

KINGSLAND



for impressive
performances



PUNCH RANGE

hydraulic punching machines

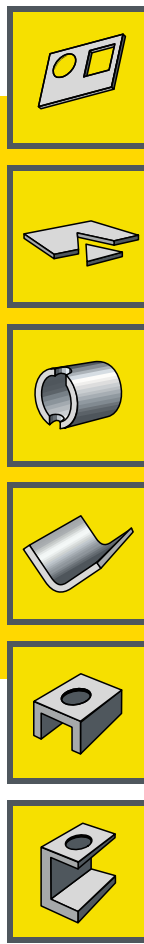


PUNCH RANGE

punch - double punch

The Kingsland range of Hydraulic Punching machines all come equipped with a deep throat of 25" 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 Kingsland Hydraulic Punching machines are also available in double-ended execution, using a shared frame and thus saving 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. The punching machines are available from 60 ton to 175 ton, both in single-ended as well as double-ended execution! Further-more, 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 2 1/4" diameter/slot. The front part of the table can be removed in order to punch in large format angle-iron.

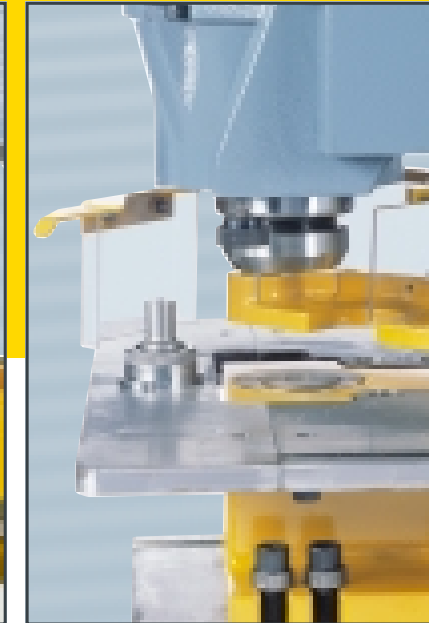


punch station-applications

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



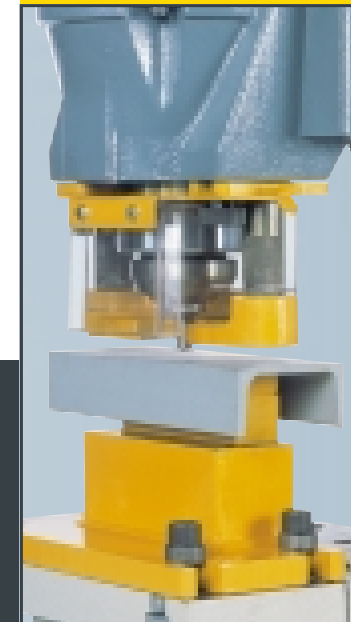
quick tool change
Quick change punch holder. Only needs to turn the punch holder by 90° to lock in position.



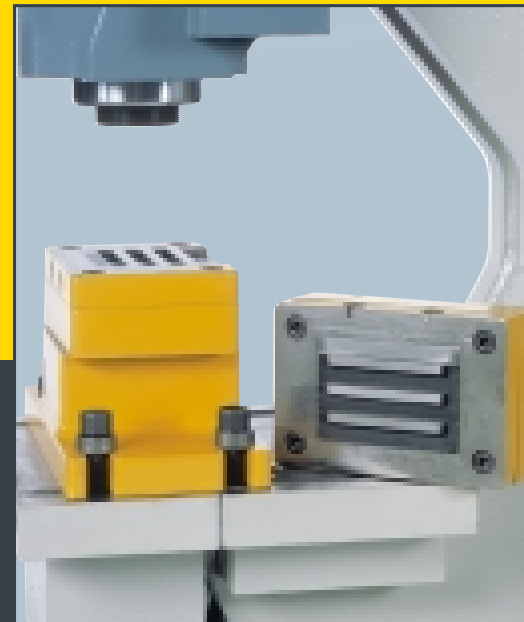
large hole attachment
Large hole/slot attachment for diameters from 1 1/2" up to 4 3/8". Also available for diameters up to 6 3/8" or 9".



