

# HYDRACROP SERIES



**SANDFELD** <sup>®</sup><sub>A/S</sub>  
**VÆRKTØJSMASKINER**  
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**GEKA**   
The steel working company

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**
- **∅ and ∇ shearing**
- **Notching**

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

The first figure indicates metric tons on the punching end.

The second figure, metric tons on L-shearing end.

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

## S VERSION

- Machines driven by two cylinders.
- 5 work stations, fitted with tools for L, shearing, bars ∅ and ∇, 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.

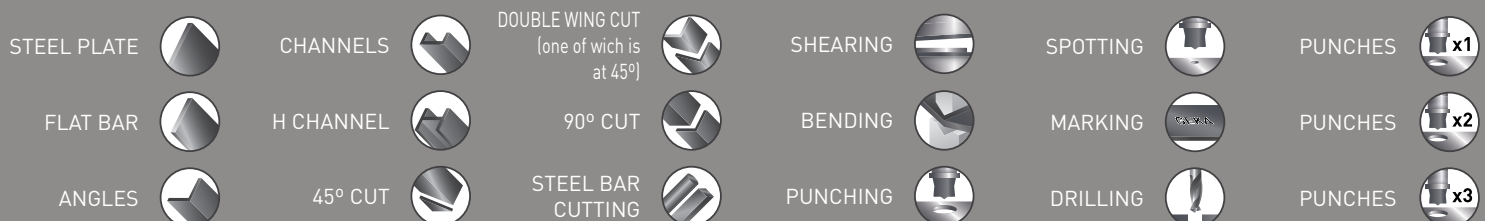
## SD VERSION

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

# FEATURES

			55/110 S, SD	80/150 S, SD	110/180 S, SD	165/300 S, SD	220/300 S, SD
<b>SHEARS FOR FLATBAR</b>							
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
<b>SHEARS FOR SECTION IRON</b>							
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
<b>WITH SPECIAL BLADE</b>							
L at 90 ° (with slight deformation)	mm		130x130x13	152x152x13	160x160x16	205x205x25	205x205x25
<b>SHEARS FOR BARS</b>							
Round bar $\varnothing$	mm		40	45	50	60	60
Square bar $\square$	mm		40	45	50	60	60
<b>WITH SPECIAL BLADES</b>							
UPN	mm		120	140	160	180	180
IPN	mm		120	140	160	180	180
<b>NOTCHING</b>							
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
<b>PUNCHING</b>							
Punching power	kN		550	800	1100	1650	2200
Maximum capacity	mm		$\varnothing$ 40x10	$\varnothing$ 40x14	$\varnothing$ 40x20	$\varnothing$ 40x30	
	mm		$\varnothing$ 20x20	$\varnothing$ 24x24	$\varnothing$ 28x28	$\varnothing$ 34x34	$\varnothing$ 40x40
Throat	S	mm	250	300	300	510	385
	SD	mm	500	500	610	610	475
Stroke		mm	60	70	80	100	100
Working height		mm	1085	1095	1165	1110	1110
<b>GENERAL SPECIFICATIONS</b>							
N° strokes per minute (stroke= 20mm)			37	40	28	31	26
Motor		kW	5	9	9	15	15
Net weight	S	kg	1390	2070	2750	5200	5900
	SD	kg	1750	2400	3300	6300	7000
Gross weight	S	kg	1598	2323	3162	5980	6875
	SD	kg	2012	2760	3795	7245	8050
Packaging dimensions	S	m	1,67x1,16x2,09	2,13x1,20x2,05	2,13x1,20x2,20	2,83x1,60x2,20	2,88x1,60x2,40
	SD	m	2,10x1,16x2,09	2,31x1,2x2,05	2,69x1,4x2,20	2,95x1,60x2,20	3,04x1,60x2,40
Volume of seaworthy package	S	m <sup>3</sup>	4,04	4,72	5,62	10	11,06
	SD	m <sup>3</sup>	5,09	6,68	8,28	10,38	11,67

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



# MODELS

## Hydracrop 55/110

### FEATURES

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 $\nabla$ bars	40 mm
Punching capacity $\emptyset$	40 x 10 mm



## Hydracrop 80/150

### FEATURES

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

### FEATURES

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 165/300

### FEATURES

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 $\varnothing$ and $\nabla$ bars	60 mm
Punching capacity $\varnothing$	40 x 30 mm



## Hydracrop 220/300

### FEATURES

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 $\varnothing$ and $\nabla$ bars	60 mm
Punching capacity $\varnothing$	40 x 40 mm



