

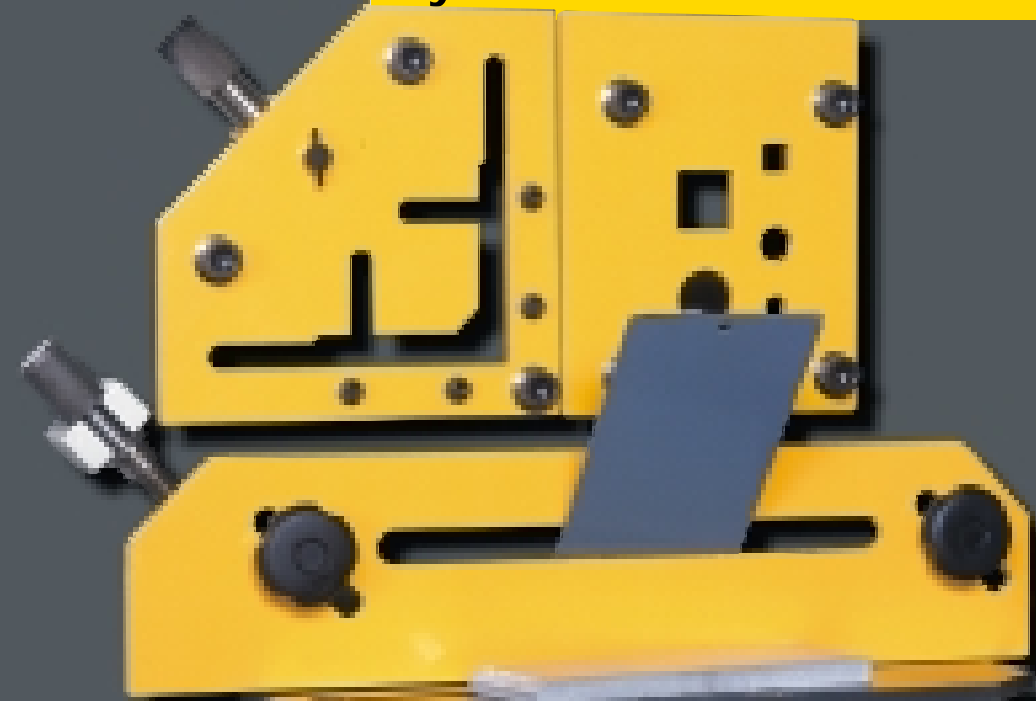
**KINGSLAND**



for impressive  
performances



**MULTI**  
hydraulic steelworker



## 1 punch station

The large punch bed area has a removable front block and is designed to give a very wide range of punching applications. A punch table with rules and guides for repetition work are fitted as standard equipment.



The Kingsland Multi range of 60 up to 175 ton machines are in the Kingsland tradition of well engineered, robust steelworkers, built for a long working life. These universal machines are supplied with standard tooling including repetition support tables at punch, shear and notch stations and with easily adjusted holddowns at all five work stations to safely control the operations. Comprehensive safety guards are fitted as standard on all work stations. Free standing on a suitable floor, they just require electrical connection to be ready for work. For two operator utilisation, the hydraulic system is activated by two shielded foot controls, one operating the punch end cylinder, the other operating the shear end cylinder. The shear cylinder provides the power to the three

shearing and the notch stations. The system gives accurate power inching at all five work stations and allows the machine to be stopped at any position giving safe and accurate tool setting and work positioning. Limit switches at both ends of the machine control stroke length at all stations. Centralised lubrication is metered by one-shot system, being only one feature of the low maintenance requirement. An optional 'Production Pack' is available to enhance the machine specification, this includes: 1 low volt halogen lamp on a movable magnetic base, 1.0 m long touch and cut ruled length stop, fine adjustment facility to the punch stroke and measuring scales in the notch table.

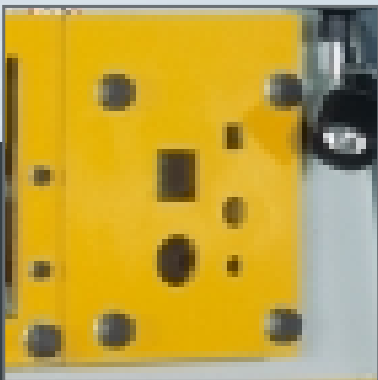
## 2 angle station

This station provides large capacity angle cutting at 90° and 45°. Angles between 45° and 90° can be achieved by first cutting at 90° and then flange trimming to the required angle in the shearing station.



