

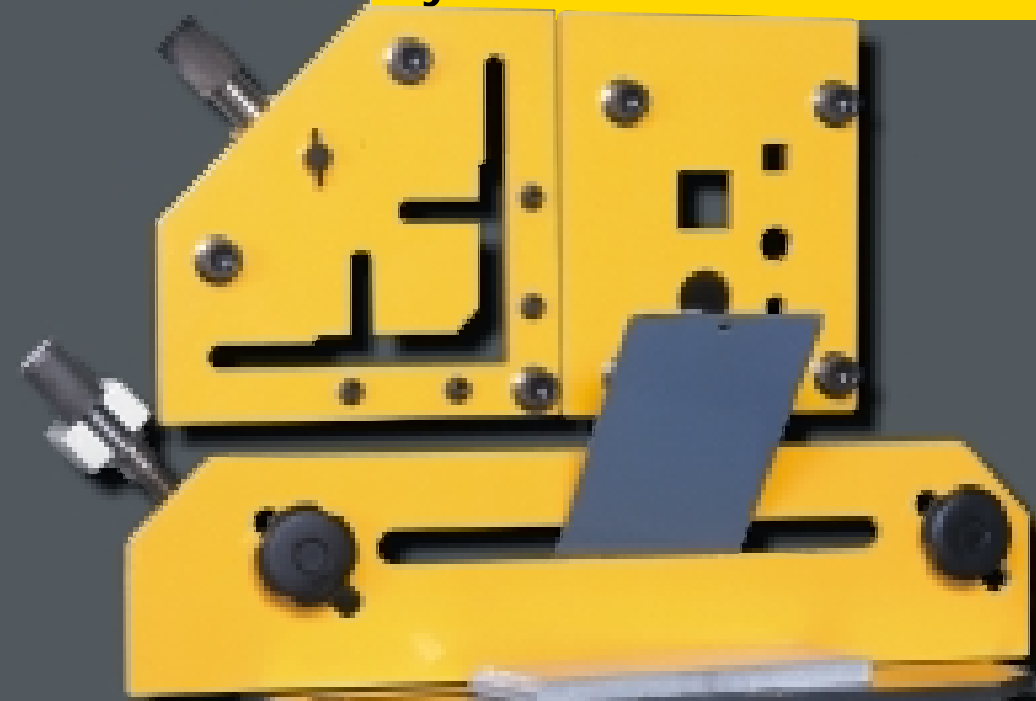
**KINGSLAND**



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, 39" long touch and cut ruled length stop, fine adjustment facility to the punch stroke and measuring scales in the notch table.

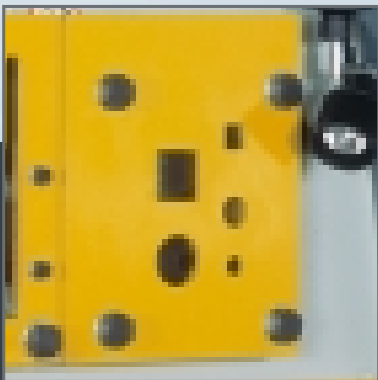
## 2 angle station

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.



