**Kingsland COMPACT Hydraulic Steelworker Range**

<table>
<thead>
<tr>
<th>SPECIFICATION</th>
<th>C50</th>
<th>C65</th>
<th>C80</th>
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<td><strong>FINISHING</strong></td>
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<tr>
<td>Maximum Capacity (mm)</td>
<td>23x15</td>
<td>30x15</td>
<td>28x20</td>
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<tr>
<td>Diameter x Thickness (mm)</td>
<td>38x9</td>
<td>38x12</td>
<td>38x14</td>
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<tr>
<td>Stroke Length (mm)</td>
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<tr>
<td>Standard Thrust Depth (mm)</td>
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<td>Largest Hole (standard)</td>
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<td>Maximum Section</td>
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<tr>
<td>Working Height (mm)</td>
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<tr>
<td><strong>SHEARING</strong></td>
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<tr>
<td>Flat Bar - Max Width (mm)</td>
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<tr>
<td>Working Height (mm)</td>
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<tr>
<td><strong>ANGLE CUTTING</strong></td>
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<tr>
<td>90° cut</td>
<td>100x10</td>
<td>120x12</td>
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<tr>
<td>45° max 45°</td>
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<td><strong>SECTION CUTTING</strong></td>
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<tr>
<td>Round / Square</td>
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<tr>
<td>Channel / Beam</td>
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<td>Tee</td>
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<td><strong>BENDING</strong></td>
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<td>Depth - Rectangular (mm)</td>
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<td>Depth - Flat (mm)</td>
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<td><strong>SIDE NOTCH</strong></td>
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<td><strong>TECHNICAL DATA</strong></td>
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<tr>
<td>Motor Power (Kw)</td>
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<tr>
<td>Net Weight (kg)</td>
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<tr>
<td>Gross Weight (kg)</td>
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<td>1385</td>
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<td>Machine Dimensions (LxWxH, cm)</td>
<td>152x59x170</td>
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<tr>
<td>Packed Dimensions (LxWxH, cm)</td>
<td>166x77x190</td>
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</table>

Illustrations, dimensions & weights are not binding as designs are constantly being reviewed.
The Compact 50, 65 and 80 are universal and compact hydraulic steelworkers. They are equipped with five workstations, developed for production purposes with maximum efficiency as a result of years of continuous improvement and innovation.

The Compact machines are designed, well-engineered and manufactured for a long working life using our long experience in the manufacturing of hydraulic machinery.

**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 110mm diameter
- Heavy duty support table on the punch, shear and the notch station fitted as standard with the same working height
- Inch mode and adjustable stroke on every station
- Unique ‘Z’ 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 miter 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
- Extended safety features as standard
- Centralised lubrication
- High quality interchangeable bearings, brand-name seals and valves available from stockists
- Machines with low maintenance requirements
- Single phase execution available on the C50 and C65
- Possibility to use tooling from other brand names (adaptors may be required but are available)

**Standard equipment**
- Punch adaptors
- Swing away punch stripper unit
- Easy change punch holder
- Universal die bolster
- Heavy duty support tables with guides at shear and punch stations
- Heavy duty support table with guides at notch station
- Curved shear arm-blade with 2 (optional: 4) cutting edges
- Shear body blade with 4 cutting edges
- Section arm & body blade with T cutting edge
- Angle cutting arm & body blades with 4 cutting edges
- Rectangular notch bolster blades with 4 cutting edges
- 1-metre ruled length stop
- Service toolkit
- Work station guards
- Instruction, operating and maintenance manual
- Special central pin, play-free on frame

**Extensive range of standard equipment**

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. Comprehensive safety guards are fitted as standard on all work stations. Easily adjustable hold-downs to enable safe and accurate production are fitted on every station. Free-standing on a suitable floor, these steelworkers only need an electrical connection and oil to be ready for work.

**Five Workstation Types**

- **Punch Station**
  The easy tool change system and swing-away stripper with fast manual adjustment assures a quick setup and is designed for a wide range of punching applications.

- **Section Cutting Station**
  The machines are fitted as standard with blades for cutting round and square bars. With extra equipment in this aperture, the machines are able to cut channel, beams or joist, T-section and many other special profiles.

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

- **Shearing**
  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.

- **Notching Station**
  This versatile station is standard equipped with a rectangular notch unit. The notch table has adjustable back and side stops. Side notch applications are also possible.
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- optional large hole attachment for punching up to 110 mm diameter
- heavy duty support table on the punch, shear and the notch station fitted as standard with the same working height
- inch mode and adjustable stroke on every station
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- easy change punch holder
- universal die bolster
- heavy-duty support table with guides at shear and punch stations
- heavy-duty support table with guides at notch station
- curved shear arm-blade with 2 (optional: 4) cutting edges
- 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
- 1-metre ruled length stop
- service toolkit
- work station guards
- instruction, operating and maintenance manual
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- **Notching Station**
  This versatile station is standard equipped with a rectangular notch unit. The notch table has adjustable back and side stops. Side notch applications are also possible.
Shielded foot control
The hydraulic circuit is activated by a shielded foot-pedal. The inch mode on each workstation enables the correct work piece positioning and tool alignment. Limit switches allow accurate adjustment of the stroke length for maximum efficiency. Stroke with automatic return.

