

**Ironworkers**

METALpro

BAILEIGH

MARVEL



JET

Generate high-pressure hydraulic force to perform different metal-forming actions such as punching, shearing, forming, bending, pressing, and notching on thick plate metal, angles, and bars. They have separate tooling stations for each function and accept compatible add-on stations for additional functions. **Hydraulic Ironworkers** have a hydraulic

pump to drive different metal-forming actions. **Ironworkers with External Hydraulic Power Output** use a hydraulic pump to drive different metal-forming actions and an external output to power other compatible hydraulic tools. They eliminate the need for a separate hydraulic power unit to run additional tools such as benders, rollers, and presses.



Hydraulic 15V750

Eternal Hydraulic Power Output 53DK34



External Hydraulic Output Force	Included Tool Types	No. of Stations	Punch Capacity Mild Steel	Punch Throat Depth	Notcher Capacity Mild Steel	Flat Bar Shear Capacity Mild Steel	Tool Series	Brand	Mfr. Model	Item No.
<b>Hydraulic Ironworkers</b>										
<b>115V AC ; Single-Phase</b>										
45 Tonf		2	—	3 3/4 in	—	—	MP	Metalpro	MP4500FS	1UC51
50 Tonf	Punch	2	—	3 3/4 in	—	—	MP	Metalpro	MP5000FS	49LX78
<b>230V AC ; Single-Phase</b>										
50 Tonf	Angle Shear, Flat Shear, Pipe Notcher,	5	3/8 in x 1/4 in	6 in	2 in x 3.5 in x 0.281 in	10 in x 0.375 in	SW	Baileigh Industrial	SW-501	15V750
62 Tonf	Punch, Round Shear, Square Shear	5	1 1/8 in x 3/8 in	8 in	2 in x 3.5 in x 0.312 in	13.5 in x 0.5 in	SW	Baileigh Industrial	SW-621	31XW02
<b>230V AC ; Three-Phase</b>										
65 Tonf		5	—	9 7/8 in	—	—	MSIW	Marvel	MSIW66S	419J32
192 Tonf	Punch	5	—	24 3/8 in	—	—	MSIW	Marvel	MSIW192DX	419J42
<b>460V AC ; Three-Phase</b>										
60 Tonf		5	—	10 in	—	—	MSIW	Marvel	MSIW60D	419J35
93 Tonf	Punch	5	—	14 in	—	—	MSIW	Marvel	MSIW93D	419J39
192 Tonf		5	—	24 3/8 in	—	—	MSIW	Marvel	MSIW192DX	419J43
<b>Ironworkers with External Hydraulic Power Output</b>										
<b>230V AC ; Single-Phase</b>										
50 Tonf		4	3/8 in	7 in	—	—	IW50	Edwards	IW50-1P230-AC500	53DK32
55 Tonf	Punch	4	3/8 in	7 1/2 in	—	—	IW55	Edwards	IW55-1P230-AC500	53DK34
<b>230V AC ; Three-Phase</b>										
60 Tonf		4	3/4 in	8 1/2 in	—	—	IW60	Edwards	IW60-3P230-AC500	53DK37
65 Tonf	Punch	5	3/4 in	9 3/4 in	—	—	IW65	Edwards	IW65-3P230-AC600	53DK39
100 Tonf		5	1 in	11 in	—	—	IW100DX	Edwards	IW100DX-3P230-AC800	53DK45
<b>460V AC ; Three-Phase</b>										
50 Tonf		4	3/8 in	7 in	—	—	IW50	Jet	IW50-3P460-AC500	56LZ76
60 Tonf	Punch	4	3/4 in	8 1/2 in	—	—	IW60	Jet	IW60-3P460-AC500	56LZ78
100 Tonf		4	1 in	11 in	—	—	IW100	Jet	IW100-3P460-AC600	56LZ81

Accessories		Description	Brand	Mfr. Model	Item No.
<b>Add-On Notcher Stations</b>					
		Angle Notcher Type Compatible Model IW100, IW120	Edwards	AC0126	53DK90
		Pipe Notcher Type Compatible Model ELT65110, IW120, IW55	Edwards	AC0925C	53DL05
<b>Add-On Press Brake Stations</b>					
		Compatible Model: MP4000, MP4000FS, MP4500FS, MP5000FS	Metalpro	MP4510	1UC52
<b>Cutting Gauges &amp; Backstops</b>					
		Compatible Tool Series: 100 TON, 100 TON Deluxe, 120 TON, 25T, 40 TON C, 50 TON, 55 TON, 60 TON, 65 TON, 75 TON, Elite 110, Elite 110/65	Edwards	PR135	53DK70
		Compatible Tool Series: 100 TON, 100 TON Deluxe, 120 TON, 50 TON, 55 TON, 60 TON, 65 TON, 75 TON, Elite 110, Elite 110/65	Edwards	AC1011	53DK69
<b>Hydraulic Power Units</b>					
		230V AC Single-Phase, 5 hp	Edwards	HAT001	53DK57
		230V AC Three-Phase, 5 hp	Edwards	HAT002	53DK58
<b>Punching Dies</b>					
		Compatible Model: MP4000, MP4000FS, MP4500FS, MP5000FS, 1/4 in Die Size	Metalpro	MP8000	3ZJ49
		Compatible Model: MP4000, MP4000FS, MP4500FS, MP5000FS, 3/8 in Die Size	Metalpro	MP8004	3ZJ51

