

Ask a professional fabricator and they will tell you there is no substitute for an American made, true guillotine drive system when shearing. Low quality, typically foreign made swingbeam / rocker arm style competitors attempt to compare themselves to a guillotine but all fail. No other shear design can compare when it comes to the power and precision delivered by the straight line cutting action of a Standard shear.

## 4 CRUCIAL FACTORS TO PROVIDE THE MOST PRECISE CUT

1. Strength of the drive system
2. Strength of the frame
3. Consistent angle of the upper blade to the work piece throughout the cut
4. A heavy duty, high tonnage hold down system to hold work piece

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## Guillotine

The most important factor in providing a precision cut is the manner in which the upper blade cuts through material from the beginning to the end of the cut. A Standard guillotine drive system ensures the upper blade comes down in a straight line because the linkage is driven from directly above the workpiece. Throughout the cut the relationship of the upper blade to the material never changes.

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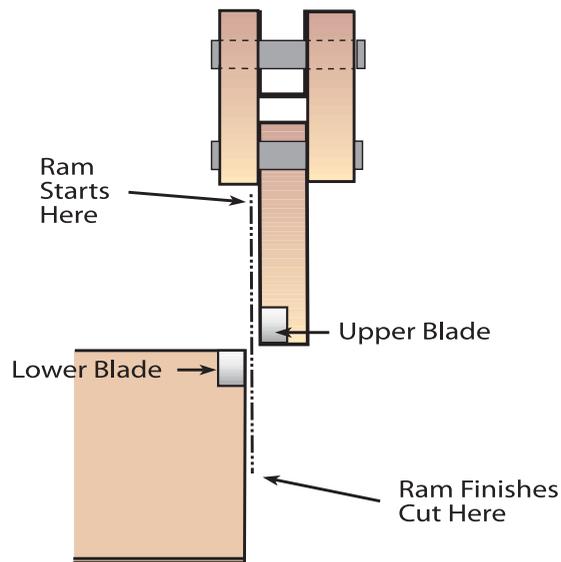
## Swingbeam / Rocker Arm

In direct opposition to this, the swingbeam / rocker arm system pivots from the side of the end frames and brings the ram down in an arc or "swing." This causes the relationship of the top blade to the work piece to change throughout the entire cut. Because the blade comes down in an arc, the cut is distorted throughout the cut.

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# Standard Industrial Guillotine Drive System

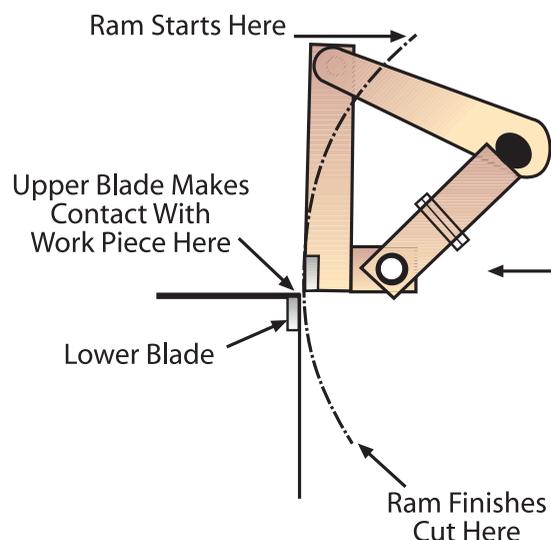
- The relationship of the top blade to the work piece never changes.
- Straight line cutting action.
- Due to the rigidity of our system you can shear a very wide range of material with a single blade setting.
- Because of the reliability of our guillotine drive, we are able to provide our unmatched 5 year parts warranty.



- Incredibly heavy duty gibbs control left to right and front to back forces to keep ram in a straight line giving the most precise cut.
- With our guillotine drive, the angle of the cut is consistent throughout the stroke.

# Swingbeam / Rocker Arm Drive System

- If the ram pivots from the end frames, an arc or "swing" is created throughout the stroke.
- Due to their weaker drive system, swingbeams must adjust their blade gap for virtually every material thickness.
- Because the swingbeams pivot points are fixed, they cannot have variable rake adjustments.



