

KINGSLAND



for impressive
performances

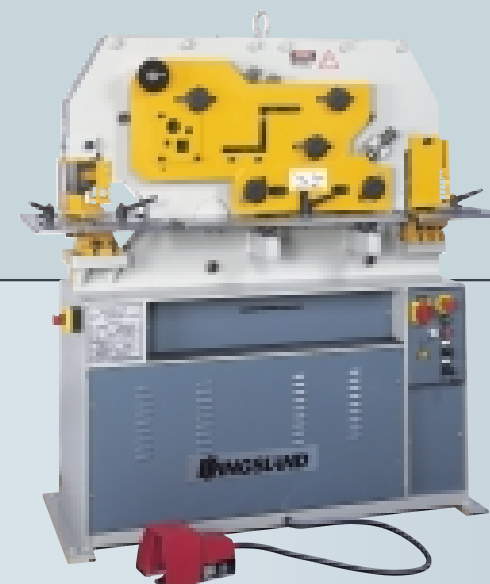


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COMPACT
hydraulic steelworker



COMPACT 45

The 'Compact 45' is the most compact steelworker in the range of Kingsland hydraulic steelworkers. Kingsland machines are built using the long experience gained in the manufacturing and sales of robust and high-quality machines, designed for a long working life. The punch station is designed to enable multiple punching applications. The universal bolster offers the option of punching sheet-metal, flat bar, angle iron and the flange of channel and beam, all of which can be punched up to a maximum diameter of 1 1/2" in the standard execution. Tooling for special applications is available on request.

Large, heavy-duty tables with guides are part of the extensive range of standard equipment. The machines are equipped with blades for cropping round and square bars, optional blades are available for cutting U-, I-, T- and many other special profiles. Angle iron can be cut on 90° and/or 45° (through both flanges, internal and external). All blades have multiple cutting edges and can be reground. The shear is equipped with a simple, but robust holddown, adjustable for every plate thickness within the capacity of the machine. A heavy-duty support table is fitted in order to guarantee an accurate feeding of the material.

**1****punch station**

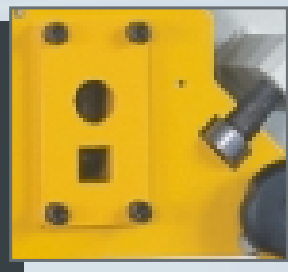
The standard punch station enables punching holes with a diameter of up to 1 1/2". Fully adjustable stroke.

**2****angle station**

With the angle station, angle iron can be cut on 90° and/or 45°, both internal and external, through both flanges. The flange of large angle iron can be mitre cut with the shearing station.

**3****section cutting station**

While cropping round and square solid bars in the standard setup, this station also allows optional blades for cropping channels, beams, Tee- and many other special profiles.

**4****shearing**

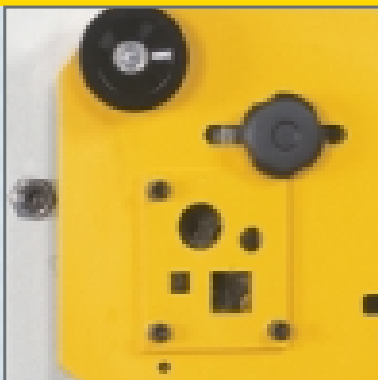
Cutting thick as well as thin material without the need for blade gap or cutting-angle adjustments, the shear also enables cutting flanges of angle profiles.



COMPACT 50 & 65

1 section cutting station

While cropping round and square solid bars in the standard setup, this station also allows optional blades for cropping channels, beams, Tee- and many other special profiles.



The 'Compact 50' and the 'Compact 65' are universal and compact hydraulic steelworkers with 5 workstations and are developed for production purposes with maximum efficiency. The 'Compact' machines are designed and manufactured using the long experience in the field of sales and manufacture of hydraulic steelworkers. The hydraulic circuit is activated by a shielded foot-pedal — the low power inch mode on each workstation enables the correct workpiece-positioning and tool-alignment. Limit-switches allow accurate adjustment of the stroke length for maximum efficiency. Stroke with automatic return. On the angle-cutting station, angle iron can be cut on

every angle from 45° up to 90°, both internal and external, without any adaptations to the machine. Flanges from larger angle-iron can be mitre cut with the shear. Moreover, the machines are equipped with centralised pressure lubrication — being one feature of the low maintenance requirements. The universal steelworkers are delivered with an extensive range of standard equipment, such as large heavy-duty tables on the punch-, shear-, and notching station. Easy adjustable hold-downs to enable production in a safe and accurate way are fitted on every station. Free standing on suitable floor, they just need electrical connection to be ready to work.

2 angle station

Cropping angle iron is possible for every angle between 45° and 90°, both internal and external.



3 punch station

Easy tool change system and swing-away stripper with fast manual adjustment assure a quick setup.



