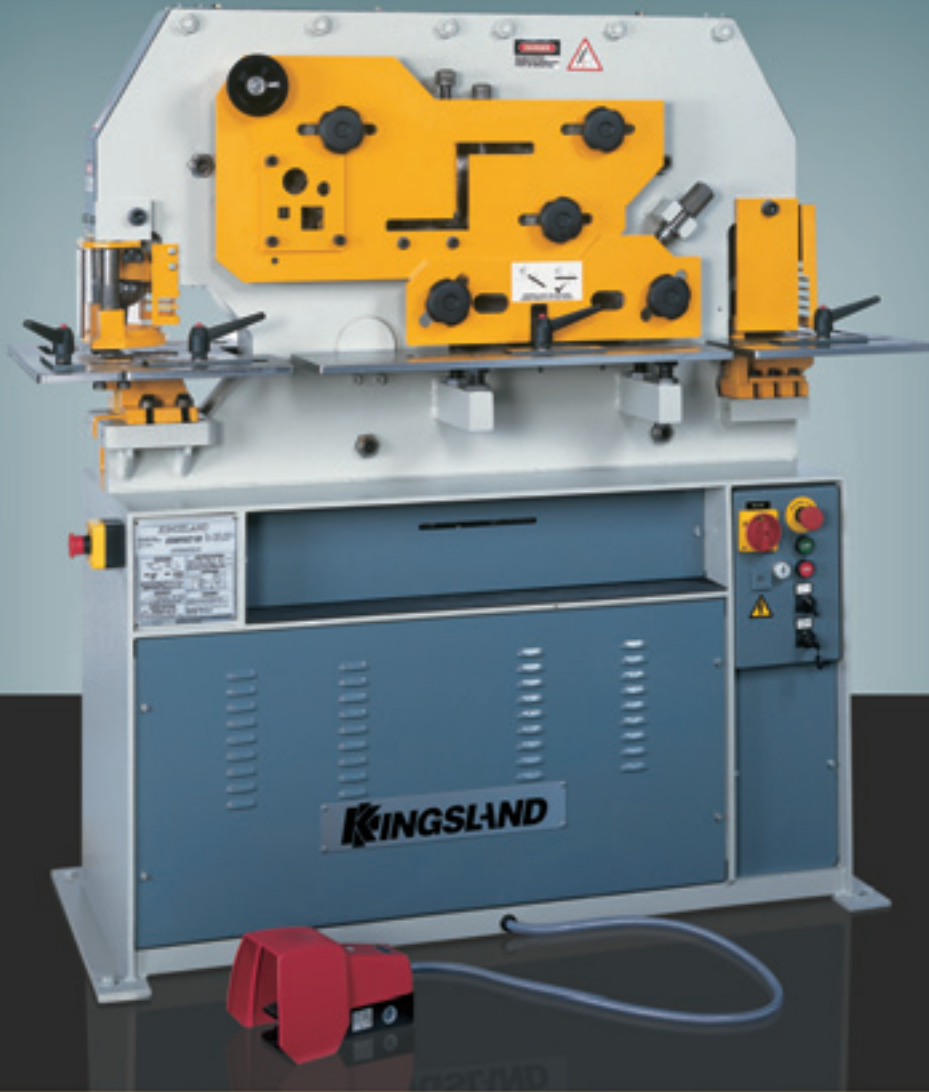




for impressive
performances



COMPACT HYDRAULIC STEELWORKER



COMPACT 40



Hydraulic steelworker

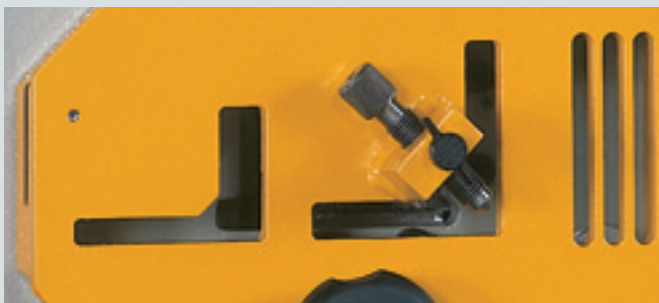
The 'Compact 40' is the most compact steelworker in the range of hydraulic steelworkers. These machines are built using the long experience gained in the manufacturing and sales of robust and high-quality machines, designed for a long working life. The punch station is designed to enable multiple punching applications. The universal bolster offers the option of punching sheetmetal, flat bar, angle iron and the flange of channel and beam, all of which can be punched up to a maximum diameter of 38 mm in the standard execution. Tooling for special applications is available on request. Large, heavy-duty tables with guides are part of the