## 3 section cutting station

The machines are fitted as standard with blades for cutting round and square bars. With extra equipment, the machines are able to cut, in this aperture, channel, joist, T-sections and many other special profiles.



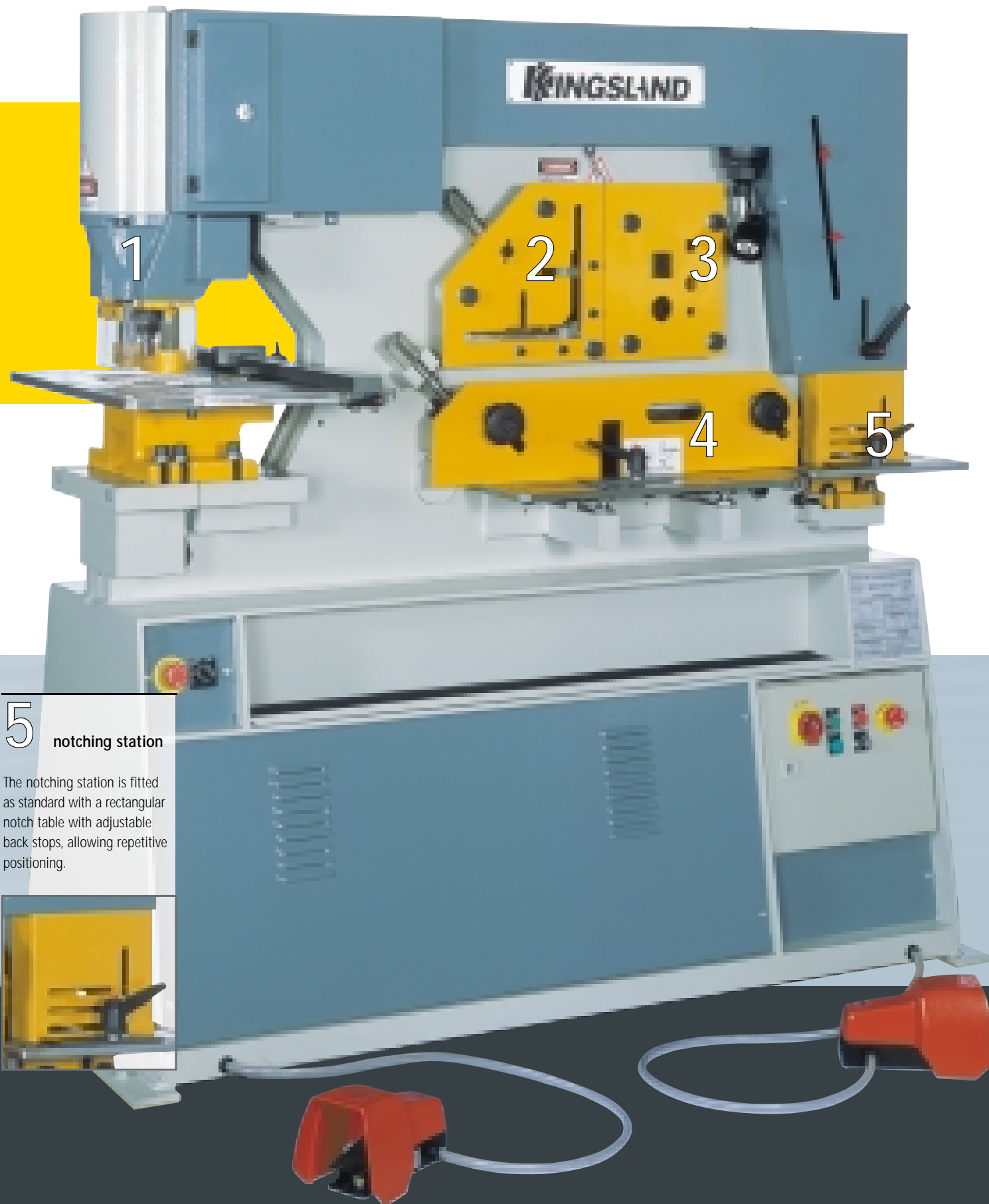
## 4 shearing

The shearing unit is fitted with a simple robust holddown which is adjustable to any thickness of material within the cutting capacity of the machine. The shear feed table with adjustable guides is fitted to allow accurate feeding of materials. The guide can be adjusted to allow mitre cutting up to 45° for flat bars or to trim the flanges of angle.



