



## **P90 IRONWORKER**



**\$41,995.**

**P90 Machine Price including Standard Equipment listed below**

(Prices listed are ExWorks Rockford, IL, in USD and are valid for machines purchased and installed in the U.S.)

### **STANDARD EQUIPMENT**

**Automatic Hold Down**

**Punch Holder, Stripper, & Die Block**

**5 Punch & Die Sets 9/16" through 1-1/16"**

**Set of Angle Knives**

**Set 1-1/4" Round Bar Knives**

**Set of 14-5/8" Plate Shear Knives**

**Set of Coper Knives**

**Coupling Wrench**

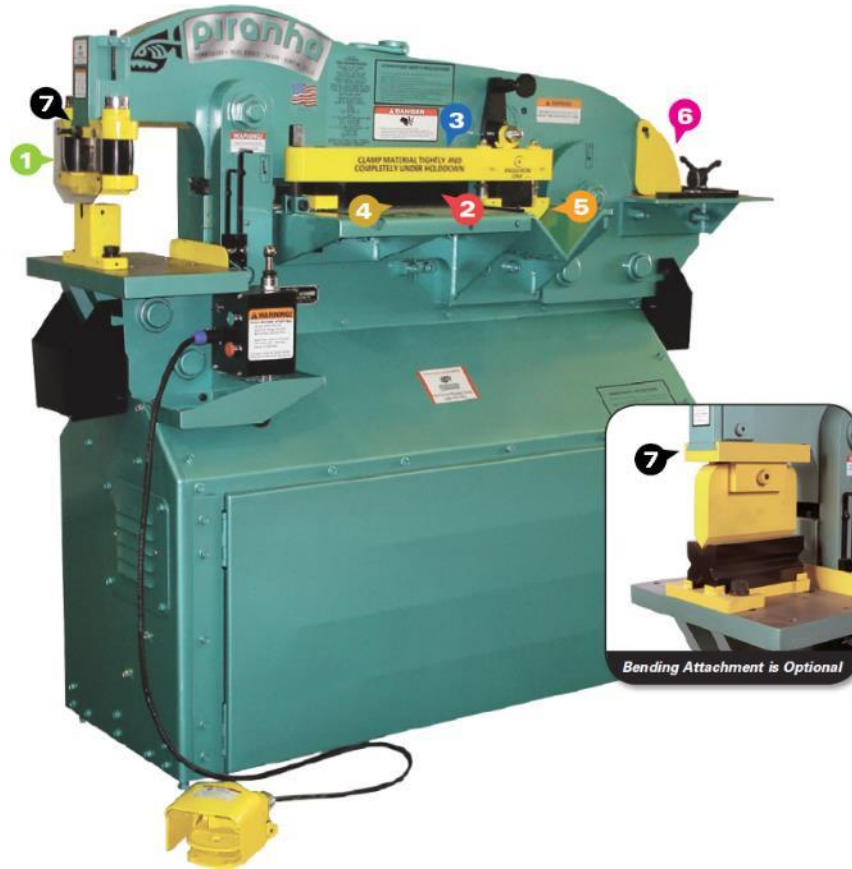
**3/8" Allen Wrench**

**Set of Chip Buckets**

**Extra Filter Element**

**Foot Switch**

**Instruction/Parts Book/Video Link**



## STANDARD FEATURES

- 1. Urethane Stripper Attachment-** keeps material flat through the punching process, eliminating distortion. The shorter required stroke gives you a faster punching cycle.
- 2. Automatic Urethane Hold-downs-** clamps and releases material automatically with each stroke. Part movement is eliminated by clamping the part throughout the entire shearing cycle.
- 3. Visibility-** a direct line of sight over the hold down bar allows the operator to easily and accurately line up cuts to the shear blades.
- 4. Flat Bar Shear-** the low rake angle shear design results in flatter and higher quality sheared parts. Shear blades have four useable edges giving you a longer life and less expensive blades.
- 5. Angle Shear-** the floating upper blade seats in the center of the angle prior to cutting minimizing distortion giving you a higher quality cut.
- 6. Cooper Notcher-** the low rake angle keeps part flat and under control during notching.
- 7. Quick Change Tooling-** the unique Piranha dovetail design allows for quick installation and removal of all standard and optional tools.

