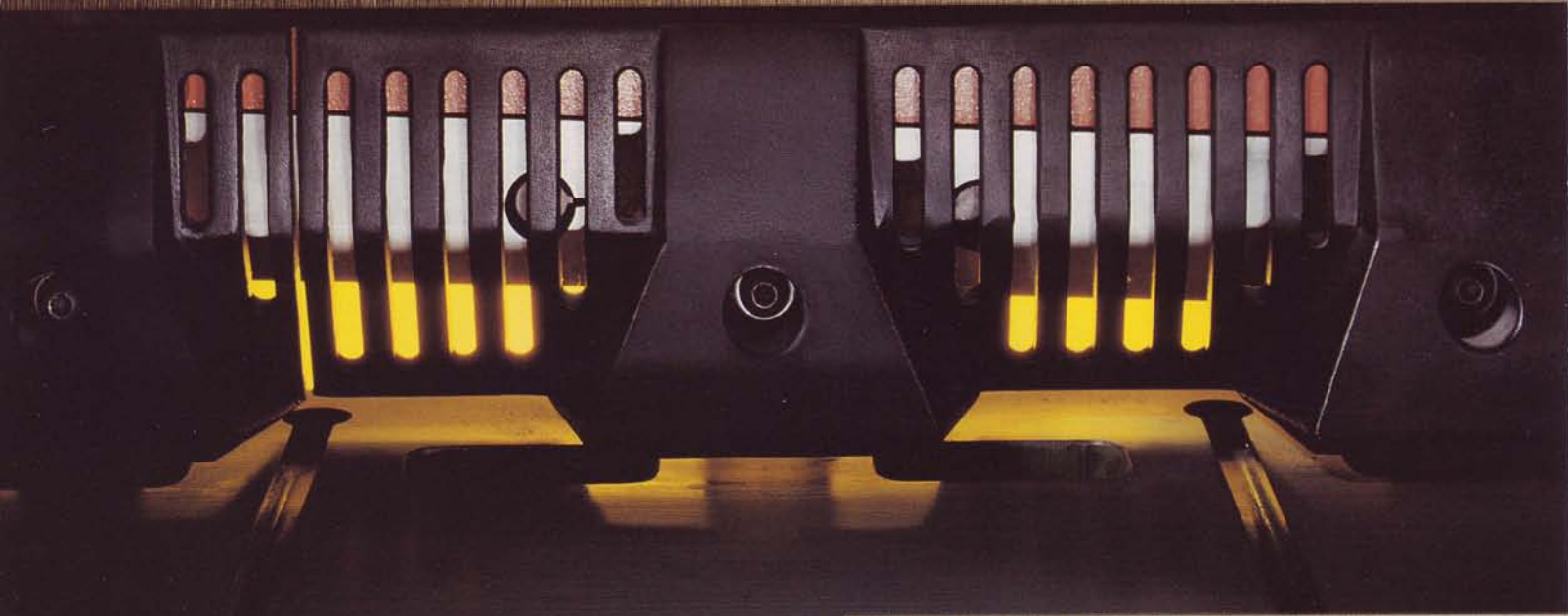


CINCINNATI



**HYDRAULIC SHEARS**

# VALUE

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**EXCELLENT ACCURACY**  
**GREATER PRODUCTIVITY**  
**UNMATCHED VERSATILITY**  
**SOLID RELIABILITY**  
**SUPERIOR SAFETY**  
**PREFERENTIAL SERVICE**

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CINCINNATI hydraulic shears are designed for exceptional performance by every standard, and have proven that performance in hundreds of installations. Their versatility easily handles a wide variety of jobs. They increase productivity through fast, simple setup and easier operation. Superior accuracy provides higher quality blanks and minimizes scrap, while their rugged reliability withstands the toughest applications.



*Model 250HS8 with optional Touchscreen Shear Control, squaring arm, frontgauge support arms*



Cincinnati Shears are designed to meet the construction requirements of ANSI B11.4. Safeguarding covers all moving parts and areas of potential hazards.

