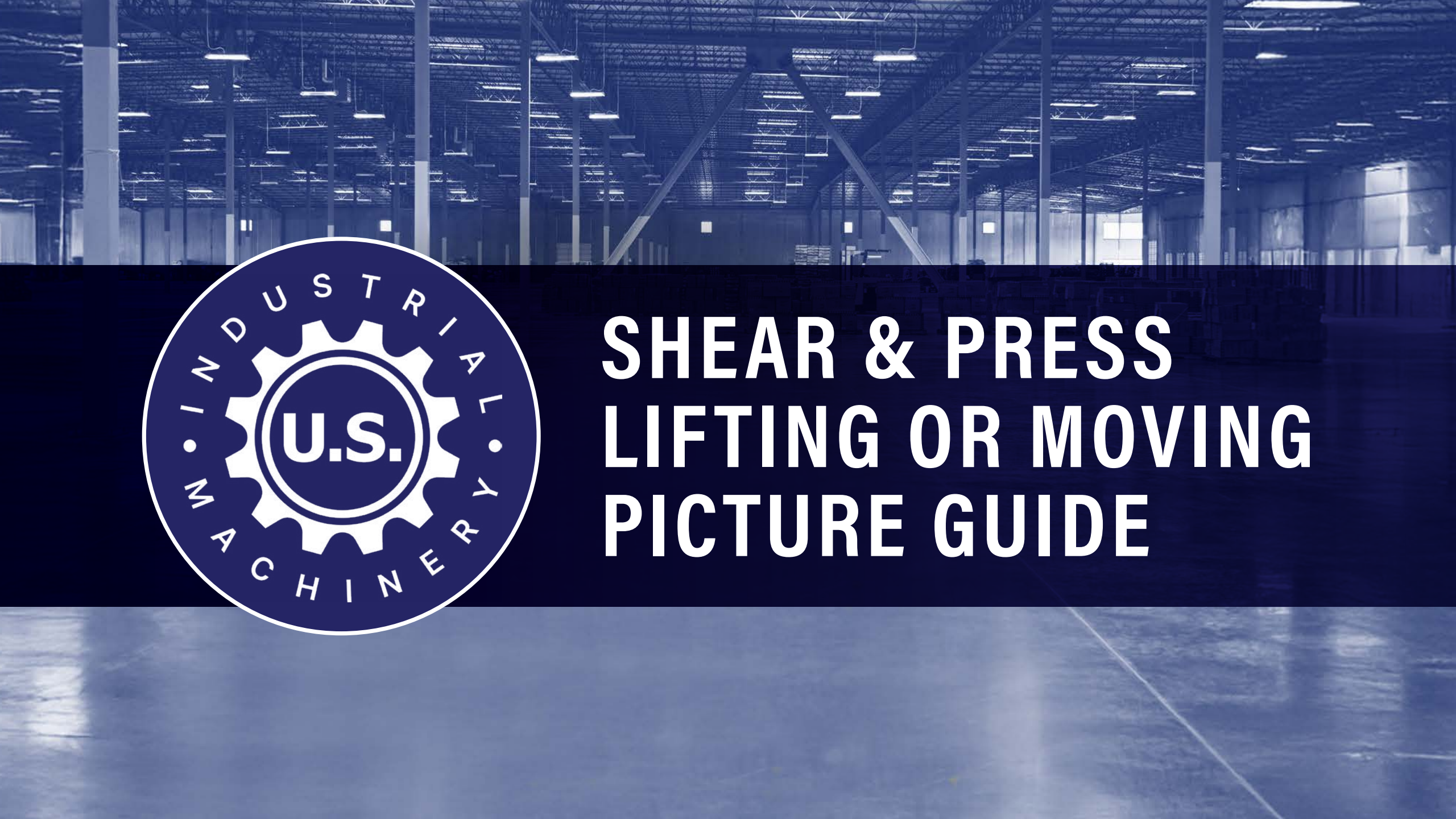


SHEAR & PRESS LIFTING OR MOVING PICTURE GUIDE

LIFTING LUG LOCATIONS ON SHEAR

LEFT SIDE:

