

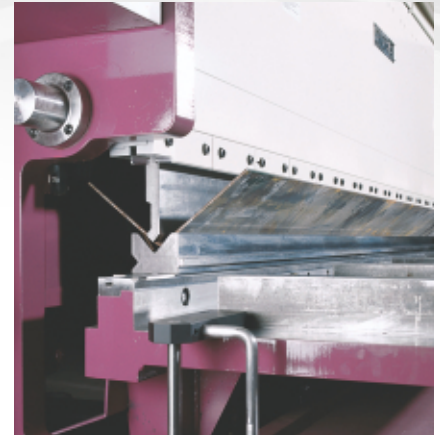
COMBINATION SHEAR/PRESS-BRAKE

GINGRAS

SIMPLE, COMPACT, HIGH PERFORMANCE

SIMPLE, COMPACT AND HIGH PERFORMANCE

In an increasingly competitive world, CEOs must take all factors into account to assure the viability of their business. One of these factors is the cost of floor space. In fact, whether you rent or you own the building, cost related to floor space that you use is important. With the GINGRAS Combined Shear/Press-brake, you can be assured that shearing and bending operations can be carried out in a minimum of space.



The secret of the GINGRAS' great reliability is in its simple and efficient design. There's no complex hydro-mechanical system that could cause damage due to an off-centered load. On the GINGRAS, no bearing or bushing

turns when the load is applied to the ram. When a load is not centered, the load is automatically distributed by the hydraulic system and not by levers or torsion tubes. Thus the GINGRAS will not twist or deform laterally.

Thus with proper maintenance, you can be sure that your GINGRAS will be productive for decades to come.

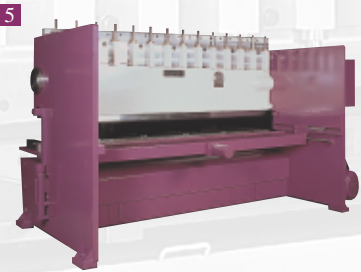
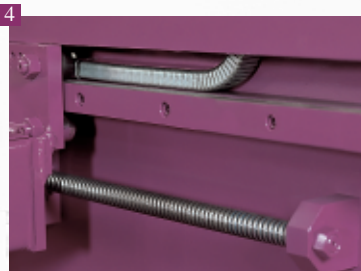
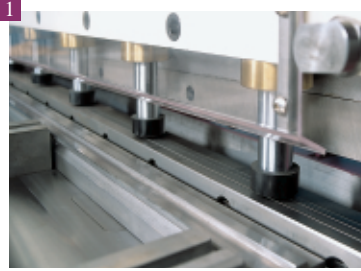


SHEAR MODE TO PRESS-BRAKE MODE IN

15 SECONDS



FEATURES AND BENEFITS



- Sectional high chrome, high carbon steel blades are interchangeable and may be used on all four edges.
- Hold downs are hydraulic and have a wide stroke making cutting complex shapes possible. Standard urethane anti-marking pads for aluminum, stainless steel and other polished metals are easily installed. (photo 1)
- Blade replacement is made easy by positioning the upper ram horizontally. (photo 2)
- The GINGRAS machine is equipped with rapid shear gap adjustment to increase cutting precision and prolong the life of the blades. (photo 3)
- The table is equipped with transfer balls to facilitate handling of heavy plates (optional on model SPB-04-045).
- The protective guard is made of transparent polycarbonate giving a clear view of the cutting edge.
- The back gauge is precise and extremely accurate because it is mounted on ball screws (rack and pinion for model SPB-04-045). It can be used both in shearing mode as well as in press-brake mode. (photo 4)
- The back of the GINGRAS is completely open to give better access to the sheared pieces. (photo 5)
- Front arm supports are designed for rapid installation and removal. (photo 6)
- The GINGRAS Shear/Press-brake offers a clear span of much larger conventional machines. For example, on our 10-foot model, the distance between the housings is 122 inches, which is equivalent to a conventional 12-foot press-brake.
- The upper and lower rams can be equipped with a replaceable hardened steel bed. This facilitates repairs in case of accidental breakage or due to normal wear after years of service (standard on our 240 ton and 320 ton machines).
- Fade-out work is very easily accomplished by hydraulically tilting the table without risk of damage to ram gibs as in conventional press-brakes.