Deep, solid shear table resists horizontal deflections to maintain accurate cuts. The table is machined with dovetail slots for gage stops and hand slots for rapid material handling.

Maximum strength steel frame members provide a rigid base while interlocked construction improves reliability by eliminating load-bearing welds.

Hydraulic holddowns on 12" centers clamp material with tons of pressure to prevent slippage regardless of material thickness. Recessed guarding allows close positioning to knives. Close tolerance four-edge ground and hardened knives provide strength, accuracy and multiple edges for long life.

Adjustable knife clearance provides optimal edge quality in different materials, thicknesses and back piece depths.

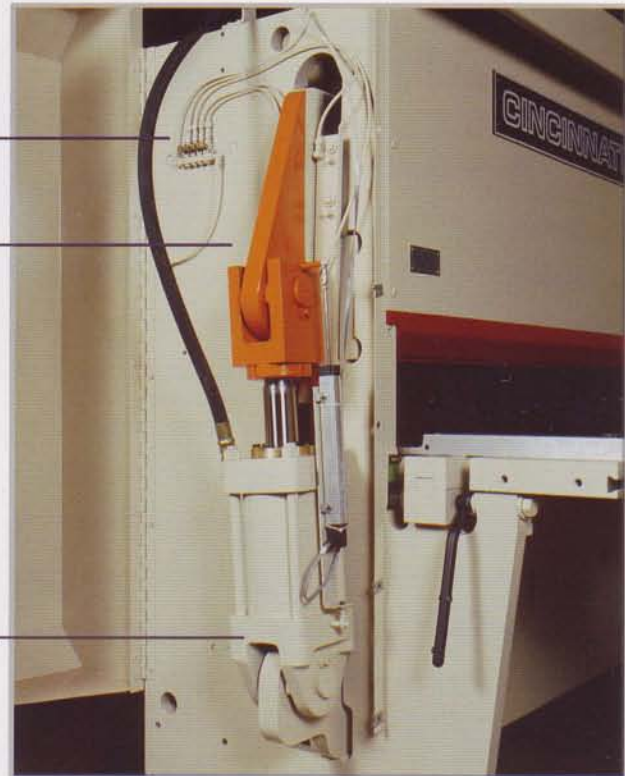
# RELIABILITY

## CINCINNATI SHEARS ARE BACKED BY AN INDUSTRY-LEADING, FIVE-YEAR PARTS WARRANTY.

An automatic system lubricates the front gibs every 200 strokes to ensure years of dependable service. A closed-circuit hydraulic system with dual linear potentiometers maintains the relative position of the two pistons to ensure proper rake angle throughout the stroke.

Unique two-degree inclined ram travel shears the edge perpendicular to the work surface.

Clevis-mounted cylinders with swivel bearings minimize wear to piston seals.



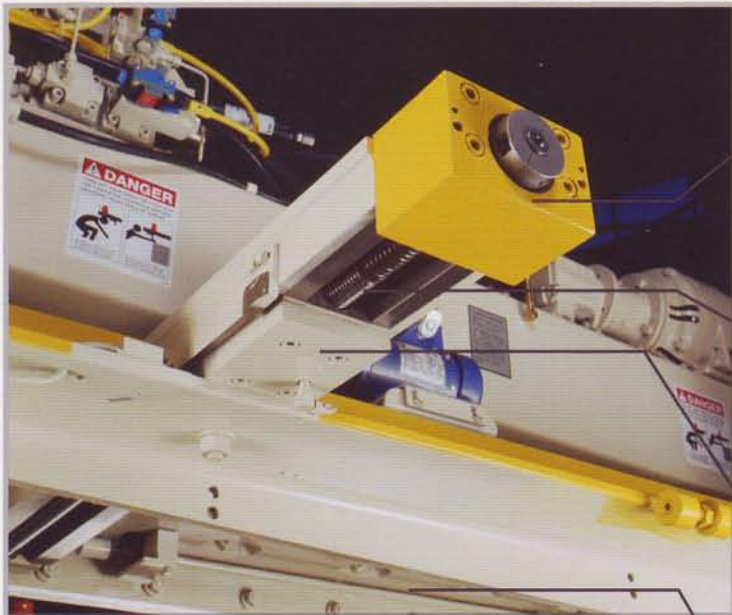
# ACCURACY



Manifold hydraulics with cartridge control valves and O-ring seals reduce piping and maintenance.

