

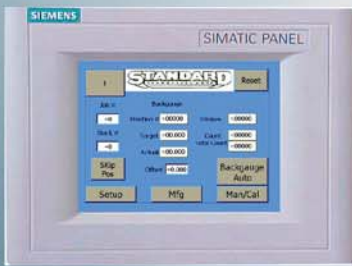
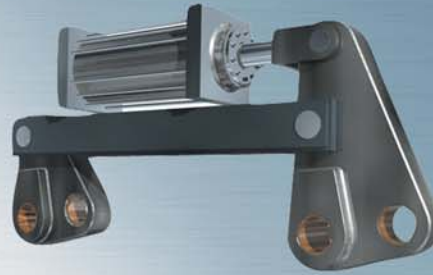


# STANDARD

INDUSTRIAL CORP



**100% MADE IN THE U.S.A.**



**5 YEAR WARRANTY**

# GUILLOTINE SHEARS

# Why It Is Important For You To Buy A Standard Industrial Shear

- Standard Industrial is one of the last manufacturers that is 100% U.S. Owned and Operated
- 5 year parts and limited labor warranty
- Unheard of Factory and Dealer Service and Support

**AS500-10** (1/2" x 10' A36 capacity - 3/8" x 10' stainless capacity)

- The most heavy-duty shear on the market today

- Typical 30+ Year Lifetime

- A lifetime of readily available parts and service

- The most powerful hydraulic system on the market allowing the most hold-down and shearing tonnage available on any shear



- 100% true Guillotine Drive System

- State-of-the-art PLC touch-screen control with simple go-to and multi-level job programmability

- Simple, easy to operate shear controls on front of shear with 3 position footswitch

- Fully O.S.H.A. compliant operation as well as ANSI B11.4 compliant

- Extraordinarily heavy-duty table allowing the least amount of deflection.



- Hand slots, T-slots and a 4' squaring arm are standard on all shears - Other features are also standard depending on model and size.

- Components are readily available from your local suppliers and are covered by our 5 year warranty.



- All parts will be readily available for a lifetime from anywhere in the USA.

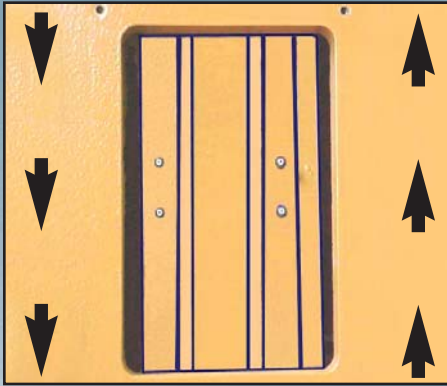
- Massive unitized frame in a single fabrication. Strongest design available on the market.



- Frame consists of closed end housings, (2) upper cross members, a lower beam and flat table.

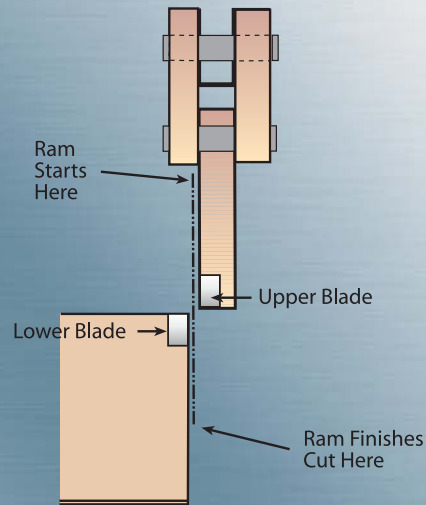
# 100% American Innovation

- Positive mechanical tapered gibb blade gap adjustment



- Gibbs slide uniformly up or down
- Both manual and powered blade gap systems available

- Guillotine drive system



- Straight line cutting action
- The absolute most precise shear design in the world

- A real 5 year parts warranty for a real machine
- 80,000 PSI steel capacity
- A real service department giving you direct access to the manufacturer of your machine
- 40 years of machine building experience and generations of customer references
- Incredibly high re-sell value due to readily available parts and 100% U.S. made
- Complete owners manual with all hydraulic and electric schematics
- Complete list of all original manufacturers names and part numbers so you can always find replacement parts

## Single Cylinder Hydra-Mechanical Drive System



- Full shearing capacity from one end of the shear to the other
- Each A660 bronze bearing is guaranteed for 5 years
- Each bearing is designed to withstand **6 TIMES** total tonnage of shear
- Relationship/Angle of top blade to work piece **NEVER** changes during cut.

