



TOOLING & MACHINERY, INC.

COMPLETE METALWORKING SOLUTIONS
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Ironworkers Catalogue

inches



GEKA 
The steel working company





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.

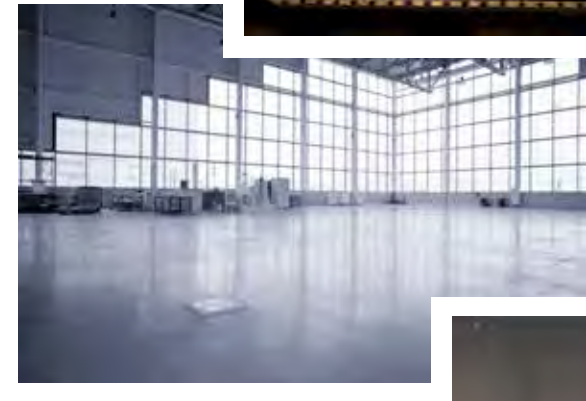
Our team of experienced experts devotes their time exclusively to researching and innovating our developments.

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 + ▣	✓	✓	✓

FEATURES

		MICROCROP	MINICROP	MULTICROP
SHEARS FOR FLATBAR				
Flatbar (with slight deformation)	In	13 3/4" x 1/4" 8" x 1/2"	10" x 3/8" 8" x 1/2"	10" x 3/8" 8" x 1/2"
Length of blade	In	14"	12"	12"
Round bar Ø	In	1-3/16"	-	-
Square bar 𐀀	In	1"	-	-
Cut of an L leg at 45°	In	2 1/2"	3"	3"
Working height	In	38 1/2"	40 1/2"	40 1/2"
SHEARS FOR SECTION IRON				
L at 90 °	In	3" x 3" x 5/16"	3" x 3" x 5/16"	3" x 3" x 5/16"
L at 90 ° (with slight deformation)	In	-	4" x 4" x 3/8"	-
L at 45 °	In	2" x 2" x 1/4"	-	2 1/4" x 2 1/4" x 1/4"
Round bar Ø	In	1 3/8" (optional)	1 1/4"	1"
Square bar 𐀀	In	1 1/4" (optional)	1 1/4"	7/8"
NOTCHING (OPTIONAL)				
Plate thickness	In	5/16"	1/4"	1/4"
Angle of	In	2 1/2"	2 1/2"	2 1/2"
Depth	In	2"	2"	2"
Width	In	1 3/8"	1 1/2"	1 1/2"
PUNCHING				
Punching power	Ton	40	50	50
Maximum capacity	In	Ø 1-1/16" x 3/8"	Ø 1-1/16" x 1/2"	Ø 1-1/16" x 1/2"
Throat	In	6 5/8"	6 7/8"	6 1/4"
Stroke	In	1-3/32"	3"	3"
Working height	In	38 1/2"	40"	40"
BENDING (OPTIONAL) (OPTIONAL) (OPTIONAL)				
Bending power	Ton	36	45	45
Maximum width	In	3"	3"	3"
Maximum capacity	In	3" x 1/2"	3" x 9/16"	3" x 9/16"
GENERAL SPECIFICATIONS				
Motor	H.P.	3	4	4
N° strokes per minute (stroke= 3/4")		24	16	16
Net weight	Lbs	1067	1760	1985
Gross weight	Lbs	1265	2690	2425
Packaging dimensions	In	43" x 30" x 59"	54" x 43" x 59"	54" x 44" x 67"
Volume of seaworthy package	Ft ³	45	80	90
OPTIONAL EQUIPMENT				
SHEARS FOR SECTION IRON L and I section iron	In	2"	4"	4"
PIPE NOTCHING Maximum diameter	In	2"	2 1/4"	2 1/4"
PUNCHING LARGER DIAMETERS Maximum diameter	In	Ø 1-13/32" x 5/16"	Ø 4" x 5/32"	Ø 4" x 5/32"

- Capacities are based on a material resistance of 65,000 PSI tensile.
- The manufacturer reserves the right to make modifications without prior notice.

FEATURES

Angle cutting station

- L cut up to 3" x 3" x 5/16" 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 1-1/16" x 3/8" (Microcrop) and Ø 1-1/16" x 1/2" (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 1 3/16" cut and ∇ up to 1" in position of flat plate (with slight deformation)
- Shearing of flat plate up to 8" x 1/2"
- 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 1 3/8" x 5/16" 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

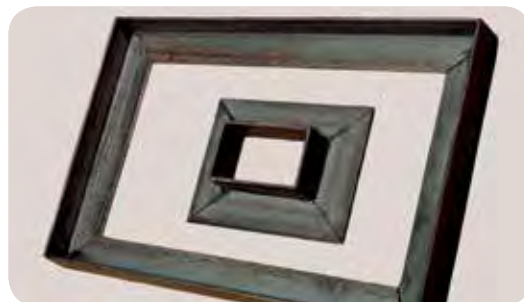


Rectangular notching equipment



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.



