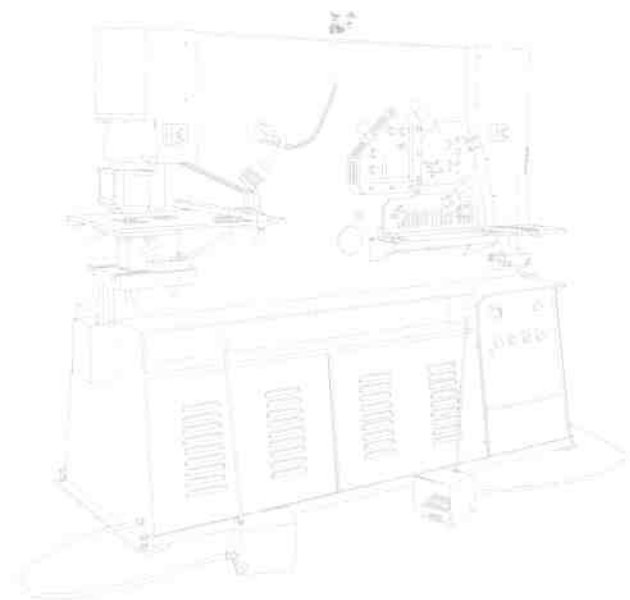




HYDRAULIC IRONWORKERS & PUNCHING MACHINES



**Multi-Functions
Excellent Quality
Economical Investment**



IW-80S



Introduction

The Sunrise Hydraulic Ironworkers are designed with multi-functions to save labor, time, energy and cost. This versatility aspect allows the Sunrise Ironworkers to meet the diversified needs of the engineering industry.

Maximum efficiency and long life is guaranteed by latest manufacturing methods, from powerful CAD design, modern production line with CNC equipment, to continuous quality control. Each work station is equipped with specially designed hold-downs to ensure safety while providing precision and ease of use.

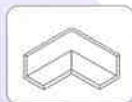
At their affordable prices, these ironworkers are the most economical and effective machines in the industry for the manufacturing of metal products.



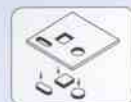
* Optional CNC Gauging Table
(IW-SD and PM-LT/XT only)



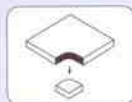
*Pipe Notching



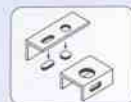
*Angle Bending



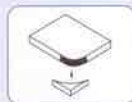
Punching



*Radius Corners



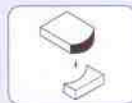
Punching



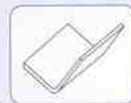
*Rounding off Corners



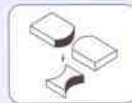
*Pipe Punching



*Cutting and Rounding off



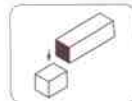
*Press Brake



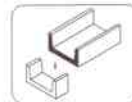
*Bilateral Rounding off



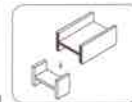
Round Bar Shear



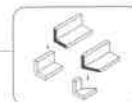
Square Bar Shear



*Channel Shear



*I Beam Shear



Angle Shear



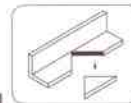
IW-125S



Flat Bar Shear



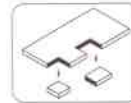
Angle Miter Shear



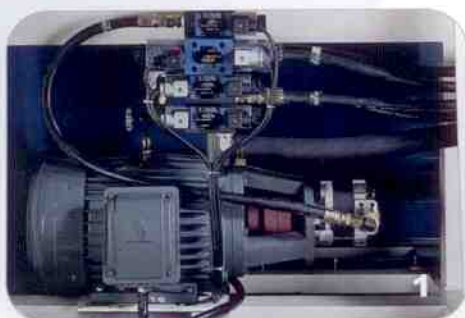
*Vee Notching



Notching



Notching



1. The use of namebrand hydraulic parts ensure great reliability on the hydraulic system.

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

* : Optional tooling



Sunrise Ironworker

Punching Station

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



*Punches and dies are sold separately.



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



Single hole die holder for punching channel webs. (optional on double cylinder models)



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



*Urethane spring stripper for minimal deformation.



*Pipe notcher.



*Large hole punching.

