



## CAPACITY AND TECHNICAL DATA

### P1, P3, P5/2, P6, P8, P9, P10 and T6

TYPE OF MACHINE		P1	P3	P5/2	P6	P8	P9	U10	T6
Edge cutting	mm	3	4	6	6,5	8	9	10	6,5
Cutting in centre of plate	mm	2,5	3,5	5	5,5	7	8	8,5	5,5
D.o without starting hole	mm	2,5	3	4	4,5	6	7	7,5	4,5
Beadling	mm	1,5	3	3,5	3,5	4	5	5	3,5
Joggling	mm	1,5	3	3,5	3,5	4	5	5	3,5
Slot cutting	mm	1,5	2	3	3	4	4,5	4,5	3
Louvring	mm	1	2	3	3	3	3	3	3
Nibbling	mm	—	1,5	2	4	4	6	6	4
Doming	mm	2	2	3	3	4	6	6	3
Flanging	mm	1,5	2	2,5	2,5	3	3,5	3,5	2,5
Edge bending 45°	mm	2	2	3	3	4	5	5	3
Edge bending 90°	mm	—	—	2,5	2,5	3	3	3	2,5
Punching (capacities for Ø 30 mm)	mm	—	2	2,5	2,5	3	3	3	2,5
<b>Circle cutting</b>									
with inner centre attachment:									
Max. Diameter	mm	700	1040	1050	1050	1200	1200	990	1050
Min. Diameter	mm	100	75	80	80	106	110	225	80
D.o with extension for small circles	mm	30	30	30	30	30	30	90	30
<b>Segment cutting</b>									
with inner centre attachment:									
Max. radius	mm	400	660	675	675	790	790	675	665
Min. radius	mm	50	38	40	40	53	55	113	40
D.o with extension for small circles	mm	15	15	15	15	15	15	45	15
<b>Band cutting</b>									
with straight cutting attachment:									
Largest width	mm	348	646	650	650	745	770	500	620
Smallest width	mm	15	17	20	20	23	26	38	20
<b>Cutting speed</b>									
with manual feeding	meters/minute	5	5	5	5	6	6	6	5
Cuts per minute		2800	2800	2800	2000	2000	2000	1800	2000
		1400	1400	1400	1000	1000	1000	900	1000
					500	500	500	700	500
								350	
Stroke length	mm	2	1,8	1,7	1,75	1,5	2,5	0	1,75
			3,0	3,5	6,0	6,2	10	10	6,0
Electric motor	HP	0,9	1	2	3,0	5	5	5	3
		0,5			2,5	4,5	4,5	4,5	2,5
Depth of jaw	mm	713	1085	1070	1070	1225	1230	1015	1070
Overall length	mm	1320	1850	1900	1900	2230	2265	2100	1960
Overall height	mm	1060	1195	1265	1265	1465	1565	1775	1615
Overall width	mm	300	535	545	700	680	860	840	730
Weight excl. accessories	Kg	295	575	765	800	1360	1750	2100	1340

All capacity figures apply to mild steel plate with a tensile strength of 40 kg/sq. mm.

#### PULLMAX

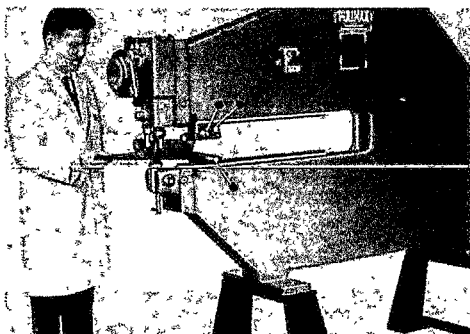


Totally enclosed, 1 h.p. electric motor, connected to the mechanism by means of a flexible coupling. Two striking rates — 1400 and 2800 strokes per min. — by turning the control lever to the right or left respectively. All PULLMAX cutting and forming operations can be performed. The lengths of stroke make this machine particularly suitable for use in sheet-metal shops, experimental and development workshops, schools, etc.