- The swing of the upper blade causes the angle or relationship of the top blade to the work piece to change throughout the stroke.
- This angle change causes distortion from the beginning to the end of the cut.
- As a result of their lighter weight construction and less rigid drive system, swingbeams typically only have a 1-2 year warranty.

# Standard Features



## Cybelec CNC control

- Automatically sets power blade gap\*\* and variable rake\*\* to desired material thickness (\*\*when included w/machine)
- Off the shelf control, available anywhere in the world
- Controls backgauge travel
- Programmable stroke length
- 200 programmable jobs with automatic actuation to next desired depth/job
- Programmable X-retract
- Simple Go-To functions with manual controls as well as CNC functions.
- Available with wireless programming through RF link

## 36" or 48" Travel EXTREMELY Heavy Duty Backgauge



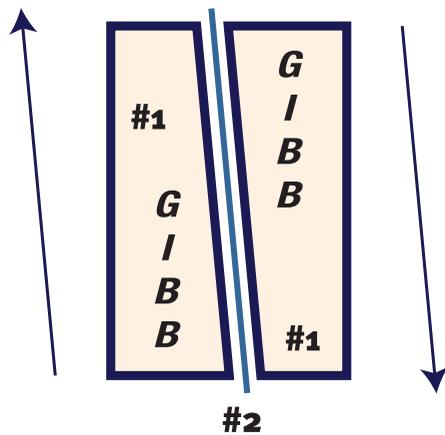
No other backgauge comes close to the rigidity coupled with the brute strength of the Standard Industrial shear backgauge. Perfectly built for precision and outright ability to take abuse.

- Equipped with a manual easy swingaway backstop
- Available with optional power swingaway backstop
- Clear area under backgauge for support equipment
- 5 years parts warranty
- Complete O.S.H.A. compliance
- The absolute heaviest backgauge on the market

# Infinitely Variable Quick-Change Blade Gap Adjustment

All Standard shears (except B series) come equipped with our positive drive, mechanical, quick-change blade gap adjustment. The AS250-6 up through the A375-12 models are equipped with our INFINITELY VARIABLE side adjustable manual system.

The 14' and longer and all 1/2" and larger shears are equipped with the INFINITELY VARIABLE front operated POWER blade gap system. Uniform and precision movement along machined tapered gibbs allows you to zero in on an exact precision cut.



On each end of the shear ram is our EXTREMELY HEAVY-DUTY Gibbing system. This positive mechanical system provides a smooth, uniform gap adjustment via precision machined tapered gibbs. Each gibb plate (#1) slides opposite of each other on oil impregnated nylon call Nylatron (#2). These gibbs also control the front to back and left to right forces of the ram travel delivering the most precision cut available on any shear.



MODEL AS500-10 WITH BALL TRANSFERS

Each shear comes standard with an incredibly heavy duty, precision machined table. Each machine is equipped with multiple large hand slots for easy part handling. Plus t-slots for setting stops and front gauging. Also included is a 4' squaring arm (2' off table on right side) with a precision inlaid scale.



Model AS250-10 (1/4" x 10')

## AS250 and AS375 shears up to 10'

- 4' squaring arm with embedded scale
- (2) hand slots in table
- (2) t-slots in table
- 36" travel, PLC controlled backgauge
- Manual, side adjustment, quick-change blade gap adjustment
- All AS135B and AS250B model shears do not come standard with manual quick-change blade gap adjustment but it is available optionally.



Model AS375-12 (3/8" x 12')

## AS250-12 through AS375-12

- 4' squaring arm with embedded scale
- (2) hand slots in table
- (2) t-slots in table
- 36" travel, PLC controlled backgauge
- Manual, side adjustment, quick-change blade gap adjustment.

