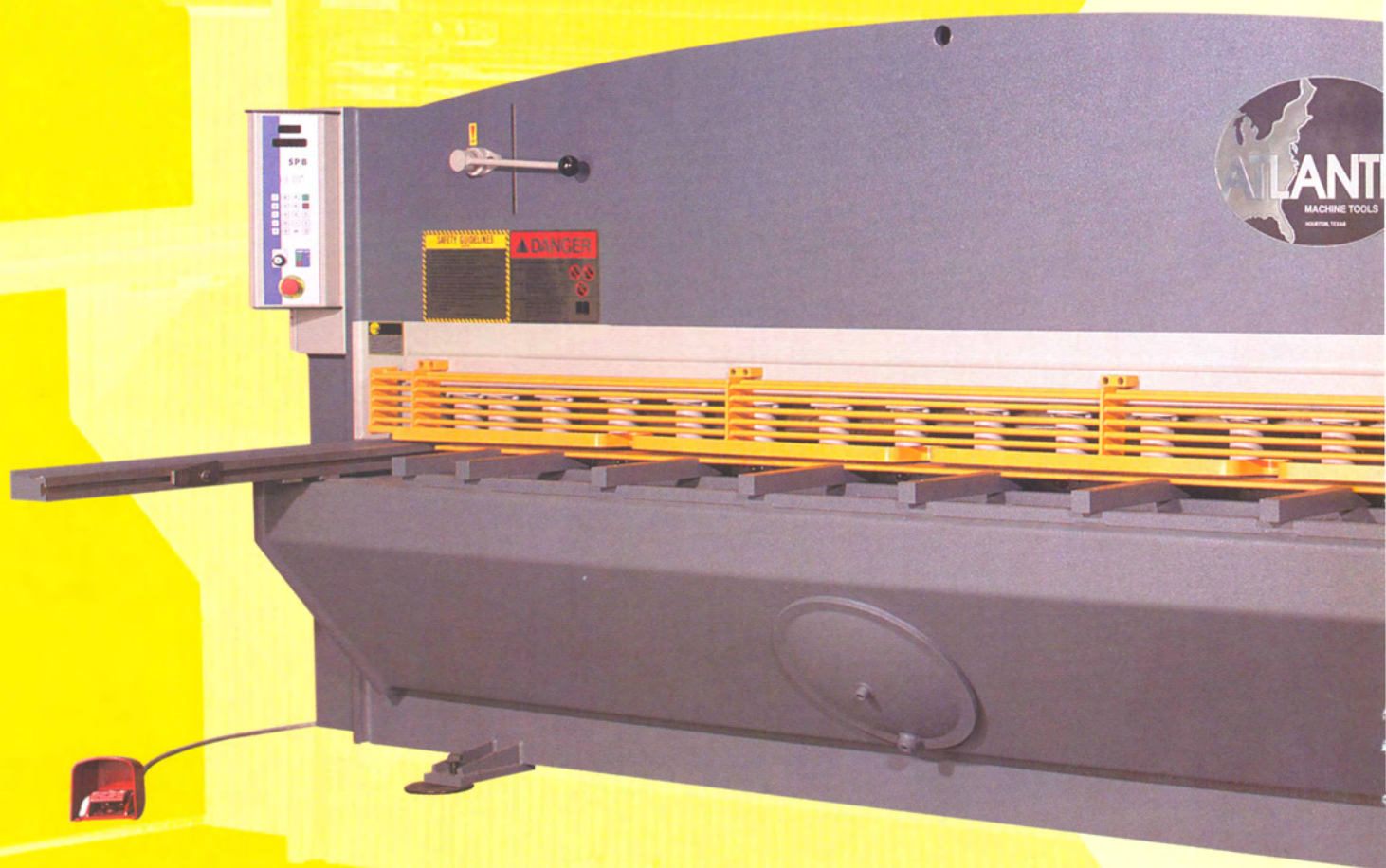


All ATLANTIC shears are recognized for being well-built, accurate and cost-effective, meeting the demand for the high-precision sheet metal and heavy fabrication market to run short- or high-volume production.