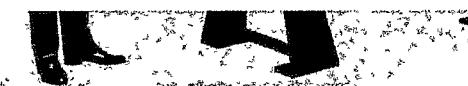
#### PULLMAX



Totally enclosed, 2 h.p. electric motor, connected to the



mechanism by means of a flexible coupling. Two striking rates — 1400 and 2800 strokes per min. — by turning the control lever to the right or left respectively. All standard PULLMAX operations can be performed. The machine has the same excellent characteristics as the PULLMAX P3, but is stronger and thus covers a greater working range, which is particularly advantageous for forming operations. This type of machine is frequently used in the aircraft and automotive industries and by manufacturers of restaurant and dairy utensils, etc. A popular machine for trade schools and repair shops.



*Excerpts from capacity table*

	P3		P5	
	mm	inches	mm	inches
Edge cutting	4	$\frac{5}{32}$	6	$\frac{1}{4}$
Beading and Jogging	3	12 ga	3.5	$\frac{1}{8}$
Louvring	2	14 ga	3	12 ga

## PULLMAX



Totally enclosed, two-speed, 2.5/2.3 h. p. electric motor. "V"-belt transmission. With the aid of an intermediate eccentric in combination with different settings of the control lever, 6 different stroke lengths can be set at the rate of 500, 1000 or 2000 strokes per minute. This machine has been designed especially in view of the increasing need for nibbling, for instance in the production of instrument panels. It is recommended not only for all standard PULLMAX operations but also for use together with the PULLMAX coordinate table.

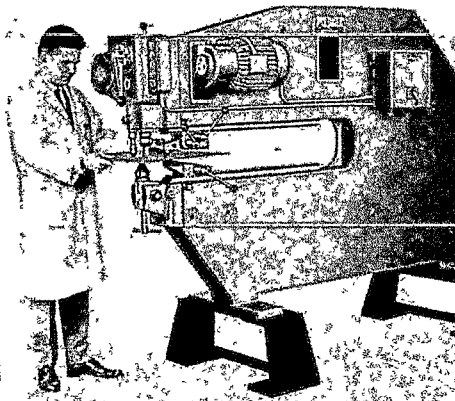
*Excerpts from capacity table*

	P6		P8		P9	
	mm	inches	mm	inches	mm	inches
Edge cutting	6.5	$\frac{1}{4}$	8.0	$\frac{5}{16}$	9.0	$\frac{11}{32}$
Nibbling	4.0	$\frac{5}{32}$	4.0	$\frac{5}{32}$	6.0	$\frac{1}{4}$
Doming	3.0	12 ga	4.0	$\frac{5}{32}$	6.0	$\frac{1}{4}$
Edge bending	3.0	12 ga	4.0	$\frac{5}{32}$	5.0	$\frac{3}{16}$

## PULLMAX



Totally enclosed, two-speed, 3.5/3.0 h. p. electric motor. "V"-belt transmission. The intermediate eccentric, in combination with different control lever settings, gives 8 different stroke lengths at the rate of 500, 1000 or 2000 strokes per minute. All PULLMAX plate-working operations can be performed with this machine, which is also suitable for use together with the PULLMAX coordinate table. An extra powerful, heavy-duty machine, capable of withstanding heavy production loads.



