

# **ERMAK**<sup>®</sup>

Sheet Metal Working Machinery



Hydraulic Variable Rake Guillotine Shear

**CNCHVR**



**CYBELEC DNC 60 G Controller**  
 Sequence repeat, sub-programs and chain-programming, 75 x 130 mm Black-White LCD graphic screen (visible area), 240 x 128 pixel automatic contrast adjustment, 16 input (24 or 32 optional), Easy cut page.

Standard



## GENERAL SPECIFICATION

ERMAK CNCHVR angle adjustable hydraulic guillotine shears are strong and easy to use machines which are able to cut any type of sheet with the best quality and speed.

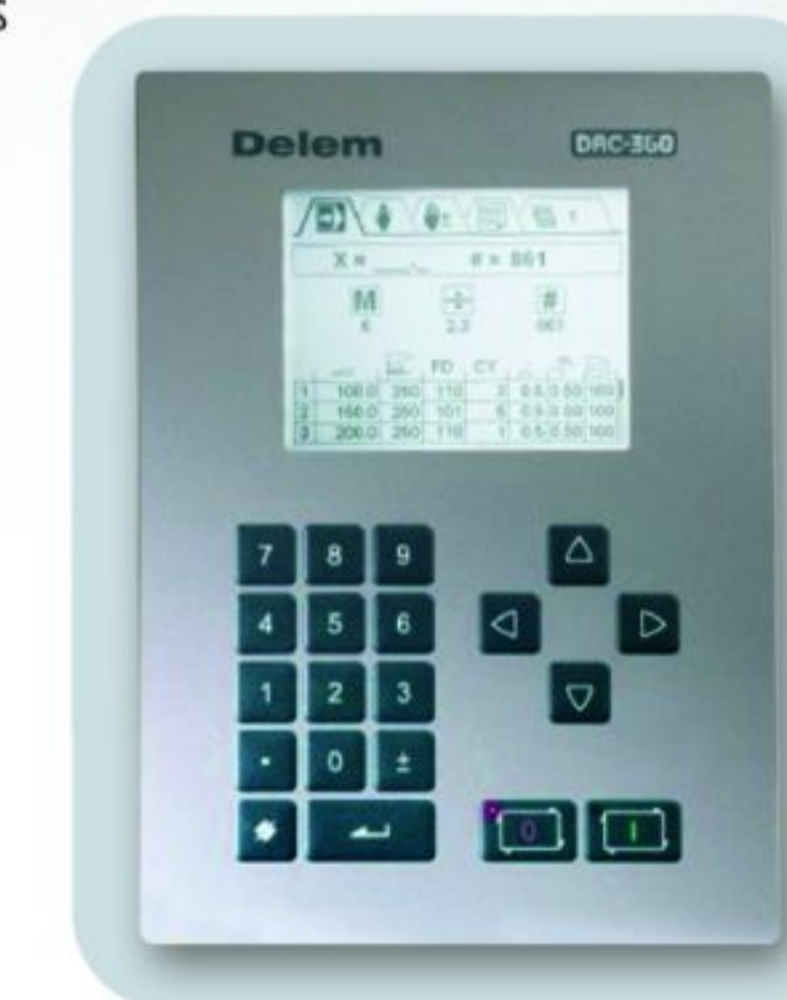
Machines could be programmed easily with the use of dialog programs on CYBELEC control units. When the type, thickness and length of the sheet is entered to the controller, machine calculates and adjusts blade gap adjustment, backgauge distance, cutting length and cutting angle automatically.

Cutting angle adjustment is done automatically according to sheet thickness, so during cutting thin sheets, the shortest stroke is used.

## DAC-360 Controller (Standart)

Compact and complete control for shearing machines. The DAC-360 provides a complete solution for shearing machines. In addition to the X axis position it offers automatic control of cutting angle, stroke length and gap. The numerical programming is user-friendly and guides the operator through the programming possibilities.