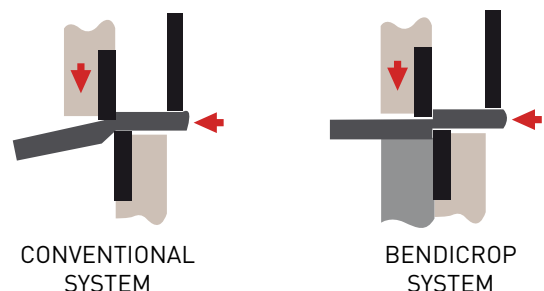
Triangular notching with table.
Bendicrop 85SD



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 85S	Bendicrop 85SD
Shears of flatbar	In	14" x 3/8" (5°) 14" x 1/2"	14" x 3/8" (5°) 14" x 1/2"	14" x 3/8" (5°) 14" x 1/2"	18" x 5/8" (5°) 18" x 3/4"	18" x 5/8" (5°) 18" x 3/4"
Length of blade	In	14"	14"	14"	19"	19"
Cut of an L leg at 45°	In	2 1/2"	2 1/2"	2 1/2"	-	-
Working height	In	31 7/8"	33 13/16"	33 13/16"	36 7/32"	36 7/32"

SHEARS FOR SECTION IRON

L at 90 °	In	3" x 3" x 5/16"	5" x 5" x 3/8"	5" x 5" x 3/8"	5" x 5" x 3/8"	5" x 5" x 3/8"
L at 45 °	In	-	-	-	-	-
Round bar Ø	In	1 3/8"	2"	2"	2"	2"
Square bar \square	In	1 1/4"	1 1/2"	1 1/2"	1 1/2"	1 1/2"

NOTCHING		RECTANGULAR	TRIANGULAR	TRIANGULAR	TRIANGULAR	TRIANGULAR
Plate thickness	In	3/8"	3/8"	3/8"	1/2"	1/2"
Angle of	In	4"	4"	4"	5"	5"
Depth	In	3 1/2"	-	-	-	-
Width	In	1 9/16"	-	-	-	-

PUNCHING

Punching power	Ton	55	61	61	93.5	93.5
Maximum capacity	In	(B) Ø1 1/4" x 1/2" (A) Ø1-1/16 x 1/2"	Ø1 1/2" x 7/16"	Ø1 1/2" x 7/16"	Ø 1 1/2" x 1/2"	Ø 1 1/2" x 1/2"
Throat	In	7"	10"	20"	12"	20"
Working height	In	38 3/8"	43 1/2"	43 1/2"	43"	43"

BENDING

Maximum capacity	In	4" x 3/8"	6" x 3/8"	6" x 3/8"	8" x 1/2"	8" x 1/2"
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GENERAL SPECIFICATIONS

Motor	H.P.	7.5	7.5	7.5	12.5	12.5
N° strokes per minute		34 (stroke 3/4")	32 (stroke 3/4")	32 (stroke 3/4")	40 (stroke 1")	40 (stroke 1")
Net weight	Lbs	2095	3065	3850	5291	5291
Gross weight	Lbs	2530	3525	4435	4785	6084
Packaging dimensions	In	51" x 43" x 73"	83" x 55" x 63"	83" x 55" x 81"	91" x 55" x 75"	91" x 55" x 91"
Volume of seaworthy package	Ft ³	94	174	203	171	171

OPTIONAL EQUIPMENT

SHEARS FOR SECTION IRON LJ and I section iron	In	4"	5"	5"	5"	5"
PIPE NOTCHING Maximum diameter	In	2"	2"	2"	2"	2"
PUNCHING LARGER DIAMETERS Maximum diameter	In	Ø 4" x 5/32"	Ø 4" x 3/16"	Ø 4" x 3/16"	Ø 4" x 1/4"	Ø 4" x 1/4"

(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 , ∇ , \square , cutting stations, punching stations and trimming stations, includes a permanent built-in bending station, with capacity up to 4" x 3/8". It also has a system to reduce cutting deformation.

Bendicrop 50

The Bendicrop 50 model comes with an electric stop and two 1 1/2" and 3" V bending dies.



Bendicrop 60

There are two different versions of this model: S, (10" throat) and SD (20" throat).

The Bendicrop 60 model comes with an electric stop and two 1 1/2" and 3" V bending dies.



Bendicrop 85

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 8" x 5/8". 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, 20" extended throat**
- **Flat bars shearing**
- **Bending station**
- **Triangular notching station**
- **Round and square bars shearing station**
- **Standard hydraulic hold down:**

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.

There are two different versions of this model: S, (12" throat) and SD (20" throat).







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 \square 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 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

