

Piranha P-Series Ironworkers



P-50

50 Ton
Single Operator Ironworker

STANDARD FEATURES AND ACCESSORIES

- Automatic Urethane Punch Stripper Attachment
- Push Button and Foot Pedal Control
- Electronic Stroke Control
- Angle Iron and Flat Bar Shear with Quick Adjust Mechanical Hold Down
- Integrated Coper Notcher

P-65

65 Ton
Single Operator Ironworker

STANDARD FEATURES AND ACCESSORIES

- Dovetail Slide Mounting System
- Automatic Urethane Punch Stripper Attachment
- Two Speed Joystick and Foot Pedal Control
- Electronic Stroke Control
- Round/Square Bar, Angle Iron and Flat Bar Shear with Automatic Urethane Hold Down
- Integrated Coper Notcher



Piranha P-Series Ironworkers



P-90

90 Ton
Single Operator Ironworker

P-110

110 Ton
Single Operator Ironworker



P-90, P-110 AND P-140 MODELS STANDARD FEATURES

- Dovetail Slide Mounting System
- Automatic Urethane Punch Stripper Attachment
- Two Speed Joystick and Foot Pedal Control
- Electronic Stroke Control
- Round/Square Bar, Angle Iron and Flat Bar Shear with Automatic Urethane Hold Down
- Integrated Coper Notcher

P-140

140 Ton
Single Operator Ironworker



Piranha PII-Series Ironworkers

PII-88

88 Ton
Dual Operator Ironworker



PII-88 AND PII-140 MODELS STANDARD FEATURES

- Punching and Shearing Ends Can Be Operated Independently at the Same Time
- Two Speed Joystick and Foot Pedal Controls on Punch and Shearing Stations
- Electronic Stroke Control
- Round/Square Bar, Angle Iron and Flat Bar Shear with Automatic Urethane Hold Down
- Integrated Coper Notcher



PII-140

140 Ton
Dual Operator Ironworker

Piranha Standard Features



Features vary by model, P-65 model shown.



Stripping (Punch Station) 1

Conventional Ironworker: Fixed Stripper Plate needs adjustment for each material thickness; Requires extra stroke (slower) and finished part distorts (poor quality).

Piranha Ironworker: Urethane strippers keep material flat (better quality); Shorter stroke (faster) and no adjustment necessary (easier to use).



Hold-downs (Shearing) 2

Conventional Ironworker: Fixed hold-down needs to be clamped/unclamped with each stroke (slow); Material can shift while shearing (less accurate). Inadequate clamping promotes short blade life (more expensive).

Piranha Ironworker: Urethane hold-downs clamp and unclamp the material automatically with each stroke (fast); Parts remain clamped during entire shearing cycle (more accurate); Complete clamping promotes long blade life (less expensive).



Visibility (Shearing) 3

Conventional Ironworker: Cannot see shear blade to line up a cut (less accurate).

Piranha Ironworker: Easily line up a cut line to the shear blade (more accurate).



Shear Blade 4

Conventional Ironworker: High rake angle shear blade distorts the finished part (poor quality); Most manufacturers provide only two blade edges (shorter life/more expensive).

Piranha Ironworker: Low rake angle shear blade results in flatter parts (better quality); Piranha provides four shear edges on each blade (longer life/less expensive).



Angle Shear 5

Conventional Ironworker: Fixed upper blade does not seat in center of angle causing the cut piece to deform (poor quality).

Piranha Ironworker: Floating upper blade seats in center of the angle eliminating distortion (better quality).



Cooper Notcher 6

Conventional Ironworker: High rake angle blade deforms and moves part while notching (poor quality).

Piranha Ironworker: Low rake angle blade keeps part flat and under control during notching (better quality).



Bending Attachment (Optional) 7

Conventional Ironworker: Attachment guided on two sides and must be center loaded. Cannot bend angle iron (hard to use).

Piranha Ironworker: Attachment open ended allowing angle to be bent easily (easy to use).



Installing the Bending Attachment (Optional) 8

Conventional Ironworker: Large, heavy attachment is awkward and time consuming to install (hard to use).

