



Multi Steelworker



Five Station: **Punching, Shearing, Angle, Section Cropping and Notching Machines.**

The machine is supplied with standard equipment and accessories as listed on the next page, suitable for operation on 415v/3Ph/50Hz supply.

The Kingsland Multi range of 60 up to 175 ton machines are in the Kingsland tradition of **well engineered, robust steelworkers**, built for a long working life.

These universal machines are supplied with standard tooling including repetition support tables at punch, shear and notch stations and with easily adjusted hold downs at all five work stations. Free standing on a suitable floor, they just require electrical connection and hydraulic oil to be ready for work.

For two operator utilization, the hydraulic system is activated by two shielded foot controls, one operating the punch and cylinder, the other operating the shear and cylinder. The shear cylinder provides the power to the three shearing and the notch stations.

The system gives accurate power inching at all five work stations and allows the machine to be stopped at any position giving safe and accurate tool setting and work positioning. Limit switches at both ends of the machine control stroke length at all stations.

Centralized lubrication is metered by one-shot system, being only one feature of the low maintenance requirement.

An **optional 'Production Pack'** is available to enhance the machine specification, this includes: 1 low volt halogen lamp on a movable magnetic base, 1.0m long touch and cut ruled length stop, fine adjustment facility to the punch stroke and measuring scales in the notch table.

Specifications

	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 140	MULTI 175
Punching							
Rated Capacity	60 Ton	70 Ton	80 Ton	95 Ton	125 Ton	140 Ton	175 Ton
Maximum Capacity	29 x 15	26 x 20	28 x 20	27 x 25	35 x 25	39 x 25	40 x 32
Diameter x Thickness	57 x 8	57 x 9	57 x 10	57 x 12	57 x 16	57 x 17	57 x 22
Stroke Length	55	55	55	80	80	80	80
Cycle/Min (20mm Stroke)	34	34	34	34	28	28	625
Standard Throat	305	305	305	355	355	355	625
Deep Throat Model	625	625	625	625	625	625	57
Largest Hole (Optional)	160	160	160	160	225	225	225
Maximum Section	305	305	305	305	305	305	380
Working Height	1030	1030	1087	1039	1056	1060	1120
Shearing							
Flat Bar - Max Thickness	230 x 20	300 x 20	300 x 20	380 x 20	380 x 25	400 x 25	380x30
Flat Bar - Max Width	375 x 10	375 x 15	450 x 15	480 x 15	600 x 15	600 x 20	600x20
Angle Flange Trim - 45°	100 x 15	100 x 15	100 x 15	120 x 15	120 x 15	120 x 15	120x15
Working Height	890	890	890	890	900	900	900
Flat Bar - Max Thickness	230 x 20	300 x 20	300 x 20	380 x 20	380 x 25	380 x 30	380x30
Flat Bar - Max Width	375 x 10	375 x 15	450 x 15	480 x 15	600 x 15	600 x 20	600x20
Angle Cutting							
90° Cut	130 x 13	130 x 13	150 x 13	150 x 15	150 x 18	150 x 18	200x20
45° Cut	70 x 10	70 x 10	70 x 10	80 x 10	80 x 10	80 x 10	80x10
Working Height	1130	1130	1155	1155	1160	1160	1160
Notching							
Material Thickness	10	10	12	13	13	13	16
Width - Rectangle	45	45	40	52	60	60	60
Depth - Rectangle	90	90	90	100	100	100	100
Depth - Vee	60	60	60	70	80	80	80
Angle Flange - Max Profile	100 x 10	100 x 10	100 x 10	100 x 13	100 x 13	100 x13	110x14
Working Height	890	890	890	890	900	900	900
Section Cutting							
Round	45	45	45	50	55	55	65/55
Square	45	45	45	50	55	55	300x125
Channel	130 x 65	130 x 65	130 x 65	160 x 90	200 x 100	200 x 100	150x15
Tee	90 x 12	90 x 12	90 x 12	100 x 12	120 x 12	120 x 12	65/55
<i>Other Profiles Available on Request</i>							
Corner Notching							
Maximum Capacity	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6	250sqx2
Tube Notching							
Max Outside Diameter	83	83	83	108	108	108	165
Bending							
Max Bar Bending	250 x 12	250 x 13	250 x 15	250 x 20	250 x 22	250 x 22	250x25
Max Sheet Bending	500 x 3	500 x 3	500 x 3	500 x 3	700 x 3	700 x 3	700x4
Punching at Notch Station							
Throat Depth	125	125	125	125	125	125	125
Maximum Capacity	38 x 7	38 x 8	38 x 8	38 x 10	38 x 12	38 x 12	38x13
Technical Data							
Motor Power (3Ph~)	5.5 KW	5.5 KW	7.5 KW	7.5 KW	7.5 KW	9 KW	11 KW
Net Weight (Std Throat)	1570 Kg	1620 Kg	1925 Kg	2430 Kg	3100 Kg	3160 Kg	5750 Kg
Gross Weight (Std Throat)	1695 Kg	1740 Kg	2095 Kg	2640 Kg	3370 Kg	3430 Kg	5970 Kg
Machine Dimensions	164x17x178	164x71x180	176x71x183	190x79x191	200x80x203	200x80x203	270x112x216
Packed Dimensions	175x86x195	175x86x197	191x86x200	205x94x209	215x95x221	215x95x221	285x127x241

Specifications based on 450N/mm² Material tensile strength

Note: technical specifications can be subject to modifications without prior notice