Piranha work stations are at a consistent, ergonomic level throughout the entire machine. Easily adaptable to material feed systems without the need to adjust the height between stations.





**MAXIMUM SPECIFICATIONS (rated on mild steel – 60,000 PSI Tensile)**

<b>Punching (90 Tons)</b>	<b>1-1/8" diameter through 1" plate</b>
<b>Throat Depth</b>	<b>10"</b>
<b>Bending (Optional)</b>	<b>12" up to 24" w/4-way die block</b>
<b>Round Bar Shear</b>	<b>1/2" through 2"</b>
<b>Square Bar Shear</b>	<b>1/2" through 1-3/8"</b>
<b>Flat Bar Shear</b>	<b>18" x 1/2", 12" x 3/4", 8" x 1"</b>
<b>Angle Shear</b>	<b>5" x 5" x 1/2"</b>
<b>Coping/Notching</b>	<b>3-1/2" x 5" x 3/8"</b>
<b>Motor</b>	<b>10 HP</b>
<b>Weight</b>	<b>4,250 Lbs.</b>

**DELIVERY**

Normal delivery is from stock subject to confirmation at the time of order. Price is ExWorks factory Rockford, Illinois and does not include any applicable sales tax or installation. **Up to twenty-five gallons** of ISO Grade 32 hydraulic oil is required. The machine is shipped totally wired through the electrical enclosure box. It has been left to the purchaser's discretion whether to wire direct to a disconnect or to install a cord and plug for mobility.

**SHIPMENT REQUIREMENTS**

MegaFab requires Flatbed Trailer(s), with adequate Chains and tarps (to cover full height and width), to assure protection of this equipment when using truck transportation. Please make sure that adequate deck space is allotted for machine and all accessories shipping with order. Upon request, MegaFab will arrange shipping to destination. Freight and insurance charges are the responsibility of the customer, and will be invoiced on machine order. Please consult the factory for any questions regarding shipping requirements.

**WARRANTY**

Twelve (12) months, covering parts against defects in materials or workmanship.

## AVAILABLE OPTIONS

### BENDING ATTACHMENTS

The bending attachments are designed to increase productivity on the punch end of the machine. They utilize the dovetail mounting system for quick and easy installation. The 8", 12" and 14" versions are mounted parallel to the beam allowing you unlimited throat depth and the 24" version mounts perpendicular to the beam. All bending attachments include 4-way bending dies with openings of 7/8", 1-1/8", 1-1/2" and 2".

4451648	12" Bending Attachment	\$1,975
4451503	14" Bending Attachment	\$2,195
4451510	24" Bending Attachment	\$3,075
4451960	24" Press Brake Tool Holders*	\$3,295

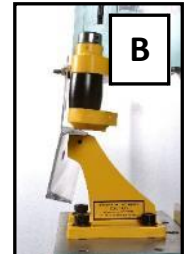
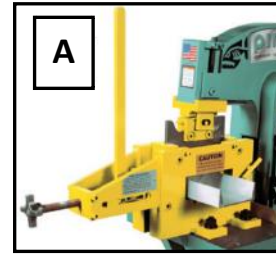
\*Tooling holders only. Does not include punch or die\*



### CHANNEL PROCESSING ATTACHMENTS

On the punch end of the machine we offer an adjustable Channel Shear capable of shearing 2"-8" standard channel. We also offer a Channel Die Block which replaces the standard die block and is designed to punch a hole in the leg or web of channel.

4451600	Channel Shear 2"-8" adjustable	Photo A	\$4,420
4431615	Channel Die Block	Photo B	\$985



### OVERSIZE PUNCHING ATTACHMENTS

Oversize Attachments mount in place of standard punch attachment and are designed to punch a 50-ton maximum hole. Heavy Duty attachments and urethane stripping options for attachments 2-3/4" and larger are available upon request.

