

HYDRAULIC IRONWORKERS & PUNCHING MACHINES



QUALITY | VERSATILITY | DEPENDABILITY

INTRODUCTION

With a highly dedicated team, Sunrise Fluid Power Inc. has been specializing in the manufacturing of hydraulic ironworkers, punching machines, bending machines, and other hydraulic machinery and equipment for more than 30 years. Total customer satisfaction is our number one goal. We are passionate about providing engineering excellence in everything we do, and we are dedicated to manufacturing world-class, high-value products for our global customers.

Product Differentiation

Sunrise is ISO-9001 certified by BVQI, and our products meet the CE safety requirements and regulations. We relentlessly seek continuous improvement and product development. Currently Sunrise has the broadest range of ironworker and punching machine models compared to any other manufacturer. Sunrise product advantages: Durability, Accuracy, and Versatility. Besides our very popular single and dual operator models, we have introduced the K-series, a new line of ironworker with vertical movement at all stations. The center beam in the entire range of K-series moves in straight up and down motion to provide less deformation, better results and longer tooling life.

Quality Control

Quality of the highest standard is the key factor in success. All key components of our ironworkers, punching machines, etc. are made in-house at our modern plant and automated production lines. We use the latest control system to ensure highly efficient production, and the quality assurance team measures and tests each component to ensure precision standards of machined parts are met or surpassed. Finally, before shipping, each complete machine goes through intensive quality and performance tests to make absolute sure it meets our strict company quality standards before it arrives at the customer's operation.

Sales and Service

Our global sales network covers almost 50 countries in Europe, Australia, North America, Southeast Asia, the Middle East and more. This coverage, combined with the quality of our machines, makes Sunrise one of the best choices when it comes to metal forming. In this highly competitive international market, Sunrise's market share continues to grow. Thank you to our many and growing list of satisfied customers for your continued support. Sunrise is now one of the leading brands in the fabricating industry. We look forward to your continued support and comments -- together we will push quality at Sunrise ever higher.

Sunrise Hydraulic Ironworkers are designed with multiple functions to save labor, time, energy and cost. This allows Sunrise Ironworkers to meet the diversified needs of the metal fabricating industry.

Maximum efficiency and long life is guaranteed by using the latest manufacturing methods, including powerful CAD design, modern production line with CNC equipment and continuous quality control.

Each work station is equipped with specially designed hold-downs to ensure safety while providing precision and ease of use. These ironworkers are the most economical and efficient machines in the industry for the manufacturing of metal products.

All Sunrise ironworkers and punching machines come standard with a low pressure tool alignment mode. The operator can use the JOG mode to run the machine in low pressure and low speed for tool alignment, blade changes and maintenance operations. This greatly improves operator safety and prevents tool damage in case of mis-alignment.

Key features on the dual cylinder models:

The dual cylinder models feature a separate cylinder for independent operation from shearing stations.

Cylinder ram with flat surface for rigid guiding and to ensure proper alignment of tool.

Keyed punch ram to ensure alignment of shaped tooling.



The cylinder ram is guided at three positions to provide extra support and absorb side-load forces for added protection of cylinder seals.



The punching station features a large cylinder mounting plate to ensure maximum cylinder support under heavy load. The punching base is one solid plate with T-slot grooves for universal tool fixture.

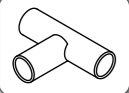
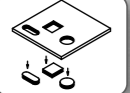
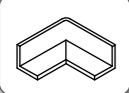
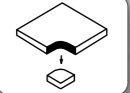
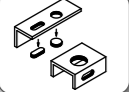
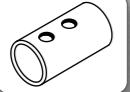
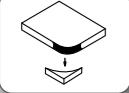
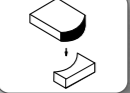
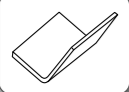
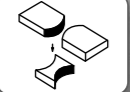


The base of the machine is made from welded channel in a grid pattern for a rigid machine foundation.

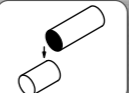
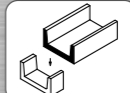
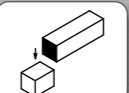
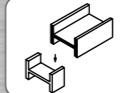
The frame of the machine is a monoblock construction that integrates both bolts and welding reinforcement to provide maximum frame structure rigidity.

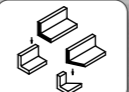
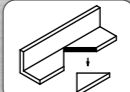


FEATURES

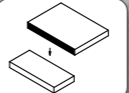
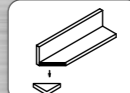
HYDRAULIC IRONWORKERS & PUNCHING MACHINES

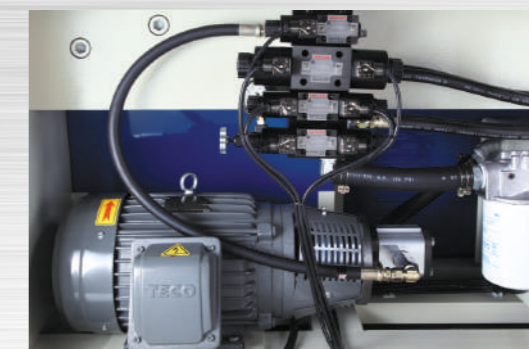
| | |
|---|---|
|  |  |
| *Pipe Notching | Punching |
|  |  |
| *Angle Bending | *Radius Corners |
|  |  |
| Punching | *Pipe Punching |
|  |  |
| *Rounding off Corners | *Cutting and Rounding off |
|  |  |
| *Press Brake | *Bilateral Rounding off |



| | |
|---|---|
|  |  |
| Round Bar Shear | *Channel Shear |
|  |  |
| Square Bar Shear | *I Beam Shear |

| | | | |
|---|---|---|---|
|  |  |  |  |
| Angle Shear | *Vee Notching | Notching | Notching |

| | |
|---|---|
|  |  |
| Flat Bar Shear | Angle Miter Shear |



The use of name-brand hydraulic components ensure excellent reliability of the hydraulic system.