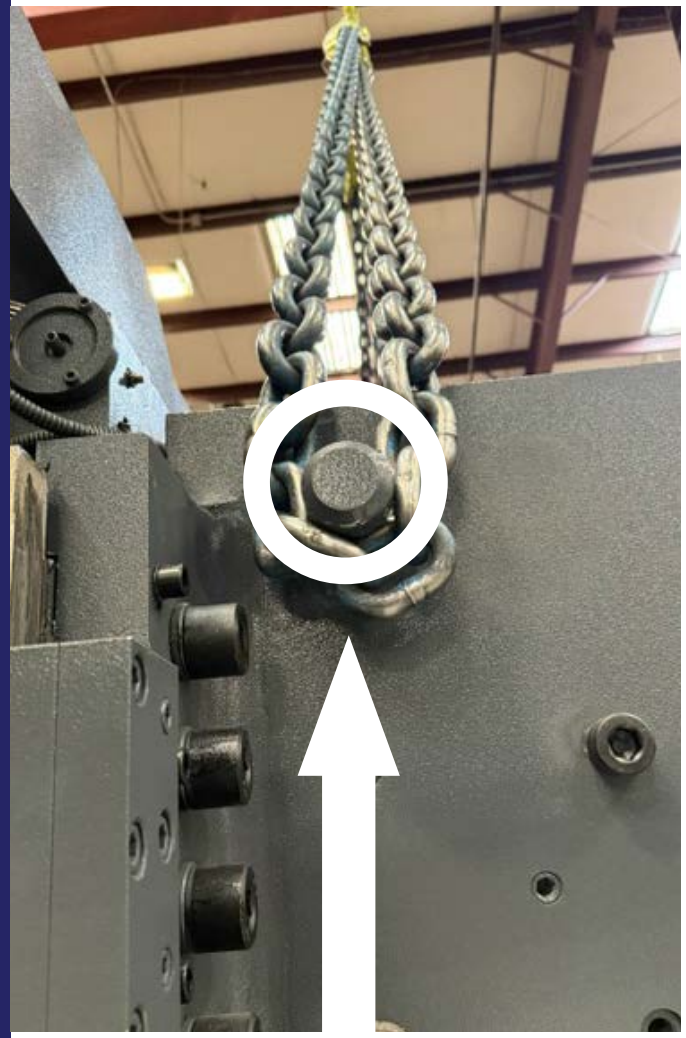
Lifting lugs are located right of the electrical cabinet and above the Hydraulic cylinder mounting plate.

RIGHT SIDE:

Lifting lugs are located towards the front of the machine just above the Hydraulic cylinder mounting plate.

NOTE:

Lifting lugs are small round lugs mounted to machine



Lifting lugs are located on left side of machine

Lifting lugs are located on right side of machine

LIFTING LUG LOCATIONS ON PRESSBRAKE

LEFT SIDE:

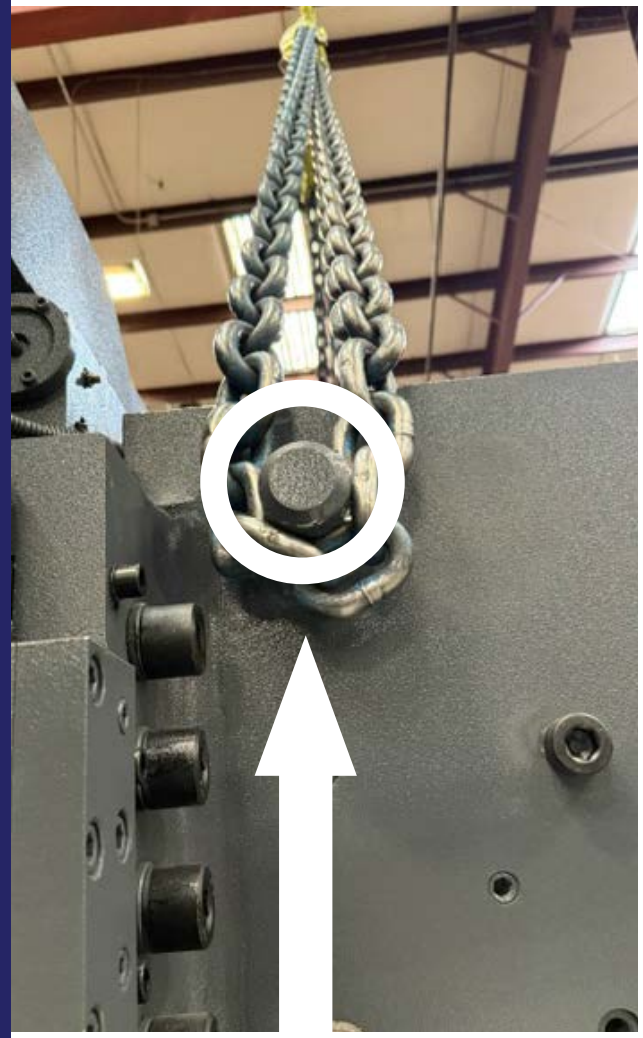
Lifting lugs are located behind left side hydraulic cylinder.

RIGHT SIDE:

Lifting lugs are located behind the right side hydraulic cylinder.

