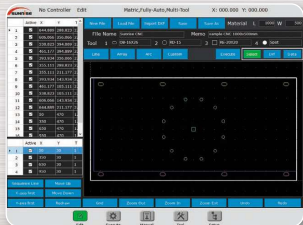


### IW-165SD with dual CNC positioning systems

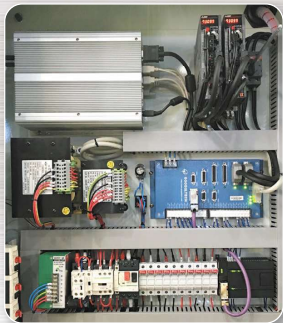
- Semi-automatic 3000x400mm table with PC based controller for punching station.
- CNC feeding table with Omron PLC based controller for flat bar shear station.
- Hydraulic stripper, hydraulic angle shear holddown, and hydraulic holddown for flat bar shear.
- Very user friendly interface for easy operation.
- Oil cooling system.
- Tool lubrication system.



### PC Based Controller



- Touch screen
- Intel CPU and MS Windows
- USB and Ethernet ports for flexible connectivity
- Direct ACAD.dxf file import
- Real time graphic preview and scaling
- Tool base for tooling management
- Punching sequence editing



- Industrial grade fanless PC



**SUNRISE  
Fluid Power Inc.**  
No. 7, Road 12, Industrial Zone,  
Taichung City 407, Taiwan  
TEL: 886-4-2359-1190  
FAX: 886-4-2359-3409  
www.sunriseiw.com  
sales@sunriseiw.com.tw

AGENT:



831EG429 2025.05



## HYDRAULIC IRONWORKERS & PUNCHING MACHINES



Multi-Function / Excellent Quality / Economical Investment ISO 9001



# INTRODUCTION

With a highly dedicated team, Sunrise Fluid Power Inc. has been specializing in the manufacturing of hydraulic ironworkers, punching machines, bending machines, and other hydraulic machinery and equipment for over 30 years. Total customer satisfaction is our number one goal. We are passionate about providing engineering excellence in everything we do, and we are dedicated to manufacturing world-class, high-value products for our global customers.

## Product Differentiation

Sunrise is ISO-9001 certified by BVQI, and our products meet the CE safety requirements and regulations. We relentlessly seek continuous improvement and product development. Currently Sunrise has the broadest range of ironworker and punching machine models compared to any other manufacturer. Sunrise product advantages: Durability, Accuracy, and Versatility. Besides our very popular single and dual operator models, we have introduced the K-series, a new line of ironworker with vertical movement at all stations. The center beam in the entire range of K-series moves in straight up and down motion to provide less deformation, better results and longer tooling life.



## Quality Control

Quality of the highest standard is the key factor in success. All key components of our ironworkers, punching machines, etc. are made in-house at our modern plant and automated production lines. We use the latest control system to ensure highly efficient production, and the quality assurance team measures and tests each component to ensure precision standards of machined parts are met or surpassed. Finally, before shipping, each complete machine goes through intensive quality and performance tests to make absolute sure it meets our strict company quality standards before it arrives at the customer's operation.



## Sales and Service

Our global sales network covers almost 50 countries in Europe, Australia, North America, Southeast Asia, the Middle East and more. This coverage, combined with the quality of our machines, makes Sunrise one of the best choices when it comes to metal forming. In this highly competitive international market, Sunrise's market share continues to grow. Thank you to our many and growing list of satisfied customers for your continued support. Sunrise is now one of the leading brands in the fabricating industry. We look forward to your continued support and comments -- together we will push quality at Sunrise ever higher.



Sunrise Hydraulic Ironworkers are designed with multiple functions to save labor, time, energy and cost. This allows Sunrise Ironworkers to meet the diversified needs of the metal fabricating industry.

Maximum efficiency and long life is guaranteed by using the latest manufacturing methods, including powerful CAD design, modern production line with CNC equipment and continuous quality control.

Each work station is equipped with specially designed hold-downs to ensure safety while providing precision and ease of use. These ironworkers are the most economical and efficient machines in the industry for the manufacturing of metal products.