## Manifold Based Hydraulic System

- Incredibly simple to troubleshoot
- 5 Year parts coverage
- Fewer Hoses, Tubing, Fittings Provides Far LESS Maintenance And Downtime
- Under 3,000 P.S.I. system to provide long life for all components
- Allows operator to shear a tremendous range of material thickness' with a single blade gap setting



# Guillotine Shears

vs.

# Swingbeam Shears

In today's shear marketplace there are many type's of machines to choose from, but the main two drive systems are the guillotine and the swingbeam. The true guillotine drive system, like that of our model AS and CS shears, has been the proven design of quality U.S. shear manufacturers for the better part of a century. No other design comes close to the precision provided by a guillotine drive.

Although a distant second in precision and design quality, the swingbeam shear has been a favorite of manufacturers from overseas and from just north of our border largely due to the fact that it is a less expensive way to build a shear. The swingbeam is very effective for 10 gauge and smaller material, but for 1/4" plate and larger applications the swingbeam is outgunned by the guillotine in every way. For this reason many swingbeam manufacturers try to pass their shears off as guillotine drives.

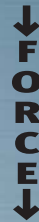
## 4 crucial factors to provide the most precise cut:

- (# 1) Strength of the drive system
- (# 2) Strength of the frame
- (# 3) Consistent angle of the upper blade to the work piece throughout cut
- (# 4) A heavy-duty high tonnage hold-down system to hold the 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 beginning to the end of the cut. A Standard Industrial guillotine drive system insures that the upper blade comes down in a straight line because the linkage is driven from directly above the workpiece. From the beginning of the cut all the way to the end of the cut, the relationship of the upper blade to the material never changes.



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## Swingbeam

In direct opposition to this, a swingbeam pivots from the side of the end frames and brings the ram down in an arc or a "swing" (like a welding helmet coming down over your face). 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 from the beginning all the way through the cut.



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Here are features of both designs to determine if the shear you are being offered is either a guillotine or a swingbeam.

### Characteristics of Each Drive System

#### **Guillotine**

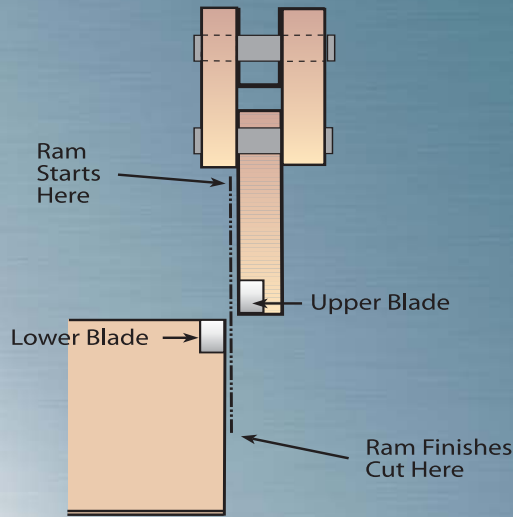
- Either single cylinder or dual cylinder
- Ram is driven from the top down and is not pivoted from the end frame
- Can have a infinitely variable blade gap adjustment
- Due to it's down-acting ram, it is capable of a variable rake adjustment because it pivots from the end frames

#### **Swingbeam**

- Typically dual cylinder
- Typically ram pivots from the side of the shear
- Is incapable of a variable rake

# Standard Industrial Guillotine Drive System

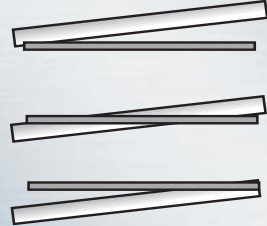
- The relationship of the top blade to the work piece never changes.
- Straight line cutting action
- Due to the rigidity of our system you can shear a very wide range of material with a single blade setting.
- Because of the reliability of our guillotine drive, we are able to provide our unmatched 5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