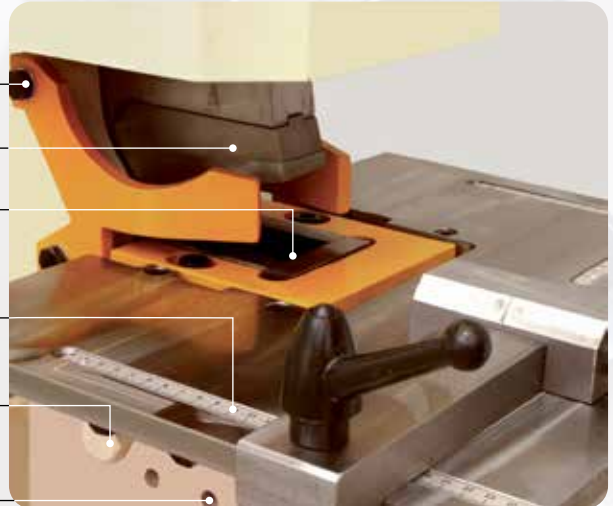
Rectangular punch

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

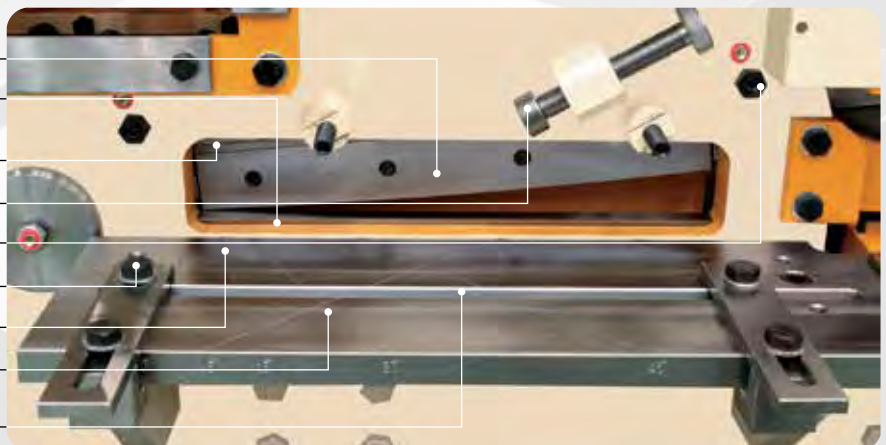
Clearance control of blade-holder

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



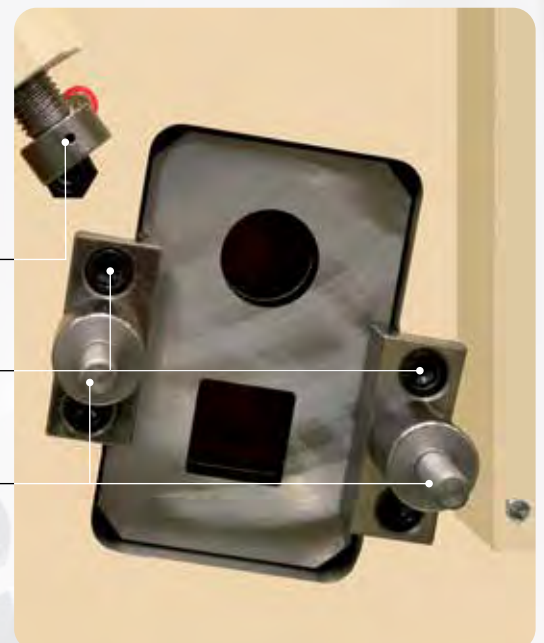
Cutting of \emptyset and ∇ bars

The GEKA HYDRACROP machines are fitted as standard with blades for cutting \emptyset 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.

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.

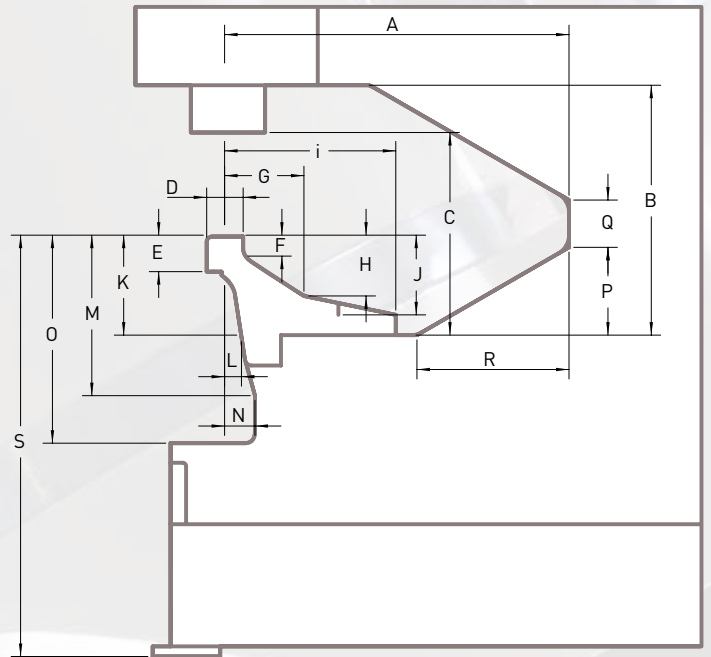
The first figure indicates metric tons on the punching end.
The second figure, metric tons on L-shearing end.

Version 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.
 - 40" "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.

Version 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	10.00	13.78	11.02	2.56	2.24	1.30	4.74	3.19	9.19	3.19	5.39	0.98	8.19	1.38	9.17	2.83	10.55	4.96	41.94
	SD	20.00	13.78	11.02	2.56	2.24	1.30	4.74	3.19	9.19	3.19	5.39	0.98	8.19	1.38	9.17	3.90	4.33	6.73	41.97
HYDRACROP80	S	12.01	14.57	11.81	2.56	2.52	1.22	4.84	3.50	9.98	3.50	5.67	0.98	9.21	1.77	11.97	4.72	9.84	4.72	43.07
	SD	20.08	14.57	11.81	2.56	2.52	1.22	4.84	3.50	9.98	3.50	5.67	0.98	9.21	1.77	11.97	5.12	2.76	8.86	43.07
HYDRACROP110	S	12.01	15.55	12.80	3.11	3.19	1.57	5.53	3.78	10.51	3.78	6.34	0.98	10.08	1.77	12.24	4.72	10.83	4.72	45.31
	SD	24.02	15.55	12.80	3.11	3.19	1.57	5.53	3.78	10.51	3.78	6.34	0.98	10.08	1.77	12.24	5.91	2.83	10.24	45.31
HYDRACROP165	S	20.08	17.72	14.96	3.35	3.35	1.85	6.22	4.09	12.68	5.59	7.87	0.98	14.53	1.77	17.72	6.30	3.15	6.30	43.70
	SD	24.02	17.72	14.96	3.35	3.35	1.85	6.22	4.09	12.68	5.59	7.87	0.98	14.53	1.77	17.72	5.91	3.15	10.24	43.70
HYDRACROP220	S	15.16	18.50	15.75	3.35	3.35	1.85	6.22	4.09	12.68	5.59	7.87	0.98	14.65	1.77	17.72	1.38	13.78	1.38	42.91
	SD	18.70	18.50	15.75	3.35	3.35	1.85	6.22	4.09	12.68	5.59	7.87	0.98	14.65	1.77	17.72	3.35	11.81	3.35	42.91

Measurements in inches.