extensive range of standard equipment. The machines are equipped with blades for cropping round and square bars, optional blades are available for cutting U-, I-, T- and many other special profiles. Angle iron can be cut on 90° and/or 45° (through both flanges, internal and external). All blades have multiple cutting edges and can be reground. The shear is equipped with a simple, but robust holddown, adjustable for every plate thickness within the capacity of the machine. A heavy-duty support table is fitted in order to guarantee an accurate feeding of the material.



1 PUNCH STATION

The standard punch station enables punching holes with a diameter of up to 38 mm. Fully adjustable stroke.



2 ANGLE STATION

With the angle station, angle iron can be cut on 90° and/or 45°, both internal and external, through both flanges. The flange of large angle iron can be mitre cut with the shearing station.



3 SECTION CUTTING STATION

While cropping round and square solid bars in the standard setup, this station also allows optional blades for cropping channels, beams, Tee- and many other special profiles.



4 SHEARING STATION

Cutting thick as well as thin material without the need for blade gap or cutting-angle adjustments, the shear also enables cutting flanges of angle profiles.

COMPACT 45 & 60



Hydraulic steelworker

The Compact 45 and the Compact 60 are universal and compact hydraulic steelworkers with 5 workstations and are developed for production purposes with maximum efficiency. The Compact machines are designed and manufactured using the long experience in the field of sales and manufacture of hydraulic steelworkers. The hydraulic circuit is activated by a shielded foot-pedal – the low power inch mode on each workstation enables the correct workpiece-positioning and tool-alignment. Limit-switches allow accurate adjustment of the stroke length for maximum efficiency. Stroke with automatic return. On the angle-cutting station, angle iron can be cut on every angle from 45° up to 90°, both internal

and external, without any adaptations to the machine. Flanges from larger angle-iron can be mitre cut with the shear. Moreover, the machines are equipped with centralised pressure lubrication – being one feature of the low maintenance requirements. The universal steelworkers are delivered with an extensive range of standard equipment, such as large heavy-duty tables on the punch-, shear-, and notching station. Easy adjustable holddowns to enable production in a safe and accurate way are fitted on every station. Free standing on suitable floor, they just need electrical connection to be ready to work.



1 PUNCH STATION

Easy tool change system and swing-away stripper with fast manual adjustment assure a quick setup.



2 SECTION CUTTING STATION

While cropping round and square solid bars in the standard setup, this station also allows optional blades for cropping channels, beams, Tee- and many other special profiles.



3 ANGLE STATION

Cropping angle iron is possible for every angle between 45° and 90°, both internal and external.



4 SHEARING STATION

Specially designed blade approach angle to avoid the necessity to change blade settings when cutting thick or thin material and yet offer minimum distortion cropping.



5 NOTCHING STATION

This versatile unit is equipped with a rectangular notch unit as standard – side notch applications are also possible.

Punch station



STANDARD PUNCH END

Easy tool change system. Overhang position for punching in the flange of I- and U-profiles. Punching up to 38 mm diameter in the standard execution. Table and stop with guides are fitted as standard.

