

# Hydraulic Shearing Machine

Model: HQ01-5214B  
HQ01-9816B

## Operation Manual

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## I .Structure and Use

The power of this shearing machine is hydraulic drive, transmit smooth. The major components such as Machine frame, upper knife frame, work table, etc. are all with welded-steel plate construction, make it with high strength of structure, nice appearance, compact, safety and reliable. With electric back gauge and digital feed, fast and accurate.

This machine is suitable for metal plate processing, electrical, automotive and sheet metal cutting process.

## II .Main Technical parameter

### HQ01-5214B

No.	Technical Parameter	value	Unit	Remarks
1	Max.shearing thickness	2	mm	
2	Max.shearing width	1320	mm	
3	Height of work table	800	mm	
4	Max. Distance of back gauge	800	mm	
5	Motor power(kW)	1.5	Kw	
6	Packing size	198x92x143cm		

### HQ01-9816B

No.	Technical Parameter	value	Unit	Remarks
1	Max.shearing thickness	1.6	mm	
2	Max.shearing width	2500	mm	
3	Height of work table	800	mm	
4	Max. Distance of back gauge	800	mm	
5	Motor power(kW)	2.2	Kw	
6	Packing size	314x99x143cm		

## III.Swing and Installation

Moving: When moving , must ensure the machine keep balance and stable. should be moved by forklift or crane.

## IV .Test run and Preparation before test

1. After installation, must clean the anti-rust oil and the dust on the machine away.
2. Check the screws, nuts, etc on each connection to make sure they are without looseness, the transmission part should be no obstruction
3. Inject clean hydraulic oil into the tank: summer (when ambient temperature is high) with 46 # hydraulic oil, winter (when ambient temperature is low) with 32 # hydraulic oil. Generally oil level position should be to the upper part of content gauge.
4. Check oil road whether smooth according to lubrication instructions, and inject lubricating oil.
5. Check the electrical components in electrical box to make sure they without any looseness, then plug in and connect earth wire, start the motor (pay attention to direction of rotation, reversal is prohibited!), Observe whether abnormal phenomena or not. And check whether system pressure need adjust (10Kpa, have been adjusted when leave factory), if not please adjust. Start motor for idle running.
6. Check whether the gap value between up blade and down blade is the same as cutting thickness
7. Cutting according to the operation manual.

