

**Name and Address**

**of Manufacturer: THE KINGSLAND ENGINEERING COMPANY LTD  
WEYBOURNE ROAD  
SHERINGHAM  
NORFOLK NR26 8HE  
ENGLAND**

**Year of Manufacture: .....**

**Model Type: COMPACT 40 HYDRAULIC STEELWORKER**

**Serial Number: .....**

**Weight of Machine: 550 KG – 1,209 LBS NET**

**KINGSLAND COMPACT 40 HYDRAULIC STEELWORKER**

This Kingsland Steelworker has been developed to give you, the user, a reliable long service - low maintenance machine tool.

These machines are capable of performing four basic functions, with the facility to add various additional tooling arrangements to complement the fully universal aspects of the Steelworker.

These instructions give general guide lines for the use of the Steelworker, commissioning, operating and maintenance, and should be carefully studied by the installation engineer and operator before the machine is put into operation.

Any assistance regarding the machine, should first be sought from the supplier, or alternatively from the manufacturer:

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## **1 SAFETY NOTES FOR KINGSLAND STEELWORKERS**

In this manual particular references are made regarding aspects of safety and the notes below are intended as a summary to highlight the main areas for your attention.

The machine should be positioned so that the operator has sufficient room to work having regard for long lengths of material which may be punched or cropped. Electrical supply should be by overhead cable to avoid possible cable damage.

It should be considered if additional equipment will be required to safely handle long or heavy items being processed.

Any person who will use the machine should be given adequate instruction on the operation and safety aspects of the machine. Extra copies of this manual are available from the manufacturer.

In addition it should be established which persons shall be responsible for the changing and setting of tools and blades and these persons given a more detailed instruction.

Kingsland machines are supplied complete with various guards and barriers as standard equipment which provide a generally accepted level of guarding when the machine is used for the purpose for which it was designed.

1. The main areas of deviation from design criteria would probably be:
2. The use of materials other than mild steel (45 kg/mm<sup>2</sup>)
3. The incorrect use of material hold-downs
4. The punching, cropping or notching of small items  
(as this would encourage the operator place fingers or hands into danger area).

If at any time additional tooling or equipment is fitted to the machine the question of adequate guarding must be reviewed and the advice of the manufacturer sought if necessary.

All maintenance should be carried out by suitably qualified personnel and particular attention must be paid to the correct setting and alignment of punches and dies, blades and other tools.

## **2 BRIEF SPECIFICATIONS**

The machine has been developed to perform four basic functions:  
Punching, Flat Bar Shearing, Angle and Section Cutting.

### **2.1 MEASUREMENTS** (Full details, see page 22-23.)

Length x Width x Height	1,060 x 550 x 1,480 mm
Die Height from floor	1,075 [mm]
Shear Support from floor	1,075 [mm]
Angle Support from floor	1,210 [mm]

### **2.2 CAPACITIES** (Full details, see page 22-23.)

Punching*	20 dia x 15mm or 30 dia x 10mm or 38dia x 8mm
Shearing	200 x 13mm or 350 x 6mm
Angle Cutting	80 x 80 x 8mm
Section Cutting	30 mm Round, 25mm Square

(All capacities are based on materials of 45 kg/mm<sup>2</sup> Tensile Strength.)

Punch Pressure	400KN or 40 Tons
*Standard Supply Punch & Die	18 mm dia.

### **2.3 STANDARD EQUIPMENT SUPPLIED WITH MACHINE**

Punch Retaining Ring	2557
Punch Adaptors	9035 & 9036
Punch & Die (1 set )	9001 - 18 & 9023 - 19
Punch Bolster	83050
Shear Blade (1 set)	3902 (2 off)
Angle Blades (1 set)	3903 (Arm), 3904 (2 off) (Body)
Section Blades (1 pair)	3906 & 3907

#### **Toolkit containing:**

- Grease gun
- 'C' spanner 80/90
- Open end spanner 13, 17, 24 mm
- Allen keys 4, 5, 8, 10, 14 mm
- Location key 4\*20 mm

### **3 BRIEF DESCRIPTION OF MACHINE**

#### **3.1 PUNCHING** (For details see pages 7-13)

The large punch bed area is designed to give a very wide range of punching applications; with the available optional tooling - large holes of any shape up to diameter/square as shown in the capacity chart can be punched.

Additional tooling in this versatile work station can provide bending (max. length 80mm), corner notching, tube notching and general die-set work.

#### **3.2 SHEARING** (For details see page 14-15)

The shearing unit is fitted with a simple robust hold-down which is adjustable to any thickness of material within the cutting capacity of the machine. A shear feed table with adjustable guides is fitted to allow the accurate feeding of materials. The guide can be adjusted to allow mitre cutting up to 45 degrees for flat bars or to trim the flanges of angle sections previously cut at the angle cutting station.

#### **3.3 ANGLE CUTTING** (For details see page 16-19)

This station provides large capacity angle cutting at 90 degrees and lighter angle cutting at 45 degrees. Angles between 45 and 90 degrees can be achieved by first cutting at 90 degrees and then flange trimming to the required angle in the shearing station.

The hold-down supports the material thus ensuring a true cut.

#### **3.4 SECTION CUTTING** (For details see pages 20-21)

The machines are fitted as standard with blades for cutting round and square bars. With extra equipment, the machines are able to cut, in this aperture, Channels, Joists and Tee Sections. The blades are retained by simple clamps, allowing easy changes without the need for elaborate setting.

### **3.5 FURTHER INFORMATION**

#### **3.5.1 System Pressure**

To check any operational loadings, a pressure gauge can be fitted at the manifold position. The max. system pressure has been set at the works to 250 bar (3,600 P. S. I.) which is below the max. continuous working pressure of the pump, thereby giving increased reliability.

#### **3.5.2 Cleaning**

On arrival, all anti-corrosion lacquer should be removed from the machined bright parts with petroleum solvent. When the machine is operational, all visible working parts should be regularly cleaned of foreign matter, thus preventing excessive wear and possible failure.

#### **3.5.3 Lifting**

The machine is supplied with a lifting eye, mounted on top of the machine. All lifting and manoeuvring should be carried out using this eye along with a suitably rated chain or sling. The eye can be removed if desired after final siting of the machine and the hole should be blanked off.

**DO NOT USE SLINGS UNDER MACHINE!**

#### **3.5.4 Installing**

Locate the machine on a solid foundation allowing sufficient area all round for easy working and maintenance. The machine may be used free standing, but bolting to the foundation is recommended. With the machine mounted directly on the floor - this gives a comfortable working height.

#### **3.5.5 Electrical Supply**

Input wires should arrive at the machine via suitably protected underground supply directly into the electrics box in the base of the machine. As an alternative by overhead supply to the top of the machine and routed inside the top guard and hydraulic pipe trunking to the electrics box. A 30 amp isolating switch, fuse and appropriate cable should be used for mains supply connection. The circuit provides protection against sustained over-load and phase failure. Should the machine cut out during an operation or whilst running, the cause of the problem should be investigated to prevent re-occurrence.

### **IMPORTANT**

**Motor rotation MUST be as arrow on motor fan end cover!**

**This machine will not operate if the motor is running in the wrong direction. It must be stressed however that the motor must not be allowed to run in the wrong direction for more than a few seconds, as this will cause seizure of the pump. To check motor direction start and stop motor with foot on footswitch if machine does not operate reverse two of the incoming 3 phase connections.**



### **3.6 SAFETY POINTS**

- All adjustments, setting, change of tooling and maintenance must be carried out by a suitable qualified engineer in accordance with the manufacturers instructions.
- Remove off-cuts, slugs and any other waste from around the machine before leaving the work station.
- The operator should check all tooling is in good condition before operating machine.
- All stations should be checked for obstructions.
- Heavy work should be supported by a sound work steady.
- The machine should never be left running while unattended.
- When leaving, the machine **MUST** be switched off.