FEATURES



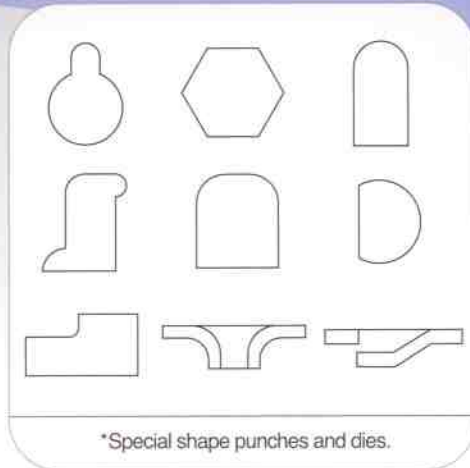
*Multi-stop gauge table. (S/SD/KD and PM models only)



*Single vee press brake.



*Multi vee press brake.



*Special shape punches and dies.



*Large vee-notcher. (punch side)



*Angle bending press.

Optional duplicating table with hydraulic stripper and hydraulic clamping for fast and accurate repetition work. (S/SD/KD and PM models only)

* : Optional tooling

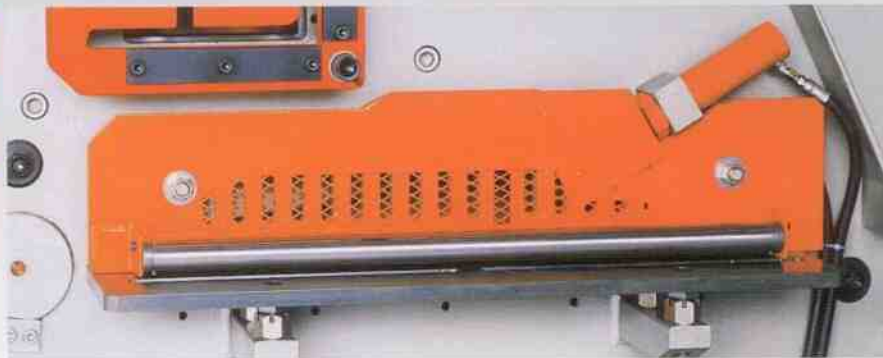
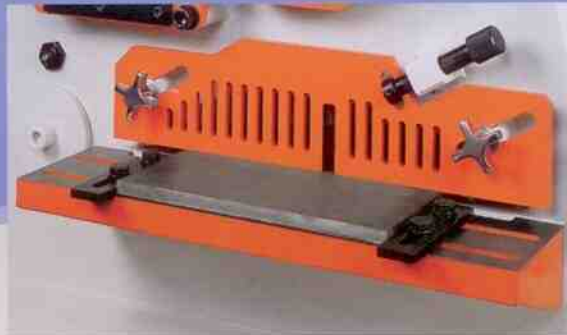




Sunrise Ironworker

Flat Bar Shearing Station

- Special curved 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.

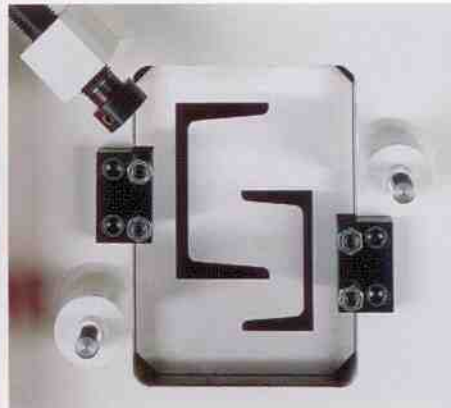
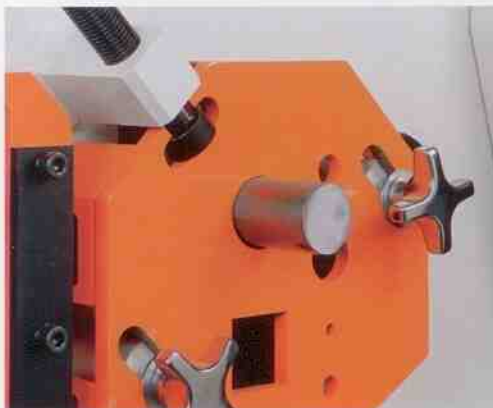


Standard backgauge.

*Optional hydraulic hold-down for double cylinder ironworkers.
(Standard on IW-165SD)

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)



FEATURES

Angle Shearing Station

- Single shear with no material loss and minimal deformity.
- 45° miter-cut is easy and clean.
- Featuring blades with four usable cutting edges.



Notching Station

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



*Optional.



