EXPERIENCE
The GEKA Group began manufacturing ironworkers in 1919. GEKA ironworkers process angles, flat bar and steel profiles used in the construction of prefab metal structures; towers for high-voltage power lines and power stations; telecommunications towers; and other diverse industrial metalworking applications.

Each new machine project is studied individually by our technical office and is manufactured in full at our facilities in accordance with the strictest quality standards.

GEKA has the broadest range of accessories and optional equipment on the market to ensure versatile machines that meet our customers’ needs.

QUALITY ASSURANCE
Each and every GEKA machine is crafted by us in our plant which permits us absolute control over every aspect of the production process. Like our machines, we also manufacture our extensive line of tools and accessories in our own plant, guaranteeing a standard of quality far superior to “knockoffs” available elsewhere on the market. GEKA is your benchmark for experience and quality.

VERSATILITY
GEKA has earned its name as a pioneering and trustworthy brand in the metalwork sector due to its continuous developments and hard work, from the very first manual shearing machines to today’s cutting-edge automated equipment.

EXCEEDING CUSTOMER EXPECTATIONS
Our customer care and on-line support are provided around the clock. A qualified team of technicians in our Customer Care Center is committed to provide after-sales service in order to solve any questions or needs.

R&D&i
Against a background of growing international competition, automation and innovation in production processes are key factors in guaranteeing a company’s competitive edge. Our team of experienced experts devotes their time exclusively to researching and innovating our developments.

GEKA has consistently delivered outcomes that spell customer success and satisfaction for over 90 years.
GEKA Worldwide

Know-how and market share characterize our GEKA success story since our humble beginnings almost a century ago. In the first ninety years, the GEKA Group has forged for itself a proven track record of excellence and performance.

- Over 80% of our production is exported
- Our global network consisting of 60 local distributors all over the world
- Worldwide sales in over 85 countries
- On-demand customer-care offering superior service and maintenance

On any given day, more than 80,000 GEKA machines are pounding away on five different continents. Now that’s customer satisfaction!

Capabilities based on a material resistance of 45 Kg/mm². Technical characteristics valid except for typographical errors or omissions. GEKA group, committed to continuous product improvement, may without notice change technical specifications, equipment and photographs of models, as well as any other information contained herein.
IRONWORKERS

ONE-CYLINDER IRONWORKERS

MINICROP

MAIN FEATURES
- Monoblock Frame.
- Electrically driven hydraulic unit with submerged pump.
- Double acting cylinder.
- Electrical box with safety and integrated controls.
- Monoblock blade holder with antifriction bushings.

BENDICROP SERIES: universal punching ans shearing machines with permanent bending station

BENDICROP 60

MAIN FEATURES
- Permanent bending station is compliance with CE standards.
- Anti-torsion system for flat bar shearing without deformation.
- Angle shearing without loss of material. Wide range of openings for Ø, Ø, and L Ø, Ø and L Ø, rim cutting station. Stations equipped with an assembly that acts as a hydraulic stop.
- Goose neck die-holder for punching of L I and I sections on legs and webs.
- Quick tool change.

HYDRACROP SERIES: TWO-CYLINDER IRONWORKERS

HYDRACROP 110

MAIN FEATURES
- Monoblock Frame.
- Blade holder designed to obtain maximum efficiency in cutting.
- Hydraulic unit assembly.
- Electric panel with overload protection elements and integrated controls.
- Notching table with scaled end stops.
- Punching table with scaled end stops.