All Sunrise ironworkers and punching machines come standard with a low pressure tool alignment mode. The operator can use the JOG mode to run the machine in low pressure and low speed for tool alignment, blade changes and maintenance operations. This greatly improves operator safety and prevents tool damage in case of mis-alignment.

## Key features on the dual cylinder models:

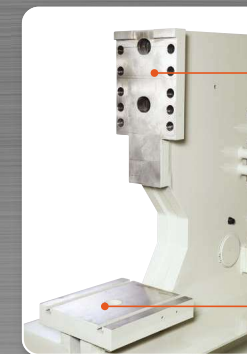
The dual cylinder models feature a separate cylinder for independent operation from shearing stations.

Cylinder ram with flat surface for rigid guiding and to ensure proper alignment of tool.

Keyed punch ram to ensure alignment of shaped tooling.



The cylinder ram is guided at three positions to provide extra support and absorb side-load forces for added protection of cylinder seals.



The punching station features a large cylinder mounting plate to ensure maximum cylinder support under heavy load. The punching base is one solid plate with T-slot grooves for universal tool fixture.













The base of the machine is made from welded channel in a grid pattern for a rigid machine foundation.

The frame of the machine is a monoblock construction that integrates both bolts and welding reinforcement to provide maximum frame structure rigidity.





# FEATURES





## HYDRAULIC IRONWORKERS & PUNCHING MACHINES



	
*Pipe Notching	Punching
	
*Angle Bending	*Radius Corners
	
Punching	*Pipe Punching
	
*Rounding off Corners	*Cutting and Rounding off
	
*Press Brake	*Bilateral Rounding off



IW-165SD

	
Round Bar Shear	*Channel Shear
	
Square Bar Shear	*I Beam Shear

			
Angle Shear	*Vee Notching	Notching	Notching

	
Flat Bar Shear	Angle Miter Shear



The use of name-brand hydraulic components ensure excellent reliability of the hydraulic system.



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

\* : Optional tooling

# WORK STATIONS

## Punching Station

- A full range of punches and dies are available for various punching needs.
- Quick change retaining nut system for fast punch tooling change.
- Thoughtfully designed stripper for visibility, safety and ease of use.

- A large 2-piece table with scales and gauging stops is standard on all models.
- Stripper with interchangeable plates of various openings to minimize deformation is standard on all models.
- Optional hydraulic stripper is available on dual-cylinder ironworkers and all punching machines.



\*Punches and dies are sold separately.



\*Standard dual-opening die block for up to 50mm round punch and die.



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



\*Laser alignment system for more accurate positioning of marked parts.



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



\*Urethane spring stripper for minimal deformation. Safety cover removed for showing.



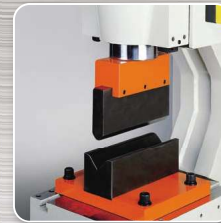
\*Pipe notcher.



\*Oversize punch attachment. Safety cover removed for showing.



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



\*Single vee press brake.



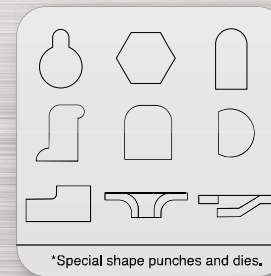
\*Multi vee press brake.



\*Large vee-notcher. (Punch side)



\*Angle bending press.



\*Special shape punches and dies.

\*Optional Semi-Automatic CNC Tables with 1000x400mm travel. Shown with optional hydraulic stripper.



# WORK STATIONS

## Flat Bar Shearing Station

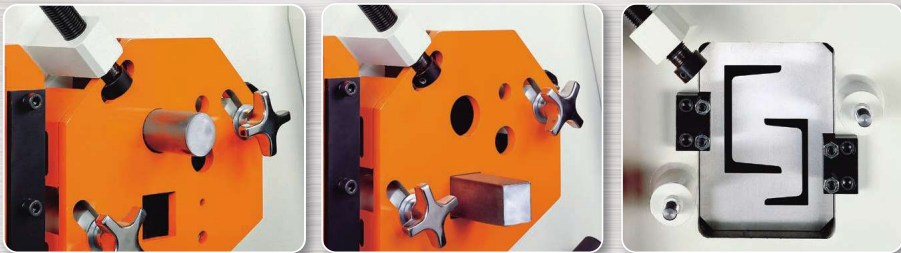
- Specially machined upper blade to give a clean shear with minimum distortion.
- Lower blade has four usable cutting edges.
- Variable degree miter-cutting on angle flange.
- Easily adjustable hold-down.
- Support table with guides for accurate positioning.