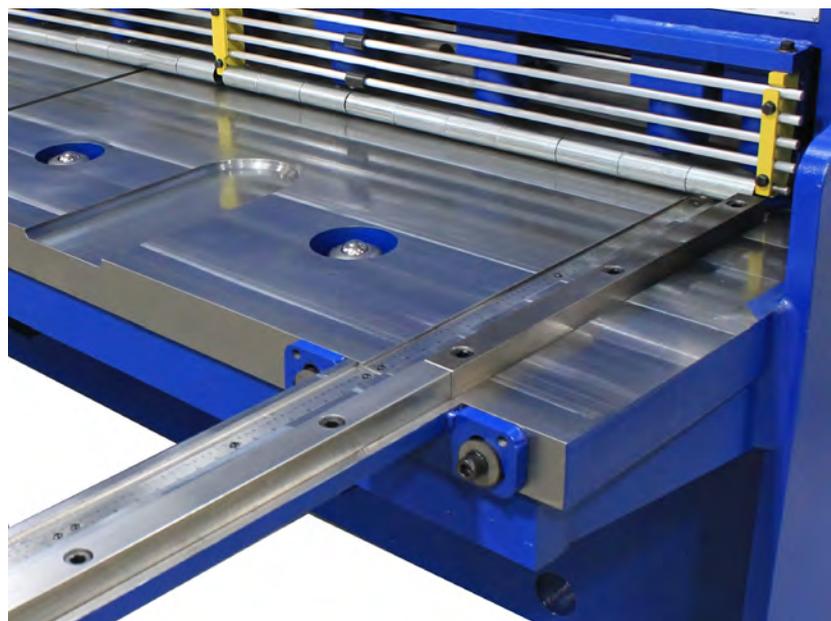


Model AS500-12 (1/2" x 12')

## AS250-14 through AS375-20 AS500-6 through AS500-20

- 4' squaring arm with embedded scale
- Hand slots in table
- (2) t-slots in table
- 36" travel, PLC controlled backgauge
- POWER, FRONT OPERATED INFINITELY ADJUSTABLE, quick-change blade gap adjustment.

All 1/2" and 14" and longer shears are equipped with heavy duty ball transfers mounted in the table.



## AS625-6 through AS1250-20

- 4' squaring arm with embedded scale
- Hand slots in table
- (2) t-slots in table
- 48" travel, PLC controlled backgauge
- POWER, FRONT OPERATED INFINITELY ADJUSTABLE, quick-change blade gap adjustment.
- Heavy duty ball transfers mounted in table.



Model AS625-12 (5/8" x 12')



Model AS500-12 (1/2" x 12')

## HOW IT WORKS



Full Even Tonnage Throughout Stroke  
and the Entire Length of the Shear

The single cylinder horizontal cylinder creates full tonnage via the massive bellcrank linkage system. Powered by just one cylinder, the bellcrank linkage supplies full tonnage the entire length of the shear. On each end of the shear ram is our incredibly heavy-duty and precision-machined tapered gibb system. This gibb system controls all front to back and left to right forces to provide the most precision cut available.

With only one cylinder you do not have to worry about “balancing” two cylinders and creating un-even tonnage and distortion in the cut. One cylinder creates full tonnage the entire cut instead of multiple cylinders creating various amounts of force.

# Optional Features

## Table Options

Squaring Arms – (4' on right hand side is standard) – Optional 8' (6' off table) or 12' (10' off table) or additional 4' (2' off table) available on either left (high end of rake) and/or right hand side of shear.

Swing Stops For Squaring Arms – Quick-change, flip up/down stops that slide the length of the squaring arm for front gauging, repetitive work.

Disappearing/Gravity Stops for T-Slots – Stops that allow work piece to slide over the top but not backwards. These stops slide in table t-slots or in the optional support arms.

Support Arms – Heavy duty, t-slotted arms mounted in line with standard table t-slots. Also able to slide left to right across front edge of shear table with optional t-slot. Available in 24", 36" and 48" and with optional embedded scales and mounted ball transfers.

T-Slot Across Front Edge of Table – Slot for sliding support arms left to right.

Ball Transfers in Table – Heavy duty, rolling transfers mounted in holes in table to aid with material handling. Standard on most machines except for ¼" and 3/8" shears that are 12' and shorter.

Additional T-Slots in Table – 2 are standard on all shears but more are available.



Additional Hand Slots in Table – 2 or 3 are standard depending on length but more are available.

Protractor – Used primarily for angle shearing, this unit can be mounted in the t-slots in the table.