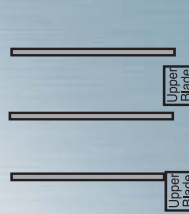
## Guillotine Shearing Cycle

Operator's Front View



Beginning Of Cut  
Middle Of Cut  
End Of Cut

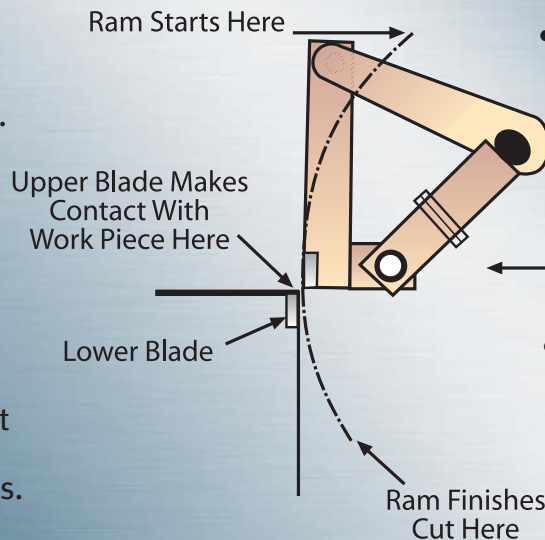
Side View



Angle of top blade to work piece remains constant

# Swingbeam Drive System

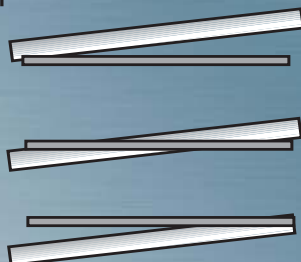
- If the ram pivots from the end frames, an arc or "swing" is created throughout the stroke.
- Due to their weaker drive system, swingbeams must adjust their blade gap for virtually every material thickness.
- Because the swingbeams pivot points are fixed, they cannot have variable rake adjustments.



- 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.

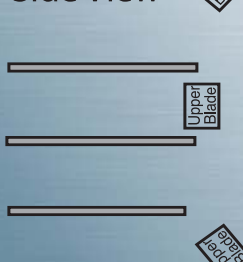
## Swingbeam Shearing Cycle

Operator's Front View



Beginning Of Cut  
Middle Of Cut  
End Of Cut

Side View



Angle of top blade to work piece changes throughout the entire cut.

# Standard Features For M

There are few pieces of equipment in any plant that are depended on as much as a shear. From the smallest job shop to the largest state of the art manufacturing facility, a reliable, precise shear is a key part of their success. Our 100% American made, guillotine drive shear has proven itself over the last forty years to be that key in thousands of installations all over the world. The Standard Industrial shear gives something that most manufacturer's shears can't, the total satisfaction of knowing they purchased a machine from a company that was 100% owned, operated and manufactured completely in the U.S.A.

Over the last 20 years we have overwhelmed our customers and our competition by the uncompromising rigidity of our machinery. This rigidity coupled with our simplicity and trouble free operation has made us one of the top selling shear manufacturers in the world. In January 2000 we raised the bar even further by initiating an unheard of 5 year parts and limited labor warranty that drastically separated us from the competition and we haven't stopped there.

Whether you are a price conscious smaller facility changing jobs on an hourly basis or a 3 shift a day manufacturing facility that requires dependable machines with minimal downtime, the model AS or CS shears are exactly what you are looking for. Here are just some of the impressive standard features on both models of Standard Industrial shears.



- 4' squaring arm with scale
- Exceptional short and full length stroke speeds
- Shadow light for shearing line
- Full capacity throughout stroke
- 80,000 P.S.I. steel capacity
- Pendant mounted swing arm PLC display shows location of backstop and on screen programming instructions
- 100% true U.S. made guillotine drive system provides the ultimate straight line cutting
- (2) 4 edge medium chrome blades provide longest blade life
- Fully adjustable stroke via three position footswitch control and/or mechanical limit switches
- Large heavy duty hold down cylinders providing uncompromising hold on work piece—Fewer hold downs means fewer components to maintain

Although powerful, the hydraulic and electric systems are incredibly simple to keep downtime to a minimum. All components are made from U.S. suppliers and were designed from those manufacturers stock, which means you can buy parts for your Standard Industrial machines from the original manufacturer of the part, from your local suppliers or from us. This means you are not forced to buy specially made, overpriced "proprietary" components only from the manufacturer.

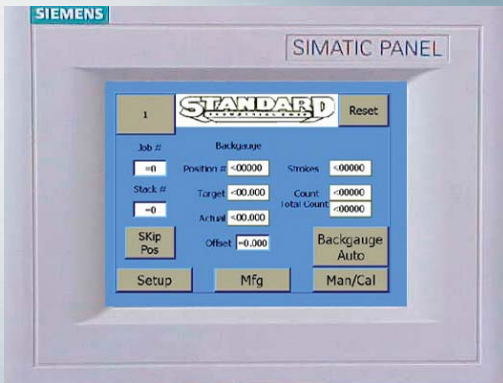
The hydraulic system is designed for quiet shockless operation to eliminate most needs for special foundation requirements. The shears also come standard with system overload protection to stop damage to the shear frame if the operator attempts to cut more than the machine's capacity.

All of the quality U.S. made shears manufactured over the last century have been of the guillotine design. The guillotine system uses ram slides (gibbs) which guide the upper beam and solidly contain the shearing forces. Our ram slides are located directly above the shearing area on the front and back of the shear ram above the shearing center line. This drive system location is what gives the guillotine its precision.