\*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)



\*Channel blades. (optional)

## Angle Shearing Station

- Single shear with no material loss and minimal deformation.
- 45° miter-cut is easy and clean.
- Stationary blades with four usable cutting edges.
- Selectable corner radii on moving blades for optimum results on small or large angles.



\*Optional hydraulic hold-down for angle shear.

## Notching Station

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



\*Optional vee-notcher.

## Other Included Features

1. Three limit switches enable setting of short notch stroke to improve efficiency. (on IW-60H and S/SD models)
2. Magnetic base LED work light for safer operation. (optional on IW-45M)
3. 1000mm electric backgauge for higher efficiency in repetitious work. The gauge extension is available depending on request.



\*Optional on IW-45M, IW-60H.

# K SERIES

## K - SERIES IRONWORKERS

The K-series are special designed compact ironworkers 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. Hydraulic hold-down and urethane spring stripper are also available for the best performance. The fast cylinder stroke greatly improves the efficiency. This model incorporates versatility, efficiency, accuracy, and ease of use at an excellent price.



Hydraulic hold-down.  
(optional on IW-45K / IW-60B)



\*Single vee press brake.



\*Urethane spring stripper.  
Safety cover removed for showing.



\*Multi vee press brake.



\*Channel Shear.



IW-45K



IW-60K



IW-60B



IW-60BN

## Dual Operator K-Series



IW-85KD



IW-125KD

\*Hydraulic shear holddown included as standard

## SINGLE CYLINDER

## Single Cylinder Models

### IW-45M

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-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 angles. The round/square bar shearing on this model is a stand-alone station that has large shearing capability.



IW-45M



IW-60H

# Capacities and Specifications

Unit: mm

MODEL	IW-45K	IW-60K	IW-60B	IW-60BN
<b>PUNCHING</b>				
Punching Force	45 Ton	60 Ton	60 Ton	60 Ton
Punch Capacity (Diameter x Thickness)	ø22 x 15 ø40 x 8	ø22 x 20 ø40 x 11	ø22 x 20 ø40 x 11	ø22 x 20 ø40 x 11
Throat Depth	165	200	200	200
Maximum Stroke Length	30	40	40	40
Cycles / Min. (15mm stroke)	37	34	34	34
Working Height Up to Die	1050	1050	1150	1050
<b>ANGLE SHEARING</b>				
At 90° Shearing	75 x 75 x 6	100 x 100 x 7	100 x 100 x 7	100 x 100 x 7
Working Height	1000	1070	1170	1070
<b>FLAT SHEARING</b>				
Flat Bar Shear	300 x 10	350 x 15	350 x 15	350 x 15
Blade Length	310	360	360	360
Working Height	800	805	905	805
<b>BAR SHEARING</b>				
Round Bar Shear	ø30	ø40	ø40	ø40
Square Bar Shear	25 x 25	38 x 38	38 x 38	38 x 38
Channel Shear (H x B)	75 x 40*	100 x 50*	100 x 50*	100 x 50*
<b>NOTCHING</b>				
Rectangular Notcher (W x D x T)	50.8 x 90 x 7	50.8 x 90 x 8	--	50.8 x 90 x 8
Vee-Notcher (Side x Side x T)	90 x 90 x 8*	90 x 90 x 8*	--	--
Working Height	1050	1050	--	1020
<b>SPECIAL TOOLING</b>				
Single Vee Press Brake (W x T)	160 x 8*	160 x 8*	160 x 8*	100 x 8
Multi Vee Press Brake (W x T)	250 x 4*	250 x 6*	300 x 6	--
Angle Bending	65 x 65 x 8*	65 x 65 x 8*	65 x 65 x 8*	65 x 65 x 8*
Pipe Notching	ø60*	ø60*	ø60*	ø60*
<b>OTHER</b>				
Electric Power (HP)	5 HP	7.5 HP	7.5 HP	7.5 HP
Net Weight (Appr.)	800 kg	1160 kg	1360 kg	1285 kg
Gross Weight (Appr.)	940 kg	1310 kg	1460 kg	1390 kg
Machine Dimension (Appr.)	1050 x 760 x 1490	1180 x 760 x 1630	1350 x 760 x 1730	1260 x 760 x 1690
Packing Dimension (Appr.)	1300 x 880 x 1750	1460 x 900 x 1880	1700 x 870 x 1950	1600 x 870 x 1910

\* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm<sup>2</sup> tensile.  
Design and specifications subject to change without notice.

Unit: mm

MODEL	IW-85KD	IW-125KD	IW-45M	IW-60H
<b>PUNCHING</b>				
Punching Force	85 Ton	125 Ton	45 Ton	60 Ton
Punch Capacity (Diameter x Thickness)	ø27 x 22 ø50 x 12	ø33 x 27 ø50 x 18	ø22 x 15 ø40 x 8	ø28 x 15 ø40 x 11
Throat Depth	410	410	175	220
Maximum Stroke Length	100	100	35	55
Cycles / Min. (15mm stroke)	38	37	31	29
Working Height Up to Die	1050	1050	970	1000
<b>ANGLE SHEARING</b>				
Shearing Force	110 Ton	160 Ton	--	--
Shearing Cylinder Stroke Length	50	50	--	--
At 90° Shearing	130 x 130 x 12	152 x 152 x 15	75 x 75 x 6	100 x 100 x 13
At 45° Miter Shearing	--	--	50 x 50 x 6	75 x 75 x 6
Working Height	1040	990	1120	1236
<b>FLAT SHEARING</b>				
Flat Bar Shear	406 x 17	460 x 20	350 x 8	350 x 15
Blade Length	410	465	360	360
Angle Flange Trim	--	--	75	100
Working Height	726	770	970	1006
<b>BAR SHEARING</b>				
Round Bar Shear	ø45	ø45	ø25	ø40
Square Bar Shear	45 x 45	45 x 45	25 x 25	38 x 38
Channel Shear (H x B)	150 x 75*	180 x 75*	--	100 x 50*
I Beam Shear (H x B)	150 x 75*	180 x 100*	--	--
<b>NOTCHING</b>				
Rectangular Notcher (W x D x T)	63.5 x 90 x 12	63.5 x 90 x 15	--	50.8 x 90 x 8
Vee-Notcher (Side x Side x T)	105 x 105 x 12*	105 x 105 x 15*	--	90 x 90 x 10*
Working Height	1050	1050	--	1006
<b>SPECIAL TOOLING</b>				
Large Vee-Notcher (Side x Side x T)	145 x 145 x 10*	145 x 145 x 12*	--	--
Single Vee Press Brake (W x T)	250 x 12*	250 x 20*	--	--
Multi Vee Press Brake (W x T)	500 x 5*	700 x 5*	--	--
Angle Bending	100 x 100 x 7*	100 x 100 x 13*	--	--
Pipe Notching	ø100*	ø100*	--	--
<b>OTHER</b>				
Electric Power (HP)	10 HP	15 HP	5HP	7.5HP
Net Weight (Appr.)	2720 kg	4095 kg	790 kg	1390 kg
Gross Weight (Appr.)	2920 kg	4360 kg	890 kg	1530 kg
Machine Dimension (Appr.)	1755 x 1020 x 1865	2060 x 1120 x 2070	1260 x 700 x 1350	1460 x 770 x 1560
Packing Dimension (Appr.)	2000 x 1140 x 2120	2280 x 1260 x 2330	1480 x 820 x 1570	1680 x 900 x 1780

\* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm<sup>2</sup> tensile.  
Design and specifications subject to change without notice.

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

# 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 pedals, and separate operations can be safely performed simultaneously. 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" mounting provides a solid base for securing the punching tooling, as well as a wide range of optional and custom designed tooling.



