

45 Ton

IRONWORKERS



**SINGLE
OPERATOR**
4 STATIONS

PORTA FAB 45

Capacities and Specifications

Rated On: A36 Mild Steel / 65,000 PSI Tensile

Punching Capacity	45 ton (41 mt) 1-1/8" in 1/2" (28 mm in 12 mm)
Special Tooling	2-1/4" (57 mm) Max. Dia.
Throat Depth	4-1/4" (108 mm)
Flat Bar Shear	6" Length (152 mm) 1/2" x 4" (12 x 102 mm) 3/8" x 6" (10 x 152 mm)
Angle Shear 90°	3" x 3" x 5/16" (76 x 76 x 8 mm)
Angle Shear 45°	2" x 2" x 1/4" (51 x 51 x 6 mm)
Round Rod Shear	3/4" (19 mm)
Brake 8"	25 ton (23 mt)
Brake 12"	20 ton (18 mt)
Open End Brake	Max. 1/4" x 3" (6 x 76 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 1-3/4" x 1/4" (51 x 44 x 6 mm)
90° V-Notcher	6" x 6" x 1/8" (152 x 152 x 3 mm)
Rod Shear Round (max.)	5 Cavity, 1/4" to 1" (6 mm to 25 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 3/4" (6 mm to 19 mm)
Unistrut Shear	Samples Required
Square Tube Shear	1/2" to 1" (12 mm to 25 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Strokes per minute in light material	10 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	4 spm (3/4" stroke) [Punch Station]
Hydraulics	2,500 psi (172 bar)
Motor Options (must specify)	2 hp 110 v 2 hp 1 ph (1.49 kW) 220 v
Dimensions	L-38-1/4" (97 cm) W-20" (51 cm) H-39-1/4" (100 cm) H w/base-56-3/4" (144 cm)
Shipping Weight (may vary)	710 lbs. (322 kg)

STANDARD FEATURES

- 45 ton punch station
- Keyed punch ram for safety
- 2" die holder
- Punch nut with wrench and stripper
- One round punch & die: max. diameter 1"
- Electric remote foot pedal
- Adjustable electric stroke control with scale
- Three-in-one combination tool:
Angle shear, Bar shear, and Rod shear
- Tool table work area
- Slug receptacle
- Machine stand with punch & die & tooling storage rack
- 110 volt electrics
- Complies with ANSI B 11.5 safety standards
- Three-year warranty on parts
- Made in USA

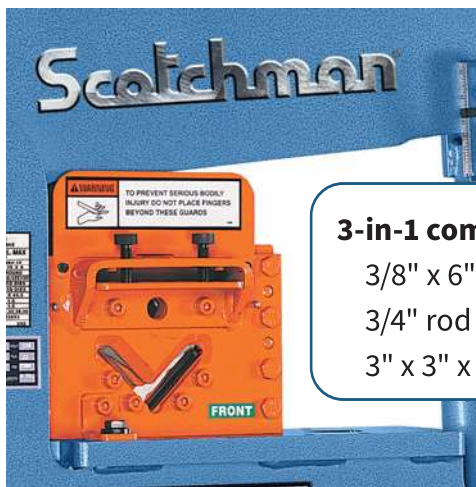


45 Ton

**It's portable, versatile, and designed for in-plant or on-the-job operation;
a perfect choice for the fabricator on-the-go!**

With 45-ton punching capacity, this ironworker can punch 1-1/8" hole through 1/2" mild steel and runs on 110-volt power from your standard wall outlet or generator. A 3-in-1 combination tool comes standard and is located in our unique tool table area. This versatile workstation allows additional tooling to be easily swapped in and out so you can customize the machine to fit your needs.

IRONWORKERS

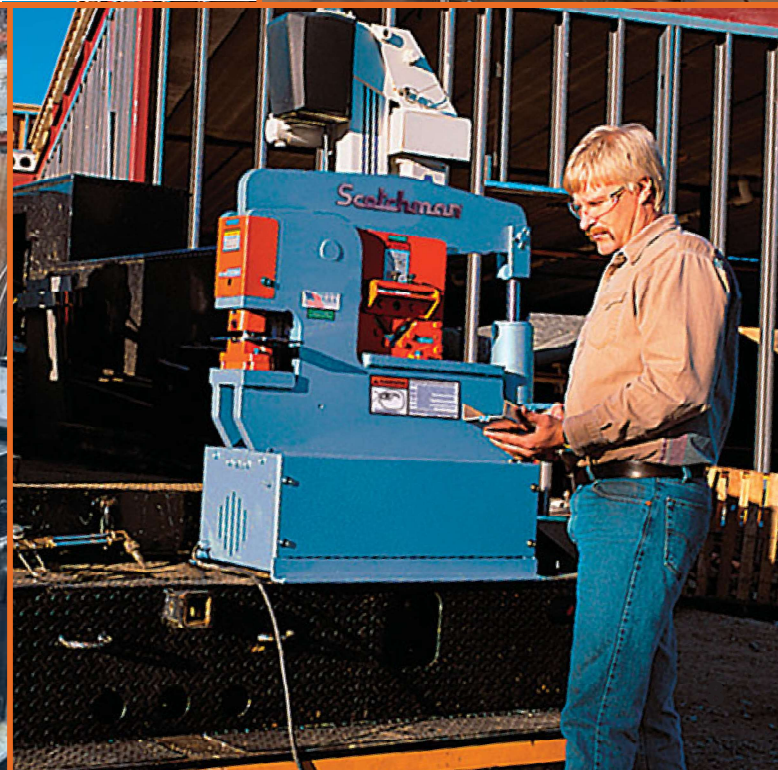


3-in-1 combination tool:

