Where production requires twin operator machines, higher speeds or greater capacity, GEKA provides the solution with the HYDRACROP range with five work stations:

- Punching
- Flat bar shearing
- Section shearing
- Ø and Ø shearing
- Notching

The Hydracrop family comes in five models with different capacities: 55/110, 80/150, 110/180, 165/300, 220/300

The first figure indicates metric tons on the punching end.
The second figure, metric tons on L-shearing end.

There are two different versions of each model: S and SD.

**S VERSION**

- Machines driven by two cylinders.
- 5 work stations, fitted with tools for L, shearing, bars Ø and Ø, shearing, rectangular notching and punching.
- Quick change punch.
- Flat bar shearing table with adjustable guides.
- 2 simultaneous work stations.
- Ready for “Production Kit” comprising:
  - Precision punching table with x & y measuring stops.
  - Precision notching table with x & y measuring stops.
  - One metre “touch & cut” length stop with fine adjusting.
  - Lamp for enhanced vision of cutting zones.
  - 10 sets of round punches and dies.
- Greater speed backed by a powerful hydraulic unit.
- Special equipment for approaching at reduced pressure and slow speed.

**SD VERSION**

- The same features as the S version, but with a deeper throat for larger plate and sheet metal applications.
### FEATURES

#### SHEARS FOR FLATBAR

<table>
<thead>
<tr>
<th>Flatbar (with slight deformation)</th>
<th>55/110 S, SD</th>
<th>80/150 S, SD</th>
<th>110/180 S, SD</th>
<th>165/300 S, SD</th>
<th>220/300 S, SD</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm</td>
<td>300x15</td>
<td>450x15</td>
<td>600x15</td>
<td>750x20</td>
<td>750x20</td>
</tr>
<tr>
<td>mm</td>
<td>200x20</td>
<td>300x20</td>
<td>400x20</td>
<td>400x30</td>
<td>400x30</td>
</tr>
<tr>
<td>Length of blade</td>
<td>305</td>
<td>475</td>
<td>605</td>
<td>765</td>
<td>765</td>
</tr>
<tr>
<td>mm</td>
<td>25</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Square bar Ø</td>
<td>880</td>
<td>850</td>
<td>960</td>
<td>870</td>
<td>870</td>
</tr>
<tr>
<td>mm</td>
<td>60</td>
<td>80</td>
<td>100</td>
<td>120</td>
<td>120</td>
</tr>
</tbody>
</table>

#### SHEARS FOR SECTION IRON

<table>
<thead>
<tr>
<th>Shearing power</th>
<th>kN</th>
<th>1100</th>
<th>1500</th>
<th>1800</th>
<th>3000</th>
<th>3000</th>
</tr>
</thead>
<tbody>
<tr>
<td>L at 90° without deformation</td>
<td>mm</td>
<td>120x120x10</td>
<td>130x130x13</td>
<td>152x152x13</td>
<td>205x205x18</td>
<td>205x205x18</td>
</tr>
<tr>
<td>L at 45° [2legs]</td>
<td>mm</td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
<td>70x70x7</td>
</tr>
<tr>
<td>WITH SPECIAL BLADE</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L at 90° (with slight deformation)</td>
<td>mm</td>
<td>130x130x13</td>
<td>152x152x13</td>
<td>160x160x16</td>
<td>205x205x25</td>
<td>205x205x25</td>
</tr>
</tbody>
</table>

#### SHEARS FOR BARS

<table>
<thead>
<tr>
<th>Round bar Ø</th>
<th>mm</th>
<th>40</th>
<th>45</th>
<th>50</th>
<th>60</th>
<th>60</th>
</tr>
</thead>
<tbody>
<tr>
<td>Square bar Ø</td>
<td>mm</td>
<td>40</td>
<td>45</td>
<td>50</td>
<td>60</td>
<td>60</td>
</tr>
</tbody>
</table>

#### NOTCHING

<table>
<thead>
<tr>
<th>Plate thickness</th>
<th>mm</th>
<th>10</th>
<th>12</th>
<th>13</th>
<th>16</th>
<th>16</th>
</tr>
</thead>
<tbody>
<tr>
<td>Angle of</td>
<td>mm</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>120</td>
<td>120</td>
</tr>
<tr>
<td>Depth</td>
<td>mm</td>
<td>90</td>
<td>90</td>
<td>90</td>
<td>110</td>
<td>110</td>
</tr>
<tr>
<td>Width</td>
<td>mm</td>
<td>42</td>
<td>52</td>
<td>52</td>
<td>58</td>
<td>58</td>
</tr>
</tbody>
</table>