IW-100S

### Capacities and Specifications

Unit: mm

MODEL	IW-60S IW-60SD	IW-80S IW-80SD	IW-100S IW-100SD	IW-125S IW-125SD	IW-165SD
<b>PUNCHING</b>					
Punching Force	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: SD: 310 510	310 510	310 510	310 510	-- 510
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
<b>ANGLE SHEARING</b>					
At 90° Shearing	130 x 130 x 12	150 x 150 x 12	150 x 150 x 15	150 x 150 x 15	200 x 200 x 20
At 45° Miter Shearing	65 x 65 x 8	75 x 75 x 9	75 x 75 x 9	75 x 75 x 9	75 x 75 x 9
Working Height	1115	1165	1216	1185	1185
<b>FLAT SHEARING</b>					
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	--
Working Height	910	926	954	920	920
<b>BAR SHEARING</b>					
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 (H x B)	125 x 65*	150 x 75*	150 x 75*	150 x 75*	200 x 90*
I Beam Shear (H x B)	--	150 x 75*	150 x 75*	150 x 75*	200 x 100*
Working Height	1220	1270	1332	1310	1370
<b>NOTCHING</b>					
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
<b>SPECIAL TOOLING</b>					
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 12*	145 x 145 x 12*
Single Vee Press Brake (W x T)	250 x 12*	250 x 12*	250 x 15*	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	100 x 100 x 7*	100 x 100 x 7*	100 x 100 x 13*	100 x 100 x 13*	100 x 100 x 13*
Pipe Notching	ø100*	ø100*	ø100*	ø100*	ø100*
<b>OTHER</b>					
Electric Power (HP)	7.5 HP	10 HP	10 HP	15 HP	20HP
Net Weight (Appr.)	S: SD: 1780 kg 2060 kg	2120 kg 2550 kg	2880 kg 3340 kg	3300 kg 3900 kg	-- 5180 kg
Gross Weight (Appr.)	S: SD: 1890 kg 2230 kg	2250 kg 2760 kg	3050 kg 3600 kg	3530 kg 4160 kg	-- 5480 kg
Machine Dimension (Appr.)	S: SD: 1700 x 800 x 1710 2070 x 800 x 1710	1830x820x1760 2220x820x1730	2100x860x1810 2460x860x1810	2170x1030x1850 2490x1030x1850	-- 2710x1070x2100
Packing Dimension (Appr.)	S: SD: 1930 x 900 x 1940 2290 x 900 x 1950	2070x940x1960 2450x960x1985	2350x950x2100 2700x1000x2060	2430x1150x2070 2730x1150x2100	-- 2940x1210x2270

\* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm<sup>2</sup> tensile.  
Design and specifications subject to change without notice.

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

# PM SERIES

## Hydraulic Punching Machine

- The patented dual-piston hydraulic cylinder enables the machine to retract faster, and also makes our cylinder slimmer, which brings a better appearance to the machine.
- Punching machines ranging from 35 to 200 tons of punching capacities, combined with different throat depths to choose from, provides a complete range of models to meet our customer's wide range of 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 a universal machine.



PM-55LT



\*Bar shearing.



\*Channel shearing.



\*Angle shearing.



\*Flat bar shearing.



\*Rectangular notcher.