Deep, rigid ram brace with precision knife straightener on 12" centers provides superior control of knife clearance without shims (250HS shown).

Twin precision lead screws mounted in heavy-duty steel weldment housings maintain precise backgag positioning.



Micrometer adjustment in .001" increments easily adjusts the gage parallel to the knives. Pull-back cylinders, standard on 250-750 models, avoid material binding between the lower knife and backgag.

Shock-absorbing springs protect backgag screws from material impact.

Automatic backlash compensation, steel guides, bronze slides and automatic lubrication ensure accuracy and long life.

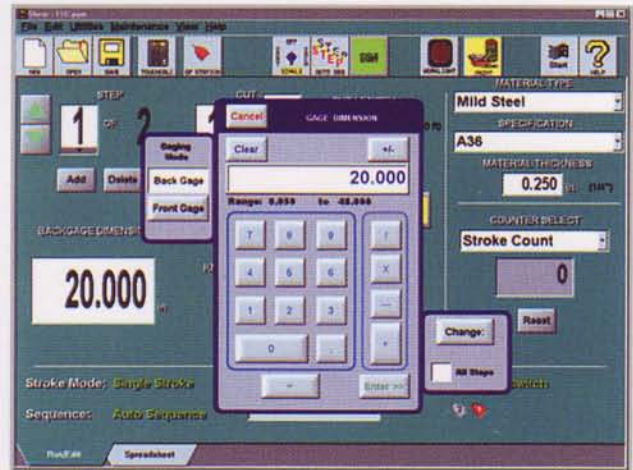
Backgag drive shaft is located underneath the ram brace, preventing damage from lift trucks and crane hooks.



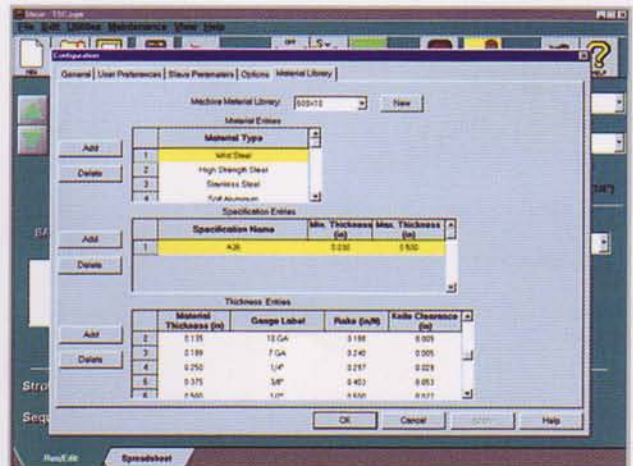
The standard Shear Control Center provides simple, easy-to-use controls for material thickness, cut length, footswitch, optional probes and backgauge settings. The backgauge readout is displayed in increments of 1/64" and numbered every 1/16."



The optional PC-based Touchscreen Shear Control (TSC) provides fast, repeatable setup of the machine and gages for productive shearing and accurate blanks. Repeat jobs can be saved on the hard drive, floppy drive or network storage location using the standard Ethernet communication port.



To produce quality blanks with minimal burr and distortion, preloaded rake and knife clearance parameters are stored in the Material Library. The operator selects material type and thickness to obtain the proper machine settings.