## PULLMAX

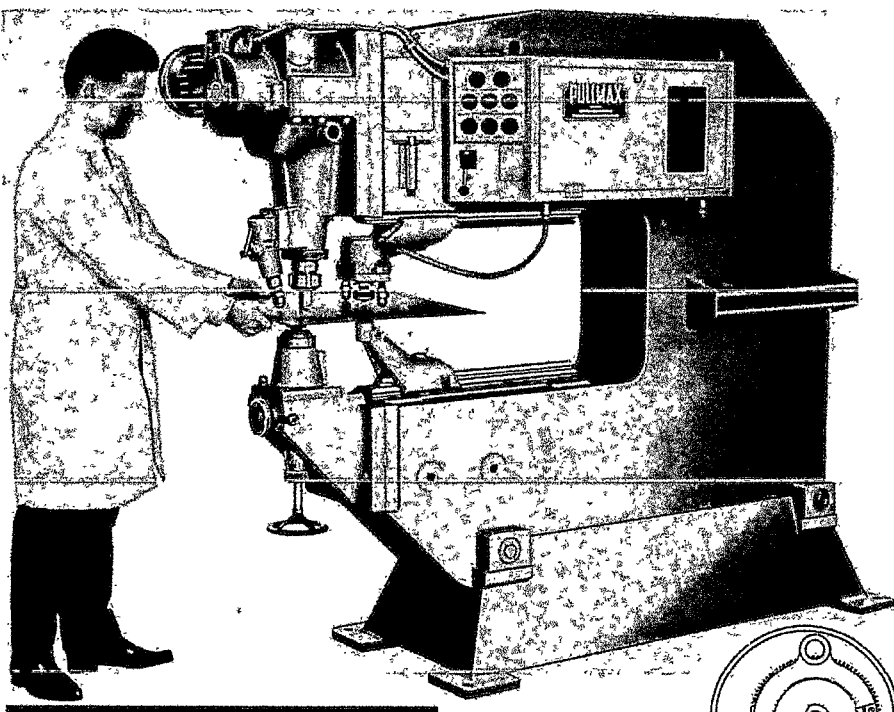


Totally enclosed, two-speed, 5.5/4.5 h. p. electric motor. "V"-belt transmission. 10 different stroke lengths at striking rates of 500, 1000 or 2000 strokes per minute can be obtained by means of the intermediate eccentric, in combination with different control lever settings. The PULLMAX P9 incorporates all the operational features of PULLMAX universal machines and also covers the field of heavier plate-working. Like the PULLMAX P6 and the PULLMAX P8, it is particularly suitable for forming operations and nibbling. The PULLMAX P9 has proved to be particularly suitable for shipyards, iron and steel works, manufacturers of mechanical handling equipment, makers of chemical plant equipment, etc.



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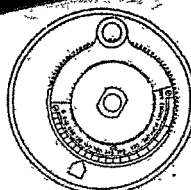


## PULLMAX



In numerous industrial undertakings, including shipyards, iron and steel works, and factories for the manufacture of rolling stock, tanks, etc. there has been a tendency to utilize

rails for the straight edge and centering device are also de-



the PULLMAX machines for increasingly heavy tasks, bulky workpieces can be dealt with in a machine with a large throat depth. The PULLMAX U10, which is the biggest and most mechanized machine in the PULLMAX series, covers this need.

The PULLMAX U10 is provided with a totally enclosed, two-speed, 5.5/4.5 h.p. electric motor. The power is transmitted via a two-stage gear box, enabling the tool to work at 4 different striking rates — 350, 700, 900 and 1800 strokes per minute.

The mechanism, as on other PULLMAX universal machines, is totally enclosed and runs in an oil bath. The tool movement is brought about by means of a direct eccentric, through which the stroke length can be infinitely varied between 0 and 10 mm. (0 and 394 inch) with automatic counterbalancing. The length of the stroke can be checked on an easily readable scale.

The motor-driven tool lift with which the PULLMAX U10 is fitted facilitates working with heavy plates.

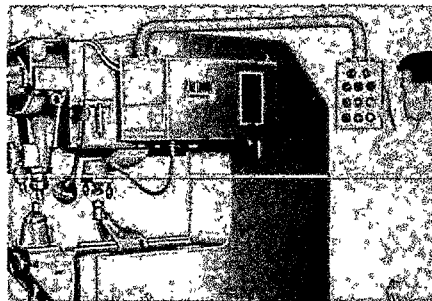
Normally, the machine is operated from a front panel, but for work with large plates it can be fitted either with a control pendulum which can be equipped as required or with a pedal for tool advance and withdrawal.

Bearing in mind the extra heavy load to which the PULLMAX U10 is subjected, the frame is built to absorb great stresses, while the lower tool holder is also of a particularly robust construction. The same holder is used for all tools. The guide

signed so as not to obstruct scrap flow-off. The straight edge and centering device are extra reinforced and the centering device, as standard, has pneumatic locking.

Excerpt from capacity table.