# Model AS and CS Shears

## PLC Touchscreen Control

The state of the art Touchscreen PLC control will allow your operators to shear your material in record time. Not only is this control extremely easy to use, but it provides you with all the features of shears that cost much more.



- Simple Go-To function
- 50 job programmability
- Stack two jobs for up to 100 memory variation
- 5 different cut lengths per job
- 999 strokes per job
- Auto-sequencing allows the gauge to automatically set up for the next cut
- Stack your jobs up to any number of strokes
- Stroke counter
- Inch/Metric conversion
- X-retract function allows you to program the distance the backstop retracts
- 2 Year PLC warranty
- Off the shelf, readily available parts
- Simple and fast electronic calibration
- Manual (push button) or Automatic (programmed) operation

## 36" Travel PLC Controlled Heavy-Duty Backgauge

Both models come standard with our incredibly heavy duty 36" travel (48" travel on all 5/8" and larger shears) PLC controlled backgauge. No other manufacturer comes remotely close to the strength and rigidity provided by this gauge. Built for precision and to take abuse, this gauging system comes standard with:

- A manual swing-away backstop (power swingaway is available on AS models)
- Clear area under back gauge for conveying/stacking/support equipment
- A shaft fitted with couplings to allow quick and easy end to end adjustment of the backstop
- (2) incredibly stout precision lead screws
- A lifetime of readily available parts from your local suppliers



## Fully-Loaded, Extremely Heavy-Duty Table/Bed

All model AS and CS shear tables come standard with:

- (2) T-slots machined front to back in the bed (for setting front stops)
- Hand slots machined in table to allow easy part handling
  - (2) hand slots on 10' shears
  - (3) hand slots on all 12' and longer shears
- Squaring bar with scale machined in table (right side)
- 4' squaring arm with scale on right hand side (low end of rake)
- OSHA compliant awareness barrier
- Shadow light for shearing line

## Standard Features On Model AS And CS Shears

- 5 Year parts and limited labor warranty
- 4' squaring arm with scale
- Complete manual with all original manufacturers name and part numbers
- 36" travel backgauge with swingaway backstop
- Hand slots in table
- Shadow light for shearing line
- T-slots in table
- 4 edge shock resistant blades
- Either manual or power blade gap adjustment (depending on model and size)
- Low pressure readily available off the shelf hydraulics and electrics with replaceable oil filter (oil not included)
- Pendant mounted swing arm PLC control
- Overload protection to prevent damage to shear frame
- High tonnage heavy duty hold down cylinders to hold work piece
- Adjustable hold down pressure
- Simple and versatile hydraulic and electric control
- Fully adjustable stroke length with full capacity throughout stroke
- Rigid all steel unitized frame
- All liquid tight components
- 120 volt electrical control system
- Electric disconnect switch and electric magnetic starter with overload protection
- Unitized high strength frame
- Guillotine straight line cutting action
- 80,000 p.s.i. capacity steel rating
- Blade relief angle
- Low friction, nylatron way/gibb surfaces
- Fixed rake angle (optional rake available on AS model)

# Model CS Shear

## Precision and Affordability

These days a U.S. manufacturer has to be as competitive as possible against other manufacturers both overseas and just over the border. The question is how to maintain U.S. quality and still give our customer's the best price we can.

When it comes to 1/4" and 3/8" shears in 10' and 12' lengths, the answer is our model CS hydramechanical guillotine drive shear. Using the same single cylinder drive system and extremely heavy construction as the AS, the model CS sets a new standard for precision and affordability. The CS shear takes all the advantages of our guillotine shear in a fully loaded, yet economical shear to compete against cheaper swingbeam and overseas shears.

The only difference between the AS and the CS shears is that we batch build the CS shears and limit the amount of options available on this model. This practice keeps our costs down allowing us to be more competitive against foreign machines. This gives you the quality of a true U.S. manufacturer at an affordable price.

### CS Shears have the following standard features:

- 4' squaring arm with scale
- (2) t-slots in the table
- Hand slots in table (2 for 10' and 3 for 12')
- Quick-change Manual blade gap adjustment
- 36" travel PLC controlled backgauge
- 5 year parts and limited labor warranty
- All standard features listed on page 7