Other Features

1. Three limit switches enable setting of short notch stroke to improve efficiency. (on IW-50A, IW-60H and S/SD models)
2. Magnet mounted light for safer operation. (standard on IW-50A, IW-60H, IW-60K and S/SD/KD, PM models)
3. Electric backgauge for higher efficiency in repetitious work.



* Optional on IW-45M, IW-45K, IW50A, IW-60H.



The IW-45M has four standard stations, capable of a wide range of applications. The punching station can be converted into a notching station. IW-45M is heavier and stronger than other competitive machines. This durable and economical model is perfect for small shops with a limited budget.



IW-45M



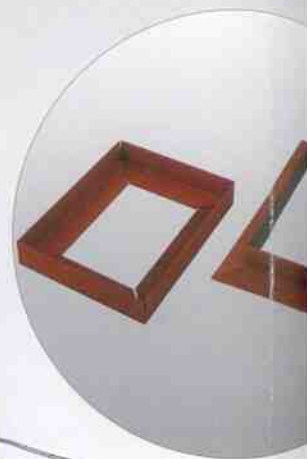
IW-50A

The IW-50A features vertical moving ram at the punching station which improves the punching result and enable use of optional tooling such as pipe notching and bending tool. The square/round bar shear is a stand-alone station with possibility of optional channel shear and section bar shear tooling. This model also features lower angle shearing and bar shearing stations.



IW-60H

The IW-60H features the "Z" shape aperture at the angle shear station, which makes this model capable of doing both the internal and external miter shear on angle bars. The round/square bar shearing on this model is a stand-alone station that has large shearing capability.



SINGLE CYLINDER IRONWORKERS

Capacities and Specifications

Unit: mm

MODEL	IW-45M	IW-50A	IW-60H
PUNCHING			
Punching Pressure	45 Ton	50 Ton	60 Ton
Punch Capacity (Diameter x Thickness)	ø22 x 15 ø40 x 8	ø20 x 18 ø40 x 9	ø28 x 15 ø40 x 11
Throat Depth	175	180	220
Maximum Stroke Length	35	42	55
Cycles / Min. (15mm stroke)	31	24	29
Working Height Up to Die	970	840	1000
ANGLE SHEARING			
At 90° Shearing	80 x 80 x 8	100 x 100 x 10	100 x 100 x 13
At 45° Miter Shearing	50 x 50 x 6	65 x 65 x 8	80 x 80 x 8
Working Height	1120	850	1236
FLAT SHEARING			
Flat Bar Shear (Width x Thickness)	350 x 8 180 x 12	300 x 12 200 x 18	350 x 15 210 x 20
Blade Length	360	310	360
Angle Flange Trim	75	100	100
Working Height	970	1150	1006
BAR SHEARING			
Round Bar Shear	ø25	ø32	ø40
Square Bar Shear	25 x 25	30 x 30	38 x 38
Channel Shear	---	76*	102*
I Beam Shear	---	76*	102*
Working Height	1190	880	1260
NOTCHING			
Rectangular Notcher (W x D x T)	50.8 x 90 x 7**	50.8 x 90 x 7	50.8 x 90 x 8
Vee-Notcher (Side x Side x T)	90 x 90 x 8**	90 x 90 x 8*	90 x 90 x 10*
Working Height	---	1150	1006
SPECIAL TOOLING			
Single Vee Press Brake (W x T)	160 x 6*	160 x 10*	160 x 8*
Multi Vee Press Brake (W x T)	---	250 x 6*	---
Angle Bending	65 x 8*	65 x 8*	65 x 10*
Pipe Notching	---	ø63*	---
OTHER			
Electric Power (HP)	5HP	5HP	7.5HP
Net Weight (Apr.)	830 kg	1130 kg	1500 kg
Gross Weight (Apr.)	930 kg	1250 kg	1650 kg
Machine Dimension (Apr.)(LxWxH)	1260 x 700 x 1350	1310 x 770 x 1450	1460 x 770 x 1560
Packing Dimension (Apr.)(LxWxH)	1530 x 860 x 1630	1580 x 930 x 1730	1730 x 930 x 1840

* : Optional Tooling

** : On IW-45M the notcher is optional tooling to be installed at the punching station.

Note: Based on low carbon / mild steel material strength of 45kg / mm² tensile.

Design and specifications subject to change without notice.

An 1-hole die holder and a 2-piece gauging table are provided as standard equipment on all single cylinder models.



