GEKA
since 1919

www.geka.es

- World leader in punching and shearing solutions
- Worldwide distribution network
- Proven quality, design and craftsmanship
- Continuous innovation
- Complete after sales service
- Great versatility that includes the highest range in accessories and optional equipments in the market
- The only machine fully produced and manufactured in the European Union
- All GEKA machines are special order. GEKA is the only ironworker that you can customize to fit your needs

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Distributor

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GEKA
The steel working company

Hydracrop models

Where production requires twin operator machines, higher speeds or greater capacity, **GEKA** provides the solution with the **HYDRACROP** range with five working stations: punching, notching, shearing of flat bars, angles and Ø and ☐ bars.

	HYDRACROP 55	HYDRACROP 80	HYDRACROP 110	HYDRACROP 165	HYDRACROP 220
SHEAR FOR FLAT BARS					
Shearing capacity	300x15 / 200x20 mm	450x15 / 300x20 mm	600x15 / 400x20 mm	750x20 / 400x30 mm	750x20 / 400x30 mm
Length of blades	305 mm	475 mm	605 mm	765 mm	765 mm
Working height	880 mm	850 mm	960 mm	870 mm	870 mm
SHEAR FOR SECTION IRON					
Shearing capacity	1100 Kn	1500 Kn	1800 Kn	3000 Kn	3000 Kn
L at 90 º	120x120x10	130x130x13	152x152x13	205x205x18	205x205x18
L at 45	70x70x7	70x70x7	70x70x7	70x70x7	70x70x7
SHEAR FOR BARS					
Round bar Ø	40 mm	45 mm	50 mm	60 mm	60 mm
Square bar ☐	40 mm	45 mm	50 mm	60 mm	60 mm
WITH SPECIAL BLADES					
UPN Profiles	120 mm	140 mm	160 mm	180 mm	180 mm
IPN Profiles	120 mm	140 mm	160 mm	180 mm	180 mm
NOTCHING					
Plate thickness	10 mm	12 mm	13 mm	16 mm	16 mm
Depth	90 mm	90 mm	90 mm	110 mm	110 mm
Width	42 mm	52 mm	52 mm	58 mm	58 mm
PUNCHING					
Punching power	550 Kn	800 Kn	1100 Kn	1650 Kn	2200 Kn
Maximun capacity with quick change	Ø40x10	Ø40x14	Ø40x20	Ø40x30	
and die with gooseneck die holder	Ø20x20	Ø24x24	Ø28x28	Ø34x34	Ø40x40

Capacities are based on a material resistance of 45 kg/mm^2

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Hydracrop models

Punching station

The punching station is fitted with an independent cylinder that creates a large, flexible, universal workstation easily adaptable for mounting special tools and "die sets".


Cylinder support


Split double acting cylinder


Limit switches for punch travel setting


Generous travel for bending, deep-drawing, 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


Fixing bolt at base of gooseneck

L cutting angle

Fully aware of the importance of distortion free shearing, **GEKA** has designed a patented system of a floating upper blade that travels along a rectilinear line and is able to shear angles without any deformation and loss of material (single cut); All **GEKA** Hydracrop models ensure that distortion problems caused by the conventional radial system are now a problem of the past.


Adjustable Support


Blade gap adjustment screws


Upper shear blade without deformation

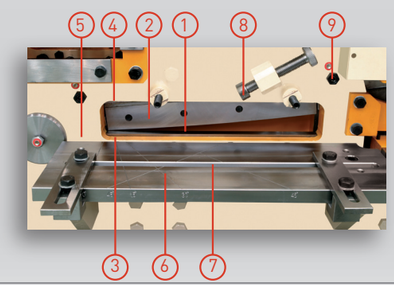

Upper shear blade guides


Safety protection

Shearing for flat bars

The excellent stability of the monoblock blade-holder, which is controlled at the each end, makes it possible to mount a long upper blade with a proven geometry to obtain optimum shearing quality. The radial system allows a generous cutting capacity as a result of the force multiplier effect.

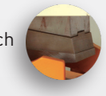
1. Lower blade
2. Upper blade with special geometry
3. Clearance control between shear blades
4. Supplement shearing angle control of upper blade, for shearing without deformation.
5. Adjustable guides 45º right and left.
6. Flat plate/bar shearing table.
7. Slotted guide positioning with coverage of the entire blade length
8. Guide fixing screw
9. Clearance control of blade-holder

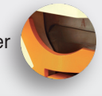


Notching station

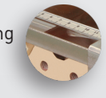
This station of the machine has been designed to mount several optional accessories, all of which are normally held in stock.

- Triangular notching at 90º
- Tube notching equipment
- Notching of footings


Rectangular punch


Material stripper


Cross centring bolts


Fixing holes special tooling

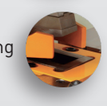
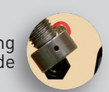

Rectangular notching


Table with scaled measuring stops, included in production kit

Cutting of ∅and ☐ bars

The GEKA HYDRACROP machines are fitted as standard with blades for cutting ∅and ☐ bars. Furthermore, this station has been designed bearing in mind the shearing of other sections such as ⊔, ⊥, Z for which a large stock of blades is available.


Adjusting bolt and height setting of the guide


Blade holding flanges


Guide fixing bolts

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