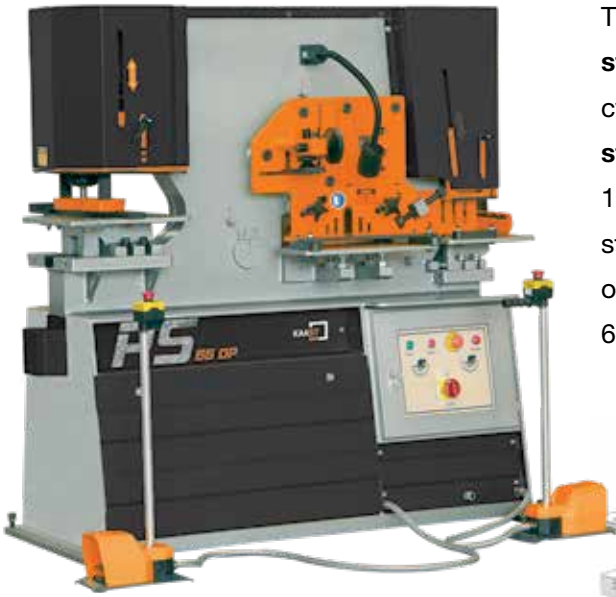
KAAST

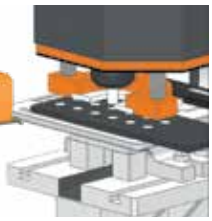
PS / PS DP

45 | 65 DP | 85 DP | 115 DP | 175 DP

Ironworkers, 5 Work Stations, Punching, Shearing and Notching



The PS ironworker is a multi-purpose machine equipped with **five work stations** for punching, shearing, notching, and more. The PS DP two-cylinder model allows for **parallel work** on both the punch and a **second station** simultaneously. They include an **electric trigger switch** up to 1000 mm (39.4”) for fast, repetitive workflows and **jog-mode** at each station for precise tool and workpiece positioning. Also available is an optional **CNC-controlled material feed stock** with a 4000 mm (12’) or 6000 mm (20’) table and **pneumatic holding device**.



Punching Station

Flat Shear

STANDARD CONFIGURATION

- Electronic Length Trigger
- Punching Station
- Flat Shearing Station
- Angle Shearing Station
- Section Bar Shearing Station
- Notching Station

PUNCHING STATION

Designed for punching sheet metal, flat, and angle steel, this machine features a sturdy table for high-quality results. It includes stepless stroke adjustment and an adapter for punches and dies.

FLAT SHEAR

The flat shear features a lower blade with 4 cutting edges and an upper blade with 2 cutting edges. The table includes both angle and length stops for precise cutting.

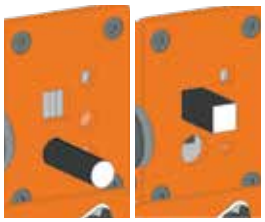
ANGLE SHEAR

Designed for cutting profiles at various angles, this machine includes an adjustable rear stop for accurate, repeatable cuts

STEELWORKER

The steelworker is designed for cutting round and square steel, featuring a 1000 mm (39.4”) back gauge for precise length control.

Angle Shear



Steelworker

Notching Station

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KAAST

PS / PS DP

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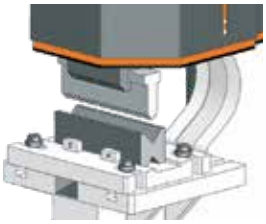
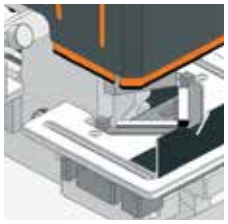


Bending Station V-Punch and Die



V-Blade for Notching

OPTIONAL CONFIGURATION

Motorized Back Gauge
Cutting U, T and I-Profiles Station
V-Punch & Die Bending Station
Station for Punching of Channel
Notching V-Blade
Punches and Dies

PS		45	65 DP	85 DP	115 DP	175 DP
		50 tons	70 tons	90 tons	125 tons	190 tons
Cutting Capacity 45°	mm	70x6 (2.8x0.24")	70x10 (2.8x0.39")	80x8 (3.1x0.31")	80x10 (3.1x0.39")	80x10 (3.1x0.39")
Working Height	mm	1140 (44.9")	1140 (44.9")	1200 (47.2")	1215 (47.8")	1130 (44.5")
Sheet Shearing						
Max. Capacity (Width/Thick)	mm	200x15 (7.8x0.6") 300x12 (11.8x0.5")	300x20 (11.8x0.75") 375x15 (14.75x0.6")	380x20 (15x0.75") 480x15 (18.9x0.6")	380x25 (15x1") 600x15 (23.6x0.6")	380x30 (15x1.2") 600x20 (23.6x0.75")
Blade Length	mm	316 (12.4")	380 (15")	482 (19")	610 (24")	610 (24")
Angle Cutting Capacity	mm	80x10 (3.1x0.4")	100x15 (4x0.6")	120x15 (4.75x0.6")	120x15 (4.75x0.6")	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")	13 (0.5")	16 (0.625")
Length/Width	mm	75x35 (2.95x1.3")	90x45 (3.5x1.3")	100x52 (4x2")	100x60 (4x2.3")	100x60 (4x2.3")
Working Height	mm	935 (36.8")	900 (35.4")	940 (37")	940 (37")	910 (35.8")
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")	38x12 (1.5x0.5")
V-Shaped Punch & 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")
Angle Shearing Station						
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")
Cutting Capacity 90°	mm	100x100x10 (4x4x0.4")	120x120x12 (4.7x4.7x0.47")	150x150x15 (6x6x0.5")	150x150x16 (6x6x0.6")	200x200x20 (7.8x7.8x0.75")
V-Shaped Tool and Die [Optional]	mm	100x100x8 (4x4x0.3")	100x100x10 (4x4x0.4")	100x100x13 (4x4x0.5")	100x100x13 (4x4x0.5")	100x100x16 (4x4x0.63")
Hydraulic Performance	l/min	11 (3 gal/min)	16 (4 gal/min)	22 (5.7 gal/min)	22 (5.7 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)	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	9702006	9702007	9702004	9702005

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