3/8" x 6" flat bar shear

3/4" rod shear

3" x 3" x 5/16" angle shear



Ironworker *Optional Tooling*

		PF 45	50514-EC	5014-ET	6509	DO70	DO85	FI85	9012	DO95	12012	DO120	DO135	DO150
A	6" Brake	•	•	•										
B	8" Brake	•	•	•										
C	12" Brake	•	•	•	•	•	•	•	•	•	•	•	•	•
D	24" Brake				•	•	•	•	•	•	•	•	•	•
E	Open End Brake	•	•	•	•	•	•	•	•	•	•	•	•	•
F	Pipe Notcher	•	•	•	•	•	•	•	•	•	•	•	•	•
G	Rectangle Notcher	•			•				•		•			
H	90° V-Notcher	•	•	•	•	•	•	•	•	•	•	•	•	•
I	Square Tube Shear	•	•	•	•	•	•	•	•	•	•	•	•	•
J	Rod Shear	•	•	•	•	•			•	•	•	•	•	•
K	Unistrut Shear	•	•	•	•	•	•	•	•	•	•	•	•	•
L	Weld Coupon Bender	•	•	•	•	•	•	•	•	•	•	•	•	•
M	Picket Tool	•	•	•	•	•	•	•	•	•	•	•	•	•
N	Channel Shear				•	•		•	•	•	•	•	•	•
O	Channel Shear Blades						•							
P	6"x 6" Die Holder				•	•	•	•	•	•	•	•	•	•
Q	Offset Die Holder				•	•	•	•	•	•	•	•	•	•
R	Urethane Stripper				•	•	•	•	•	•	•	•	•	•
S	Hydraulic Hold Down				•			•	•		•	•	•	•
T	4" Angle Iron Miter Guide		•	•										
U	6" Angle Iron Miter Guide				•	•			•	•	•	•	•	•
V	Optional Punch for Notcher End						•							
W	Open End Brake for Notcher End						•							
X	30" Material Stop	•												
Y	48" Back Gauge		•	•	•	•	•	•	•	•	•	•	•	•
Z	Brake Table w/ scale & squaring arm 12"	•	•	•	•	•	•	•	•	•	•	•	•	•
Z	Brake Table w/ scale & squaring arm 24"				•	•	•	•	•	•	•	•	•	•
Z	Brake Length Gauge w/ scale 8"	•	•	•										
Z	Brake Length Gauge w/ scale 12"	•	•	•	•	•			•	•	•	•	•	•
Z	Brake Length Gauge w/ scale 24"				•	•			•	•	•	•	•	•
AA	Shear Table w/ Miter Fence		•	•										
BB	Punch Gauging Table w/ Fence & Scale		•	•										
CC	Unequal Leg Blades for Angle Shear				•	•			•	•	•	•	•	•
DD	Multi-Loc Punch Gauging Extension: 36" & 85"				•	•	•	•	•	•	•	•	•	•
EE	Punch Table Extension				•	•	•	•	•	•	•	•	•	•
FF	Tool table extension with punch & die drawer		•	•	•	•			•	•	•	•	•	•
GG	Laser Light (Shear)		•	•	•	•		•	•	•	•	•	•	•
HH	LED Lights	• (P)	• (P, S, N)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)	• (P&S)
II	Jog Control		•	•										
JJ	24" x 5' Conveyor w/ angle iron support		•	•	•	•	•	•	•	•	•	•	•	•

• Punch • Punch & Shear • Punch, Shear & Notch

Ironworker *Optional Tooling*



6" Brake (A)



8" Brake (B)



12" Brake (C)



24" Brake (D)



Brake Options (Z)
(sold separately)



Open End Brake (E)



Pipe Notcher (F)



Rectangle
Notcher (G)



90° V-Notcher (H)



Square Tube
Shear (I)



Rod Shear
(J)



Unistrut
Shear (K)



Weld Coupon
Bender (L)



Picket Tool (M)



Channel Shear (N)



Channel Shear
Blades (O)
(DO85 only)



6" x 6" Die
Holder (P)



Offset Die
Holder (Q)



Urethane
Stripper (R)



Hydraulic Hold
Down (S)



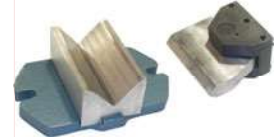
4" Angle Iron
Miter Guide (T)



6" Angle Iron
Miter Guide (U)



Optional Punch
for Notcher End (V)
(DO85 only)



Open End Brake
for Notcher End (W)
(DO85 only)



30" Material Stop (X)



48" Back Gauge (Y)



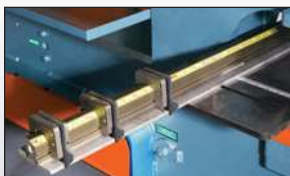
Shear Table
w/ Miter Fence (AA)



Punch Gauging Table
w/ Fence & Scale (BB)



Unequal Leg Blades
for Angle Shear (CC)
66°, 70°, 74°, or 80°



Multi-Loc Punch Gauging
Extension: 36" & 85" (DD)



Punch Table
Extension (EE)



Tool table extension
with punch & die
drawer (FF)



Laser Light (GG)



LED Lights (HH)



Jog Control (II)



24" x 5' conveyor
with angle iron support (JJ)
← (attached to DO 70)
(attached to 5014-ET) →