### 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
<b>PUNCHING</b>						
Punching Force	35 Ton	55 Ton	80 Ton	120 Ton	160 Ton	200 Ton
Punch Capacity (Diameter x Thickness)	ø18 x 14 ø50 x 5	ø22 x 18 ø50 x 8	ø25 x 23 ø50 x 12	ø32 x 27 ø50 x 17	ø36 x 32 ø50 x 23	ø41 x 35 ø50 x 29
Throat Depth	T: 310 LT: 510 XT: 760	310 510 760	310 510 760	-- 510 760	-- 510 760	-- 510 760
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 LT: 700 x 700 XT: 700 x 950	700 x 500 700 x 700 700 x 950	700 x 500 700 x 700 700 x 950	-- 700 x 700 700 x 950	-- 700 x 700 700 x 950	-- 700 x 700 700 x 950
Working Height Up to Die	1050	1050	1050	1050	1050	1050
<b>OPTIONAL TOOLING</b>						
Largest Hole*	ø152 x 2	ø152 x 3	ø152 x 4	ø152 x 5	ø152 x 6.5	ø152 x 8
Single Vee Press Brake (W x T)*	250 x 12	250 x 12	250 x 12	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*	65 x 65 x 8	75 x 75 x 6	100 x 100 x 7	100 x 100 x 13	100 x 100 x 13	100 x 100 x 13
Rectangular Notcher (WxDxT)*	63.5 x 90 x 5	63.5 x 90 x 6	63.5 x 90 x 8	63.5 x 90 x 10	63.5 x 90 x 10	63.5 x 90 x 10
Vee Notcher (Side x Side x T)*	145 x 145 x 4	145 x 145 x 6	145 x 145 x 10	145 x 145 x 12	145 x 145 x 12	145 x 145 x 12
Pipe Notcher (Max diameter)*	ø100	ø100	ø100	ø100	ø100	ø100
Flat Bar Shearing*	175 x 5	175 x 7	175 x 10	175 x 14	175 x 14	175 x 14
Angle Shearing*	65 x 65 x 8	75 x 75 x 6	100 x 100 x 7	100 x 100 x 13	100 x 100 x 13	100 x 100 x 13
Round Bar Shearing*	ø28	ø32	ø32	ø32	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 (H x B)*	--	100 x 50	100 x 50	100 x 50	100 x 50	100 x 50
<b>OTHER</b>						
Electric Power	5 HP	5 HP	7.5 HP	10 HP	15 HP	20 HP
Net Weight (Appr.)	T: 1160 kg LT: 1450 kg XT: 1810 kg	1390 kg 1750 kg 2450 kg	1720 kg 2080 kg 2800 kg	-- 2950 kg 4380 kg	-- 3640 kg 4700 kg	-- 4780 kg 5720 kg
Gross Weight (Appr.)	T: 1300 kg LT: 1610 kg XT: 1980 kg	1540 kg 1920 kg 2630 kg	1870 kg 2260 kg 3000 kg	-- 3140 kg 4600 kg	-- 3900 kg 5060 kg	-- 5100 kg 6150 kg
Machine Dimension (Appr.) (L x W x H)	T: 1090x820x1770 LT: 1420x820x1795 XT: 1820x820x1815	1160x820x1960 1520x820x1960 1920x820x1960	1280x865x1980 1620x865x1980 2045x865x1980	-- 1720x970x2035 2170x940x2035	-- 1870x1040x2070 2370x1040x2135	-- 1975x1065x2095 2475x1065x2175
Packing Dimension (Appr.) (L x W x H)	T: 1330x940x2000 LT: 1650x950x2020 XT: 2060x980x2100	1400x940x2200 1770x940x2200	1530x1000x2200 1870x990x2205 2250x1000x2270	-- 1980x1060x2290 2440x1220x2250	-- 2080x1150x2280 2630x1160x2420	-- 2150x1400x2400 2515x1395x2360

\* : Optional Tooling

Note: Based on low carbon / mild steel material strength of 45kg / mm<sup>2</sup> tensile.  
Design and specifications subject to change without notice.

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

## Semi-Automatic

- Preview function before executing program
- Four pre-programmed patterns: Line, Array, Arc, and Custom
- Spotting function using low pressure mode
- Maximum table travel speed: 10m/min



\*Optional angle leg up stripper



\*Auto lubrication system with adjustable frequency and oil amount for longer tool life.



\*Oil cooling system

The semi-automatic CNC positioning tables from SUNRISE are plate, angle and channel positioning systems with simple user-friendly interfaces. The CNC positioning table is available as a factory-installed option on Dual-Cylinder Ironworker or Punching Machine with a 510mm or larger throat depth. The operation is CNC controlled using a pendant mounted controller featuring easy programming and a virtually indestructible design. The operator simply positions the plate against the CNC-controlled X and Y stops and initiates the punch sequence. Ideal for base plates, connection plates, angles, channels and more.