Angle cutting
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.

Low maintenance
Moreover, the machines are equipped with centralised pressure lubrication, being only one feature of the low maintenance requirements.

Regular Notching Station (standard)
- the notching station comes equipped with a rectangular notch unit as standard, complete with table and guides
- the unit can be interchanged optionally with a triangular notching unit (available with angle from 22.5° up to 90°)

For Bending Applications (optional)
- maximum capacity is 150 x 12 mm (Compact 50)
- maximum capacity is 150 x 12 mm (Compact 65)
- maximum capacity is 150 x 12 mm (Compact 80)

Quick Change Punch Holder (optional)
- quick, fast and accurate punch holder
- available up to 38 mm diameter

Standard Punch End (standard)
- easy tool change system
- overhang position for punching in the flange of I-profiles and U-profiles
- punching up to 38 mm diameter in the standard execution
- Table with guide stops fitted as standard

Large Hole Attachment (optional)
- large hole unit for diameters of 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
Shielded foot control
The hydraulic circuit is activated by a shielded foot-pedal. The inch mode on each workstation enables the correct work piece positioning and tool alignment. Limit switches allow accurate adjustment of the stroke length for maximum efficiency. Stroke with automatic return.

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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.

Low maintenance
Moreover, the machines are equipped with centralised pressure lubrication, being only one feature of the low maintenance requirements.
HYDRAULIC STEELWORKERS

ANGLE STATION APPS

- Angle Iron Cutting (standard)
  - unique ‘Z’ aperture makes it possible to cut angle iron from 45° up to 90°
  - both internal and external

SHEARING STATION APPS

- Flat Bar & L-Profile Flange Cropping
  - Heavy duty table with adjustable guides
  - under angle: ±45° permanent guidelines

SECTION CUTTING APPS

- Special Blades for Cropping Channels (opt.)
  - I-beam and T-section blades also available in different sizes. Blades for special profiles on demand

Also available in the KINGSLAND STEELWORKER RANGE

MULTI
- 2 operators, 5 work stations
- double cylinder
- standard or deep throat
- 60, 70, 80, 95, 125, 140 & 175 ton

PUNCHING
- 1 or 2 operators
- 1 or 2 cylinders
- standard or deep throat
- 50, 60, 70, 80, 95, 125, 140 & 175 ton

PRESS
- 1 station
- single cylinder
- standard throat
- available in special formats
- 50, 80, 110, & 200 ton

CNC PUNCH CUTTING LINE
- CNC punch
- tool changer: 3 or more tools
- multi as CNC shear station (in picture above)
- rotating shear ±45° available
- marking unit available

DRILLFLEX
- box sections, I, U, T profiles
- from 30 up to 1100mm
- tool changer ISO40 or 50
- drilling, milling
- rigid tapping
- DSTV compatible

TOOLING
- genuine Kingsland tooling
- other brand tooling
- special tooling
- made in Sheringham, UK
- unique vacuum oven hardened
- customised R&D for tooling
HYDRAULIC STEELWORKERS

ANGLE STATION APPS

- **Angle Iron Cutting**
  - unique "Z" aperture makes it possible to cut angle iron from 45° up to 80°
  - both internal and external

- **Angle Iron Cutting**
  - angle iron mitring

SHEARING STATION APPS

- **Flat Bar & L-Profile Flange Cropping**
  - Heavy duty table with adjustable guides
  - under angle: ±45° permanent guidelines

SECTION CUTTING APPS

- **Special Blades for Cropping Channels** (opt.)
  - I-beam and T-section blades also available in different sizes. Blades for special profiles on demand

Also available in the **KINGSLAND STEELWORKER RANGE**

**MULTI**
- 2 operators, 5 work stations
- double cylinder
- standard or deep throat
- 60, 70, 80, 95, 125, 140 & 175 ton

**PUNCHING**
- 1 or 2 operators
- 1 or 2 cylinders
- standard or deep throat
- 50, 60, 70, 80, 95, 125, 140 & 175 ton

**PRESS**
- 1 station
- single cylinder
- standard throat
- available in special formats
- 50, 80, 110, & 200 ton

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- CNC punch
- tool changer: 3 or more tools
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<tr>
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<td>Largest Hole (optional)</td>
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<td>Bar Bending on Notch End</td>
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<td><strong>TECHNICAL DATA</strong></td>
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