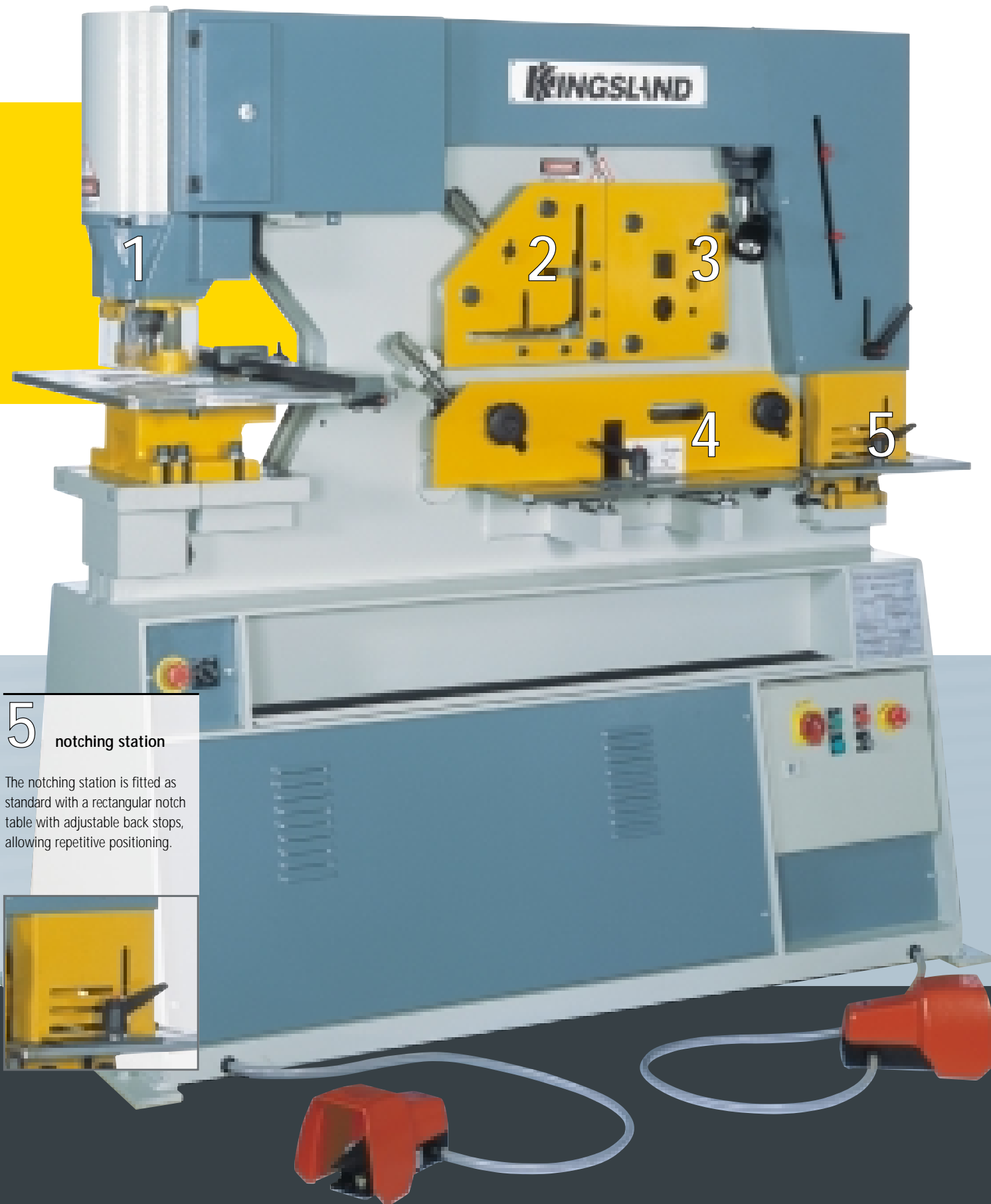
## 4 shearing

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.

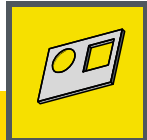


## 5 notching station

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

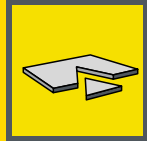


## punch station-applications with optional equipment



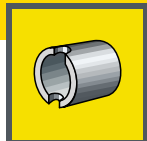
### minimum deform stripper assembly

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.