- Panel based housing
- Bright LCD screen
- Backgauge control
- Retract function
- Cutting angle control
- Cutting gap control
- Stroke length limitation
- Force control
- Manual movement of axes



## CYBELEC DNC 60G Controller

- Automatic calculation of blade gap, cutting angle and stroke depth according to programmed material and thickness,
- 5 pre-programmed material type,
- Stroke depth management by frequency distortion or potentiometer,
- Automatic back gauge re-adjustment according to the blade gap,
- Sequence repeat, sub-programs and chain-programming,
- Multi-processor designed using ASIC and SMD. This provides full entegration and high safety,
- Keyboard with ergonomic buttons,
- 75 x 130 mm Black-White LCD graphic screen (visible area), 240 x 128 pixel automatic contrast adjustment,
- Internal SRAM memory,
- FLASH memory, updating with RS232 as an optional. 2 x RS232 port (Optional),
- High speed (250 KHz) N2X axis with PID regulator and programmable resolution,
- Inch/mm, TON/TONS conversion,
- 16 input (24 or 32 optional),
- 16 output (24 or 32 optional),
- Easy cut page.
- Flying cut
- On CNCHVR, blade gap adjustment, stroke adjustment and back gauge position is automatically adjusted from the DNC controller unit according to the sheet thickness. (Standard)

## COLLAPSIBLE FRONT COVER



For safety reasons, front side of the hold downs is closed with a protection cover and upon customers' request, 1 m. part on the left side of this cover could be opened. With the help of this system, angled or drawn line cuttings could be done easily and controllably.

## THROAT



With the help of 350 mm throat depth on standard models, it is possible to cut longer sheets than the standard cutting length, thus avoiding extra workmanship costs due to the longer sheets. Throat depth can be designed up to 500 mm upon request.

## LASER CUTTING LINE



With the help of laser cutting line, angled or drawn line cuttings could be done easily and controllably. (Optional)

## PNEUMATIC SYSTEM



Pneumatic sheet support system that provides the user an easy method of working, is an optional function to protect hanging of sheets down and to improve cutting precision during cutting of long and thin sheets.