## 5 notching station

The notching station is fitted as standard with a rectangular notch table with adjustable back stops, allowing repetitive positioning.

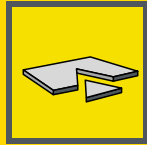


## punch station applications - with optional equipment



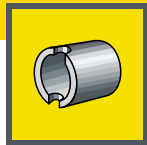
### minimum deform stripper assembly

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.



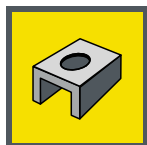
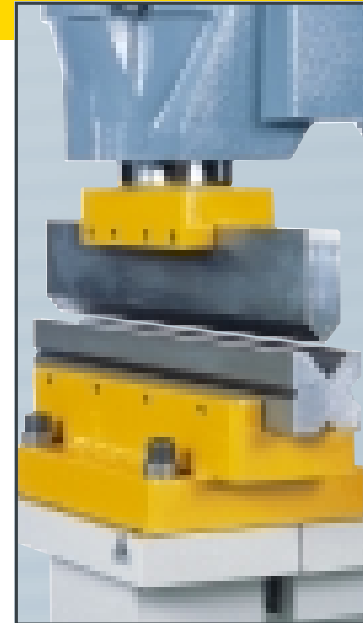
### large hole attachment

Large hole/slot attachment for diameters from 38 up to 110 mm. Also available for diameters up to 160 or 225 mm.

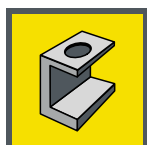


### sheet bending unit

Sheet bending unit with multi-vee block (with 10, 20, 24 & 40 mm wide V-openings, all 85°).

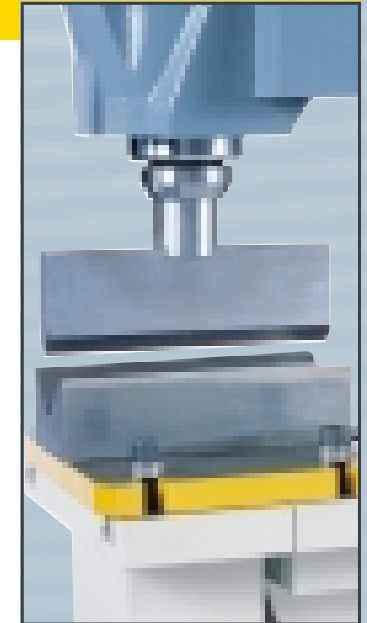


### large corner notch attachment



### bar bending unit

For bending material up to max. 22 mm thickness. With single-vee block, 76 mm with V at 85°.



### 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 165 mm.



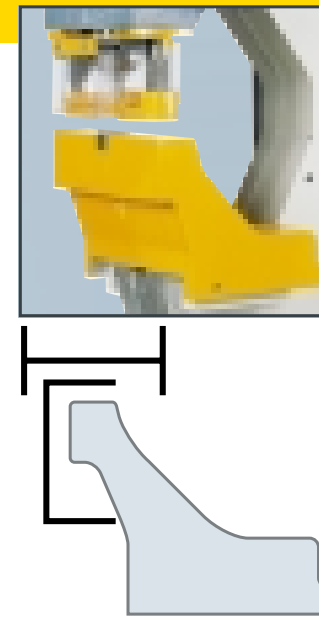
### twin hole unit

Twin hole variable pitch unit. Punches 2 holes up to 29 mm dia.



### swan neck bolster

For web and flange punching up to 32mm dia. in 300 mm max. channel and 'I' beam.

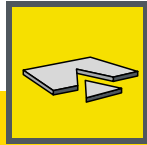


### dovetail assembly

Changing from punching to bending in 20 seconds.

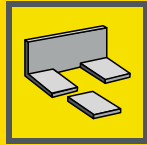
punch holder, minimum deform stripper, bolster multi-vee bending tool





## notching station

This versatile station can be fitted with a punching station (option) to give double ended punching-throat depth 125 mm.



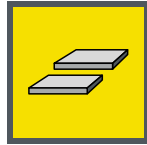
### rectangular notch unit

The notching station is fitted as standard with a rectangular notch unit and notch table with adjustable back stops allowing repetitive positioning. Extra equipment is available for narrow widths.



### 90 degree V-notch (option)

For triangular notching purposes, the standard rectangular notch station can be replaced by a V-notch unit. The V-notch unit is available in various angles up to 90°.