SPECIFICATIONS

	SPB-04-045	SPB-08-080	SPB-10-080
SHEARING CAPACITY	1/4" x 53"	1/4" x 8'	1/4" x 10'
BENDING CAPACITY	45 TONS x 53" (3/16" x 53" IN MILD STEEL)	80 TONS x 8' (10GA. x 8' IN MILD STEEL)	80 TONS x 10' (1/8" x 10' IN MILD STEEL)
DISTANCE BETWEEN HOUSINGS	53"	98"	122"
BACK GAUGE	24" RACK AND PINION	27" BALL-SCREW ASSISTED TRANSFER	27" BALL-SCREW ASSISTED TRANSFER
STROKE	5"	6"	6"
OVERALL LENGTH	77" (APPROX.)	124" (APPROX.)	148" (APPROX.)
OVERALL WIDTH	56"	69 1/2"	69 1/2"
OVERALL HEIGHT	63"	76"	76"
TABLE HEIGHT	34 1/2"	34 1/2"	34 1/2"
OPEN HEIGHT	8"	10"	10"
APPROACH SPEED	46 IN./MIN	70 IN./MIN	70 IN./MIN
BENDING SPEED	0 TO 30 IN./MIN	0 TO 30 IN./MIN	0 TO 30 IN./MIN
RETURN SPEED	90 IN./MIN	120 IN./MIN	120 IN./MIN
BLADE LENGTH	59"	102" (IN 34" SECTIONS)	125" (IN 31 1/4" SECTIONS)
MOTOR	10 HP	25 HP	25 HP
WEIGHT	8,000 LBS (APPROX.)	18,000 LBS (APPROX.)	20,000 LBS (APPROX.)



SPB-10-160	SPB-10-240	SPB-12-240	SPB-10-320	SPB-12-320
1/2" x 10'	5/8" x 10'	5/8" x 12'	3/4" x 10'	3/4" x 12'
160 TONS X 10' (1/4" X 10' IN MILD STEEL)	240 TONS X 10' (3/8" X 10' IN MILD STEEL)	240 TONS X 12' (3/8" X 12' IN MILD STEEL)	320 TONS X 10' (1/2" X 10' IN MILD STEEL)	320 TONS X 12' (1/2" X 12' IN MILD STEEL)
122"	122"	150"	126"	150"
27" BALL-SCREW ASSISTED TRANSFER	40" BALL-SCREW ASSISTED TRANSFER	40" BALL-SCREW ASSISTED TRANSFER	40" BALL-SCREW ASSISTED TRANSFER	40" BALL-SCREW ASSISTED TRANSFER
6"	7 1/2"	7 1/2"	7 1/2"	7 1/2"
148" (APPROX.)	158" (APPROX.)	186" (APPROX.)	166" (APPROX.)	188" (APPROX.)
69 1/2"	78 1/2"	78 1/2"	78 1/2"	78 1/2"
83 1/2"	92"	96"	106"	106"
34 1/2"	36"	36"	36"	36"
10"	12"	12"	12"	12"
35 IN./MIN	60 IN./MIN	60 IN./MIN	45 IN./MIN.	45 IN./MIN.
0 TO 25 IN./MIN	0 TO 30 IN./MIN.	0 TO 30 IN./MIN.	0 TO 25 IN./MIN.	0 TO 25 IN./MIN.
50 IN./MIN.	120 IN./MIN.	120 IN./MIN.	90 IN./MIN.	90 IN./MIN.
125" (IN 31 1/4" SECTIONS)	125" (IN 31 1/4" SECTIONS)	154" (IN 38 1/2" SECTIONS)	125" (IN 31 1/4" SECTIONS)	154" (IN 38 1/2" SECTIONS)
25 HP	50 HP	50 HP	50 HP	50 HP
30,000 LBS (APPROX.)	40,000 LBS (APPROX.)	50,000 LBS (APPROX.)	60,000 LBS (APPROX.)	70,000 LBS (APPROX.)



SPB-10-160
Press-brake
mode



SPB-04-045
Shear mode



SPB-10-080
Shear mode

HOW THE GINGRAS WORKS



The GINGRAS Shear/Press-brake is unique. It is the only machine on the market offering the flexibility to function as either a shear or a press-brake. The transformation only takes a few seconds by rotating the upper ram 180 degrees. The positioning is secured with two hydraulic tapered cylinders inserted in hardened bushings.

The GINGRAS is easy to use and requires only a minimum of training. Your operator will appreciate the machine's diversity and flexibility especially compared to conventional shears. The GINGRAS' versatility allows you to cut a leg of angle iron lengthwise as well as the beveling of its ends. Furthermore, the greater clearance of the upper turning ram offers the ability to insert more odd-shaped pieces than permitted by conventional press-brakes. Replacement of the blades is the quickest and easiest in the industry. The operator simply rotates the upper ram, permitting replacement while standing in front of the machine. It is further facilitated by setting the hold downs in retracted position. Standard blades are HCHC (high chrome, high carbon) suitable

for mild steel and stainless and their efficiency is maximized due to precision ground sections, each with 4 cutting edges. Damage or wear to one side doesn't require the replacement of all blades.

Once shearing has been completed, the operator simply turns a switch and presses the control pedal to transform the machine into a press-brake. As a result, the operator is ready to bend the sheared pieces into the desired parts with no fuss and without having to move to another workstation. One person can install the heaviest of dies unaided by using the loading rings located at each end of the ram.

The distance between housings on a 10-foot GINGRAS machine is 122", which provides the equivalent clear span of a conventional 12-foot press-brake. Its unique hydraulic system generates full tonnage at any point of the stroke and over the entire length of the ram. The open access and easy control of material permits shaping of cones. It is also possible to make fade-out work by tilting the lower ram.

