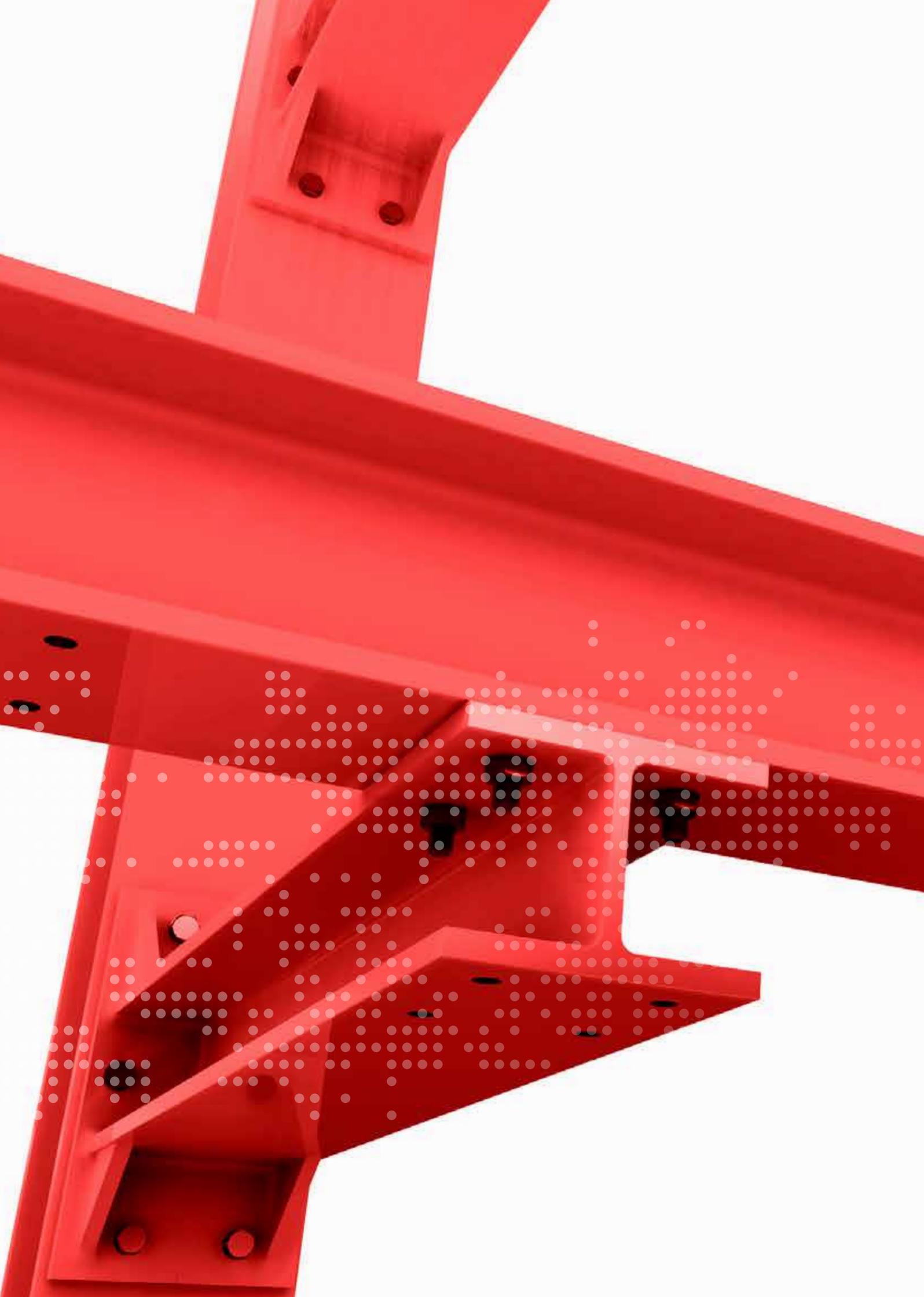


# Ironworkers Catalogue







### World leader in punching and shearing solutions

With more than 80000 happy and satisfied customers worldwide and more than 90 years experience.



### Proven quality, design and craftsmanship

ISO 9001 and OHSAS certifications besides 90 years experience and a continuous benchmarking policy.



### Complete after sales service

Permanent stock and next day delivery of consumables, accessories and parts. After sales assistance by GEKA's qualified engineers.



### Great versatility

More than 50 different machine models and over 8000 different accessories. GEKA offers the highest range in accessories and optional equipment in the market.



### Produced & manufactured in the European Union

Conversely other manufacturers, GEKA is the only ironworker fully produced by Geka in the UE.



### Continuous innovation

New Bendicrop 85, C2PL, Alfa 500, Alfa 150...



### Worldwide distribution network

With more than 60 distributors and present in more than 85 countries in 5 continents.



### All GEKA machines are special order

Every new GEKA machine is one of a kind. Our designers develop solutions suited to your specific needs. We manufacture each GEKA in our own facilities according to precisely defined standards.



the GEKA GROUP

quality  
know-how  
service



## EXPERIENCE

The **GEKA Group** began manufacturing ironworkers in 1919. **GEKA** ironworkers process angles, flat bar and steel profiles used in the construction of prefab metal structures; towers for high-voltage power lines and power stations; telecommunications towers; and other diverse industrial metalworking applications.

Each new machine project is studied individually by our technical office and is manufactured in full at our facilities in accordance with the strictest quality standards.

**GEKA** has the broadest range of accessories and optional equipment on the market to ensure versatile machines that meet our customers' needs.

## QUALITY ASSURANCE

Each and every **GEKA** machine is crafted by us in our plant which permits us absolute control over every aspect of the production process. Like our machines, we also manufacture our extensive line of tools and accessories in our own plant, guaranteeing a standard of quality far superior to "knockoffs" available elsewhere on the market.

**GEKA** is your benchmark for experience and quality.

## VERSATILITY

**GEKA** has earned its name as a pioneering and trustworthy brand in the metalwork sector due to its continuous developments and hard work, from the very first manual shearing machines to today's cutting-edge automated equipment.

## EXCEEDING CUSTOMER EXPECTATIONS

Our customer care and on-line support are provided around the clock. A qualified team of technicians in our Customer Care Center is committed to provide after-sales service in order to solve any questions or needs.

## R&D&i

Against a background of growing international competition, automation and innovation in production processes are key factors in guaranteeing a company's competitive edge.

Our team of experienced experts devotes their time exclusively to researching and innovating our developments.

**GEKA has consistently delivered outcomes that spell customer success and satisfaction for over 90 years.**

# Applications

Structures of pavilions, tents and stands, wrought ironwork, iron fittings, football fields, dockyards, mining, wine-making equipment, treatment of copper, boiler-making works, traffic signs, publicity boards, truck chassis, trailers, sporting equipment, children's playgrounds, farm machinery, metal cabins, high voltage pylons, cranes, catenaries, urban furnishing, handrails, fences and enclosures, windows, cement anchoring elements, bullrings...





Every GEKA machine has been designed and manufactured in accordance with applicable Standardised Directives and Regulations in the field of safety. As a consequence, we build machines equipped with protection devices that minimise risk in danger zones in accordance with applicable European and national regulations.



STEEL PLATE



FLAT BAR



ANGLES



CHANNELS



H CHANNEL



45° CUT



DOUBLE WING CUT  
(one of wich is at 45°)



90° CUT



STEEL BAR CUTTING



SHEARING



BENDING



PUNCHING



SPOTTING



MARKING



DRILLING



PUNCHES



PUNCHES



PUNCHES



\* For graphic reasons, some of the photographs shown in this catalogue do not comply with safety regulations. They are for information purposes only.

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## ONE-CYLINDER PUNCHING AND SHEARING MACHINES

The GEKA universal one-cylinder punching shearing machine comes with three, four and even five work stations, depending on the cylinder capacity. This makes it a versatile machine that can provide several different services.

The design of the GEKA punching shearing machine makes the tool replacement procedure easy, quick and practical.

In terms of safety systems, the machines are supplied with guards and devices to avoid exposing workers to unnecessary risks.

# FEATURES

This range includes four electrically driven models with the following standard equipment: work table, limit switches and measuring scales. Optionally, electric limit switches may be fitted (except on BENDICROP, which form part of the standard equipment) for cutting flat bar and section iron.