## V. Lubrication

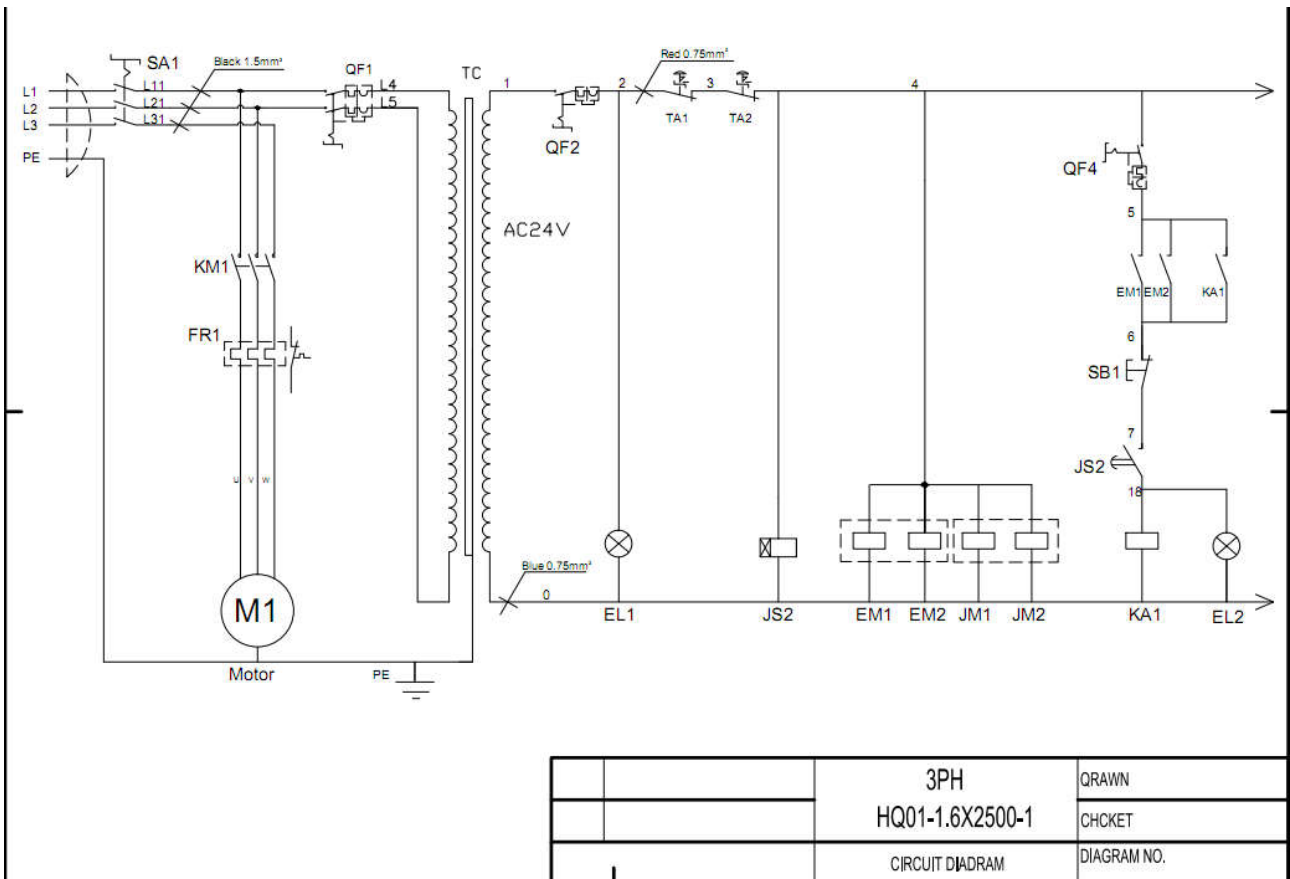
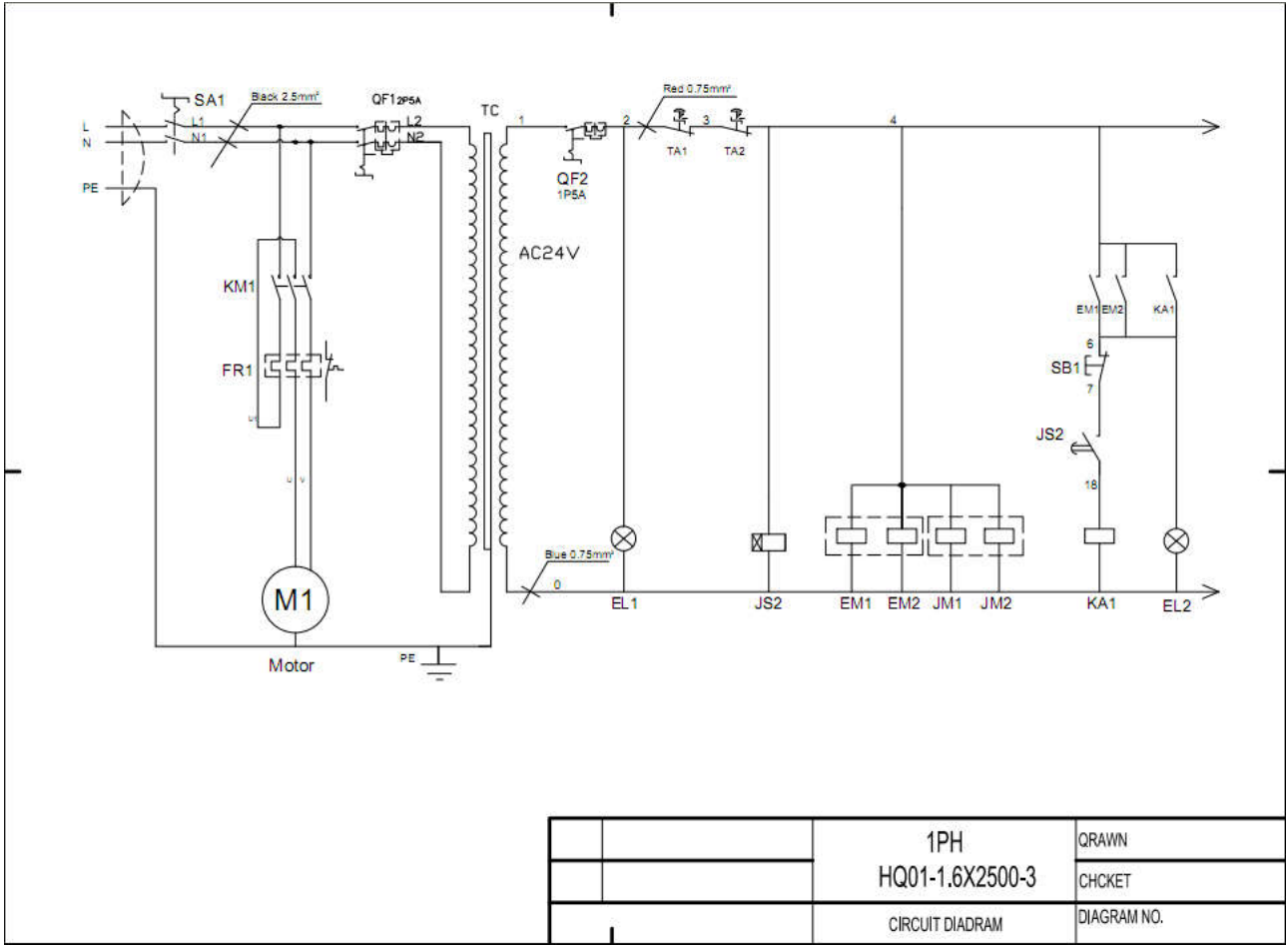
Serial No.	Lubrication position	number of lubrication	Time of lubrication	Type of lubricants
1	Upper parts of Top rest	2	1/ per shift	Machine oil
2	Axis pin of top rest	2	1/per shift	Machine oil
3	Copper sleeve of principal axis	2	1/per shift	Machine oil
4	Axis pin of connecting rod	2	1/per shift	Machine oil
5	End of hydraulic cylinder	2	1/per shift	Machine oil