# PREFERENTIAL SERVICE

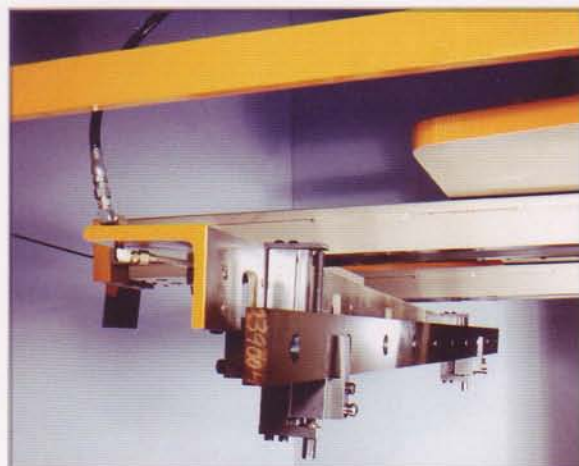


Your shear investment is protected by a comprehensive warranty and service program. Field-based, factory-trained service representatives provide assistance before, during and after installation. Located in major cities throughout the United States and Canada, Cincinnati representatives supervise the installation of new machines, provide startup assistance, demonstrate the equipment, and furnish instruction on operation, maintenance and safety.

Cincinnati Incorporated stocks a large inventory of parts for all Cincinnati shears. Operator and maintenance training programs to help develop the skills of your personnel are available at your facility or at Cincinnati Incorporated.



Each new Cincinnati shear complies with ANSI B11.4 and OSHA construction requirements. Knife and holddown guards, specifically designed for each model, allow a good view of the work area. A unique knife-change fixture is included with each machine for safe and efficient knife handling during rotation or changes.



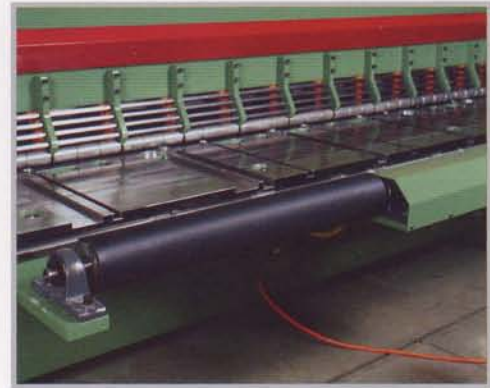
# SAFETY

# STANDARD FEATURES

- Front-controlled power backgage
- 60 ipm backgage speed
- 460/3/60 electricals
- Dovetail and hand slots in shear table
- Automatic lubrication to ram guides and backgage
- Manifold hydraulics with cartridge valves
- Hydraulic oil
- Stroke counter
- Electronic adjustable cut length
- Short stroke on left end
- Hardened piston rods
- Hydraulic holddowns
- Dual holddowns on left end
- Guarded footswitch
- Precision knife straightener
- Knife change fixture
- OSHA and ANSI B11.4 compliance for construction
- Five-year parts warranty, one-year control and labor
- Operator, maintenance, safety manuals
- Adjustable knife clearance (250-750HS)
- Electronic adjustable rake (250-750HS)
- Hydraulic pullback of backgage (250-750HS)
- Dual holddowns on both ends (375-750HS)
- Power swing-up backgage (375-750HS)
- Ball transfers in shear table (500-750HS)
- Air cooled heat exchanger (250-750HS) except 250HS 6', 8' & 14'
- Paint color - Tech beige
- English/Spanish control display



*Power swing-up backgage*



*Power front feed rolls*

- Squaring arm
- Hardened insert in squaring arm
- Frontgage support arm
- Light beam shearing gage and area lights
- Additional footswitch
- Decimal backgage readout in place of fractional
- 208, 230, 575 voltage
- TEFC motors
- Power knife clearance adjustment (250-750HS)
- Touchscreen Shear Control (TSC)
  - Pendant mounted in place of pedestal mounted
  - Ethernet convenience outlet
  - Programmable knife clearance adjustment
- Multi-Axis Gaging with TSC (MATSC)
- Probes in backgage angle (135-375HS)
- Increased backgage range (250HS)
- Increased backgage speed
- Hinged backgage angle (250HS)
- Pneumatic sheet supports (135-375HS) except 375HS14
- Holddown cups
- Cushion clamp holddown system
- Ball transfers in shear table (250-375HS)
- Individual air chambers for ball transfers (375-750HS)
- Power front feed rolls (500-750HS)
- Heater for oil reservoir
- Special paint color
- Special language legend plates



