



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 niching and adjustable stroke
- universal die bolster punching up to 57 mm as standard
- large punch table with multi-purpose bolster – removable table block for overhanging channel/joist, large 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

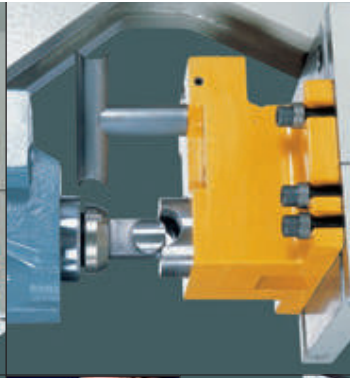
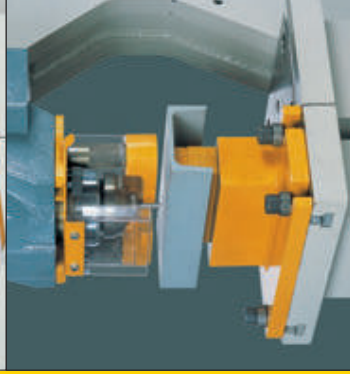
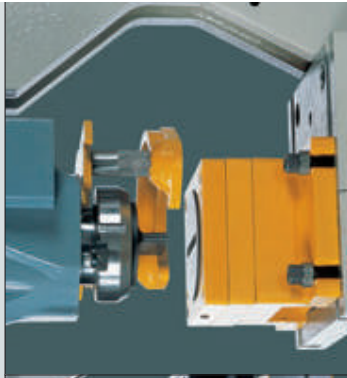
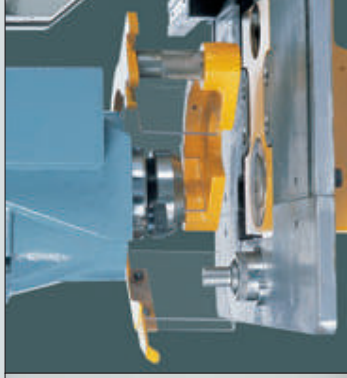
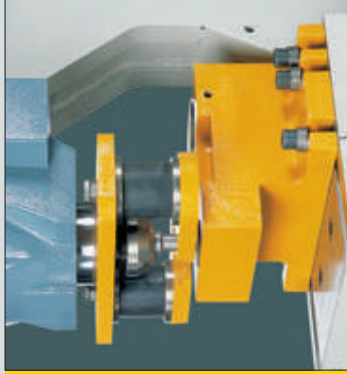
Minimum deform stripper assembly to give minimum deformation while punching close pitch holes in flat bar.

### 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)**



**Sheet bending unit**

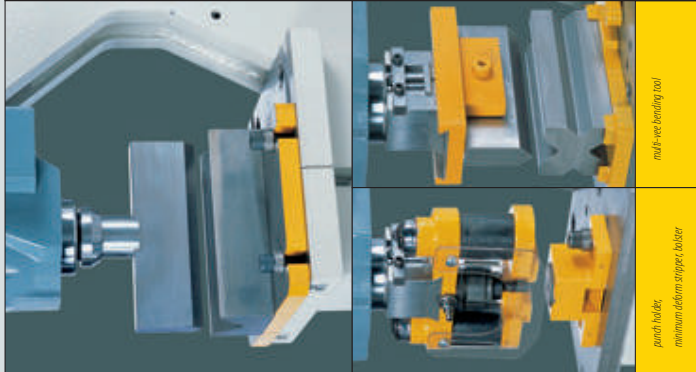
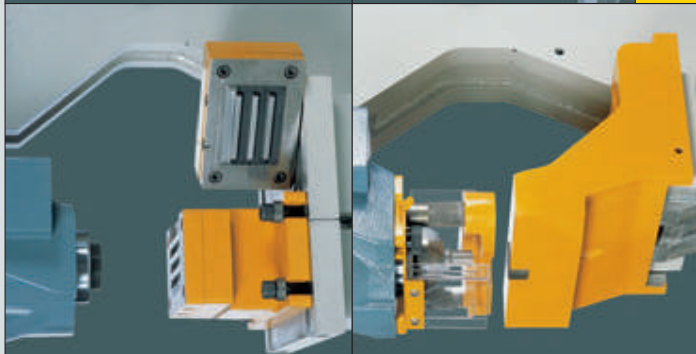
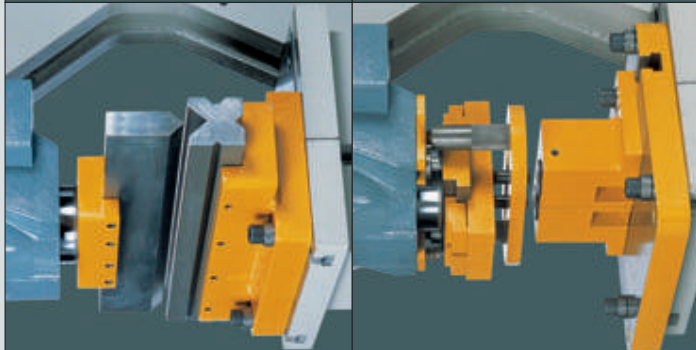
Sheet bending unit with multi-vee block (with 10, 20, 24 & 40mm wide V-openings, all 85°).

