



PREPARATION FOR SHEARLINE INSTALLATION

KRB normally provides an installation supervisor for two days. This is to ensure that the shearline is properly installed, tested, and customer's personnel are trained in operating and maintenance skills. The installation can be done very effectively if the customer is prepared when the installation supervisor arrives. It is important that the customer does the following.

1. **The area where the shearline is to be installed must be cleared of equipment and cleaned.** This is to make sure loading and unloading will be no problem with proposed location of shearline.
2. The shear must be located, secured to the floor when the exact passline height is determined. The lower blade must be 6mm to 9mm lower than passline of both entry/intermediate conveyor rollers and gage conveyor rollers. Push a 3m long straight bar back and forth from entry to gage. Shim shear accordingly. When rebar conveys in both directions, lower blade of shear should be 6mm to 9mm below rollers.
Please do not secure to floor until KRB Technician has inspected.
3. Upon arrival of the KRB installation supervisor, an **electrician** (electrical power) and **plumber** (compressed air) should be present to discuss electrical and air requirements. Both will need to gather the necessary material so that both wiring and plumbing can begin A.S.A.P. ***We also need a welder and welding machine during installation.***
4. There will be (2) 3-phase power lines required to run the machine, (1) for the console and (1) for the shear. Plus additional power points for any additional equipment supplied. Consult factory for additional locations.

**** NOTE ** Always refer to your layout drawing to confirm the electrical requirements. In some cases, additional electrical services will be needed depending on the options purchased with the shearline.**

5. The customer must have several qualified men to pick up the components of the shearline and position them. Refer to the foundation plan. The customer should have shims precut for leveling purposes. Recommended are (20) 6mm x 100mm x 150mm and (20) 3mm x 100mm x 150mm Hot Rolled Steel Shims. There are two critical dimensions. First, the .5m gauge stop must be .5m from the shear when the measuring table is at 0" (all the way forward towards the shear) Secondly, the intermediate conveyor and the entrance of the measuring table must be slightly elevated 6mm to 9mm above the shear's lower knife to insure smooth conveyance of the rebar.

6. After all the components are positioned, normally 12mm x 100mm concrete anchors are used to secure the equipment to the floor. **The customer should have 1-2 men available with a rotary hammer drill to drill all the required holes and bolt machine to the floor.** Depending on the type shearline 100-300 anchors will be required. ***If KRB Shear is included with the shearline you will need anchor bolts for it. If an A-114 Shear is supplied it will require (6) 1" x 5" concrete anchors, and a H4002/H2000 Shear will require (8) 1" x 5" concrete anchors.***
7. The pneumatic connection requires a compressor unit fitted with an air drying system capable of removing condensate.
The absence of a proper air drying system may cause functioning irregularities and or serious damage to equipment which will void any warranties.
8. Both electrician and plumber can be wiring and running the airlines while the shearline is being secured to the floor.
9. If points 1 and 2 are met, points 3 through 6 can be completed the first day. The second day can be devoted to testing, training, and machine run-in. If all goes well, orders can be processed during the second day.

It is important there is complete cooperation during the installation. By assuring complete cooperation, the customer will receive the best installation.

If you have any questions prior to the installation, please do not hesitate to phone KRB at 717-252-3667. We are looking forward to meeting your people and installing the Shearline.

In advance, thanks for your cooperation.



KRB
1058 Cool Creek Road
Wrightsville, PA 17368
717.252.3667 p. x 218
717.252.9247 f.
www.krbmachinery.com