Electric cabinet with low 24 volt DC control circuit provides full protection and safety.

IW-185SD



New! 'Best in the Business' Warranty!

* : Optional tooling

WORK STATIONS

Punching Station

- A full range of punches and dies are available for various punching needs.
- Quick change retaining nut system for fast punch tooling change.
- Thoughtfully designed stripper for visibility, safety and ease of use.
- A large 2-piece table with scales and gauging stops is standard on all models.
- Stripper with interchangeable plates of various openings to minimize deformation is standard on all models.
- Optional hydraulic stripper is available on dual-cylinder ironworkers and all punching machines.



*11 sets round punches and dies included.



*Standard dual-opening die block for up to 2" round punch and die.



Overhang die holder for punching channel flanges and angles. (optional on single cylinder models)



*Goose-neck die holder for punching channel flanges and webs.



*Urethane spring stripper for minimal deformation. Safety cover removed for showing.



*Pipe notcher.



*Flip-stop gauge table. 1-3M lengths. (S/SD/KD and PM models only)



*Single vee press brake.



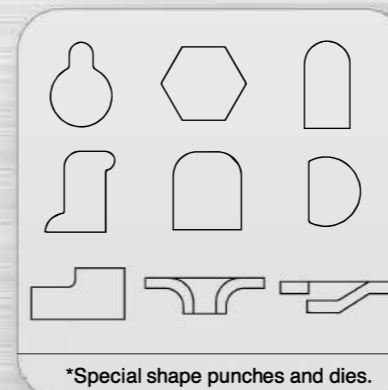
*Multi vee press brake.



*Large vee-notcher. (Punch side)



*Angle bending press.



*Special shape punches and dies.

*Optional Semi-Automatic CNC Tables with 40" x 16" travel.

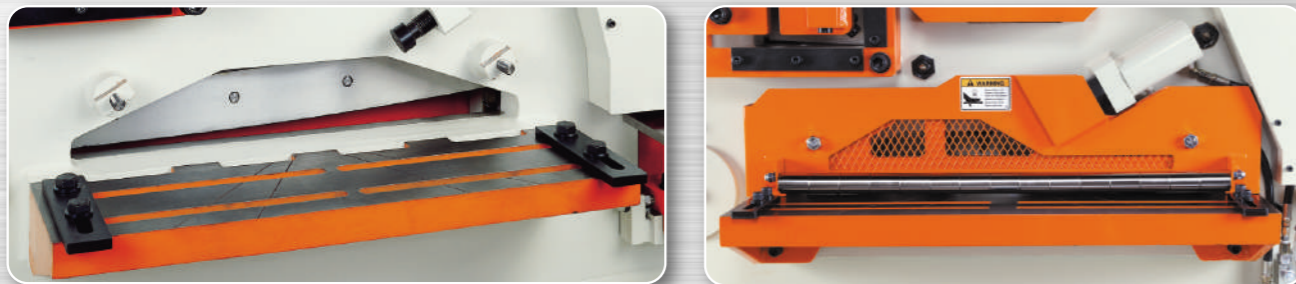


* : Optional tooling

WORK STATIONS

Flat Bar Shearing Station

- Specially machined upper blade to give a clean shear with minimum distortion.
- Lower blade has four usable cutting edges.
- Variable degree miter-cutting on angle flange.
- Easily adjustable hold-down.
- Support table with guides for accurate positioning.



*Optional hydraulic hold-down for double cylinder ironworkers. (Standard on IW-185SD)

Angle Shearing Station

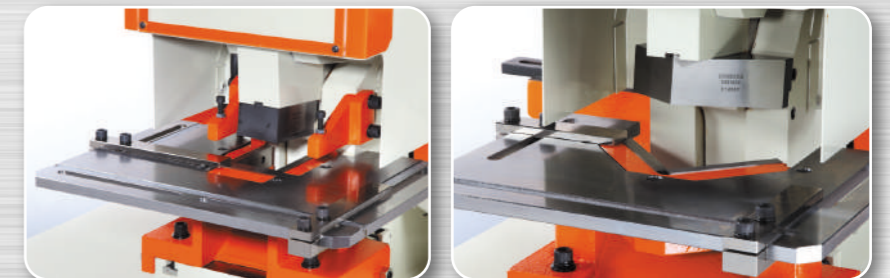
- Single shear with no material loss and minimal deformation.
- 45° miter-cut is easy and clean.
- Stationary blades with four usable cutting edges.
- Selectable corner radii on moving blades for optimum results on small or large angles.



*Optional hydraulic hold-down for angle shear.