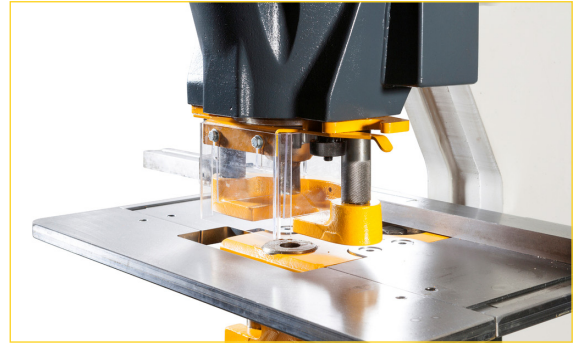
Standard Equipment

- Easy change Punch Holder, Ring and Adaptors
- Swing away Punch Stripper with simple adjustment
- Universal Die Bolster for the punching of flats, angle and flanges of Channel and I Beam
- Blades for cropping angle, round/square bar, flat bar
- Punch Support Table c/w Side Stops
- Shear Support Table
- Adjustable Hold Down for Shear, Angle and Section Stations
- Shielded Foot Pedal Control to both Punch and Shear ends
- Power Inching and Adjustable Stroke
- Remote Foot Pedal Control
- Machine painted in light grey RAL 7044, dark grey RAL 7031 and yellow RAL 1007
- NEW power saving mode electric box
- Automatic Overload Relief on Hydraulic System
- Electric I.P. 55 Class 'F' T.E.F.C. Motor
- Low volt electrical control circuit
- Comprehensive Safety Guards to all Work Stations
- Complete Service Tool Kit

Pictures

Punch station

The large punch bed area has a removable front block and is designed to give a very wide range of punching applications. A punch table with rules and guides for repetition work are fitted as standard equipment



Angle station

This station provides large capacity angle cutting at 90° and 45°. Angles between 45° and 90° can be achieved by first cutting at 90° and then flange trimming to the required angle in the shearing station



Section cutting station

The machines are fitted as standard with blades for cutting round and square bars

With extra equipment, the machines are able to cut, in this aperture, channel, joist, T-section and many other special profiles



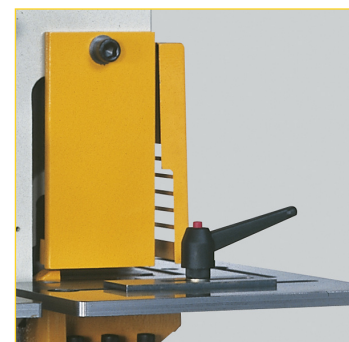
Shearing

The shearing unit is fitted with a simple robust hold down which is adjustable to any thickness of material within the cutting capacity of the machine. The shear feed table with adjustable guides is fitted to allow accurate feeding of materials. The guide can be adjusted to allow mitre cutting up to 45° for flat bars or to trim the flanges of angle



Notching station

The notching station is fitted as standard with a rectangular notch table with adjustable back stops, allowing repetitive positioning



Optional machine attachments



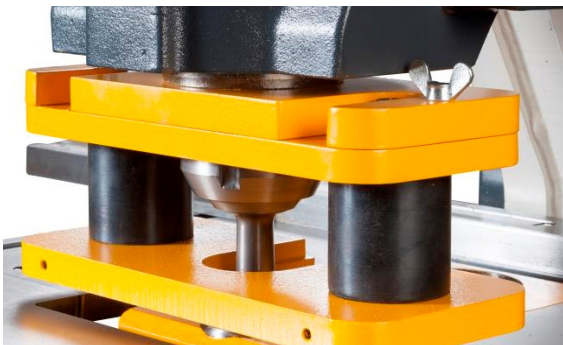
Bar Bending Unit

Picture left shows the optional Bar Bending attachment



Swan Neck Bolster

Picture left shows the optional Swan Neck Bolster. Primarily used for web/flange punching of I beams and Channel beams. Also shown in the diagram below



Minimum Deform Stripper Assembly

Picture left shows the optional Minimum Deform Stripper. This reduces deformation when punching close pitch holes in flat bar



Sheet Bending Unit

Picture left shows the optional Sheet Bending Unit. Multi V bottom tool (all at 85°)



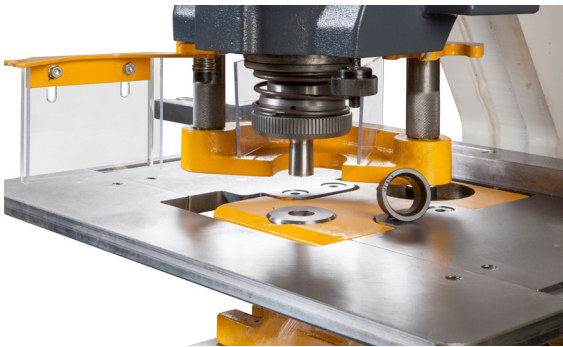
Large Hole Punching Attachment

Picture above shows the optional L/H Attachment that can be fitted to Machine. Allowing for punching up to 110, 160 or 200mm diameter



Louvre Punching Attachment

Picture above shows louvre punching Attachment retrofitted to machine Louvres of 3 x 100mm long or Louvres of 3 x 180mm long



Tooling super quick change

Picture above of tooling super quick change. Spring and ball bearings lock/un lock the tool in position with 90-degree hand turn. No C spanner required



Tooling quick change

Picture above of tooling quick change only needs to turn the punch holder by 90 degree to lock in position



Hydraulic Clamping to Punch Station

Deep Throat Version Steelworker



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Robot Plasma Cutting System



Punching machines



Tools & accessories