The shearing system consists of one single cut, without wasting any material. **The MINICROP and MULTICROP have been fitted with a patented floating blade for cutting section iron without any deformation of the material.**



Monoblock bed



Electrically driven hydraulic unit with submerged pump



Double acting cylinder



Electrical box with safety and integrated controls



Monoblock blade holder with antifriction bushings

	MICROCROP	MINICROP	MULTICROP
L 90°	✓	✓	✓
L 45°	2 legs	1 leg	2 legs
Flat bar	✓	✓	✓
Punching	✓	✓	✓
Notching	Optional on punching station	✓	✓
Bending	Optional on punching station	Optional on punching station	Optional on punching station
Electric length gauge inst.	Presintalation	Presintalation	Presintalation
Ø + ▯	✓	✓	✓

## MICROCROP

## MINICROP

## MULTICROP

**SHEARS FOR FLATBAR**

Flatbar (with slight deformation)	mm	350 x 6 200 x 13	300 x 10 200 x 13	300 x 10 200 x 13
Length of blade	mm	356	305	305
Round bar Ø	mm	30	-	-
Square bar 𐀀	mm	25	-	-
Cut of an L leg at 45°	mm	70	80	80
Working height	mm	980	1030	1030

**SHEARS FOR SECTION IRON**

L at 90 °	mm	80 x 80 x 8	80 x 80 x 8	80 x 80 x 8
L at 90 ° (with slight deformation)	mm	-	100 x 100 x 10	-
L at 45 °	mm	50 x 50 x 6	-	60 x 60 x 6
Round bar Ø	mm	35 (optional)	30	25
Square bar 𐀀	mm	30 (optional)	30	22

**NOTCHING**

(OPTIONAL)

Plate thickness	mm	8	7	7
Angle of	mm	60	60	60
Depth	mm	53	50	50
Width	mm	36	40	40

**PUNCHING**

Punching power	kN	360	450	450
Maximum capacity	mm	Ø27 x 10	Ø27 x 12	Ø27 x 12
Throat	mm	170	175	160
Stroke	mm	28	21	21
Working height	mm	980	1015	1015

**BENDING**

(OPTIONAL)

(OPTIONAL)

(OPTIONAL)

Bending power	kN	360	450	450
Maximum width	mm	80	80	80
Maximum capacity	mm	80 x 12	80 x 14	80 x 14

**GENERAL SPECIFICATIONS**

Motor	kW	2,2	2,2	2,2
N° strokes per minute (stroke= 15mm)		24	16	16
Net weight	kg	485	800	900
Gross weight	kg	575	1000	1100
Packaging dimensions	m	1,1 x 0,76 x 1,5	1,36 x 1,1 x 1,5	1,36 x 1,1 x 1,7
Volume of seaworthy package	m <sup>3</sup>	1,26	2,25	2,55

**OPTIONAL EQUIPMENT**

SHEARS FOR SECTION IRON L and I section iron	mm	50	100	100
PIPE NOTCHING Maximum diameter	mm	50	60	60
PUNCHING LARGER DIAMETERS Maximum diameter	mm	Ø36 x 8	Ø100 x 4	Ø100 x 4

- Capacities are based on a material resistance of 45 kg/mm<sup>2</sup>.
- The manufacturer reserves the right to make modifications without prior notice.

# FEATURES

## Angle cutting station

- L cut up to 80x80x8 mm. without any waste of material or burrs
- Material clamping guide
- Adjustable Gap on L blades
- Safety protection

## Punching station

- Monoblock body and sandwich structure
- Blade-holder Adjustment
- Punching
  - Ø 27 X 10 mm (Microcrop) and
  - Ø 27 X 12 mm (Mini & Multicrop)
- Quick change punch
- Off-set punches available for small angles
- Safety protection
- Adjustable Stripper
- Accurate positioning table with removable front for L punching leg down

## Flat plate cutting station

- Ø 30 cut and  $\nabla$  up to 25 mm. in position of flat plate (with slight deformation).
- Shearing of flat plate up to 200x13 mm
- Shearing of an L -leg at 45°
- Material clamping guide
- Adjustable play between flat bar blades
- End switches for travel setting

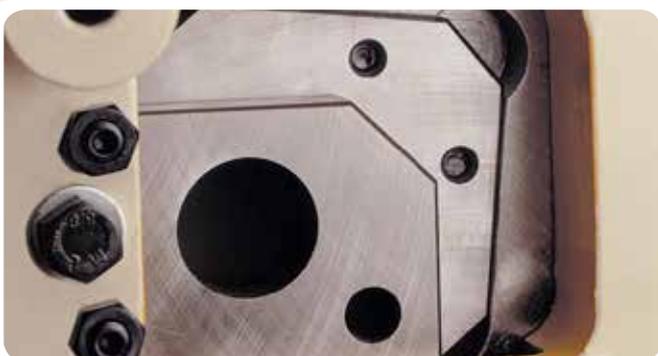
## Optional equipment



Punching equipment up to Ø 36 x 8 mm. in thickness



Rectangular notching



Blades for Øcut minimum deformation



"Touch & Cut" length stop

# Microcrop

IRONWORKER - ONE CYLINDER PUNCHING  
MACHINE WITH 3 WORK STATIONS:

- punching
- shear for flat bars
- angle cutting

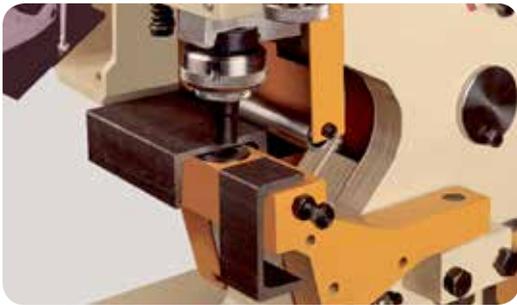
Excellent cutting quality on the shearing of flat bar station.



# Minicrop

One cylinder universal ironworker with four work stations (punching, notching, shear for flat bars shear L profiles, cutting of round and square bars). In addition to the features the Microcrop machine has, this model also includes:

## Common features to Minicrop and Multicrop



Goose neck die-holder for punching



Ø and ∇ cut without deformation

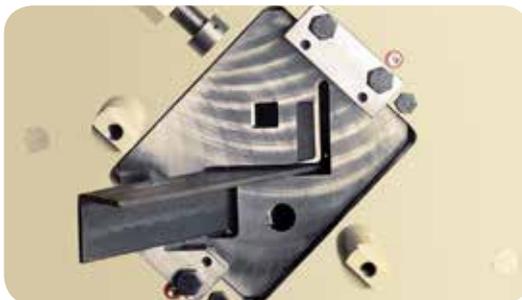


Rectangular notching equipment



# Multicrop

The Multicrop model offers, all features of the Minicrop model, as well as shearing angle section iron at 45 ° leg in and leg out.



Standard shear blades L, Ø and ∇.







## BENDICROP SERIES

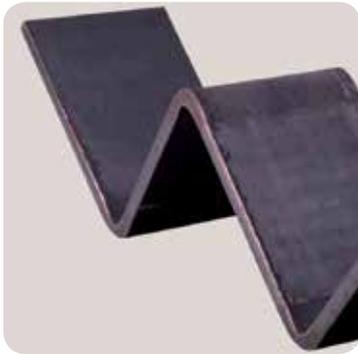
Apart from the five usual punching shearing stations, BENDICROP has a permanent bending station, the only one on the market. The machine is therefore more complete than the conventional punching shearing machine as it can perform bending work via a simple and safe procedure.

# FEATURES

In order to eliminate permanent deformation in material during the cutting process, the BENDICROP range includes an exclusive DEFORMATION-FREE CUTTING SYSTEM. This system is specially designed to cut soft materials (copper, aluminium), with spectacular cutting finishes.



Permanent bending station is compliant with CE standards.



Angle shearing without loss of material.  
Wide range of openings for  $\emptyset$ ,  $\square$  and L  
 $\emptyset$ ,  $\square$  and  $\perp$  L rim cutting station:  
Stations equipped with an assembly that acts as a hydraulic stop



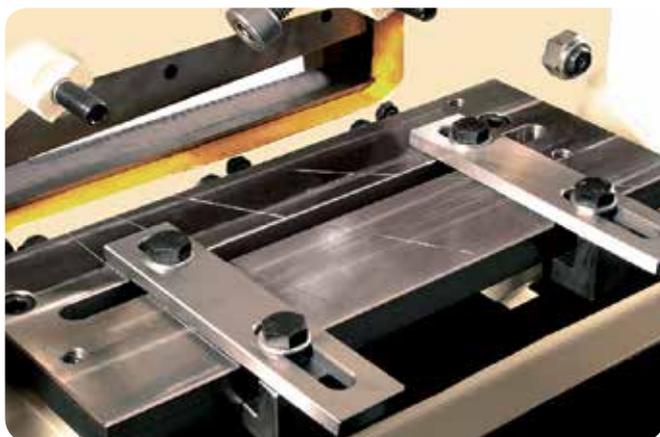
Rectangular notching with table.  
Bendicrop 50  
This station can also be used for tube notching.



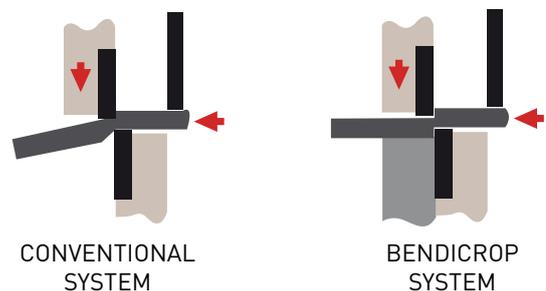
Triangular notching with table.  
Bendicrop 85SD



Goose neck die-holder for punching of L and I sections on legs and webs. Quick tool change.