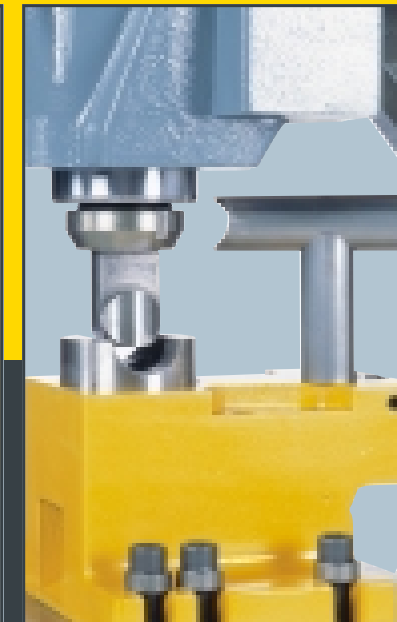
channel/beam web bolster
Specially designed web bolster for punching in the web of channel or beam. Bolsters for special profiles available on application.

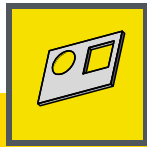


louvre punch unit
Special punch unit for punching ventilation applications.

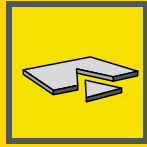


tube notch unit
For 90-degree connection with tubes. Available for outside diameters up to 6 1/2".



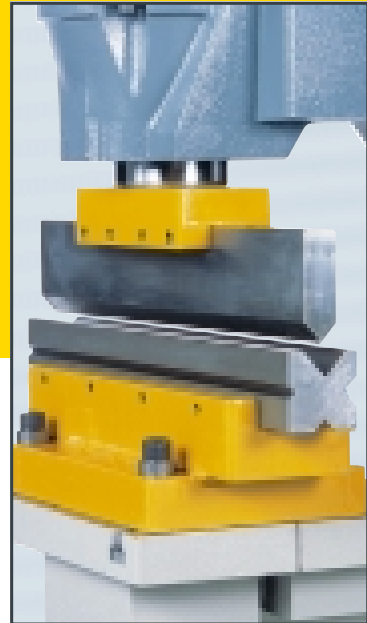


punch station-applications



sheet bending unit

Sheet bending unit with multi-vee block (with 3/8", 3/4", 5/16" and 1 1/2" wide V-openings, all 85°).

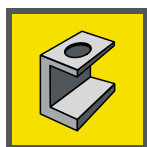
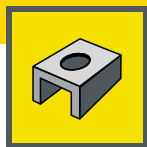
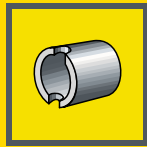
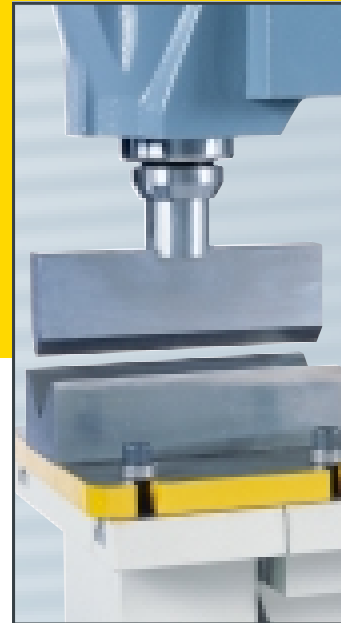


large corner notch attachment



bar bending unit

For bending material up to max. 7/8" thickness. With single-vee block, 3" with V at 85°.



technology

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 M200 (or optional M 600) control.

Especially advantageous is the repeatability accuracy when manufacturing repeat batches. 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 25" deep throat.
Working area: · lateral stop (X-axis): 39 1/2" · bit stop (Y-axis): 20" · positioning accuracy: ±0,004"

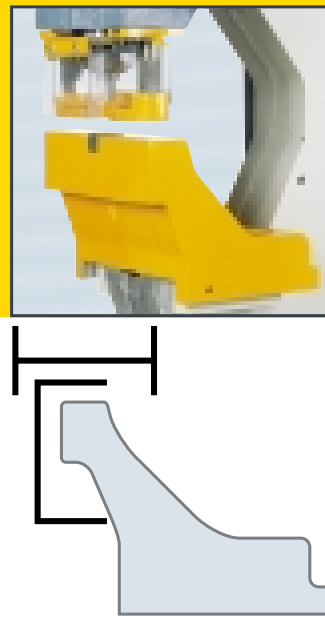
twin hole unit

Twin hole variable pitch unit. Punches 2 holes up to 1 1/8" dia.



swan neck bolster

For web and flange punching up to 1 1/4" dia. in 12" max. channel and I-beam.



dovetail assembly

Changing from punching to bending in 20 seconds.

punch holder, minimum deform
stripper, bolster

multi-vee bending tool



The M 200 Controller has been developed to execute punching jobs in a fast and repeatable way with high accuracy. With the M 200 Controller it is possible to make 8 different punching programs, each with a maximum of 100 steps (holes). The holes need to be programmed with their respective X and Y axis co-ordinates. Furthermore, the co-ordinates can be programmed using their absolute or relative positions. Repetition of incremental steps is also possible. The controller can be used in both auto-matic or manual mode.