4451622	2" 28XX Punch Attachment (2" Max Hole)	\$1,865
4451624	3" 28XX Punch Attachment (3" Max Hole)	\$2,085
4451626	4" 28XX Punch Attachment (4" Max Hole)	\$2,525
4451628	5" 28XX Punch Attachment (5" Max Hole)	\$2,745



## AVAILABLE OPTIONS (continued)

### QUICKSET GAUGING TABLES

The quickset gauging table option is a productivity tool for the punch end. The gauging table mounts around the die block and uses finger stops to repeat a series of punched holes in flat bar or angle. The attachment comes with a table and flat bar gauge with measuring rules for easy hole location layout. A 5' or 10' extension can be added to the left or right side of the base table for longer part processing.



44516201	Punch Quick Set Table Attachment	\$1,920
4431618	5' Quick Set Table Extension Attachment	\$1,535
4431619	10' Quick Set Table Extension Attachment	\$1,975

### SHEARING BACKGAUGES

The backgauge option is a productivity tool for the shearing section. The backgauge mounts on the drop side of the machine and uses a compression sleeve for infinite, easy adjustment to gauge cut lengths in the angle, flat bar and round bar shearing stations. Electronic versions of this backgauge are available which automatically cycles the machine every time material makes contact with the backgauge probe. A support leg is included with the 9' and 12' versions.



44517501	3' Backgauge, manual	\$2,305	44517503	3' Backgauge, electric	\$6,265
44517506	6' Backgauge, manual	\$2,525	44517507	6' Backgauge, electric	\$6,485
44517509	9' Backgauge w/leg, manual	\$2,965	44517508	9' Backgauge w/ leg, electric	\$6,705
44517502	12' Backgauge w/leg, manual	\$3,185	44517504	12' Backgauge w/leg, electric	\$6,925

### ROLLER FEED TABLES

The roller feed tables come in 5' lengths and can be bolted together to make longer sections for fast, easy feeding of plate or angle. Includes 20" wide rollers for flat bar and 6" rollers in the angle section. Adjustable to accommodate floor height and machine type.

4431850-1	5' Roller Feed Table	\$2,305
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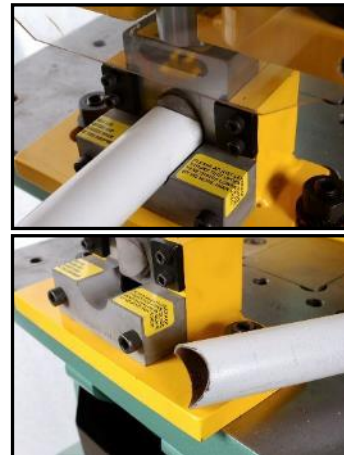


## AVAILABLE OPTIONS (continued)

### PIPE NOTCHING ATTACHMENTS

The pipe notching attachments mount easily on the platen table in place of the punch die block. This is a single notch system. To notch both sides of the pipe you must rotate the pipe and realign with the notching die for the second notch. The pipe notching attachment is made up of three separate pieces, the pipe notching die holder, the pipe notching die and the pipe notching striker.

- The pipe notching die holder is a universal die holder that bolts to the platen table and can accept 3/4" through 2" Schedule 40 Pipe Notching Dies
- The pipe notching dies are spring return die sets that mount in the pipe notching die holder. Standard sizes of pipe notching dies are 3/4", 1", 1-1/4", 1-1/2" and 2" Schedule 40. Other sizes of pipe and tube notching dies are available upon request but may require a different die holder.
- The pipe notching striker is an extended flat bottom punch used in your standard stripper assembly to press down the pipe notching die.



4433631	Pipe Notching Die Holder	\$292
4433642	¾" Schedule 40 Pipe Notching Die	\$476
4433636	1" Schedule 40 Pipe Notching Die	\$476
4433637	1-1/4" Schedule 40 Pipe Notching Die	\$476
4433638	1-1/2" Schedule 40 Pipe Notching Die	\$476
4433639	2" Schedule 40 Pipe Notching Die	\$579
4433641	Fig. EF Pipe Notching Striker	\$42

### PERFORMANCE / MOTOR OPTIONS

4451604	Speed up kit increase to 45 strokes at ¾" per min.	\$1,500
0251601-1	Single Phase Motor (Not available with speed up)	\$950



## COMPARISON CHART

Please use the below chart to help make a comparison between the Piranha Ironworker and other brands. We have filled in some capacities and features that are very beneficial to all ironworker users. Fill in the boxes provided for the other brands to help you make your comparisons.