*Pneumatic sheet supports*



*Multi-Axis gaging*

# OPTIONS



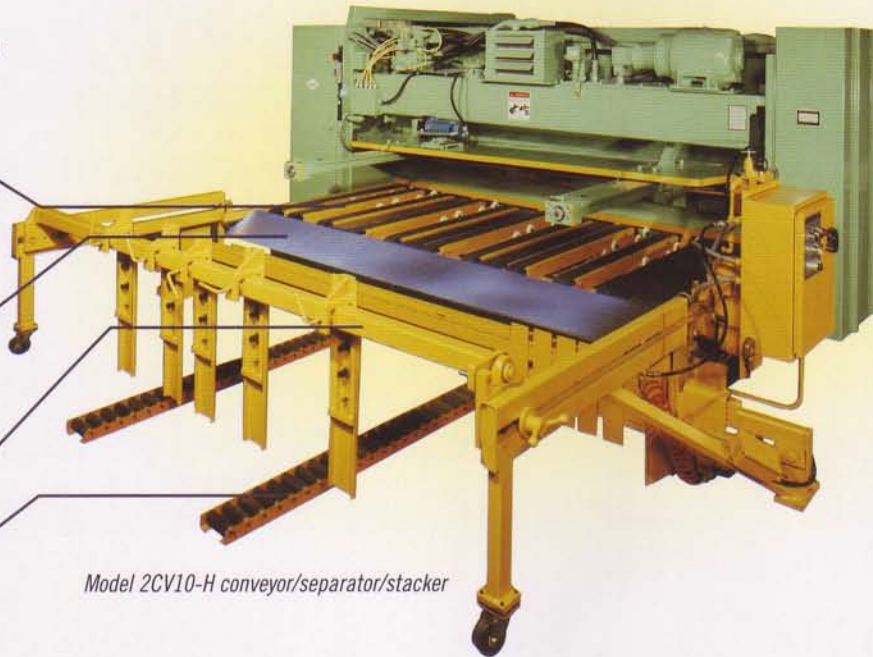
Cincinnati offers a choice of conveyor/separator/stacker and machine options to dramatically speed material handling and free the operator for more productive shearing. A sheet or plate conveyor improves blank accuracy, safely guides blanks from under the shear, and removes finished blanks for stacking. Cincinnati conveyors can be installed on both new and existing Cincinnati shears.

**Conveyor** includes standard features such as steel belts, material support rollers and shielding between belts for smooth material flow.

**Scrap Separator** includes air actuated scrap door and 12" deep bin on casters for quick side removal.

**Stacker** includes heavy tubular frame, pneumatic side tamper, swing out backstops, front stops.

**Optional Roller Conveyors.**



Model 2CV10-H conveyor/separator/stacker

## CONVEYOR/SEPARATOR/STACKER

### STANDARD FEATURES

#### Model 2CV and 4CV Conveyor

- Two 7-1/2" wide belts on left end with remaining 3-1/4" wide belts
- 1-1/2 HP TEFC motor
- 460/3/60 electrics
- Shielding between belts
- Start/Stop "pushbutton" operator station
- Air filter, regulator and lubricator
- 18" convex mirror for hydraulic shears
- Material support rollers
- Paint color: Yellow

#### Separator

- Air-actuated scrap door
- Scrap bin with casters
- Control selector: "normal/open"
- Portable magnetic base "pushbutton" operator station

#### Stacker

- Heavy tubular frame with casters
- Heavy-duty adjustable front stops
- Heavy-duty swing-up adjustable back stops
- Automatic side tamper with manual left/right adjustment, (two on 4CV)
- Pneumatic backstop lift (4CV)
- Drop leaf tamper (4CV)

### OPTIONS

#### Model 2CV and 4CV Conveyor

- Additional belt configurations
- Material supports for 48" range backgage
- Neoprene pads bonded to steel belts
- Bar-type sheet supports
- Roller conveyors
- Conveyor stop button mounted in magnetic operator station in front of shear
- Parts counter
- Footswitch control for material supports
- Pedestal mounted controls in front of machine
- Special paint color
- Special language legend plates
- 208, 230, 575 voltage