Anti-torsion system for flat bar shearing without deformation



# FEATURES

SHEARS FOR FLATBAR		BENDICROP 50	BENDICROP 60 S	BENDICROP 60 SD	BENDICROP 85SD
Shears of flatbar	mm	350x10 (5°) 350x15	350x10 (5°) 350x15	350x10 (5°) 350x15	450x15 (5°) 450x18
Length of blade	mm	356	356	356	475
Cut of an L leg at 45°	mm	70	70	70	-
Working height	mm	865	859	859	920
SHEARS FOR SECTION IRON					
L at 90 °	mm	80 x 80 x 8	120 x 120 x 10	120 x 120 x 10	120 x 120 x 10
L at 45 °	mm	-	-	-	-
Round bar Ø	mm	35	45	45	45
Square bar □	mm	30	40	40	40
NOTCHING		RECTANGULAR	TRIANGULAR	TRIANGULAR	TRIANGULAR
Plate thickness	mm	10	10	10	12
Angle of	mm	100	100	100	120
Depth	mm	90	-	-	-
Width	mm	42	-	-	-
PUNCHING					
Punching power	kN	500	600	600	850
Maximum capacity	mm	(B) Ø31 x 12 (A) Ø28 x 13	Ø40 x 11	Ø40 x 11	Ø40 x 15
Throat	mm	177	250	500	500
Working height	mm	973	1106	1106	1094
BENDING					
Maximum capacity	mm	100 x 10	150 x 10	150 x 10	200 x 12
GENERAL SPECIFICATIONS					
Motor	kW	3	5,5	5,5	9
N° strokes per minute		34 (stroke 15mm)	32 (stroke 15mm)	32 (stroke 15mm)	40 (stroke 20mm)
Net weight	kg	1000	1390	1750	2400
Gross weight	kg	1200	1598	2012	2760
Packaging dimensions	m	1,3 x 1,1 x 1,85	1,85 x 1,3 x 2,06	2,01 x 1,4 x 2,06	2,31 x 1,2 x 2,05
Volume of seaworthy package	m <sup>3</sup>	2,65	6,05	5	6,68
OPTIONAL EQUIPMENT					
SHEARS FOR SECTION IRON LJ and I section iron	mm	100	120	120	120
PIPE NOTCHING Maximum diameter	mm	60	60	60	60
PUNCHING LARGER DIAMETERS Maximum diameter	mm	Ø100 x 4	Ø100 x 5	Ø100 x 5	Ø100 x 6

(A). Spain, South America, Denmark, Australia, Saudi Arabia, África

(B). Rest of the world.

## Bendicrop Series

Metalwork companies need to perform simple bending work. GEKA has designed the Bendicrop model which, apart from including L,  $\emptyset$ ,  $\nabla$ ,  $\square$ , cutting stations, punching stations and trimming stations, includes a permanent built-in bending station, with capacity up to 100x10 mm. It also has a system to reduce cutting deformation.

### Bendicrop 50

The Bendicrop 50 model comes with an electric stop and two 40 and 70 mm V bending dies.



### Bendicrop 60

There are two different versions of this model: S, (250mm throat) and SD (500mm throat).

The Bendicrop 60 model comes with an electric stop and two 40 and 70 mm V bending dies.



# Bendicrop 85SD

Metal fabricators and construction companies often have to perform simple bending operations. GEKA has developed the BENDICROP 85 SD model which, in addition to the cutting, punching and notching stations  $\perp$ ,  $\emptyset$ ,  $\square$ ,  $\square$ , holds a permanently fitted bending station with a capacity of up to 200x15 mm. Geka's exclusive Bendicrop 85 SD is a dual cylinder machine with 5 working stations. Furthermore, it is fitted with a system to reduce deformation when shearing flat bars.

- **Punching station. More powerful, 500 mm extended throat**
- **Flat bars shearing**
- **Bending station**
- **Triangular notching station**
- **Round and square bars shearing station**
- **Standard hydraulic stop:**

With its special design and vertically-moving blade holder, the Bendicrop 85 SD has a single hydraulic stop that integrates the flat bar, angle, and round and square bar cutting stations.

- **Built-in Safety System:**

The punching guard is linked to a limit switch so that when this guard opens, the punch lowers without pressure during the first pedal interval and rises during the second interval. This makes centering between the die and punch easier and safer for the user.







## HYDRACROP SERIES

Where production requires twin operator machines, higher speeds or greater capacity, GEKA provides the solution with the HYDRACROP range with five work stations:

- Punching
- Flat bar shearing
- Section shearing
- $\varnothing$  and  $\nabla$  shearing
- Notching

# FEATURES

## Design

Every GEKA two-cylinder shearing machine is designed with GEKA's design and manufacturing guarantee.



Single-block bench



Blade holder designed to obtain maximum efficiency in cutting



Hydraulic unit assembly



Notching table with scaled end stops



Electric panel with overload protection elements and integrated controls



Punching table with scaled end stops



Optional T slotted table for special tooling and "die sets"

# WORKING STATIONS

## Punching station

---

Fitted with an independent cylinder creating a large, flexible, universal workstation easily adaptable for mounting special tools and "die sets".

- 1 Cylinder support
- 2 Split double acting cylinder
- 3 Limit switches for punch travel setting
- 4 Generous travel for bending, deep-drawing, forming jobs etc
- 5 Adjustable generous non-turning guiding
- 6 Additional guiding for damping of offset forces and protection of hydraulic seals
- 7 Quick punch change
- 8 Adjustable material stripper
- 9 Table with millimetre scales, included in production kit
- 10 Adjustable measuring stop
- 11 Gooseneck die-holder for punching channel and section
- 12 Adjustable bolster locking device X axis
- 13 Adjustable bolster locking device Y axis
- 14 Fixing bolt at base of gooseneck



# WORKING STATIONS

## Notching Station

This station of the machine has been designed to mount several optional accessories, all of which are normally held in stock.

- Triangular notching at 90°.
- Punching equipment.
- Pipe notching equipment.
- Radiusing of flat bar ends.
- Radiusing corners.
- Notching of footings, etc.

Rectangular punch

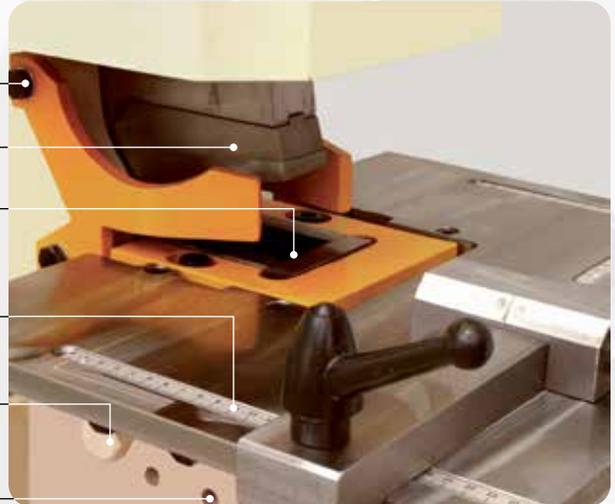
Rectangular punch

Rectangular notching

Table with scaled measuring stops, included in production kit

Cross centring bolts

Fixing holes special tooling



## Shearing of flat bar

The excellent stability of the monoblock blade-holder, which is controlled at the each end, makes it possible to mount a long upper blade with a proven geometry to obtain optimum shearing quality. The radial system allows a generous cutting capacity as a result of the force multiplier effect.

Upper blade with special geometry

Lower blade

Supplement shearing angle control of upper blade, for shearing without deformation

Guide fixing screw

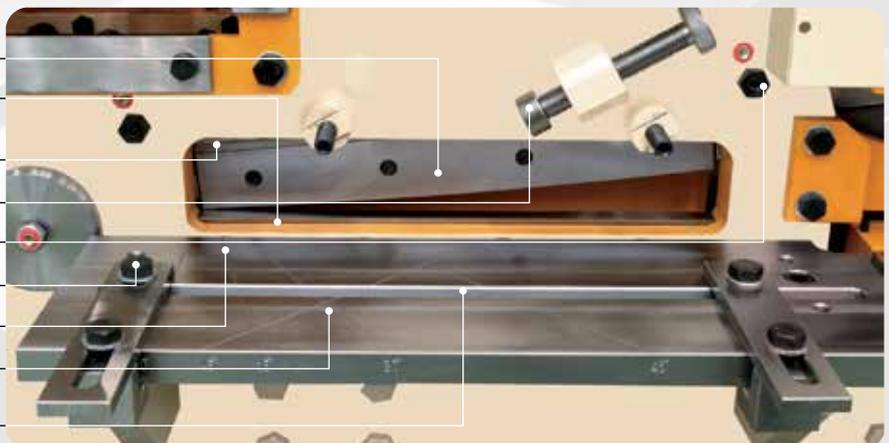
Clearance control of blade-holder

Adjustable guides 45° right and left

Clearance control between shear blades

Flat plate/bar shearing table

Slotted guide positioning with coverage of the entire blade length



## L cutting angle

Fully aware of the importance of distortion free shearing, GEKA has designed a patented system of a floating upper blade that travels along a rectilinear line and is able to shear angles without any deformation or loss of material (single cut); All GEKA Hydracrop models ensure the distortion problem caused by the conventional radial system is now a problem of the past.