All our ATLANTIC shears are equipped with power rake angle adjustment, HC-HC blades and one quick-set blade gap lever in front of the machine and are available with our SC70 CNC controls.

The HDE series shears remains the pacesetters in the price/quality ratio market of today. With more than thousands running day after day all over the world we are pretty convinced about the durability and craftsmanship of these machines.





# STANDARD FEATURES OF HDE- RANGE

- ✓ Hydraulic system, located in the back of the machine, easy accessible and covered.
- ✓ 2 underdriven cylinders. Electro-hydraulic rake angle setting by pushbuttons on the control panel.
- ✓ Quick blade clearance setting by one easy accessible lever at the front of the machine.
  - ✓ Tilting plate holddowns with separate pressure system to clamp various sheet thickness correctly.
  - ✓ Hydraulic and electric overload protection.
  - ✓ 4 edged HC/HC cutting blades.
  - ✓ Motorised backgauge stroke 39".
  - ✓ Shear table with a number of square iron table blocks, easing the sheet feed-in and increasing drastically operators' safety.
  - ✓ 40" squaring arm with with scale, T-slot and disappearing stop, attached to the left side of the machine.
  - ✓ All operator controls are conveniently located at the left-hand side of the machine within the immediate reach of the operator.
  - ✓ The standard SP8 control offers the following functions : automatic positioning of the backgauge to the preselected position with digital read-out, stroke control and selection for backgauge retraction.
  - ✓ Movable footpedal control.
  - ✓ Filled oiltank.
  - ✓ Instruction and maintenance manuals.
  - ✓ Service tools.
  - ✓ Shadow line lighting.

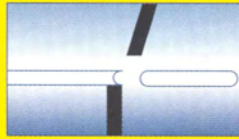
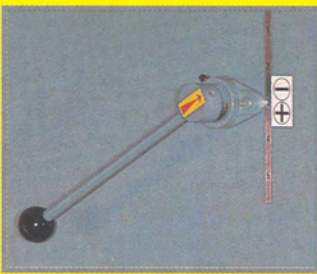




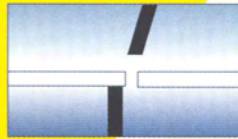
## BLADE GAP ADJUSTMENT

Our quick blade gap adjustment is located conveniently in front of the machine.

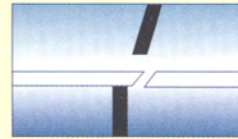
Adjustment ranges from .002" knife clearance for very light gauges and progressively increases for heavier gauges up to the maximum shear capacity.



