



**HACO**

**HACO**  
GSX 3006-R

**Hydraulic  
Guillotine Shears**  
**GSX SERIES**

# Hydraulics

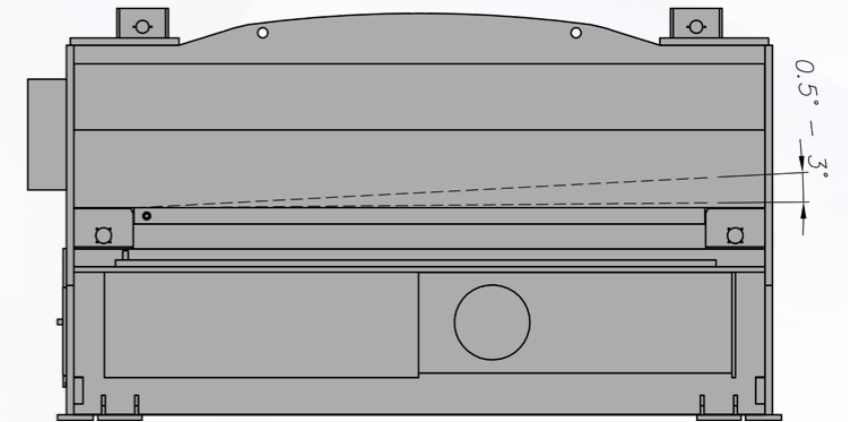
The hydraulic guillotine shears of the GSX range are driven by top mounted cylinders. Our long experience in the production of hydraulic guillotine shears guarantees a product of exceptional design and great efficiency.

The fully open rear side provides the operator the possibility of easy removal or adapting different conveying and stacking systems to the machine.

The all-welded interlocked construction makes the machine virtually indestructible. The GSX shears are well equipped and have as standard the SC100 T controller.



# Cutting angle/blade gap adjustment



## Hydraulics

The hydraulic system consists of a motor pump group and a multifunction manifold block for the control of the machine, easy access at the side of the machine. The connections to the cylinders, the hold downs and pumps are by means of flexible hoses. Two high pressure relief valves protect the hold downs and the cutting cycle from overload. Oversized oil tank for trouble free high production shearing.

The parallelism control of the ram is based on the so-called differential principle. Guiding of the beam by roller bearings on hardened ways.



## Hydraulics hold downs

The hydraulic hold downs work independently, which makes it possible to clamp plates of different lengths and thicknesses correctly. The hold downs operate independently from the shearing pressure. On the left and the right hand side of the machine the hold downs are arranged more closely to allow cutting small plates without any problems.



## CUTTING ANGLE ADJUSTMENT

Automatic setting as a function of the plate thickness with SC100 T control. This allows to cut thin material at a lesser angle, minimizing deformation of the sheared plate.

## BLADE GAP ADJUSTMENT

The blade clearance is set automatically by means of two hydraulic cylinders, as a function of the entered sheet thickness and material type.



Too small



Correct



Too big

# Standard features

## Standard features of GSX-range

- 2 Upper-driven push-down cylinders.
- All operator controls are conveniently located at the left-hand side of the machine in the immediate reach of the operator.
- Squaring arm of 1000 mm with scale, T-slot and disappearing stop, attached to the left hand side of the machine.
- Movable foot pedal control.
- Instructions and maintenance manual.
- Non-filled oil tank (because of environmental regulations).
- Service tools.
- Iron sheet guides with ball transfers.



## SC100 T Control

### Basic features

- LCD display (5.7") and Touch Screen.
- Memory capacity: Max. 500 programs with each max. 255 steps. Material list of max. 32 materials.
- Electro-hydraulic blade gap setting by means of 2 cylinders.
- Stroke control adjustment (cutting length).
- Automatic programmable retraction of the back gauge.
- Possibility of jog mode on back gauge.
- Backlash compensation, delayed sheet release.
- Mode selection Inch-Metric.
- Preset counter with 0-stop.
- USB interface.