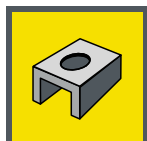
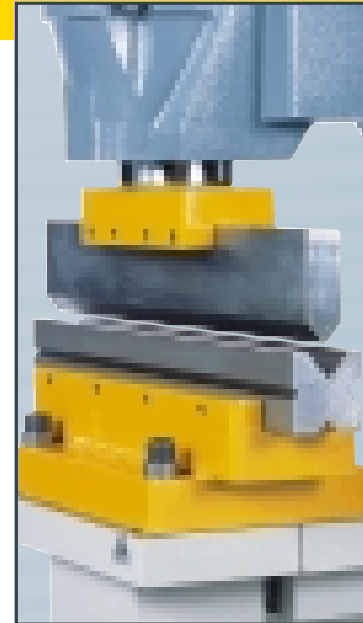
### large hole attachment

Large hole/slot attachment for diameters from 1 1/2" up to 4 3/8". Also available for diameters up to 6 3/8" or 9".

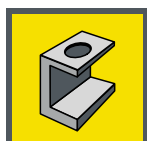


### sheet bending unit

Sheet bending unit with multi-vee block (with 3/8", 3/4", 15/16" and 1 1/2" wide V-openings, all 85°).

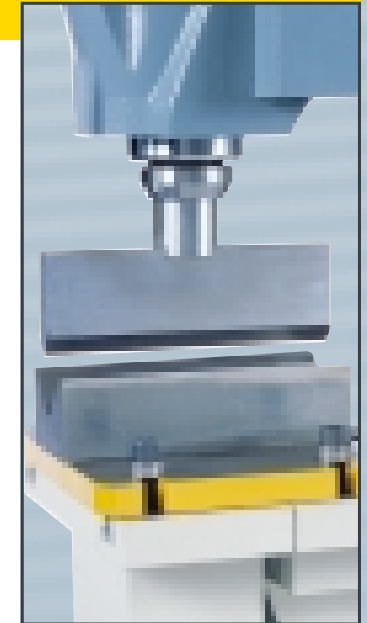


### large corner notch attachment



### bar bending unit

For bending material up to max. 7/8" thickness. With single-vee block, 3" 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 6 1/2".



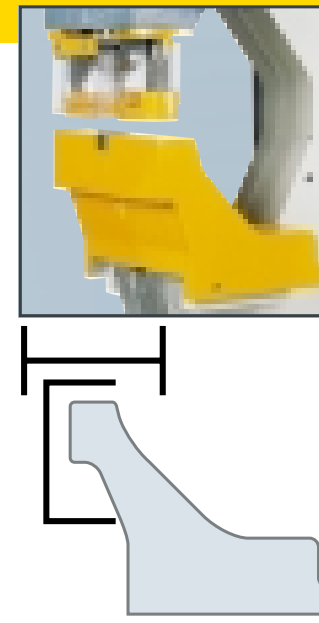
### twin hole unit

Twin hole variable pitch unit. Punches 2 holes up to 1 1/8" dia.



### swan neck bolster

For web and flange punching up to 1 1/4" dia. in 12" max. channel and 'I' beam.

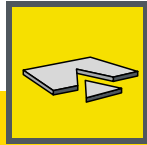


### dovetail assembly

Changing from punching to bending in 20 seconds.

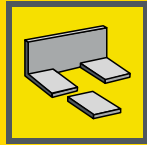
punch holder, minimum deform stripper, bolster multi-vee bending tool





## notching station

This versatile station can be fitted with a punching station (option) to give double ended punching-throat depth 5".



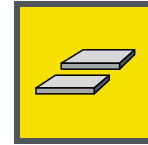
### rectangular notch unit

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.

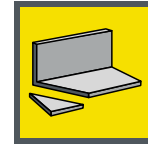


### 90 degree V-notch (option)

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°.

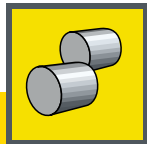
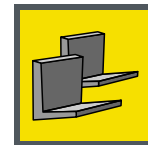
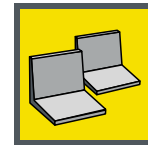


## shearing/angle station

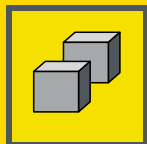


### chamfering application (option)

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.