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

Flatbar (with slight deformation)	In	12" x 5/8" 8" x 3/4"	18" x 5/8" 12" x 3/4"	16" x 3/4" 12" x 1"	20" x 1" 16" x 1 1/8"	20" x 1" 16" x 1 1/8"
Length of blade	In	12"	18-11/16"	24"	30 1/8"	30 1/8"
Square bar \square	In	1"	-	-	-	-
Working height	In	34 5/8"	33 1/2"	37-13/16"	33 1/4"	33 1/4"
Cut of an L leg at 45°	In	2 3/8"	3 5/32"	4"	5"	5"

SHEARS FOR SECTION IRON

Shearing power	Ton	110	150	180	300	300
L at 90 ° without deformation	In	4" x 4" x 1/2"	5" x 5" x 1/2"	6" x 6" x 1/2"	8" x 8" x 3/4"	8" x 8" x 3/4"
L at 45 ° [2legs]	In	3" x 3" x 5/16"	3" x 3" x 5/16"	3" x 3" x 5/16"	3" x 3" x 5/16"	3" x 3" x 5/16"

WITH SPECIAL BLADE

L at 90 ° (with slight deformation)	In	5" x 5" x 1/2"	6" x 6" x 1/2"	6" x 6" x 5/8"	8" x 8" x 1"	8" x 8" x 1"
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SHEARS FOR BARS

Round bar \emptyset	In	1-9/16"	1 3/4"	2"	2 3/8"	2 3/8"
Square bar \square	In	1-9/16"	1 3/4"	2"	2 3/8"	2 3/8"

WITH SPECIAL BLADES

UPN	In	4"	5"	6"	7"	7"
IPN	In	4"	5"	6"	7"	7"

NOTCHING

Plate thickness	In	3/8"	15/32"	1/2"	5/8"	5/8"
Angle of	In	4"	4"	4"	5"	5"
Depth	In	3 1/2"	3 1/2"	3 1/2"	4-5/16"	4-5/16"
Width	In	1 5/8"	2"	2"	2 1/4"	2 1/4"

PUNCHING

Punching power	Ton	60	88	120	185	240
Maximum capacity	In	\emptyset 1 1/2" x 3/8"	\emptyset 1 1/2" x 9/16"	\emptyset 1 1/2" x 3/4"	\emptyset 1 1/2" x 1 1/4"	
	In	\emptyset 3/4" x 3/4"	\emptyset 7/8" x 7/8"	\emptyset 1-3/32" x 1-3/32"	\emptyset 1-15/16" x 1-5/16"	\emptyset 1 1/2" x 1 1/2"
Throat	S SD	In	10" 20"	12" 20"	12" 24"	20" 24"
Stroke	In	2 3/8"	2 3/4"	3-5/32"	3-15/16"	3-15/16"
Working height	In	42"	43"	45 3/8"	43 3/4"	43"

GENERAL SPECIFICATIONS

N° strokes per minute (stroke= 3/4")			37	40	28	31	26
Motor	H.P.		8.5	12.5	12.5	20	20
Net weight	S SD	Lbs.	3,065 3,860	4,565 5,300	6,060 7,275	11,465 13,890	13,010 15,435
Gross weight	S SD	Lbs.	3,525 4,435	5,125 6,085	6,975 8,370	13,185 15,975	14,960 17,750
Packaging dimensions	S SD	In	67 3/4" x 45 5/8" x 82 1/4" 82 5/8" x 45 5/8" x 82 1/4"	83 3/4" x 47 1/4" x 80 3/4" 91" x 47 1/4" x 80 3/4"	83 3/4" x 47 1/4" x 86 5/8" 106" x 55" x 86 5/8"	111 1/2" x 63" x 86 5/8" 116" x 63" x 86 5/8"	113 3/8" x 63" x 94 1/2" 119 5/8" x 63" x 94 1/2"
Volume of seaworthy package	S SD	ft ³	142 1/2 179 3/4	166 5/8 235 7/8	198 1/2 292 1/2	353 1/8 366 1/2	390 5/8 412 1/8

- Capacities based on a material resistance of 65,000 PSI tensile.
- The manufacturer reserves the right to make modifications without prior notice.

HYDRACROP SERIES



Hydracrop 55/110

Shearing of flat plate	12"x5/8" 18"x5/8"
L cut with standard blade (no distortion):	4" x 4" x 1/2"
L cut with optional blade (minor distortion):	5" x 5" x 1/2"
Shearing of \emptyset and \sphericalangle bars	1-9/16"
Punching capacity \emptyset	1 1/2" x 3/8"

HYDRACROP SERIES

Hydracrop 80/150

Shearing of flat plate	18" x 5/8" 12" x 3/4"
L cut with standard blade (no distortion):	5" x 5" x 1/2"
L cut with optional blade (minor distortion):	6" x 6" x 1/2"
Shearing of \emptyset and \square bars	2"
Punching capacity \emptyset	1 1/2" x 9/16"



Hydracrop 110/180

Shearing of flat plate	24" x 5/8" 16" x 3/4"
L cut with standard blade (no distortion):	6" x 6" x 1/2"
L cut with optional blade (minor distortion):	6" x 6" x 5/8"
Shearing of \emptyset and \square bars	2"
Punching capacity \emptyset	1 1/2" x 3/4"



HYDRACROP SERIES

Hydracrop 165/300

Shearing of flat plate	30" x 3/4" 20" x 1"
L cut with standard blade (no distortion):	8" x 8" x 3/4"
L cut with optional blade (minor distortion):	8" x 8" x 1"
Shearing of \emptyset and \square bars	2 3/8"
Punching capacity \emptyset	1 1/2" x 1 1/4"