### Programming Modes

- **Automatic**  
By entering the sheet thickness, the control automatically sets the blade gap and the cutting angle as a function of the sheet thickness. All parameters can be manually modified according to the actual data.
- **Manual**  
All cutting parameters such as material type, sheet thickness, cutting angle and blade gap can be programmed manually.

### Quick and easy:

The SC100 T fits all requirements for sheet cutting operations that require the highest accuracy and minimum time-loss. Creating a program requires only a few actions. The program parameters include: back gauge position, cutting time, sheet thickness, blade angle & blade gap setting. The blade gap adjustment is done electro-hydraulically.

**No specific training is required to work with this control!**

# Back gauges



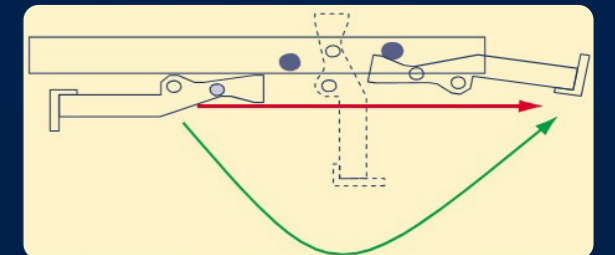
The back gauge consists of 2 rigid arms (containing guidings and ball screws) and the parallel adjustable back gauge bar. This assembly assures a precise positioning of the sheet. Programmable positioning with the SC100 T control. Digital read-out of the actual and preselected or programmed position. Swing-away back gauge enables cutting of sheets longer than the standard stroke length, driven on ball screws.

## Motorised back gauge (MOT)

Lateral movement front to back.  
Standard on all models.  
Powered back gauge, stroke 1000 mm

## Swing-away back gauge (SAB)

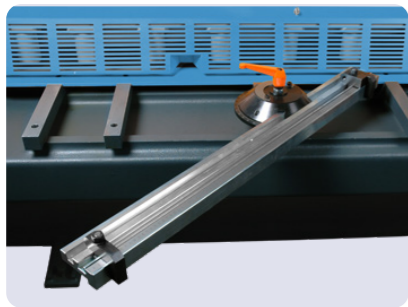
Powered back gauge, stroke 1000 mm.  
Available as option.  
When removing the shafts in both carriers and running the backstop backwards, the complete carrier will swing away to the back, enabling to cut longer sheets.



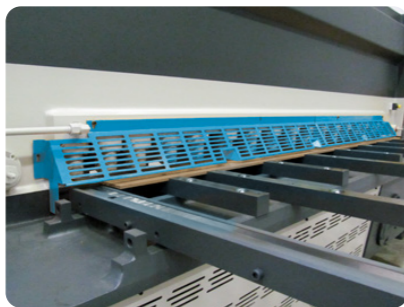
# Optional equipment

## Optionals

- Squaring arms and front support arms.
- Protractor for angle shearing.
- Hand Safety Guard with safety light curtain.
- Swing away back-gauge.
- Full table with ball transfers.
- Pendant control arm.
- Safety fences and light beams at the rear side of the machine. (standard for countries requiring the CE safety specifications)
- Soft padded hold downs.
- Hydraulic sheet support system with Sheet Back to Sender functionality (SBS).



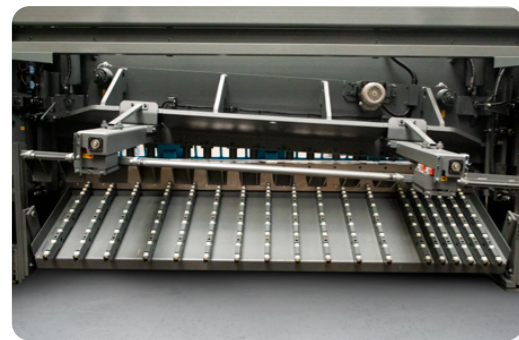
Protractor for angle shearing.



Squaring arms and front support arms with or without scale, T-slots and flip over stop. Lengths respectively from 1000 up to 6000 mm and from 500 to 3000 mm.