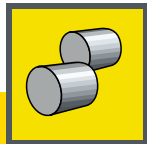
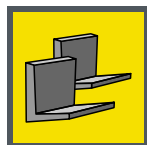
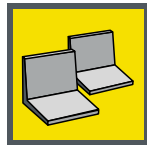


## shearing/angle station

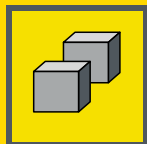


### chamfering application (option)

Specially designed-patented blades and hold-down for chamfering applications. With this special equipment it is possible to cut 45° chamfers at the edge of flat plate, thus eliminating the need for special machinery. For welding applications.

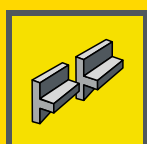
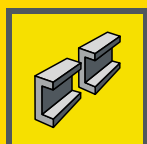
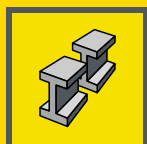


## section cutting station



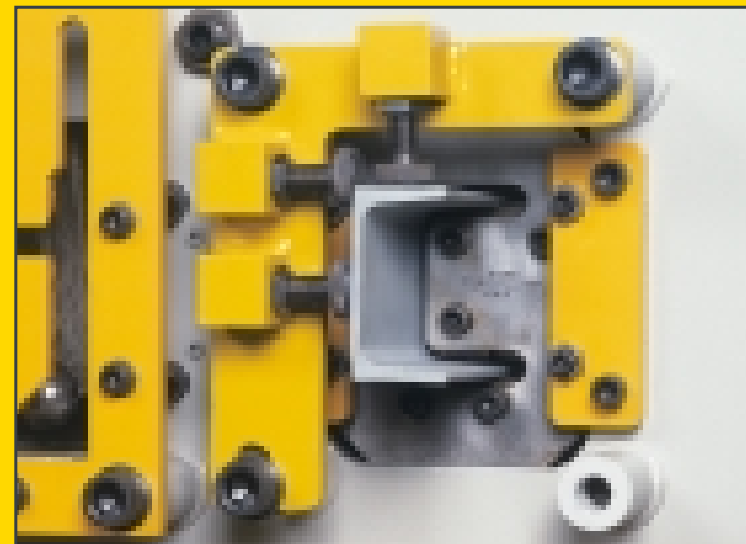
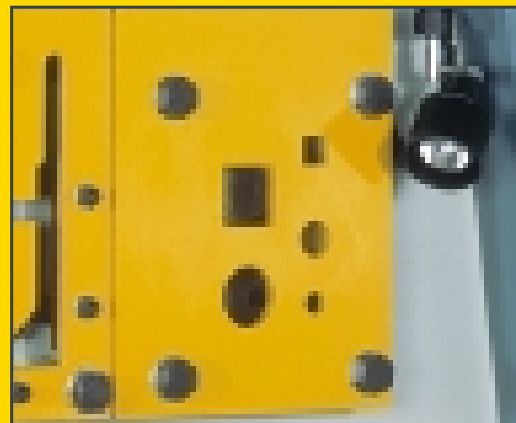
### standard execution

The machines are fitted as standard with multi-hole blades for cutting round and square bars. With optional equipment, the machines are able to cut channels, joists, Tee-beams and many different profiles. The blades are firmly retained by simple clamps, allowing easy change without the need for elaborate setting.



### blades for cropping channel

Optional solid blades for cropping UPN-profiles. Blades available for many different and special profiles and/or with interchangeable insert blades.



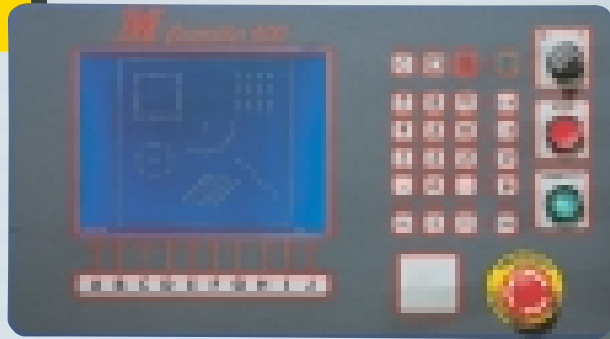
### Touch & Cut ruled length stop

The (optional) Touch & Cut ruled length stop (one metre) can be used for the angle-cutting, section-cutting and shear station. 2 or 3 metre lengths available.