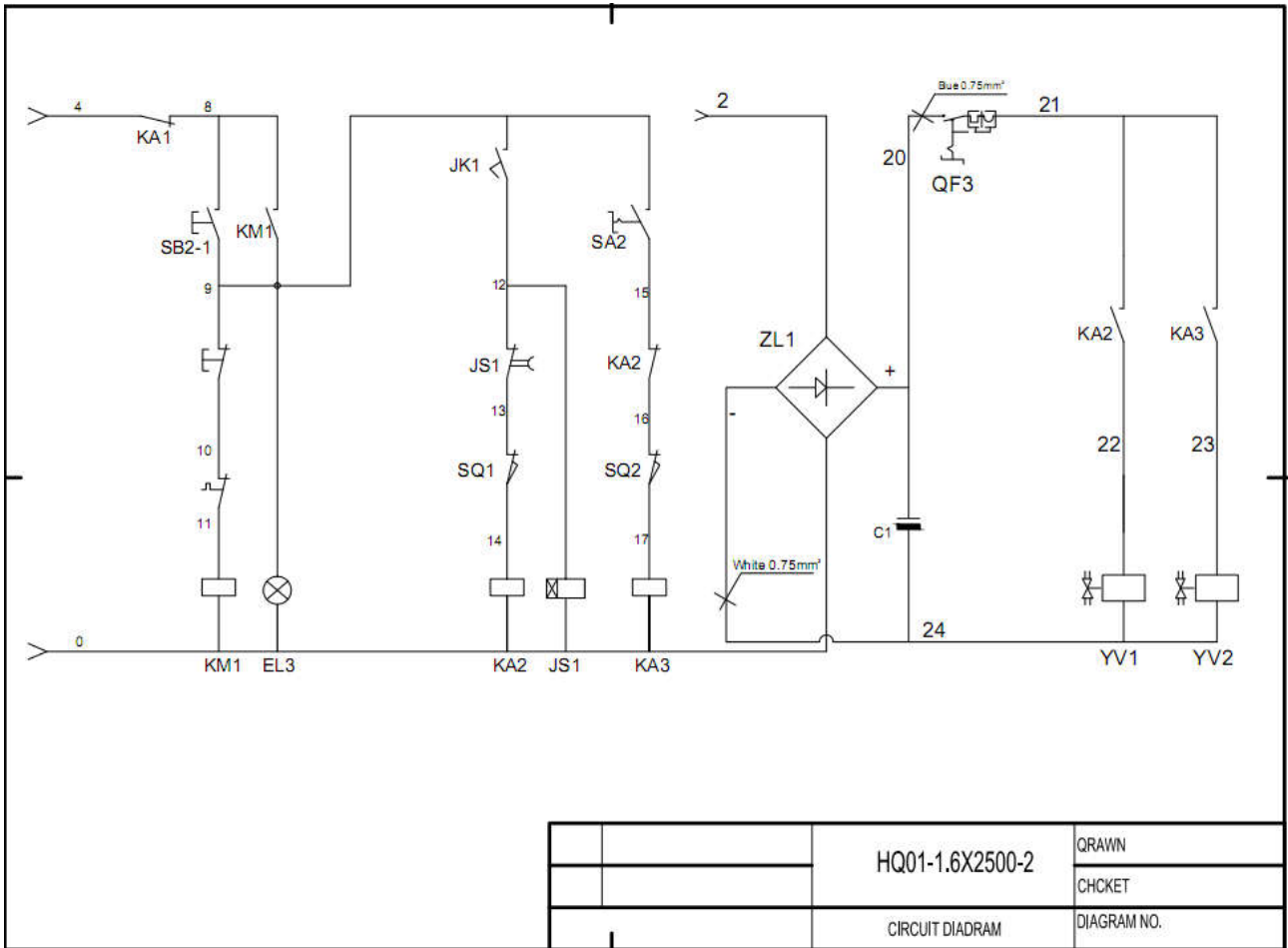
## VI.Repair and Maintenance

- 1、 The machine must be operated by specially-assigned person, should read the instruction manual carefully before operation.
- 2、 The machine must be kept clean, the parts without painted and sliding parts should be coated with grease, should be coated with anti-rust oil if don't use for a long time.
- 3、 Cutting blade should be kept sharp, if damaged and wear down should be sharpen or replace timely; should avoid cutting material with exceed thickness, or with hard scars, slag, welding line, etc defects such as edges or exorbitant hardness material.
- 4、 Should use clean and non-corrosive grease.
- 5、 Operate according to rules, do not overload the machine in order to avoid damage machine parts.