**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°.

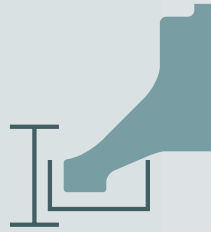


**Twin hole unit**

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.

**Technology: linear rail and CNC controlled positioning tables**

**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 channels 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 fiberosoft 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 . . .



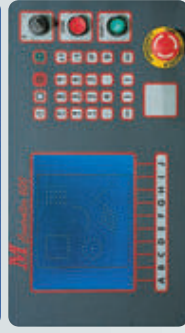
The CNC Controlled Positioning Table can be fitted to all Kingsland Steelworkers and Punching machines with 625 mm deep throat.

Working area: - lateral stop (X-axis): 1,005 mm - bit stop (Y-axis): 505 mm - positioning accuracy: ±0.1 mm

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 arcs 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).







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

	60P	70P	80P	95P	140P	175P
<b>Punching</b>						
maximum capacity	29 x 15	26 x 20	28 x 20	27 x 25	35 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 22
stroke length	55	55	55	80	80	80
standard throat depth – punch	65	65	65	65	65	65
standard throat depth – double punch (DP)	305 + 305	305 + 305	305 + 305	335 + 355	335 + 355	625 + 625
deep throat model – double punch (DPV)	305 + 625	305 + 625	305 + 625	335 + 625	335 + 625	-
largest hole (standard equipment)	57	57	57	57	57	57
largest hole (optional equipment)*	160	160	160	160	225	225
maximum section	305	305	305	305	305	380
working height	1075	1075	1075	1050	1054	1100
<b>Corner notch*</b>	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2	250 sq x 2
<b>Tube notch*</b>	83	83	83	108	108	165
<b>Bending*</b>						
bar bend, max. capacity	250 x 12	250 x 13	250 x 15	250 x 20	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 4
<b>Technical data</b>						
motorpower (kW)	5.5	5.5	7.5	7.5	7.5	9
net weight – punch (kg)	1320	1330	1610	2130	2675	2735
gross weight – std. throat (kg)	1450	1460	1745	2295	2920	2980
machine dim. (L x W x H) (cm)	664 x 71 x 178	664 x 71 x 180	176 x 71 x 183	190 x 79 x 191	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	285 x 127 x 241
net weight – double punch (DP) (kg)	1386	1390	1650	2450	2900	3400
gross weight – double punch (DP) (kg)	1510	1515	1800	2760	3150	3800
machine dim. (L x W x H) (cm)	667 x 71 x 178	667 x 71 x 180	179 x 73 x 183	192 x 79 x 192	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	288 x 127 x 245

\*ground equipment

shown fitted to 60P



**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 making 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 Robotsoft K210 controller (as described above).

gripper assembly detail



optional drive-in minimum dimensions gripper and bolster assemblies



shown fitted to Multi 80



hydraulic clamping

# 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



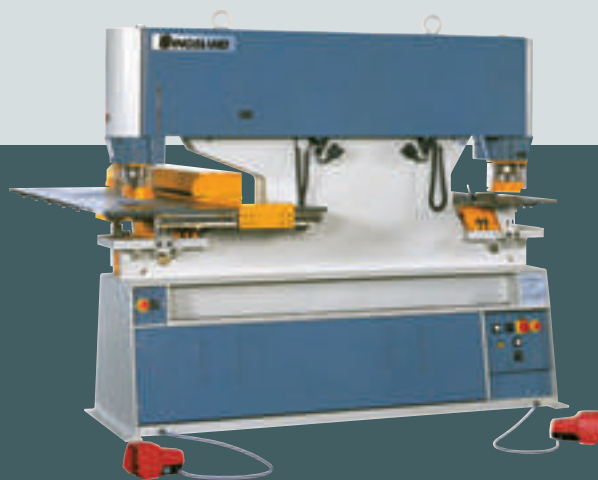
**Punch 60**

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