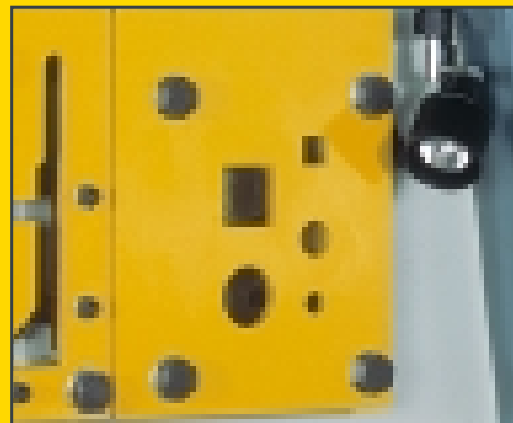
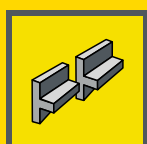
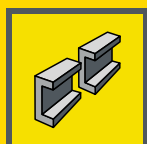
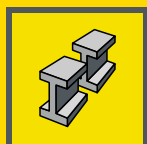


## section cutting station



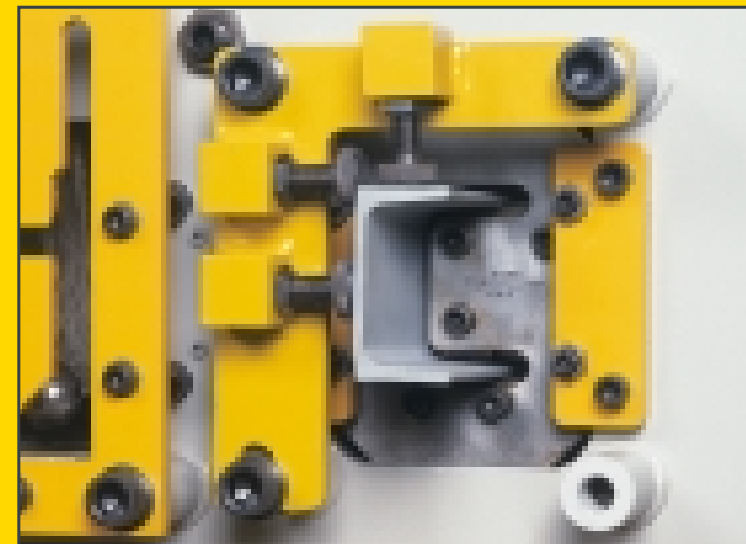
### standard execution

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.



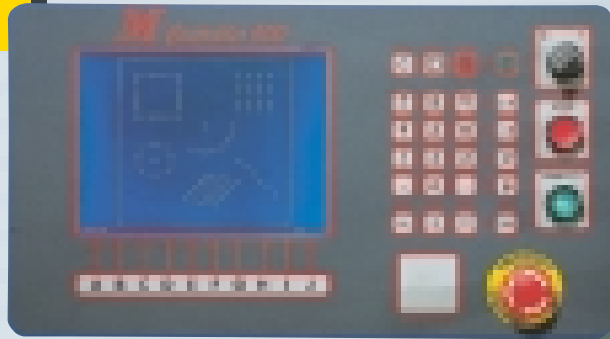
### Touch & Cut ruled length stop

The (optional) Touch & Cut ruled length stop (39") can be used for the angle-cutting, section-cutting and shear station. 18" or 118" lengths available.



## further optional equipment

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



**M 200 Controller (standard)**



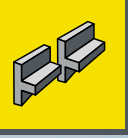
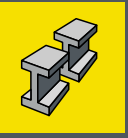
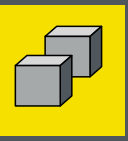
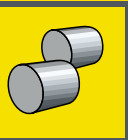
### CNC-controlled positioning table