Safety protection

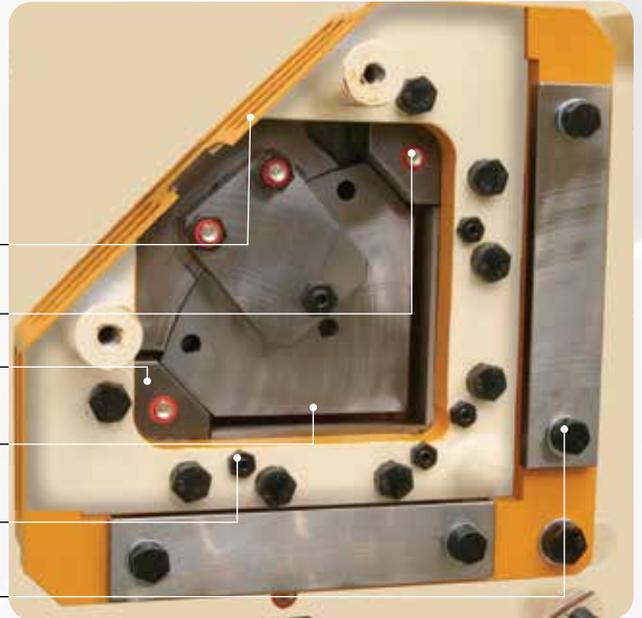
Upper shear blade guides

Lower shear blade guides

Upper shear blade without deformation

Blade gap adjustment screws

Adjustable Support



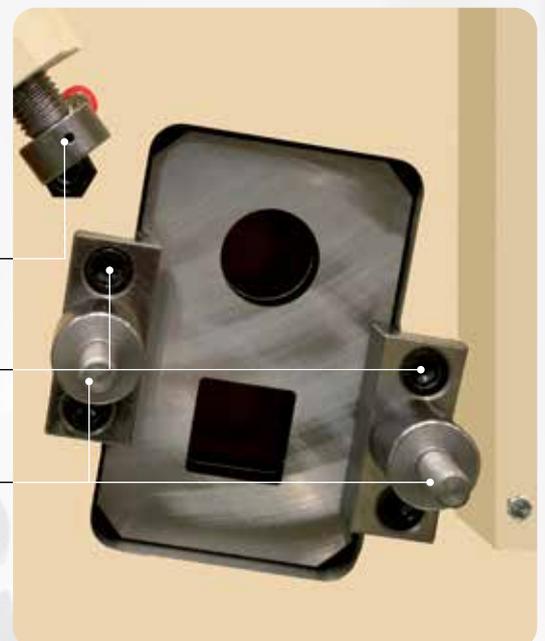
## Cutting of $\emptyset$ and $\nabla$ bars

The GEKA HYDRACROP machines are fitted as standard with blades for cutting  $\emptyset$  and  $\nabla$  bars. Furthermore, this station has been designed bearing in mind the shearing of other sections such as L, I, T for which a large stock of blades is available.

Adjusting bolt and height setting of the guide.

Blade holding flanges

Guide fixing bolts



# HYDRACROP SERIES

5 HYDRACROP MODELS: 55/110, 80/150, 110/180, 165/300, 220/300

Hydracrop comes in five models with different capacities: There are two different versions of each model: S and SD.

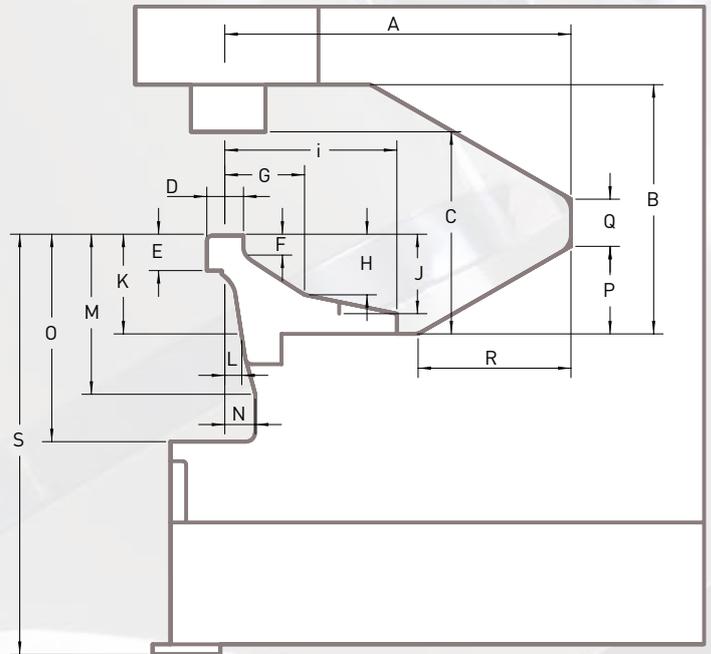
The first figure indicates metric tons on the punching end.  
The second figure, metric tons on L-shearing end.

## Versión S

- Machines driven by two cylinders.
- 5 work stations, fitted with tools for L, shearing, bars  $\varnothing$  and  $\square$ , shearing, rectangular notching and punching.
- Quick change punch.
- Flat bar shearing table with adjustable guides.
- 2 simultaneous work stations.
- Ready for "Production pack" comprising:
  - Precision punching table with x & y measuring stops.
  - Precision notching table with x & y measuring stops.
  - One metre "touch & cut" length stop with fine adjusting.
  - Lamp for enhanced vision of cutting zones.
  - 10 sets of round punches and dies.
- Greater speed backed by a powerful hydraulic unit.
- Special equipment for approaching at reduced pressure and slow speed.

## Versión SD

- The same features as the S version, but with a deeper throat for larger plate and sheet metal applications.



		A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S
HYDRACROP55	S	254	350	280	65	57	33	120,5	81	233,5	81	137	25	208	35	233	72	268	125	1066
	SD	508	350	280	65	57	33	120,5	81	233,5	81	137	25	208	35	233	99	110	170	1066
HYDRACROP80	S	305	370	300	65	64	31	123	89	253,5	89	144	25	234	45	304	120	250	120	1094
	SD	510	370	300	65	64	31	123	89	253,5	89	144	25	234	45	304	130	70	225	1094
HYDRACROP110	S	305	395	325	79	81	40	140,5	96	267	96	161	25	256	45	311	120	275	120	1151
	SD	610	395	325	79	81	40	140,5	96	267	96	161	25	256	45	311	150	72	260	1151
HYDRACROP165	S	510	450	380	85	79	47	158	104	322	142	200	25	369	45	450	160	80	160	1110
	SD	610	450	380	85	79	47	158	104	322	142	200	25	369	45	450	150	100	260	1110
HYDRACROP220	S	385	470	400	85	79	47	158	104	322	142	200	25	372	45	450	35	350	35	1090
	SD	475	470	400	85	79	47	158	104	322	142	200	25	372	45	450	85	300	85	1090

Measurements in mm.

# HYDRACROP SERIES

55/110  
S, SD

80/150  
S, SD

110/180  
S, SD

165/300  
S, SD

220/300  
S, SD

## SHEARS FOR FLATBAR

		55/110	80/150	110/180	165/300	220/300
Flatbar (with slight deformation)	mm	300x15	450x15	600x15	750x20	750x20
	mm	200x20	300x20	400x20	400x30	400x30
Length of blade	mm	305	475	605	765	765
Square bar $\square$	mm	25	-	-	-	-
Working height	mm	880	850	960	870	870
Cut of an L leg at 45°	mm	60	80	100	120	120

## SHEARS FOR SECTION IRON

		55/110	80/150	110/180	165/300	220/300
Shearing power	kN	1100	1500	1800	3000	3000
L at 90 ° without deformation	mm	120x120x10	130x130 x13	152x152x13	205x205x18	205 x205x18
L at 45 ° (2legs)	mm	70x70x7	70x70x7	70x70x7	70x70 x 7	70x70x7

## WITH SPECIAL BLADE

L at 90 ° (with slight deformation)	mm	130x130x13	152x152x13	160x160x16	205x205x25	205x205x25
-------------------------------------	----	------------	------------	------------	------------	------------

## SHEARS FOR BARS

Round bar $\emptyset$	mm	40	45	50	60	60
Square bar $\square$	mm	40	45	50	60	60

## WITH SPECIAL BLADES

UPN	mm	120	140	160	180	180
IPN	mm	120	140	160	180	180

## NOTCHING

Plate thickness	mm	10	12	13	16	16
Angle of	mm	100	100	100	120	120
Depth	mm	90	90	90	110	110
Width	mm	42	52	52	58	58

## PUNCHING

Punching power	kN	550	800	1100	1650	2200	
Maximum capacity	mm	$\emptyset$ 40x10	$\emptyset$ 40x14	$\emptyset$ 40x20	$\emptyset$ 40x30		
	mm	$\emptyset$ 20x20	$\emptyset$ 24x24	$\emptyset$ 28x28	$\emptyset$ 34x34	$\emptyset$ 40x40	
Throat	S SD	mm	250 500	300 500	300 610	510 610	385 475
Stroke	mm	60	70	80	100	100	
Working height	mm	1085	1095	1165	1110	1110	

## GENERAL SPECIFICATIONS

N° strokes per minute (stroke= 20mm)			37	40	28	31	26
Motor	kW		5	9	9	15	15
Net weight	S SD	kg	1390 1750	2070 2400	2750 3300	5200 6300	5900 7000
Gross weight	S SD	kg	1598 2012	2323 2760	3162 3795	5980 7245	6875 8050
Packaging dimensions	S SD	m	1,67x1,16x2,09 2,10x1,16x2,09	2,13x1,20x2,05 2,31x1,2x2,05	2,13x1,20x2,20 2,69x1,4x2,20	2,83x1,60x2,20 2,95x1,60x2,20	2,88x1,60x2,40 3,04x1,60x2,40
Volume of seaworthy package	S SD	m <sup>3</sup>	4,04 5,09	4,72 6,68	5,62 8,28	10 10,38	11,06 11,67

- Capacities based on a material resistance of 45 Kg/mm<sup>2</sup>.
- The manufacturer reserves the right to make modifications without prior notice.