## STANDARD EQUIPMENTS

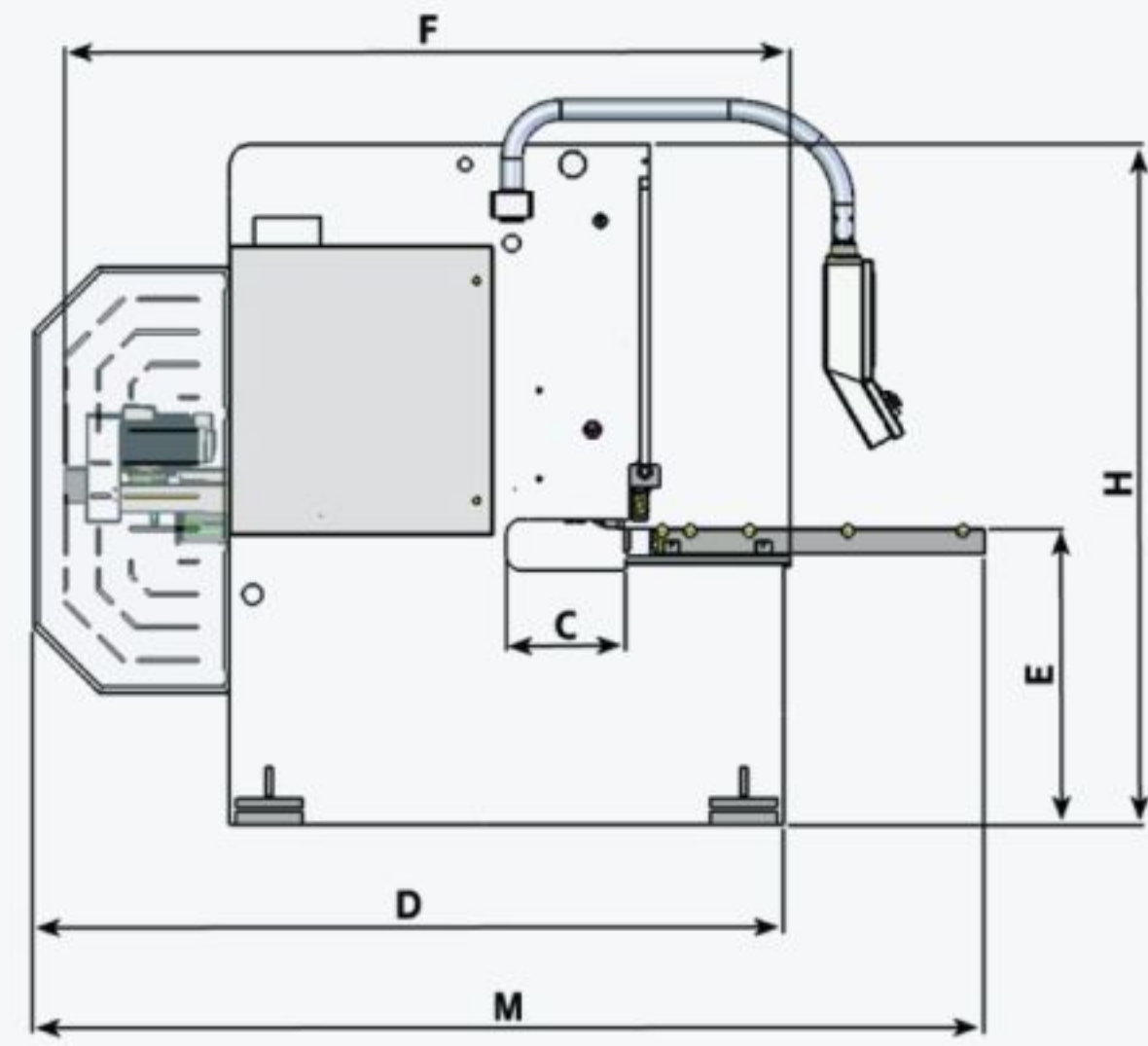
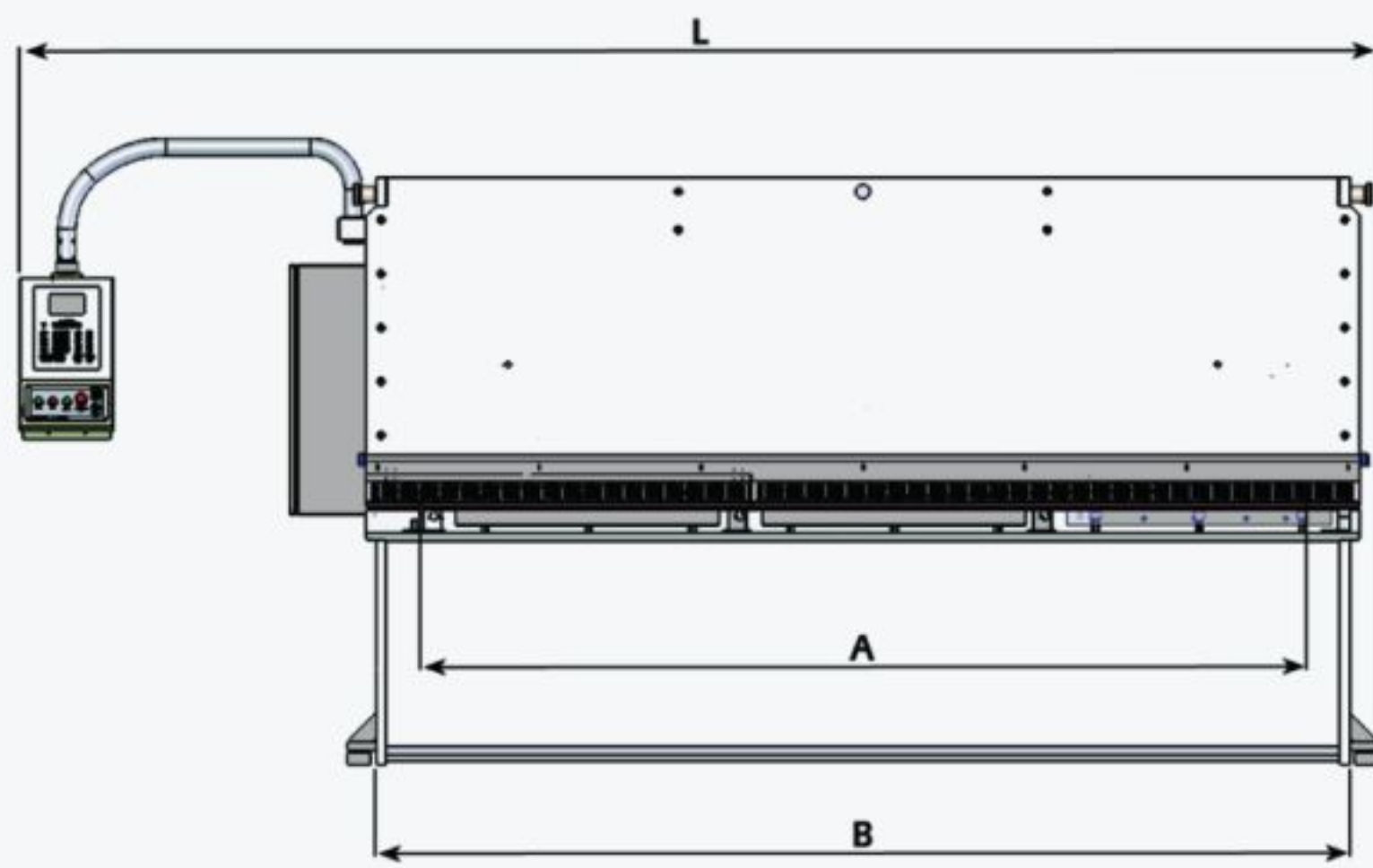
- Mono block, welded steel frame rigid to deflection moment and high tensile with ST44 A1 material.
- Fast and powerful back gauge with 1000mm distance, moving by ballscrewed shafts , with automatic swing away feature,
- Avoiding sheet sliding during cutting action, powerful hold downs with maximum performance,
- Roller bearings on the table to help placing sheets to machine easily,
- CYBELEC DNC 61 G cut Controller,
- Honed hydraulic cylinders and chrome coated pistons,
- High quality top and bottom blades,  
Bottom : 4  
Top : 2 cutting sides
- Hydraulic operated blade gap and angle adjusting system with CNC control,
- Bosch – Rexroth hydraulic system,
- High pressurized silent ATOS pump,
- Front support arms with ruler and flip-stop,
- Foot pedal available for single or continuous cutting,
- Cutting line illumination and shadow line,
- 350 mm throat depth,
- Side and rear guards,
- Automatic serial cutting, flying cut,
- Cnc controlled automatic angle adjustment stroke adjustment, hydraulic blade gap adjustment.