NOTE:

Lifting lugs are small round lugs mounted to machine



Lifting lugs are located on left side of machine

Lifting lugs are located on right side of machine

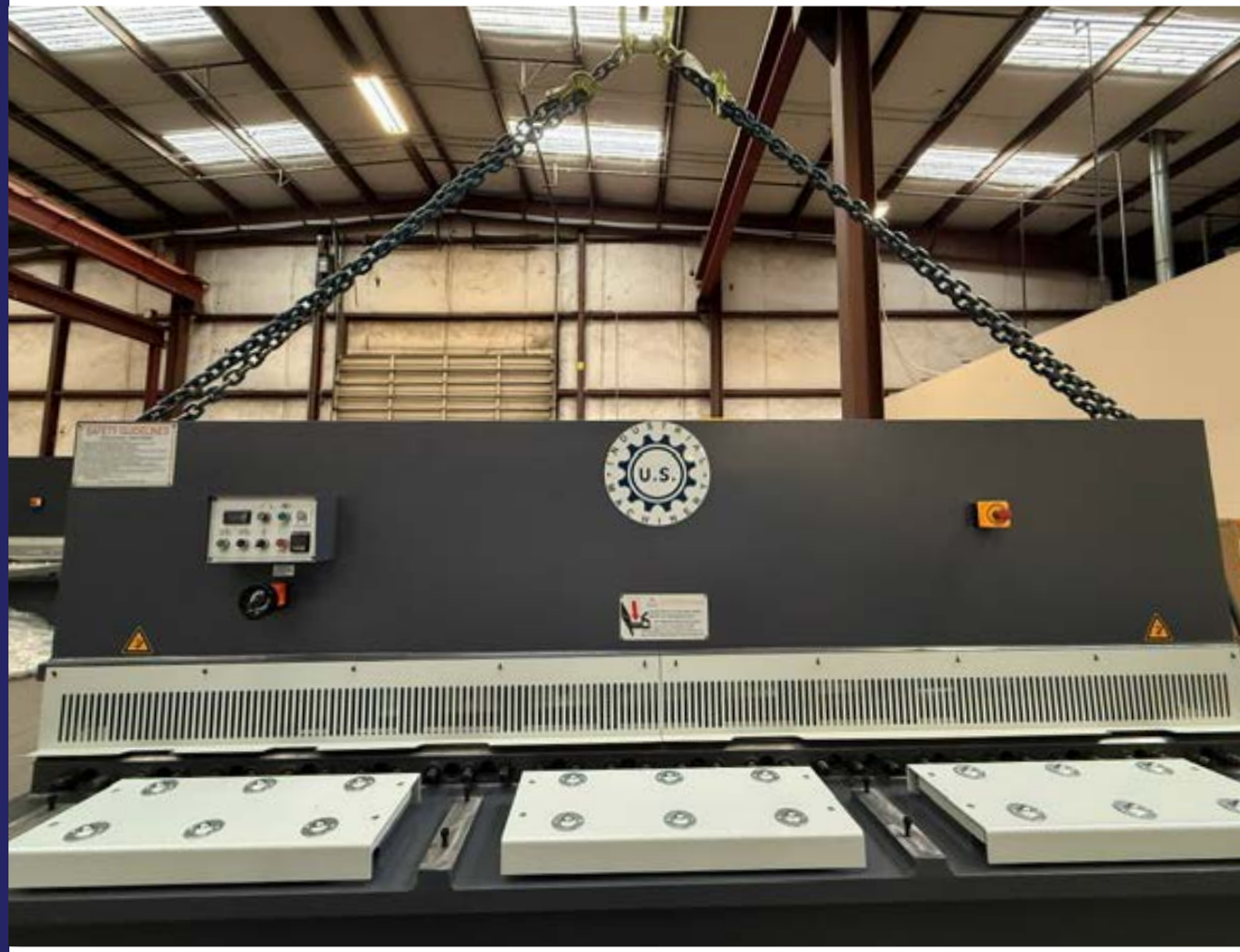
HOW TO USE LIFTING LUGS

- Place lifting mechanism (usually chains or straps rated for the correct weight) over the lifting lugs.
- Make sure that lifting mechanism is even on both sides of the machine. This will prevent the machine from tipping or spinning while it is being moved.
- SLOWLY lift the machine.

LIFTING PLACEMENT

LIFTING INSTRUCTIONS

- Make sure the area is clear.
- If you are moving an existing machine, makesure that the machine is disconnected from power and all tools / parts are out of the way.
- LIFT SLOWLY
- Once the machine is slightly off the ground, double check that your lifting mechanism is even and the area is clear.
- Move the machine into place slowly.
- Slowly place the machine in position.



Make sure machine is lifted evenly and slowly

ANNEX A & B

ANNEX A: SHEAR LIFTING INSTRUCTIONS FROM MANUAL

ANNEX B: PRESSBRAKE LIFTING INSTRUCITONS FROM MANUAL

ANNEX A

SHEAR LIFTING INSTRUCTIONS FROM MANUAL

U.S. INDUSTRIAL MACHINERY

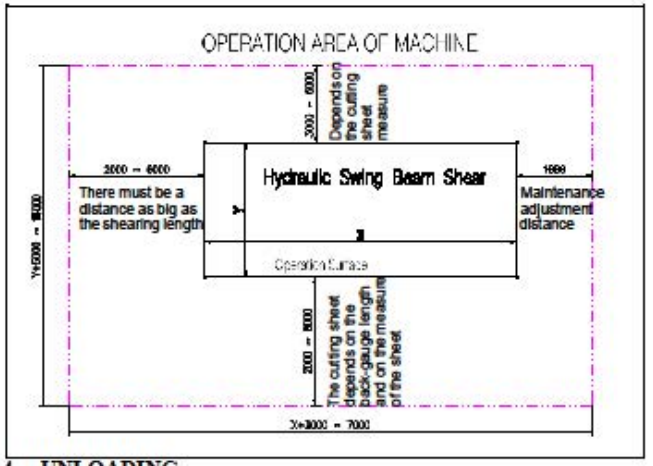


Figure1.1

4. UNLOADING

To unload machine use a crane of sufficient capacity or rig machine on to foundation. **(See Figure 1.2)**

WARNING: Machine is heavy in front, guard against tipping until anchor bolts are secured. Don't attach lifting equipment to shafts or cross braces. Use protective measures to prevent damage to finished surfaces.