- 6、 While working, whether what anomalous thing happend, should stop operation immediately, poweroff, and inform relevant department to check.
- 7、 Poweroff when finished work, and clean up the machine.
- 8、 Should check circuit regularly, pay attention to motor's rotary direction when examine and repair motor or re-connected circuit after break.

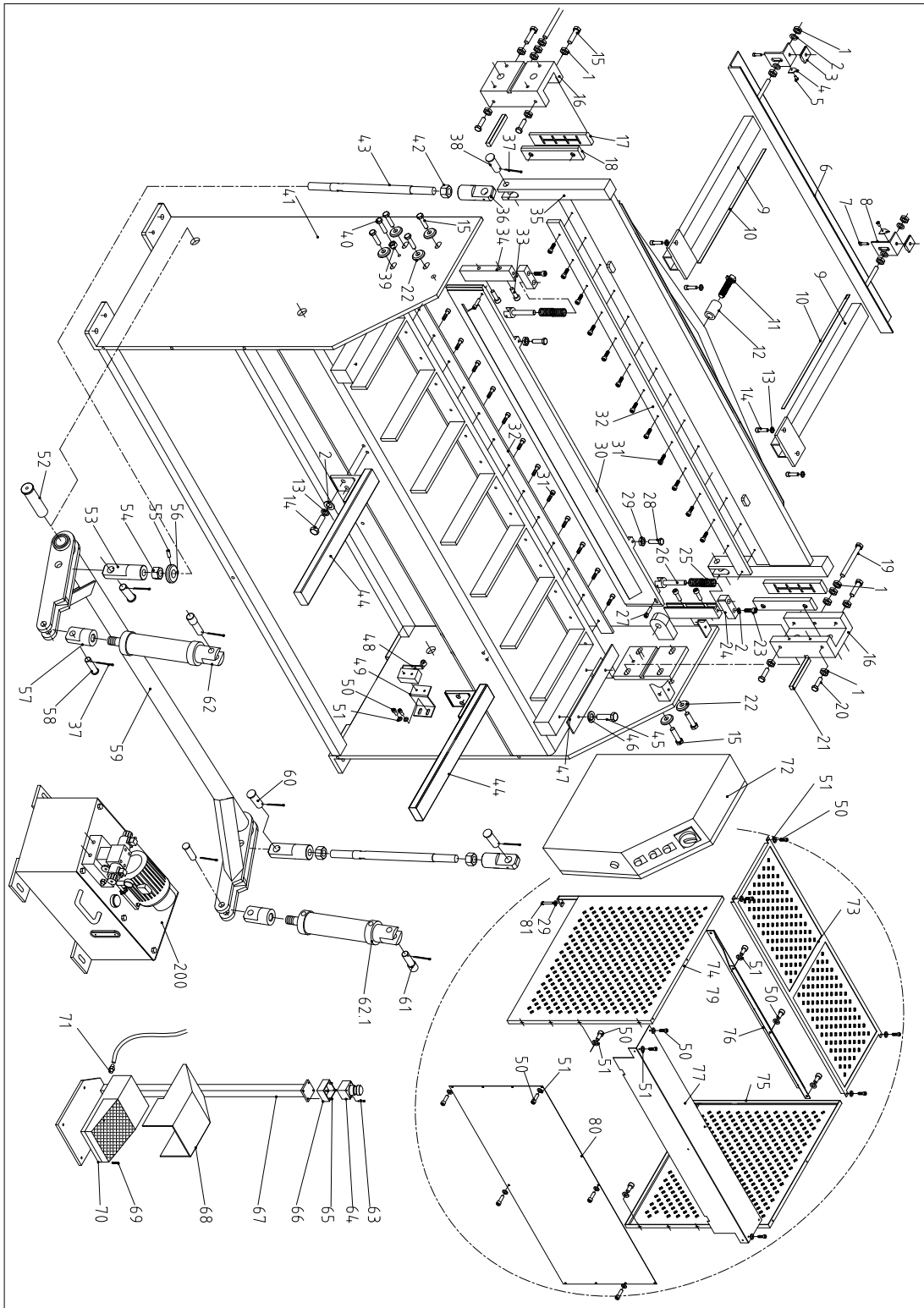
**Note:** The first installation, it is necessary to keep the oil level in tank, should mend oil appropriately after one work cycle, oil level is too low or idling without oil is prohibited. Replace new oil after 100 hours from add hydraulic oil at first time, after can replace new oil each year (about 1500 working hours).

