



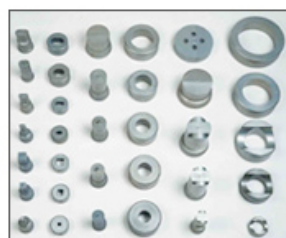
## IRON WORKER (MADE IN TAIWAN)



### Double Cylinder

IW-60S/SD, IW-80S/SD,  
IW-100S/SD, IW-120S/SD, IW-165SD

The double cylinder "S/SD" series are in the Sunrise tradition of well engineered ironworkers built for high power, quality, and reliability. These ironworkers have two control foot paddles, and separate operations can be safely performed simultaneously without interference. The low pressure setting for tool change provides maximum operation safety. The long punching cylinder stroke and deep throat enable mounting a wide range of special equipment. The large punching base with the "T-slot" fixing provide a solid base for securing the punching tooling, as well as a wide range of optional and custom designed tooling..

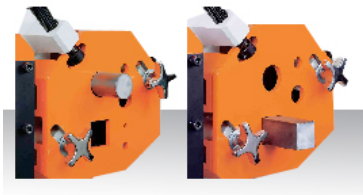


### PUNCHING STATION

Easily changeable punches and dies for fast tool change.  
Thoughtfully designed stripper for visibility, safety and ease of use.

Standard gauging table or optional multi-stop gauging table or optional duplicating gauging table.

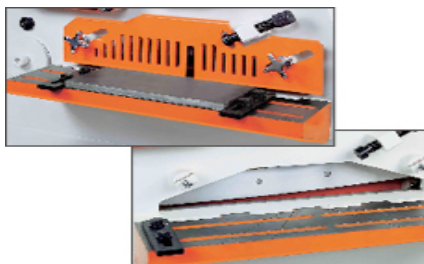
Optional hydraulic stripper is available on double cylinder ironworkers and punching machines.



### BAR SHEARING STATION

One hold-down for various sizes of square bar shearing and round bar shearing.

Optional channel shear tooling is available for most models. (See specification chart for details)



### FLAT BAR SHEARING STATION

Special curved upper blade to give a clean shear with minimum distortion.

Lower blade has four usable cutting edges.

Variable degree miter-cutting on angle flange.

Easily adjustable hold-down.

Support table with guides for accurate positioning.

Optional hydraulic hold-down is available on double cylinder ironworkers.

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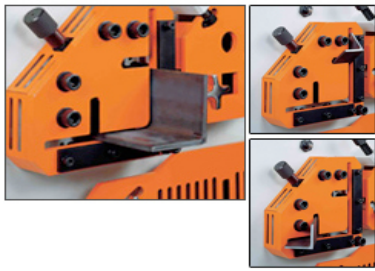
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### ANGLE SHEARING STATION

Single shear with no material loss and minimal deformity. 45 degree miter-cut is easy and clean. Featuring blades with four usable cutting edges.



### NOTCHING STATION (optional on IW-45M)

Ideal for notching on flat bars and angles. Feature electrically interlocked safety guard for maximum safety and visibility. Gauging table with stops for precise positioning. Optional Vee-Notcher is also available.