Straightforward, simple adjustments



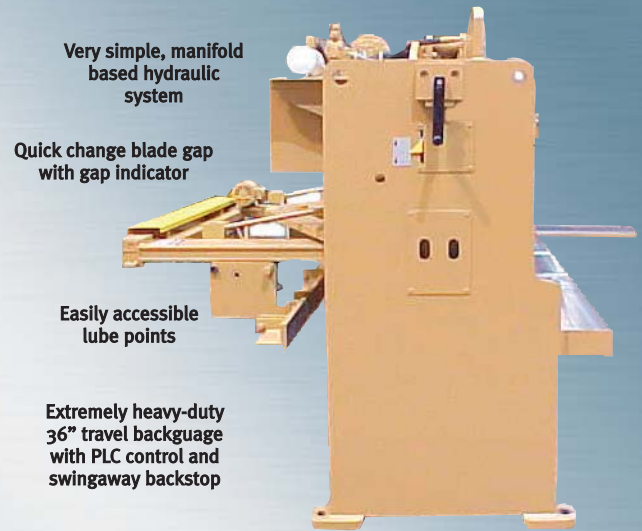
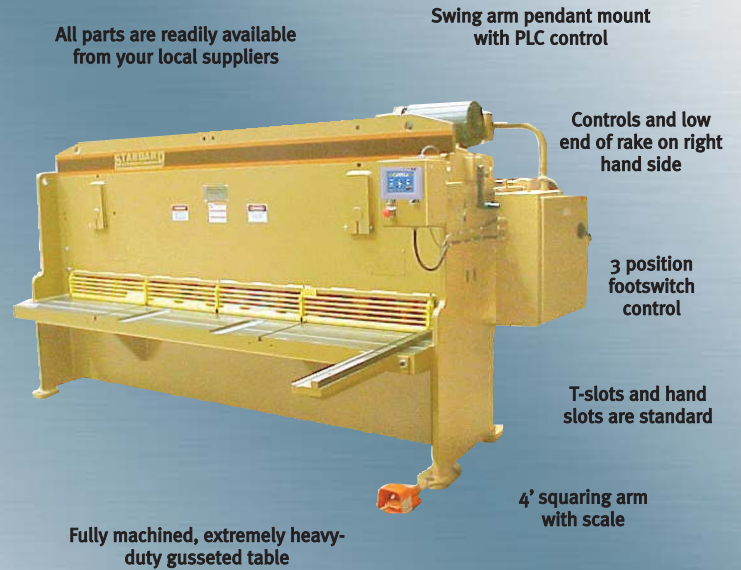
Easy to understand blade gap indicators



Positive mechanical precision tapered gibbs



The model CS shear comes standard with quick change infinitely variable, manual blade gap adjustments located at the sides of the shear to give you a wide range of shearing capacities. With positive mechanical, tapered gibbs plus substantial hold down pressure to hold the material in place and our precision guillotine drive system you will not find a better shearing system.



**CS shears come only in 1/4" and 3/8" capacities and only in 10' and 12' lengths**

### Available Options For Model CS Shears (other options will require the AS model)

- 8' or 12' squaring arm with scale (available on left side optionally-NOTE low end of rake on right side)
- Swing stop for squaring arm
- 24" t-slot support arms to match up with (2) t-slots in table
- Gravity stops for t-slots and/or t-slot support arms
- Impact pads for the hold downs for sensitive materials (may delay delivery)
- Protractor(s) for angle shearing
- Conveyors, Stackers and Sheet Support Systems
- T-slot bar across front edge of shear table to slide support arms left to right (may delay delivery)
- Hi-Carbon/Hi-Chrome blades in lieu of the standard shock resistant blades



# Model AS Shear

## Precision Custom Equipment Per Your Specifications

Although many improvements and upgrades have been instituted over the last 40 years, the model AS shear has the same tried and true guillotine drive system our management team first manufactured back in 1967. The AS has all the outstanding features of the CS (and more), plus we customize the AS to match our customer's specific needs. Like the CS, the base model AS shear comes standard with just about everything an operator needs, plus an extremely wide array of options.

The model AS shear is beneficial to all levels of production, especially to steel service centers and larger manufacturers that need a few more features than the CS can offer. Please review all the options in order to get the exact machine you need.



Optional 12' squaring arm with (2) swing stops and ball transfers mounted on arm

AS Shears are available from 1/4" x 6' up to 1 1/4" x 22' capacities.