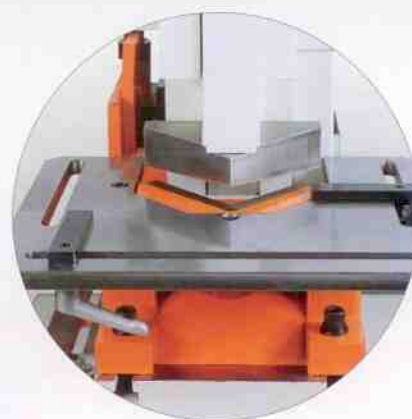
The all new K-series is a special designed compact ironworker with vertical movements at all stations. The entire main slide moves in straight up and down motion to provide the optimum results for punching, shearing, notching, and bending. Optional hydraulic hold-down and urethane spring stripper are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



IW-45K



IW-85KD



K - SERIES IRONWORKERS

Capacities and Specifications

Unit: mm



Hydraulic hold-down (optional on IW-45K)



Channel notching on IW-85KD.



*Urethane spring stripper.



*Punching tool on notching station.

MODEL	IW-45K	IW-60K	IW-85KD
PUNCHING			
Punching Pressure	45 Ton	60 Ton	85 Ton
Punch Capacity (Diameter x Thickness)	ø22 x 15 ø40 x 8	ø22 x 20 ø40 x 11	ø27 x 22 ø50 x 12
Throat Depth	165	200	410
Channel Flange Punch (Height)	--	--	75 ~ 180
Maximum Stroke Length	30	40	100
Cycles / Min. (15mm stroke)	37	34	38
Working Height Up to Die	1050	1050	1050
ANGLE SHEARING			
Shearing Capacity	45 Ton	60 Ton	110 Ton
Shearing Cylinder Stroke Length	--	--	50
At 90° Shearing	75 x 75 x 6	100 x 100 x 8	130 x 130 x 12
Working Height	1000	1070	1040
FLAT SHEARING			
Flat Bar Shear	300 x 10	350 x 15	406 x 20
Blade Length	310	360	410
Working Height	800	805	726
BAR SHEARING			
Round Bar Shear	ø30	ø40	ø45
Square Bar Shear	25 x 25	38 x 38	45 x 45
Channel Shear	76*	102*	152*
I Beam Shear	76*	102*	152*
NOTCHING			
Rectangular Notcher (W x D x T)	50.8 x 90 x 7	50.8 x 90 x 8	63.5 x 90 x 12
Vee-Notcher (Side x Side x T)	90 x 90 x 8*	90 x 90 x 8*	105 x 105 x 12*
Channel Notching	--	--	180 ~ 200
Working Height	1050	1050	1050
SPECIAL TOOLING			
Large Vee-Notcher (Side x Side x T)	--	--	145 x 145 x 10*
Single Vee Press Brake (W x T)	160 x 8*	160 x 8*	250 x 15*
Multi Vee Press Brake (W x T)	250 x 4*	250 x 6*	500 x 5*
Angle Bending	65 x 8*	65 x 8*	102 x 8*
Pipe Notching	ø63*	ø63*	ø114*
OTHER			
Electric Power (HP)	5 HP	7.5 HP	10 HP
Net Weight (Apr.)	840 kg	1180 kg	2750 kg
Gross Weight (Apr.)	940 kg	1320 kg	2900 kg
Machine Dimension (Apr.)	1050 x 760 x 1490	1180 x 760 x 1630	1795 x 1020 x 1865
Packing Dimension (Apr.)	1320 x 920 x 1770	1450 x 920 x 1910	2150 x 1180 x 2170

* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm² tensile.
Design and specifications subject to change without notice.



"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 paddles, and separate operations can be safely performed simultaneously without interference. 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" fixing provide a solid base for securing the punching tooling, as well as a wide range of optional and custom designed tooling.