## OPTIONAL EQUIPMENTS

- Pneumatic sheet support system,
- Angular front gauge,
- 500 mm throat depth,
- Oil coolant,
- Laser cutting line,
- Finger protective light curtain, (Category 4)
- Longer front arms or squaring arm,
- Automatic stacking system,
- Dynamic backgauge with acservo motors,
- X1, X2 backgauge for the angular cutting,
- Stainless steel cutter



**TECHNICAL DIMENSIONS**



All specs are subject to change without notice

TYPES	CUTTING LENGTH	CUTTING CAPACITY (45 kg/mm <sup>2</sup> )	CUTTING CAPACITY (70 kg/mm <sup>2</sup> )	CUTTING ANGLE	STROKE PER MINUTE	NUMBER OF HOLD DOWNS	PRESSURE	MAIN MOTOR	BACKGAUGE MOTOR	BACKGAUGE TRAVEL	OIL CAPACITY	BLADE GAP ADJUSTMENT (min-max)	BACKGAUGE SPEED	NUMBER OF SHEET SUPPORT ARMS	TABLE LENGTH	THROAT DEPTH	MACHINE WIDTH	TABLE HEIGHT	TRANSPORT WIDTH	LENGTH	WIDTH	HEIGHT	WEIGHT	
	A			(°)	1/min.	Amount	ton	kw	kw	mm	Lt.	mm	mm/sec	Amount	B	C	D	E	F	L	M	H	kg	
	mm	mm	mm												mm	mm	Ops. (mm)	mm	mm	mm	mm	mm	mm	kg
CNC HVR 3100 - 6	3100	6	4	0.5 - 1.5	16 - 24	14	12	11	0.75	1000	150	0.05 - 0.8	110	2	3500	350	500	2315	900	2200	4980	2900	2225	8300
CNC HVR 3100 - 10	3100	10	6	0.5 - 2	12 - 22	14	24	22	1.1	1000	260	0.05 - 1.3	110	2	3640	350	500	2425	900	2265	5100	3000	2250	11200
CNC HVR 3100 - 13	3100	13	8	0.5 - 2	11 - 20	14	31	22	1.1	1000	310	0.05 - 1.5	110	2	3680	350	500	2570	900	2315	5110	3100	2330	13450
CNC HVR 3100 - 16	3100	16	10	0.5 - 2.5	9 - 16	14	42	30	1.1	1000	500	0.05 - 1.9	110	2	3760	350	500	2700	900	2340	5210	3240	2450	18700
CNC HVR 3100 - 20	3100	20	13	0.5 - 2.5	7 - 13	14	54	37	1.1	1000	500	0.05 - 2.3	110	2	3800	350	500	2700	900	2355	5220	3240	2550	20700
CNC HVR 3100 - 25	3100	25	15	0.5 - 2.5	6 - 10	20	76	45	1.1	1000	800	0.05 - 3.0	110	2	3880	350	500	2725	1000	2430	5250	3240	2900	30200
CNC HVR 3100 - 30	3100	30	18	0.5 - 3	4 - 7	20	100	45	1.5	1000	800	0.05 - 4	110	2	3960	350	500	2750	1100	2430	5330	3240	2970	34800
CNC HVR 3100 - 35	3100	35	20	0.5 - 3	4 - 7	25	125	55	1.5	1000	800	0.05 - 4.5	110	2	4040	350	500	2840	1100	2500	5410	3400	3200	43500
CNC HVR 3100 - 40	3100	40	25	0.5 - 3	3 - 5	20	150	55	2	1000	1000	0.05 - 5.5	110	2	4200	350	500	2950	1150	2600	5600	3500	3410	52100
CNC HVR 4100 - 6	4100	6	4	0.5 - 1.5	14 - 22	18	15	11	0.75	1000	150	0.05 - 0.8	110	3	4500	350	500	2315	950	2200	6000	2900	2320	13100
CNC HVR 4100 - 10	4100	10	6	0.5 - 2	10 - 17	18	28	22	1.1	1000	260	0.05 - 1.3	110	3	4640	350	500	2580	1000	2270	6100	3125	2460	17000
