

# BENDICROP SERIES



ENGLISH (mm)

**GEKA**   
The steel working company

## BENDICROP SERIES

Metalwork companies need to perform simple bending work. GEKA has designed the BENDICROP MODELS which, apart from including L, Ø, ▧, ▨, cutting stations, punching stations and trimming stations, include a permanent built-in bending station. They also have a system to reduce cutting deformation.



















Apart from the five usual punching shearing stations, BENDICROP SERIES have a permanent bending station, the only ones on the market.

The machines are therefore more complete than the conventional punching shearing machines as they can perform bending work via a simple and safe procedure.

# FEATURES

SHEARS FOR FLATBAR		Bendicrop 50	Bendicrop 60 S	Bendicrop 60 SD	Bendicrop 85 S	Bendicrop 85 SD
Shears of flatbar	mm	350x10 (5°) 350x15	350x10 (5°) 350x15	350x10 (5°) 350x15	450x15 (5°) 450x18	450x15 (5°) 450x18
Length of blade	mm	356	356	356	475	475
Cut of an L leg at 45°	mm	70	70	70	-	-
Working height	mm	865	859	859	920	920
SHEARS FOR SECTION IRON						
L at 90 °	mm	80 x 80 x 8	120 x 120 x 10	120 x 120 x 10	120 x 120 x 10	120 x 120 x 10
L at 45 °	mm	-	-	-	-	-
Round bar Ø	mm	35	45	45	45	45
Square bar □	mm	30	40	40	40	40
Working height	mm	1093	1078	1078	1141	1145
NOTCHING		RECTANGULAR	TRIANGULAR	TRIANGULAR	TRIANGULAR	TRIANGULAR
Plate thickness	mm	10	10	10	12	12
Angle of	mm	100	100	100	130	130
Depth	mm	90	-	-	-	-
Width	mm	42	-	-	-	-
Working height	mm	1025	1039	1039	1005	1005
PUNCHING						
Punching power	kN	500	600	600	850	850
Maximum capacity	mm	(B) Ø31 x 12 (A) Ø28 x 13	Ø40 x 11	Ø40 x 11	Ø40 x 15	Ø40 x 15
Throat	mm	177	250	500	300	500
Working height	mm	961	1106	1106	1094	1094
BENDING						
Maximum capacity	mm	100 x 10	150 x 10	150 x 10	200 x 12	200 x 12
Working height	mm	1300	1306	1306	1356	1360
GENERAL SPECIFICATIONS						
Motor	kW	3	5,5	5,5	9	9
N° strokes per minute		34 (stroke 15mm)	32 (stroke 15mm)	32 (stroke 15mm)	40 (stroke 20mm)	40 (stroke 20mm)
Net weight	kg	1000	1390	1750	2170	2400
Gross weight	kg	1200	1598	2012	2400	2760
Packaging dimensions	m	1,3 x 1,1 x 1,85	2,1 x 1,4 x 1,6	2,1 x 1,4 x 2,06	2,31 x 1,4 x 1,9	2,31 x 1,4 x 2,3
Volume of seaworthy package	m <sup>3</sup>	2,65	4,70	6,06	6,14	7,44
OPTIONAL EQUIPMENT						
SHEARS FOR SECTION IRON LJ and I section iron	mm	100	120	120	120	120
PIPE NOTCHING Maximum diameter	mm	60	60	60	60	60
PUNCHING LARGER DIAMETERS Maximum diameter	mm	Ø100 x 4	Ø100 x 5	Ø100 x 5	Ø100 x 6	Ø100 x 6

[A]. Spain, South America, Denmark, Australia, Saudi Arabia, África  
 [B]. Rest of the world.

STEEL PLATE 	CHANNELS 	DOUBLE WING CUT (one of which is at 45°) 	SHEARING 	SPOTTING 	PUNCHES 
FLAT BAR 	H CHANNEL 	90° CUT 	BENDING 	MARKING 	PUNCHES 
ANGLES 	45° CUT 	STEEL BAR CUTTING 	PUNCHING 	DRILLING 	PUNCHES 

# MAIN FEATURES

**1.-** One and two cylinders ironworkers with six work stations. Exclusive from Geka.

- Permanent bending station complying with CE standards.
- Punching
- Notching
- Shear for flat bars
- Angle cutting
- Cutting of round and square bars

**2.-** Blade holder's vertical movement that gives the machines an excellent performance.

**3.-** Fitted with an anti-torque system to reduce deformation when shearing flat bars. The BENDICROP models are fitted with a touch and cut length stop and is delivered with two V-shaped bending dies.