5. FOUNDATION (See Figure 1.3)

1) Before moving the machine, check the foundation site. The foundation must be rigid enough to support machine without settling.
2) Check location of foundation bolts. Bolts must match spacing and alignment of bolt holes in machine housing feet or toes.
3) Prepare for shimming by placing steel plates of equal thickness over each foundation bolt. These plates will provide a bearing surface for leveling shims.

CAUTION: When grouting is used, grout only under housing feet. Do not grout under beds which extend below floor line.

ANNEX B

PRESSBRAKE LIFTING INSTRUCTIONS FROM MANUAL

U.S. INDUSTRIAL MACHINERY

TRANSPORTATION AND INSTALLATION

1. Shipping and Receiving

Immediately upon receiving your press brake, visually inspect the machine for any external damage. If damaged, notify the carrier for claims inspection and advise the distributor.

2. Storing Conditions

The machine is delivered in such a way that it would not sustain any damage upon consignment

a) If the machine is to be stored in a damp environment, moisture removing materials should be placed in the electrical panel and around the hydraulic block to keep the parts protected.

b) In order to prevent the punch and die from rusting, protective oil should be used.

c) The machine must be carefully protected against sunlight.

d) Storage must be never be carried out in the open air (wet environment), or defects may occur in the valve sockets or electrical parts.

3. Operation Area of the Machine

It is recommended to have ample space for working around your machine. (See Figure 1.1)