# HYDRACROP SERIES



## Hydracrop 55/110

Shearing of flat plate	300 x 15 mm 200 x 20 mm
L cut with standard blade (no distortion):	120 x 120 x 10 mm
L cut with optional blade (minor distortion):	130 x 130 x 13 mm
Shearing of $\emptyset$ and $\sphericalangle$ bars	40 mm
Punching capacity $\emptyset$	40 x 10 mm

# HYDRACROP SERIES

## Hydracrop 80/150

Shearing of flat plate	450 x 15 mm 300 x 20 mm
L cut with standard blade (no distortion):	130 x 130 x 13 mm
L cut with optional blade (minor distortion):	152 x 152 x 13 mm
Shearing of $\emptyset$ and $\nabla$ bars	45 mm
Punching capacity $\emptyset$	40 x 14 mm



## Hydracrop 110/180

Shearing of flat plate	600 x 15 mm 400 x 20 mm
L cut with standard blade (no distortion):	152 x 152 x 13 mm
L cut with optional blade (minor distortion):	160 x 160 x 16 mm
Shearing of $\emptyset$ and $\nabla$ bars	50 mm
Punching capacity $\emptyset$	40 x 20 mm



# HYDRACROP SERIES

## Hydracrop 165/300

Shearing of flat plate	750 x 20 mm 400 x 30 mm
L cut with standard blade (no distortion):	205 x 205 x 18 mm
L cut with optional blade (minor distortion):	205 x 205 x 25 mm
Shearing of $\emptyset$ and $\square$ bars	60 mm
Punching capacity $\emptyset$	40 x 30 mm



## Hydracrop 220/300

Shearing of flat plate	750 x 20 mm 400 x 30 mm
L cut with standard blade (no distortion):	205 x 205 x 18 mm
L cut with optional blade (minor distortion):	205 x 205 x 25 mm
Shearing of $\emptyset$ and $\square$ bars	60 mm
Punching capacity $\emptyset$	40 x 40 mm



# PRODUCTION PACK

## Greater productivity

To obtain maximum output, GEKA provides its customers with the Production kit at a symbolic price, which comprises:



"Touch & cut" electrical end stop – 1 metre long



Set of ten round punches and dies



Work light with magnetic Base





## PUMA SERIES

The GEKA hydraulic punching machines have been designed by experienced technicians, assisted by powerful CAD CAM equipment and adapted to the ongoing suggestions of over 60,000 users of GEKA shears and punching machines, worldwide.

# PUMA SERIES

## FEATURES

- Technically dimensioned bed
- Cylinder with additional guide
- Strong and accurate shaft system to avoid distortions
- Gradual centring of punch
- Quick punch change
- Safety protection
- Ample space for mounting special equipment
- Optimum operation speed
- Large number of optional, standard and special accessories to perform a wide range of jobs
- Range of Puma Models from 55 Tn to 220 Tn with punching throats of between 500mm and 800 mm
- Range of Portable punching machines from 50 Tn with punching throats of 130mm

		PUMA-55	PUMA-80	PUMA-110	PUMA-165	PUMA-220
Punching power	kN	550	800	1100	1650	2200
Maximum capacity	mm	Ø40x10	Ø40x14	Ø40x20	Ø40x30	Ø40x40
Throat	mm	500	510	500	510	510
	mm	750	750	750	760	800

### PUNCHING OF SECTIONS WITH GOOSENECK DIE HOLDER

I on the leg	mm	100-300	100-300	100-450	100-450	100-450
I on the web	mm	100-500	100-500	100-500	120-500	120-500
LJ on the leg	mm	100-300	100-300	120-400	120-400	120-400
LJ on the web	mm	120-260	120-380	120-400	120-400	120-400

### GENERAL FEATURES

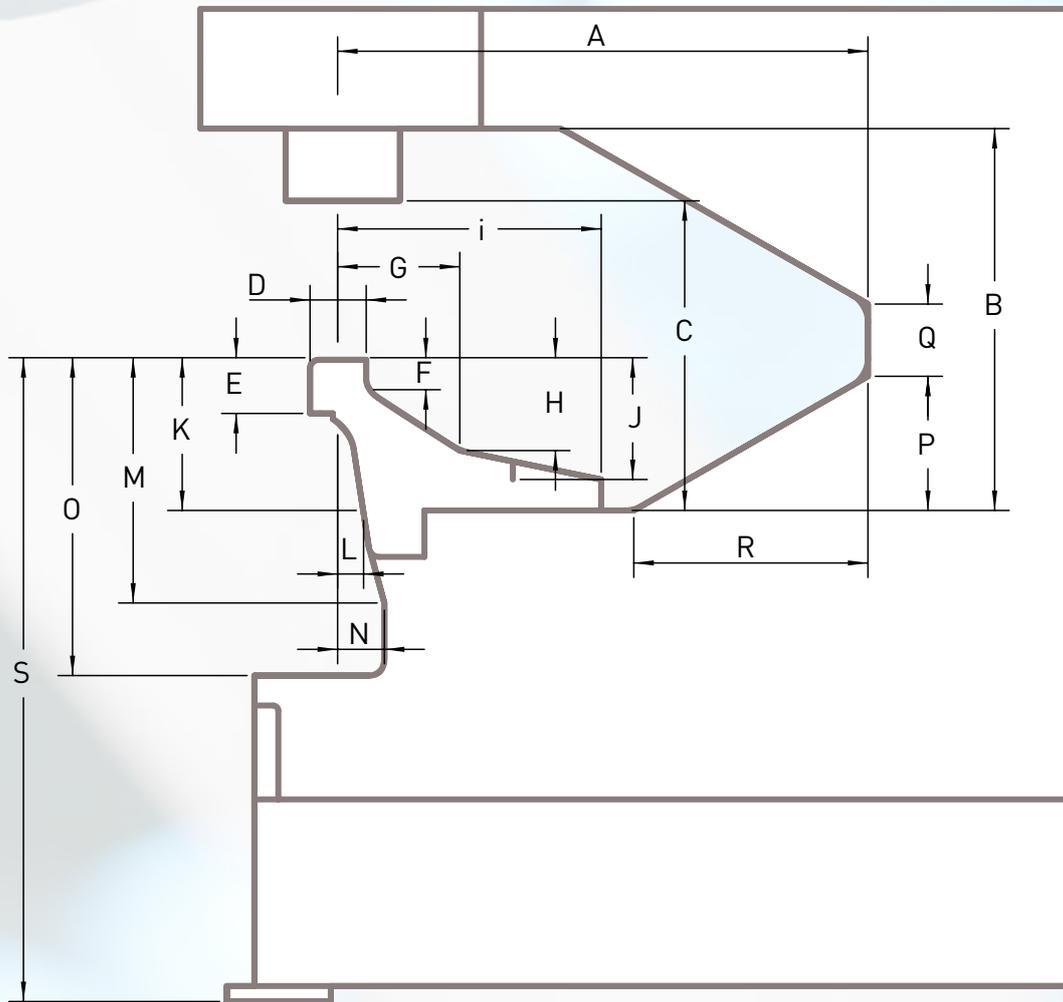
Motor power	kW	5	9	9	15	20
Strokes per minute based on 20 mm stroke		37	40	28	28	25
Maximum stroke	mm	60	70	80	100	100
Working height	mm	1060/810	1094/1194	991/1066	1060/1060	1013/1013
Net weight	kg	1150/1885	1715/2115	3150/3970	4290/4525	5200/5500
Gross weight	kg	1320/2100	1925/2350	3400/4300	4700/5000	5700/6000
Volume	m <sup>3</sup>	3,63/4,17	4,53/5,87	5,55/6,82	7,31/8,95	9,63/10
Dimensions with seaworthy packaging S	m	1,55x1,2x1,95	1,7x1,3x2,05	2,08x1,3x2,05	2,03x1,6x2,25	2,56x1,6x2,35
Dimensions with seaworthy packaging SD	m	1,93x1,2x1,8	2,1x1,3x2,15	2,28x1,3x2,3	2,03x1,6x2,35	2,66x1,6x2,35

### OPTIONAL EQUIPMENT

Pipe notching	mm	60	60	60	60	60
Oversize Punching diameters	mm	Ø100x4	Ø100x6	Ø100x8	Ø100x 12	Ø100x16

- Capacities based on a material resistance of 45 Kg/mm<sup>2</sup>.
- The manufacturer reserves the right to make modifications without prior notice.

# PUMA SERIES



		A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S
PUMA55	S	500	340	270	65	55	33	120,5	81	233,5	1	137	25	231	45	327	102	78	185	1060
	SD	750	340	270	65	55	33	120,5	81	233,5	81	137	25	231	45	327	102	78	185	810
PUMA80	S	510	370	300	65	62	31	123	89	253,5	89	144	25	234	45	304	130	70	234	1094
	SD	750	370	300	65	62	31	123	89	253,5	89	144	25	234	45	304	130	70	278	1194
PUMA110	S	500	420	350	79	79	40	140,5	96	267	96	161	25	326	47	461	95	125	100	991
	SD	750	420	350	79	79	40	140,5	96	267	96	161	25	326	47	461	95	125	100	1066
PUMA165	S	510	450	350	85	79	35	158	104	430	160	200	25	372	45	450	0	240	0	1060
	SD	760	450	380	85	79	35	158	104	430	160	200	25	372	45	450	141	98	245	1060
PUMA220	S	510	450	375	85	79	33	162	100	435	151	198	30	-	30	483	0	330	0	1013
	SD	800	450	375	85	79	33	162	100	435	151	198	30	-	30	483	125	200	216	1013

Measurements in mm.

# PUMA SERIES

## Puma 55

Punching power	550 kN
Max. capacity Ø	40 x 10 mm
Max. capacity Ø	20 x 20 mm
Max. capacity ∅	28 x 11 mm
Throat	500 / 750 mm



## Puma 80

Punching power	800 kN
Max. capacity Ø	40 x 14 mm
Max. capacity Ø	24 x 24 mm
Max. capacity ∅	28 x 16 mm
Throat	510 / 750 mm



# PUMA SERIES

## Puma 110

Punching power	110 kN
Max. capacity Ø	40 x 20 mm
Max. capacity Ø	28 x 28 mm
Max. capacity ∇	28 x 20 mm
Throat	500 / 750 mm



## Puma 165

Punching power	1650 kN
Max. capacity Ø	40 x 30 mm
Max. capacity Ø	34 x 34 mm
Max. capacity ∇	28 x 28 mm
Throat	510 / 760 mm



# PUMA SERIES

## Puma 220

Punching power	2200 kN
Max. capacity $\varnothing$	40 x 40 mm
Max. capacity $\square$	28 x 28 mm
Throat	510 / 800 mm



# PUMA SERIES

The PP-50 portable punching machines have a punching power of 500 kN and a throat of 130 mm.