### **3.7 OVERLOADING**

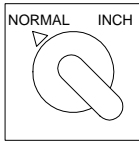
In the event of an accidental overload to the hydraulic circuit, the oil will be diverted direct back to the tank via a relief valve, until the overload condition is removed.

IT MUST BE STRESSED HOWEVER IT IS NOT ADVISABLE TO EXCEED THE CAPACITY OF THE MACHINE USING RELIEF VALVE AS A SAFETY VALVE.

### **3.8 WARNINGS AND DANGERS**

Any point of the machine painted YELLOW should be treated as a danger area. Operators should be instructed not to extend any finger or limbs into or beyond the vicinity of the warning labels. Any guards or hold downs removed for maintenance or adjustments **MUST** be replaced before the machine is put back in service.

### 3.9 OPERATING MODE SWITCH



The Operating Mode Switch has two positions - **NORMAL** and **INCH**. With the switch set to **INCH** all work stations are in the slow speed Inching Mode.

#### 3.9.1 Inching Positon

In Inching position the arm will travel down slowly when footswitch is fully depressed. The arm will remain in any position when foot is removed. Turn switch to **NORMAL** to return arm to top of stroke. All tool setting and adjusting and setting of stroke limit switches should be done in the Inching position.

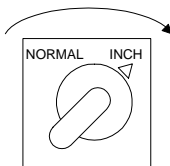
#### 3.9.2 Normal Operating

With Selector Switch to **NORMAL** the arm will travel down at operating speed when footswitch is fully depressed and will return to top of stroke when foot is completely removed.

The footswitch does however have three “positions” giving the very useful facility that after bringing the arm down by full depression of switch, the arm may be held in any position of the stroke by raising the foot to the mid-position. Remove foot and arm will return to top position.

#### 3.9.3 Punch and Die Alignment

Should be checked before using, and **MUST** be checked after punch and die changes have been made.



To check alignment switch mode of operation **INCH**, then inch the punch down by fully depressing the footswitch. Care must be taken as the punch approaches the die, if misalignment is apparent remove foot from switch.

To align punch and die release bolster fixing screws, operate the foot switch with care, aligning the bolster containing the die to the punch, the punch will stay in the down position. Centralise the die clearance around the punch, clamp the bolster in position, tighten die retaining screw, check die maintains in the central position after clamping. Return punch to top position by switching back to run position.

## **4 PUNCHING WORK STATION**

### **4.1 GENERAL DESCRIPTION**

The punch station is a particular well equipped station. It offers many features normally associated with much larger machines.

The large punch bed area is designed to give a very wide range of punching applications. The punch table is particularly useful when the side and back stops are set for small repetitive work. This coupled with a finely adjusted stroke length gives a very productive machine. The table is assembled in two parts of which the front is removable for flange punching.

The punch is retained by means of locking ring part 2557, the punch depending on its size may use one of the two adaptors supplied. The die is retained in the bolster by a set screw, ensure the screw locates correctly on the machined flat on the die when shaped punches and dies are being aligned.

The punch stripper plate must be correctly adjusted allowing sufficient clearance for placing and removal of material, but must NOT restrict the punch stroke, ensure the bottom stroke limit switch is correctly adjusted. Punch holes with sufficient material around the hole so that contact will be made on both sides of the stripper plate. Stripping forces can be severe and unbalanced stripping forces, due to contact on one side stripper, may cause punch breakages. When using stripper fingers for oversize holes or irregular shapes position and adjust fingers equally so as to avoid unbalanced stripping loads.

Additional tooling in this versatile work station can provide bar bending, corner notching, tube notching and general die-set work.

**WHEN ORDERING REPLACEMENT PUNCHES AND DIES, ALWAYS  
QUOTE - MODEL, TYPE AND SERIAL NUMBER OF MACHINE.**

## **4.2 PUNCH TOOLING**

The Punch and Die should be checked for alignment, prior to punching any material. Standard size fitted 18mm, unless specifically ordered otherwise.

### **4.2.1 Tooling Changes**

**Punch:** To change punch, unscrew locking ring using 'C' Spanner from tool kit, replace punch and retighten locking ring. Adaptors are supplied to suit various punch head sizes.

**Die:** To change die, slacken set screw in side of bolster, remove die and replace with new die, retighten set screw.

After replacing punches and dies, it is important that they are correctly aligned. See page 6 for alignment procedure under the heading 'Safety Points'. Extra care must be taken when fitting square or shaped punches that they are correctly aligned before operating machine.

## **4.3 PUNCH TOOLING - GENERAL GUIDES**

1. The punch stripper plate must be adjusted correctly with sufficient clearance to allow positioning and removal of the material being punched.
2. Punch holes with sufficient material around the hole so contact is made on both sides of the stripper plate. Stripping forces can be severe. Unbalanced stripping forces may cause punch breakage.
3. Liberal oiling of the punch will considerably lengthen the life of the punch and die and also help reduce the stripping forces.
4. The quality of the hole (or blank) is an immediate indication of the condition of the punch and die.
5. Do not punch material thicker than the punch diameter, this overloads the punch and can result in breakage.
6. Punch full and complete holes, do not punch partial holes unless tooling is specifically designed to do so.
7. When punching small items (i.e. small pieces of plate, bar etc) these items **MUST** be placed and extracted with suitable handling aids, extra guarding may be required too ensure operator safety.
8. Stay within the rated capacity of the machine.

#### **4.4 PUNCH AND DIE LUBRICATION**

It is recommended that one of the following oils is applied by brush to the punch and die or both sides of the material being punched.

SHELL	- GARIA 927
B. P.	- SERVORA 68
CASTROL	- ILOBROACH 219
DUCKHAMS	- ADFORNOL EP7

**Die clearance: It is normal practice to aim for a clearance of 10% material thickness.**

Because of the radial action of the punching stroke, the dies must never have less than 0.4 mm clearance.

Whether clearance is added to the size of the die or deducted from the size of the punch, depends on the nature of the work. When holes of a given size are required the punch is made to size and the die is made larger. Conversely, when blanks of a given size are required the die is made to size and the punch smaller.

Special clearance dies for thin sheet and plate punching, or size dies and special clearance punches can be supplied to order.

#### 4.5 PUNCHING CAPACITY

If you want to calculate the max. Material thickness / max. hole sizes use one of the following formulars:

**Constant / Material Thickness = max. Diameter**

**or:**

**Constant / Diameter = Max. Material Thickness**

The machine constant is:

Compact 40      300

##### 1. **Example:**

You are going to work with a material of 12mm thickness on a Compact 40 machine.  
The max. hole size is then calculated by:

$$300 / 12 = 25 \text{ [mm]} \quad \Rightarrow \text{The max. hole size is 25mm.}$$

##### 2. **Example:**

Your punch / die diameter is 28mm.

The max. material thickness you can punch is calculated by:

$$300 / 28 = 10.7 \text{ [mm]} \quad \Rightarrow \text{The max. material thickness is 10mm.}$$

This system will probably prove to be convenient because when the machine capacity constant has been memorised, no tables or graphs are required to establish max. diameters through a known thickness of material.