## further optional equipment

**M 600 Controller (optional)**  
Graphical simulation of the hole pattern.



**M 200 Controller (standard)**



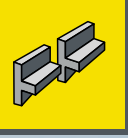
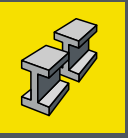
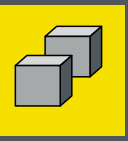
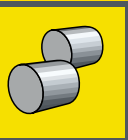
### CNC-controlled positioning table

Punching of plates, flat steel, in the web of channel and on the flange of channel and I-beams. The table is delivered with an easy to operate control and TDC screen. The CNC-control system ensures the required accuracy within a hole pattern with several gauge lines. Especially advantageous is the repeatability accuracy. The use of labour intensive manual layout is no longer required. Available for deep throat machines.



## features

- large punch table with multi-purpose bolster – removable table block for overhang channel/joist flange punching
- punch table, shear table and notch table standard equipment
- non-tiltable and as thus wear-free angle-cutting blades
- power inching and adjustable strokes at punch & shear end
- centralised pressure lubrication
- wide variety of applications – for large hole punching, crimping, tube notching, bar bending, sheet bending, punch press applications...
- large throat depth at the punching station – extra deep throat models available
- mitre cut flanges of angle under shear blade
- alternative rectangular/vee notching facility
- work station guards standard fitment
- two cylinder operation
- overload relief on hydraulic system
- interchangeable bearings, seals and valves readily available from stockists of hydraulic equipment
- machines with very low maintenance requirements



## standard equipment

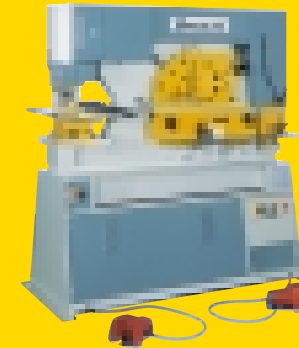
	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 175
• punch and die	Ø 22	Ø 22	Ø 22	Ø 22	Ø 24	Ø 26
• section blades						
• round	16, 25, 45	16, 25, 45	16, 25, 45	20, 30, 50	20, 40, 55	20, 25, 30, 40, 65
• square	20, 45	20, 45	20, 45	30, 50	30, 40, 55	25, 40, 55

- punch adaptors
- swing away punch stripper unit
- easy change punch holder
- universal die bolster
- heavy-duty support tables with guides at shear station and notch station
- heavy-duty punch table with guides and backstop
- curved shear arm blade with 2 (optional: 4) cutting edges
- 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
- service toolkit
- work station guards
- instruction, operating and maintenance manual
- hydraulic oil fill

# MULTI

**KINGSLAND**

## model specifications



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

all dimensions are in mm

based on material strength of 450 N/mm <sup>2</sup>	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 175
<b>PUNCHING</b>						
maximum capacity	29 x 15	26 x 20	28 x 20	27 x 25	35 x 25	40 x 32
diameter x thickness	57 x 8	57 x 9	57 x 10	57 x 12	57 x 16	57 x 22
stroke length	55	55	55	80	80	80
standard throat depth	305	305	305	355	355	625
deep throat model	625	625	625	625	625	625
largest hole - std. equipment	57	57	57	57	57	57
largest hole (optional) (*)	160	160	160	160	225	225
maximum section	305	305	305	305	305	380
working height	1030	1030	1087	1039	1056	1134
<b>SHEARING</b>						
flat bar – max. thickness	230 x 20	300 x 20	300 x 20	380 x 20	380 x 25	380 x 30
flat bar – max. width	375 x 10	375 x 15	450 x 15	480 x 15	600 x 15	600 x 20
angle flange trim – max 45°	100 x 15	100 x 15	100 x 15	120 x 15	120 x 15	120 x 15
working height	890	890	890	890	900	900
<b>ANGLE CUTTING</b>						
90° cut	130 x 13	130 x 13	150 x 13	150 x 15	150 x 18	200 x 20
45° mitre (true int./ext.)	70 x 10	70 x 10	70 x 10	80 x 10	80 x 10	80 x 10
working height	1130	1130	1155	1155	1160	1160
<b>SECTION CUTTING</b>						
round/square	45	45	45	50	55	65/55
channel/beam (**) (*)	130 x 65	130 x 65	130 x 65	160 x 90	200 x 100	300 x 125
Tee (**) (*)	90 x 12	90 x 12	90 x 12	100 x 12	120 x 12	150 x 15
(**) other profiles are also possible (*) optional equipment						