Full Nylatron Table Cover – (picture left) Fully covered table for complete protection of material, typically used in conjunction with hold down cylinders with nylatron impact pads.

## Backgauge Options

48" travel in lieu of 36" – For ½" and smaller shears. All 5/8" and larger shears are equipped with a 48" travel gauge.

Automatic Power Swing-Away Backgauge – All shears are equipped with a manual swing-away backstop. This option comes with 48" of travel and automatically swings the entire backgauge up and out of the way for longer material pass through.

## High Speed Hydraulic System

All Shears are available with high speed systems. Contact factory for more information.

## Hold Down Cylinder Options

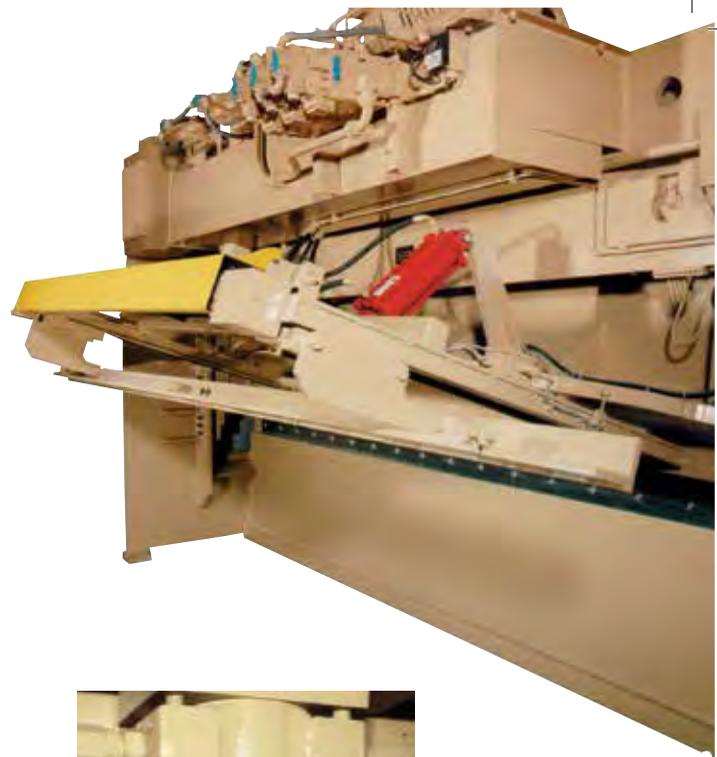
Impact Pads for Hold Down Cylinders – Heavy duty nylatron caps for all hold down cylinders to reduce marring of sensitive material.

Additional Hold Downs – Add an additional hold down on left hand side of shear for small piece work. Working on both sides of shear also prolongs blade life.

Independent Activation of Hold Downs – This option allows operator to actuate hold downs without actuating the ram/blade.

## Automatic Lubrication System

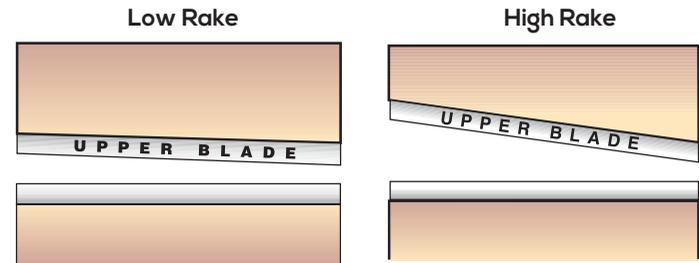
Air operated, timed system automatically brings grease to all lubrication points (except backgauge screws)



# Optional Features

## Productivity Options

Variable Rake Adjustment – When ordered this feature is controlled via the Cybele control. The rake is automatically set according to the material thickness the operator inputs into the control.



Variable rake is typically used for slitting purposes.

Infinitely Variable Power Blade Gap Adjustment – (standard on all 14' and longer and 1/2" and larger shears). When included on shear this feature is controlled via the Cybele control. The blade gap position is automatically set according to the material thickness the operator inputs into the control. Positive mechanical lead screws drive extremely heavy duty tapered gibbs providing the most precision cut available.

## Shear Blades

Shock resistant industry standard blades come with all shears. Optional high carbon – high chrome blades are available – recommended for customers who use stainless 75% or more.

