



Ironworkers PS • PS DP

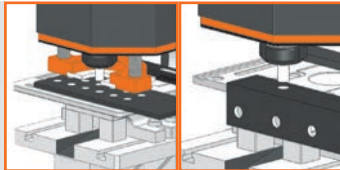
Multi-purpose machine with 5 work stations
for punching, shearing and notching



Standard configurations

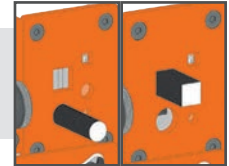
Punching station

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



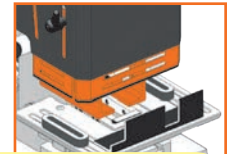
Steelworker

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



Notching station

- ✓ Table with stops



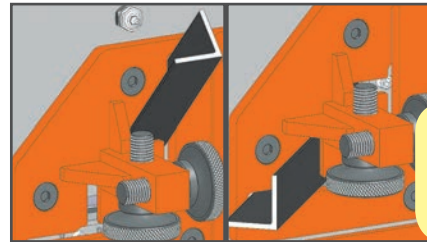
Flat shear

- ✓ 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 ton	PS 65 DP 70 ton	PS 85 DP 90 ton	PS 115 DP 125 ton	PS 175 DP 190 ton
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 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 (4.7x4.7x0.47")	150x150x15 (6x6x0.5")	150x150x16 (6x6x0.6")	200x200x20 (7.8x7.8x0.75")

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

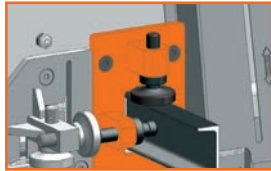


Optional configurations

- 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



✓ Motorized back gauge for automatic operation

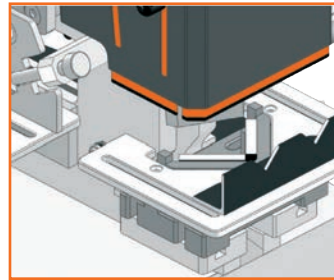


✓ Station for cutting of the U, T and I-profiles
✓ The dimensions of the station must be agreed in advance

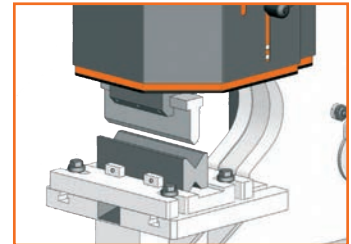
✓ Punches and dies



✓ Station for punching of channel



✓ V-blade for notching



Bending station
✓ V-punch and die

Specifications	PS 45		PS 65 DP		PS 85 DP		PS 115 DP		PS 175 DP		
	50 ton		70 ton		90 ton		125 ton		190 ton		
Cutting capacity 45°	mm	70x6 (2.8x0.24")	70x10 (2.8x0.39")	80x8 (3.1x0.31")	80x10 (3.1x0.39")	80x10 (3.1x0.39")	80x10 (3.1x0.39")	80x10 (3.1x0.39")	80x10 (3.1x0.39")	80x10 (3.1x0.39")	
Working height	mm	1140 (44.9")	1140 (44.9")	1200 (47.2")	1215 (47.8")	1215 (47.8")	1215 (47.8")	1215 (47.8")	1130 (44.5")	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")	380x25 (15x1") 600x15 (23.6x0.6")	380x25 (15x1") 600x15 (23.6x0.6")	380x25 (15x1") 600x15 (23.6x0.6")	380x30 (15x1.2") 600x20 (23.6x0.75")	380x30 (15x1.2") 600x20 (23.6x0.75")	
Blade length	mm	316 (12.4")	380 (15")	482 (19")	610 (24")	610 (24")	610 (24")	610 (24")	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")	120x15 (4.75x0.6")	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")	935 (36.8")	935 (36.8")	935 (36.8")	810 (31.9")	810 (31.9")	
PUNCHING STATION											
Max. material thickness	mm	8 (0.31")	10 (0.4")	13 (0.5")	13 (0.5")	13 (0.5")	13 (0.5")	13 (0.5")	16 (0.625")	16 (0.625")	
Length/Width	mm	75x35 (2.95x1.3")	90x45 (3.5x1.3")	100x52 (4x2")	100x60 (4x2.3")	100x60 (4x2.3")	100x60 (4x2.3")	100x60 (4x2.3")	100x60 (4x2.3")	100x60 (4x2.3")	
Working height	mm	935 (36.8")	900 (35.4")	940 (37")	940 (37")	940 (37")	940 (37")	940 (37")	910 (35.8")	910 (35.8")	
OPTIONAL TOOLING											
V-shaped tool and die	mm	100x100x8 (4x4x0.3")	100x100x10 (4x4x0.4")	100x100x13 (4x4x0.5")	100x100x13 (4x4x0.5")	100x100x13 (4x4x0.5")	100x100x13 (4x4x0.5")	100x100x13 (4x4x0.5")	100x100x16 (4x4x0.63")	100x100x16 (4x4x0.63")	
GENERAL DATA											
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)	22 (5.7 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)	11 (15 Hp)	11 (15 Hp)	11 (15 Hp)	11 (15 Hp)	
Pressing force	t	45 (50 ton)	65 (70 ton)	85 (90 ton)	115 (125 ton)	115 (125 ton)	115 (125 ton)	115 (125 ton)	175 (190 ton)	175 (190 ton)	
Dimensions (L/W/H)	mm	1330x770x1460 (53x31x58")	1685x770x1765 (67x31x70")	1865x770x1890 (74x31x75")	2045x770x2030 (81x31x80")	2045x770x2030 (81x31x80")	2045x770x2030 (81x31x80")	2045x770x2030 (81x31x80")	2810x1020x2210 (111x41x87")	2810x1020x2210 (111x41x87")	
Weight	kg	1180 (2,600 lbs)	1600 (3,500 lbs)	2315 (5,000 lbs)	2920 (6,400 lbs)	2920 (6,400 lbs)	2920 (6,400 lbs)	2920 (6,400 lbs)	6000 (13,200 lbs)	6000 (13,200 lbs)	
Item No.		9702001		9702002		9702003		9702004		9702005	

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Cutting

Turning

Milling

Drilling/Boring

Grinding

Sawing

Fabricating
Brakes • Shears • Ironworkers • Rolls • Presses • Other