CNC HVR 4100 - 13	4100	13	8	0.5 - 2	9 - 15	18	40	22	1.1	1000	310	0.05 - 1.5	110	3	4680	350	500	2700	1000	2325	6120	3240	2600	20000
CNC HVR 4100 - 16	4100	16	10	0.5 - 2.5	7 - 13	18	52	30	1.1	1000	500	0.05 - 1.9	110	3	4760	350	500	2700	1000	2340	6220	3240	2700	26500
CNC HVR 4100 - 20	4100	20	13	0.5 - 2.5	6 - 11	18	67	37	1.1	1000	500	0.05 - 2.3	110	3	4800	350	500	2700	1000	2355	6220	3270	2700	31000
CNC HVR 4100 - 25	4100	25	15	0.5 - 2.5	5 - 9	25	88	45	1.1	1000	800	0.05 - 3.0	110	3	4880	350	500	2725	1100	2430	6270	3240	3215	42000
CNC HVR 4100 - 30	4100	30	18	0.5 - 3	3 - 5	25	120	45	1.5	1000	800	0.05 - 4	110	3	4960	350	500	2750	1150	2430	6350	3240	3320	48300
CNC HVR 4100 - 35	4100	35	20	0.5 - 3	3 - 5	30	145	55	1.5	1000	800	0.05 - 4.5	110	3	5040	350	500	2850	1150	2500	6430	3400	3580	60400
CNC HVR 4100 - 40	4100	40	25	0.5 - 3	2.5 - 4	25	170	55	2	1000	1000	0.05 - 5.5	110	3	5200	350	500	2950	1150	2600	6600	3500	3815	72500
CNC HVR 6100 - 6	6100	6	4	0.5 - 1.5	9 - 15	26	20	18.5	1.1	1000	260	0.05 - 0.8	110	5	6600	350	500	2375	1000	2285	8250	2950	2725	25750
CNC HVR 6100 - 10	6100	10	6	0.5 - 2	8 - 13	26	44	22	1.1	1000	260	0.05 - 1.3	110	5	6680	350	500	2375	1100	2285	8265	2950	2725	28800
CNC HVR 6100 - 13	6100	13	8	0.5 - 2	6 - 11	26	60	22	1.1	1000	310	0.05 - 1.5	110	5	6720	350	500	2535	1100	2330	8365	3050	2825	32300
CNC HVR 6100 - 16	6100	16	10	0.5 - 2.5	5 - 9	26	76	30	1.1	1000	500	0.05 - 1.9	110	5	6820	350	500	2700	1100	2350	8400	3240	2995	41100
CNC HVR 6100 - 20	6100	20	13	0.5 - 2.5	4 - 7	26	96	37	1.1	1000	500	0.05 - 2.3	110	5	6940	350	500	2730	1100	2375	8415	3210	3120	55600
CNC HVR 6100 - 25	6100	25	15	0.5 - 2.5	3 - 5	36	123	45	1.1	1000	800	0.05 - 3.0	110	5	7020	350	500	2730	1200	2480	8570	3185	3390	68500
CNC HVR 6100 - 30	6100	30	18	0.5 - 3	2 - 3	36	160	45	1.5	1000	800	0.05 - 4	110	5	7060	350	500	2750	1200	2480	8615	3185	3470	83800
CNC HVR 6100 - 35	6100	35	20	0.5 - 3	2 - 3	40	180	55	1.5	1000	800	0.05 - 4.5	110	5	7140	350	500	2850	1200	2600	8695	3400	3730	98500
CNC HVR 6100 - 40	6100	40	25	0.5 - 3	2 - 3	36	210	55	2	1000	1000	0.05 - 5.5	110	5	7300	350	500	2950	1200	2800	8915	3500	3980	118200

Consult to our company for special dimension and capacity applied machines.



**ERMAKSAN MACHINERY**

Yeni Yalova Yolu 15. Km Ovaakça BURSA/TURKEY Tel : +90.224 - 267 19 00 (Pbx) Fax : +90.224 - 267 14 40  
[http : //www.ermaksan.com.tr](http://www.ermaksan.com.tr) e-mail: [ermaksan@ermaksan.com.tr](mailto:ermaksan@ermaksan.com.tr)