## Oil Cooler

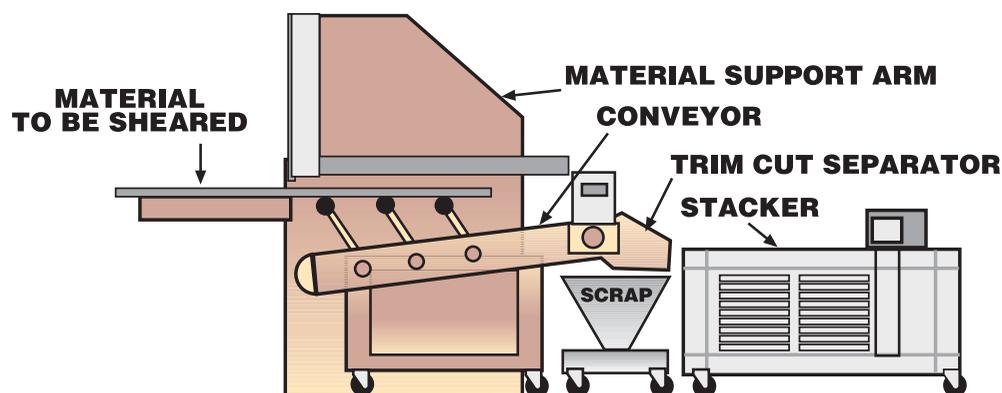
Air cooled heat reduction unit. Great for multiple shift operations and warmer climates. These coolers are the standard with all high speed systems.

## Material Handling Systems

Conveyors – Conveyance system used in conjunction with sheet support system used to remove material from under backgauge area.

Stacker – Final stage of Material Handling System. Stacks material conveyed from under shear.

Pneumatic Sheet Supports – Air actuated support system arms with rollers that rise and lower with the actuation of the ram. Used for material up to 1/2" plate.



## 7 Year Extended Warranty Service

Only available from Standard Industrial Corp. is our unmatched Extended Warranty that substantially lengthens the existing 5 year parts warranty but also provides a 5 year limited onsite labor warranty. This package includes:

- A 7 year parts warranty in lieu of standard 5 year parts warranty
- A 1 year PLC and CNC warranty
- A 5 year onsite limited labor warranty

In the event of a problem the customer will be required to help troubleshoot over the phone. If the problem cannot be diagnosed and troubleshooting has been exhausted, Standard will send in a technician at no charge to resolve the situation.

## Onsite Training

Onsite training is not included or required due to simplicity of our machinery however it is available if needed.

## Safety Systems

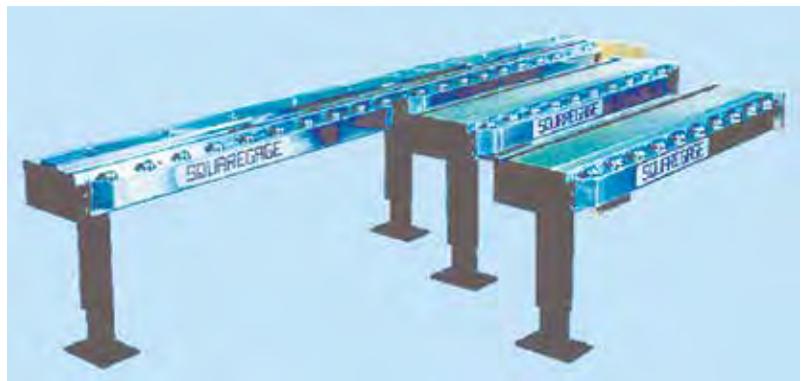
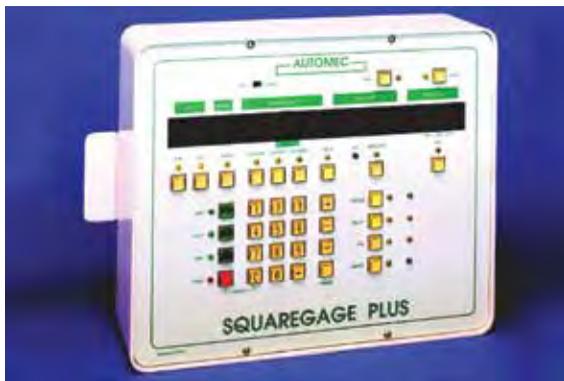
Light Curtain Safety Barriers – Infra-red light curtains that can be used in lieu of or in conjunction with standard OSHA approved awareness barrier. These curtains can also be placed on back of shear to enclose backgauge area.