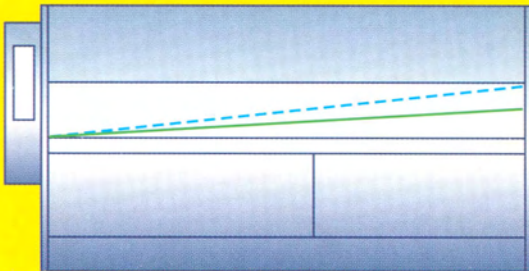
Too small



Correct



Too big

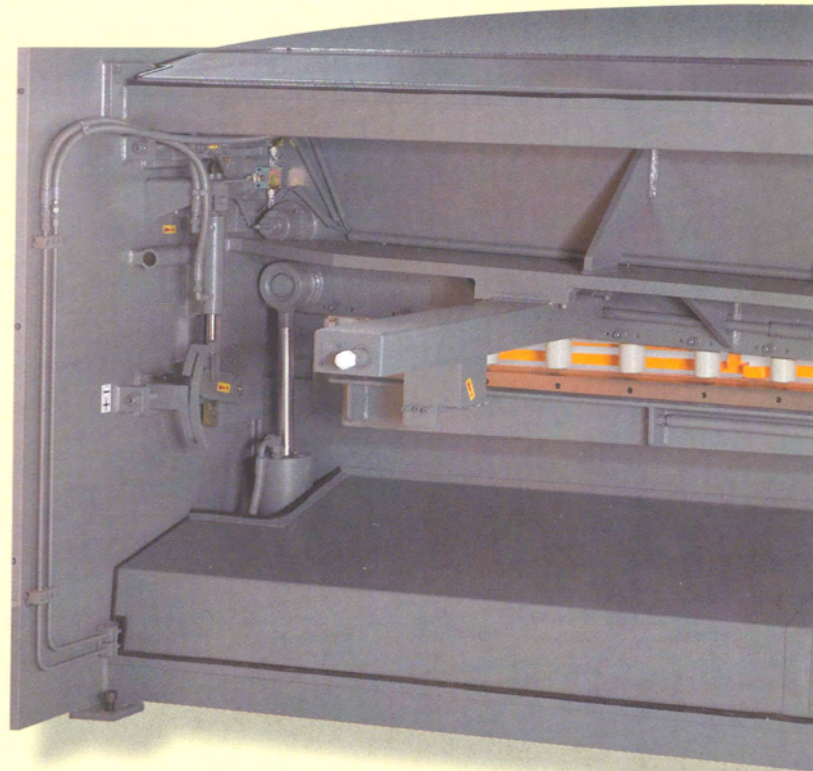


## RAKE ANGLE ADJUSTMENT

The rake angle of the top blade is programmable in the SP8 control. The rake angle setting allows cutting thin material at a smaller rake to decrease sheet curling and makes cutting thicker material easier. Cutting stainless requires a larger rake angle.



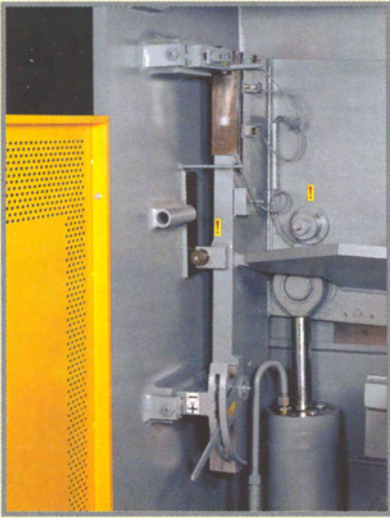
Picture including hydraulic blade gap setting (standard on HDE models with SC70 control unit)



## HYDRAULICS

HDE shears are bottom driven by 2 pull-down cylinders. The hydraulic system consists of a motorpump group and a multi-function manifold block, conveniently located at the rear of the machine. We use flexible hoses to connect the cylinders, holddowns, pumps and manifold. Two high pressure relief valves protect the holddowns and the cutting pressure from overloading. The HDE has an oversized hydraulic fluid tank for trouble free high production shearing.