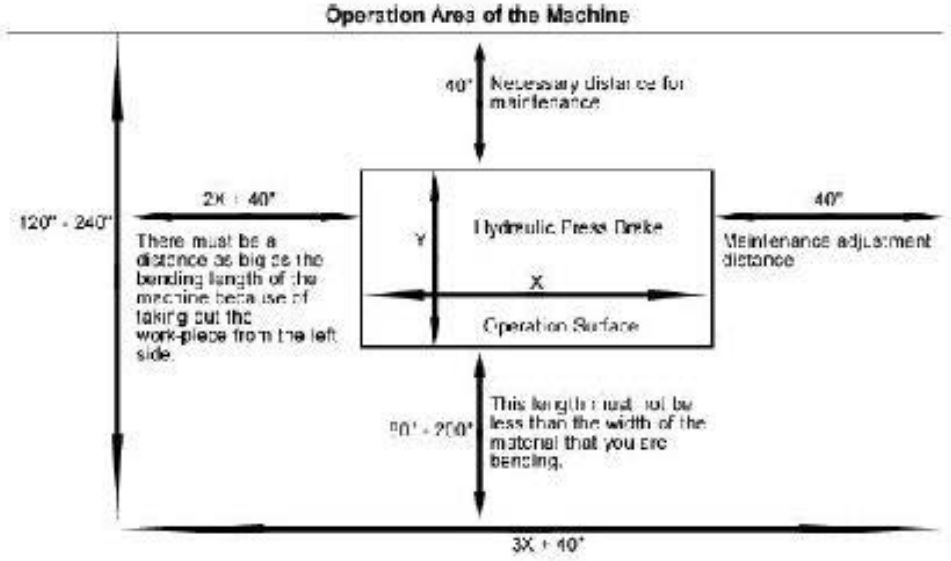


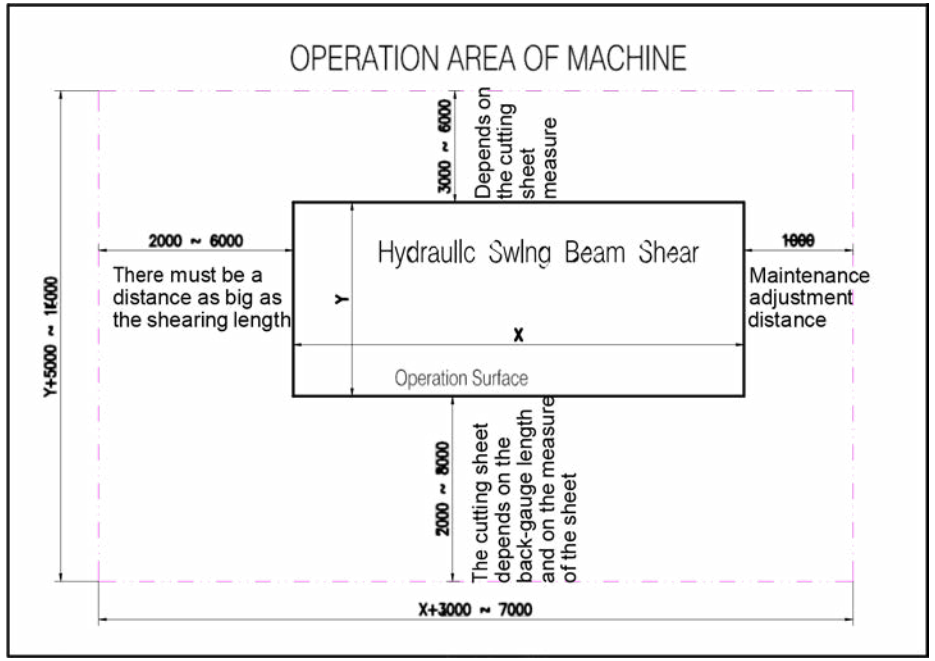
Figure 1.1

QUESTIONS?

If you run into any problems or have questions,
contact the U.S Industrial service department.

Contact – (800) 860-1850

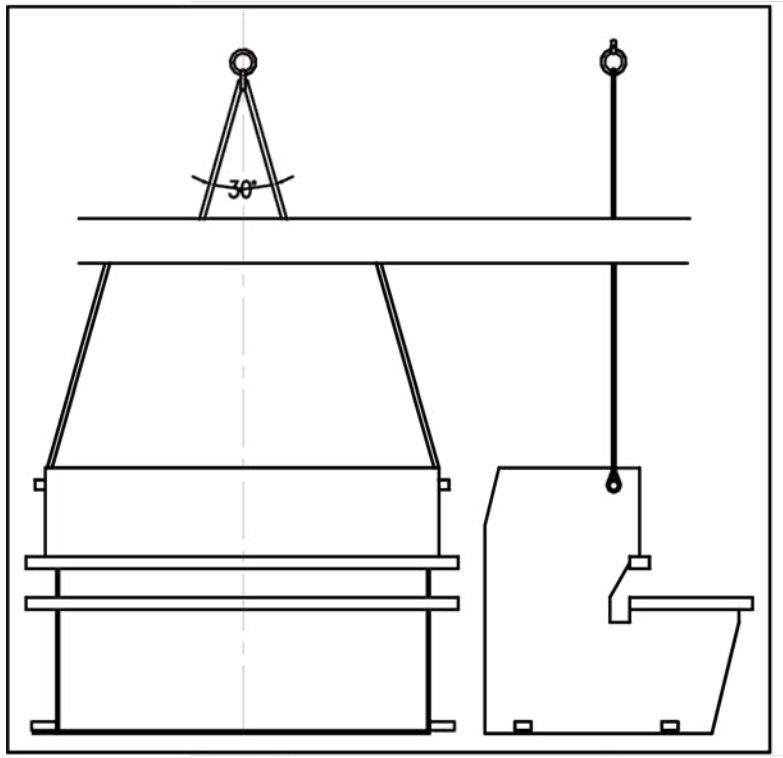
Figure1.1



4. UNLOADING

To unload machine use a crane of sufficient capacity or rig machine on to foundation.

Figure1.2



WARNING (See Figure 1.2)

Machine is heavy in front, guard against tipping until anchor bolts are secured. Don't attach lifting equipment to shafts or cross braces.

Use protective measures to prevent damage to finished surfaces.

5. FOUNDATION (See Figure 1.3)

1. Before moving the machine, check the foundation site. The foundation must be rigid enough to support machine without settling.

2. Check location of foundation bolts. Bolts must match spacing and alignment of bolt holes in machine housing feet or toes.

3. Prepare for shimming by placing steel plates of equal thickness over each foundation bolt. These plates will provide a bearing surface for leveling shims.

CAUTION
When grouting is used, grout only under housing feet.
Do not grout under beds which extend below floor line.