4 shearing

Specially designed blade approach angle to avoid the necessity to change blade settings when cutting thick or thin material and yet offer minimum distortion cropping.



5 notching

This versatile unit is equipped with a rectangular notch unit as standard – side notch applications are also possible.



1**standard punch end**

Easy tool change system. Overhang position for punching in the flange of I- and U-profiles. Punching up to 1 1/2" diameter in the standard execution. Table and stop with guides are fitted as standard.

3**quick change punch holder**

Quick, fast and accurate punch holder. Available up to 1 1/2" diameter.

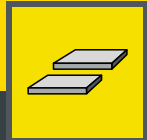
2**large hole attachment**

Large hole unit for diameters up to 4 3/8". Special shapes and applications are also possible.

4**channel/beam web bolster**

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

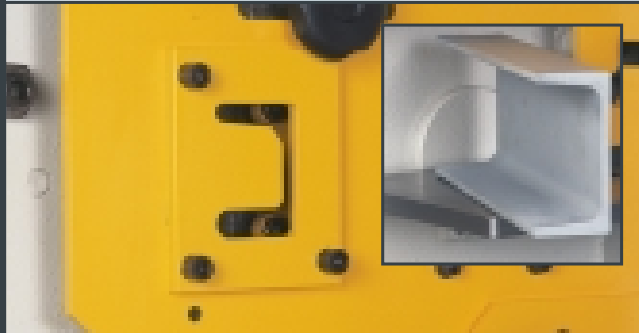
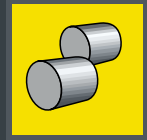
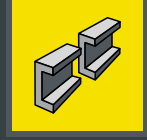




shearing/section cutting station

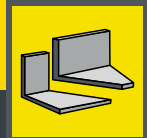
special solid blades for cropping channels

Optional solid blades for cropping UPN-profiles. Blades are available for many different and special profiles.



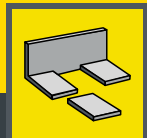
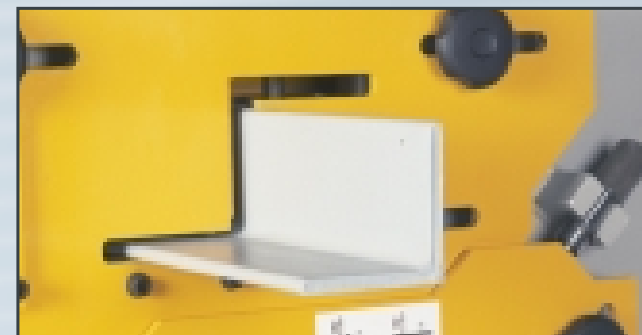
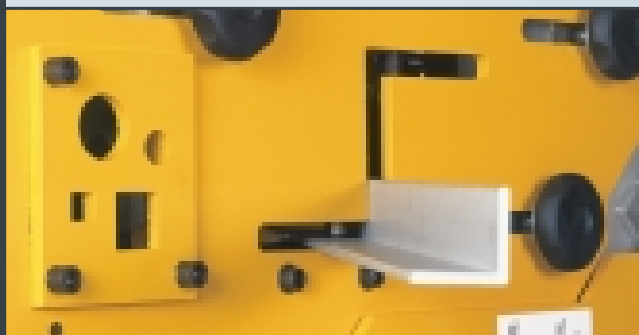
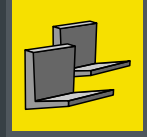
shearing

Specially designed blade approach angle to avoid the necessity to change blade settings when cropping either thick or thin material and yet offer minimum distortion cropping. Shearing the flange of angle iron is also possible.



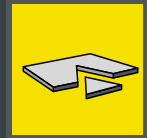
angle station

Unique 'Z' aperture makes it possible to cut angle iron on every angle varying from 45° up to 90°, both internal and external.



notching

The notching station comes equipped with a rectangular notch unit as standard, complete with table and guides. The unit can be interchanged with a triangular notching unit (available with angle from 22,5° up to 90°).

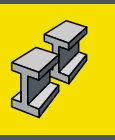
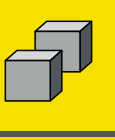
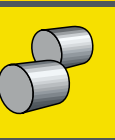


For bending applications.
Maximum capacity is 3 1/8" x 5/8" (Compact 45).
Maximum capacity is 4" x 1/2" (Compact 50).
Maximum capacity is 6" x 1/2" (Compact 65).