	U10	
	mm	inches
Edge cutting	10	13/32
Nibbling	6	1/4
Bending and Joggling	5	3/16
Doming	6	1/4



## PULLMAX



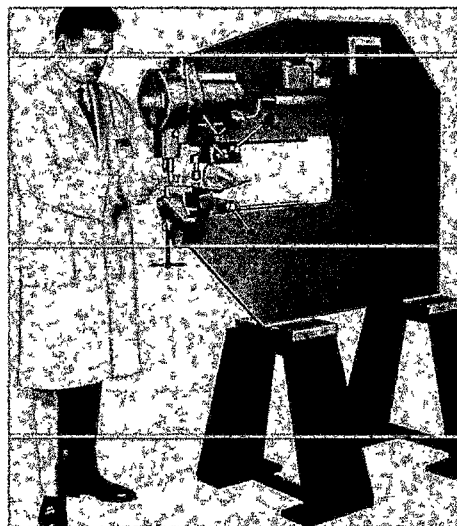
PULLMAX P1 is the smallest type in the PULLMAX series of universal machines. It is equipped with a two-speed motor, developing 0.9/0.5 h.p. at 2900/1450 r.p.m. The motor is directly coupled to an eccentric which transmits the movement to the tool. The mechanism works in an oil bath. The tool is advanced and withdrawn by setting a lever attached to the motor housing, an intermediate position being provided for louvre cutting. Most standard PULLMAX operations can be performed. The stroke is 2 mm (14 ga) in length.

The lower tool holder, though not of the block type, is of a sturdy construction which allows the tools to be set for straight and circular cutting and for forming operations.

The frame is made of heavy plate, giving good stability.

The machine throat, with its generous depth, contains dovetailed, laterally adjustable guide rails, facilitating frictionless cutting with straight edges and circle-cutting attachments.

The PULLMAX P1 is especially suitable for sheet metal shops, shoe last factories, sign factories, experimental factories for the production of prototypes, and as a complementary machine in large workshops for special purposes, for instance: trimming of pressed components.



Excerpt from capacity table

Edge cutting	3.0 mm	12 ga
Bending and joggling	1.5 mm	16 ga

## PULLMAX

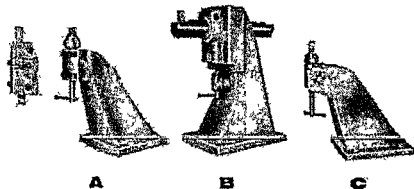


These two machines were originally developed especially for the aircraft and automotive industries, which need machines with a throat large enough for bulky, pressed workpieces to be processed in them. They have, however, also been utilized for many other purposes such as edge trimming, tube and pipe nibbling, manufacture of casings, etc.

The machines are built with a highly stable, welded box frame and with a gap height of 620 mm. (24 3/8"). Four

different tool holders allow the performance of all standard PULLMAX operations as well as trimming and working of tube and pipe. By inserting a bracket with guide rail in the opening, the machine can be used with straight and circle cutting attachments.

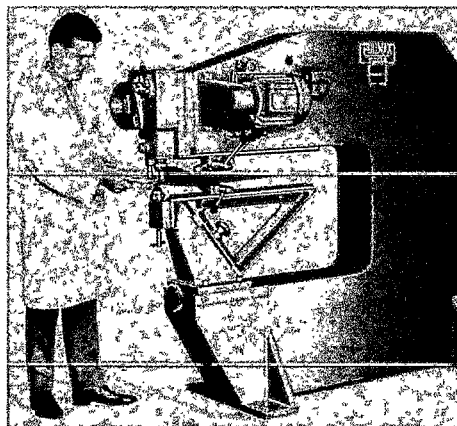
The mechanism of the PULLMAX T5 is the same as on the P5. The PULLMAX T6 has the same mechanism as the P6. Thus the T versions are equivalent in capacity to the corresponding P models.