There are two types of this model:

- P Model

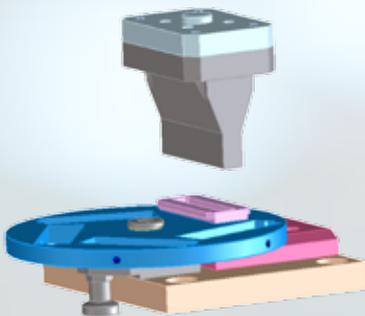
With table with T grooves, recommended for use with "die sets" and special tooling.

- G Model

For general punching of sheet metal and steel section.



## MANUAL MARKING STATION



- Marking unit with 5 references.
- The selection of the reference is made manually.
- Each reference has 6 characters which the operator can change manually.

## FEATURES

Punching power		500 kN
Maximum punching capacity		27 x 13 mm
Maximum stroke		30 mm
Throat		130 mm
Motor power		3 kW
Cycles per minute (20 mm. stroke)		23
Net weight	(G)	355 kgs
	(P)	415 kgs
Gross weight	(G)	480 kgs
	(P)	540 kgs
Dimensions with maritime packaging		1,1 x 0,9 x 1,55 m
Volumen		1,53 m3

## OPTIONAL EQUIPMENT (P)

Oversize unit for punching diameters		Ø40 x 8 mm
Marking		



The use of original GEKA consumables and special equipment ensures better performance and durability for your GEKA machine.



## GEKA ORIGINAL OPTIONAL EQUIPMENT AND ACCESSORIES

- STANDARD ACCESSORIES
- OPTIONAL ACCESSORIES
- SPECIAL ACCESSORIES

Our range of solutions is intended to cover all your needs in the steel fabrication business. Discover how GEKA can help you to improve your productivity and results.

GEKA has the broadest range of original accessories and optional equipment on the market.

# ACCESSORIES

## STANDARD ACCESSORIES

GEKA Universal Punching Shears are sold with a complete equipment of tools, whose quality and resistance give the product a great quality/price relationship.

Each workstation is equipped so that the user can carry out different productive activities comfortably and easily, saving time, energy and costs.

All our machines include a "Production kit", comprising the punching and notching tables, automatic stopper with electric trigger, 10 sets of round dies and matrices and a halogen lamp.

Some standard accessories:

- Standard punching equipment.
  - Microcrop
  - Minicrop
  - Hydracrop 55
  - Hydracrop 80
  - Hydracrop 110
  - Hydracrop 165
  - Hydracrop 220
- Standard rectangular notching equipment.
  - Microcrop
  - Hydracrop 55
  - Hydracrop 80
  - Hydracrop 110
- Standard cutting of  $\varnothing$  and  $\nabla$ .
  - Microcrop
  - Multicrop
  - Bendicrop
  - Hydracrop 55
  - Hydracrop 80
  - Hydracrop 110
  - Hydracrop 165
- Standard cutting of L at 90°
  - Microcrop
  - Minicrop
  - Multicrop
  - Bendicrop
  - Hydracrop 55
  - Hydracrop 80
  - Hydracrop 110
  - Hydracrop 165
- Standard cutting of flat bar
  - Microcrop
  - Minicrop
  - Hydracrop 55
  - Hydracrop 80
  - Hydracrop 165



# ACCESSORIES

## OPTIONAL ACCESSORIES

GEKA has a wide range of optional accessories that are easily installed, for the punching, cutting and notching stations that will allow you to increase your production levels and shorten your delivery deadlines.

These accessories, available in stock, provide our customers with a fast and economical solution to their needs.

Our philosophy is to cover the production needs of our customers with the best quality and in the fastest time possible.

### Punching

Different options for punching different diameters and shapes in sheet metal, tubes, angles or sections in strips. Likewise we have a complete range of solutions for the rounded cutting of sheet metal strips or edges.

### Section cutting

Blades for cutting U, I and T shaped sections

### Notching

Rectangular, triangular sheet metal, L-shaped section or tube edge notching equipment.

### Bending

All types of bending for rims and angled sections.

Our Bendicrop models have an integrated bending station.

For the rest of the machines the bending equipment connects at the punching or notching station.

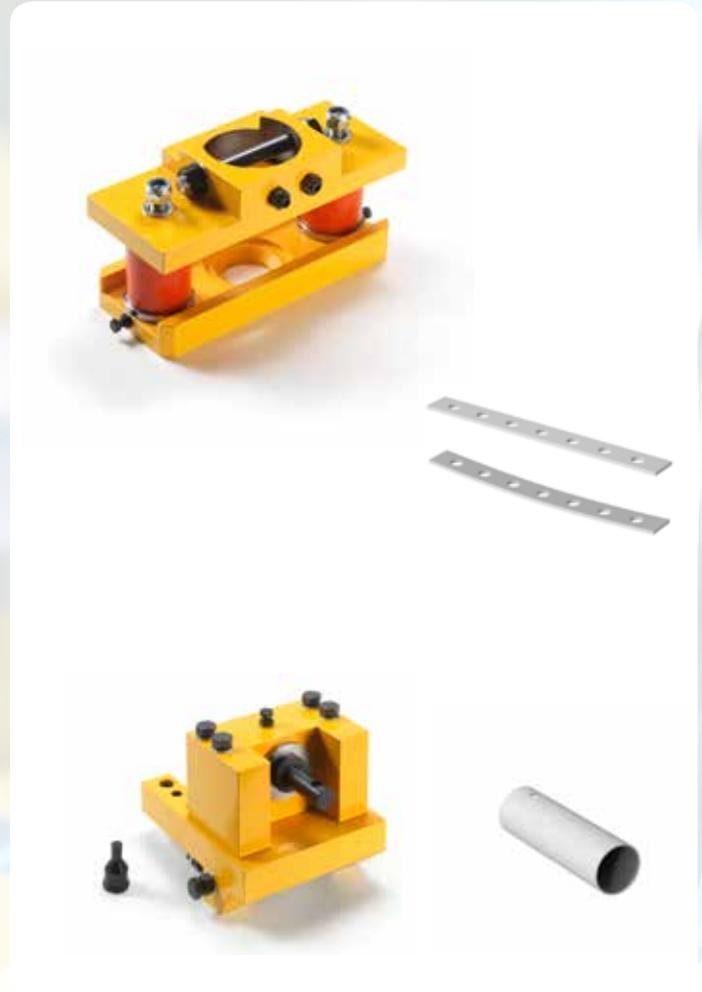


# ACCESSORIES

## OPTIONAL ACCESSORIES

Some standard optional accessories:

- T profile cutting, round and square bar cropping
- Equipment for cutting U and I profiles
- Oversize punching unit up to diam. 100mm
- Triangular notching unit
- Rectangular notching unit
- Claw equipment
- Tube notching unit
- Hydraulic hold-down for angles and flats
- Punching unit UPN from 40 to 80mm
- Urethane stripper
- Punching at the end of tube
- Triple punching head fix
- Standard press brake
- Longitudinal press brake
- Oversize punching unit up to diam. 160mm
- ...



Other available optional equipment for positioning:

Support tables and stoppers, of easy use, which contribute to improve productivity, offer greater safety and help to improve the precision and quality of the result.



# ACCESSORIES

## System for punching holes in a straight line

**Flip Stop:** It is a manually-adjustable mechanical stop unit to punch holes in a straight line.

The unit consists of a work surface, to be mounted on the machine, with 2 stops to control depth and one ruler, 2 metres long per module, which is mounted after the die holder, with 8 additional retractable stops per module.



## Options to increase shear productivity.

**Electric Stop:** It covers the shearing stations.

**Actuation:** The material is pushed manually and when this comes into contact with the electric stop head, the machine performs one complete cutting cycle. The length is adjusted using the millimetre rule with a fine head (see photo).

This device is included in the production kit and all machines are supplied completely pre-installed.



# ACCESSORIES

## SPECIAL ACCESSORIES

On many occasions, our users need to carry out special jobs, which do not fit in with any of the classical options of Conventional Punching Shears. For this reason, GEKA makes available to its users a team of engineers, with extensive experience in the development of all kinds of tools and special applications.