IW-80SD

DOUBLE CYLINDER IRONWORKERS

Capacities and Specifications

Unit: mm

MODEL	IW-60S IW-60SD	IW-80S IW-80SD	IW-100S IW-100SD	IW-125S IW-125SD	IW-165SD
PUNCHING					
Punching Pressure	60 Ton	80 Ton	100 Ton	125 Ton	165 Ton
Punch Capacity (Diameter x Thickness)	ø22 x 20 ø50 x 9	ø26 x 22 ø50 x 12	ø28 x 26 ø50 x 15	ø33 x 27 ø50 x 18	ø37 x 32 ø50 x 24
Throat Depth	S: 310 SD: 510	310 510	310 510	310 510	---
Channel Flange Punch (Height)	180	180	180	180	180
Maximum Stroke Length	100	100	100	100	100
Cycles / Min. (20mm stroke)	30	29	28	28	29
Working Height Up to Die	1010	1050	1044	1069	1050
ANGLE SHEARING					
At 90° Shearing	130 x 130 x 13	152 x 152 x 13	152 x 152 x 15	152 x 152 x 18	205 x 205 x 20
At 45° Miter Shearing	65 x 65 x 8	80 x 80 x 10	80 x 80 x 10	80 x 80 x 10	80 x 80 x 10
Working Height	1115	1165	1216	1185	1185
FLAT SHEARING					
Flat Bar Shear (Width x Thickness)	350 x 15 240 x 20	460 x 15 300 x 20	610 x 16 400 x 20	610 x 18 400 x 25	760 x 20 400 x 30
Blade Length	360	465	620	620	770
Angle Flange Trim	100	100	100	100	120
Working Height	910	926	954	920	920
BAR SHEARING					
Round Bar Shear	ø40	ø45	ø45	ø50	ø60
Square Bar Shear	38 x 38	45 x 45	45 x 45	50 x 50	60 x 60
Channel Shear	130*	152*	152*	180*	203*
I Beam Shear	130*	152*	152*	180*	203*
Working Height	1220	1270	1332	1310	1370
NOTCHING					
Rectangular Notcher (W x D x T)	50.8 x 90 x 9	50.8 x 90 x 12	63.5 x 90 x 12	63.5 x 90 x 13	63.5 x 90 x 16
Vee-Notcher (Side x Side x T)	90 x 90 x 10*	90 x 90 x 12*	105 x 105 x 12*	105 x 105 x 13*	105 x 105 x 16*
Working Height	910	926	954	920	920
SPECIAL TOOLING					
Large Vee-Notcher (Side x Side x T)	145 x 145 x 8*	145 x 145 x 10*	145 x 145 x 12*	145 x 145 x 13*	145 x 145 x 13*
Single Vee Press Brake (W x T)	250 x 15*	250 x 15*	250 x 20*	250 x 20*	250 x 20*
Multi Vee Press Brake (W x T)	500 x 5*	500 x 5*	700 x 5*	700 x 5*	700 x 5*
Angle Bending	102 x 6*	102 x 8*	102 x 13*	102 x 13*	102 x 13*
Pipe Notching	ø114*	ø114*	ø114*	ø114*	ø114*
OTHER					
Electric Power (HP)	7.5 HP	10 HP	10 HP	15 HP	20HP
Net Weight (Apr.)	S: 1800 kg SD: 2200 kg	2180 kg 2650 kg	2950 kg 3450 kg	3340 kg 3950 kg	---
Gross Weight (Apr.)	S: 1950 kg SD: 2380 kg	2360 kg 2880 kg	3180 kg 3700 kg	3590 kg 4220 kg	---
Machine Dimension (Apr.) (LxWxH)	S: 1700 x 800 x 1710 SD: 2070 x 800 x 1710	1830x820x1760 2210x820x1760	2100x860x1810 2460x860x1810	2170x1030x1850 2490x1030x1850	---
Packing Dimension (Apr.) (LxWxH):	S: 1970 x 960 x 1990 SD: 2340 x 960 x 1990	2100x980x2040 2480x980x2040	2370x1020x2090 2730x1020x2090	2440x1190x2130 2760x1190x2130	---

* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm² tensile.

Design and specifications subject to change without notice.

An 2-hole overhang die holder and a 2-piece gauging table are provided as standard equipment on all double cylinder ironworkers.



PM SERIES

Hydraulic Punching Machine

- Special designed hydraulic cylinder enables the machine to retract faster, also makes our cylinder slimmer, which brings a better appearance to the machine.
- Ranging from 35 to 200 tons of punching capacities, combined with different throat depths to choose, provides a complete range of models to meet the customer's different 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 an universal machine.



PM-55LT



*Bar shearing.



*Channel shearing.



*Angle shearing.



*Flat bar shearing.



*Rectangular notcher.