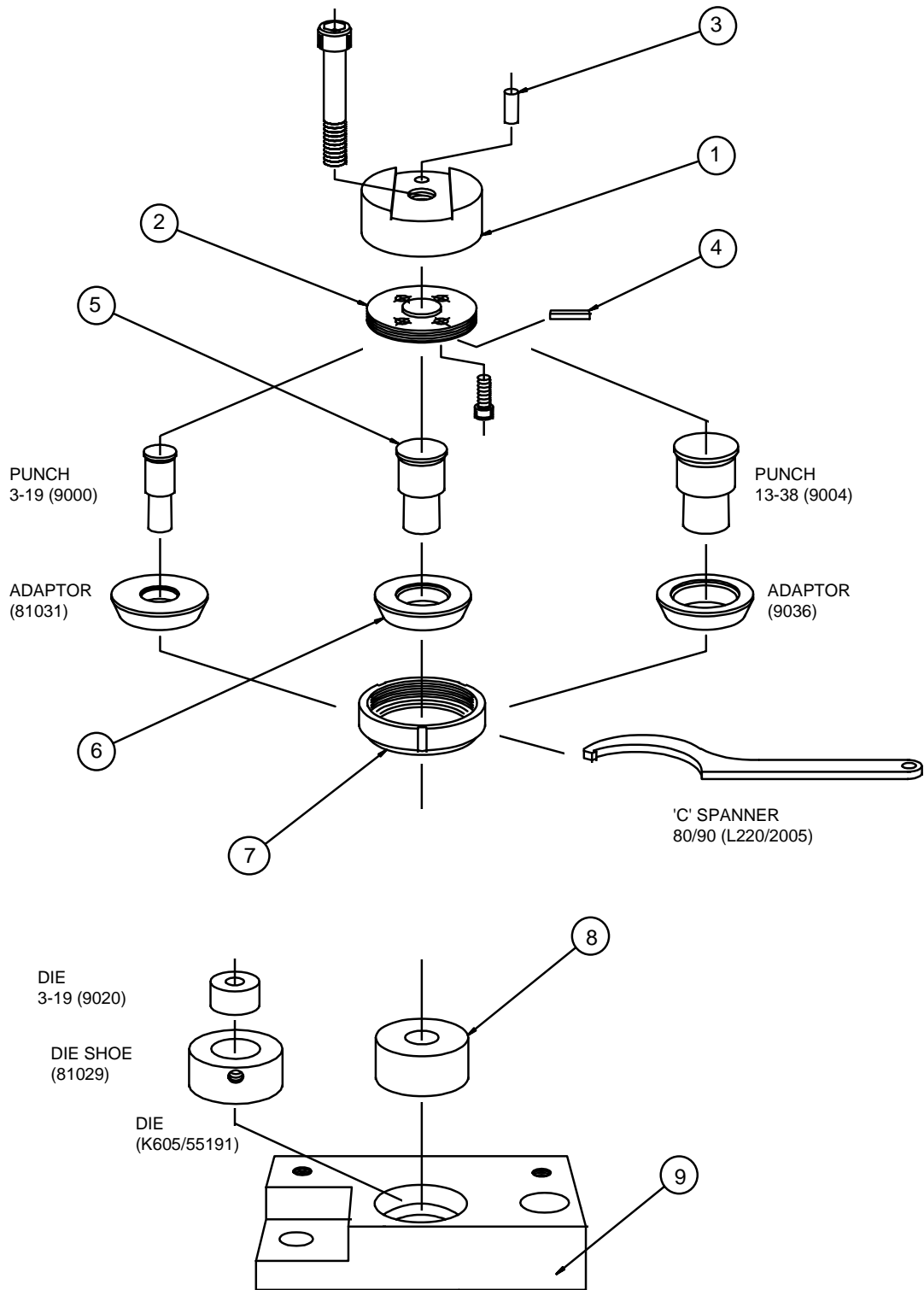
Please Note:

**DANGEROUS PRACTICE:**  
**DO NOT ATTEMPT TO PUNCH MATERIAL**  
**THICKER THAN THE PUNCH DIAMETER!**

##### Note:

All capacities are based on materials to be punched having a tensile strength of 45 kg/mm<sup>2</sup>.  
Always keep within the rated capacity of the machine and never attempt to punch a hole smaller in diameter than the thickness of material being punched.

**4.6 STANDARD PUNCH TOOLING**



In the following table you can find a list of the standard punch tooling for a **Compact 40**. It includes equipment which is supplied as standard with the machine. The standard punch tooling includes an 18mm punch (9001) and die (9023). Other punches and dies are available on request.

<b>No.</b>	<b>Part No.</b>	<b>Description</b>	<b>No. off</b>
<b>1</b>	3905	punch block	1
<b>2</b>	2093	pressure plate	1
<b>3</b>	3944	dowel	1
<b>4</b>	L805/2700	punch location key	1
<b>5</b>	9001-18	Punch – 18 mm dia.	1
<b>6</b>	9035	Adaptor	1
<b>7</b>	2557	retaining ring	1
<b>8</b>	9023-18	Die – 18 mm dia.	1
<b>9</b>	83050	bolster	1

#### **4.7 LARGE HOLE PUNCHING**

Extra equipment available for punching up to 57mm dia.

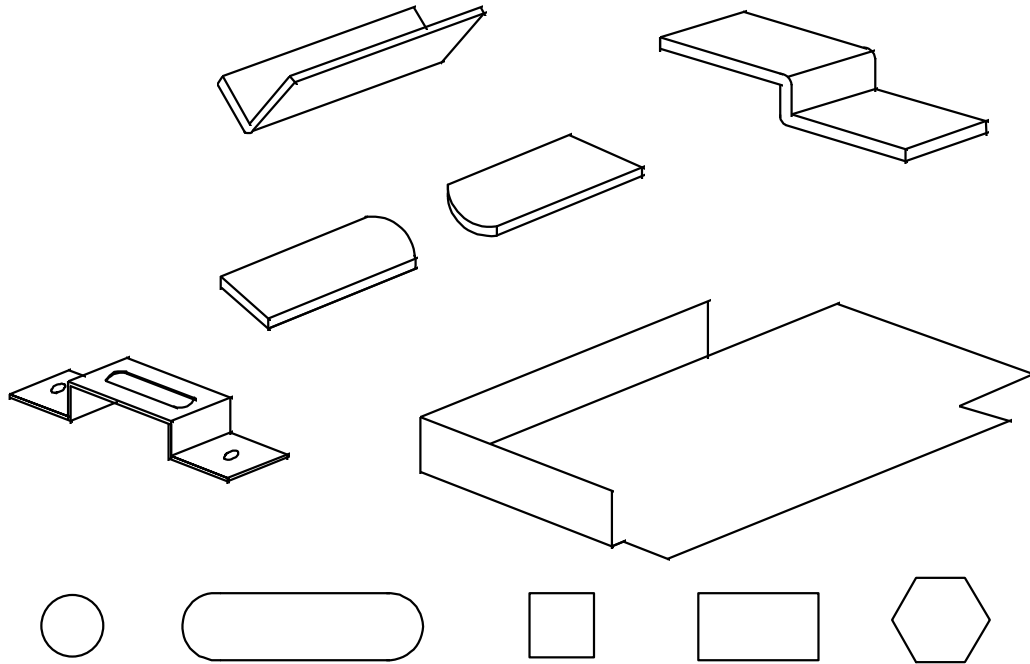
This unit comprises:

- Special ram pressure plate
- Adaptors
- Retaining Ring
- Bolster with die holder plates
- Large hole stripper head



## 4.8 TYPICAL APPLICATIONS

( achieved with special tooling at punch station )



## **5 SHEARING STATION**

### **5.1 DESCRIPTION**

The shearing unit is fitted with a simple robust hold-down which is adjustable to any thickness of material within the cutting capacity of the machine. A shear feed table with adjustable guides is fitted to allow the accurate feeding of materials. The guide can be adjusted to allow mitre cutting up to 45 degrees for flat bars or to trim the flanges of angle sections previously cut at the angle cutting station.