PUNCHING MACHINES

PUMA 80

MAIN FEATURES
- Technically dimensioned bed.
- Cylinder with additional guide.
- Strong and accurate shaft system to avoid distortions.
- Gradual centering of punch.
- Quick punch change.
- Safety protection.
- Ample space for mounting special equipment.
- Optimum operation speed.
**MAIN FEATURES**

- **Punching power**: 500 kN
- **Punching capacity**: 27 x 13 mm
- **Maximum stroke**: 30 mm
- **Throat**: 130 mm
- **Cycles per minute (20 mm stroke)**: 23
- **Oversize unit for punching diameters**: *Optional P Model.
- **Marking**: *Optional

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<table>
<thead>
<tr>
<th><strong>Shears of flatbar (mm)</strong></th>
<th><strong>Microcrop</strong></th>
<th><strong>Minicrop</strong></th>
<th><strong>Multicrop</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>350x6</td>
<td>300x10</td>
<td>300x10</td>
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<tr>
<td></td>
<td>200x13</td>
<td>200x13</td>
<td>200x13</td>
</tr>
<tr>
<td><strong>L at 90° (mm)</strong></td>
<td>80x80x8</td>
<td>80x80x8</td>
<td>80x80x8</td>
</tr>
<tr>
<td><strong>L at 45° (mm)</strong></td>
<td>50x50x5</td>
<td>-</td>
<td>60x60x6</td>
</tr>
<tr>
<td><strong>Round bar Ø (mm)</strong></td>
<td>-</td>
<td>30</td>
<td>25</td>
</tr>
<tr>
<td><strong>Punching (mm)</strong></td>
<td>Ø27x13</td>
<td>Ø27x13</td>
<td>Ø27x13</td>
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</table>

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<table>
<thead>
<tr>
<th><strong>Shears of flatbar (mm)</strong></th>
<th><strong>Bendi50</strong></th>
<th><strong>Bendi60S</strong></th>
<th><strong>Bendi60SD</strong></th>
<th><strong>Bendi85S</strong></th>
<th><strong>Bendi85SD</strong></th>
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</thead>
<tbody>
<tr>
<td><strong>L at 90° (mm)</strong></td>
<td>80x80x8</td>
<td>120x120x10</td>
<td>120x120x10</td>
<td>120x120x10</td>
<td>120x120x10</td>
</tr>
<tr>
<td><strong>Bars Ø/Ø (mm)</strong></td>
<td>35/30</td>
<td>45/40</td>
<td>45/40</td>
<td>45/40</td>
<td>45/40</td>
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<tr>
<td><strong>Punching (mm)</strong></td>
<td>Ø31x12</td>
<td>Ø40x11</td>
<td>Ø40x11</td>
<td>Ø40x15</td>
<td>Ø40x15</td>
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<tr>
<td><strong>Bending (mm)</strong></td>
<td>100x10</td>
<td>150x10</td>
<td>150x10</td>
<td>200x12</td>
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</table>

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<table>
<thead>
<tr>
<th><strong>Shears of flatbar (mm)</strong></th>
<th><strong>HYD55</strong></th>
<th><strong>HYD80</strong></th>
<th><strong>HYD110</strong></th>
<th><strong>HYD165</strong></th>
<th><strong>HYD220</strong></th>
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<tbody>
<tr>
<td></td>
<td>300x15</td>
<td>450x15</td>
<td>600x15</td>
<td>750x20</td>
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<tr>
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<td>200x20</td>
<td>400x20</td>
<td>400x30</td>
<td>400x30</td>
<td>400x30</td>
</tr>
<tr>
<td><strong>L at 90° (mm)</strong></td>
<td>120x120x10</td>
<td>130x130x13</td>
<td>152x152x13</td>
<td>205x205x18</td>
<td>205x205x18</td>
</tr>
<tr>
<td><strong>L at 45° (2legs) (mm)</strong></td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
</tr>
<tr>
<td><strong>Bars Ø/Ø (mm)</strong></td>
<td>40</td>
<td>45</td>
<td>50</td>
<td>60</td>
<td>60</td>
</tr>
<tr>
<td><strong>Punching (mm)</strong></td>
<td>Ø40x10/Ø100x4*</td>
<td>Ø40x14/Ø100x6*</td>
<td>Ø40x20/Ø100x8*</td>
<td>Ø40x30/Ø150x12*</td>
<td>Ø40x40/Ø100x16*</td>
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</table>