features

- Universal bolster for punching flat bar, angle iron and the flange of channel and/or beam.
- Punching up to 1 1/2" in the standard execution.
- Large hole attachment for punching up to 4 3/8" diameter available (up to 2 1/4" for Compact 45).
- Heavy-duty support table on the punch & the shear station (Compact 45) and the notch station (Compact 50 & Compact 65) fitted as standard – all with the same working height.
- Low power inch mode and adjustable stroke on every station.
- Unique 'Z' (on Compact 50 & Compact 65 only) – aperture enables the cutting of angle iron in every angle, varying from 45° up to 90°, both internal and external (both flanges). Cutting flanges from large-sized angle-iron can be mitre cut with the shear (see capacities).
- Extensive range of applications – tube notching, bending, bar-end cropping, special shape punching...
- Rectangular and triangular notching applications. The notching station can be transformed into a secondary punching station (Compact 50 & Compact 65).
- Extended safety features as standard equipment.
- Centralised pressure lubrication (on the Compact 50 & Compact 65).
- High quality interchangeable bearings, seals and valves with well-known brand names, available from stockists.
- Machines with low maintenance requirements.
- Single-phase execution available.
- Possibility to use tooling from other brand names.



standard equipment

	COMPACT 45	COMPACT 50	COMPACT 65
• punch and die	Ø 18 mm	Ø 22 mm	Ø 22 mm
• section blades			
• round	1 7/16"	1 3/16"	3/4", 1 1/16"
• square	1"	1 3/16"	5/8", 1 1/8"

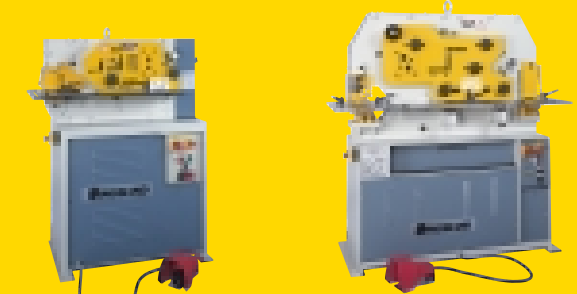
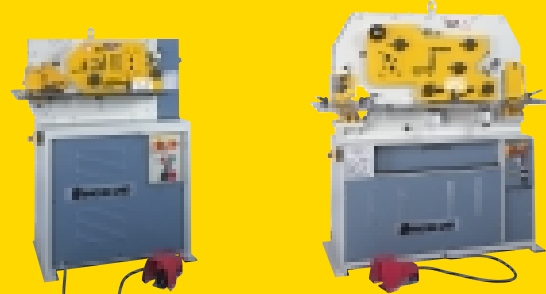
- punch adaptors
- swing away punch stripper unit
- easy change punch holder
- universal die bolster
- heavy-duty support tables with guides at shear station and punch station
- heavy-duty support table with guides at notch station (Compact 50 & Compact 65)
- shear arm-blade with 4 cutting edges (Compact 45)
- curved shear arm-blade with 2 (optional: 4) cutting edges (Compact 50 & Compact 65)
- shear body blade with 4 cutting edges
- section arm & body blade with 1 cutting edge
- angle cutting arm & body blades with 4 cutting edges
- rectangular notch bolster blades with 4 cutting edges (Compact 50 & Compact 65)
- 3'3" ruled length stop (Compact 50 & Compact 65)
- service toolkit
- work station guards
- instruction, operating and maintenance manual
- hydraulic oil fill

COMPACT

KINGSLAND

specifications models

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



based on material strength of 62,000 P.S.I.

	COMPACT 45	COMPACT 50	COMPACT 65
PUNCHING			
rated capacity	45 T	50 T	65 T
maximum capacity	3/8" x 5/8"	7/8" x 5/8"	1 1/16" x 5/8"
diameter x thickness	1 1/2" x 5/16"	1 1/2" x 5/16"	1 1/2" x 7/16"
stroke length	1 1/4"	2"	2 1/8"
cycles/min. - 5/8" travel	23	20	26
standard throat depth	6 7/8"	6 7/8"	8 9/8"
deep throat model	-	-	-
largest hole (optional)	2 1/4"	4 3/8"	4 3/8"
maximum height UPN	5"	6"	6"
working height	42 3/8"	37"	37"
SHEARING			
flat bar - maximum thickness	8" x 1/2"	8" x 5/8"	8" x 3/4"
flat bar - maximum width	13 3/4" x 1/4"	12" x 1/2"	12" x 5/8"
angle flange trim - max 45°	3 1/8" x 5/16"	3 1/8" x 5/16"	3 1/8" x 5/16"
working height	42 3/8"	37"	37"
ANGLE CUTTING			
90° cut	3 1/8" x 3/8"	4" x 3/8"	4 3/4" x 1/2"
45° mitre (true int./ext.)	2" x 1/4"	2 3/4" x 1/4"	3 1/8" x 5/16"
working height	47 3/8"	44 3/4"	44 3/4"
SECTION CUTTING			
round/square (extra accessories)	1 3/16" / 1"	1 3/16" / 1 3/16"	1 9/16" / 1 3/8"
channel/beam (*)	3" x 1 1/2"	3" x 1 1/2"	4" x 2"
Tee (*)	1 1/2" x 1/4"	1 1/2" x 1/4"	3" x 3/8"
(*) other profiles are also possible			

based on material strength of 62,000 P.S.I.

