



ishear

GUILLLOTINE SHEAR



1950

MVD produced its first machine .

1971

The first sheet metal working machine “perforation press” was presented to the market.

1974

The production of “Heavy-duty Press Brakes and Guillotine Shears” started and MVD had the distinction of being the first Turkish manufacturer for heavy press brakes and shears.

1981

Moved to second factory and added the production of 4 roll bending machines and Expanded Metal presses in the next years. Thus, a great variety of machines were presented in sheet metal working industry.

1994

MVD produced the first tandem press brake in Turkey.

2001

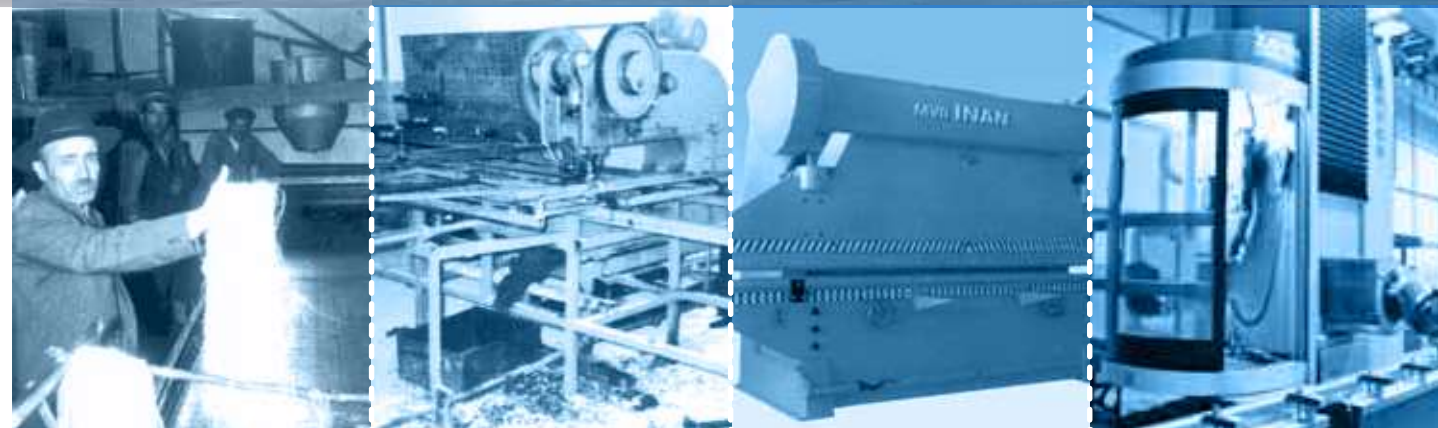
Finalised the CE conformity procedures and had its machines CE marked.

2003

CNC Hydraulic Turret Punch machine was presented to the market.

2011

Plasma cutting machine and Fiber Laser Cutting machines were presented to the market.





Quality High Technology

Quality and service support is accepted as principle. Designing and manufacturing are based on reliability, durability and precision.

Machines are easy to use and are built to be ready for user errors. Machines are designed and analyzed with 3-D supported computer aided programs, precisely machined in moving column CNC machining centres, equipped with world-known equipments and presented to the customers' use after quality control.