Figure1.3

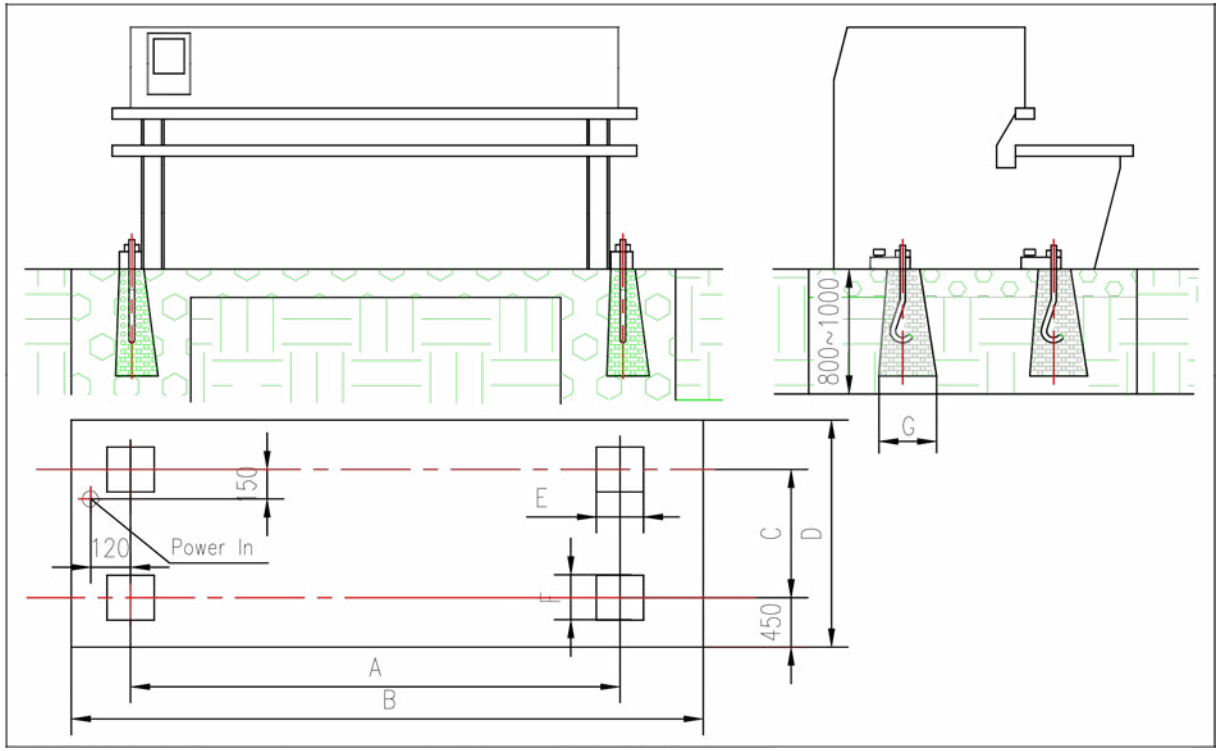


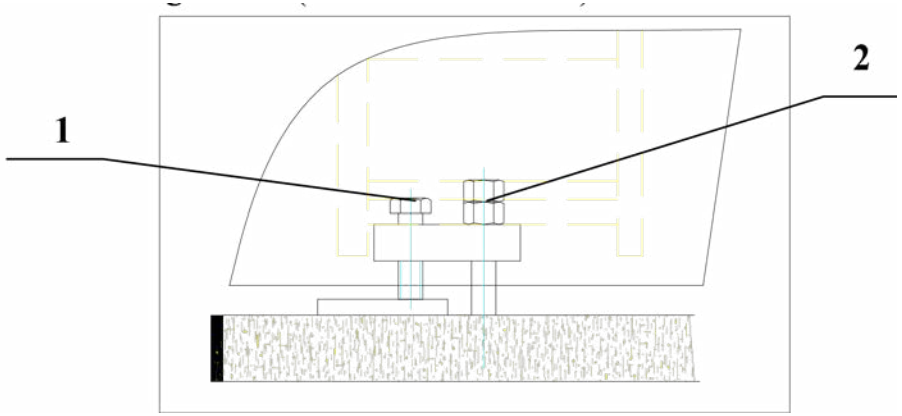
CHART 1-1 FOUNDATION

TYPE	A	B	C	D	E	F	G
6' x 1/4	92.126in	101.969	45.276	74.803	5.906	5.906	7.874
8' x 1/4	113.780	137.800	45.280	74.803	5.906	5.906	7.874
10' x 1/4	141.339	165.354	45.280	74.803	5.906	5.906	7.874
13' x 1/4	172.835	196.850	45.280	74.803	5.906	5.906	7.874
8' x 3/8l	119.690	161.417	45.280	78.740	6.693	6.693	9.843
10' x 3/8	147.244	188.976	45.280	78.740	6.693	6.693	9.843
13' x 3/8	180.315	220.472	51.181	98.425	6.693	6.693	9.843
8' x 1/2	119.690	161.417	45.280	78.740	6.693	6.693	9.843
10' x 1/2	147.244	188.976	45.280	78.740	6.693	6.693	9.843
13' x 1/2	180.315	220.472	51.181	98.425	6.693	6.693	9.843

6. LEVELING

1. Make sure all rust preventative and foreign matter are removed from the table.
2. Use a precision level, not a carpenter's or machinist's level. The level must ecalibrated to within 0.1mm per meter to properly level the shear. Please the level on the table. Check the level with horizontal and vertical direction.
3. Adjust the leveling screws(SEE FIGURE 1.5)

Figure1.5



Loose nut 2 then adjust bolt 2 to adjust.

4. After the shear is perfectly, tighten the mounting bolts. Recheck both ends of the shear to make sure it is still level. If the shear is not level, make any necessary corrections and retighten the mounting bolts.

TRANSPORTATION AND INSTALLATION

1. **Shipping and Receiving**
   Immediately upon receiving your press brake, visually inspect the machine for any external damage. If damaged, notify the carrier for claims inspection and advise the distributor.

