



for impressive
performances

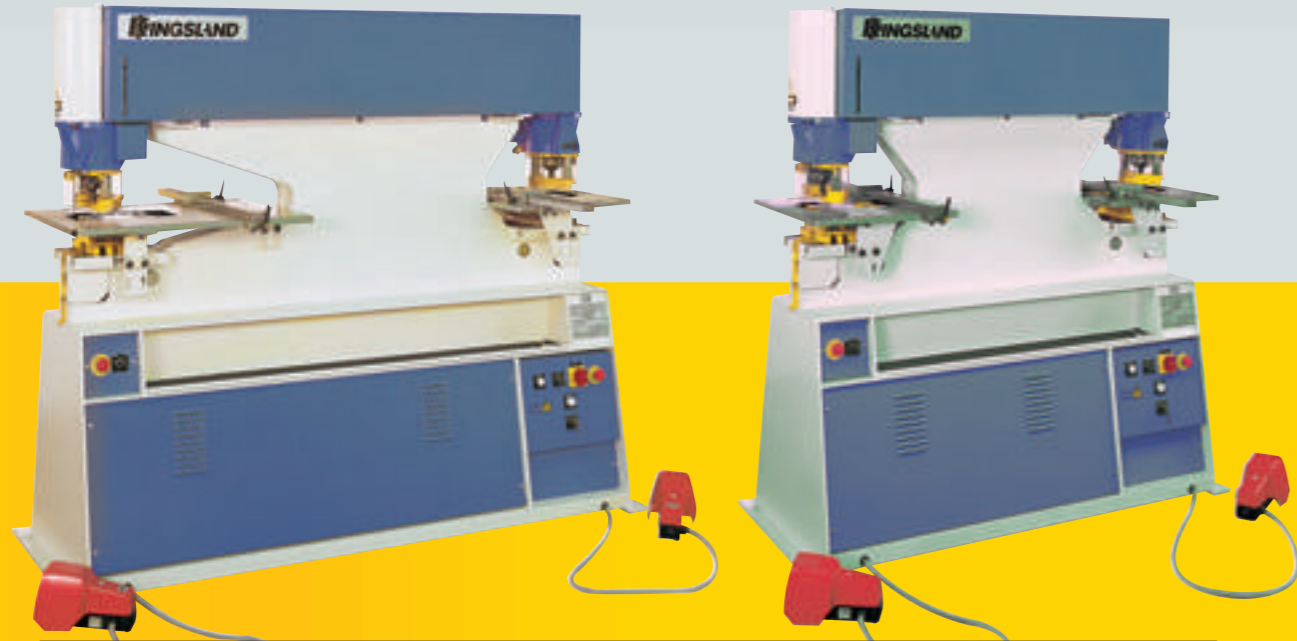


PUNCH RANGE

HYDRAULIC PUNCHING MACHINE



PUNCH RANGE



Punch - Double Punch

The Kingsland range of Hydraulic Punching machines all come equipped with a deep throat of 625 mm as standard. Heavy-duty support tables with scales and backstops, universal die holder for punching in plate, flat bar, angle iron and flange of channel and beam are all part of the standard execution. The punching machines are available from 60 ton to 175 ton, both in single-ended as well as

double-ended execution! Furthermore, tooling from competitors machines and/or other brand-names can be used without special machine-modifications. The standard machine comes equipped with a deep throat (single-ended version) and universal die-bolster, punching up to 57 mm diameter/slot. The front part of the table can be removed in order to punch in large format angle-iron.

Double ended execution

double ended punching machine

The Kingsland Hydraulic Punching machines are available in double-ended execution, using a shared frame thus saving you space and money. A second machine is no longer needed for doubling the capacity and productivity. Both ends of the machine can be used at the same time up to maximum capacity.