## PRODUCTION PACK

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



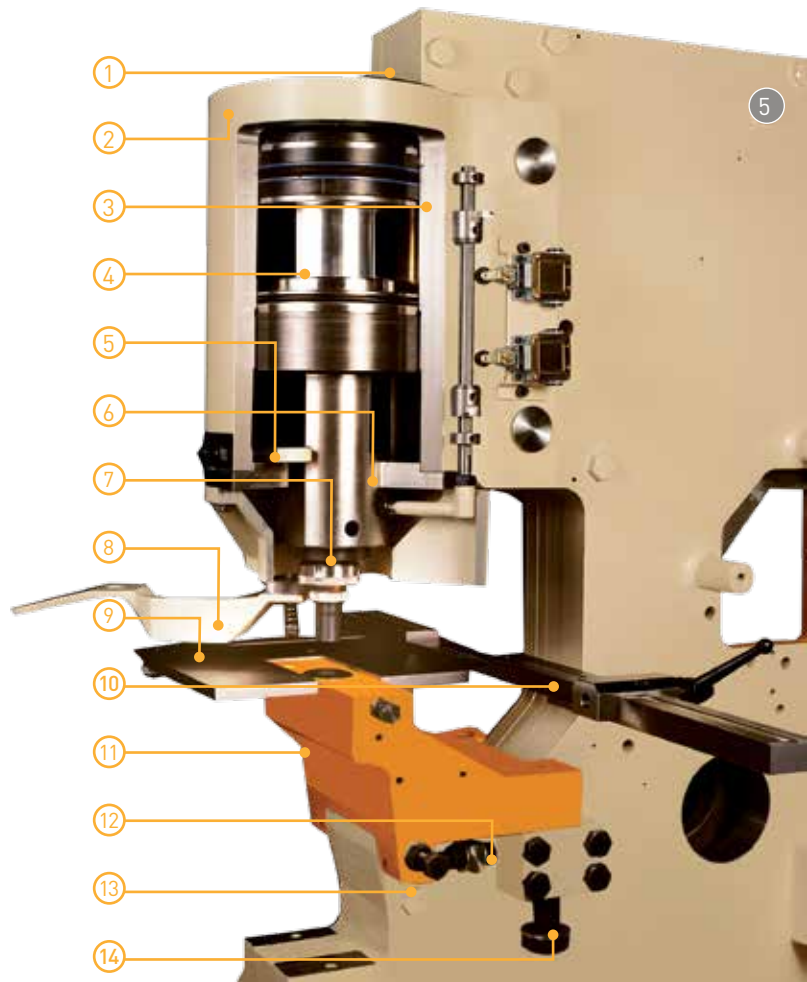
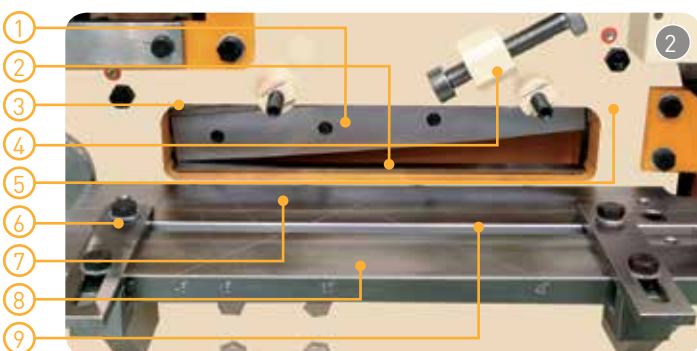
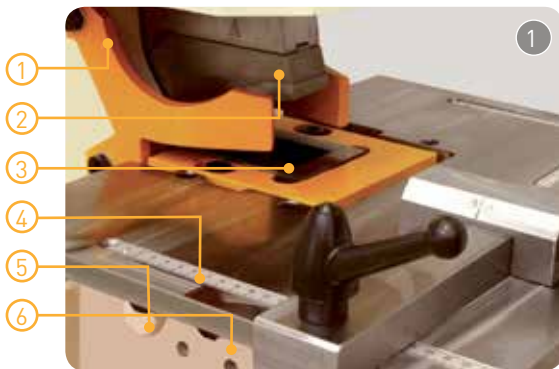
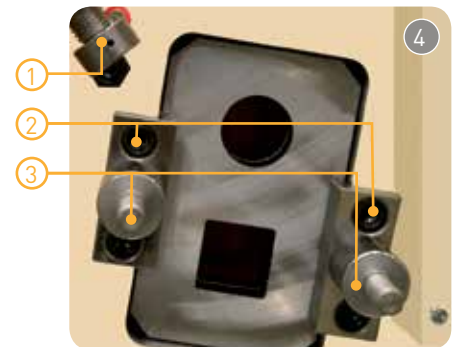
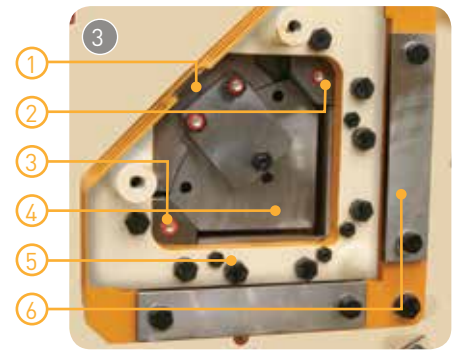
"Touch & cut" electrical end stop  
1 meter long



Set of ten round punches and dies



Work light with magnetic Base





## 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. ng corners.

- 1.- Rectangular punch
- 2.- Rectangular punch
- 3.- Rectangular notching
- 4.- Table with scaled measuring stops, included in production kit
- 5.- Cross centring bolts
- 6.- Fixing holes special tooling

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## 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.

- 1.- Upper blade with special geometry.
- 2.- Lower blade.
- 3.- Supplement shearing angle control of upper blade, for shearing without deformation.
- 4.- Guide fixing screw.
- 5.- Clearance control of blade-holder.
- 6.- Adjustable guides 45° right and left.
- 7.- Clearance control between shear blades.
- 8.- Flat plate/bar shearing table.
- 9.- Slotted guide positioning with coverage of the entire blade length.

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## 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.

- 1.- Safety protection.
- 2.- Upper shear blade guides.
- 3.- Lower shear blade guides.
- 4.- Upper shear blade without deformation.
- 5.- Blade gap adjustment screws.
- 6.- Adjustable Support.

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## Cutting of Ø and ∅ bars

The GEKA HYDRACROP machines are fitted as standard with blades for cutting Ø and ∅ 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.

- 1.- Adjusting bolt and height setting of the guide.
- 2.- Blade holding flanges.
- 3.- Guide fixing bolts.

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## 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.

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## Electric cabinet

Manual selector switch / electrical limit switch."Inching" selector switch.  
Easily removable cover to access hydraulic unit.

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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

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### 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.