	COMPACT 45	COMPACT 50	COMPACT 65
NOTCHING			
material thickness	5/16" (*)	5/16"	3/8"
width - rectangle	1 3/8" (*)	1 3/8"	1 1/8"
depth - rectangle	2 5/8"	3"	4"
depth - vee	2 3/16" (*)	2 3/8"	2 3/8"
angle flange - max. profile	-	3 1/8" x 1/4"	4 x 3/8"
working height	42 3/8"	37"	37"
(*) attachment for the punch station			
CORNER NOTCH			
maximum capacity	-	6" x 1/8"	6" x 1/8"
TUBE NOTCH			
maximum outside diameter	1 1/8"	2 3/8"	2 3/8"
BENDING			
plate			
maximum capacity	3 1/8" x 1/2"	4" x 1/2"	6" x 1/2"
PUNCHING AT NOTCH STATION			
throat depth	-	3 3/8"	4 3/8"
maximum capacity	-	1 1/16" x 1/2"	3/4" x 1/2"
TECHNICAL DATA			
motorpower	3 kW	3 kW	4 kW
nett weight	1209 lb	2375 lb	2695 lb
gross weight	1363 lb	2585 lb	2948 lb
machine dim. (LxWxH), inch	40" x 21" x 58"	56" x 23 1/4" x 60 1/4"	59 1/2" x 23 1/4" x 62"
packed dim. (LxWxH), inch	45" x 24 1/2" x 64"	60" x 30 1/2" x 67 3/4"	65 3/8" x 30 1/2" x 69 3/8"



for impressive
performances

the Kingsland range of hydraulic steelworkers

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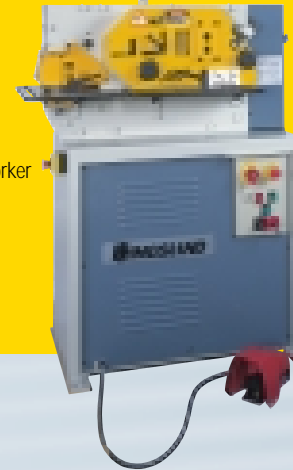
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ref KL/COMPACT E inch/2000

1 compact 45

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



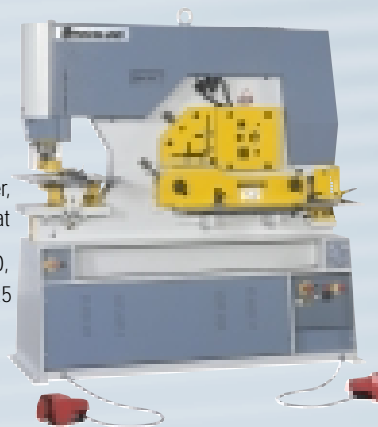
2 compact 65

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



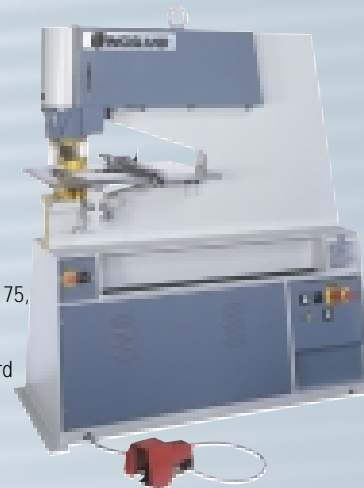
3 multi 125

- 5 stations
- double cylinder, standard throat
- available in 60, 70, 75, 95, 125 & 175 ton
- available with deep throat



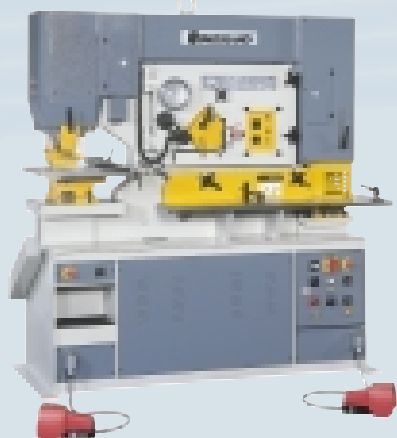
4 punch 60

- 1 station
- single cylinder hydraulic punching machine
- available in 60, 70, 75, 95, 125 & 175 ton
- deep throat standard



5 ultima 85

- 5 stations
- double cylinder hydraulic steelworker
- available in 65, 85, 110 & 140 ton
- available with deep throat



6 125D double-punch

- 2 stations
- double cylinder, hydraulic punching machine
- available in 60, 70, 75, 95, 125 & 175 ton
- with deep throat available