- Optional High Speed Hydraulic Systems
  - Special Table Configurations
- Additional Hold Down Cylinders
- Optional 2 Position Power Rake Adjustment
- Optional paint color (single color with sample)
- Customized Support Arms and Squaring Arms
- Optional Power Swingaway Backgauge (manual swingaway is standard)
- Automatic Lubrication Systems
- Additional Hand Slots and T-Slots In Table
- Infinitely Variable Power Blade Gap Adjustment (standard on many AS shear models)
- Longer Travel Backgauges
- CNC Squaregauges/Frontgauges
- Special Controls
- Special Electrics
- Ball Transfers In Table (standard on many AS shear models)
- T-slots With Scales Embedded In Table

Model AS500-10 (1/2" x 10' A36 / 3/8" x 10' stainless capacity)



### Standard Features Breakdown On AS Shears

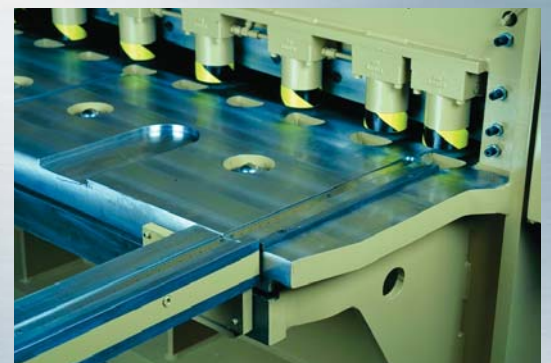
**AS250-8, AS250-10 and AS375-8, AS375-10** - 4' squaring arm with scale, (2) hand slots and (2) t-slots in table, manual quick change blade gap adjustment, 36" travel PLC controlled backgauge.

**AS250-12 and AS375-12** - 4' squaring arm with scale, (3) hand slots and (2) t-slots in table, manual quick change blade gap adjustment, 36" travel PLC controlled backgauge.

**AS250-14 through AS250-20 and AS375-14 through AS375-20** - 4' squaring arm with scale, (3) hand slots and (2) t-slots in table, Power quick change blade gap adjustment, 36" travel PLC controlled backgauge, Ball transfers in table.

**AS500-8 through AS500-20** - 4' squaring arm with scale, hand slots and t-slots in table, Power quick change blade gap adjustment, 36" travel PLC controlled backgauge, ball transfers in table.

**AS625-8 through AS1250-20** - 4' squaring arm with scale, Hand slots and T-slots in table, Power quick change blade gap adjustment, 48" travel PLC controlled backgauge, Ball transfers in table.

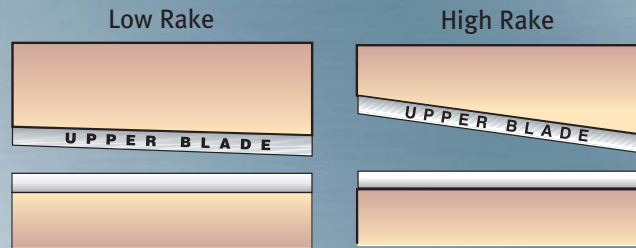


All 1/2" and larger and all 14' and longer shears have ball transfers as standard

# Model AS Options



Automatic Lubrication System



2 position power rake adjustment for slitting and other applications



48" travel power swing up backgauge (36" manual swingaway is standard)

## Available Options For A New Order Model AS Shear

**Squaring arms:** (1) 4' squaring arm with scale on right hand side is standard on all shears. Optional 4', 8' or 12' squaring arms are available on either the right or left hand side (low end of rake is always on right). Please note that the length of the squaring arm is measured from the blade and not the table (example: an 8' squaring arm is 6' off the table)

**Swing Stop For Squaring Arm:** Quick change, flip-up/down stops that slide the length of the squaring arm for front gauging repetitive work.

**Infinitely Variable Power Blade Gap Adjustment:** (standard on most AS shears—see standard features page for details) Precision push button blade gap control with mechanical pointer and scale located at front of shear showing exact location of blade gap. Positive mechanical lead screws drive machined tapered gibbs providing infinite adjustment.

**2 Position Power Rake Adjustment:** Gives the shear (2) different rake angles to allow the most precision cutting in a wide variety of capacities. Great for slitting when a flatter rake is needed.

**48" Travel Backgauge In Lieu Of Standard 36" Travel:** (standard on all 5/8" and larger shears) Same extremely heavy duty front operated PLC controlled backgauge with manual swingaway backstop with 48" of travel.

**Power Swingaway Backgauge With 48" Travel:** (manual swingaway is standard on all shears) This feature instantly swings the entire backgauge up and out of the way for shearing long work pieces, comes with 48" of travel.

**Manifold Lubrication System:** Brings all the lube points of the shear (except backgauge screws) to a centrally located area on the back of the shear for easier maintenance.

**Automatic Lubrication System:** Timed, power lubrication system that automatically brings grease to all the lube points (except backgauge screws).

**5/8" T-Slots Milled In Table:** ((2) are standard on all shears) 5/8" t-slots milled front to back in the bed/table of shear for front gauging. These t-slots are also available with scales.

**Drop Stops For T-Slots:** Disappearing/Gravity type stops that allow the work piece to slide forward over stops but not backwards. These stops slide in either the t-slots in table and/or the optional t-slot support arms.

