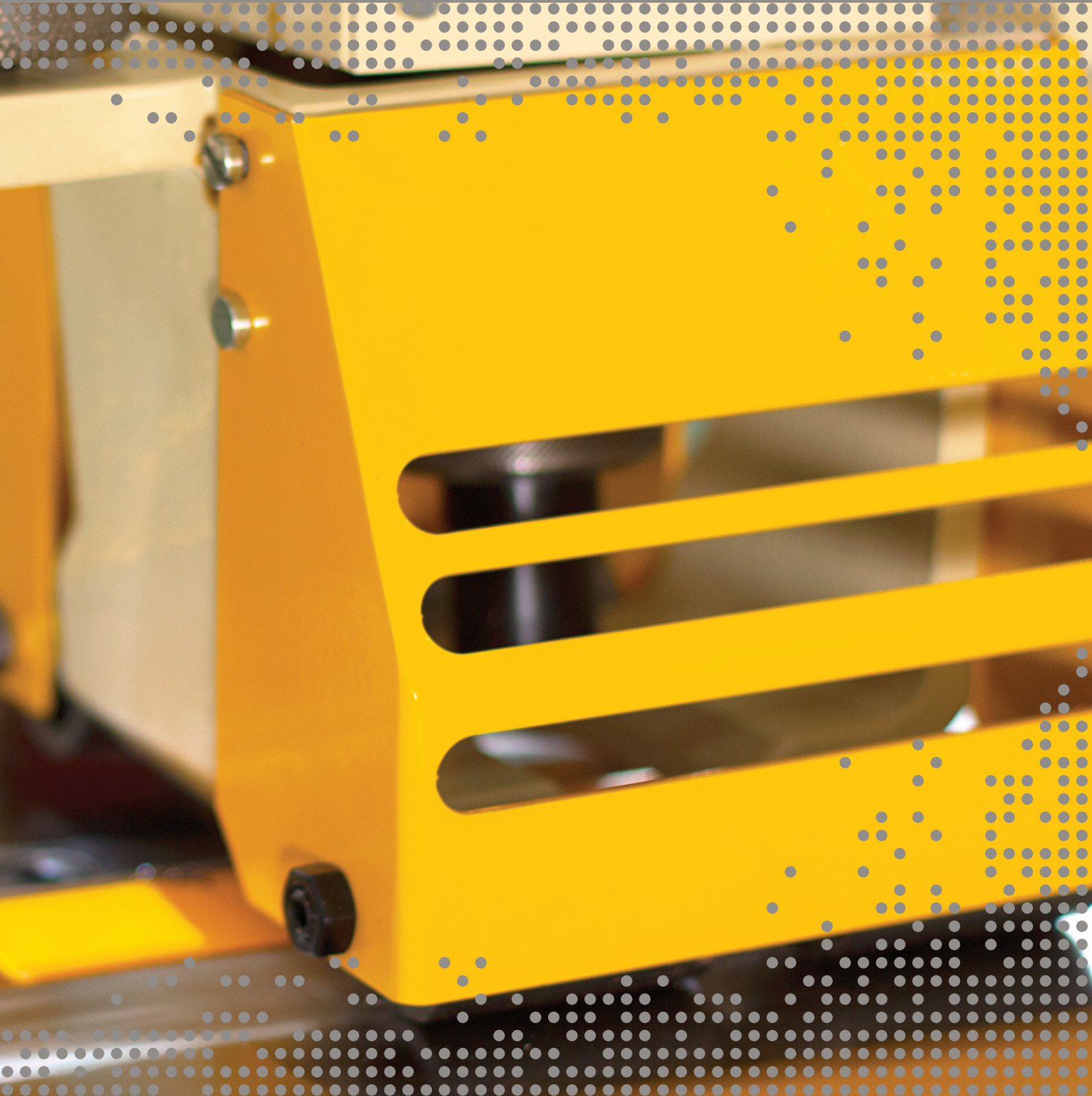



# ONE-CYLINDER PUNCHING AND SHEARING MACHINES



ENGLISH (mm)

**GEKA**   
The steel working company

## 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 SHEARS FOR FLATBAR		MICROCROP	MINICROP	MULTICROP
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 $\square$	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 $\square$	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 LJ 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

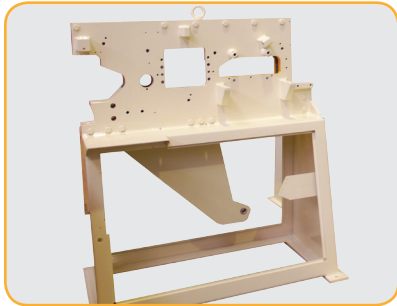
• Capacities are based on a material resistance of 45 kg/mm<sup>2</sup>.