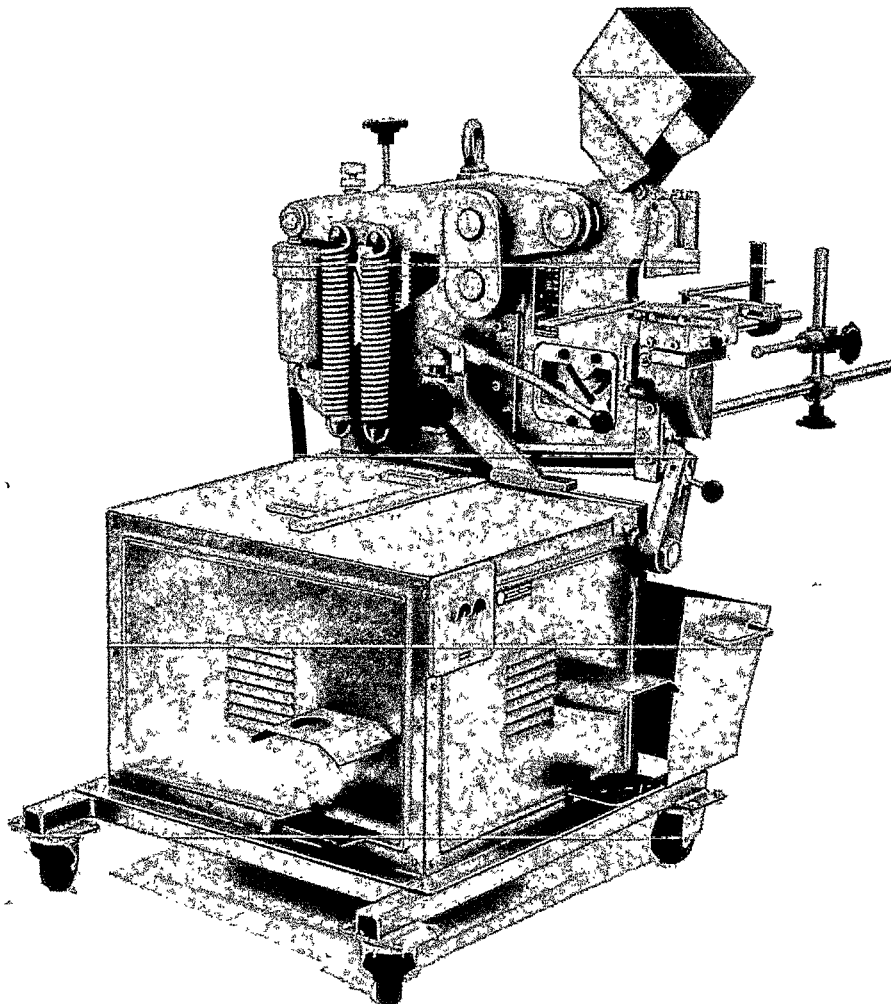
A. The PULLMAX T5 and T6 machines are normally equipped with holders for tools of PULLMAX standard type. If wanted, a special holder for an edge trimming tool can be fitted to the lower toolholder.

B. Tool holder with boom for cutting, nibbling and forming of tube ends.

C. Tool holder for use together with tool-holder of PULLMAX standard block type.



The CUTTING, PUNCHING, SLOTTING, NOTCHING  
MACHINE **BW-300**  
Hydraulic Universal Shear for plate, sections and bars



WEIGHT .....	500 kgs
VOLUME .....	1.32 m <sup>3</sup>
Notes: Without wheel under carriage	

BW-300

#### DATA

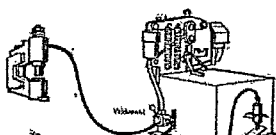
Length of cutting edges .....	300 mm	12"
Length of stroke .....	0-53 mm	0-2 1/16"
Number of strokes at full length of stroke ..	20 per min.	
Number of strokes at 25 mm (1") length of stroke .....	60/min.	
Motor, 220/380 volts or 400/440 volts .....	5.5 HP	

Table .....	580x700 mm	23"x27 1/2"
Table height .....	520 mm	20 1/2"
Base plate, Mounting hole (4) with dia. 14 mm (9/16") .....	660x740 mm	26"x29 3/8"
Total height .....	1100 mm	43 9/16"
Weight .....	500 kgs	

#### EXTRA EQUIPMENT

To enable the connecting of other hydraulic pistons, the machine can be equipped with a selection valve, with 4 outputs R 3/4" thread.

Wheel Undercarriage for ease of turning



#### Wheel Under-carriage