Standard equipment

- punch adaptors
- swing away punch stripper unit
- easy change punch holder
- universal die bolster
- heavy-duty punch table with scales, guide and backstop
- service toolkit
- work station guard
- instruction, operating and maintenance manual
- hydraulic oil fill

Features

- full stroke adjustment
- low power inching and adjustable stroke
- universal die bolster punching up to 57 mm as standard
- large punch table with multi-purpose bolster – removable table block for overhang channel/joist flange punching
- machines with very low maintenance requirements
- wide variety of applications – for large hole punching, crimping, tube notching, bar bending, sheet bending, punch press applications, etc.
- deep throat depth as standard
- overload relief on hydraulic system
- interchangeable bearings, seals and valves readily available from stockists of hydraulic equipment

Punch station-applications (optional equipment)



Minimum deform stripper assembly

Minimum deform stripper assembly to give minimum deformation while punching close pitch holes in flat bar.

Quick tool change

Quick change punch holder. Only needs to turn the punch holder by 90° to lock in position.

Large hole attachment

Large hole/slot attachment for diameters from 38 up to 110 mm. Also available for diameters up to 160 or 225 mm.



Channel/beam web bolster

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

'Super-quick' tool change

Spring and ball bearings lock/un-lock the tool in position with 90° hand turn. No spanners or wrenches required.

Tube notch unit

For 90-degree connection with tubes. Available for outside diameters up to 165 mm.

Punch station-applications (optional equipment)



Technology: linear rail and CNC controlled positioning tables

Sheet bending unit

Sheet bending unit with multi-vee block (with 10, 20, 24 & 40mm wide V-openings, all 85°).

Louvre punch unit

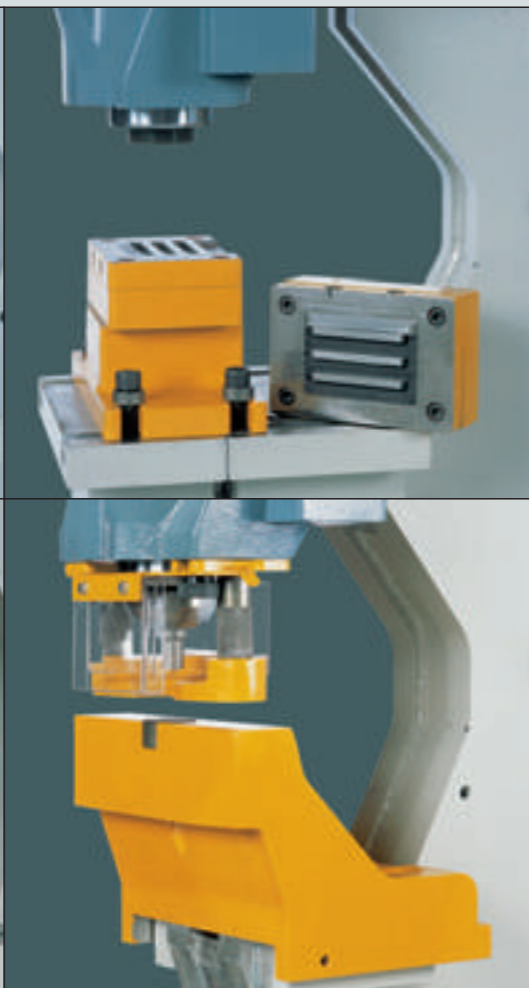
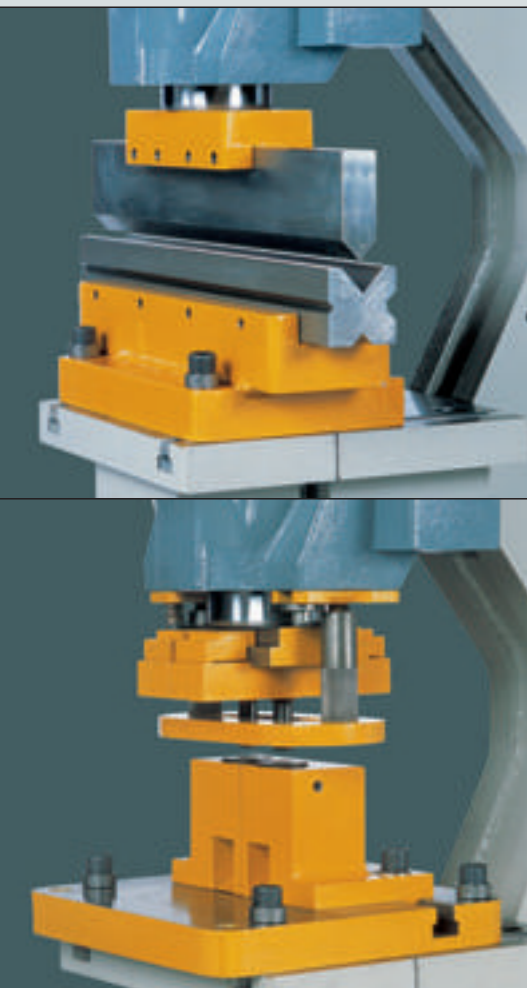
Special punch unit for punching ventilation applications.