2. **Storing Conditions**
   The machine is delivered in such a way that it would not sustain any damage upon consignment.
   a.) If the machine is to be stored in a damp environment, moisture removing materials should be placed in the electrical panel and around the hydraulic block to keep the parts protected.
   b.) In order to prevent the punch and die from rusting, protective oil should be used.
   c.) The machine must be carefully protected against sunlight.
   d.) Storage must be never carried out in the open air (wet environment), or defects may occur in the valve sockets or electrical parts.

3. **Operation Area of the Machine**
   It is recommended to have ample space for working around your machine. (See Figure 1.1)

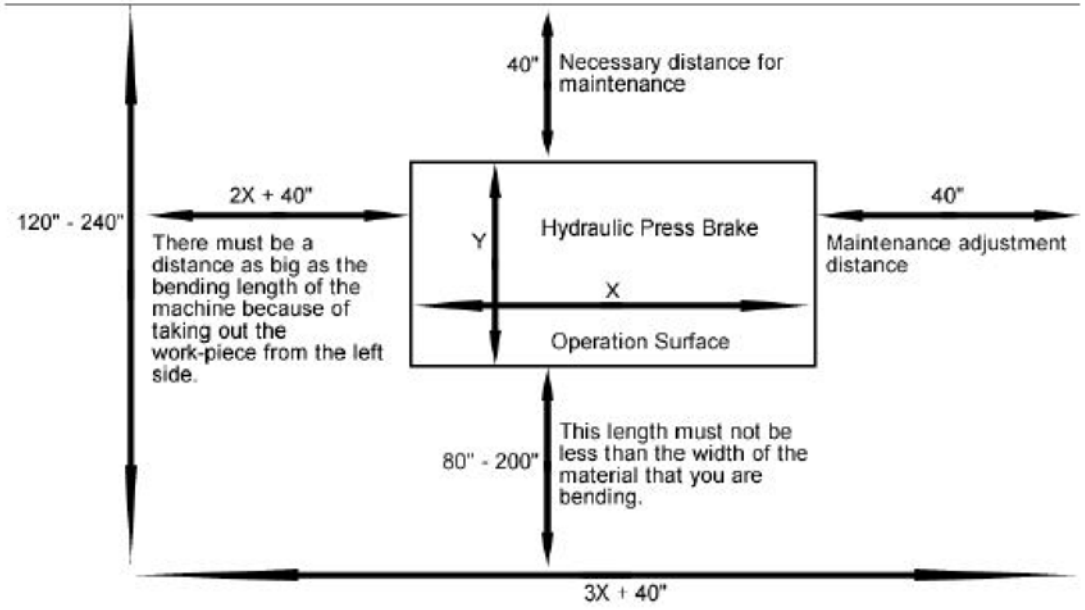


Figure1.1

4. Unloading

To unload the machine, use a crane of sufficient capacity or rig the machine to the foundation. (See Figure 1.2)

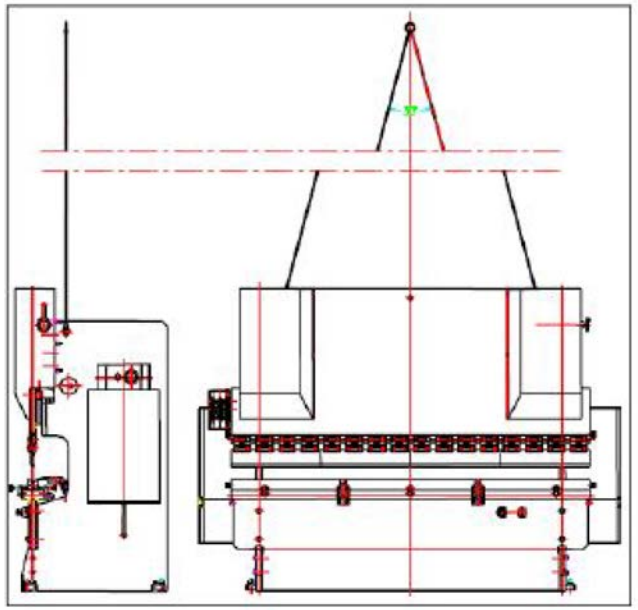


Figure 1.2 (Lifting)

WARNING

The Machine is heavy in the front. Guard it againsit tipping over until anchor bolts are secured. Do not attach lifting equipment to shafts or cross braces. These will not support the weight of the machine. Use protective measures to prevent damage to finished surfaces.

5. Foundation

(See Figure 1.3)

a) Before moving the machine, check the foundation site. The foundation must be rigid enough to support the machine without settling.

b.) Check the location of the foundation bolts. The bolts must match the spacing and alignment of the bolt holes in the machine houseing feet, or toes.

c.) Prepare for shimming by placing steel plates of equal thickness over each foundation bolt. These plates will provide a bearing surface for leveling shims.