Notching Station

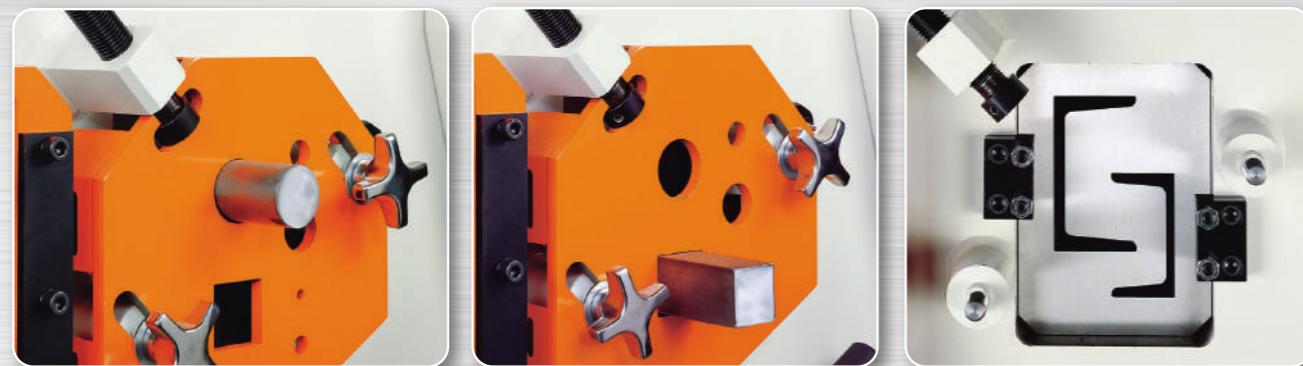
- Ideal for notching of flat bars and angles.
- Electrically interlocked safety guard for maximum safety and visibility.
- Gauging table included with stops for precise positioning.



*Optional.

Bar Shearing Station

- One hold-down for various sizes of square bar shearing and round bar shearing.
- Optional channel and section bar shear tooling is available for most models. (See specification chart for details)



*Channel blades. (optional)

Other Included Features

1. Three limit switches enable setting of short notch stroke to improve efficiency. (on S/SD models)
2. Magnetic base LED work light for safer operation. (optional on IW-50M)
3. 40" electric backgauge for higher efficiency in repetitious work. The gauge extension is available depending on request.

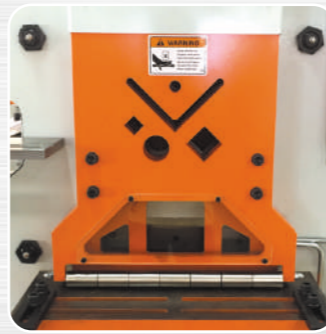


*Optional on IW-50M.

K SERIES

K - SERIES IRONWORKERS

The K-series are special designed compact ironworkers with vertical movements at all stations. The entire main slide moves in straight up and down motion to provide the optimum results for punching, shearing, notching, and bending. Hydraulic hold-down and urethane spring stripper are also available for the best performance. The fast cylinder stroke greatly improves the efficiency. This model incorporates versatility, efficiency, accuracy, and ease of use at an excellent price.



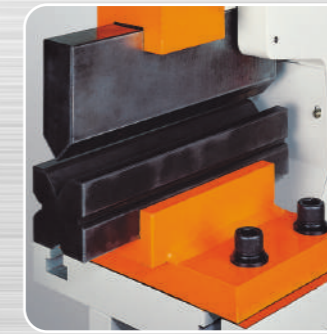
Hydraulic hold-down.
(optional on IW-50K)



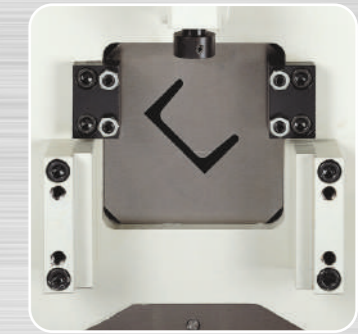
*Single vee press brake.



*Urethane spring stripper.
Safety cover removed for showing.



*Multi vee press brake.



*Channel Shear.