Hydracrop 220/300

Shearing of flat plate	30" x 3/4" 20" x 1"
L cut with standard blade (no distortion):	8" x 8" x 3/4"
L cut with optional blade (minor distortion):	8" x 8" x 1"
Shearing of \emptyset and \square bars	2 3/8"
Punching capacity \emptyset	1 1/2" x 1 1/2"



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 – 40” 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 60 Tn to 220 Tons with punching throats of between 19 5/8" and 31 1/2"
- Range of Portable punching machines from 60 Tons with punching throats of 5"

		PUMA-55	PUMA-80	PUMA-110	PUMA-165	PUMA-220
Punching power	Tons	60	88	120	185	220
Maximum capacity	∅	1 1/2" x 3/8"	1 1/2" x 9/16"	1 1/2" x 3/4"	1 1/2" x 1 1/4"	1 1/2" x 1 1/2"
Throat	S	19 5/8"	20"	19 5/8"	20"	20"
	SD	29 1/2"	29 1/2"	29 1/2"	29 7/8"	31 1/2"

PUNCHING OF SECTIONS WITH GOOSENECK DIE HOLDER

I on the leg	in	4" - 12"	4" - 12"	4" - 17 3/4"	4" - 17 3/4"	4" - 17 3/4"
I on the web	in	4" - 19 5/8"	4" - 19 5/8"	4" - 19 5/8"	4 3/4" - 19 5/8"	4 3/4" - 19 5/8"
LJ on the leg	in	4" - 12"	4" - 12"	4 3/4" - 15 3/4"	4 3/4" - 15 3/4"	4 3/4" - 15 3/4"
LJ on the web	in	4 3/4" - 10 1/4"	4 3/4" - 14 7/8"	4 3/4" - 15 3/4"	4 3/4" - 15 3/4"	4 3/4" - 15 3/4"

GENERAL FEATURES

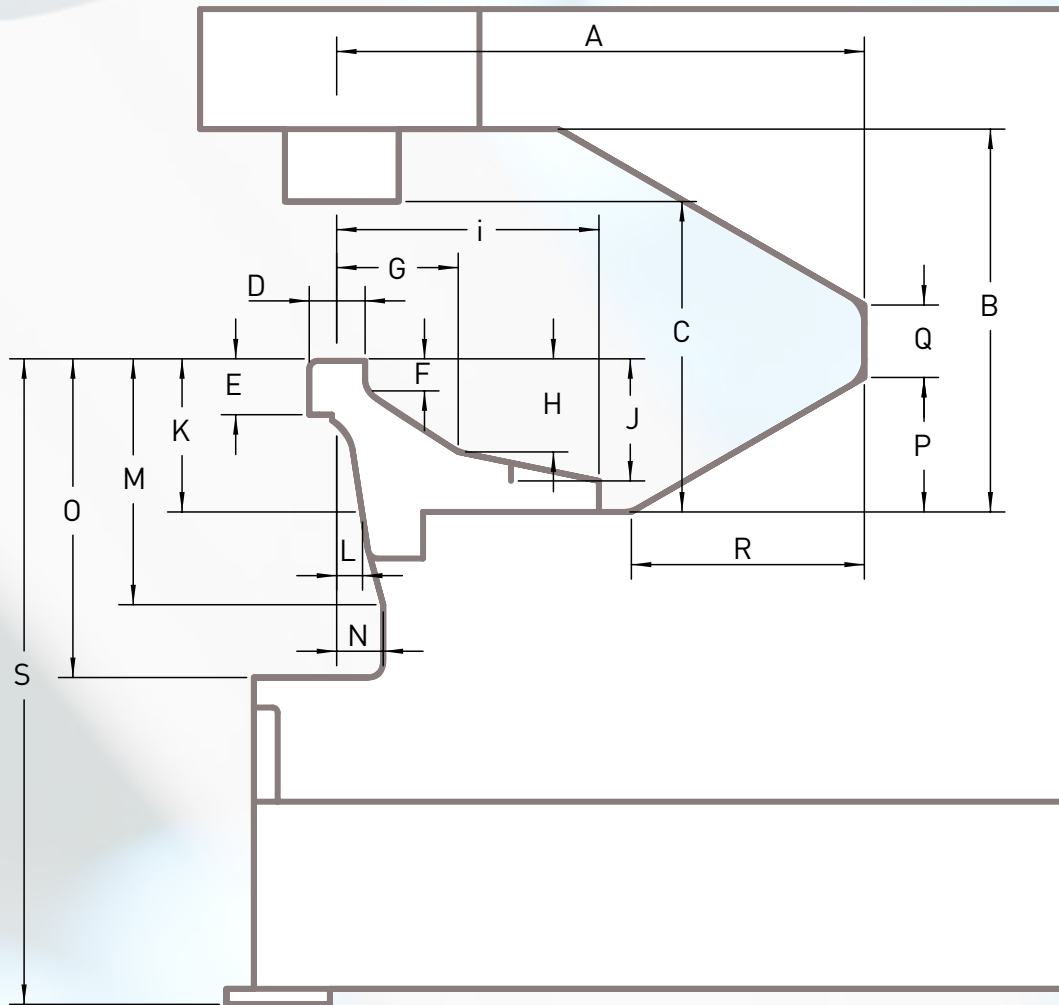
Motor power	H.P.	8,5	12	20	27	27
Strokes per minute based on 3/4" stroke		37	40	28	28	25
Maximum stroke	in	2 3/8"	2 3/8"	3-5/32"	3-15/16"	3-15/16"
Working height	in	41 3/4" / 31 7/8"	43" / 47"	39" / 42"	41 3/4" / 41 3/4"	39 7/8" / 39 7/8"
Net weight	Lbs	2,535 / 4,155	2,415 / 4,665	6,945 / 8,755	9,460 / 9,975	11,465 / 12,125
Gross weight	Lbs	2,910 / 4,630	4,245 / 5,180	7,495 / 9,480	10,365 / 11,025	12,570 / 13,230
Volume	Ft ³	128 1/8 / 147 1/4	160 / 207 1/4	196 / 240 7/8	258 1/8 / 316	340 / 353 1/8
Dimensions with seaworthy packaging S	in	61"x47"x77"	67"x51"x81"	82"x51"x81"	80"x63"x128"	100"x63"x93"
Dimensions with seaworthy packaging SD	in	73"x47"x71"	83"x51"x85"	90"x51"x91"	80"x63"x128"	105"x63"x93"