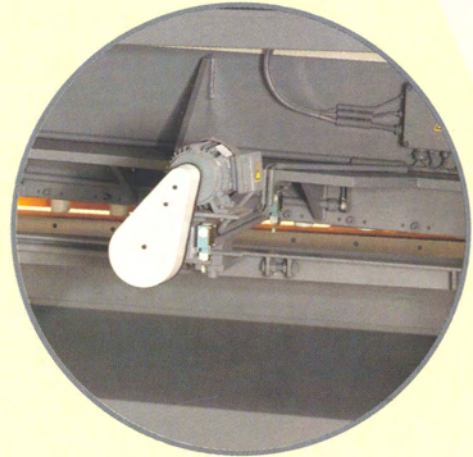
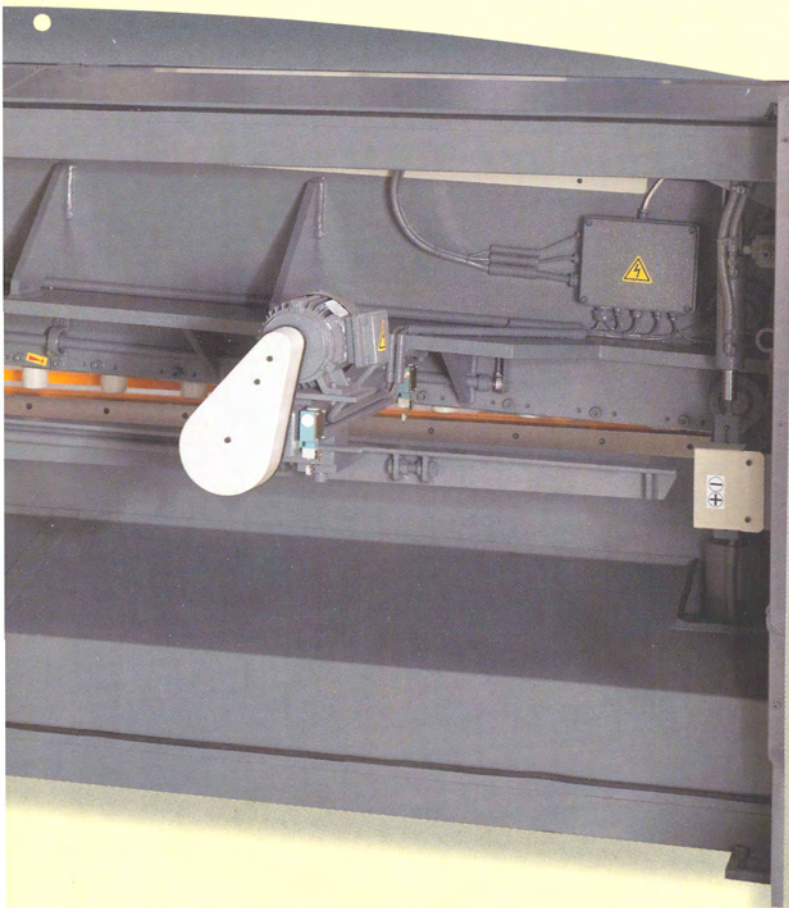




## BACKGAUGES

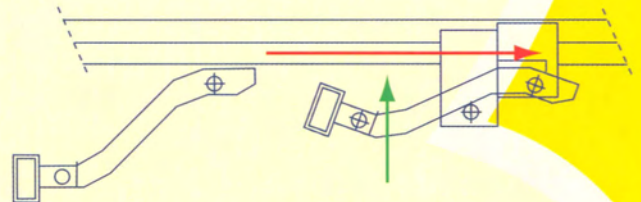
The backgauge consists of 2 rigid arms (containing guides and control spindle) and the parallel adjustable backgauge bar. This assembly assures a precise positioning of the sheet. Swing-up types enable cutting of sheets longer than the standard stroke length.

The standard programmable "Go-To" backgauge has a SP8 control with LED readout. We also offer the SC70 multi-functional CNC control.



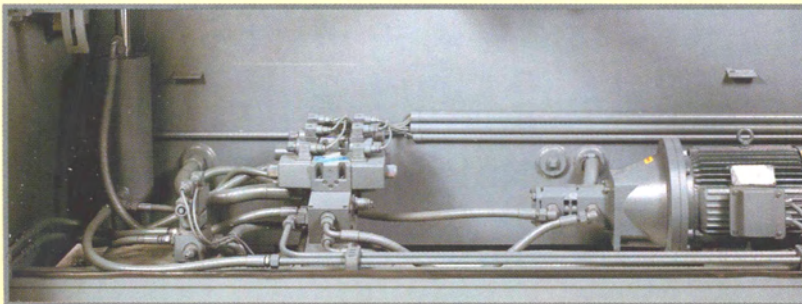
### MOTORISED BACKGAUGE

Lateral movement front to back.  
Standard on all models  
Power backgauge stroke 39".