**24" T-slot Support Arms:** 24" t-slotted support arms that mount to the front of the shear table and typically are lined up with t-slots in the table. Can also slide left to right in optional t-slot across front edge of shear table. These support arms are also available with scales to match optional scales in table.

**Hand Slots Machined In Table:** ((2) are standard on 10' shears and (3) are standard on 12' and longer shears) Large slots milled in table of shear so operators can get hands underneath work piece for easier part handling.

**T-Slot Across Front Edge Of Shear Table:** 5/8" t-slot milled across front edge of table to allow t-slot support arms to slide left to right in table.

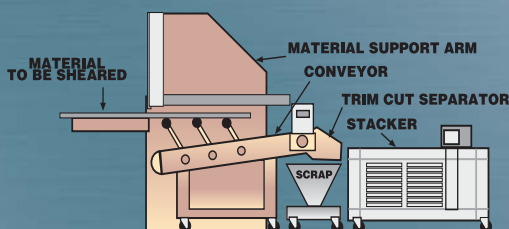
**Ball Transfers In Table:** (standard on most AS shears—see standard features page for details) Heavy-duty, adjustable height ball transfers to greatly aid in the handling of large work pieces.

**High Carbon/High Chrome Blades:** HCHC blades have more carbon and chrome than the industry standard shock resistant blades that are standard on the shear. These HCHC blades are primarily used for customers who use 75% or more stainless materials.

**Hold Down Cylinders With Impact Pads:** Hold down cylinders machined to accept nylon pads to protect sensitive work pieces.

**Special Paint Color:** Any single color paint (with sample) is available that matches our normal paint specs.

**High Speed Hydraulic Systems:** All AS shears are available with higher speed systems for faster production.



Sheet supports, conveyors and stackers available on all models of AS and CS shears



AS375-10 shown with optional ball transfers, t-slot across front edge of table and protractor



CNC front gauges are available on all model AS shears

## The Standard Industrial Corporation Five Year Warranty

As part of the purchase of a new Standard Industrial machine, a 5 year limited warranty will be included. The warranty begins at the point of initial shipment and will not automatically be passed along to second owners. The decision to repair or replace any part will be made by Standard Industrial management only. On all simple warranty repairs, Standard Industrial will provide instruction and parts (fob Clarksdale, MS). The customer or dealer involved will be invoiced for any replaced components and credit will be issued upon return of the defective component to Standard Industrial Corp.

**The Five Year Warranty Covers The Following:** Main hydraulic cylinder and seals • Drive components • Shafts • Bearings • Motors • Pumps • Valves • Backgauge components manufactured by Standard Industrial (not PLC components) • Structural integrity of non-removable parts of the machine • Hold down cylinders and seals • Fittings

**Labor:** Labor to repair structural integrity problems (cracks in the frame) of non-removable parts which fail during the 5 year warranty may be furnished at the customers plant in the continental U.S. This labor is supplied at no charge only if Standard Industrial is in agreement that the problem is not due to improper use of the machine or wrongful tampering with the machine by customer or dealer. Labor to assist our service rep. and/or necessary services are to be furnished by the customer at no cost to Standard Industrial. Labor to repair removable components (anything other than the welded frame of the machine) will only be supplied if the customer sends the failed component(s) back to Standard Industrial freight pre-paid to be repaired at our facility. The repaired components will be shipped back to customer (fob Clarksdale, MS). **Standard Industrial will NOT be responsible for freight OR for onsite labor on components that are removable.** Turn around time of the repair is dependant upon current backlog.

**The 5 Year Parts Warranty Does Not Include The Following:** PLC, PLC interface and PLC related components (2 year parts warranty in lieu of the 5 year parts warranty) Other components such as Shear Blades • Dies • Die Holders and accessories • Die compensators • Die cushions • Sheet support systems • CNC controls, backgauges and frontgauges and any other purchased computer controls are all subject to the manufacturers warranty.

The 5 year warranty excludes any damages caused by rigging, transportation, and incorrect use or modification by customer or dealer. The user must abide by the maintenance information provided in the service manual that is included with each machine. Maintenance items such as lubrication, bolt tightening, proper leveling of the machine and all other specified actions in the service manual must be adhered to in order for the 5 year warranty to be honored. Second users may be subject to the remainder of the 5 year warranty if they pay for full inspection of the machine by a Standard Industrial rep (contact us for details).

This equipment is manufactured and intended to operate as a component of a complete operating system. The complete system is to include the feeding equipment and/or guards or devices to protect all persons in the vicinity including the operators, depending on the work to be performed. The complete system is the sole responsibility of the owner/operator. The warranty is exclusive and may not be modified by verbal agreement. Other than those representations made expressly in this warranty, we exclude and disclaim all implied warranties of fitness for a particular purpose, and any other implied warranties.