iShear B Series

HEAVY-DUTY HYDRAULIC SWING BEAM SHEARS



**HIGH SPEED
CUTTING QUANTITY**
DOUBLE SPEED SYSTEM

General Features

- ▶ Special Design MVD swing beam shears provide up to 25 cutting stroke per minute .
- ▶ When cutting thin sheets, up to 50% faster cutting and efficiency gains achieved with high speed,
- ▶ precise cutting is provided for thick materials with slow speed working mode .
- ▶ Manufactured in sizes 3 meters to 6 meters and capacities 6mm to 20mm .
- ▶ Provides high cutting quality with low cutting angle design machine concepts
- ▶ Construction feature has a fixed angle of cut
- ▶ Machine can produce with automatically blade gap and stroke adjustment by CNC controller according to customer's request
- ▶ Machine body and upper beam's made of steel constructions, has been designed according minimum stretch and optimum resistance criteria
- ▶ Body, as the manufacture of precise CNC machining center for provide maximum cutting quality and accuracy.
- ▶ Body, as the manufacture of precise CNC machining center is a single operation
- ▶ Designed Heavy –Duty rigid body concept in order to prevent deflections.
- ▶ Back gauge range (stroke) 1000 mm .
- ▶ Back gauge accuracy performed with linear ball shaft, without backlash guide
- ▶ Programmable back gauge has 0,1 mm positioning tolerance and retract features .
- ▶ Automatic swing –up feature of backgauge after 1000mm to feed longer sheets easily

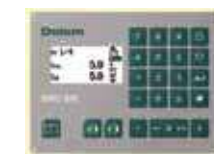
▶ Controller



▶ Elgo P9521 NC
Standard



▶ Cybelelec Touch 6
Optional



▶ Delem DAC 310
Optional

iShear B Series

Standard Equipments

- ▶ NC Controller
- ▶ Easily adjustable with scale blade gap setting system for precise cutting and long life blade's
- ▶ Movable controller arm
- ▶ Roller bearings on the table to help feeding sheets to the machine easily
- ▶ Welded monoblock, heavy steel frame using rigid structural steel produced with modern manufactured methods
- ▶ Automatic, Digital controlled motorized back gauge 1000 mm range (stroke) with ball shaft and guide system.
- ▶ Programmable back gauge, with retract and swing up features for longer sheets
- ▶ Prevents scratching of the sheet with ball on the table
- ▶ Hydraulic Sheet hold down system, holds the sheet in place during the cutting process.
- ▶ Cylinders, processed as precise from solid full material and made honed.
- ▶ Pistons, processed from forged steel, hardened, grinding is done, and chrome-coated.
- ▶ Simple and Easy operations Blade Gap adjustment system
- ▶ Adjustable bottom blade holder
- ▶ Double Speed machine concept
- ▶ Stroke adjustment on the control panel for increase stroke number for short cutting efficiency
- ▶ High Quality alloy material bottom and upper blade for long life
- ▶ Bottom Blade 4 edges, Upper Blade 2 edges
- ▶ No maintenance dry ball joint system
- ▶ Hoerbiger or Bosch Rexroth low maintenance hydraulic block
- ▶ Schneider-Telemecanique electrical components, with ventilations electrical cabinet
- ▶ Foot pedal stand suitable for serial cutting operation and setting blade adjustment
- ▶ Front support arms 1000mm, with scale and flip over stops in T slot
- ▶ Back and side protection covers
- ▶ CE conformity rear light beams
- ▶ Shadow, illuminations cutting line
- ▶ Emergency stop button
- ▶ Oil tank level indicator
- ▶ Complete electrical switch board and control panel for 400V AC 3 Phase 50Hz