FEATURE	PIRANHA P90		
PUNCH CAPACITY	90 TONS 1-1/8" HOLE IN 1" PLATE		
THROAT DEPTH	10"		
PUNCH AND DIES	5 PIECE SET INCLUDED		
FLAT SHEAR CAPACITY	18" OF 1/2" PLATE 12" OF 3/4" PLATE 8" OF 1" PLATE		
ANGLE SHEAR CAPACITY	5" X 5" X 1/2"		
NOTCHING CAPACITY	3-1/2" X 5" X 3/8"		
PUNCH STRIPPING TYPE	URETHANE CLAMPING AND STRIPPING INCLUDED		
SHEARING HOLD DOWN TYPE	AUTOMATIC URETHANE CLAMPING INCLUDED		
PUNCH END MOUNTING TYPE	QUICK CHANGE DOVETAIL SLIDE		
WEIGHT	4,250 LBS.		
INVESTMENT			

**Price and specs are subject to change without notice.**



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#### TERMS & CONDITIONS OF SALE

1. **ACCEPTANCE.** Seller makes all quotations and accepts orders only on the terms and conditions stated herein. All orders are subject to acceptance only at Seller's facility in Rockford, IL. No conditions stated by Buyer shall be binding upon Seller and are hereby rejected, unless expressly accepted in a writing signed by the Seller. In the event of conflict or differences in the terms of Buyer's order form and the terms stated herein, the terms stated herein shall govern. Seller shall have no responsibility to commence any of its obligations related to the order until Seller's receipt of the initial down payment. Acceptance by Seller of any order, and therefore the imposition of responsibilities by Seller, is expressly made conditional on Buyer's assent of all Terms and Conditions set forth, herein, and this writing shall constitute the entire Terms and Conditions of the contract of sale notwithstanding any different or additional provisions on Buyer's order, unless otherwise expressly agreed in writing by Seller.
2. **SHIPMENTS AND DELIVERY.** All orders are Ex Works Seller's facility in Rockford, Illinois USA (or Ex Works at such warehousing facilities as Seller may establish) as defined by the International Chamber of Commerce (ICC) Incoterms 2010 unless otherwise agreed to in writing. If Seller has agreed to a delivery location other than Seller's facility, Buyer is responsible for all costs associated with the shipment of goods and insurance from Seller's facility to Buyer's final destination. Buyer's freight carrier must be approved by Seller to provide for the safe and proper delivery of goods to Buyer's final destination. The scheduled shipment date is to be considered an estimate and is not guaranteed by Seller.
3. **PRICE AND PAYMENT TERMS.** All prices are in US Dollars. Prices are subject to all federal, state and local taxes upon the production, sale or shipment of the goods sold hereunder, now or hereafter becoming effective, and if not included in the invoice, such amount may be invoiced later, and Buyer shall pay all such taxes. If the goods are exempt from such taxes, Buyer must furnish Seller with an applicable exemption certificate. Unless otherwise agreed to in writing by Seller, payment terms are 100% Paid Prior to Shipping. Partial invoices may be issued for partial shipments of goods. In the event that Seller extends payment terms to Buyer, Buyer hereby grants to Seller a purchase money security interest in all of the equipment, together with any proceeds of the equipment. Buyer authorizes Seller to file a uniform commercial code financing statement or take such other action necessary to perfect or otherwise provide notice of its security interest, without Buyer's signature or further authorization in order to perfect such security interest.
4. **INSURANCE.** The risk of loss passes to Buyer upon delivery of the goods to the freight carrier at Seller's facility. Insurance against loss or damage to the goods during shipment is the responsibility of Buyer. Claims against a carrier for damage caused during transport to the destination will be made by the Buyer. Until the entire purchase price for the goods is paid in full, Buyer will keep the goods insured against loss or damage by fire and other risks and hazards included with so-called "extended coverage" insurance, in an amount at least equal to such purchase price. Losses under such insurance shall be made payable to Seller and any payments under such insurance shall be paid to Seller and applied to the unpaid balance of the purchase price. Buyer will furnish Seller with copies of the policies of such insurance and each renewal thereof.
5. **CANCELLATION AND RETURN.** Unless otherwise agreed in writing by Seller, all orders are non-cancellable and non-refundable. No equipment will be accepted for return without prior written authorization from the Seller. All returns are subject to Seller's inspection upon receipt. Credit will not be allowed on damaged or used material. If a return is allowed by Seller, a restocking charge equal to 20% of the invoice price. All equipment authorized for return shall be shipped prepaid by Buyer to Seller. Risk of loss of all returned goods shall remain with Buyer until Seller's acceptance of delivery at Seller's premises.
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8. **SOFTWARE LICENSING.** By accepting and using a CNC control incorporating application software licensed from the control manufacturer and Seller, Buyer agrees that such software (Software) constitutes valuable trade secrets and proprietary information of the control manufacturer and Seller, and/or its licensors and that you shall hold the Software in confidence and secrecy and shall not, in whole or in part, copy or disclose the Software to any third party or make any unauthorized use thereof. Authorized use shall