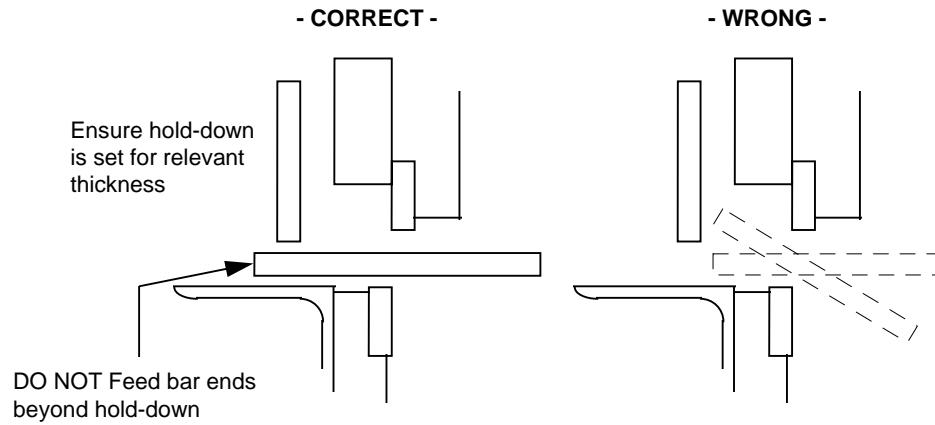
The standard shear blades as fitted permit the bottom blade to be turned four times giving new cutting edges, whilst the top blade must be ground to sharpen the cutting edge. These blades give minimum distortion from full capacity down to as light as 2mm thickness.

When the shear blades require sharpening, grind only on the cutting faces - max. regrinding 0.80mm, after grinding the blades must be adjusted to a clearance of 0.10mm. Adjusting screws have been provided to reset the shear blades, the adjusting screws are positioned around blade fixing screws, accessible when shear table has been removed. Even clearance between top and bottom blades is important along the entire blade length and care should be taken to ensure that the bottom blade is in a vertical plane, parallel to top blade.

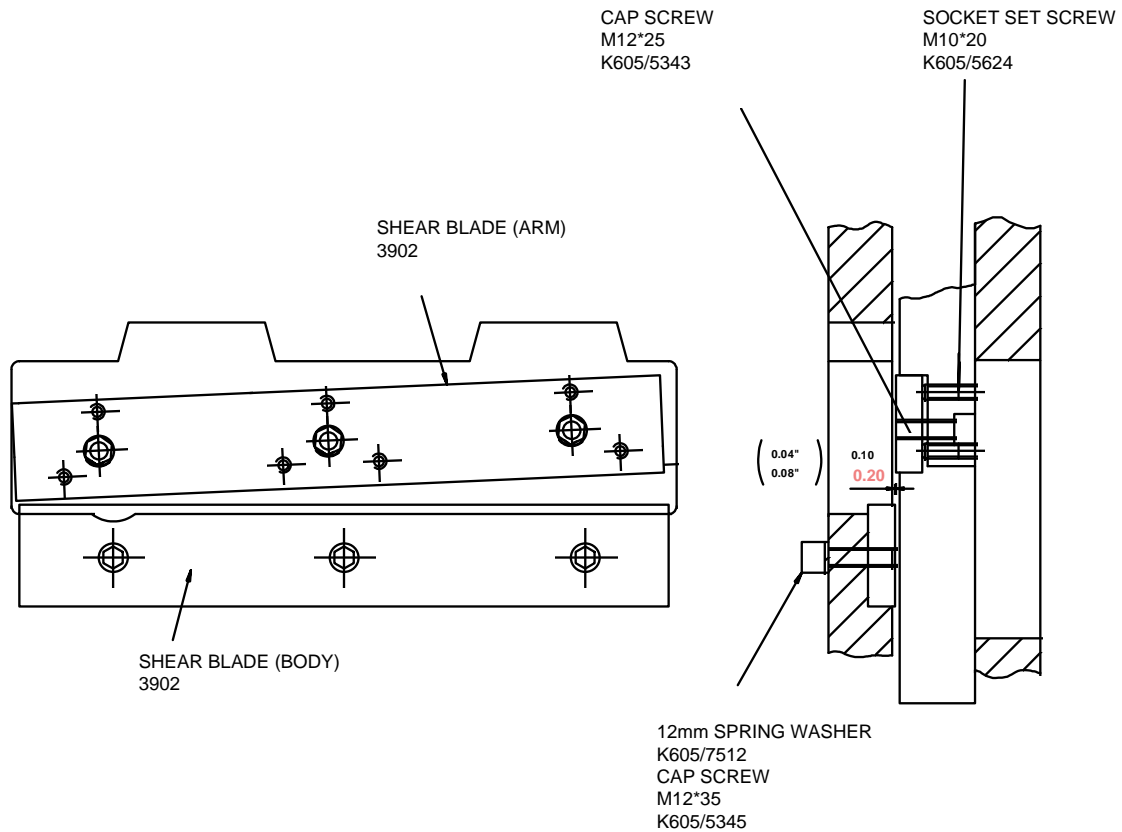
**WHEN ORDERING SPARE BLADES, ALWAYS QUOTE -  
MODEL, TYPE AND SERIAL NUMBER OF MACHINE.**

### **5.2 SHEAR TOOLING - GENERAL GUIDES**

1. The quality of the cut is an immediate indication of the condition of the blades.
2. Ensure hold-down is always set for relevant thickness of material being sheared.  
DO NOT allow ends of bars to be fed beyond the hold down, because bar would tend to twist between blades and cause body distortion.
3. Always feed material between blades from the hold down side.
4. Keep the blade area clean. Do not allow 'build up' of mill scale.
5. Stay within the rated capacity of the machine.



**5.3 SHEAR BLADES**



## **6 ANGLE CUTTING**

### **6.1 DESCRIPTION**

This working station provides large capacity angle cutting at 90 degrees and lighter angle cutting at 45 degrees.

To cut angle section, place the material through the hold down into the cutting area, adjust the support screw to the material but leave sufficient clearance to enable the section to be fed on for progressive cutting.

#### **To mitre cut at 45 degrees:**

firstly cut the angles to length allowing approx. 12mm oversize for end trimming.

1. Place the first end into the blade using the higher support position, trim approx. 6mm off the end of the section whilst maintaining 45 degrees to vertical position.
2. Place the other end into the blade using the left hand support position, trim section to length whilst maintaining 45 degrees to face of machine position.

To achieve other angles of cut between 45 degrees and 90 degrees, first cut the angle section to length and then trim the flange to required angle in the shear station.

The slot in the shear hold down allows angle sections to be positioned for left hand on right hand trimming, ensure hold down is set for relevant thickness.