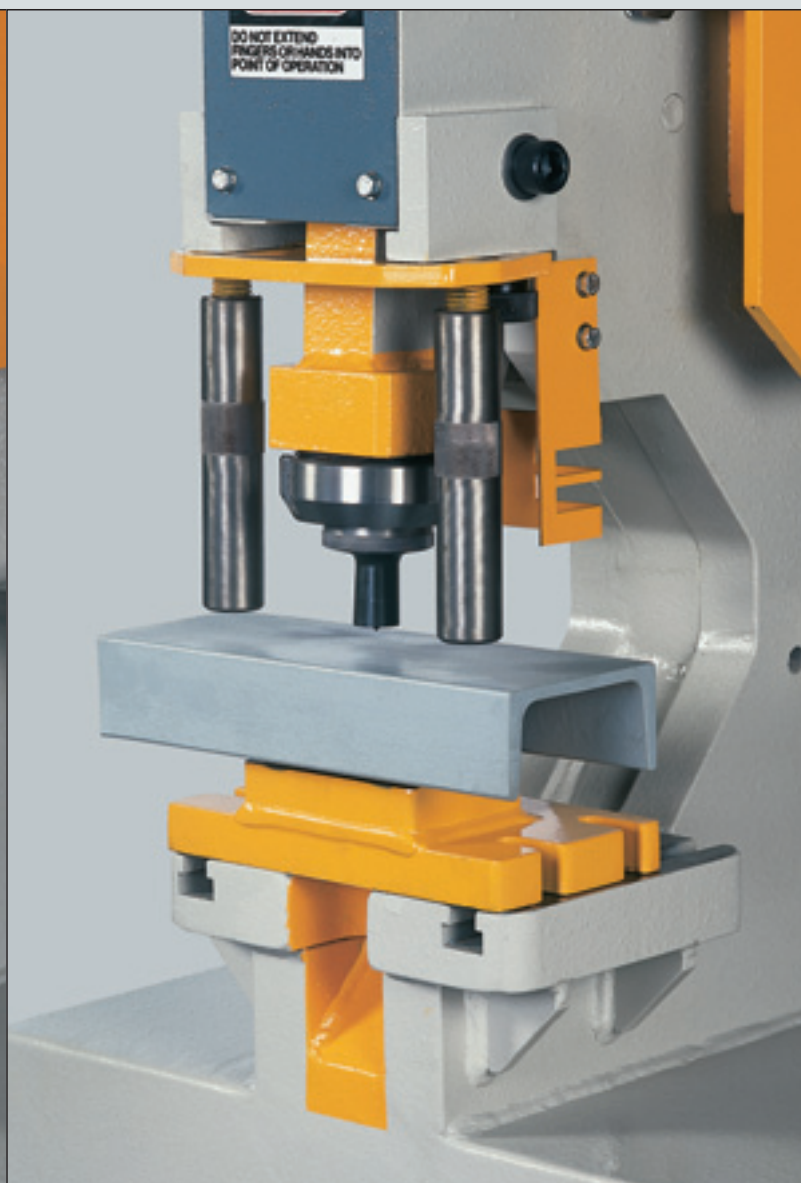


QUICK CHANGE PUNCH HOLDER (OPTIONAL)

Quick, fast and accurate punch holder. Available up to 38 mm diameter.

**LARGE HOLE ATTACHMENT (OPTIONAL)**

Large hole unit for diameters up to 110 mm. Special shapes and applications are also possible.

**CHANNEL/BEAM WEB BOLSTER (OPTIONAL)**

Specially designed bolster for punching in the web of channel or beam. Bolsters for special profiles on demand.

Notching station



The notching station comes equipped with a rectangular notch unit as standard, complete with table and guides. The unit can be interchanged with a triangular notching unit (available with angle from 22,5° up to 90°).



For bending applications (optional).

Maximum capacity is 80 x 10 mm (Compact 40).