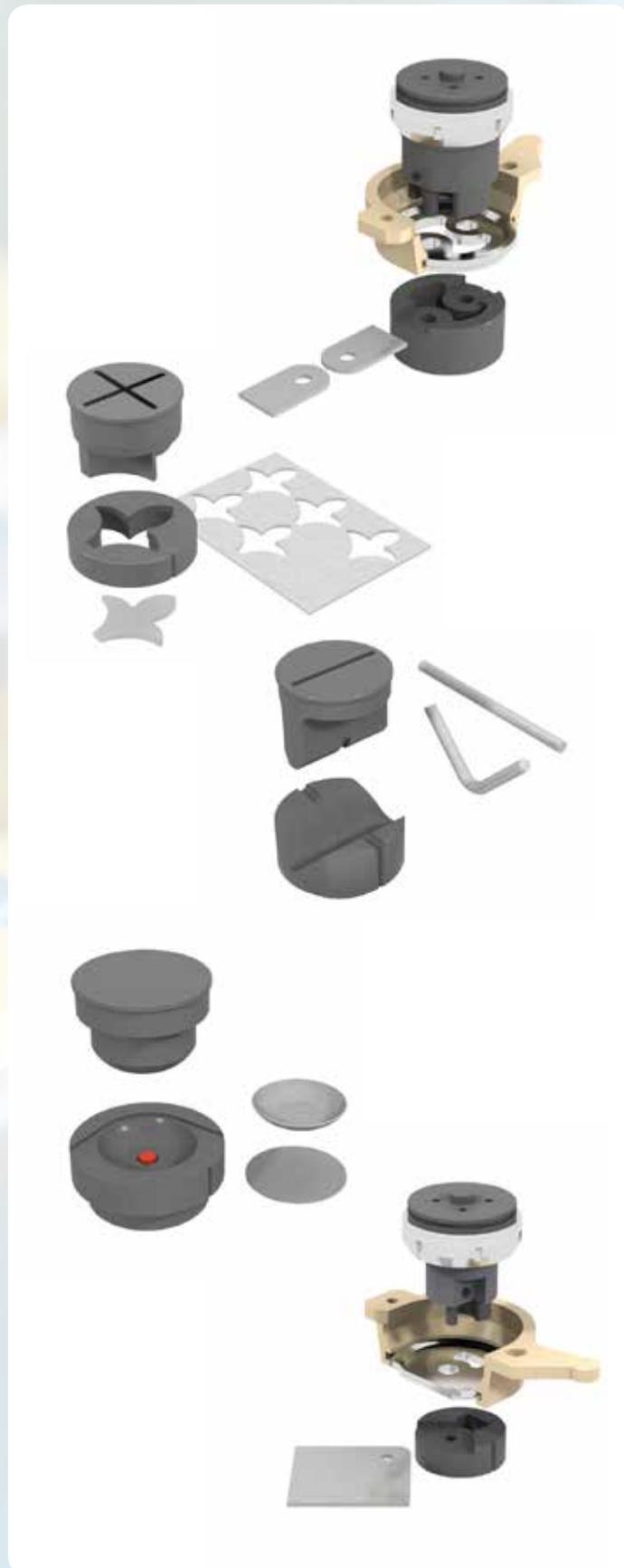
Geka currently has a complete range of over 7000 personalised designs of accessories for special applications.

Our versatility and continuous innovation allows us to continue being faithful to our goal of adapting to the needs of our customers.

We will show you a small selection of some of our special accessories, designed to cater to the demands of our customers:

- Rounding and punching flattened pipe
- Profiles punching
- Punching oblong special l and u
- Pipe notching
- Key notching in u
- Special notching without plan
- Multiple punching
- Flat bar shearing and punching
- Flower shape
- Angles rounding and punching
- Punch+die flat bar shearing
- Shearing and special notching
- Special notching
- Shearing, notching and 2 punching
- Doble punching upn
- Punching (notching area)
- Flat bar rounding in notching
- Flat bar rounding+ 2 punches
- Flat bar rounding+4 punches
- Direct shearing and punching
- Notching of louvres n 13
- Notching of louvres n 13 with hold down
- Triple notching of louvres
- Guided punching
- Metal ring punching
- Flat bar notching for t profile
- Elastic hold down Hydracrop
- Elastic hold down Minicrop Microcrop
- Chain shearing
- Flat bar rounding/direct + punching

...



# CONSUMABLES

More than 8,000 different manufactured models give us the necessary experience and knowledge to be able to design almost any accessory or optional equipment, whether standard or custom-designed.

The following are just a few examples of the tools and accessories GEKA can supply.

## Punches and dies



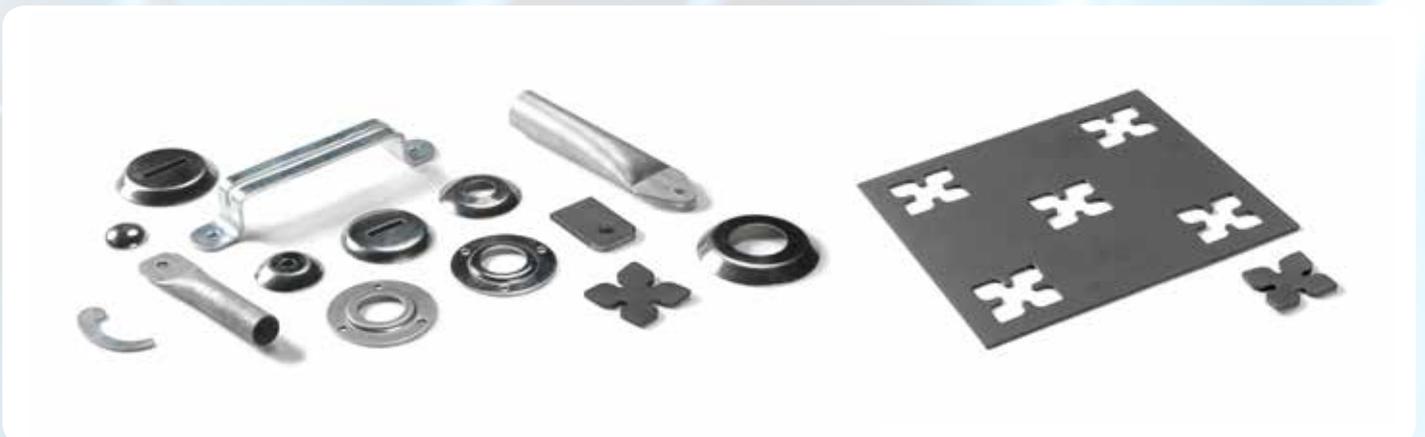
## Shearing blades



## Notching blades



## Multiple possibilities







# GEKA CNC SOLUTIONS

Against a background of growing international competition, automation and innovation in production processes are key factors in guaranteeing a company's competitive edge.

With a view to achieving more precision and productivity, GEKA has included automated mechanisms in its equipment.

GEKA combines the latest in CNC technology for the automated processing of angles and profiles, decades of experience in shearing and punching, and state-of-the-art automation. Our products are technically superior, possessing a natural advantage in the market place. GEKA is a premium quality brand.

# POSITIONING DEVICES

## Semi-Paxy

Our Semipaxy product line brings the newest CNC automation and positioning technology to punching of steel. This unit is equipped with programmable stops along the X- and Y-Axis. Mounted onto existing or new GEKA models with a minimum throat size of 500 mm, our Semipaxy is available as part of an option package for our HYDRACROP SD or PUMA family of products.

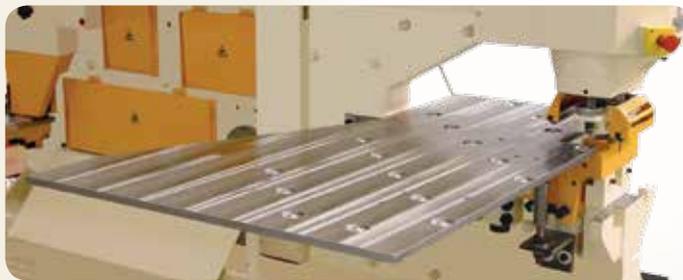
**Versions:**

X 1000: Accomodates material with a maximum length of 1.000 mm

X Plus: Accomodates extension devices for longer material: 2000, 3000, 4000, 5000 and 6000 mm

**Maximum Widths according to Model:**

- HYDRACROP or PUMA (500 mm throat) = 400 mm
- HYDRACROP Models 110SD and 165 SD = 500 mm
- PUMA (750 mm throat) = 650 mm



**MOTION-ENHANCING FEATURES**

- Integrated ball transfers along table top permit convenient positioning of material
- Spring-loaded trackballs equipment



**PC-CONTROL**

- Standard, color touch screen monitor and keyboard
- User-friendly graphic interfaces and programming
- Importing of .dxf and .dstv format files

**Basic features:**

- Support chassis
- Two servo motor-driven positioning carriages
- Touch screen
- Conveyor assembly consisting of independent servo drives along each axis, spindle and encoder units

**Standard operation:**

- 1) Program the coordinates of each perforation (absolute or by increments)
- 2) Run application (sets automated stops for the first perforation)
- 3) Place material securely against the stops and depress the punching pedal
- 4) Once the perforation is complete, the automated stops reposition themselves for the next programmed perforation
- 5) Repeat the sequence until the end of the program

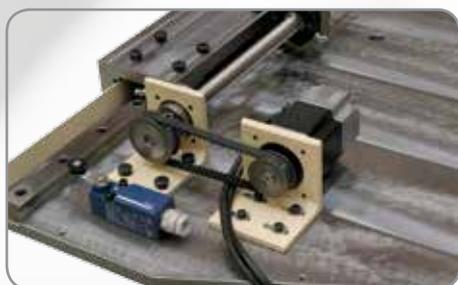


**TRIPLE-PUNCHING HEAD**

- Three on-demand, programmable punches
- Diameters up to 40 mm
- Punching is accomplished by means of forcible strokes or blows
- Excellent for operations requiring identical perforations with varying diameters

**FEATURES**

Rate of Motion (X-Axis)	0-12 m/min
Rate of Motion (Y-Axis)	0-12 m/min
Position Tolerance	+/- 0,20 mm/min
Repeatability	+/- 0,1 mm



Basic Semipaxy Version detailing servo drive-spindle-encoder assembly



# Feeders

## PAX

Our PAX product line guarantees the automated positioning of material along the X-Axis permitting sequential multiple punching of profiles.