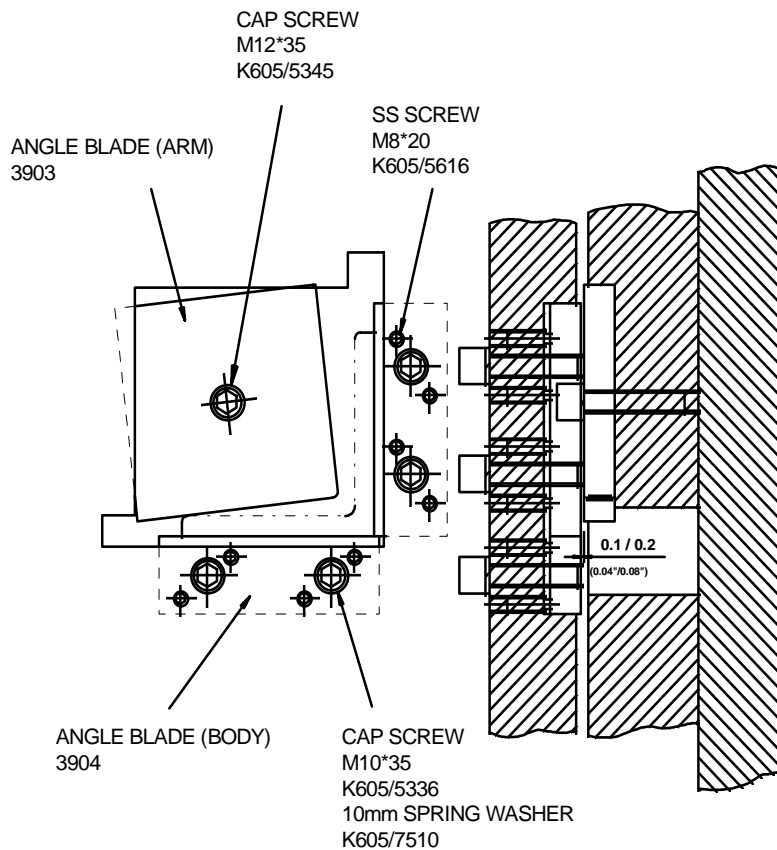
Each cutting blade has four cutting edges and is retained by simple fixing screws.

**DO NOT sharpen these blades, after turning four times replace with new blades.**

**WHEN ORDERING REPLACEMENT BLADES, ALWAYS QUOTE -  
MODEL, TYPE AND SERIAL NUMBER OF MACHINE.**

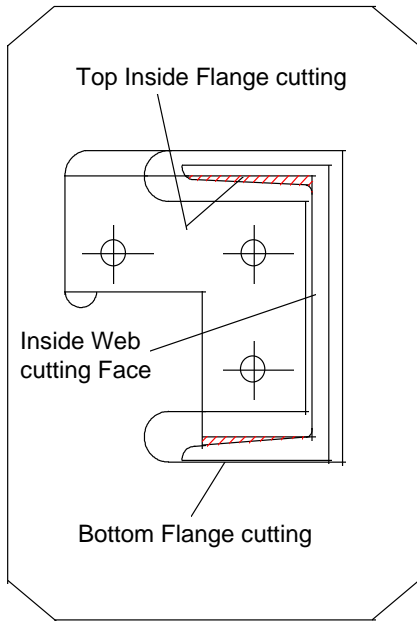
**6.2 ANGLE TOOLING - GENERAL GUIDES**

1. The quality of cut is an immediate indication of the condition of the blades. Keep sharp, keen cutting edges.
2. Ensure support screw is set for relevant thickness of material being cut.
3. Always feed material between blades from hold down side.
4. Keep cutting aperture clean, small slivers, short cuts and any other pieces should be removed from the blade area. **DO NOT** allow mill scale to 'build up' in the blade area.
5. Stay within the rated capacity of the machine.



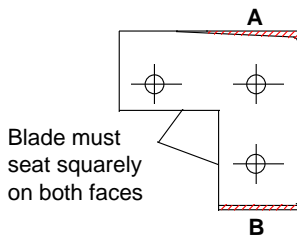
**6.3 GRINDING OF CHANNEL INSERT BLADES**

**Body Blade**



Fit blade to carrier, retain position with three screws, ensure blade is seating on both faces, see sketch. Mount a sample of channel, with a cleanly cut end, on to the blade with the bottom flange in line with bottom cutting face and the inside of the web square and in line with the inside web cutting face, as shown in sketch.

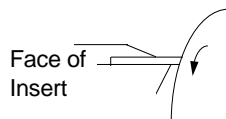
Having mounted channel correctly, scribe round inside of channel flanges.



- Remove blade from carrier.
- With 'mark out' A continue inner flange line as shown.
- With 'mark out' B continue line from radius square to cutting face. Allow a small clearance when grinding to permit easy passage of channel.

**Grinding**

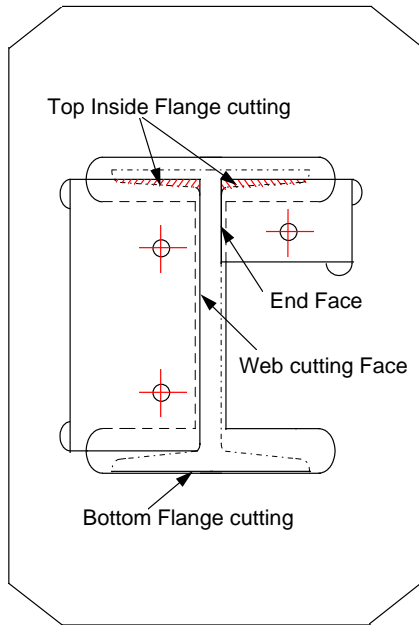
Grind insert blades to lines scribed, shown shaded in sketch.



When hand grinding, if using face of grinding wheel, ensure angle between face of insert and cutting face does not exceed 90 degrees.

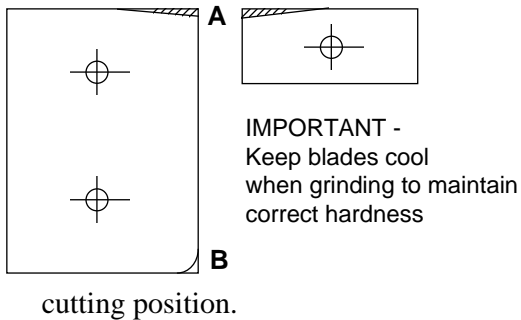
**6.4 GRINDING OF JOIST INSERT BLADE**

**Body Blade**



Fit blades to carrier, retain positions with fixing screws, ensure blades are seating correctly. Mount a sample of joist, with a cleanly cut end, on to the blade with the bottom flange in line with **BOTTOM CUTTING FACE** and the web square and in line with **WEB CUTTING FACE**, as shown in sketch.

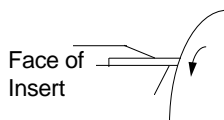
Having mounted joist correctly, scribe round inside of joist flanges.



- Remove blades from carrier.
- With 'mark out' A continue inner flange line of required.
- With 'mark out' B radius to suit that of sample joist.
- The **END FACE** may require clearance to permit easy passage of joist for heavy or light sections, when blades are in

**Grinding**

Grind insert blades to lines scribed, shown shaded in sketch.



When hand grinding, if using face of grinding wheel, ensure angle between face of insert and cutting face does not exceed 90 degrees.