### SWING-UP BACKGAUGE (OPTIONAL)

Power backgauge stroke 32".  
Available on all models.  
When the back gauge approaches the end of the stroke to the back, it will mechanically lift up to cut longer sheets.  
A 39" stroke is available as an option.





# OPTIONAL EQUIPMENT

## HDE executed with the optional SC70 control is called HDEX

Basic features of the SC70 control :

- Monochrome LCD screen.
- Memory capacity :  
Max 200 programs with max. 400 steps  
Max 127 steps per program.  
Material list of max. 32 materials
- Each program contains the basic cutting parameters such as material type, material thickness, blade gap and cutting angle setting
- Electro-hydraulic blade gap setting by 2 cylinders.
- Stroke control adjustment.



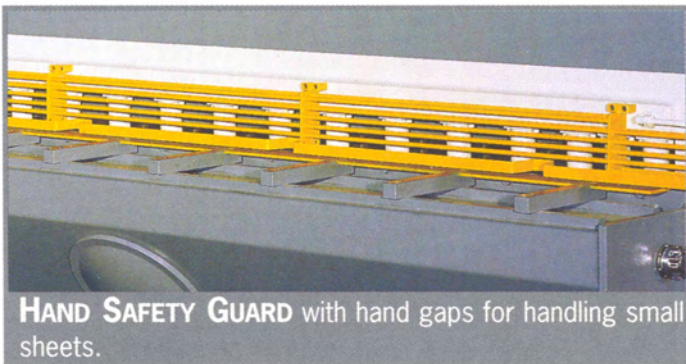
- Automatic programmable retraction of the back gauge.
- Possibility of jog mode on backgauge.
- Backlash compensation, delayed sheet release.
- Mode selection Inch-Metric.
- (preset) Counter with 0-step.

### Programming modes :

- Automatic :  
By entering the sheet thickness for mild steel, 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 are programmed manually.

- SC70 control unit
- Squaring arms and front support arms.
- Ball transfers in the iron table blocks.
- Movable pendant control panel (only available for SC70 control)

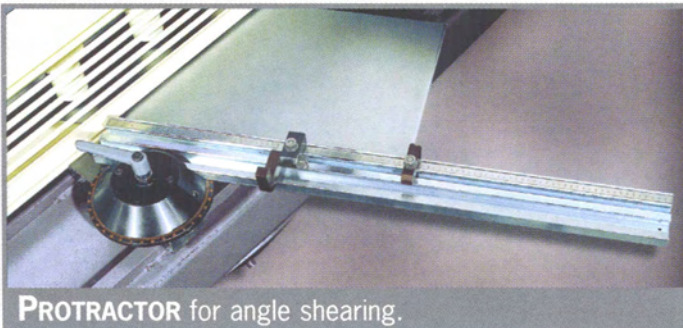
- Protractor for angle shearing.
- Knives for cutting stainless steel.
- Hand Safety Guard with hand gaps.
- Different backgauge types.
- Removable Table sections



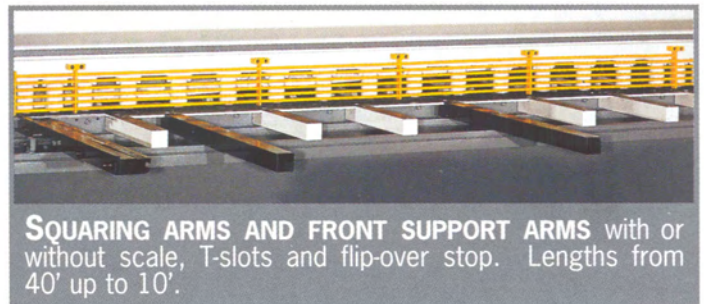
**HAND SAFETY GUARD** with hand gaps for handling small sheets.