## 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.

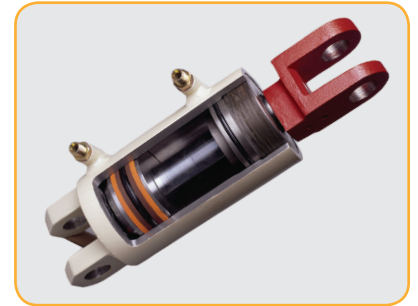
The shearing system consists of one single cut, without wasting any material. **The MINICROP and MULTICROP have been fitted with a patented floating blade for cutting section iron without any deformation of the material.**



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
∅ + ▣	✓	✓	✓

## 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

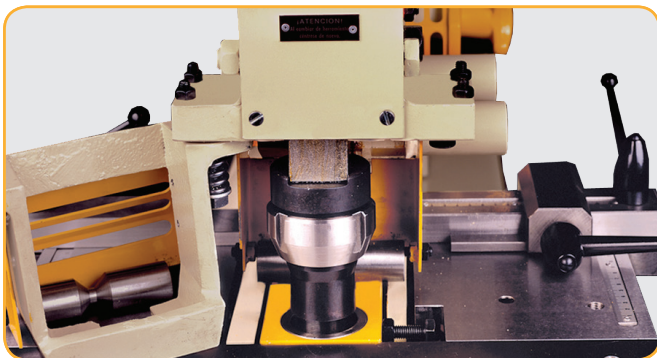
## Punching station

- Monoblock body and sandwich structure
- Blade-holder Adjustment
- Punching
  - $\varnothing 27 \times 10$  mm (Microcrop) and
  - $\varnothing 27 \times 12$  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

- $\varnothing 30$  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

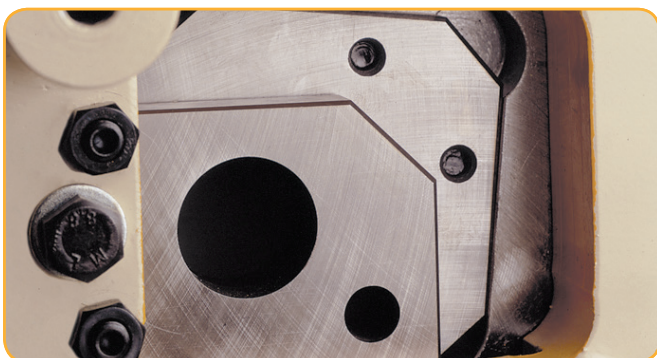
## Optional equipment



Punching equipment up to  $\varnothing 36 \times 8$  mm. in thickness



Rectangular notching



Blades for  $\varnothing$  cut minimum deformation



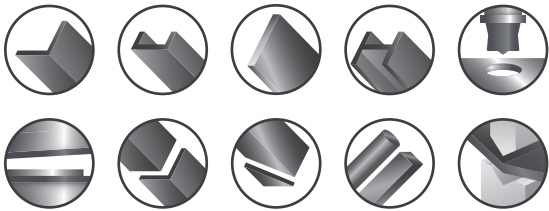
"Touch & Cut" length stop

## Microcrop

IRONWORKER - ONE CYLINDER PUNCHING MACHINE WITH 3 WORK STATIONS:

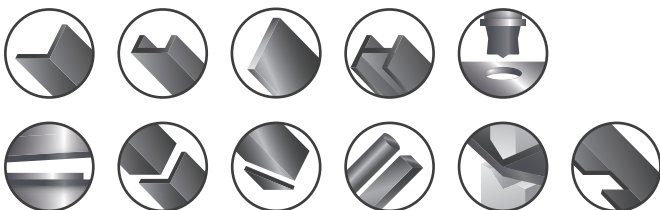
- punching
- shear for flat bars
- angle cutting

Excellent cutting quality on the shearing of flat bar station.



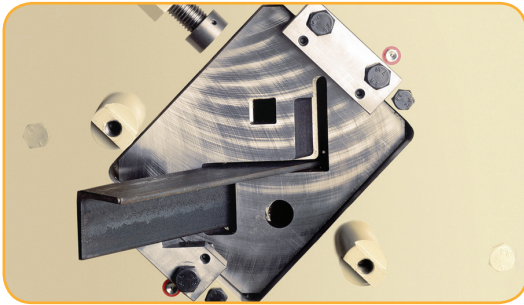
## Minicrop

One cylinder universal ironworker with four work stations (punching, notching, shear for flat bars shear L profiles, cutting of round and square bars).

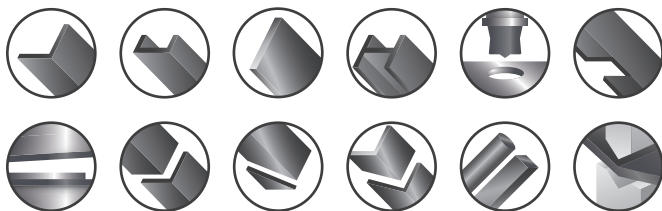


# Multicrop

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 ∇.



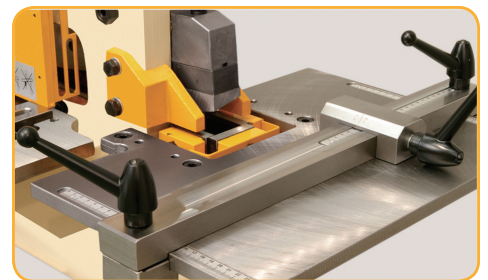
## Common features to Minicrop and Multicrop



Goose neck die-holder for punching



Ø and ∇ cut without deformation



Rectangular notching equipment

# GEKA GROUP

## Quality Know-how Service



### 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, Gamma Traction, Sigma110...



### 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.

**GEKA**   
The steel working company

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