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9. **SAFETY.** It is the responsibility of Buyer to know, understand and comply with the work and safety laws and regulations in effect and governing Buyer's use of the goods sold hereunder. Seller assumes no responsibility for damages, injuries or accidents caused by improper or other than normal use, as directed by Seller, of the equipment. The equipment includes Seller's standard safety devices normal to such system or equipment. Additional safety devices may be required by laws and regulations applicable to the Buyer. It is Buyer's responsibility to identify and furnish any additional safety devices required for Buyer's intended usage and location.
10. **CONFIDENTIALITY.** Any proposals, prints, brochures, drawings, or other information furnished to the Buyer by Seller is intended for confidential use by the Buyer (or Buyer's original user), shall remain the property of Seller and shall not be used or disclosed by Buyer except as necessary for the use and maintenance of equipment. Should such confidential information ever be used or disclosed in violation of this Section, Seller shall be entitled to liquidated damages in the amount equal to the purchase price of the purchased goods, an injunction by any competent court or arbitrator to enjoin and restrain the unauthorized disclosure of such information, and any other available remedy at law or in equity.
11. **WARRANTY; LIMITATION OF REMEDY.** Seller warrants the equipment sold hereunder (excluding software): (a) will conform to the specifications provided, or agreed to in writing, by Seller; and (b) will be free from defects in material and workmanship, for a period of twelve (12) months from date of shipment (the "Warranty Period"). Seller grants no warranty on tooling and consumables, and other perishable items including but not limited to punches and dies, plasma nozzles and electrodes, and laser cutting head optics, cover slides, nozzles, fiber tips, nozzle adapters, ceramic insulators and any other items located below the lower cover slide. Any goods covered by this warranty that are defective, will be repaired or replaced at Seller's option, as the sole and exclusive remedy available to Buyer under this warranty. Seller reserves the right to inspect the goods that are asserted to be defective to confirm its condition. THE WARRANTY CONTAINED HEREIN IS IN LIEU OF ANY OTHER WARRANTY, WHETHER EXPRESSED OR IMPLIED BY STATUTE OR OTHERWISE, INCLUDING ANY WARRANTY OF MERCHANTABILITY, FITNESS FOR PARTICULAR PURPOSE, OR NONINFRINGEMENT (WHICH WARRANTIES ARE HEREBY SPECIFICALLY DISCLAIMED AND EXCLUDED UNDER THIS CONTRACT). The warranties provided herein shall be void if (i) equipment is utilized by Buyer for a purpose or to perform a function for which such equipment was not designed or originally intended; (ii) any change, addition, alteration, modification or repairs have been made in or to equipment without Seller's prior written consent; (iii) where equipment is used with consumables, tooling, and/or accessories not furnished by Seller and/or modifications that have not been recommended or approved by Seller in writing; (iv) where Buyer has failed to utilize qualified maintenance and operating personnel in the operation and/or repair of the equipment; (v) where installation, maintenance and operation of the equipment has not been in strict accordance with applicable manuals and instructions furnished by Seller; or (vi) where equipment has been subject to misuse, negligence or accident in installation or operation beyond Seller's control.