The M 600 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).



linear rails

CNC-Controlled Linear Rail – model KA

The Kingsland linear rail is commonly used in the manufacture of long, multi-holed items. The length of the rail (beam) is supplied to suit the users application, starting at 3 feet and rising in 39" lengths. It will manually (model KM) or automatically (model KA) feed lengths of material such as flat bar, angle or channel sections into the machine for punching or cropping without the need for marking out, thus increasing production speeds significantly and eliminating costly operator error.



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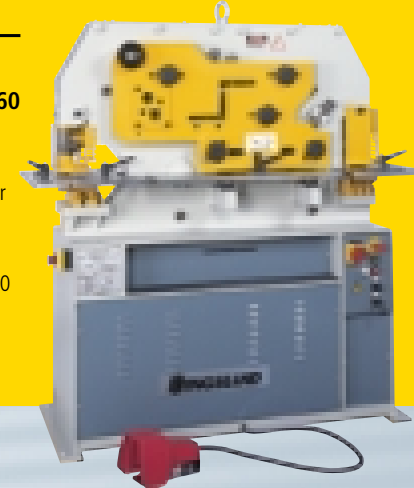
1 COMPACT 45

- 4 stations
- single cylinder hydraulic steelworker
- 45 ton capacity



2 COMPACT 60

- 5 stations
- single cylinder hydraulic steelworker
- available in 50 and 65 ton



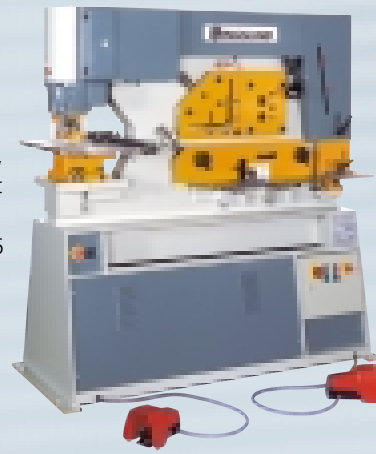
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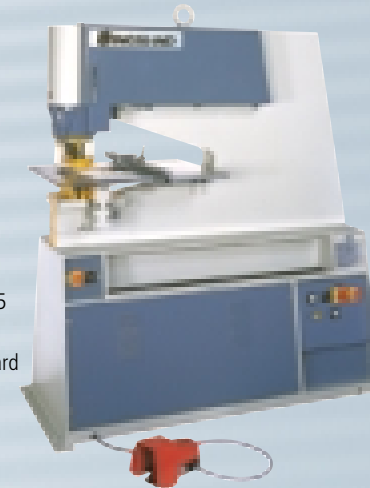
3 MULTI 80

- 5 stations
- double cylinder, standard throat
- available in 60, 70, 80, 95, 125 and 175 ton
- available with deep throat



4 PUNCH 60

- 1 station
- single cylinder hydraulic punching machine
- available in 60, 70, 80, 95, 125 and 175 ton
- deep throat standard



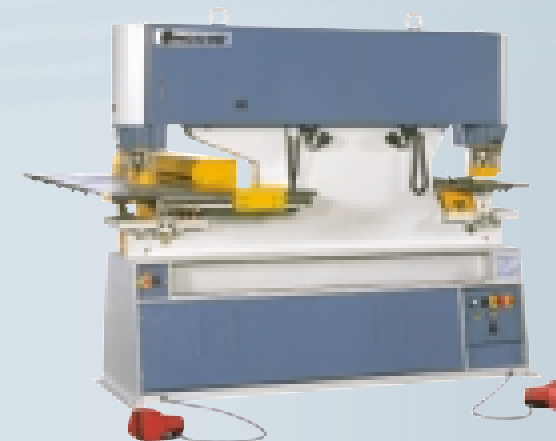
5 50P

- hydraulic punching machine
- 50 ton



6 125 D DOUBLE PUNCH

- 2 stations
- double cylinder, hydraulic punching machine
- available in 60, 70, 80, 95, 125 and 175 ton
- available with deep throat



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