## **7 SECTION CUTTING**

### **7.1 DESCRIPTION**

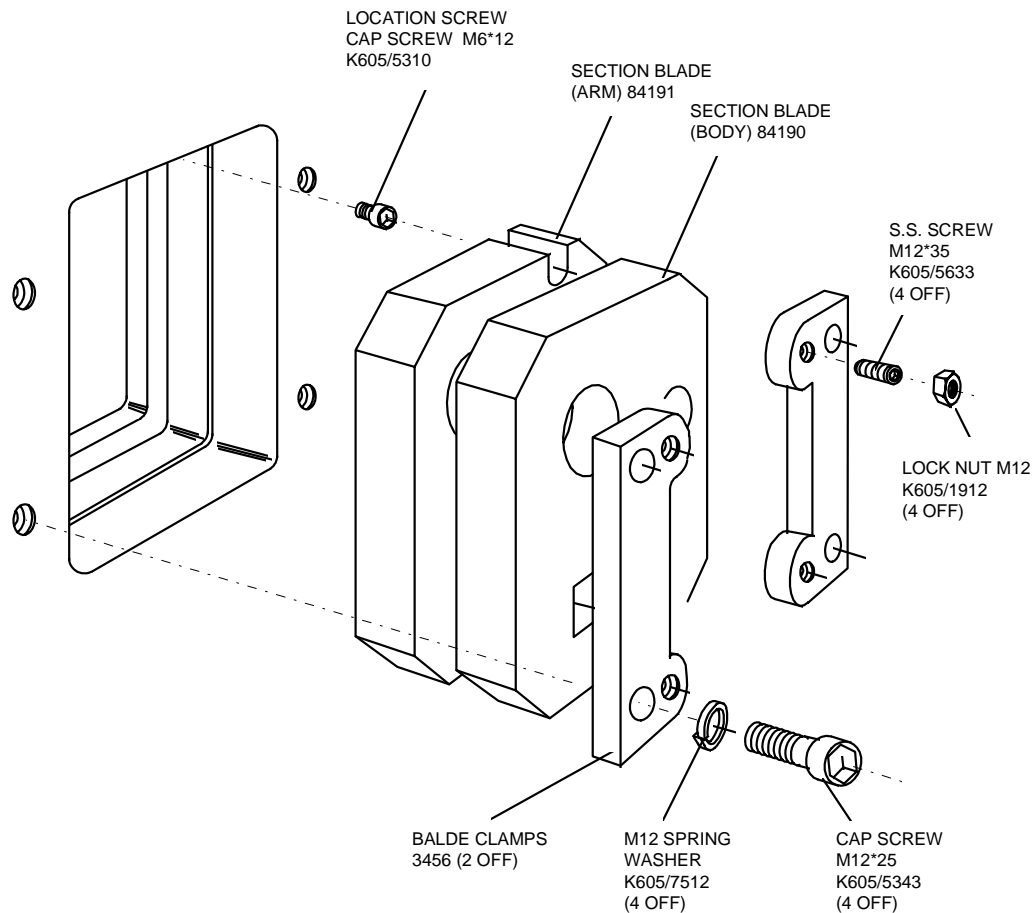
A variety of sections can be cropped at this aperture - round and square sections, unequal angle, channel, joist etc.

Blades for round and square section cropping are fitted as standard equipment and have apertures of varying sizes. The smallest aperture should be chosen, which will accept the material, thus ensuring a complete and well supported cut.

To change the blades, the material support must be removed. Release the four screws securing the blade clamps, remove blade clamps then withdraw the blades.

It will be noticed that the arm blade is smaller than the body blade.

This safeguards incorrect assembly when inserted carrier blades are used. Also notice the safety peg, there is a safety slot in the arm blade to prevent incorrect positioning.



#### **To set blade clearance:**

Ensure arm blade is properly seated in shear arm.

Position body blade in frame firmly pushed against arm blade.

Secure blade clamp to frame.

Tighten the four SS screws, then release each one 0,2 of a turn.

Thigten locknut whilst holding the SS screw with alan key.



**IMPORTANT:**

- ⇒ Never remove screw fitted as safety peg in the arm blade milled recess.
- ⇒ In the case of worn solid blades, new blades must be fitted.  
DO NOT attempt to regrind faces; this makes blades undersize for secure fitting.
- ⇒ In the case of worn insert blades, new inserts can be supplied for grinding to worn sample.
- ⇒ When fitting new blades reverse the removal procedure.
- ⇒ The blade clamps are marked (RH) right hand and (LH) left hand, ensure they are replaced correctly.
- ⇒ To cut sections place the material through the hold down into the cutting area, adjust the hold down screw (if fitted) to achieve square cut.

**WHEN ORDERING SPARE BLADES, ALWAYS QUOTE-  
MODEL, TYPE AND SERIAL NUMBER OF MACHINE.**

**7.2 SECTION TOOLING - GENERAL GUIDES**

1. The quality of the cut is an immediate indication of the condition of the blades.  
Keep sharp, keen cutting edges.
2. Ensure bar sizes are used in smallest aperture that will accept them, ensuring well supported cut.
3. Always feed material between blades from hold down side.
4. Keep cutting aperture clean, small slivers, short ends and any other pieces should be removed from the blade area. DO NOT allow mill scale to 'build up' in the blade area.
5. Stay within the rated capacity of the machine.

## **8 FURTHER INFORMATION**

### **8.1 CAPACITIES COMPACT 40**

<u>8.1.1 Punching</u>	<u>Metric (mm)</u>
Max. Capacities	20 x 15
Dia. x Thickness	30 x 10 or 38 x 8
Max. Stroke Length	32
Speed - 16mm travel	23 full cycles/min
Throat Depth	175
Working Height	1,075

### 8.1.2 Shearing

Flat Bar	200 x 13
Alternative	350 x 6
Blade Length	356
Angle Flange Trim (max 45°)	80 x 80 x 10
Working Height	1,075

### 8.1.3 Angle Cutting

At 90°	80 x 80 x 8
At 45°	50 x 50 x 6
Working Height	1,210

### 8.1.4 Section Cutting

Round/Square Bar	30 / 25
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## **8.2 SPECIFICATION**

Motor	3 kW
Nett Weight	550 Kg
Gross Weight	620 Kg
Machine Dims.	106 x 55 x 148 cm
Packed Dims.	115 x 62 x 163 cm

**8.3 ADDITIONAL TOOLING****Section Crop**

Channel / Beam	76 x 38
Tee	38 x 38 x 6

**Large Hole Unit**

Dia. x Thickness	57 x 6
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**Bending**

Max. Bar Size	80 x 10
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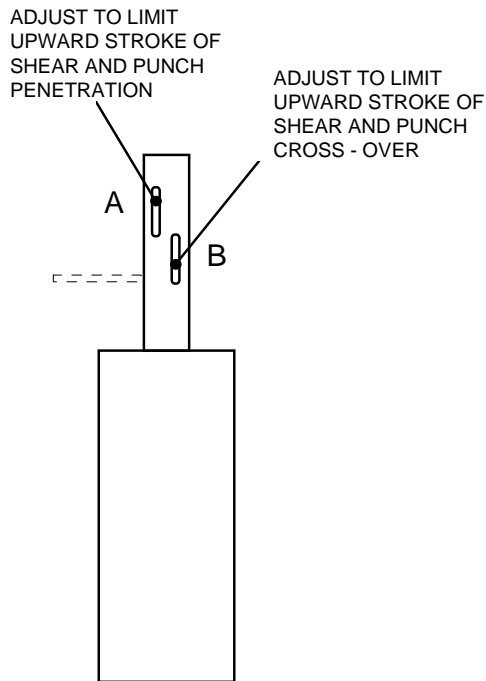
**Notching**

Material Thickness	8
Width	35
Depth: Vee - Rect.	55 - 65

**Tube Notch**

Max. Diam.	40
------------	----

## 8.4 STROKE ADJUSTMENT



Stroke adjustment 'A' and 'B' can be adjusted by loosening the relevant actuator and sliding the actuator to the desired position.