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



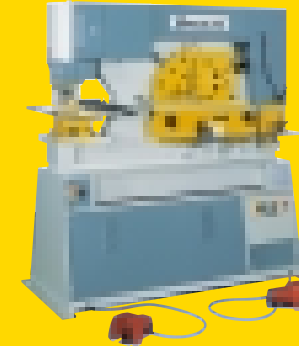
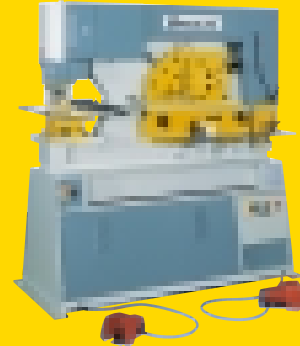
## standard equipment

	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	5/8", 1", 1 1/4"	5/8", 1", 1 1/4"	5/8", 1", 1 1/4"	3/4", 1 1/8", 2"	3/4", 1 1/8", 2 1/8"	1/2", 1", 1 1/8", 1 1/2", 2 1/2"
• square	3/4", 1 1/4"	3/4", 1 1/4"	3/4", 1 1/4"	1 1/8", 2"	1 3/8", 1 1/2", 2 1/8"	1", 1 1/8", 2 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 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



Information not binding to detail as design and specifications are constantly being reviewed.  
All dimensions are shown in inches unless otherwise stated.

based on material strength of 28 ton/inch <sup>2</sup>	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 175
<b>PUNCHING</b>						
maximum capacity	1 1/4 x 1/2	1 x 3/4	1 1/8 x 3/4	1 1/16 x 1	1 3/8 x 1	1 1/2 x 1 1/4
diameter x thickness	2 1/4 x 5/16	2 1/4 x 11/32	2 1/4 x 3/8	2 1/4 x 1/2	2 1/4 x 5/8	2 1/4 x 7/8
stroke length	2 1/8	2 1/8	2 1/8	3 1/8	3 1/8	3 1/8
standard throat depth	12	12	12	14	14	25
deep throat model	25	25	25	25	25	25
largest hole - std. equipment	2 1/4	2 1/4	2 1/4	2 1/4	2 1/4	2 1/4
largest hole (optional) (*)	6 3/8	6 3/8	6 3/8	6 3/8	9	9
maximum section	12	12	12	12	12	15
working height	40 1/2	40 1/2	42 5/16	40 3/16	41 1/2	44 3/8
<b>SHEARING</b>						
flat bar - max. thickness	9 x 3/4	12 x 3/4	12 x 3/4	15 x 3/4	15 x 1	15 x 1 1/16
flat bar - max. width	14 3/4 x 3/8	14 3/4 x 5/8	18 x 3/8	18 3/4 x 3/8	24 x 3/8	24 x 3/4
angle flange trim - max 45°	4 x 3/8	4 x 3/8	4 x 3/8	5 x 3/8	5 x 3/8	5 x 3/8
working height	35	35	35	35	35 3/8	35 3/8
<b>ANGLE CUTTING</b>						
90° cut	5 3/16 x 1/2	5 3/16 x 1/2	6 x 1/2	6 x 3/8	6 x 3/4	8 x 3/4
45° mitre (true int./ext.)	2 3/4 x 3/8	2 3/4 x 3/8	2 3/4 x 3/8	3 x 3/8	3 x 3/8	3 x 3/8
working height	44 1/2	44 1/2	45 1/2	45 1/2	45 5/8	45 5/8
<b>SECTION CUTTING</b>						
round/square	1 3/4	1 3/4	1 3/4	2	2 1/8	2 1/2 / 2 1/2
channel/beam (**) (*)	5 3/16 x 2 1/2	5 3/16 x 2 1/2	5 3/16 x 2 1/2	6 x 3 1/2	8 x 4	12 x 5
Tee (**) (*)	3 1/2 x 1/2	3 1/2 x 1/2	3 1/2 x 1/2	4 x 1/2	5 x 1/2	6 x 3/8
(**) other profiles are also possible (*) optional equipment						