**4.-** Goose neck die-holder for punching of  $\square$  and  $\Gamma$  sections on legs and webs.

**5.-** Quick tool change.

**6.-** Angle shearing without loss of material. Wide range of openings for  $\emptyset$  and  $\sphericalangle$ .

**7.-** Flat bar and plate shearing system with minimum deformation  $\perp$  mitre shearing up to  $45^\circ$ .

**8.-** Rectangular and triangular notching with table. Also suitable for tube notching, rectangular notching, etc.

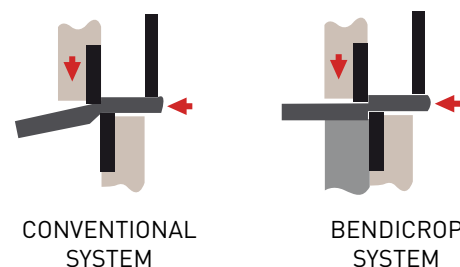
**9.-** Built-in Safety System: The punching guard is linked to a limit switch so that when this guard opens, the punch lowers without pressure during the first pedal interval and rises during the second interval. This makes centering between the die and punch easier and safer for the user



1 Permanent bending station is compliant with CE standards.



3 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.



3 Anti-torsion system for flat bar shearing without deformation



## Bendicrop 50 (1 cylinder)

The Bendicrop 50 model comes with:

- Electric stop.
- With 40 and 70 mm V bending dies.
- Rectangular notching with table.



- 4 Goose neck die-holder for punching of L and I sections on legs and webs. Quick tool change.



- 6 Angle shearing without loss of material.  
Wide range of openings for  $\emptyset$ ,  $\nabla$  and L  
 $\emptyset$ ,  $\nabla$  and L rim cutting station:  
Stations equipped with an assembly that acts  
as a hydraulic stop only in Bendicrop 85 SD.



- 8 Rectangular notching with table. Bendicrop 50



- Triangular notching with table. Bendicrop 60 & 85.

This station can also be used for tube notching.



## Bendicrop 60 (2 cylinders)

The Bendicrop 60 model comes with

- Electric stop.
- With 40 and 70 mm V bending dies.
- Triangular notching with table.

There are two different versions of this model:

- Bendicrop 60S (250mm throat)
- Bendicrop 60 SD (500mm throat).



## Bendicrop 85 (2 cylinders)

The Bendicrop 85 model comes with:

- Electric stop.
- With 50 and 90 mm V bending dies.
- Triangular notching with table.

There are two different versions of this model:

- Bendicrop 85S (300mm throat)
- Bendicrop 85SD (500mm throat) with 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.





## Flat bars cutting station

Shearing of flat bars up to 450x15 mm.

Guided table for flat shearing.

Adjustable gap between flat blades.

Automatic length stop included.

Anti-torque system for flat bar shearing without deformation.

Built in hydraulic hold down for the shearing station (Bendicrop 85SD)



## Angle cutting station

L cut up to 120x120x10 mm without any waste of material or bars.

Built in hydraulic hold down for the shearing station. (Bendicrop 85SD)

Angle shearing without loss of material.



## Bar shearing station

Fitted as standard with blades for cutting  $\varnothing$  and  $\nabla$  bars.

Wide range of openings for  $\varnothing$  and  $\nabla$ .



## Bending station

Permanent bending station is compliant with CE standards.



## Notching station

Rectangular notching with table (Bendicrop 50)

Triangular notching with table (Bendicrop 60S, 60SD, 85S and 85SD)

This station can also be used for tube notching, rectangular notching, etc.



## Punching station

Cylinder support.

Split double acting cylinder.

Limit switches for punch travel setting.

Generous travel for bending, deep-drawing, and forming jobs etc.

Adjustable generous non-turning guiding.

Additional guiding for damping of offset forces and protection of hydraulic seals.

Spindle for fitting of special tools.

Quick punch change.

Adjustable material stripper.

Table with millimetre scales, included in production package.

Adjustable measuring stop up to 500 mm.

Gooseneck die-holder for punching channel and section.

Adjustable bolster locking device X axis.

Adjustable bolster locking device Y axis.

Large fixing bolts for the base of the gooseneck punching die block.



## Electric cabinet

Manual selector switch / electrical limit switch.

"Inching" selector switch.

Easily removable cover to access hydraulic unit.

# GEKA GROUP

## Quality Know-how Service



### 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, Gamma Traction, Sigma110...



### Worldwide distribution network

With more than 60 distributors and present in more than 85 countries in 5 continents.



### All GEKA machines are special order

Every new GEKA machine is one of a kind. Our designers develop solutions suited to your specific needs. We manufacture each GEKA in our own facilities according to precisely defined standards.

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