12. **LIMITATION OF LIABILITY.** SELLER'S LIABILITY ON ANY CLAIM(S) OF ANY KIND, INCLUDING NEGLIGENCE OR STRICT LIABILITY, FOR ANY LOSS OR DAMAGE ARISING OUT OF, CONNECTED WITH, OR RESULTING FROM THE PERFORMANCE OR BREACH OF THE TERMS HEREOF, SHALL IN NO CASE EXCEED THE PRICE ALLOCABLE TO THE GOODS WHICH GIVE RISE TO THE CLAIM. IN NO EVENT SHALL SELLER HAVE ANY LIABILITY FOR ANY INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF OR IN CONNECTION WITH A BREACH OF THE CONTRACT OF SALE OR ANY OTHER DUTY OF SELLER WITH RESPECT TO THESE GOODS INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES SUCH AS FOR LOST PRODUCTION, LOST PROFITS, LOST SALES, EVEN IF SELLER HAS BEEN ADVISED OF THE POSSIBILITY THEREOF, OR INJURY TO PERSONS OR PROPERTY.
13. **NOTICE OF CLAIMS.** Buyer shall inspect the goods upon receipt and shall notify Seller in writing of any claims, including claims for shortage or breach of warranty, within 14 days after Buyer discovers or should have discovered facts upon which the claim is based. Failure of Buyer to give written notice of a claim within the time period or in the form specified above shall be deemed to be a waiver of such claim.
14. **INDEMNITY.** BUYER SHALL INDEMNIFY, SAVE AND HOLD HARMLESS TO THE FULLEST EXTENT PERMITTED BY LAW, SELLER AND ANY OF ITS OFFICERS, AGENTS, EMPLOYEES, PARENTS OR AFFILIATES FROM AND AGAINST ANY LOSS, DAMAGES, CLAIMS, ACTIONS, PENALTIES, LIABILITIES AND COSTS, INCLUDING ATTORNEY'S FEES, ARISING FROM ANY LOSS OR DAMAGE TO PROPERTY OR INJURY TO PERSONS, INCLUDING, WITHOUT LIMITATION, ANY INJURY, DISABILITY OR DEATH OF WORKERS OR EMPLOYEES, CAUSED BY OR IN ANY MANNER CAUSED OR ALLEGEDLY CAUSED DIRECTLY OR INDIRECTLY BY: (i) OPERATION OF THE EQUIPMENT WITHOUT ALL SAFETY DEVICES, GUARDS AND PROPER SAFE OPERATING PROCEDURES OR WITH PERSONS OTHER THAN QUALIFIED OPERATING PERSONNEL; OR (ii) THE POSSESSION, USE, MODIFICATION, OR OPERATION OF THE GOODS AFTER DELIVERY. BUYER'S OBLIGATION HEREUNDER IS IN NO WAY LIMITED TO ANY PROTECTION AFFORDED IT UNDER WORKERS' COMPENSATION ACTS, DISABILITY BENEFITS ACTS, OR OTHER EMPLOYEE BENEFITS ACTS.
15. **FORCE-MAJEURE.** The Seller is released of the obligation for full, partial, and proper performance of its obligations under the contract for goods, if resulting from circumstances beyond its reasonable control (including, but not limited to, government action, war/armed hostilities, military actions, embargo, fire, flood, earthquake, strike, epidemic, act of God, or tornado). The delivery dates stipulated by this Contract shall extend for the duration of such circumstances.
16. **CHOICE OF LAW AND FORUM.** All rights of the parties hereto shall be governed by and construed in accordance with the laws of the State of Illinois, and, to the extent the arbitration clause above may be held unenforceable, such dispute or cause of action shall be heard exclusively in Winnebago County, State of Illinois, for state jurisdiction, and the Northern District of Illinois, Western Division, for federal jurisdiction.
17. **EXPORT RESTRICTIONS.** Any commodities, technology, or software that will be exported from the United States by Buyer will be done so in accordance with the Export Administration Regulations. Diversion contrary to U.S. law is prohibited.