Model AS750-6  
(3/4" x 6' A36/1/2" x 6' SS capacity)



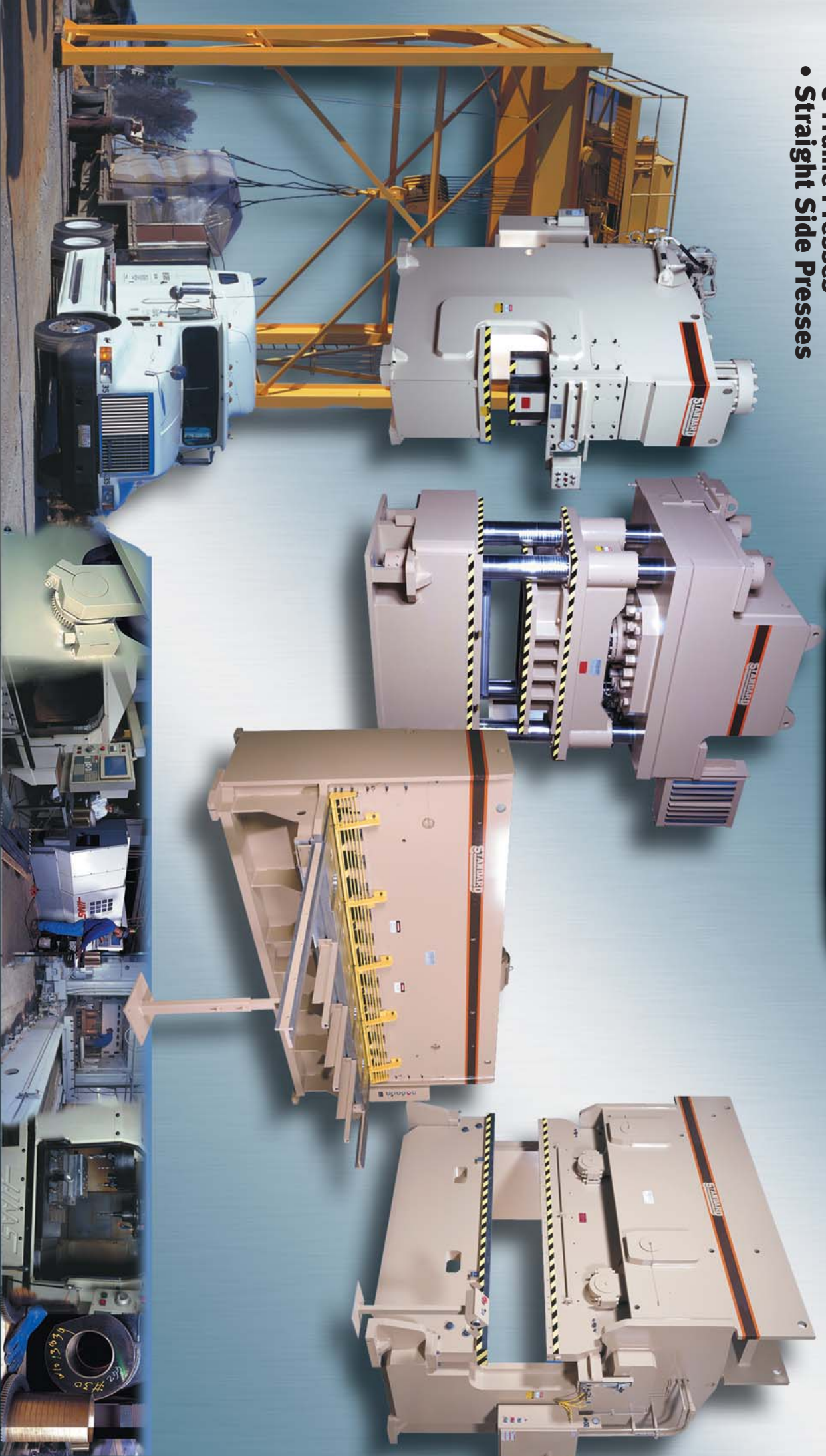
Model AS375-12  
(3/8" x 12' A36/1/4" x 12' SS capacity)



Model AS1000-00 Shear  
(1" x 10' A36 capacity  
3/4" x 10' Stainless Capacity)

- Press Brakes
- Shears
- Four Column Presses
- C-Frame Presses
- Straight Side Presses

# STANDARD INDUSTRIAL CORP.



## STANDARD INDUSTRIAL CORP.

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