OPTIONAL EQUIPMENT

Pipe notching	in	2 3/8"	2 3/8"	2 3/8"	2 3/8"	2 3/8"
Oversize Punching diameters	∅	4"x5/32"	4"x1/4"	4"x3/8"	4"x1/2"	4"x5/8"

- Capacities based on a material resistance of 65,000 PSI tensile.
- 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	19.69	13.39	10.63	2.56	2.17	1.30	4.74	3.19	9.19	3.19	5.39	0.98	9.09	1.77	12.87	4.02	3.07	7.28	41.73
	SD	29.53	13.39	10.63	2.56	2.17	1.30	4.74	3.19	9.19	3.19	5.39	0.98	9.09	1.77	12.87	4.02	3.07	7.28	31.89
PUMA80	S	20.08	14.57	11.81	2.56	2.44	1.22	4.84	3.50	9.98	3.50	5.67	0.98	9.21	1.77	11.97	5.12	2.76	9.21	43.07
	SD	29.53	14.57	11.81	2.56	2.44	1.22	4.84	3.50	9.98	3.50	5.67	0.98	9.21	1.77	11.97	5.12	2.76	10.94	47.01
PUMA110	S	19.69	16.54	13.78	3.11	3.11	1.57	5.53	3.78	10.51	3.78	6.34	0.98	12.83	1.85	18.15	3.74	4.92	3.94	39.02
	SD	29.53	16.54	13.78	3.11	3.11	1.57	5.53	3.78	10.51	3.78	6.34	0.98	12.83	1.85	18.15	3.74	4.92	3.94	41.97
PUMA165	S	20.08	17.72	13.78	3.35	3.11	1.38	6.22	4.09	16.93	6.30	7.87	0.98	14.65	1.77	17.72	-	9.45	-	41.73
	SD	29.92	17.72	14.96	3.35	3.11	1.38	6.22	4.09	16.93	6.30	7.87	0.98	14.65	1.77	17.72	5.55	3.86	9.65	41.73
PUMA220	S	20.08	17.72	14.76	3.35	3.11	1.30	6.38	3.94	17.13	5.94	7.80	1.18	-	1.18	19.02	0.00	12.99	-	39.88
	SD	31.50	17.72	14.76	3.35	3.11	1.30	6.38	3.94	17.13	5.94	7.80	1.18	-	1.18	19.02	4.92	7.87	8.50	39.88

Measurements in inches.

PUMA SERIES

Puma 55

Punching power	60 Tons
Max. capacity Ø	1 1/2" x 3/8"
Max. capacity Ø	3/4" x 3/4"
Max. capacity ∅	1 7/64" x 7/16"
Throat	19 5/8" / 29 1/2"



Puma 80

Punching power	88 Tons
Max. capacity Ø	1 1/2" x 9/16"
Max. capacity Ø	15/16" x 15/16"
Max. capacity ∅	1 7/64" x 5/8"
Throat	20" / 29 1/2"



PUMA SERIES

Puma 110

Punching power	120 Tons
Max. capacity Ø	1 1/2" x 3/4"
Max. capacity Ø	1 7/64" x 1 7/64"
Max. capacity ∇	1 7/64" x 3/4"
Throat	19 5/8" / 29 1/2"



Puma 165

Punching power	185 Tons
Max. capacity Ø	1 1/2" x 1 1/4"
Max. capacity Ø	1 11/32" x 1 11/32"
Max. capacity ∇	1 7/64" x 1 7/64"
Throat	20" / 29 7/8"



PUMA SERIES

Puma 220

Punching power	220 Tons
Max. capacity \varnothing	1 1/2" x 1 1/2"
Max. capacity \square	1 7/64" x 1 7/64"
Throat	20" / 31 1/2"



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

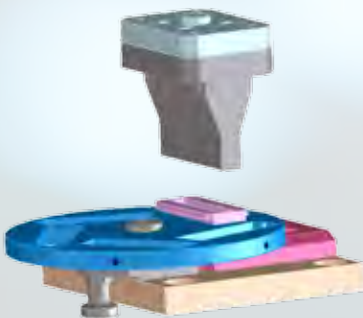
With table with T grooves, recommended for use with "die sets" and special tooling.

- 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		50 tons
Maximum punching capacity		1-1/16" x 1/2"
Maximum stroke		1-3/16"
Throat		5"
Motor power		7.5 H.p.
Cycles per minute (3/4" stroke)		23
Net weight	(G)	785 Lbs.
	(P)	915 Lbs.
Gross weight	(G)	1,060 Lbs.
	(P)	1,190 Lbs.
Dimensions with maritime packaging		433/8" x 351/2" x 61"
Volume		54 In3

OPTIONAL EQUIPMENT (P)

Oversize unit for punching diameters		Ø1 1/2" x 5/16"
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.