IW-50K



IW-66K



IW-66KB



IW-95KD

K - SERIES IRONWORKERS

Capacities and Specifications

Unit: inch

| MODEL | IW-50K | IW-66K | IW-66KB | IW-95KD |
|--|---|---|---|--|
| PUNCHING | | | | |
| Punching Pressure | 50 Ton | 66 Ton | 66 Ton | 95 Ton |
| Punch Capacity (Diameter x Thickness) | $\varnothing^{3/4} \times 5/8$ $\varnothing^{1 1/2} \times 5/16$ | $\varnothing^{7/8} \times 3/4$ $\varnothing^{1 1/2} \times 7/16$ | $\varnothing^{7/8} \times 3/4$ $\varnothing^{1 1/2} \times 7/16$ | $\varnothing 1 \times 7/8$ $\varnothing 2 \times 1/2$ |
| Throat Depth | 6 1/2 | 7 7/8 | 7 7/8 | 16 1/8 |
| Maximum Stroke Length | 1 1/8 | 1 1/2 | 1 1/2 | 4 |
| Cycles / Min. (1/2" stroke) | 37 | 34 | 34 | 38 |
| Working Height Up to Die | 41 1/2 | 41 1/4 | 41 1/4 | 41 1/4 |
| ANGLE SHEARING | | | | |
| Shearing Capacity | 50 Ton | 66 Ton | 66 Ton | 120 Ton |
| Shearing Cylinder Stroke Length | -- | -- | -- | 2 |
| At 90° Shearing | 3 x 3 x 1/4 | 4 x 4 x 5/16 | 4 x 4 x 5/16 | 5 x 5 x 1/2 |
| Working Height | 39 1/2 | 42 | 42 | 41 |
| FLAT SHEARING | | | | |
| Flat Bar Shear (Width x Thickness) | 12 x 3/8 | 14 x 5/8 | 14 x 9/16 | 16 x 5/8 |
| Blade Length | 12 1/4 | 14 1/4 | 14 1/4 | 16 1/8 |
| Working Height | 31 1/2 | 31 3/4 | 31 3/4 | 28 1/2 |
| BAR SHEARING | | | | |
| Round Bar Shear | $\varnothing 1 1/8$ | $\varnothing 1 1/2$ | $\varnothing 1 1/2$ | $\varnothing 1 3/4$ |
| Square Bar Shear | 1 x 1 | 1 1/2 x 1 1/2 | 1 1/2 x 1 1/2 | 1 3/4 x 1 3/4 |
| Channel Shear | 3* | 4* | 4* | 6* |
| I Beam Shear | -- | -- | -- | 6* |
| NOTCHING | | | | |
| Rectangular Notcher (W x D x T) | 2 x 3 1/2 x 1/4 | 2 x 3 1/2 x 5/16 | -- | 2 1/2 x 3 1/2 x 1/2 |
| Vee-Notcher (Side x Side x T) | 3 1/2 x 3 1/2 x 5/16* | 3 1/2 x 3 1/2 x 5/16* | -- | 4 x 4 x 1/2* |
| Channel Notching | -- | -- | -- | 7~8 |
| Working Height | 41 1/4 | 41 1/4 | -- | 41 1/4 |
| SPECIAL TOOLING | | | | |
| Large Vee-Notcher (Side x Side x T) | -- | -- | -- | 5 3/4 x 5 3/4 x 3/8* |
| Single Vee Press Brake (W x T) | 6 x 5/16* | 6 x 5/16* | -- | 10 x 9/16* |
| Multi Vee Press Brake (W x T) | 10 x 1/8* | 10 x 1/4* | 12 x 1/4** | 20 x 3/16* |
| Angle Bending | 2 1/2 x 5/16* | 2 1/2 x 5/16* | 2 1/2 x 5/16* | 4 x 5/16* |
| Pipe Notching | $\varnothing 2^*$ | $\varnothing 2^*$ | $\varnothing 2^*$ | $\varnothing 4^*$ |
| OTHER | | | | |
| Electric Power (HP) | 5 HP | 7.5 HP | 7.5 HP | 10 HP |
| Net Weight (Apr.) | 1875 lb | 2625 lb | 2830 lb | 6075 lb |
| Gross Weight (Apr.) | 2100 lb | 2925 lb | 3160 lb | 6400 lb |
| Machine Dimension (Apr.) | 41 x 30 x 59 | 47 x 30 x 64 | 54 x 30 x 64 | 71 x 41 x 74 |
| Packing Dimension (Apr.) | 52 x 37 x 70 | 57 x 36 x 75 | 67 x 35 x 76 | 85 x 47 x 86 |

* : Optional Tooling

** : The multi-vee press brake is a standard station on the IW-66KB; notcher is not included.

Note: Based on low carbon / mild steel material strength of 65,000 PSI tensile.
Design and specifications subject to change without notice.

SINGLE CYLINDER

Single Cylinder Model

Capacities and Specifications

Unit: inch

| MODEL | IW-50M |
|--|---|
| PUNCHING | |
| Punching Pressure | 50 Ton |
| Punch Capacity (Diameter x Thickness) | $\varnothing^{3/4} \times 5/8$ $\varnothing^{1 1/2} \times 5/16$ |
| Throat Depth | 7 |
| Maximum Stroke Length | 1 3/8 |
| Cycles / Min. (1/2" stroke) | 31 |
| Working Height Up to Die | 38 1/4 |
| ANGLE SHEARING | |
| At 90° Shearing | 3 x 3 x 1/4 |
| At 45° Miter Shearing | 2 x 2 x 1/4 |
| Working Height | 44 |
| FLAT SHEARING | |
| Flat Bar Shear (Width x Thickness) | 14 x 5/16 7 x 1/2 |
| Blade Length | 14 1/4 |
| Angle Flange Trim | 3 |
| Working Height | 38 1/4 |
| BAR SHEARING | |
| Round Bar Shear | $\varnothing 1$ |
| Square Bar Shear | 1 x 1 |
| Working Height | 47 |
| OTHER | |
| Electric Power (HP) | 5 HP |
| Net Weight (Apr.) | 1850 lb |
| Gross Weight (Apr.) | 2075 lb |
| Machine Dimension (Apr.)(LxWxH) | 50 x 28 x 53 |
| Packing Dimension (Apr.)(LxWxH) | 61 x 34 x 64 |

Note: Based on mild steel material strength of 65,000 PSI tensile.
Design and specifications subject to change without notice.
A 1-hole die holder and a 2-piece gauging table are provided as standard equipment on all single cylinder models.