#### Separator

- Phenolic cover bonded to scrap door
- Footswitch control for scrap door
- Scrap door open indicator light

#### Stacker

- Increased stack height

Model 6CV conveyor for 750HS is available upon request



Bar-type sheet supports

# HYDRAULIC SHEAR SPECIFICATIONS

MACHINE MODEL	MILD STEEL CAPACITY (1)	CUTTING LENGTH	MAX. RAKE IN. / FT	FORCE TONS			HOLD DOWNS	DISTANCE UNDER	GAGE RANGE			STROKES PER MINUTE		KNIFE SIZE INCHES	MOTOR HP	APPROX. SHIPPING WEIGHT (lbs)
				NUMBER	HOLD/DOWN	GUARD	FRONT (2)	BACK	MAX. (4)	MIN. (5)						
135HS x 6	10 GAUGE	74-3/4"	1/4"	3.5	8	1/2"	1/4"	48-1/2"	36"	85	60	1 x 3 x 78		15	9,200	
135HS x 10	10 GAUGE	122-3/4"	1/4"	5.3	12	1/2"	1/4"	48-1/2"	36"	70	38	1 x 3 x 126		15	11,600	
250HS x 6	1/4"	74-3/4"	3/8"	5.7	8	1/2"	1/2"	55"	36"	65	32	1 x 3 x 78		15	14,600	
250HS x 8	1/4"	98-3/4"	3/8"	7.1	10	1/2"	1/2"	55"	36"	63	26	1 x 3 x 102		15	15,600	
250HS x 10	1/4"	122-3/4"	3/8"	8.5	12	1/2"	1/2"	55"	36"	70	32	1 x 3 x 126		25	16,600	
250HS x 12	1/4"	146-3/4"	3/8"	9.9	14	1/2"	1/2"	58-1/2"	36"	65	28	1 x 3 x 150		25	17,600	
250HS x 14	1/4"	170-3/4"	3/8"	11.3	16	1/2"	1/2"	63-1/2"	36"	52	16	1 x 3 x 174		15	18,600	
375HS x 10	3/8"	122-3/4"	7/16"	14.9	13	5/8"	5/8"	58-1/2"	48"	60	18	1 x 3 x 126		25	19,100	
375HS x 12	3/8"	146-3/4"	7/16"	17.2	15	5/8"	5/8"	63-1/2"	48"	56	16	1 x 3 x 150		25	20,600	
375HS x 14	3/8"	170-3/4"	7/16"	19.5	17	5/8"	5/8"	61-15/16"	48"	41	7	1 x 4 x 172		25	31,600	
500HS x 10	1/2"	122-3/4"	1/2"	20.6	13	1"	1"	53-15/16"	48"	53	19	1 x 4 x 124		40	25,600	
500HS x 12	1/2"	146-3/4"	1/2"	23.8	15	1"	1"	58-15/16"	48"	50	17	1 x 4 x 148		40	28,600	
750HS x 10	3/4"	122-1/2"	3/4"	32.3	13	1-1/2"	1-1/2"	54"	48"	45	10	1-1/8 x 5 x 124		40	35,600	
750HS x 12	3/4"	146-1/2"	3/4"	37.3	15	1-1/2"	1-1/2"	59"	48"	43	8	1-1/8 x 5 x 148		40	39,600	

