



Ironworkers

PS • PS DP

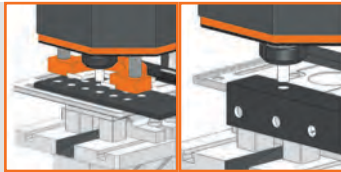
**Multi-purpose machine with 5 work stations
for punching, shearing and notching**



Standard configurations

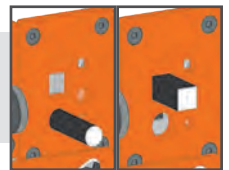
Punching station

- Punching of sheet metal, flat and angle steel
- Sturdy table for high-quality cutting results
- Stepless stroke adjustment
- Adapter for punches and dies



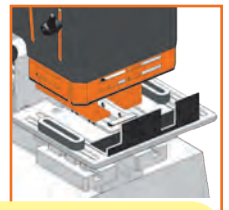
Steelworker

- Cutting round and square steel
- 1000 mm (39.4") back gauge



Notching station

- Table with stops



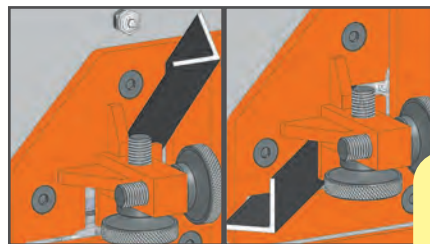
Flat shear

- Lower blade with 4 cutting edges
- Upper blade with 2 cutting edges
- Table with angle and length stop



Angle shear

- Cutting angle profiles at different angles
- Adjustable rear stop



All models available with optional larger radius!

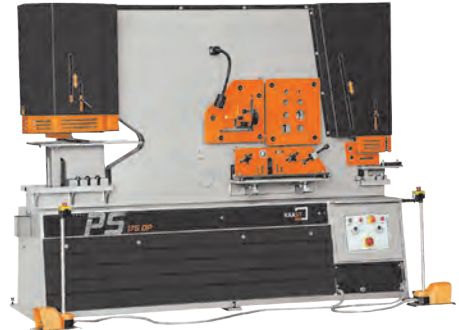
Specifications			PS				
			45 50 tons	65 DP 70 tons	85 DP 90 tons	115 DP 125 tons	175 DP 190 tons
Punching station	Max. capacity (Ø/thick)	mm	Ø22x15 (0.86x0.6") Ø100x3 (3.9x0.1")	Ø26x20 (1x0.78") Ø110x3 (4.3x0.1)	Ø33x20 (1.25x0.78") Ø110x4 (4.3x0.16")	Ø34x26 (1.25x1") Ø55x16 (2.2x0.6")	Ø40x32 (1.57x1.25") Ø57x22 (2.2x0.86")
	Punch stroke length	mm	50 (2")	55 (2.2")		80 (3.2")	
	Strokes/min (20 mm, 3/4")		20		25		22
	Throat	mm	175 (6.9")	305 (12")	355 (14")		625 (24.5")
	Working height	mm	935 (36.7")	1005 (39.5")	1080 (42.5")	1110 (43.7")	1130 (44")
Optional tooling	Rectangular notch	mm	18x12 (0.7x0.5")	38x8 (1.5x0.3")	38x10 (1.5x0.4")	38x12 (1.5x0.5")	
	V-shaped punch and 90° die	mm	100x12 (4x0.5")	250x12 (10x0.5") 500x3 (19.5x0.12")	250x20 (10x0.75") 500x3 (19.5x0.12")	250x22 (10x0.86") 700x3 (27.5x0.12")	250x25 (10x1") 700x4 (27.5x0.15")
Section bar shearing station	Round/Square section	mm	Ø30/25 (1.1/1")	Ø45/45 (1.75/1.75")	Ø50/50 (2/2")	Ø55/50 (2.1/2")	Ø65/55 (2.5/2.1")
	Working height	mm	1115–1180 (45")	1115–1195 (45")	1200–1295 (49")	1160–1250 (47")	1235–1330 (50")
Optional tooling	U/H-section	mm	80x45 (3.1x1.75")	120x58 (4.75x2.25")	160x74 (6.2x3")	200x90 (7.8x3.5")	300x125 (12x5")
	T-section	mm	40x5 (1.5x0.2")	90x11 (3.5x0.4")	100x11 (4x0.4")	120x13 (4.75x0.5")	150x15 (5.9x0.6")
Angle shearing station	Cutting capacity 90°	mm	100x100x10 (4x4x0.4")	120x120x12 (4.7x4.7x0.5")	150x150x15 (6x6x0.6")	150x150x16 (6x6x0.6")	200x200x20 (7.8x7.8x0.78")

*The above specifications are subject to change without prior notice. No liability for printing mistakes. Machine may be shown with optional equipment.