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 \square .
 - 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. 4"
- Triangular notching unit
- Rectangular notching unit
- Claw equipment
- Tube notching unit
- Hydraulic hold-down for angles and flats
- Punching unit UPN from 1-9/16" to 3"
- Urethane stripper
- Punching at the end of tube
- Triple punching head fix
- Standard press brake
- Longitudinal press brake
- Oversize punching unit up to diam. 6"
- ...



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, 80'' 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.

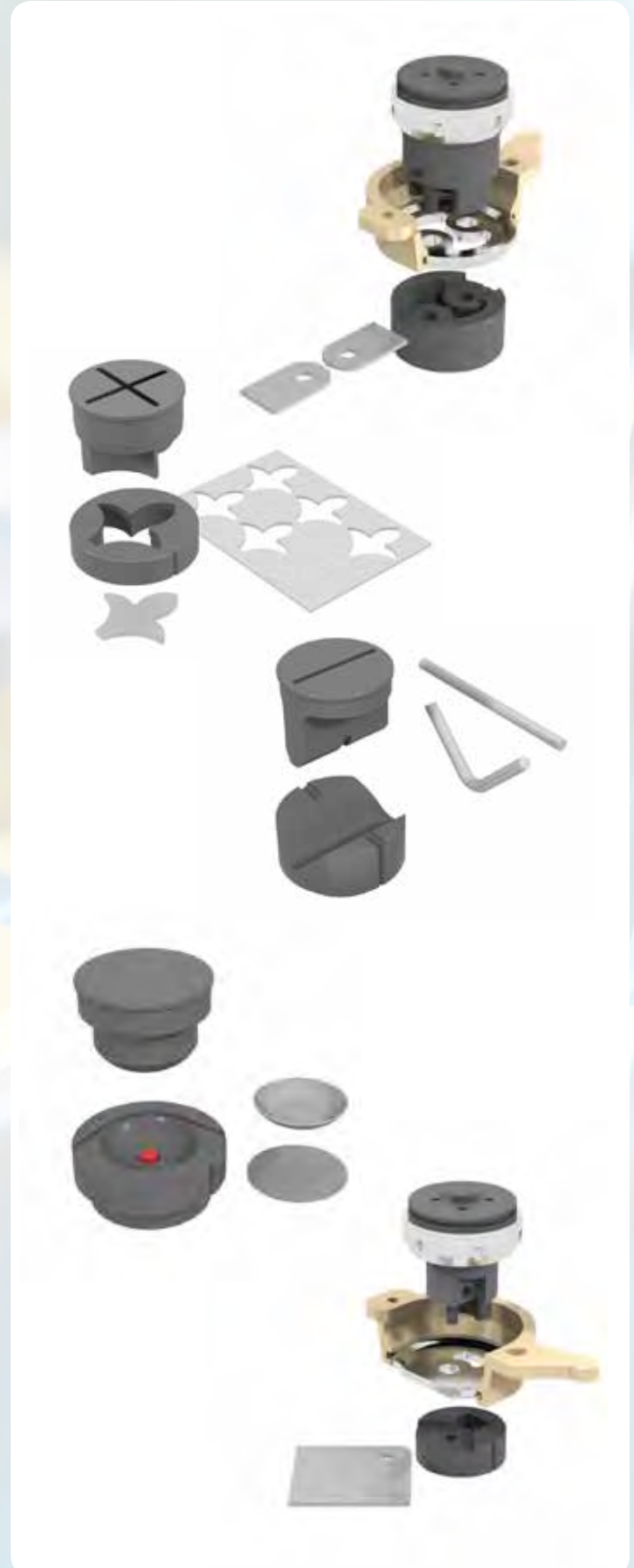
Geka currently has a complete range of over 7000 personalised designs of accessories for special applications.

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 # 13
- Notching of louvres # 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 + 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 20", our Semipaxy is available as part of an option package for our HYDRACROP SD or PUMA family of products.

Versions:

X 1000:

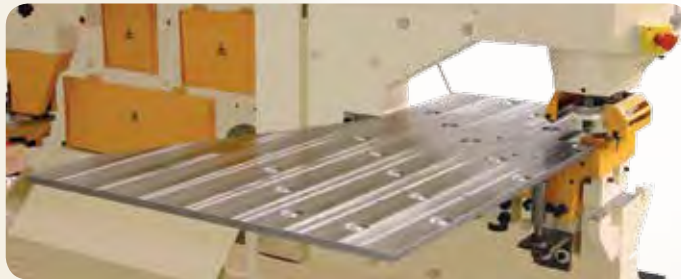
Accommodates material with a maximum length of 40"

X Plus:

Accommodates extension devices for longer material: 78.74", 118", 157", 196.85", and 236"

Maximum Widths according to Model:

- HYDRACROP or PUMA (20" throat) = 15.74"
- HYDRACROP Models 110SD and 165 SD = 20"
- PUMA (30" throat) = 25.59"



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 1-9/16"
- 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)	0-470"/min
Rate of Motion (Y-Axis)	0-470"/min
Position Tolerance	+/- 0,008"/40"
Repeatability	+/- 0,004"



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	118"*
Max. feed speed	78.740 ft/min
Position Tolerance	± .009"/ft
Max. feed weight	551 lb
Repeatability	± .002"/ft

* Additional in feed per 39" available.



Feeder slide PAX unit



ALRS

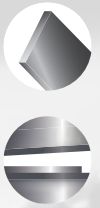
The ALRS product line is an automated feeder of flat bar, available as part of an option package for our HYDRACROP shearing stations.

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.

