Specification - **2004 Leimbach scrap shear**
Type HS 960 / 6600 x 2800/2300 – 4/1
Automatic, with rough-pressing device, synchronisation shaft and prefill hopper – right hand configuration
4 x 90 kW – 1 x 45kW Electro / Hydraulic unit

Total weight of machine:	approx. 275 t
net container length	6,600 mm
net container opening	2,800 mm
press container width	2,300 mm
net container depth	1,800 mm
lateral cage height	800 mm
cutting strength	9,600 kN
cutting width	950 mm
max. cutting height	850 mm
cutter angle	12 °
cutting strokes per min.	approx. 5 - 7
cutting length	variable, non-incrementally adjustable
device for holding down plate	4,150 kN
stroke height of device for holding down plate	1,100 mm
lid cylinder	3,400 kN (2 x 1,700 kN)
lid opening	90 °
lateral compression	6,700 kN (2 x 3,350 kN)
forward moving cylinder	2,000 kN
rough-pressed scrap	800 mm x 900 mm x variable
cutting performance in the case of steel with a hardness of 45 Kp/mm^2	metal 95 x 940 mm profile Np 600 shafts 140 - 150 mm squares 130 - 140 mm parts from ship and wagon scrap, process scrap from steel works, e.g. structural steels collected and mixed scrap

Processing is dependent on the dimension and thickness of the material to be processed.

Performance per hour	approx. 24 - 35 t, dependent on scrap type and cutting length (usually 300-800 mm) continual feeding is assumed. These figures are for guidance only.

Automatic regulation of the cutting stroke always corresponds to the strength of the material.

Main drive electrics:

4 electric motors each 90 kW,
400 V, 50 Hz, 1500 rpm.,
protection IP 54 (fully protected)
construction form B3 / B5 (foot / flange design)

1 electric motor 45kW
400 V, 50 Hz, 1500 rpm.,
protection IP 54 (fully protected)
construction form B3 / B5 (foot / flange design)

Auxiliary drives electrics:

Oil cooling filter circulation:

2 electric motors each 7.5 kW

400 V, 50 Hz, 1500min^{-1}
For driving the pump oil cooler
protection IP 54
construction form B3, B5

Cooling valves:

2 electric motors each 2.5 kW
for driving the valve at the oil
cooler

Required connection of energy:

Electric: 400 V; 50 Hz; 3/PE
Overall connection trafo: approx. 900 kVA

Main pumps hydraulics:

4 units of pumps consisted of:
4 high pressure angled disc pumps with power regulator
Bosch-Rexroth make
Production performance 360 Ltr./min
Work pressure 250-335 bar
Testing pressure 420 bar

4 constant dual pumps
Denison make
Production performance 445 Ltr./min/pump
Work pressure approx. 80-130 bar
Testing pressure 200 bar

1 constant full pump
Rexroth Erckel make
Production performance 240 Ltr./min
Work pressure approx. 130 bar
Testing pressure 240 bar

Entire production amount : 3,500 Ltr./min
Work pressure : 315/350 bar

Pump auxiliary units

Oil cooling filter circulation:	2 vane airframe pumps Q= 300 Ltr./min Denison make
Oil tank:	V = 9,000 Ltr.
Hydraulic control:	logical control blocks Moog-Hydrolux make
Electrical control:	freely programmable control Siemens SU 7 / 300 make
Cutting impact damping of shearing cylinder:	To reduce the load of the entire system, a hydraulic counter pressure is produced in the annular space of the shearing cylinder directly after cutting the material, which reduces the cutting impact. Such a tried and tested method of damping the cutting impact is used by Leimbach in all scrap shears as standard.

Complete dimensions of the machine:

length:	approx	17,500 mm
width:	approx.	8,800 mm
height:	approx.	5,700 mm

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