### Optional Tooling for Double Cylinder Ironworkers:

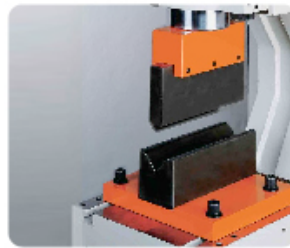
#### For PUNCHING STATION



Urethane spring stripper for minimal deformation



Pipe Notcher



Single Vee Press Brake



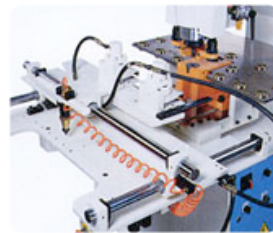
Multi Vee Press Brake



Large Vee Notcher



Multi Stop Gauge Table



Duplicating Table with Hydraulic stripper and Hydraulic Clamping

#### For BAR SHEARING STATION



Channel Shear or Special Profile Shear

#### For FLAT BAR SHEARING STATION



Hydraulic Holddown for Flat Shear

#### For NOTCHING STATION



Vee - Notcher

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## TECHNICAL SPECIFICATIONS

| MODEL   | IW-60S         | IW-80S          | IW-100S   | IW-125S         | IW-165SD        |                |
|---|----------------|-----------------|---|-----------------|-----------------|----------------|
|   | IW-60SD        | IW-80SD         | IW-100SD  | IW-125SD        |                 |                |
| <b>PUNCHING</b>   |                |                 |   |                 |                 |                |
| Punching Pressure   | 60 Ton         | 80 Ton          | 100 Ton   | 125 Ton         | 165 Ton         |                |
| Punch Capacity<br>(Diameter x Thickness)                          | ø22 x 20       | ø26 x 22        | ø28 x 26  | ø33 x 27        | ø37 x 32        |                |
| Throat Depth S:   | 310            | 310             | 310   | 310             | ---             |                |
| Throat Depth SD:  | 510            | 510             | 510   | 510             | 510             |                |
| Channel Flange Punch (Height)                                     | 180            | 180             | 180   | 180             | 180             |                |
| Max. Stroke Length  | 100            | 100             | 100   | 100             | 100             |                |
| Cycles / Min. (20mm stroke)                                       | 30             | 29              | 28  | 28              | 29              |                |
| Working Height Up to Die  | 1010           | 1050            | 1044  | 1069            | 1050            |                |
| <b>FLAT SHEARING</b>  |                |                 |   |                 |                 |                |
| Flat Bar Shearing<br>(Width x Thickness)                          | 350 x 15       | 460 x 15        | 610 x 16  | 610 x 18        | 760 x 20        |                |
| Blade Length  | 240 x 20       | 300 x 20        | 400 x 20  | 400 x 25        | 400 x 30        |                |
| Angle Flange Trim   | 360            | 465             | 620   | 620             | 770             |                |
| Working Height  | 100            | 100             | 100   | 100             | 120             |                |
|   | 910            | 926             | 954   | 920             | 920             |                |
| <b>ANGLE SHEARING</b>   |                |                 |   |                 |                 |                |
| At 90° Shearing   | 130 x 130 x 13 | 152 x 152 x 13  | 152 x 152 x 15  | 152 x 152 x 18  | 205 x 205 x 20  |                |
| At 45° Miter Shearing   | 65 x 65 x 8    | 80 x 80 x 10    | 80 x 80 x 10  | 80 x 80 x 10    | 80 x 80 x 10    |                |
| Working Height  | 1115           | 1165            | 1216  | 1185            | 1185            |                |
| <b>BAR SHEARING</b>   |                |                 |   |                 |                 |                |
| Round Bar Shear   | ø40            | ø45             | ø45   | ø50             | ø60             |                |
| Square Bar Shear  | 38 x 38        | 45 x 45         | 45 x 45   | 50 x 50         | 60 x 60         |                |
| Channel Shear   | 130*           | 152*            | 152*  | 180*            | 203*            |                |
| I-Beams Shear   | 130*           | 152*            | 152*  | 180*            | 203*            |                |
| Working Height  | 1220           | 1270            | 1332  | 1310            | 1370            |                |
| <b>NOTCHING</b>   |                |                 |   |                 |                 |                |
| Rectangular Notcher (WxDxT)                                       | 50.8 x 90 x 9  | 50.8 x 90 x 12  | 63.5 x 90 x 12  | 63.5 x 90 x 13  | 63.5 x 90 x 16  |                |
| Vee-Notcher (Side x Side x T)                                     | 90 x 90 x 10*  | 90 x 90 x 12*   | 105 x 105 x 12*   | 105 x 105 x 13* | 105 x 105 x 16* |                |
| Large V-Notcher (Side x Side x T)                                 | 145 x 145 x 8* | 145 x 145 x 10* | 145 x 145 x 12*   | 145 x 145 x 13* | 145 x 145 x 13* |                |
| Working Height  | 910            | 926             | 954   | 920             | 920             |                |
| <b>SPECIAL TOOLING</b>  |                |                 |   |                 |                 |                |
| Single Vee Press Brake (W x T)                                    | 250 x 15*      | 250 x 15*       | 250 x 20*   | 250 x 20*       | 250 x 20*       |                |
| Multi Vee Press Brake (W x T)                                     | 500 x 5*       | 500 x 5*        | 700 x 5*  | 700 x 5*        | 700 x 5*        |                |
| Angle Bending   | 102 x 6*       | 102 x 8*        | 102 x 13*   | 102 x 13*       | 102 x 13*       |                |
| Pipe Notching   | ø114*          | ø114*           | ø114*   | ø114*           | ø114*           |                |
| <b>OTHER</b>  |                |                 |   |                 |                 |                |
| Electric Power (HP)   | 7.5 HP         | 10 HP           | 10 HP   | 15 HP           | 20 HP           |                |
| Net Weight (Apr.)   | S              | 1800 kg         | 2180 kg   | 2950 kg         | 3340 kg         | ---            |
|   | SD             | 2200 kg         | 2650 kg   | 3450 kg         | 3950 kg         | 4950 kg        |
| Gross Weight (Apr.)   | S              | 1950 kg         | 2360 kg   | 3180 kg         | 3590 kg         | ---            |
|   | SD             | 2380 kg         | 2880 kg   | 3700 kg         | 4220 kg         | 5250 kg        |
| Machine Dimension<br>(Apr.) (L x W x H)                           | S              | 1700x800x1710   | 1830x820x1760   | 2100x860x1810   | 2170x1030x1850  | ---            |
|   | SD             | 2070x800x1710   | 2210x820x1760   | 2460x860x1810   | 2490x1030x1850  | 2710x1070x2010 |
| Packing Dimension<br>(Apr.) (L x W x H)                           | S              | 1970x960x1990   | 2100x980x2040   | 2370x1020x2090  | 2440x1190x2130  | ---            |
|   | SD             | 2340x960x1990   | 2480x980x2040   | 2730x1020x2090  | 2760x1190x2130  | 2980x1230x2290 |
| <b>All dimension are in M.M.</b>                                  |                |                 | <b>Specification with * marked are Optional Toolings</b>            |                 |                 |                |
| <b>Based on material strength of 45kg/mm<sup>2</sup> tensile.</b> |                |                 | <b>Design &amp; Specifications subject to change without notice</b> |                 |                 |                |

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