**Manual Sheet Metal Combination Machines**

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Feature separate tooling stations for each function and eliminate the need for individual, dedicated-purpose machines. Suitable for cutting, bending, or rolling lighter-gauge sheet metal than hydraulic-powered ironworkers.

Brake Capacity Mild Steel	Shear Capacity Mild Steel	Roller Capacity Mild Steel	Finger Width	Maximum Bend Angle	Brand	Item No.
<b>Shear, Roller</b>						
20 ga	20 ga	20 ga	1 in, 1 1/2 in, 2 in, 2 1/2 in, 4 in, 7 in, 9 in, 10 in, 15 in	90 °	Baileigh Industrial	31XV62
<b>Shear, Roller, Bender</b>						
16 ga	16 ga	16 ga	1 in, 1 1/2 in, 2 in, 2 1/2 in, 4 in, 7 in, 9 in, 10 in, 15 in	90 °	Baileigh Industrial	15V785
19 ga	19 ga	19 ga	1 in, 2 in, 3 in, 6 in, 8 in, 10 in	90 °	Dayton	13W869
20 ga	20 ga	20 ga	2 in, 3 in, 6 in, 8 in, 10 in	150 °	Jet	42W892
20 ga	20 ga	20 ga	1 1/2 in, 2 in, 2 1/2 in, 4 in, 7 in, 10 in, 12 in	150 °	Jet	42W893



Shear, Roller, Bender 15V785

**Box and Pan Brakes**

Dayton

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JET

Have a segmented, top beam that can fabricate multiple bends in sheet metal workpieces and form boxes, trays, and pans. **Manual Box and Pan Brakes** need manual effort to clamp the top beam and lift the folding bar to make bends in sheet metal. They are commonly used in areas or on jobsites without

access to power. **Hydraulic Box and Pan Brakes** have hydraulic cylinders to apply force to clamp the top beam and lift the folding bar to make more controlled bends with less effort than manual brakes. They are used for longer bends and thicker materials than manual brakes.

Finger Style	Sheet Metal Capacity Mild Steel	Sheet Metal Capacity Stainless Steel	Sheet Metal Capacity Aluminum	Maximum Bending Length	Maximum Bend Angle	Finger Width	Brand	Item No.
<b>Manual Box &amp; Pan Brakes Hand Lever</b>								
Top and Bottom Edge	12 ga	18 ga	8 ga	51 in	135 °	3 in, 4 in, 5 in, 20 in	Dayton	13W877
	12 ga	16 ga	10 ga	48 in	135 °	3 in, 4 in, 5 in, 6 in	Baileigh Industrial	31XT93
	12 ga	16 ga	10 ga	96 in	135 °	3 in, 4 in, 5 in, 6 in	Baileigh Industrial	18F316
	12 ga	18 ga	10 ga	—	135 °	3 in, 4 in, 5 in	Jet	48RJ43
Top Edge	14 ga	18 ga	10 ga	48 in	135 °	3 in, 4 in, 25 in	Baileigh Industrial	31XT94
	16 ga	18 ga	14 ga	—	135 °	2 1/2 in, 3 in, 3 1/2 in, 4 in, 5 in, 6 in, 12 in	Jet	48RJ42
	16 ga	22 ga	12 ga	30 1/2 in	135 °	2 in, 3 in, 4 in	Dayton	13W876
	16 ga	22 ga	14 ga	—	135 °	2 in, 3 in, 4 in	Jet	48RJ44
<b>Hydraulic Box &amp; Pan Brakes Foot Pedal, Hand Lever</b>								
	10 ga	12 ga	8 ga	48 in	135 °	3 in, 4 in, 5 in, 6 in	Baileigh Industrial	31XT92
	10 ga	12 ga	8 ga	96 in	135 °	3 in, 4 in, 5 in, 6 in	Baileigh Industrial	31XU02
	12 ga	16 ga	8 ga	96 in	135 °	3 in, 4 in, 5 in, 6 in	Baileigh Industrial	31XU03



Manual 13W877



Hydraulic 31XT92