To reduce punch clearance stroke:  
- set actuator 'B'.

To reduce shear clearance stroke:  
- set actuator 'A'.

To adjust for air bending penetration:  
- set actuator 'A'.

A correctly set machine will considerably reduce operating times when stroke lengths are kept to a minimum.

### **8.5 HYDRAULIC SYSTEM**

A 3 kW Motor drives a hydraulic pump, which through control valves feed the power cylinder of the machine. The cylinder is connected to a pivoted arm.

Hydraulic Oil - refer to the recommended oils label. The oil filler/breather is positioned on the tank accessible by removing the louvred cover at base of the machine.

Suction Strainer - inspect oil strainer every twelve months. The strainer is accessible, having released the screws in tank cover, if necessary wash in paraffin (Replacement L820/5020).

Sludge Tray - whilst lower cover is removed, check tray located under main frame once every twelve months.

### **8.6 CLEANING**

Under normal operation, all visible working parts should be regularly cleaned of foreign matter, thus preventing excessive wear and possible failure.

### **8.7 REGULAR MAINTENANCE**

- Daily** - Before starting machine -  
Check fluid level in tank - top up as necessary.  
Check condition of all blades, punch and die.  
Check surrounding work area is tidy, remove any off-cuts, slugs from floor area.  
Clean off any mill scale which may have collected around the cutting apertures.
- Weekly** - But depending on work load  
Examine power cable and foot pedal cable for damage or chafing.  
Check movement of machine is smooth when running under no load condition.
- Monthly** - Check arm adjustment for any slackness.
- Yearly** - Change hydraulic fluid, inspect oil suction strainer.

**8.8 HYDRAULIC FLUID**

Fill to top level of inspection glass. Use only mineral oil as recommended or equivalent.

Castrol	Hyspin AWS32-6018
B. P.	Energol HLP32
Shell	Pollus 37
Mobil	DTE 24
Esso	Nuto H32

**8.9 PERIODIC LUBRICATION**

The machine is fitted with 6 grease nipple points. These points should be lubricated periodically (6 - 8 hours) using the grease gun from tool kit.

Gease Total SRC 2 or equivalent is recommended.

**8.10 MACHINE ARM ADJUSTMENT**

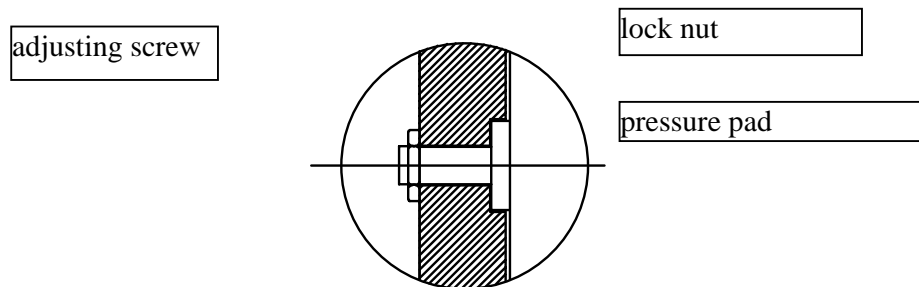
The Shear Arm is adjusted by four 24mm Socket Set Screws which apply pressure to the Internal Bronze Pressure Pads. These are located on the Feed (Hold Down) Side of the machine as shown in the figure below.

**Adjusting Arm**

Isolate machine before making any adjustments.

1. Slacken locking nuts at the four pad positions only (M24 lock nuts).
2. Turn adjusting screws clockwise until slight resistance is felt.
3. Tighten lock nuts and test movement of arm.

N. B. The arm should be adjusted prior to any adjustment of the shear blade.



**8.11 PARTS LIST**

When ordering spares always quote model, type and Serial Number of Machine.

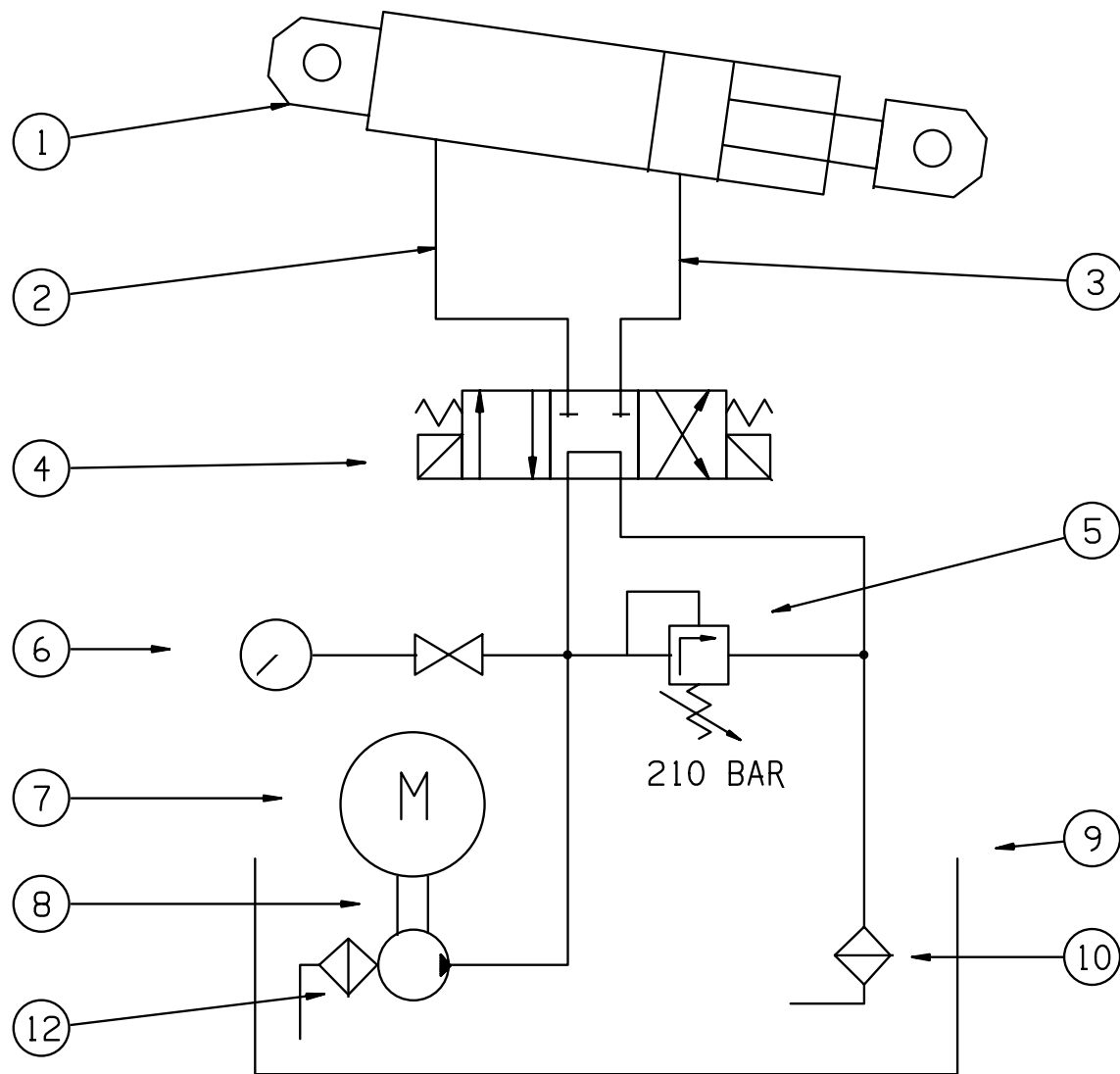
<b>Nr.</b>	<b>Part No.</b>	<b>Description</b>	<b>No. off</b>
1	3855	Clevis	1
2	3860	Main pivot	1
3	3858	Cylinder pin	2
4	3892	Main pivot bush	1
5	K205/0522	Bush	
6	3860	Main pivot	1
7	3861	Main arm	1
8	3899	Top cover	1
9	3900	End cover	1
10	3914	Base cover	1
11	L815/4000	Hydraulic cylinder	1
12	1202	Power pack assy	1
13	2093	RAM pressure plate	1
14	L605/2626	notch / shear guide	1
15	2557	Punch retaining ring	1
16	3456	Blade retainer	2
17	3889	Angle Hold down screw	1
18	3890	Hold down assy	1
19	3921	Shear table	1
20	3925	Shear table angle	2
21	3902	Shear blade	2
22	3903	Angle blade arm	1
23	3904	Angle blade body	2
24	3905	Punch block	1
25	84191	STD sect/bld arm	1
26	84190	STD sect/bld body	1
27	3908	Stripper	1
28	3911	Apert cover angle/sect	2
29	4260	Lmt switch actuator	2
30	3916	Shear chute	1
31	3917	Shear apert cover	1
32	3918	Punch table	1
33	3919	Punch table extension	1
34	3941	Stripper guard	1
35	83050	Bolster	1