#### PUNCHING

<table>
<thead>
<tr>
<th>Punching power</th>
<th>kN</th>
<th>550</th>
<th>800</th>
<th>1100</th>
<th>1650</th>
<th>2200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum capacity</td>
<td>mm</td>
<td>Ø40x10</td>
<td>Ø40x14</td>
<td>Ø40x20</td>
<td>Ø40x30</td>
<td></td>
</tr>
<tr>
<td></td>
<td>mm</td>
<td>Ø20x20</td>
<td>Ø24x24</td>
<td>Ø28x28</td>
<td>Ø34x34</td>
<td>Ø40x40</td>
</tr>
<tr>
<td>Throat</td>
<td>mm</td>
<td>250</td>
<td>300</td>
<td>300</td>
<td>510</td>
<td>385</td>
</tr>
<tr>
<td>S</td>
<td>500</td>
<td>500</td>
<td>610</td>
<td>610</td>
<td>475</td>
<td></td>
</tr>
<tr>
<td>Stroke</td>
<td>mm</td>
<td>60</td>
<td>70</td>
<td>80</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>Working height</td>
<td>mm</td>
<td>1085</td>
<td>1095</td>
<td>1165</td>
<td>1110</td>
<td>1110</td>
</tr>
</tbody>
</table>

#### GENERAL SPECIFICATIONS

<table>
<thead>
<tr>
<th>N° strokes per minute [stroke= 20mm]</th>
<th>37</th>
<th>40</th>
<th>28</th>
<th>31</th>
<th>26</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor</td>
<td>kW</td>
<td>5</td>
<td>9</td>
<td>9</td>
<td>15</td>
</tr>
<tr>
<td>Net weight</td>
<td>kg</td>
<td>1390</td>
<td>2070</td>
<td>2760</td>
<td>5200</td>
</tr>
<tr>
<td>S</td>
<td>1750</td>
<td>2400</td>
<td>3300</td>
<td>6300</td>
<td>7000</td>
</tr>
<tr>
<td>Gross weight</td>
<td>kg</td>
<td>1598</td>
<td>2232</td>
<td>3162</td>
<td>5980</td>
</tr>
<tr>
<td>S</td>
<td>2012</td>
<td>2760</td>
<td>3795</td>
<td>7245</td>
<td>8050</td>
</tr>
<tr>
<td>Packaging dimensions</td>
<td>m</td>
<td>1,67x1,16x2,29</td>
<td>2,13x1,20x2,39</td>
<td>2,24x1,20x2,20</td>
<td>3,2x1,60x2,49</td>
</tr>
<tr>
<td>S</td>
<td>2,10x1,16x2,69</td>
<td>2,31x1,20x2,20</td>
<td>2,65x1,60x2,20</td>
<td>2,95x1,60x2,20</td>
<td>2,95x1,60x2,20</td>
</tr>
<tr>
<td>Volume of seaworthy package</td>
<td>m³</td>
<td>4,04</td>
<td>4,72</td>
<td>5,62</td>
<td>10</td>
</tr>
<tr>
<td>S</td>
<td>5,09</td>
<td>5,68</td>
<td>8,28</td>
<td>10,38</td>
<td>11,67</td>
</tr>
</tbody>
</table>

* Capacities based on a material resistance of 45 Kg/mm².

#### STEEL PLATE

- CHANNELS
  - DOUBLE WING CUT (one of which is at 45°)
- FLAT BAR
- H CHANNEL
- ANGLES
  - 45° CUT
- SHEARING
- SPOTTING
- PUNCHING
- BENDING
- MARKING
- DRILLING
- PUNCHING

---

**Features chart**: The table provides specifications for various iron-cutting machines, detailing the capacities for different materials and operations. The chart includes dimensions, weights, and performances for flat bars, section iron, bars, and plates, among others. The specifications are based on a material resistance of 45 Kg/mm².

- **Shears for Flatbar**: Specifications for flatbar shears, including lengths of blade, square bars, and more.
- **Shears for Section Iron**: Specifications for shears for section iron, including shearing power and dimensions such as L at 90° without deformation and L at 45° [2legs].
- **Shears for Bars**: Specifications for shears for bars, including round and square bars.
- **Notching**: Specifications for notching, including plate thickness, angle, and depth.
- **Punching**: Specifications for punching, including punching power and maximum capacity for different blade sizes.
- **General Specifications**: Specifications for general usage, including motor performance, net and gross weights, packaging dimensions, and volume of seaworthy packages.
MODELS

Hydracrop 55/110

<table>
<thead>
<tr>
<th>FEATURES</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Shearing of flat plate</td>
<td>300 x 15 mm</td>
</tr>
<tr>
<td></td>
<td>200 x 20 mm</td>
</tr>
<tr>
<td>L cut with standard blade (no distortion):</td>
<td>120 x 120 x 10 mm</td>
</tr>
<tr>
<td>L cut with optional blade (minor distortion):</td>
<td>130 x 130 x 13 mm</td>
</tr>
<tr>
<td>Shearing of Ø and Ø bars</td>
<td>40 mm</td>
</tr>
<tr>
<td>Punching capacity Ø</td>
<td>40 x 10 mm</td>
</tr>
</tbody>
</table>