THE GINGRAS SUPPORT TEAM

Of the many advantages associated with the GINGRAS Shear/Press-brake, the first is space. A combined shear/press-brake takes up one-half of the floor space required for two separate machines. Secondly, the financial investment is greatly reduced while the quality and standard features surpass other manufacturers' standard offering. What's more, one machine needs much less maintenance, and this is especially true for the GINGRAS machine which requires a minimum of upkeep. Standard features which other manufacturers sell as options include transfer balls to facilitate handling of heavy sheets. Additionally, the front support arms have been designed for rapid installation and removal. The blade adjustment indicator increases cutting precision and prolongs the life of the blades. In short, every aspect has been studied and researched in order to equip this shear/press-brake with unique and more productive features.

Training

When your GINGRAS is delivered, you will receive personalized training by our experts in your factory. Thus, you're assured that your employees will receive the necessary training to use your GINGRAS safely.

Technical Services

When you purchase a GINGRAS, you can be assured of personalized service. In fact, GINGRAS designers are available during office hours to answer all your questions or to help you find solutions to specific applications.

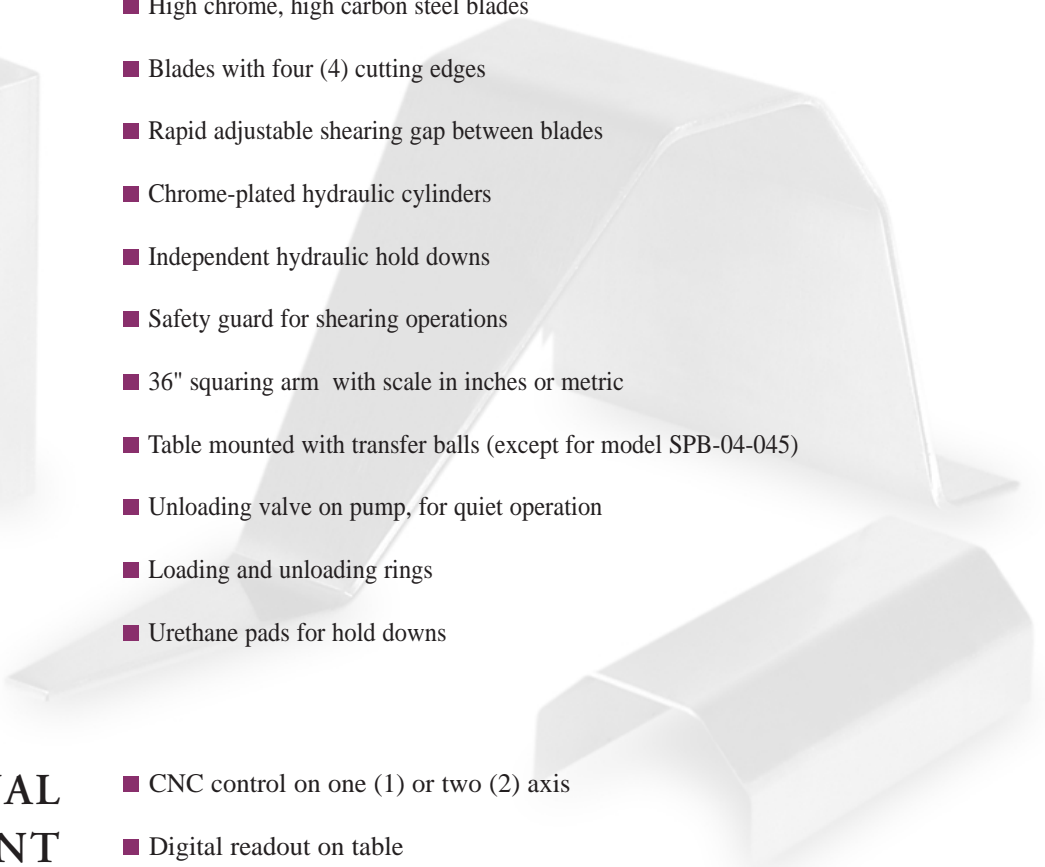
Our technicians based in Quebec, as well as those in our dealerships, are available to give you quick and qualified service. Furthermore, all replacement parts are available at the factory. With GINGRAS, you can be assured of outstanding service.



STANDARD EQUIPMENT



- Motorized back gauge with speed and direction control and digital readout
- High chrome, high carbon steel blades
- Blades with four (4) cutting edges
- Rapid adjustable shearing gap between blades
- Chrome-plated hydraulic cylinders
- Independent hydraulic hold downs
- Safety guard for shearing operations
- 36" squaring arm with scale in inches or metric
- Table mounted with transfer balls (except for model SPB-04-045)
- Unloading valve on pump, for quiet operation
- Loading and unloading rings
- Urethane pads for hold downs



OPTIONAL EQUIPMENT

- CNC control on one (1) or two (2) axis
- Digital readout on table
- 48" Back gauge
- Adjustable and retractable bending fingers
- Large variety of bending dies