Equipments



▶ Automatic swing –up feature of back gauge after 1000mm sheets back gauge



▶ Throat



▶ Roller Bearing Top Table



▶ Blade Gap Adjustment system



▶ Front Finger Protection Open able 1000 mm



▶ Rear Protection Light Beams



▶ Adjustable Angular Gauge
Optional

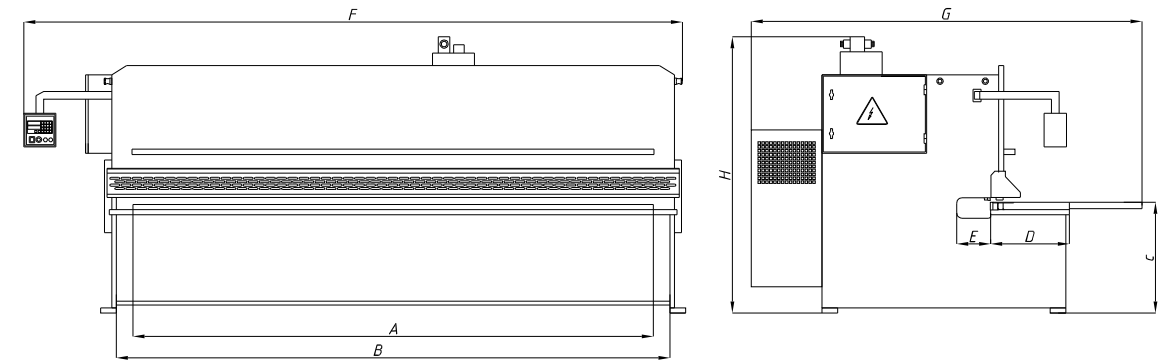


▶ Pneumatic sheet support system
Optional

iShear B Series

Optional Equipments

- ▶ CNC AUTOSET (bladegap,stroke) OPTIONS Automatically stroke, blade gap adjustment by CNC
- ▶ Controller Cybelec Touch6 or Delem DAC310 (automatically calculations according material type and thickness, cutting lengths).
- ▶ Pneumatic sheet support system
- ▶ Cybelec Touch 6 Touch panel CNC controller
- ▶ M25 CNC Controller
- ▶ Delem DAC 310 CNC Controller
- ▶ Adjustable Angular Gauge for cutting angle parts 0-180°
- ▶ Front Finger Protection Open able 1000 mm
- ▶ Special Throat 500mm
- ▶ Front finger protection light barriers with CE conformity
- ▶ Special Blade for kind of cutting material
- ▶ Longer Front Support Arms
- ▶ 220-240V 60hz operating voltage
- ▶ 440-480V 60hz operating voltage
- ▶ 220-240V 60Hz and 440V-480V 60 Hz double operating voltage (by preliminary preparation)



Technical Table

iShear B series		B06-3000	B08-3000	B10-3000	B13-3000	B16-3000	B20-3000	B06-4000	B08-4000	B10-4000	B12-4000	B14-4000	B16-4000	B20-4000	
Cutting capacity (450N/mm2)		6	8	10	13	16	20	6	8	10	12	14	16	20	mm.
Cutting capacity (700N/mm2)		4	5	6	8	10	13	4	5	6	8	9	10	13	mm.
Cutting length	A	3000	3000	3000	3000	3000	3000	4000	4000	4000	4000	4000	4000	4000	mm.
Cutting angle		1,5	1,9	2	2,1	2,25	2,75	1,5	1,5	1,5	1,8	1,8	2	2	degree
Hold Down Cylinder		12	13	14	14	17	17	18	18	17	17	18	18	18	Unit
Speed Stroke per minute / High Speed		18/23	13/19	13/19	10/14	7/10	7/10	10/14	13/20	11/17	9/15	6/20	5/16	4/15	1/min
Distance Between Columns	B	3230	3230	3240	3240	3290	3290	4230	4240	4240	4320	4350	4375	4390	mm.
Table Height	C	850	850	850	860	850	900	850	850	865	915	900	900	960	mm.
Table Width	D	500	580	600	620	625	655	600	630	630	660	660	680	710	mm.
Throat Depth	E	--	250	250	250	200	150	250	250	250	250	250	100	250	mm.
Backgauge Travel Distance		1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	mm.
Stroke		1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	mm.
Machine Length	F	4300	4330	4350	4400	4450	4450	5340	5350	5370	5450	5450	5480	5700	mm.
Machine Height	H	1650	2150	2200	2400	2400	2600	2150	2200	2380	2400	2400	2420	2850	mm.
Machine Width	G	2620	2850	3100	3150	3250	3450	2900	2950	3000	3000	3050	3100	3150	mm.
Oil tank capacity		160	230	230	230	315	350	220	220	280	370	370	370	370	lt.
Motor Power		11	15	22	22	30	45	11	22	22	30	30	30	45	Kw.
Weight		6000	8000	9000	11000	16500	21000	10200	12500	16500	19000	20000	23000	27000	Kg.

Technical specifications are subject to change without notice

Special capacity machines can be manufactured upon request