

50 Ton

IRONWORKERS



SINGLE OPERATOR
5 STATIONS

50514-EC

Single punch station



SINGLE OPERATOR
7 STATIONS

5014-ET

3-station revolving turret punch

STANDARD FEATURES

- 50 ton punch station
- 2" die holder (per punch station)
- Punch nut & stripper (per punch station)
- One round punch & die: max. diameter 1"
- Keyed punch ram for safety
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Angle shear
- Flat bar shear with 4-way reversible blade
- Rectangle notcher
- Tool table work area
- Slug receptacle
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

50514-EC

5014-ET

Capacities and Specifications		
Rated On: A36 Mild Steel / 65,000 PSI Tensile		
Punching Capacity	50 ton (45 mt) 1-1/4" in 1/2" (32 mm in 12 mm) 13/16" in 3/4" (20 mm in 19 mm)	50 ton (45 mt) 1-1/4" in 1/2" (32 mm in 12 mm) 13/16" in 3/4" (20 mm in 19 mm)
Special Tooling	2-1/4" (57 mm) Max. Dia.	2-1/4" (57 mm) Max. Dia.
Throat Depth	6" (152 mm)	4" (102 mm)
Flat Bar Shear	14" Length (356 mm) 3/4" x 4" (19 x 102 mm) 1/2" x 8" (12 x 203 mm) 3/8" x 10" (10 x 254 mm) 1/4" x 14" (6 x 356 mm)	14" Length (356 mm) 3/4" x 4" (19 x 102 mm) 1/2" x 8" (12 x 203 mm) 3/8" x 10" (10 x 254 mm) 1/4" x 14" (6 x 356 mm)
Opt. Sabre Blade	1/2" x 10" (12 x 254 mm) 3/8" x 12" (10 x 305 mm)	1/2" x 10" (12 x 254 mm) 3/8" x 12" (10 x 305 mm)
Angle Shear 90°	4" x 4" x 3/8" (102 x 102 x 10 mm)	4" x 4" x 3/8" (102 x 102 x 10 mm)
Angle Shear 45°	2" x 2" x 1/4" (51 x 51 x 6 mm)	2" x 2" x 1/4" (51 x 51 x 6 mm)
Brake 8"	30 ton (27 mt)	25 ton (23 mt)
Brake 12"	25 ton (23 mt)	25 ton (23 mt)
Open End Brake	Max. 1/4" x 3" (6 x 76 mm) [Flat or Angle Iron]	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"	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2-1/2" x 3" x 5/16" (63 x 76 x 8 mm) 2-1/2" x 2-3/4" x 3/8" (63 x 70 x 10 mm)	2-1/2" x 3" x 5/16" (63 x 76 x 8 mm) 2-1/2" x 2-3/4" x 3/8" (63 x 70 x 10 mm)
90° V-Notcher	6" x 6" x 1/8" (152 x 152 x 3 mm) 3" x 3" x 1/4" (76 x 76 x 6 mm)	6" x 6" x 1/8" (152 x 152 x 3 mm) 3" x 3" x 1/4" (76 x 76 x 6 mm)
Unistrut Shear	Samples Required	Samples Required
Rod Shear Round (max.)	5 Cavity, 1/4" to 1" (6 mm to 25 mm)	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)	1 Cavity, 1/4" to 3/4" (6 mm to 19 mm)
Square Tube Shear	1/2" to 1" (12 mm to 25 mm) 12 gauge (0.105" / 2.7 mm)	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)	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)	2" wide x 3/8" (51 mm x 10 mm)
Strokes per minute in light material	34 spm (1/4" stroke) [Punch Station]	34 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	14 spm (3/4" stroke) [Punch Station]	14 spm (3/4" stroke) [Punch Station]
Hydraulics	2,350 psi (162 bar)	2,350 psi (162 bar)
Motor Options (must specify)	3 hp 3 ph (2.24 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v	3 hp 3 ph (2.24 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v
Dimensions	L-48-1/4" (122.5 cm) W-23-1/2" (60 cm) H-63-3/4" (161 cm)	L-48-1/4" (122.5 cm) W-23-1/2" (60 cm) H-70-1/4" (178.5 cm)
Shipping Weight (may vary)	1,580 lbs. (717 kg)	1,640 lbs. (744 kg)



Ironworker *Optional Tooling*

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		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*

IRONWORKERS



6" Brake (A)



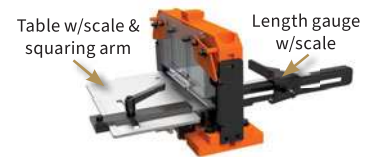
8" Brake (B)



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)



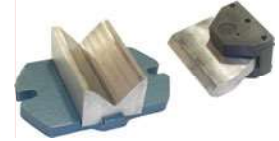
4" Angle Iron Miter Guide (T)



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)



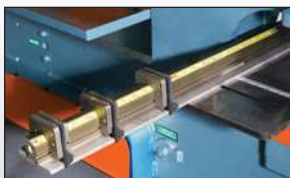
Shear Table w/ Miter Fence (AA)



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) →