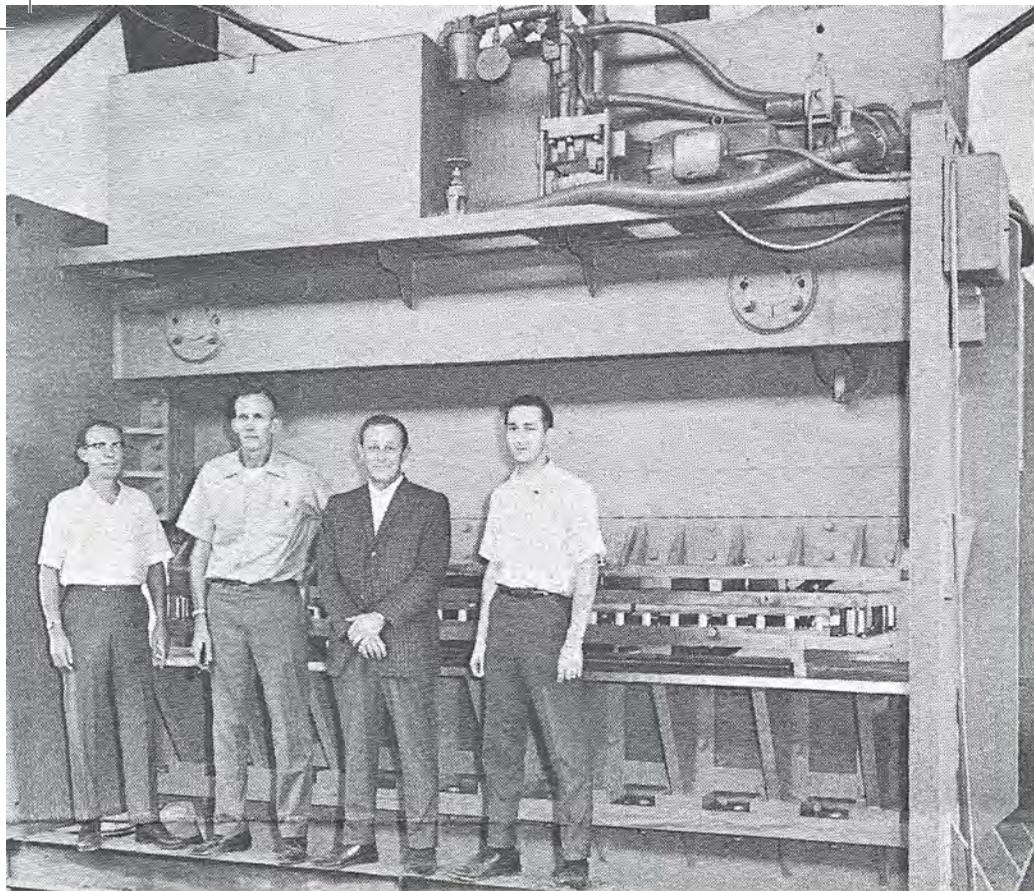
Physical Barriers/Cages – Physical barriers completely enclosing backgauge area. An interlocking gate that shuts the machine down when open is included.

Compliance Options – U.L. Listing and CSA compliance options are available.

## CNC Square Gauge Systems

State of the art, 100% U.S. Made CNC front gauging system for all Standard Industrial shears. These extremely heavy duty systems can be supplied with up to 6', 10' and 12' arms.





# A PROVEN U.S. COMPANY



First C-Frame



First Shear



First Four Column





**Thousands of machines and  
Generations of references  
across the U.S.**

**Professional, readily  
available service just  
a phone call away**

**Onsite training and  
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**UNMATCHED 5 YEAR WARRANTY  
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7 days a week, 365 days a year**



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