IW-50M

The IW-50M has four standard stations, capable of a wide range of applications. The punching station can be converted into a notching station. IW-50M is heavier and stronger than other competitive machines. This durable and economical model is perfect for small shops with a limited budget.



IW-50M

S/SD SERIES

Double Cylinder Models

The double cylinder "S/SD" series are in the Sunrise tradition of well engineered ironworkers built for high power, quality, and reliability. These ironworkers have two control foot pedals, and separate operations can be safely performed simultaneously. The low pressure setting for tool change provides maximum operation safety. The long punching cylinder stroke and deep throat enable mounting a wide range of special equipment. The large punching base with the "T-slot" mounting provides a solid base for securing the punching tooling, as well as a wide range of optional and custom designed tooling.



IW-110SD

Capacities and Specifications

Unit: inch

| MODEL | IW-66S IW-66SD | IW-88S IW-88SD | IW-110S IW-110SD | IW-135S IW-135SD | IW-185SD |
|--|-------------------------------------|------------------------------|-------------------------------|--------------------------------|-----------------------------|
| PUNCHING | | | | | |
| Punching Pressure | 66 Ton | 88 Ton | 110 Ton | 135 Ton | 180 Ton |
| Punch Capacity (Diameter x Thickness) | ø7/8 x 3/4 ø2 x 5/16 | ø1 x 7/8 ø2 x 1/2 | ø1 1/8 x 1 ø2 x 9/16 | ø1 1/4 x 1 1/16 ø2 x 1 1/16 | ø1 7/16 x 1 1/4 ø2 x 7/8 |
| Throat Depth | S: 12 SD: 20 | 12 20 | 12 20 | 12 20 | --- 20 |
| Maximum Stroke Length | 4 | 4 | 4 | 4 | 4 |
| Cycles / Min. (3/4" stroke) | 30 | 29 | 28 | 28 | 29 |
| Working Height Up to Die | 39 3/4 | 41 1/4 | 41 | 42 | 41 1/4 |
| ANGLE SHEARING | | | | | |
| At 90 ° Shearing | 5 x 5 x 1/2 | 6 x 6 x 1/2 | 6 x 6 x 9/16 | 6 x 6 x 11/16 | 8 x 8 x 3/4 |
| At 45° Miter Shearing | 2 1/2 x 2 1/2 x 5/16 | 3 x 3 x 3/8 | 3 x 3 x 3/8 | 3 x 3 x 3/8 | 3 x 3 x 3/8 |
| Working Height | 43 3/4 | 45 3/4 | 47 7/8 | 46 1/2 | 46 1/2 |
| FLAT SHEARING | | | | | |
| Flat Bar Shear (Width x Thickness) | 14 x 9/16 10 x 3/4 | 18 x 9/16 12 x 7/8 | 24 x 5/8 16 x 3/4 | 24 x 11/16 16 x 1 | 30 x 3/4 16 x 1 1/8 |
| Blade Length | 14 1/4 | 18 1/4 | 24 3/8 | 24 3/8 | 30 1/4 |
| Angle Flange Trim | 4 | 4 | 4 | 4 | 4 3/4 |
| Working Height | 36 | 36 1/2 | 37 1/2 | 36 | 36 |
| BAR SHEARING | | | | | |
| Round Bar Shear | ø1 1/2 | ø1 3/4 | ø1 3/4 | ø2 | ø2 1/4 |
| Square Bar Shear | 1 1/2 x 1 1/2 | 1 3/4 x 1 3/4 | 1 3/4 x 1 3/4 | 2 x 2 | 2 1/4 x 2 1/4 |
| Channel Shear | 5* | 6* | 6* | 7* | 8* |
| I Beam Shear | -- | 6* | 6* | 7* | 8* |
| Working Height | 48 | 50 | 52 1/2 | 51 1/2 | 54 |
| NOTCHING | | | | | |
| Rectangular Notcher (W x D x T) | 2 x 3 1/2 x 3/8 | 2 x 3 1/2 x 1/2 | 2 1/2 x 3 1/2 x 1/2 | 2 1/2 x 3 1/2 x 1/2 | 2 1/2 x 3 1/2 x 5/8 |
| Vee-Notcher (Side x Side x T) | 3 1/2 x 3 1/2 x 3/8* | 3 1/2 x 3 1/2 x 1/2* | 4 x 4 x 1/2* | 4 x 4 x 1/2* | 4 x 4 x 5/8* |
| Working Height | 35 3/4 | 36 1/2 | 37 1/2 | 36 1/4 | 36 1/4 |
| SPECIAL TOOLING | | | | | |
| Large Vee-Notcher (Side x Side x T) | 5 3/4 x 5 3/4 x 5/16* | 5 3/4 x 5 3/4 x 3/8* | 5 3/4 x 5 3/4 x 1/2* | 5 3/4 x 5 3/4 x 1/2* | 5 3/4 x 5 3/4 x 1/2* |
| Single Vee Press Brake (W x T) | 10 x 1/2* | 10 x 1/2* | 10 x 9/16* | 10 x 3/4* | 10 x 3/4* |
| Multi Vee Press Brake (W x T) | 20 x 3/16* | 20 x 3/16* | 27 1/2 x 3/16* | 27 1/2 x 3/16* | 27 1/2 x 3/16* |
| Angle Bending | 4 x 1/4* | 4 x 1/4* | 4 x 1/2* | 4 x 1/2* | 4 x 1/2* |
| Pipe Notching | ø4* | ø4* | ø4* | ø4* | ø4* |
| OTHER | | | | | |
| Electric Power (HP) | 7.5 HP | 10 HP | 10 HP | 15 HP | 20 HP |
| Net Weight (Apr.) | S: 3975 lb SD: 4875 lb | 4825 lb 5850 lb | 6525 lb 7625 lb | 7375 lb 8725 lb | --- 10925 lb |
| Gross Weight (Apr.) | S: 4300 lb SD: 5250 lb | 5210 lb 6360 lb | 7025 lb 8175 lb | 7925 lb 9325 lb | --- 11600 lb |
| Machine Dimension (Apr.) | S: 67 x 32 x 68 SD: 82 x 32 x 68 | 73 x 33 x 70 87 x 33 x 70 | 83 x 34 x 72 97 x 34 x 72 | 86 x 41 x 73 98 x 41 x 73 | --- 107 x 43 x 80 |
| Packing Dimension (Apr.) | S: 78 x 38 x 79 SD: 93 x 38 x 79 | 83 x 39 x 81 98 x 39 x 81 | 94 x 40 x 83 108 x 40 x 83 | 97 x 47 x 84 109 x 47 x 84 | --- 118 x 49 x 91 |

* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 65,000 PSI tensile.

Design and specifications subject to change without notice.

A 2-hole overhung die holder and a 2-piece gauging table are provided as standard equipment on all dual cylinder ironworkers.

PM SERIES

Hydraulic Punching Machine

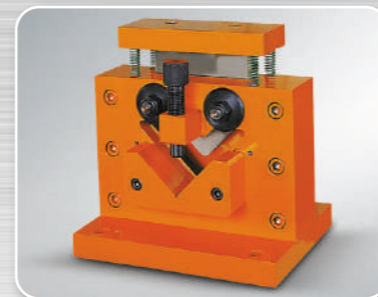
- The patented dual-piston hydraulic cylinder enables the machine to retract faster, and also makes our cylinder slimmer, which brings a better appearance to the machine.
- Punching machines ranging from 38 to 220 tons of punching capacities, combined with different throat depths to choose from, provides a complete range of models to meet our customer's wide range of requirements.
- All optional tooling used on the punching station of S/SD ironworkers can also be used on the PM models, turning the punching machine into a universal machine.



*Bar shearing.



*Channel shearing.



*Angle shearing.



*Flat bar shearing.



*Rectangular notcher.



PM-60LT

Capacities and Specifications

Unit: inch

| MODEL | PM-38T PM-38LT PM-38XT | PM-60T PM-60LT PM-60XT | PM-88T PM-88LT PM-88XT | PM-130LT PM-130XT | PM-175LT PM-175XT | PM-220LT PM-220XT |
|--|--|---|---|---|---|---|
| PUNCHING | | | | | | |
| Punching Pressure | 38 Ton | 60 Ton | 88 Ton | 130 Ton | 175 Ton | 220 Ton |
| Punch Capacity (Diameter x Thickness) | Ø1 ¹ / ₁₆ x 9 ¹ / ₁₆ | Ø7 ¹ / ₈ x 1 ¹ / ₁₆ | Ø1 x 7 ¹ / ₈ | Ø1 ¹ / ₄ x 1 ¹ / ₁₆ | Ø1 ³ / ₈ x 1 ¹ / ₄ | Ø1 ⁵ / ₈ x 1 ³ / ₈ |
| Throat Depth | | | | | | |
| T: | 12 | 12 | 12 | -- | -- | -- |
| LT: | 20 | 20 | 20 | 20 | 20 | 20 |
| XT: | 30 | 30 | 30 | 30 | 30 | 30 |
| Maximum Stroke Length | 4 | 4 | 4 | 4 | 4 | 4 |
| Cycles/Min. (3/4" stroke) | 41 | 28 | 28 | 26 | 27 | 28 |
| Table Size (W x D) | | | | | | |
| T: | 27 ¹ / ₂ x 20 | 27 ¹ / ₂ x 20 | 27 ¹ / ₂ x 20 | -- | -- | -- |
| LT: | 27 ¹ / ₂ x 27 ¹ / ₂ | 27 ¹ / ₂ x 27 ¹ / ₂ | 27 ¹ / ₂ x 27 ¹ / ₂ | 27 ¹ / ₂ x 27 ¹ / ₂ | 27 ¹ / ₂ x 27 ¹ / ₂ | 27 ¹ / ₂ x 27 ¹ / ₂ |
| XT: | 27 ¹ / ₂ x 37 ¹ / ₂ | 27 ¹ / ₂ x 37 ¹ / ₂ | 27 ¹ / ₂ x 37 ¹ / ₂ | 27 ¹ / ₂ x 37 ¹ / ₂ | 27 ¹ / ₂ x 37 ¹ / ₂ | 27 ¹ / ₂ x 37 ¹ / ₂ |
| Working Height Up to Die | 41 ¹ / ₄ | 41 ¹ / ₄ | 41 ¹ / ₄ | 41 ¹ / ₄ | 41 ¹ / ₄ | 41 ¹ / ₄ |
| OPTIONAL TOOLING | | | | | | |
| Largest Hole* | Ø6 x 1 ¹ / ₁₆ | Ø6 x 1 ¹ / ₈ | Ø6 x 3 ¹ / ₁₆ | Ø6 x 1 ¹ / ₄ | Ø6 x 5 ¹ / ₁₆ | Ø6 x 3 ¹ / ₈ |
| Single Vee Press Brake (W x T)* | 10 x 1 ¹ / ₂ | 10 x 5 ¹ / ₈ | 10 x 5 ¹ / ₈ | 10 x 3 ¹ / ₄ | 10 x 3 ¹ / ₄ | 10 x 3 ¹ / ₄ |