**Basic features:**

- Conveyor unit and positioning clamping guides
- Clamping of material
- Servo motor positioning
- Linear roller table top
- Manually-adjustable set of transverse roller guides
- Touch screen monitor

**FEATURES**

Available strokes	Meter by meter*
Max. feed speed	24 m/min
Position Tolerance	± 0,25 mm/m
Max. feed weight	250 kg
Repeatability	± 0,15 mm

\* from 3 meters



Feeder slide PAX unit



# ALRS

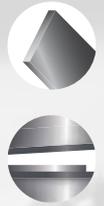
The ALRS product line is an automated feeder of flat bar, available as part of an option package for our HYDRACROP shearing stations.

Eliminating cumbersome manipulation of material, our ALRS saves you time and substantially increases your productivity while maximizing accuracy.

Our user-interface supports simultaneous processing of multiple lengths and their respective configurations, making programming of various jobs quick and easy.

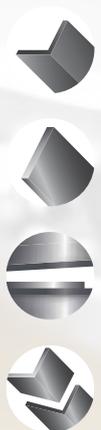
## FEATURES

	ALRS 600	ALRS 750
Max. flat bar width (mm)	600	750
Max. flat bar length (mm)	7000	7000
Displacement speed	18 m/min	18 m/min
Positioning accuracy	+/- 0,2 mm/m	+/- 0,2 mm/m



# FAAS

- CNC feeder for automatic cropping of flat bars and angles
- Ideal solution for construction manufacturers, base plates and clip angles
- Carriage driven by rack and pinion and servo motor
- Hydraulic hold down for flat bars and angles
- 600x15 mm (flat bars) and 150x150x13 mm (angles) cropping capacity
- 6 m (20 ') length of bars
- Make the most including a semipaxy to the FAAS system
- To be fitted on Hydracrop 110 S / SD models



# FLAT BAR PROCESSING

The ALFA product line is designed for automated punching, marking and shearing of flat bars. This yields a final product in one single process, significantly increasing productivity, maximizing efficiency, and dramatically reducing cost and downtime.

ALFA is the ideal choice for steel truss construction, bridge building, manufacturing of electric power transmission equipment, steel fabricators, marine metal fabrication and for high-volume flat bar processing.



**MITER SHEAR UNIT**  
Flar bar cuts (-45 ° to +45 °)



	ALFA 150	ALFA 500	ALFA 500/150	ALFA 500/165T	ALFA 500/220T
Flat Bar Size (Min.)	25x4 mm	50x5 mm	50x5 mm	100x10 mm	100x10 mm
Flat Bar Size (Max.)	150x10 mm	500x20 mm	500x20 mm	500x30 mm	500x40 mm
Horizontal-Wing Punches	2	3	3	up to 3	up to 3
Maximum Diameter	31 mm	40 mm	40 mm	40 mm	40 mm
Punching Force	640 kN	1100 kN	1100 kN	1650 kN	2200 kN
Marking	-	Disc	Disc	Disc	Disc
Number of characters	-	40	40	40	40
Vertical wing punches	-	-	1	-	-
Maximum Diameter	-	-	31 mm	-	-
Vertical Punching Force	-	-	600 kN	-	-
Angle Processing (Min. Size)	-	-	40x40x4 mm	-	-
Angle Processing (Max. Size)	-	-	150x150x15 mm	-	-
Drilling Unit	✓	✓	✓	✓	✓

Capacities based on material resistance at 45 kg/mm<sup>2</sup>

# ALFA 500



# ALFA 150



# PLATE PROCESSING

GEKA's PAXY product line offers CNC solutions for automated punching of steel plates.

The PAXY line automates tedious and time-consuming preliminary tasks, such as center marking and manual positioning. These solutions maximize productivity, reduce costs and increase accuracy.



## FEATURES

	PAXY
Material feeding	automatic
Positioning	automatic
Nº of Axis	2
The minimum area	1000x500 mm



# ANGLE-PROCESSING LINES

For customers looking to large volume processing of angles, quickly and efficiently while optimizing cost, GEKA brings you the most cost effective solution for automated punching and shearing.

Builders of steel truss structures, towers for electric transmission lines and telecommunications equipment, overhead railway power lines, and any structure that requires a large amount of angular profiles. GEKA machines make the best partners.

	C2PL 65	C2PL 80	DPS 150	ALPS 150	ALPS 160
Minimum L	40x40x4 mm	40x40x4 mm	35x35x4 mm	35x35x4 mm	35x35x4 mm
Maximum L	65x65x7 mm	80x80x8 mm	150x150x15 mm	150x150x15 mm	160x160x16 mm
Minimum Flat Bar	•	•	•	50x5 mm	50x5 mm
Maximum Flat Bar	•	•	•	150x15 mm	160x16 mm
Minimum U	•	•	•	60x30 mm	60x30 mm
Maximum U	•	•	•	120x60 mm	120x60 mm
Marking	•	•	disc	cassette	cassette
Characters	•	•	40	5x10 size typeface	5x10 size typeface
N° Punches	2 (1 /wing)	2(1 /wing)	4 (2 /wing)	6 (3 /wing)	6 (3 /wing)
Maximum Diameter	18 mm	25 mm	31 mm	31 mm	31 mm
Punching Force	170 kN	340 kN	600 kN	730 kN	730 kN
Shearing Force	350 kN	650 kN	1900 kN	1900 kN	2500 kN
Feeder Speed	Programmable up to 36 m/min				
Positioning Tolerance	+/- 0,25 mm +/- 0,15 mm/m				

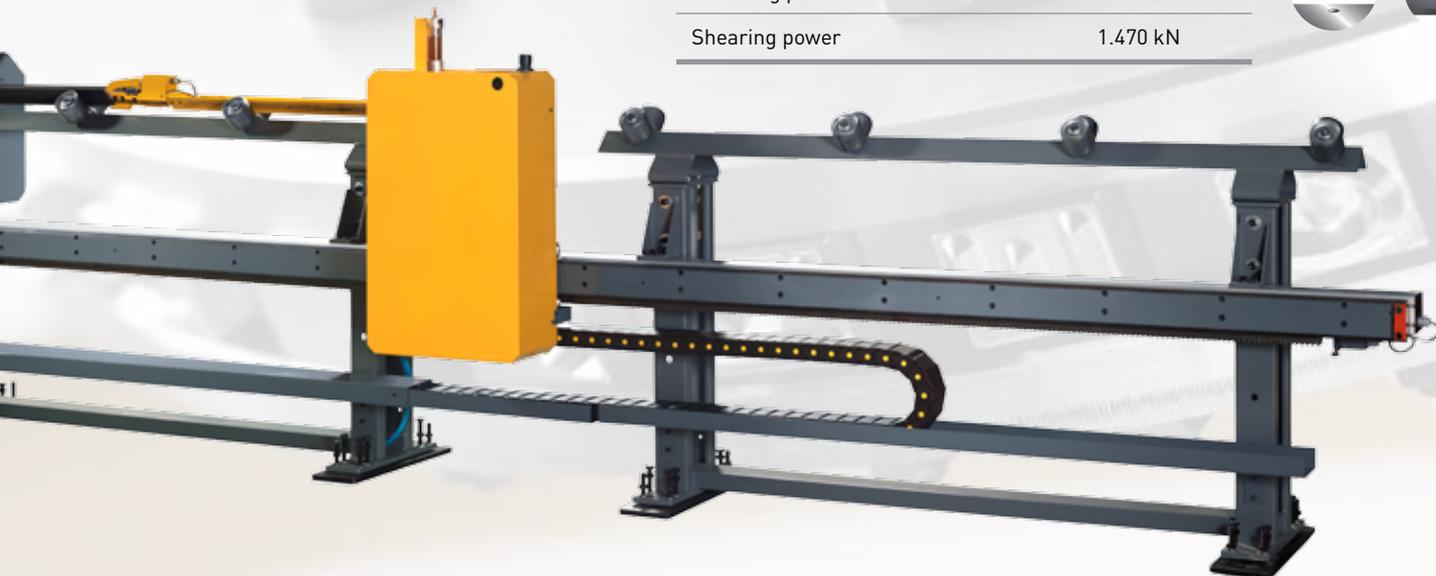
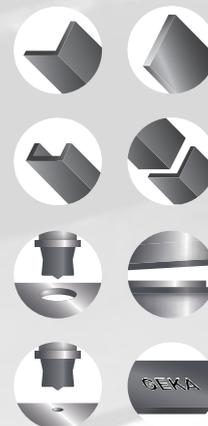
GAMMA TRACTION 100 is the new line by Geka Automation for processing angled sections with a traction system. This version is designed to satisfy the needs of punching, marking and cutting medium-sized angled sections.

Peripherals Available

- AUTOMATED FEEDER
- MARKING UNIT
- DOUBLE PUNCHING UNIT
- MATERIAL UNLOADING SYSTEM
- LINE PRO SOFTWARE

## GAMMA TRACTION 100

Minimum angle	35 x35 x4 mm
Maximum angle	100x100x10 mm
Max. length of profiles	12 m
Number of punches	Up to 4 (2 per leg)
Maximum punch diameter through thickness	31 x 10 mm
Marking	Impact
Punching power	490 kN
Shearing power	1.470 kN





# GEKA Worldwide

Know-how and market share characterize our GEKA success story since our humble beginnings almost a century ago. In the first ninety years, the GEKA Group has forged for itself a proven track record of excellence and performance.

- Over 80% of our production is exported
- Our global network consisting of 60 local distributors all over the world
- Worldwide sales in over 85 countries
- On-demand customer care offering superior service and maintenance

On any given day, more than 80,000 GEKA machines are pounding away on five different continents. Now that's customer satisfaction!





**GEKA**   
The steel working company

[www.geka-group.com](http://www.geka-group.com)

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