based on material strength of 450 N/mm <sup>2</sup>	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 175
<b>NOTCHING</b>						
material thickness	10	10	12	13	13	16
width – rectangle	45	45	40	52	60	60
depth – rectangle	90	90	90	100	100	100
depth – vee (*)	60	60	60	70	80	80
angle flange – max. profile	100 x 10	100 x 10	100 x 10	100 x 13	100 x 13	110 x 14
working height	890	890	890	890	900	900
<b>CORNER NOTCH (*)</b>						
maximum capacity	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6	250 sq x 6
<b>TUBE NOTCH (*)</b>						
maximum outside diameter	83	83	83	108	108	165
<b>BENDING (*)</b>						
bar bend. max. capacity	250 x 12	250 x 13	250 x 15	250 x 20	250 x 22	250 x 25
sheet bend. max. capacity	500 x 3	500 x 3	500 x 3	500 x 3	700 x 3	700 x 4
<b>PUNCHING AT NOTCH STATION (*)</b>						
throat depth	125	125	125	125	125	125
maximum capacity	38 x 7	38 x 8	38 x 8	38 x 10	38 x 12	38 x 13
<b>TECHNICAL DATA</b>						
motorpower	5,5 kW	5,5 kW	7,5 kW	7,5 kW	7,5 kW	11 kW
nett weight – std. throat	1570 kg	1620 kg	1925 kg	2430 kg	3100 kg	5550 kg
gross weight – std. throat	1695 kg	1740 kg	2095 kg	2640 kg	3370 kg	5970 kg
machine dim. (LxWxH), cm	164 x 71 x 178	164 x 71 x 180	176 x 71 x 183	190 x 79 x 191	200 x 80 x 203	270 x 112 x 216
packed dim. (LxWxH), cm	175 x 86 x 195	175 x 86 x 197	191 x 86 x 200	205 x 94 x 209	215 x 95 x 221	285 x 127 x 241





for impressive performances

## the Kingsland range of hydraulic steelworkers

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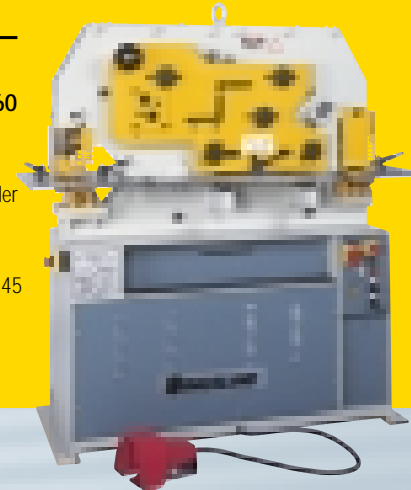
### 1 COMPACT 40

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



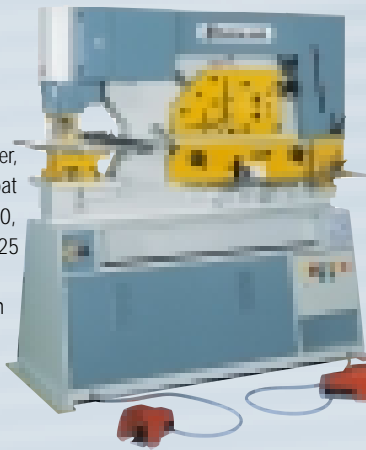
### 2 COMPACT 60

- 5 stations
- single cylinder hydraulic steelworker
- available in 45 & 60 ton



### 3 MULTI 80

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



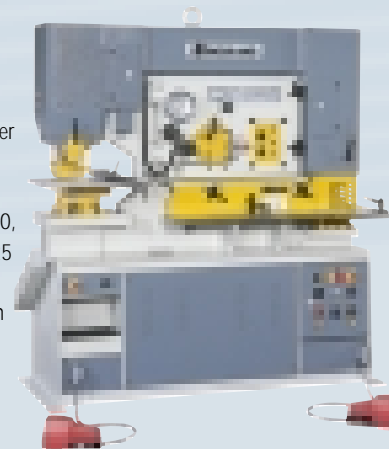
### 4 PUNCH 60

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



### 5 ULTIMA 75

- 5 stations
- double cylinder hydraulic steelworker
- available in 60, 75, 100 & 125 ton
- available with deep throat



### 6 125 D DOUBLE PUNCH

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