* Optional

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**PP SERIES**

**PUNCHING POWER**

- **PUMA 55** (mm)
  - Ø40x10
  - Ø100x4*
- **PUMA 80** (mm)
  - Ø40x14
  - Ø100x6*
- **PUMA 110** (mm)
  - Ø40x20
  - Ø100x8*
- **PUMA 165** (mm)
  - Ø40x30
  - Ø100x12*
- **PUMA 220** (mm)
  - Ø40x40
  - Ø100x16*

* Optional
CNC SOLUTIONS

POSITIONING

SEMIPAXY
- Support chassis
- Two servo motor-driven positioning carriages
- Touch screen
- Conveyor assembly consisting of independent servo drives along each axis, spindle and encoder units

FEEDERS

PAX
- Conveyor unit and positioning clamping guides
- Clamping of material
- Servo motor positioning
- Linear roller table top
- Manually-adjustable set of transverse roller guides
- Touch screen monitor

ALRS
Automated feeder of flat bar, available as part of an option package for our HYDRACRIP (except 55 tons model) shearing stations.

SPECIAL CNC SOLUTIONS

We cater to your special ironworking requirements.

Generations of solutions working for your next generation of needs.
Our range of solutions is intended to cover all your needs in the steel fabrication business. Discover how GEKA can help you to improve your productivity and results.

GEKA has the broadest range of original accessories and optional equipment on the market.

### STANDARD ACCESSORIES INCLUDED

GEKA Universal Punching Shears are sold with a complete equipment of tools, whose quality and resistance give the product a great quality/price relationship.

- Standard punching attachment
- Standard rectangular notching unit
- Standard angle cutting unit [at 90°]
- Standard flat bar shearing unit

### OPTIONAL STANDARD ACCESSORIES

GEKA has a wide range of optional accessories that are easily installed, for the punching, cutting and notching stations that will allow you to increase your production levels and shorten your delivery deadlines.

These accessories, available in stock, provide our customers with a fast and economical solution to their needs.

- Oversize punching unit up to 160mm diameter
- Triangular notching unit
- Tube notching unit
- Punching at the end of tube
- Multistop table
- Press brake attachements
- Pipe notching

### SPECIAL CUSTOM ACCESSORIES

Over 8,000 reference backgrounds allow us to manufacture tailor made accessories, optional equipments and solutions to meet your needs.

The following are just an small example of the special tooling Geka can provide with:

- Key shape punching on U channel
- Cutting and punching of flat bar
- Double punching of UPN channel
- Punching + Buttoning
- Rounding of flats + 4 punches
- Urethane stripper for HYDRACROP

### PUNCHES, DIES & BLADES

- Punches and dies
- Shearing blades
- Notching blades
World leader in punching and shearing solutions
With more than 80,000 happy and satisfied customers worldwide and more than 90 years experience.

Proven quality, design and craftsmanship
ISO 9001 and OHSAS certifications besides 90 years experience and a continuous benchmarking policy.

Complete after sales service
Permanent stock and next day delivery of consumables, accessories and parts. After sales assistance by GEKA's qualified engineers.

Great versatility
More than 50 different machine models and over 8000 different accessories. GEKA offers the highest range in accessories and optional equipment in the market.

Produced & manufactured in the European Union
Conversely other manufacturers, GEKA is the only ironworker fully produced by Geka in the UE.

Continuous innovation
New Bendicrop 85, C2PL, Alfa 500, Alfa 150, Gamma Traction, Sigma110...

Worldwide distribution network
With more than 60 distributors and present in more than 85 countries in 5 continents.

All GEKA machines are special order
Every new GEKA machine is one of a kind. Our designers develop solutions suited to your specific needs. We manufacture each GEKA in our own facilities according to precisely defined standards.

www.geka-group.com

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