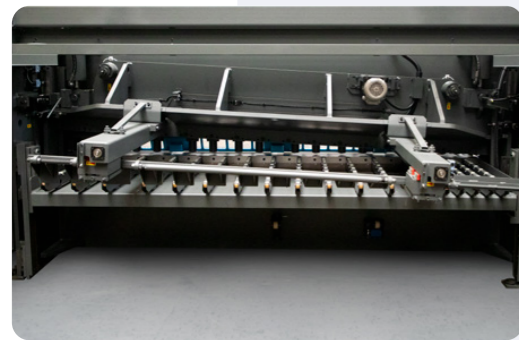
Full table ball transfers mounted in the iron table blocks, for easy feed-in of the sheets.



### Hydraulic sheet support system with Sheet Back to Sender (SBS)

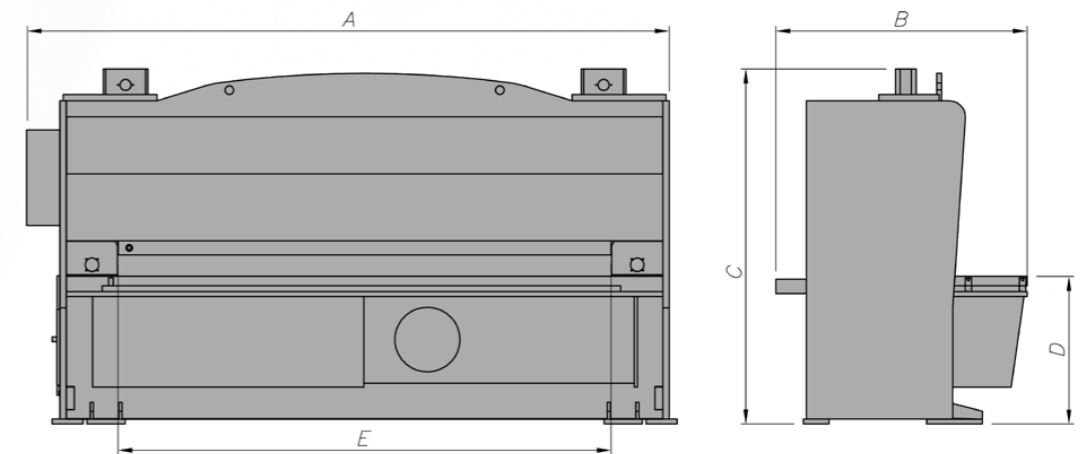
A specific feature of the GSX range is the complete free rear space between the frames, so the machine can be executed with different sheet support systems to improve production output.

The Hydraulic sheet support system follows the movement of the beam. Principally for thinner sheets, it assures the perfect gauging while entering the sheet into the machine. During the cutting action the sheet remains supported in order to avoid damage and deformation. When the cutting action is finished the plate slides down smoothly. The system can be switched off, e.g. for cutting thicker plates.



# Technical specifications GSX Range

	3006	4006	
Capacity mild steel (400N/m <sup>2</sup> )	6,5 mm	6,5 mm	
Cutting length	3050 mm	4050 mm	E
Cutting angle	0,5° - 2,5°	0,5° - 2,5°	
Number of plate clamps	18	22	
Number strokes / min. sheet with support OFF at min.- max. angle	20-10	10-6	
Number strokes / min. sheet with support ON at min. - max. angle	5-5	5-5	
Stroke back gauge MOT version	1000 mm	1000 mm	
Working height	770 mm	770 mm	D
Motor power	11 kW	11 kW	
Length	4340 mm	5340 mm	A
Width without CE safety fences	2550 mm	2590 mm	B
Width including CE safety fences	3900 mm	3940 mm	
Height	1900 mm	2090 mm	C
Approximate weight	6500 kg	10000 kg	





For impressive performances

**HACO NV**

Oeksenstraat 120  
8800 Roeselare  
Belgium  
+32 (0)51 26 52 00  
info@haco.com

**[WWW.HACO.COM](http://WWW.HACO.COM)**

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