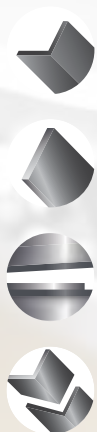
FEATURES

	ALRS 600	ALRS 750
Max. flat bar width	23 5/8"	30"
Max. flat bar length	275 19/32"	275 19/32"
Displacement speed	708.66"/min	708.66"/min
Positioning accuracy	+/- 0,008"/40"	+/- 0,008"/40"



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
- 24"x5/8" (flat bars) and 6"x6"x1/2" (angles) cropping capacity
- 20 ft. 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.)	1 x 1/8"	2 x 3/16"	2 x 3/16"	4 x 3/8"	4 x 3/8"
Flat Bar Size (Max.)	6 x 3/8"	20 x 3/4"	20 x 3/4"	20 x 1-1/4"	20 x 1-1/4"
Horizontal-Wing Punches	2	3	3	up to 3	up to 3
Maximum Diameter	1- 1/4"	1-9/16"	1-9/16"	1-9/16"	1-9/16"
Punching Force	70 Tons	120 Tons	120 Tons	185 Tons	240 Tons
Marking	-	Disc	Disc	Disc	Disc
Number of characters	-	40	40	40	40
Vertical wing punches	-	-	1	-	-
Maximum Diameter	-	-	1-1/4"	-	-
Vertical Punching Force	-	-	65 Tons	-	-
Angle Processing (Min. Size)	-	-	1- 1/2 x 1/8"	-	-
Angle Processing (Max. Size)	-	-	6 x 6 x 5/8"	-	-
Drilling Unit	✓	✓	✓	✓	✓

Capacities based on material resistance of 65,000 PSI tensile

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	40 x 20"

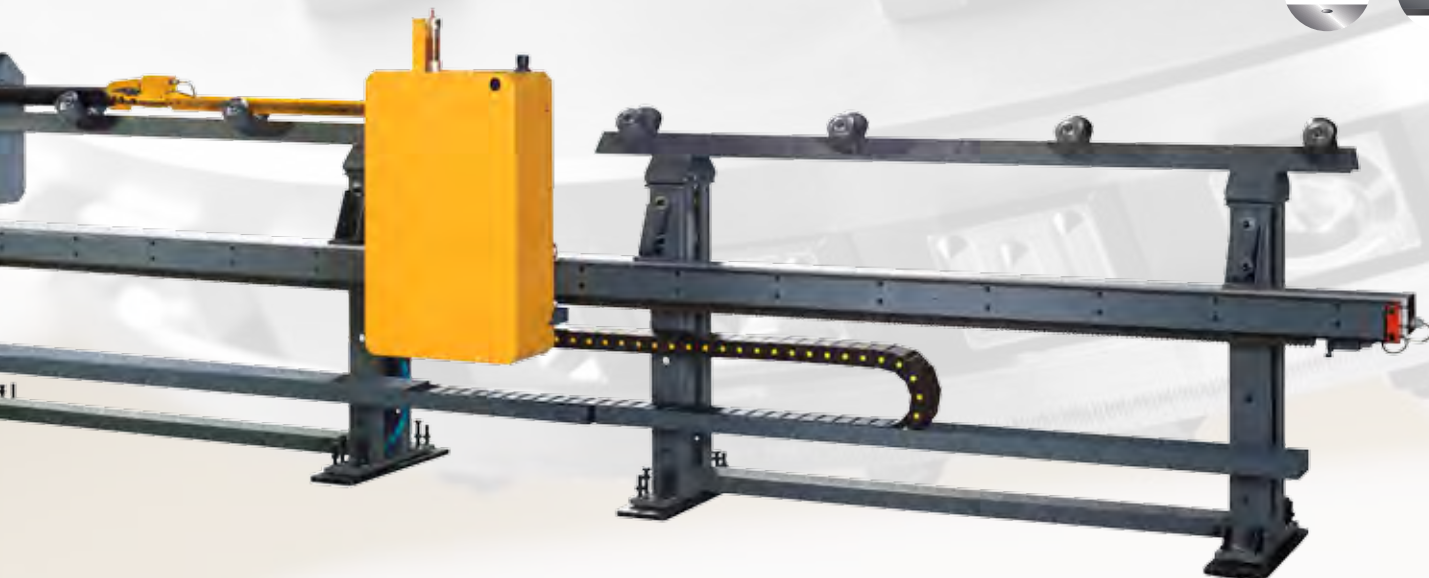
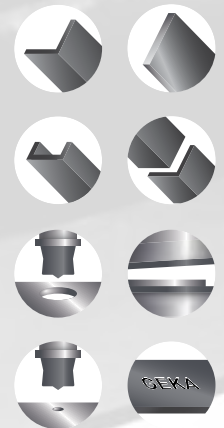


ANGLE-PROCESSING LINES

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	1-1/2x1-1/2x1/8"	1-1/2x1-1/2x1/8"	1-1/2x1-1/2x3/16"	1-1/2 x 1-1/2 x 3/16"	1-1/2 x 1-1/2 x 3/16"
Maximum L	2-1/2x2-1/2x3/8"	3 x 3 x 3/8"	6 x 6 x 5/8"	6 x 6 x 5/8"	6 x 6 x 5/8"
Minimum Flat Bar	•	•	•	2 x 3/16"	2 x 3/16"
Maximum Flat Bar	•	•	•	6 x 5/8"	6 x 5/8"
Minimum U	•	•	•	2 1/4 x 1-1/4"	2 1/4 x 1-1/4"
Maximum U	•	•	•	4 x 2"	4 x 2"
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	11/16"	1"	1-1/4"	1-1/4"	1-1/4"
Punching Force	20 Tons	38 Tons	65 Tons	80 Tons	80 Tons
Shearing Force	40 Tons	70 Tons	215 Tons	215 Tons	280 Tons
Feeder Speed	Programmable up to 1400"/min.				
Positioning Tolerance	+/- .009" +/- .002"/ft				





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

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