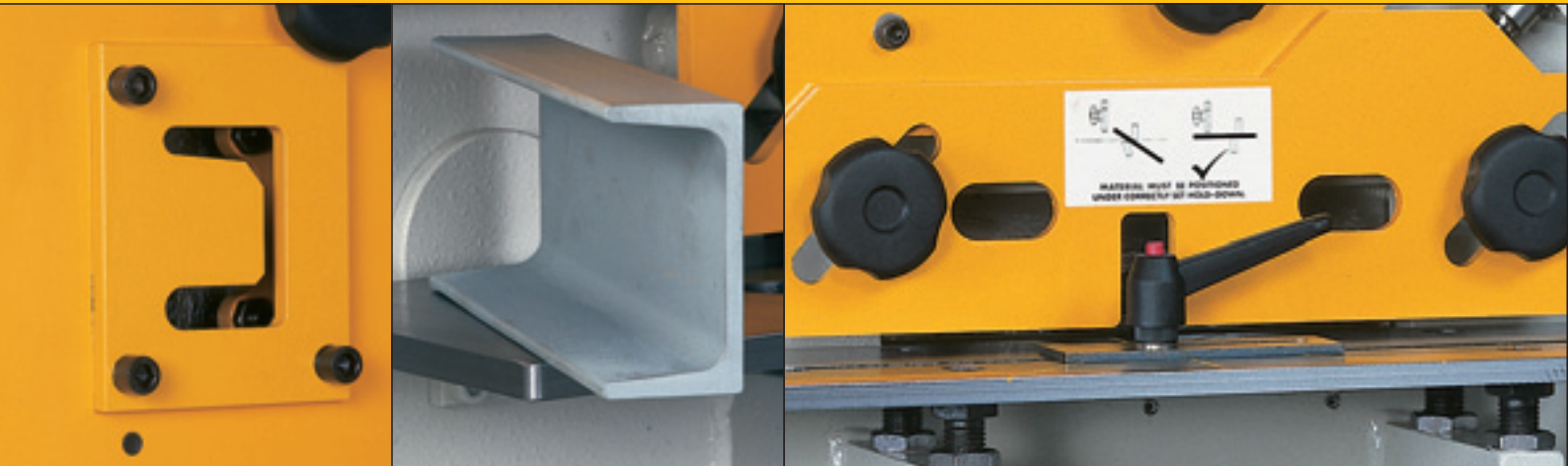
Maximum capacity is 100 x 12 mm (Compact 45).

Maximum capacity is 150 x 12 mm (Compact 60).

Angle station

Unique 'Z' aperture makes it possible to cut angle iron on every angle varying from 45° up to 90°, both internal and external.

Shearing/section cutting station



SPECIAL SOLID BLADES FOR CROPPING CHANNELS (OPTIONAL)

Optional solid blades for cropping UPN-profiles. Blades are available for many different and special profiles.

SHEARING

Specially designed blade approach angle to avoid the necessity to change blade settings when cropping either thick or thin material and yet offer minimum distortion cropping. Shearing the flange of angle iron is also possible.

Features

- Universal bolster for punching flat bar, angle iron and the flange of channel and/or beam.
- Punching up to 38 mm in the standard execution.
- Optional large hole attachment for punching up to 110 mm diameter available (up to 57 mm for Compact 40).
- Heavy-duty support table on the punch & the shear station (Compact 40) and the notch station (Compact 45 & Compact 60) fitted as standard – all with the same working height.
- Low power inch mode and adjustable stroke on every station.
- Unique 'Z' (on Compact 45 & Compact 60 only) – aperture enables the cutting of angle iron in every angle, varying from 45° up to 90°, both internal and external (both flanges). Cutting flanges from large-sized angle-iron can be mitre cut with the shear (see capacities).
- Extensive range of applications – tube notching, bending, bar-end cropping, special shape punching...
- Rectangular and triangular notching applications. The notching station can be transformed into a secondary punching station (Compact 45 & Compact 60).
- Extended safety features as standard equipment.
- Centralised pressure lubrication (on the Compact 45 & Compact 60).
- High quality interchangeable bearings, seals and valves with well-known brand names, available from stockists.
- Machines with low maintenance requirements.
- Single-phase execution available.
- Possibility to use tooling from other brand names.

Standard equipment



- Punch adaptors.
- Swing away punch stripper unit.
- Easy change punch holder.
- Universal die bolster.
- Heavy-duty support tables with guides at shear station and punch station.
- Heavy-duty support table with guides at notch station (Compact 45 & Compact 60).
- Shear arm-blade with 4 cutting edges (Compact 40).
- Curved shear arm-blade with 2 (optional: 4) cutting edges (Compact 45 & Compact 60).
- Shear body blade with 4 cutting edges.
- Section arm & body blade with 1 cutting edge.
- Angle cutting arm & body blades with 4 cutting edges.
- Rectangular notch bolster blades with 4 cutting edges (Compact 45 & Compact 60).
- 1 Metre ruled length stop (Compact 45 & Compact 60).
- Service toolkit.
- Work station guards.
- Instruction, operating and maintenance manual.
- Hydraulic oil fill

	COMPACT 40	COMPACT 45	COMPACT 60
Punch and die	Ø 18	Ø 22	Ø 22
Section blades: round	30	30	20, 40
Section blades: square	25	30	16, 35

Model specifications



Based on material strength of 450 N/mm².