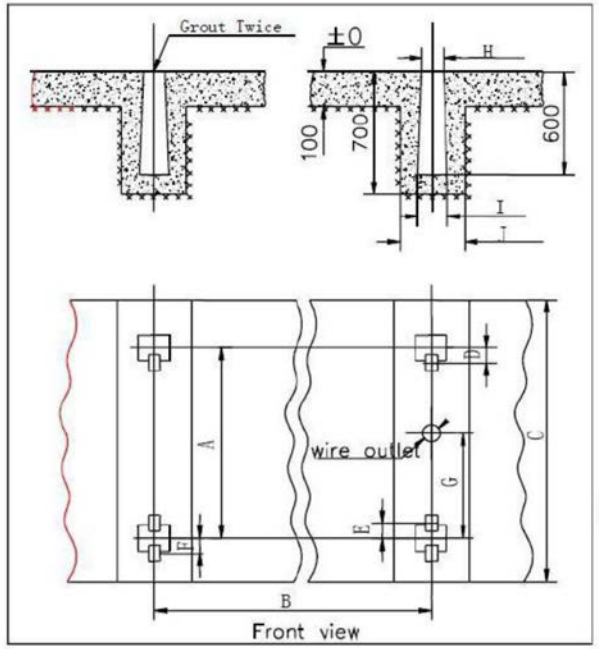


Figure 1.3 Foundation

CAUTION When grouting is used, grout only under housing feet.

FOUNDATION PARAMETER LIST

Model USHB	A	B	C	D	E	F	G	H	I	J
22x4	25.512	44.291	43.307	2.992	-	2.953	11.811	5.906	7.874	15.748
44x6	37.598	70.079	56.299	2.953	-	2.953	18.898	5.906	7.874	15.748
88x8	39.764	86.614	58.465	2.953	-	2.953	20.669	6.693	9.055	15.748
88x10	39.764	111.024	58.465	2.953	-	2.953	20.669	6.693	9.055	15.748
125x8	40.354	86.22	62.992	2.953	2.953	-	31.102	6.693	9.055	15.748
125x10	47.244	112.205	62.992	2.953	2.953	-	31.102	6.693	9.055	15.748
155x8	49.212	84.646	68.898	2.953	-	2.953	32.283	6.693	9.055	15.748
155x10	49.212	112.205	68.898	2.953	-	2.953	32.283	6.693	9.055	15.748
155x13	49.212	129.921	68.898	2.953	-	2.953	32.283	6.693	9.055	15.748
200x13	46.457	134.252	70.866	2.953	2.953	-	31.102	6.693	9.055	15.748
250x13	48.425	131.496	86.614	5.118	-	5.118	39.370	6.693	9.055	15.748

6. Leveling

a.) Make sure that all rust-preventative and foreign matter is removed from the table.

b.) Use a precision level, not a carpenter's or machinist's level. The level must be calibrated to within 0.1mm per meter to properly level the press brake. Place the level on the table and check the level with horizontal and vertical direction.

1. Check the horizontal level. (Figure 1.4)

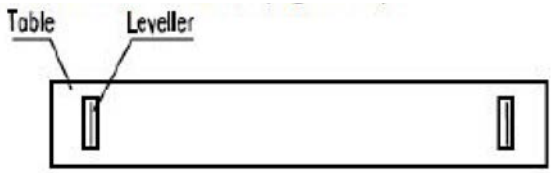


Figure 1.4

2. Check the verticall level. (Figure 1.5)

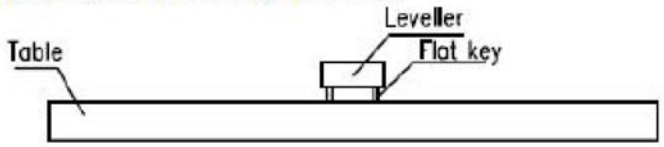


Figure 1.5

c.) Adjust the leveling screws. Loosen nut 2, then adjust bolt 1. After, bolt 3 must be screwed down. (Figure 1.6)

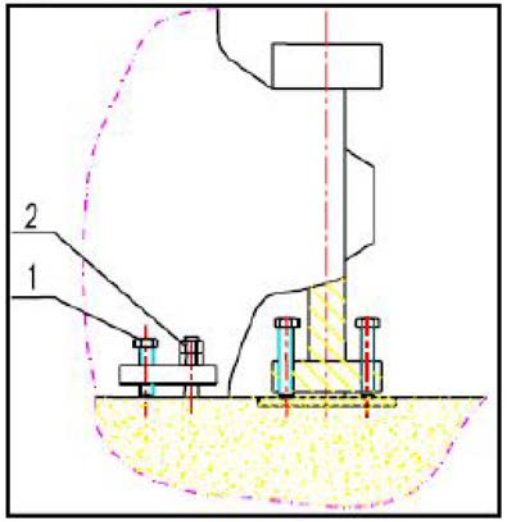


Figure 1.6

d.) After the press brake is perfectly in place, tighten the mounting bolts. Re-check both ends of the press brake to make sure it is still level. If the machine is not level, make any necessary corrections and re-tighten the mounting bolts.

U.S. INDUSTRIAL MACHINERY

120 Webster Ave, Memphis, TN 38126
P.O. Box 2098, Memphis, TN 38101
800-860-1850
901-527-8671