based on material strength of 28 ton/inch <sup>2</sup>	MULTI 60	MULTI 70	MULTI 80	MULTI 95	MULTI 125	MULTI 175
<b>NOTCHING</b>						
material thickness	3/8	3/8	1/2	1/2	1/2	5/8
width - rectangle	1 1/4	1 3/4	1 1/2	2	2 3/8	2 3/8
depth - rectangle	3 1/2	3 1/2	3 1/2	4	4	4
depth - vee (*)	2 3/8	2 3/8	2 3/8	2 3/4	3 1/8	3 1/8
angle flange - max. profile	4 x 3/8	4 x 3/8	4 x 3/8	4 x 1/2	4 x 1/2	4 3/8 x 3/16
working height	35	35	35	35	35 3/8	35 3/8
<b>CORNER NOTCH (*)</b>						
maximum capacity	10 sq x 1/4	10 sq x 1/4	10 sq x 1/4	10 sq x 1/4	10 sq x 1/4	10 sq x 1/4
<b>TUBE NOTCH (*)</b>						
maximum outside diameter	3 1/4	3 1/4	3 1/4	4 1/4	4 1/4	6 1/2
<b>BENDING (*)</b>						
bar bend. max. capacity	10 x 1/2	10 x 1/2	10 x 5/8	10 x 3/4	10 x 7/8	10 x 1
sheet bend. max. capacity	24 x 1/4	24 x 1/4	24 x 1/4	24 x 1/4	24 x 1/4	27 x 1/4
<b>PUNCHING AT NOTCH STATION (*)</b>						
throat depth	5	5	5	5	5	5
maximum capacity	1 1/2 x 1/4	1 1/2 x 5/16	1 1/2 x 5/16	1 1/2 x 3/8	1 1/2 x 1/2	1 1/2 x 1/2
<b>TECHNICAL DATA</b>						
motorpower	7,5 Hp	7,5 Hp	10 Hp	10 Hp	10 Hp	15 Hp
nett weight - std. throat	3,462 lbs	3,572 lbs	4,245 lbs	5,358 lbs	6,836 lbs	12,238 lbs
gross weight - std. throat	3,737 lbs	3,837 lbs	4,619 lbs	5,821 lbs	7,431 lbs	13,164 lbs
machine dim. (LxWxH), cm	65 x 28 x 70	65 x 28 x 71	69 x 28 x 72	75 x 31 x 75	79 x 32 x 80	106 x 44 x 85
packed dim. (LxWxH), cm	69 x 34 x 77	69 x 34 x 78	75 x 34 x 79	81 x 37 x 82	85 x 37 x 87	112 x 50 x 95



for impressive  
performances

## the Kingsland range of hydraulic steelworkers

### 1 COMPACT 45

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



### 2 COMPACT 65

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



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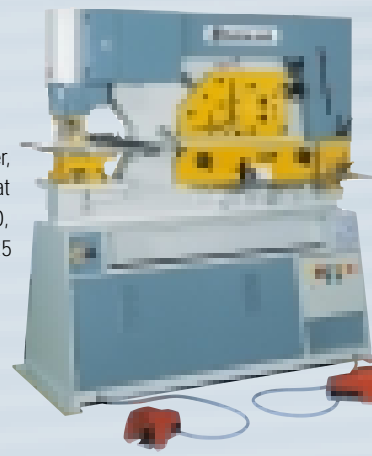
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### 3 MULTI 80

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



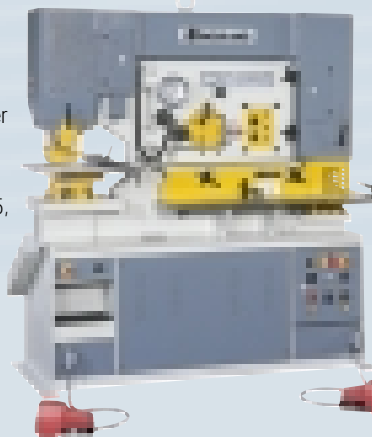
### 4 PUNCH 60

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



### 5 ULTIMA 85

- 5 stations
- double cylinder hydraulic steelworker
- available in 65, 85, 115 and 140 ton
- available with deep throat



### 6 125 D DOUBLE PUNCH

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