Hydracrop 80/150

<table>
<thead>
<tr>
<th>FEATURES</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Shearing of flat plate</td>
<td>450 x 15 mm</td>
</tr>
<tr>
<td></td>
<td>300 x 20 mm</td>
</tr>
<tr>
<td>L cut with standard blade (no distortion):</td>
<td>130 x 130 x 13 mm</td>
</tr>
<tr>
<td>L cut with optional blade (minor distortion):</td>
<td>152 x 152 x 13 mm</td>
</tr>
<tr>
<td>Shearing of Ø and Ø bars</td>
<td>45 mm</td>
</tr>
<tr>
<td>Punching capacity Ø</td>
<td>40 x 14 mm</td>
</tr>
</tbody>
</table>

Hydracrop 110/180

<table>
<thead>
<tr>
<th>FEATURES</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Shearing of flat plate</td>
<td>600 x 15 mm</td>
</tr>
<tr>
<td></td>
<td>400 x 20 mm</td>
</tr>
<tr>
<td>L cut with standard blade (no distortion):</td>
<td>152 x 152 x 13 mm</td>
</tr>
<tr>
<td>L cut with optional blade (minor distortion):</td>
<td>160 x 160 x 16 mm</td>
</tr>
<tr>
<td>Shearing of Ø and Ø bars</td>
<td>50 mm</td>
</tr>
<tr>
<td>Punching capacity Ø</td>
<td>40 x 20 mm</td>
</tr>
</tbody>
</table>
Hydracrop 165/300

**FEATURES**

<table>
<thead>
<tr>
<th>Feature</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shearing of flat plate</td>
<td>750 x 20 mm</td>
</tr>
<tr>
<td></td>
<td>400 x 30 mm</td>
</tr>
<tr>
<td>L cut with standard blade (no distortion)</td>
<td>205 x 205 x 18 mm</td>
</tr>
<tr>
<td>L cut with optional blade (minor distortion)</td>
<td>205 x 205 x 25 mm</td>
</tr>
<tr>
<td>Shearing of Ø and Ø bars</td>
<td>60 mm</td>
</tr>
<tr>
<td>Punching capacity Ø</td>
<td>40 x 30 mm</td>
</tr>
</tbody>
</table>

Hydracrop 220/300

**FEATURES**

<table>
<thead>
<tr>
<th>Feature</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shearing of flat plate</td>
<td>750 x 20 mm</td>
</tr>
<tr>
<td></td>
<td>400 x 30 mm</td>
</tr>
<tr>
<td>L cut with standard blade (no distortion)</td>
<td>205 x 205 x 18 mm</td>
</tr>
<tr>
<td>L cut with optional blade (minor distortion)</td>
<td>205 x 205 x 25 mm</td>
</tr>
<tr>
<td>Shearing of Ø and Ø bars</td>
<td>60 mm</td>
</tr>
<tr>
<td>Punching capacity Ø</td>
<td>40 x 40 mm</td>
</tr>
</tbody>
</table>

**PRODUCTION PACK**

To obtain maximum output, GEKA provides its customers with the Production kit at a symbolic price, which comprises:

- **“Touch & Cut” Electric Length Stop** 1 meter long
- Set of 10 Round Punches and Dies
- Work Light with Magnetic Base
WORKING STATIONS

**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 90°.
- Punching equipment.
- Pipe notching equipment.
- Radiusing of flat bar ends.
- Radiusing corners.
- Notching of footings, etc.
  1. Rectangular Punch
  2. Rectangular Stripper
  3. Rectangular notching lower blades
  4. Table with scaled measuring stops, included in Production Kit
  5. Cross centring Frame bolts
  6. Tapped holes for special tooling

**Cutting of Ø and □ bars**
The GEKA HYDRACROP machines are fitted as standard with blades for cutting Ø and □ bars. Furthermore, this station has been designed bearing in mind the shearing of other sections such as LI, I, T for which a large stock of blades is available.

- Adjusting bolt and height setting of the guide.
- Blade holding flanges.
- Guide fixing bolts.

**Punching station**
Fitted with an independent cylinder creating 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.
- Quick punch change.
- Adjustable material stripper.
- Table with millimetre scales, included in production kit.
- Adjustable measuring stop.
- 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.

**Shearing of flat bar**
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.

- Upper blade with special geometry.
- Lower blade.
- Supplement shearing angle control of upper blade, for shearing without deformation.
- Guide fixing screw.
- Clearance control of blade-holder.
- Adjustabe guides 45° right and left.
- Clearance control between shear blades.
- Flat plate/bar shearing table.
- Slotted guide positioning with coverage of the entire blade length.

**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 or loss of material (single cut); All GEKA Hydracrop models ensure the distortion problem caused by the conventional radial system is now a problem of the past.

- Safety protection.
- Upper shear blade guides.
- Lower shear blade guides.
- Upper shear blade without deformation.
- Blade gap adjustment screws.
- Adjustable Support.

**Electric cabinet**
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.

gleka-group.com