Bar bending unit

For bending material up to max. 22 mm thickness. With single-vee block, 76 mm with V at 85°.

2 axis CNC-controlled positioning table

Punching of plates, flat steel, in the web of channel and on the flange of channel and I-beams. The punching of the web in channel is effected with the flanges up and by using extended length punches. The table is delivered complete with servo-motor and 2 axis measuring system, and is equipped with an easy to operate Robosoft K210 (or optional M600) control. Especially advantageous is the repeatability accuracy when manufacturing repeat batches and accuracy even for one-offs. The use of labour intensive manual layout is no longer required and possible operator error is eliminated. The workpiece is pushed to the CNC controlled stop, after punching the stop goes to the next position...



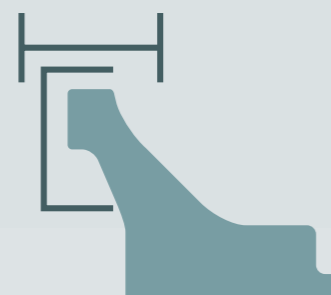
The CNC Controlled Positioning Table can be fitted to all Kingsland Steelworkers and Punching machines with 625 mm deep throat. Working area: - lateral stop (X-axis): 1,005 mm - bit stop (Y-axis): 505 mm - positioning accuracy: ±0,1 mm

Twin hole unit

Twin hole variable pitch unit. Punches 2 holes up to 29 mm dia.

Swan neck bolster

For web and flange punching up to 32 mm dia. in 300 mm max. channel and I'beam.

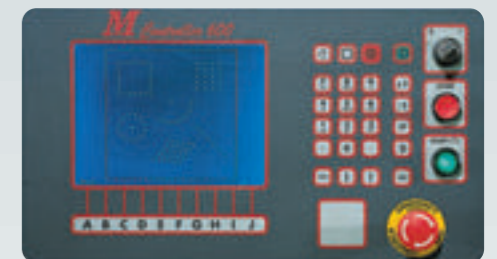


Dovetail assembly

Changing from punching to bending in 20 seconds.

The K210 Controller is very simple and operator friendly to use. Just enter the X and Y-axis co-ordinates and start. There are no G codes to remember, anyone can learn to use this control in minutes. Free DNC software can be supplied with the controller, so that you can connect it to a PC and save and load as many programmes as you want. A post-processor is available so that you have your program automatically after processing a DXF- or DSTO-file. Other files can be post-processed on request.

The optional M600 Controller with a 9"LCD screen, using standard ISO codes, it is possible to carry out linear, square, rectangular, circular and circle arts of any size of opening requested in the punching process. The workpiece with its programmed hole pattern is graphically simulated on the screen. The CNC control ensures the required accuracy within a hole pattern using several gauge lines. Each program with its graphic simulation can be stored on disk (disk memory 720 kB, 3.5" disk drive).





shown fitted to a SOP



Linear Rail

For all manufacturing divisions of the different structural steel engineering workshops, the CNC controlled Linear Rail is the ideal device for cost effective punching and notching of flat steel, angles, channels, "T" and "I" beams. Available with a standard length of 4.00 m – giving an operating distance of 3.60 m – extendable in 1.00 m lengths to suit the users application. Ideally suited to repetitive and 'one off' work without the need for marking out, greatly increasing production speeds and eliminating costly operator error.