| Multi Vee Press Brake (W x T)* | 20 x 1 ¹ / ₈ | 20 x 3 ¹ / ₁₆ | 20 x 3 ¹ / ₁₆ | 27 ¹ / ₂ x 3 ¹ / ₁₆ | 27 ¹ / ₂ x 3 ¹ / ₁₆ | 27 ¹ / ₂ x 3 ¹ / ₁₆ |
| Angle Bending* | 2 ¹ / ₂ x 5 ¹ / ₁₆ | 3 x 1 ¹ / ₄ | 4 x 3 ¹ / ₈ | 4 x 1 ¹ / ₂ | 4 x 1 ¹ / ₂ | 4 x 1 ¹ / ₂ |
| Rectangular Notcher (WxDxT)* | 2 ¹ / ₂ x 3 ¹ / ₂ x 3 ¹ / ₁₆ | 2 ¹ / ₂ x 3 ¹ / ₂ x 1 ¹ / ₄ | 2 ¹ / ₂ x 3 ¹ / ₂ x 3 ¹ / ₈ | 2 ¹ / ₂ x 3 ¹ / ₂ x 1 ¹ / ₂ | 2 ¹ / ₂ x 3 ¹ / ₂ x 1 ¹ / ₂ | 2 ¹ / ₂ x 3 ¹ / ₂ x 1 ¹ / ₂ |
| Vee Notcher (Side x Side x T)* | 5 ³ / ₄ x 5 ³ / ₄ x 3 ¹ / ₁₆ | 5 ³ / ₄ x 5 ³ / ₄ x 1 ¹ / ₄ | 5 ³ / ₄ x 5 ³ / ₄ x 3 ¹ / ₈ | 5 ³ / ₄ x 5 ³ / ₄ x 1 ¹ / ₂ | 5 ³ / ₄ x 5 ³ / ₄ x 1 ¹ / ₂ | 5 ³ / ₄ x 5 ³ / ₄ x 1 ¹ / ₂ |
| Pipe Notcher (Max diameter)* | Ø4 | Ø4 | Ø4 | Ø4 | Ø4 | Ø4 |
| Flat Bar Shearing* | 7 x 3 ¹ / ₁₆ | 7 x 1 ¹ / ₄ | 7 x 3 ¹ / ₈ | 7 x 1 ¹ / ₂ | 7 x 5 ¹ / ₈ | 7 x 5 ¹ / ₈ |
| Angle Shearing* | 3 x 3 x 1 ¹ / ₄ | 3 x 3 x 1 ¹ / ₄ | 4 x 4 x 1 ¹ / ₂ | 4 x 4 x 1 ¹ / ₂ | 4 x 4 x 1 ¹ / ₂ | 4 x 4 x 1 ¹ / ₂ |
| Round Bar Shearing* | Ø1 ¹ / ₈ | Ø1 ¹ / ₄ | Ø1 ¹ / ₄ | Ø1 ¹ / ₄ | Ø1 ¹ / ₄ | Ø1 ¹ / ₄ |
| Square Bar Shearing* | 1 ¹ / ₈ x 1 ¹ / ₈ | 1 ¹ / ₄ x 1 ¹ / ₄ | 1 ¹ / ₄ x 1 ¹ / ₄ | 1 ¹ / ₄ x 1 ¹ / ₄ | 1 ¹ / ₄ x 1 ¹ / ₄ | 1 ¹ / ₄ x 1 ¹ / ₄ |
| Channel Shearing* | -- | 4 x 2 | 4 x 2 | 4 x 2 | 4 x 2 | 4 x 2 |
| OTHER | | | | | | |
| Electric Power | 5 HP | 5 HP | 7.5 HP | 10 HP | 15 HP | 20 HP |
| Net Weight (Apr.) | | | | | | |
| T: | 2650 lb | 3200 lb | 3925 lb | -- | -- | -- |
| LT: | 3325 lb | 4100 lb | 4640 lb | 6275 lb | 7840 lb | 9790 lb |
| XT: | 4075 lb | 4875 lb | 6275 lb | 7950 lb | 10275 lb | 12350 lb |
| Gross Weight (Apr.) | | | | | | |
| T: | 2875 lb | 3600 lb | 4325 lb | -- | -- | -- |
| LT: | 3625 lb | 4525 lb | 5075 lb | 6800 lb | 8525 lb | 10600 lb |
| XT: | 4425 lb | 5350 lb | 6750 lb | 8525 lb | 11025 lb | 13150 lb |
| Machine Dimension (Apr.) | | | | | | |
| (L x W x H) | | | | | | |
| T: | 43 x 33 x 70 | 46 x 33 x 77 | 51 x 34 x 78 | -- | -- | -- |
| LT: | 56 x 33 x 71 | 60 x 33 x 77 | 64 x 34 x 78 | 68 x 38 x 80 | 74 x 41 x 82 | 78 x 50 x 83 |
| XT: | 72 x 33 x 72 | 76 x 33 x 77 | 81 x 34 x 78 | 86 x 38 x 80 | 94 x 41 x 84 | 98 x 50 x 86 |
| Packing Dimension (Apr.) | | | | | | |
| (L x W x H) | | | | | | |
| T: | 56 x 38 x 79 | 59 x 38 x 87 | 63 x 40 x 87 | -- | -- | -- |
| LT: | 69 x 38 x 80 | 73 x 38 x 87 | 77 x 40 x 87 | 81 x 44 x 90 | 87 x 47 x 91 | 91 x 56 x 92 |
| XT: | 85 x 38 x 81 | 88 x 38 x 87 | 93 x 40 x 87 | 98 x 44 x 90 | 106 x 47 x 94 | 110 x 56 x 95 |

* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 65,000 PSI tensile.

Design and specifications subject to change without notice.

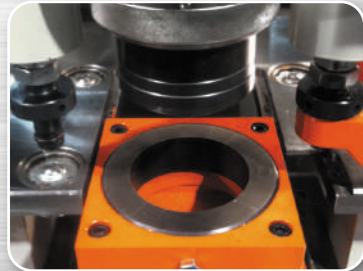
A 2-hole structural die holder and a 2-piece gauging table are provided as standard equipment on all punching machines.

Semi-Automatic

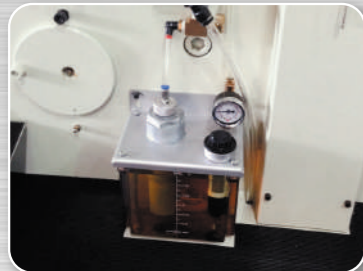
- Preview function before executing program
- Four pre-programmed patterns: Line, Array, Arc, and Custom
- Spotting function using low pressure mode
- Maximum table travel speed: 32' /min



*Optional angle leg up stripper



*Optional oversized punch



*Auto lubrication system with adjustable frequency and oil amount for longer tool life.



*Oil cooling system



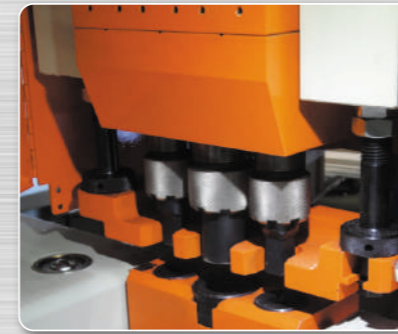
IWNC-110SD
40" x 16" Semi-Automatic Table

*Optional upgrade on semi-auto table

The semi-automatic CNC positioning tables from SUNRISE are plate, angle and channel positioning systems with simple user-friendly interfaces. The CNC positioning table is available as a factory-installed option on Dual-Cylinder Ironworker or Punching Machine with a 20" or larger throat depth. The operation is CNC controlled using a pendant mounted controller featuring easy programming and a virtually indestructible design. The operator simply positions the plate against the CNC-controlled X and Y stops and initiates the punch sequence. Ideal for base plates, connection plates, angles, channels and more.

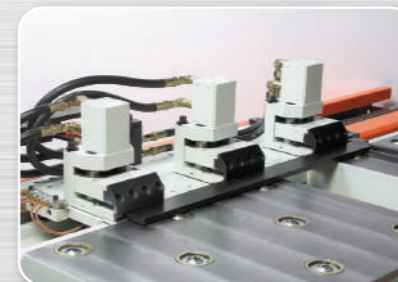
Fully-Automatic

Fully-automatic CNC systems from SUNRISE deliver highly efficient and accurate positioning that will improve your productivity. The controller is easy to learn and operate, so you can begin operations almost immediately. Hydraulic clamps come with a pressure sensor for a strong grip on the material, and come standard on Sunrise automatic CNC tables. Moreover, the included hydraulic stripper comes with exchangeable plates to suit a variety of punching operations. Ball transfer units on the support table provide smooth material movement, and the cover is complete with an interlock switch for ensured operator safety.



Optional Multi-Tool System:

- Standard punches and dies used on multi-tool system
- Each punch is individually controlled by pneumatic cylinders
- Tooling size and shape shown in preview screen



Operate in semi-automatic mode with use of gauging piece allows punching holes near the edge of the material. (Fully Automatic models only)



*Hydraulic stripper to reduce material deformation is standard equipment.



PM-88LT-CNC
40" x 20" Fully-Automatic Table



Sunrise Fluid Power Inc. has been manufacturing hydraulic products and equipment since 1960. SUNRISE has installed thousands of ironworkers, punching machines and CNC systems in the United States and over 22,000 in more than 50 countries around the world. Service, parts, and lifetime technical support are based in Maryland and our dealers around the country. SUNRISE Ironworkers are designed with multi-functions to save labor, time, energy, and cost. This versatile aspect allows the SUNRISE Ironworkers to meet the diversified needs of the metal fabricating industry. Currently, Sunrise has the highest reviews of any ironworker brand on the market today, including a, 'Best in the Business', 3 year parts and 1 year labor warranty!



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