## VII. Electrical part





VIII.Drawing and Parts List



NO.	Designation	Specifications	Qty
1	nut	M10	38
2	washer	10	40
3	washer		2
4	pointer		2



5	rivet	2X5	2
6	stock angle steel		1
7	bolt	M10X20	2
8	adjustment angle steel		2
9	stock torque tube		2
10	after the scale		2
11	adjustment bolt		1
12	Long sleeve		1
13	spring washer	10	8
14	bolt	M10X30	8
15	bolt	M10X45	20
16	slide		2
17	after the skateboard		2
18	before the board		2
19	bolt	M10X110	2
20	bolt	M10X35	4
21	article guide		2
22	washer		8
23	screw	M10X40	2
24	press cake		2
25	pressure spring		2
26	leader		2
27	screw	M6X30	2
28	bolt	M8X40	2
29	nut	M8	4
30	pressure feeder		1
31	screw	M10X20	48
32	blade		2
33	screw	M8X35	4
34	guide groove		2
35	top rack		1
36	connection on the body		2
37	cotter pin	3X45	8
38	shaft		4
39	nut	M10	2
40	bolt	M10X70	2
41	rack		1
42	nut	M20left	2
43	tie rod		2

44	carrier aircraft		2
45	bolt	M8X20	2
46	washer	8	2
47	guide plate		1
48	limit travel switch		2
49	travel switch bracket		2
50	screw	M6X12	38
51	washer	6	38
52	shaft		2
53	connect body		2
54	nut	M20	2
55	screw	M6X16	2
56	touch panel		2
57	hydraulic cylinder joint		2
58	shaft		2
59	link span		1
60	shaft		2
61	shaft		2
62	hydraulic cylinder		1
62.1	hydraulic cylinder		1
63	screw	ST4.2X45	4
64	emergency stop	LA42J-01	1
65	screw	M4X12	4
66	a single switch box		1
67	foot switch bracket		1
68	foot switch cover	YBLT-YDT1/11	1
69	screw	M4X12	4
70	foot switch	YBLT-YDT1/11	1
71	not to take off	M20X1.5	1
72	the electrical box		1
73	on the net		1
74	left retainer		1
75	right retainer		1
76	sliding plate		1
77	cover		1
80	former guard		1
81	bolt	M8X40	2

**Note:** This manual is only for your reference. Owing to the continuous improvement of the machine, changes may be made at any time without obligation on notice. And please note the local voltage while operating this electric machine.