Model KA

The automatic unit is computer controlled by a single axis Type 550 Control, with a digital display and 24 button keypad. With 8 programs, up to 80 steps, that can be programmed in a variety of modes, including: single position, manual operation and position calculation for bar processing applications. Available with heavy duty motor and drive unit.

Clampmaster

2-axis CNC controlled fully automatic table with 2x automatic gripper assemblies

The Clampmaster is a freestanding positioning table for punching plates and flat steel and can be retrofitted to any make of Steelworker or Punching machine.

- Working area:
- X-axis 1,250 mm
 - Y-axis 700 mm
 - positioning accuracy ... ±0.1 mm

Especially advantageous is the repeatability accuracy when manufacturing repeat batches. Uses the easy to operate Robosoft K210 controller (as described above).



shown fitted to a Multi 80



gripper assembly detail



optional 'drive-in' minimum deform stripper and bolster assemblies



hydraulic clamping

model specifications

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

	60P	70P	80P	95P	125P	140P	175P
Punching							
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
standard throat depth – punch	625	625	625	625	625	625	625
standard throat depth – double punch (DP)	305 + 305	305 + 305	305 + 305	355 + 355	355 + 355	355 + 355	625 + 625
deep throat model – double punch (DPX)	305 + 625	305 + 625	305 + 625	355 + 625	355 + 625	355 + 625	-
largest hole (standard equipment)	57	57	57	57	57	57	57
largest hole (optional equipment)*	160	160	160	160	225	225	225
maximum section	305	305	305	305	305	305	380
working height	1075	1075	1075	1050	1054	1.054	1100
Corner notch*							
maximum capacity	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2
Tube notch*							
maximum outside diameter	83	83	83	108	108	108	165
Bending*							
bar bend. max. capacity	250 x 12	250 x 13	250 x 15	250 x 20	250 x 22	250 x 22	250 x 25
sheet bend. max. capacity	500 x 3	500 x 3	500 x 3	500 x 3	700 x 3	700 x 3	700 x 4
Technical data							
motorpower (kW)	5,5	5,5	7,5	7,5	7,5	9	11
nett weight – punch (kg)	1320	1330	1610	2130	2675	2735	5050
gross weight – std. throat (kg)	1450	1460	1745	2295	2920	2980	5450
machine dim. (L x W x H) (cm)	164 x 71 x 178	164 x 71 x 180	176 x 71 x 183	190 x 79 x 191	200 x 80 x 203	200 x 80 x 203	270 x 112 x 216
packed dim. (L x W x H) (cm)	175 x 86 x 195	175 x 86 x 197	191 x 86 x 200	205 x 94 x 209	215 x 95 x 221	215 x 95 x 221	285 x 127 x 241
nett weight – double punch (DP) (kg)	1385	1390	1650	2450	2900	2960	5400
gross weight – double punch (DP) (kg)	1510	1515	1800	2760	3150	3210	5800
machine dim. (L x W x H) (cm)	167 x 71 x 178	167 x 71 x 180	179 x 73 x 183	192 x 79 x 192	203 x 80 x 203	203 x 80 x 203	273 x 112 x 216
packed dim. (L x W x H) (cm)	182 x 85 x 198	182 x 85 x 200	195 x 86 x 203	206 x 92 x 210	221 x 95 x 226	221 x 95 x 226	288 x 127 x 245

* optional equipment

THE KINGSLAND RANGE OF HYDRAULIC STEELWORKERS



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



for impressive performances

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FPUNCH RANGE.E mm/2006.02 (non contractual document)