ENGLISH SPECIFICATIONS

MACHINE MODEL	MILD STEEL CAPACITY (1)	CUTTING LENGTH (MM)	MAX. RAKE ANGLE	FORCE KN			HOLD DOWNS	DISTANCE UNDER (MM)	GAGE RANGE (MM)			STROKES PER MINUTE		KNIFE SIZE (MM)	MOTOR KW	APPROX. SHIPPING WEIGHT (KG)
				NUMBER	HOLD/DOWN	GUARD	FRONT (2)	BACK	MAX. (4)	MIN. (5)						
135HS x 6	3	1895	1 12'	30	8	13	6	1230	915	85	60	25 x 76 x 1981		11.2	4180	
135HS x 10	3	3115	1 12'	45	12	13	6	1230	915	70	38	25 x 76 x 3200		11.2	5275	
250HS x 6	6	1895	1 47'	50	8	13	13	1395	915	65	32	25 x 76 x 1981		11.2	6640	
250HS x 8	6	2505	1 47'	65	10	13	13	1395	915	63	26	25 x 76 x 2590		11.2	7090	
250HS x 10	6	3115	1 47'	75	12	13	13	1395	915	70	32	25 x 76 x 3200		14.9	7550	
250HS x 12	6	3725	1 47'	90	14	13	13	1485	915	65	28	25 x 76 x 3810		14.9	8000	
250HS x 14	6	4335	1 47'	100	16	13	13	1610	915	52	16	25 x 76 x 4419		11.2	8455	
375HS x 10	9	3115	2 5'	135	13	16	16	1485	1220	60	18	25 x 76 x 3200		14.9	8680	
375HS x 12	9	3725	2 5'	155	15	16	16	1610	1220	56	16	25 x 76 x 3810		14.9	9365	
375HS x 14	9	4335	2 5'	175	17	16	16	1570	1220	41	7	25 x 101 x 4368		14.9	14365	
500HS x 10	12	3115	2 23'	185	13	25	25	1370	1220	53	19	25 x 101 x 3149		29.8	11640	
500HS x 12	12	3725	2 23'	210	15	25	25	1495	1220	50	17	25 x 101 x 3759		29.8	13000	
750HS x 10	19	3110	3 35'	285	13	38	38	1370	1220	45	10	28 x 127 x 3149		29.8	16180	
750HS x 12	19	3720	3 35'	330	15	38	38	1495	1220	43	8	28 x 127 x 3759		29.8	18000	

METRIC SPECIFICATIONS

- (1) Refer to CINCINNATI Shear Capacity chart for equivalent capacity thickness based on specific grade of ASTM steels.  
 (2) Front gage range based on use of optional front support arms.  
 (3) Speed is reduced to 5/6 when machine is equipped for 50 cycle service.  
 (4) Maximum strokes per minute based on 12" (300 mm) cut length with minimum rake angle.  
 (5) Minimum strokes per minute based on full length cut with maximum rake angle.

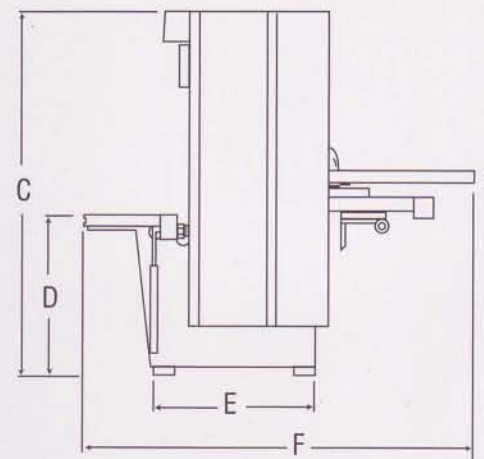
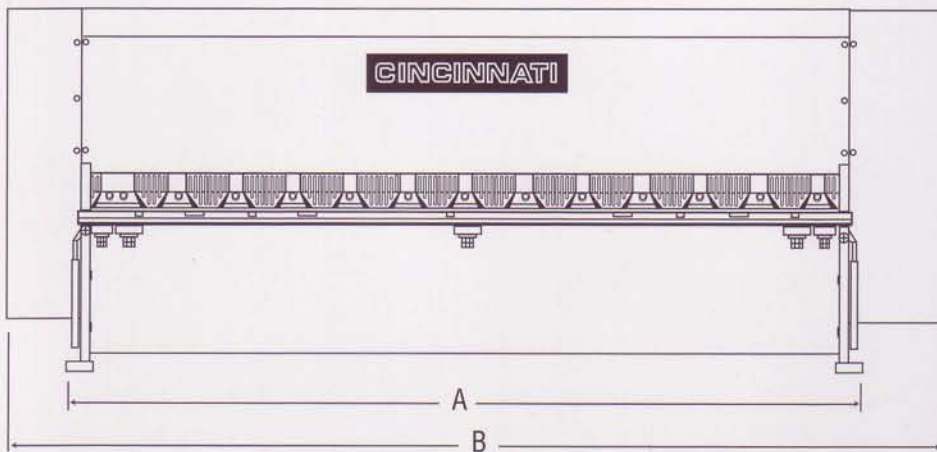
Due to a continuing product development program, engineering data and dimensions are subject to change without notice. Certified foundation plans will be furnished for each installation.