**IWNC-100SD**  
1000x400mm Semi-Automatic Table

\*shown with optional hydraulic stripper and flat shear holddown

\*Optional upgrade on semi-auto table

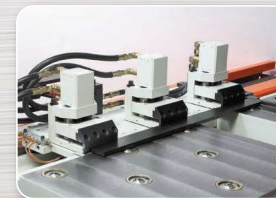
## Fully-Automatic

Fully-automatic CNC systems from SUNRISE deliver highly efficient and accurate positioning that will improve your productivity. The controller is easy to learn and operate, so you can begin operations almost immediately. Hydraulic clamps come with a pressure sensor for a strong grip on the material, and come standard on Sunrise automatic CNC tables. Moreover, the included hydraulic stripper comes with exchangeable plates to suit a variety of punching operations. Ball transfer units on the support table provide smooth material movement, and the cover is complete with an interlock switch for ensured operator safety.



### Optional Multi-Tool System:

- Standard punches and dies used on multi-tool system
- Each punch is individually controlled by pneumatic cylinders
- Tooling size and shape shown in preview screen



Operate in semi-automatic mode with use of gauging piece allows punching holes near the edge of the material. (Fully Automatic models only)



\*Hydraulic stripper to reduce material deformation is standard equipment.



**PM-80LT-CNC**  
1000x500mm Fully-Automatic Table

## CNC Feeding Systems

The new line of Sunrise CNC positioning and feeding system uses a heavily proportioned machined structural steel tube that provides unmatched rigidity and quality, yet offers simple set-up, adjustment and maintenance.

The ANC combines a punching machine with a single-axis in-feed system for punching flat bar, angle and channel webs. The APS automatic punch and shear combines a punching machine with a shearing machine and a CNC in-feed system for punching and shearing flat bars in one fully automatic operation.

The ALS angle line system is specially designed for high volume angle processing, with dual punches per leg, and stamping station included.

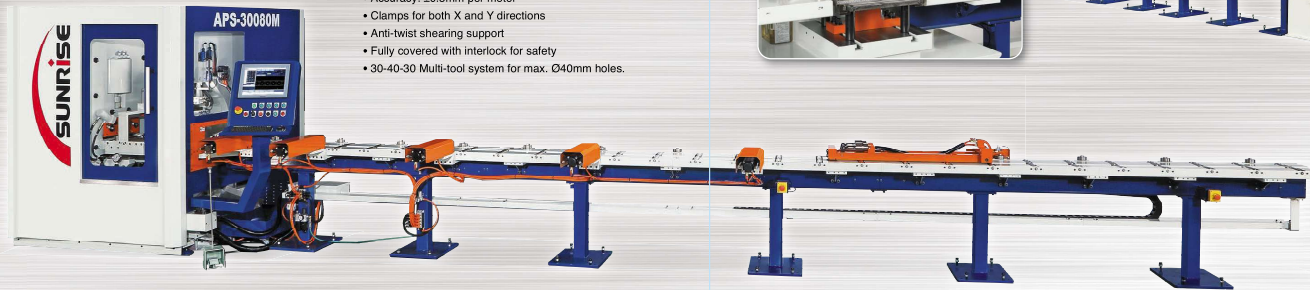
Both APS and ALS main stations comes in one unit with fully enclosed covers, providing not just visual attractiveness, but also ease of machine installation and operator protection.

Optional light curtain and fence enclosure are also available for unparalleled safety standard for the operator.



### APS-30080M Automatic Punch and Shear system

- Max. material: 300x18x6000mm
- Feeding speed: 12m/min
- Accuracy:  $\pm 0.5$ mm per meter
- Clamps for both X and Y directions
- Anti-twist shearing support
- Fully covered with interlock for safety
- 30-40-30 Multi-tool system for max.  $\varnothing 40$ mm holes.



### ALS-1506D Angle Line System

- Process 2" – 6" angle
- Process 2" – 6" flat bar at max. 12mm thickness.
- 6m feeding system standard, optional to 12m
- Max. size  $\varnothing 30 \times 12$ mm
- Stamping station included
- PC based controller with 15" touch screen
- Minimum Scrap: 150mm



### PM-80T-ANC Single Axis Angle NC Feeding System

- X-Axis travel length: 6m
- Angle size range: 2"–8" (require special punching accessories)
- X-Axis positioning speed: 12m/min
- X-Axis accuracy:  $\pm 0.5$ mm per meter (material condition may effect actual punched holes)
- Punches per minute: up to 28 (at 20mm stroke)