**BALL TRANSFERS** mounted in the iron table blocks, for easy feed-in of the sheets.



**PROTRACTOR** for angle shearing.

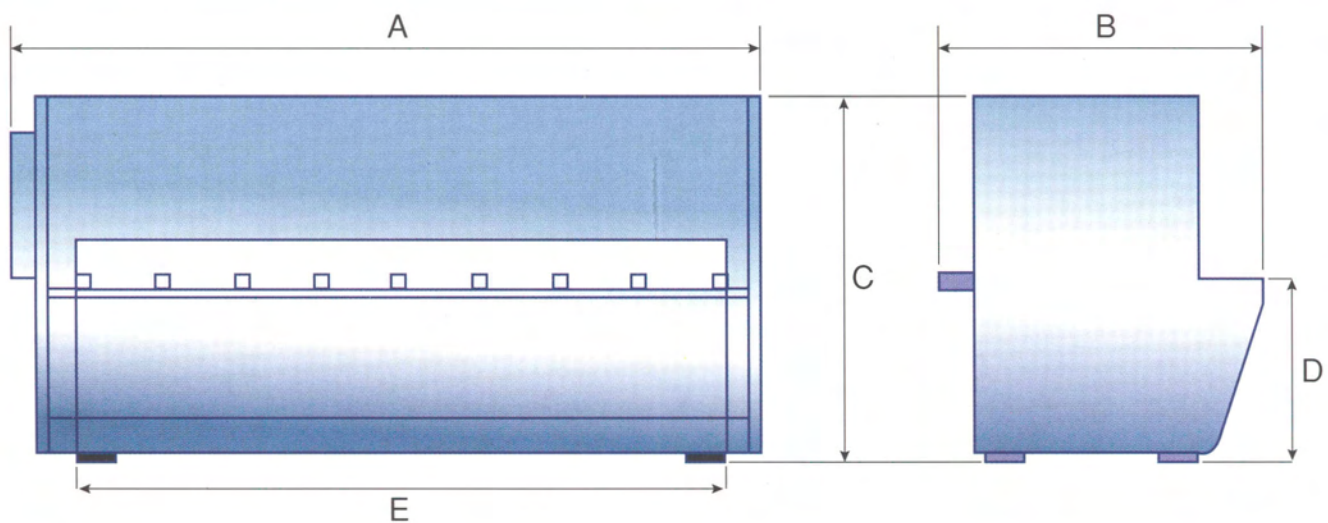


**SQUARING ARMS AND FRONT SUPPORT ARMS** with or without scale, T-slots and flip-over stop. Lengths from 40' up to 10'.



# TECHNICAL DATA HDE- range

MODEL		HDE 6' x ¼"	HDE 10' x ¼"
Capacity mild steel	(In)	¼"	¼"
Capacity stainless steel	(In)	10 ga.	10 ga.
Cutting length	(In) E	80"	122"
Angle adjustment	(°)	1 - 3°	1 - 3°
Number of plate hold-downs		13	18
Number of strokes / min.		12 - 27	10 - 25
Length squaring arm	(In)	40"	40"
Backgauge range	(In)	32" / 39"	32" / 39"
Working height	(In) D	31"	31"
Motor	(Hp)	15	15
Length	(In) A	118"	157"
Width	(In) B	77"	77"
Height	(In) C	63"	63"
Approx. weight	(Lbs)	7,900	10,500



## EXPRESSED WARRANTY

All Atlantic shears are warranted to be free from defects for a period of one full year from date of installation by our serviceman. This includes all parts and labor except shear blades. Warranty will be considered void if the machine is not used in a normal and proper manner, not properly maintained, or modified for any special use. No other warranty is either expressed or implied by Haco-Atlantic Inc, or any of its representatives.

**SAFETY** -All Atlantic shears are built conformable to American Standard Institute B 11.4 1983 Safety Standards for hydraulic power shear. However, due to the multipurpose use of some of the equipment the purchaser shall be responsible for the proper installation and continued use of point of operation guards or awareness between or assure complete operator safety.