## ENGLISH DIMENSIONS

MODEL	A	B	C	D	E	F
135HS x 6	85-1/4"	123-1/2"	71"	32"	30-1/4"	78-3/4"
135HS x 10	133-1/4"	171-1/2"	71"	32"	30-1/4"	78-3/4"
250HS x 6	89"	124"	73"	32"	33-3/8"	86-3/8"
250HS x 8	113"	148"	73"	32"	33-3/8"	86-3/8"
250HS x 10	137"	172"	73"	32"	33-3/8"	86-3/8"
250HS x 12	161"	196"	73"	32"	33-3/8"	89-7/8"
250HS x 14	185"	220"	75"	34"	37-1/8"	94-7/8"
375HS x 10	139"	173-1/2"	92-5/16"	32"	37-1/8"	100-3/4"
375HS x 12	163"	197-1/2"	92-5/16"	32"	37-1/8"	105-3/4"
375HS x 14	187"	222"	99-5/8"	36"	38-1/2"	108-1/2"
500HS x 10	139"	174"	99-5/8"	36"	38-1/2"	101-1/2"
500HS x 12	163"	198"	99-5/8"	36"	38-1/2"	106-1/2"
750HS x 10	140"	176-1/2"	104-7/8"	38"	46-7/16"	102-7/8"
750HS x 12	164"	200-1/2"	104-7/8"	38"	46-7/16"	107-7/8"

## METRIC DIMENSIONS

MODEL	A	B	C	D	E	F
135HS x 6	2170	3135	1810	820	770	2000
135HS x 10	3390	4355	1810	820	770	2000
250HS x 6	2270	3150	1860	820	770	2200
250HS x 8	2880	3760	1860	820	850	2200
250HS x 10	3480	4370	1860	820	850	2200
250HS x 12	4090	4980	1860	820	850	2290
250HS x 14	4700	5590	1910	870	850	2410
375HS x 10	3540	4405	2345	820	950	2560
375HS x 12	4150	5015	2345	820	970	2690
375HS x 14	4750	5640	2530	920	970	2760
500HS x 10	3540	4420	2530	920	980	2580
500HS x 12	4150	5030	2530	920	980	2710
750HS x 10	3560	4485	2670	970	1180	2620
750HS x 12	4170	5095	2670	970	1180	2740



**CINNATI INCORPORATED HEADQUARTERS INCLUDES MANUFACTURING FACILITIES, OFFICES AND A TECHNICAL CENTER.**



A technologically advanced manufacturer of metalworking machinery, Cinnati Incorporated places its reputation for quality and productivity behind every product.

Cinnati Incorporated maintains a modern industrial facility where product development, manufacturing, sales and support functions combine to assure complete customer service and satisfaction.

An experienced, competent staff of engineers conducts research and development in new areas of metalworking technology, as well as ongoing improvement programs for current products. CAD/CAM machine design contributes to low-cost customization and shorter deliveries.

Customers may visit the Customer Productivity Center to watch parts being cut and discuss unique applications with Product Specialists to verify production efficiency and savings.

Like all CINNATI products, the HS Shear offers exceptional value. To learn more, call your CINNATI representative or phone us direct.



The Customer Productivity Center demonstrates today's latest shearing, forming, stamping and laser-cutting technologies.

**CINNATI**  
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