<b>No.</b>	<b>Part No.</b>	<b>Description</b>	<b>No. off</b>
<b>36</b>	9001 - 18	Round Punch 18mm	1
<b>37</b>	9023 - 18	Round Die 18mm	1
<b>38</b>	9035	Punch adaptor	1
<b>39</b>	K411/338282	Micro switch	2
<b>40</b>	K411/319938	Micro switch cover	2
<b>41</b>	K410/1036	24V DC electrical box	1
<b>42</b>	K410/7009	Foot switch	1
<b>43</b>	87205	Round/square section hold down	1
<b>44</b>	L515/4107	Punch end side cover	1
<b>45</b>	L515/4108	Hold down cover	1
<b>46</b>	L515/4109	Hold down cover	1
<b>47</b>	L605/3920	Punch table support bar	2



**9 CIRCUITS**

**9.1 HYDRAULIC CIRCUIT**

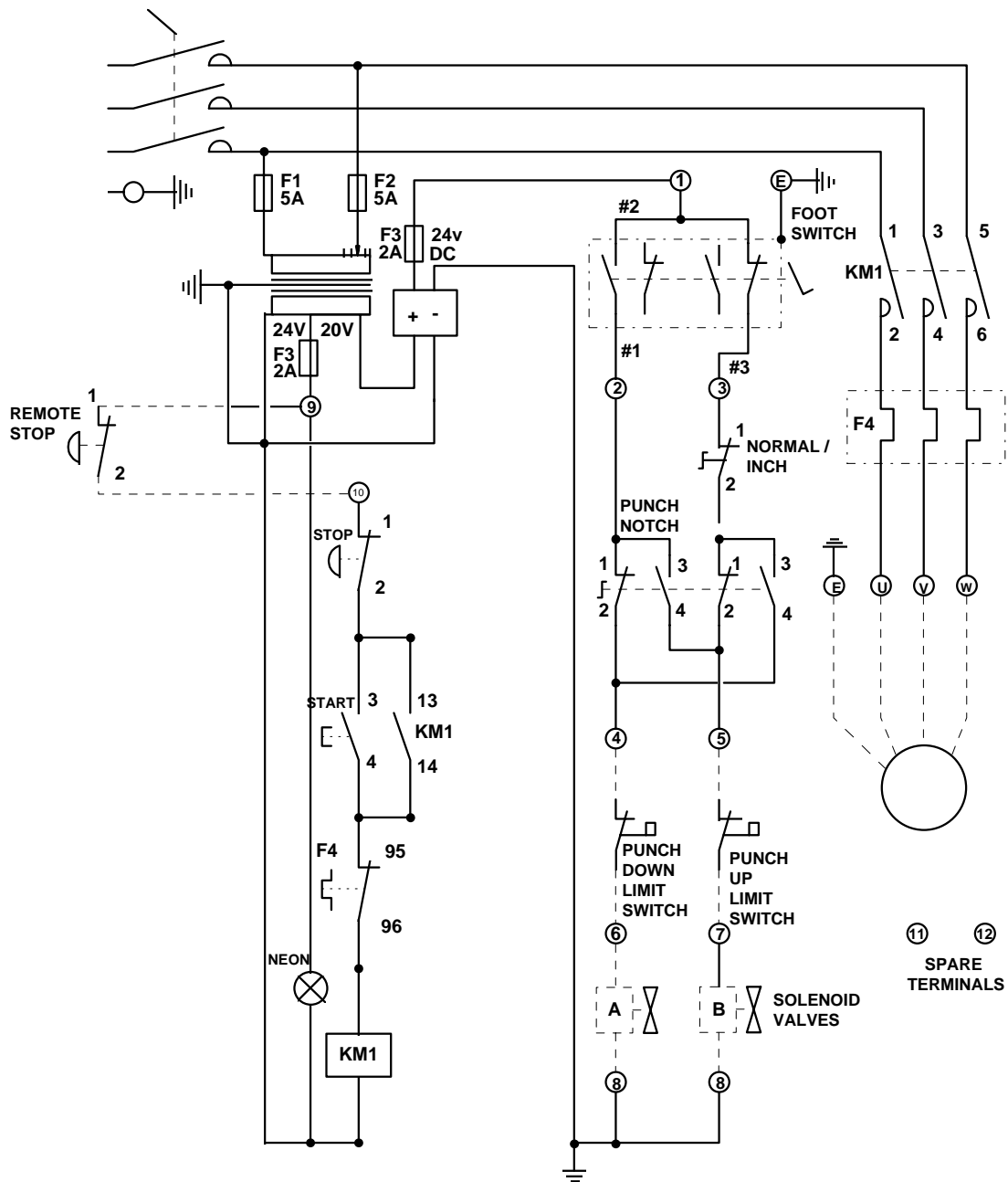


**Parts of the Hydraulic Circuit:**

<b>No.</b>	<b>Description</b>	<b>No. off</b>
<b>1</b>	Hydraulic cylinder	1
<b>2</b>	Flex Pipe A	1
<b>3</b>	Flex Pipe B	1
<b>4</b>	Direction control valve	1
<b>5</b>	Relief valve	1
<b>6</b>	Pressure Gauge	1
<b>7</b>	Motor 3 kW	1
<b>8</b>	Drive coupling	1
<b>9</b>	Tank ( 40 l )	1
<b>10</b>	Diffuser	1
<b>11</b>	Hydraulic Pump	1
<b>12</b>	Suction strainer	1

The pressure gauge must only be used for power pack setting and servicing.  
Isolate gauge after use by closing stop valve.

9.2 ELECTRICAL CIRCUIT



**10 SOUND LEVEL TEST**

**10.1 MAX. SOUND PRESSURE LEVEL**

**RESULT SHEET**

**Site:** Kingsland Engineering  
**Date:** 09.06.1993  
**Monitoring Equipment:** RS 292 + RS 294

MACHINE UNDER TEST	MONITORING POSITION	TIME IN USE	5 min. LEQ	MAX SPL	MIN SPL	AVG SPL	COMMENTS
Kingsland 40 XM	1m	-	-	72 dB	-	-	-

**10.2**