HYDRAULIC PUNCHING MACHINE

Capacities and Specifications

Unit: mm

MODEL	PM-35T PM-35LT PM-35XT	PM-55T PM-55LT PM-55XT	PM-80T PM-80LT PM-80XT	PM-120LT PM-120XT	PM-160LT PM-160XT	PM-200LT PM-200XT
PUNCHING						
Punching Pressure	35 Ton	55 Ton	80 Ton	120 Ton	160 Ton	200 Ton
Punch Capacity	ø18 x 14	ø22 x 18	ø25 x 23	ø32 x 27	ø36 x 32	ø41 x 35
(Diameter x Thickness)	ø50 x 5	ø50 x 8	ø50 x 12	ø50 x 17	ø50 x 23	ø50 x 29
Channel Flange Punch (Height)	180	180	180	180	180	180
Throat Depth	T: 310	310	310	---	---	---
LT: 510	510	510	510	510	510	510
XT: 760	760	760	760	760	760	760
Maximum Stroke Length	100	100	100	100	100	100
Cycles/Min. (20mm stroke)	41	28	28	26	27	28
Table Size (W x D)	T: 700 x 500	700 x 500	700 x 500	---	---	---
LT: 700 x 700	700 x 700	700 x 700	700 x 700	700 x 700	700 x 700	700 x 700
XT: 700 x 950	700 x 950	700 x 950	700 x 950	700 x 950	700 x 950	700 x 950
Working Height Up to Die	1050	1050	1050	1050	1050	1050
OPTIONAL TOOLING						
Largest Hole*	ø160 x 2	ø160 x 3	ø160 x 4	ø200 x 6	ø200 x 8	ø200 x 10
Single Vee Press Brake (W x T)*	250 x 12	250 x 15	250 x 15	250 x 20	250 x 20	250 x 20
Multi Vee Press Brake (W x T)*	500 x 3	500 x 5	500 x 5	700 x 5	700 x 5	700 x 5
Angle Bending*	102 x 6	102 x 9	102 x 13	102 x 13	102 x 13	102 x 13
Rectangular Notcher (WxDxT)*	63.5 x 90 x 6	63.5 x 90 x 8	63.5 x 90 x 10	63.5 x 90 x 13	63.5 x 90 x 13	63.5 x 90 x 13
Vee Notcher (Side x Side x T)*	145 x 145 x 5	145 x 145 x 6	145 x 145 x 10	145 x 145 x 12	145 x 145 x 13	145 x 145 x 13
Pipe Notcher (Max diameter)*	ø114	ø114	ø114	ø114	ø114	ø114
Flat Bar Shearing*	175 x 5	175 x 7	175 x 10	175 x 14	175 x 16	175 x 16
Angle Shearing*	75 x 75 x 6	100 x 100 x 7	100 x 100 x 10	100 x 100 x 13	100 x 100 x 13	100 x 100 x 13
Round Bar Shearing*	ø 32	ø32	ø32	ø 32	ø32	ø32
Square Bar Shearing*	28 x 28	32 x 32	32 x 32	32 x 32	32 x 32	32 x 32
Channel Shearing*	102 x 51	102 x 51	102 x 51	102 x 51	102 x 51	102 x 51
OTHER						
Electric Power	5 HP	5 HP	7.5 HP	10 HP	15 HP	20 HP
Net Weight (Apr.)	T: 1200 kg	1450 kg	1780 kg	---	---	---
LT: 1500 kg	1500 kg	1850 kg	2100 kg	2840 kg	3550 kg	4440 kg
XT: 1840 kg	1840 kg	2200 kg	2845 kg	3600 kg	4660 kg	5600 kg
Gross Weight (Apr.)	T: 1300 kg	1620 kg	1960 kg	---	---	---
LT: 1640 kg	1640 kg	2050 kg	2300 kg	3080 kg	3860 kg	4800 kg
XT: 2000 kg	2000 kg	2420 kg	3060 kg	3860 kg	5000 kg	5960 kg
Machine Dimension (Apr.)	T: 1090x820x1770	1160x820x1960	1280x865x1980	---	---	---
(L x W x H)	LT: 1420x820x1795	1520x820x1960	1620x865x1980	1720x970x2035	1870x1040x2070	1975x1265x2095
XT: 1820x820x1815	1920x820x1960	2045x865x1980	2170x970x2035	2370x1040x2135	2475x1265x2175	---
Packing Dimension (Apr.)	T: 1410x970x2010	1480x970x2200	1600x1015x2220	---	---	---
(L x W x H)	LT: 1740x970x2035	1840x970x2200	1940x1015x2220	2040x1120x2275	2190x1190x2310	2295x1415x2335
XT: 2140x970x2055	2240x970x2200	2365x1015x2220	2490x1120x2275	2690x1190x2375	2795x1415x2415	---

* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm² tensile.

Design and specifications subject to change without notice.

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



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