Piranha Ironworker: The dovetail slide makes the bending attachment easy to install (easy to use).



Ease of Use

Conventional Ironworker: Attachments and stations are at different heights (harder to use); The height of a feed table requires manual adjustment for use with each station (harder to use).

Piranha Ironworker: All attachments and stations are at the same height (easier to use); No need to adjust the feed table height between stations (easier to use).

Piranha Ironworker Attachments



A Pipe/Tube Notching Attachment

- Mounts easily to platen
- Spring-loaded return
- Standard die holder accommodates several die sizes
- Allows single notch in Schedule 40 pipe 3/4" through 2" diameter*
- Notching dies available for 3/4", 1", 1-1/4", 1-1/2", 2"
- Attaches to punch end of ironworker

*Contact Piranha for options on larger size or special notching applications.

B Channel Die Block

- Punch channel legs and other structural shapes
- Use standard punch holder and material stripper
- Punch close to material web with offset dies
- Mounts in place of standard die block
- Die is flush with front of channel die block
- Designed to punch a hole in the leg of a 3" through 6" standard weight channel
- Designed to punch a hole in the web of a 4" through 6" standard weight channel
- 50 ton punching capacity for all models
- Uses urethane punch attachment (P-50, P-65, P-90, P-110 and P-140)

Note: The machine stroke control must be used with this option.

C Bending Attachments

- Optional sizes range from 8" to 48". See specifications chart for sizes available for each model.

D 28XX Punch Attachment

- Accommodates all standard 28XX tooling
- Expand punching capacity up to 5"
- Mounts in place of standard punch holder and die block
- Available with or without urethane stripper

Note: Standard 28XX tooling is for 50-ton and lighter applications. For applications greater than 50 tons, a heavy-duty punch is required. Please refer to the Piranha Tooling & Attachments catalog for more information.

E Press Brake Tooling Holders

- Available for models P-65, P-90, P-110, P-140, PII-88, and PII-140
- Allows use of press brake punches and dies for precision bending
- Lengths up to 24"
- Accepts a 1/2" wide by 5/8" tall tang (tooling sold separately)

F Quickset Gauging Tables

- Fast set-up for punching multiple holes
- Includes plate and angle-gauging guide bars
- Left and right hand extensions available in 5' and 10' lengths
- Gauging table mounts on machine platen table without removing punch attachment or die block
- Table and guide bars have measuring rules
- All models have 3 left-hand stops on the table and 6 stops (3 left-hand and 3 right-hand) on the angle guide bar



Piranha Ironworker Attachments



F Channel Shear

- Attaches to punch end of ironworker in place of standard punch holder
- Each cut removes 1/2" slug from standard weight channel
- Slug slides out the front of the shear after each cut
- Pinned slide block adjusts to accommodate different widths of channel
- Quick release locking handle secures material



G Mechanical Backgauges

- Allows quick set-up to repeat shearing length with a mechanical backstop
- Positions in angle, plate and round bar sections
- Lengths available—3', 6', 9', 12'
- Bolts on with no machine modifications
- Easy access of sheared material
- Backgauge allows for infinite adjustment
- Compression sleeve for positive locking and no marring of the gauge bar

- Incorporates all features of the mechanical backgauge
- Available with new machines or as an option for existing machines*
- Dedicated power switch and run light standard
- Lengths available—3', 6', 9', 12'—leg support included with 9' and 12' lengths

*Note: Field installation requires minor modifications to electrical components.

H 1-1/2" Oversize Punch Attachment

- Punches up to 1-9/16" hole within capacity limits of the machine
- Mounts in place of standard punch holder and die block
- Use same stripper action as standard punch attachment
- Use No. EF punches and No. JF dies
- Available in P-50 and P-65 models

I Electrical Backgauge

- Electronic version automatically cycles the ironworker when material contacts the backgauge
- Available for models P-50, P-65, P-90, P-110, P-140, PII-88 and PII-140

- For fast, easy feeding of bar, plate and angle
- Available in 5' increments—bolt together for longer lengths
- Adjust to accommodate floor height and machine type
- Includes rollers for angle and flat bar sections
- 20" wide flat rollers; 6" angle rollers