		COMPACT 40	COMPACT 45	COMPACT 60
	Punching			
	rated capacity	400	450	600
	maximum capacity	20 x 15	22 x 15	28 x 15
	diameter x thickness	38 x 8	38 x 8	38 x 11
	stroke length	32	50	55
	cycles/min. - 16 mm travel	23	20	26
	standard throat depth	175	175	220
	deep throat model	-	-	-
	largest hole (optional)	57	110	110
	maximum height UPN-web (*)	120	160	160
	maximum height UPN-flange	-	102	102
working height	900	930	940	
	Shearing			
	flat bar - maximum thickness	200 x 13	200 x 15	200 x 20
	flat bar - maximum width	350 x 6	300 x 12	300 x 15
	angle flange trim - max 45°	80 x 10	80 x 10	80 x 10
working height	900	930	940	
	Angle cutting			
	90° cut	80 x 8	100 x 10	127 x 12
	45° mitre (true int./ext.)	50 x 6	70 x 6	80 x 8
working height	1210	1140	1140	
	Section cutting			
	round/square	30/25	30/30	40/35
	channel/beam (**) (*)	76 x 38	80 x 45	102 x 51
Tee (**) (*)	38 x 6	40 x 7	76 x 10	
	Notching			
	material thickness	(*) 8	8	10
	width – rectangle	(*) 35	35	42
	depth – rectangle	(*) 65	75	100
	depth – Vee	(*) 55	(*) 60	(*) 60
	angle flange – max. profile	-	80 x 8	100 x 10
	working height	900	930	940
(*) optional attachment for the punch station				
	Corner notching (*)			
maximum capacity	-	150 x 3	150 x 4	
	Tube notching (*)			
maximum outside diameter	40	60	60	
	Bending (*)			
	plate			
maximum capacity	80 x 10	100 x 12	150 x 12	
	Punching at notch station (*)			
	throat depth	-	85	110
maximum capacity	-	18 x 12	20 x 12	
	Technical data			
	motorpower	3 kW	3 kW	4 kW
	nett weight	550 kg	1080 kg	1250 kg
	gross weight	620 kg	1175 kg	1370 kg
	machine dim. (L x W x H), cm	106 x 55 x 148	145 x 59 x 162	152 x 59 x 170
packed dim. (L x W x H), cm	115 x 62 x 163	152 x 77 x 172	166 x 77 x 190	

Illustrations, dimensions, weights... are not binding as designs are constantly being reviewed.

(*) optional equipment

(**) other profiles are also possible

THE KINGSLAND RANGE OF HYDRAULIC MACHINES



Compact 40

- 4 stations.
- Single cylinder hydraulic steelworker.
- 40 ton capacity.



Compact 60

- 5 stations.
- Single cylinder hydraulic steelworker.
- Available in 45 & 60 ton.



Multi 80

- 5 stations.
- Double cylinder, standard throat.
- Available in 60, 70, 80, 95, 125, 140 & 175 ton.
- Available with deep throat.



Punch 60

- 1 station.
- Single cylinder hydraulic punching machine.
- Available in 60, 70, 80, 95, 125, 140 & 175 ton.
- Deep throat standard.



50P

- 1 station.
- Single cylinder hydraulic punching machine.
- Standard throat depth 280 mm.



125D Double Punch

- 2 stations.
- Double cylinder, hydraulic punching machine.
- Available in 60, 70, 80, 95, 125, 140 & 175 ton.
- Available with deep throat.

KINGSLAND MEMBER OF THE HACO INTERNATIONAL GROUP

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performances

Illustrations, dimensions, weights... are not binding as designs are constantly being reviewed.
 F.COMPACT.E mm/2006.10 (Non contractual document.)