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DP two-cylinder version allows parallel work on the punch as well as a second workstation



Optional configurations



- Motorized back gauge for automatic operation



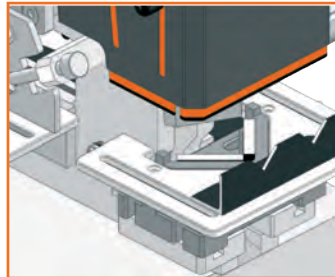
- Station for cutting of the U, T and I-profiles
- The dimensions of the station must be agreed in advance
- Punches and dies



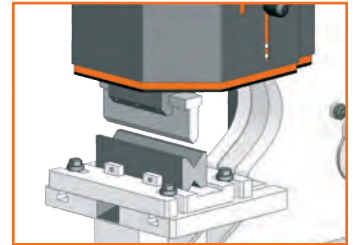
- Station for punching of channel



- Includes electric trigger switch up to 1000 mm (39.4") for quick workflow of repetitive work
- Jog-mode for each work station for precise tool and work piece positioning
- Also available with CNC-controlled material feed stock for punch, with 6 m (20') or 4 m (12') material table and pneumatic holding device



- V-blade for notching



Bending station

- V-punch and die

Specifications	PS				
	45 50 tons	65 DP 70 tons	85 DP 90 tons	115 DP 125 tons	175 DP 190 tons
Angle shearing station	Cutting capacity 45° mm 70x6 (2.8x0.24")	70x10 (2.8x0.39")	80x8 (3.1x0.31")	80x10 (3.1x0.39")	
	Working height mm 1140 (44.9")		1200 (47.2")	1215 (47.8")	1130 (44.5")
Sheet shearing	Max. capacity (Width/thick) mm 200x15 (7.8x0.6")	300x20 (11.8x0.75")	380x20 (15x0.75")	380x25 (15x1")	380x30 (15x1.2")
	Blade length mm 316 (12.4")	375x15 (14.75x0.6")	480x15 (18.9x0.6")	600x15 (23.6x0.6")	600x20 (23.6x0.75")
	Angle cutting capacity mm 80x10 (3.1x0.4")	100x15 (4x0.6")	120x15 (4.75x0.6")		
	Working height mm 935 (36.8")	900 (35.4")	940 (37")	935 (36.8")	810 (31.9")
Notching station	Max. material thickness mm 8 (0.31")	10 (0.4")	13 (0.5")		
	Length/Width mm 75x35 (2.95x1.3")	90x45 (3.5x1.3")	100x52 (4x2")	100x60 (4x2.3")	
	Working height mm 935 (36.8")	900 (35.4")	940 (37")		910 (35.8")
V-shaped tool and die [optional]	mm 100x100x8 (4x4x0.3")	100x100x10 (4x4x0.4")	100x100x13 (4x4x0.5")		100x100x16 (4x4x0.6")
Hydraulic performance	l/min 11 (3 gal/min)	16 (4 gal/min)	22 (5.7 gal/min)		
Motor power	kW 4.0 (5 Hp)	5.5 (7 Hp)	7.5 (10 Hp)	11 (15 Hp)	
Pressing force	T 45 (50 t)	65 (70 t)	85 (90 t)	115 (125 t)	175 (190 t)
Dimensions (L/W/H)	mm 1330x770x1460 (53x31x58")	1685x770x1765 (67x31x70")	1865x770x1890 (74x31x75")	2045x770x2030 (81x31x80")	2810x1020x2210 (111x41x87")
Weight	kg 1180 (2,600 lbs)	1600 (3,500 lbs)	2315 (5,000 lbs)	2920 (6,400 lbs)	6000 (13,200 lbs)
Item No.	9702001		9702002	9702003	9702004
					9702005

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