

# Piranha

## Ironworkers

**Single Operator, Dual Operator  
& Single End Punch Presses**





## No other brand of ironworker compares to the tremendously versatile Piranha P-50.

Features such as urethane stripping, automatic shear hold-downs, quick change tooling, low blade rake angles, and six standard work stations, coupled with its ergonomic design and clear lines of sight to all tools, including shear blades, place Piranha far above the competition. These features produce higher quality parts, and make Piranha ironworkers easier to use than any other ironworker.

Most of the features of the tremendously successful P-50 can be found in the entire line of Piranha ironworkers.

It's no wonder that Piranha is the leading brand of ironworker in North America.



*Urethane strippers dramatically reduce part distortion, and also minimize the stroke length. This, plus more horsepower per ton, is why Piranha machines punch faster than the competition.*



*Piranha's dovetail slide makes changeover from punching to bending fast and easy.*



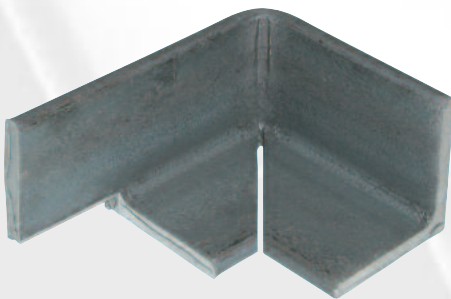
## What Can Your Ironworker Do?



*The P-50's unique automatic urethane hold-downs keep flat stock and sheet metal from distorting. There is no need for time-consuming adjustments between cuts.*



*A clear sight line, and low rake angle notcher allow easy notching and coping of all materials—fully removing the fillet on angle iron in one stroke.*



*Angle Iron — Sheared, coped, notched & bent*



*Sheared Round Bar — Square and clean cut*



*Pipe Notch*



*Saddle — Sheared, punched & bump-bent*



*Flat Stock — Sheared & bent*

Piranha's logo is known throughout the metal fabricating industry as the symbol of durable, quality-built ironworkers, press brakes and shears. Piranha equipment is simple in design, heavy in construction and outfitted with efficient, safe operator features.



Since the first Piranha ironworker came off the production line in 1973, tens of thousands of ironworkers have been delivered. Piranha's two lines of press brakes—single-cylinder and the Pro2 featuring two-cylinder action—and complete line of shears offer a broad range of heavy-duty bending and shearing capabilities.

## **MegaFab Connection**

Strong brands, reliable products, established manufacturers serving the heavy-duty metal fabrication industry join together under the MegaFab corporate umbrella.



MegaFab companies share engineering knowledge and production expertise, bringing greater efficiencies to manufacturing processes, increased innovations for all product lines, and added convenience for metal fabricators.

**MegaFab** The MegaFab brands offer a wide variety of products for the metal fabricator, including laser cutting machines, CNC plasma-punch combination machines, press brakes, ironworkers, plate rolls, section rolls, plasma cutting tables, structural punching equipment and tooling.

For specific Whitney, Piranha and Bertsch product information, visit the brand websites—[www.piranhafab.com](http://www.piranhafab.com); [www.wawhitney.com](http://www.wawhitney.com); [www.bertschrolls.com](http://www.bertschrolls.com).

## **High Quality Genuine Piranha Tooling**

***Make your Piranha Ironworker even more productive and flexible than you can imagine!***

### **High Quality Tooling**

- Genuine Piranha tooling is formulated to extend your tooling life.
- Each tool is laser-engraved for easy identification.
- Tooling is packed with a protective coating and then shrink-wrapped to cardboard. Piranha tooling arrives at your facility in the same condition it leaves ours.
- Look for the Piranha logo on your tooling.



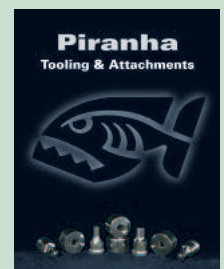
### **Fast delivery**

- Stock items ordered by 3:00 p.m. C.S.T. are shipped the same day
- Non-stock items ordered by 11:00 a.m. C.S.T. are shipped the same day

### **Special Tooling**

Piranha Engineers are on staff to design Special Tooling that may be unique to your operation. These may include gang punches, radius tools, dimples, etc.

Use your imagination to determine what your ironworker can do for you.



*To assure the best quality parts and longest tooling life, a set of genuine Piranha Punch & Die Tooling is included with each Piranha ironworker.*

**Request your NEW tooling catalog today!**  
**Log on to [www.piranhafab.com](http://www.piranhafab.com)**  
**or call 800-435-2823**

# Single Operator Ironworkers



P-40



P-50



P-70



P-90



P-120

Piranha ironworkers give metal fabricators outstanding quality and innovative features. Every Piranha provides quality work, savings in set-up time, adaptability and versatility through a wide range of tooling, and factory engineering and support.

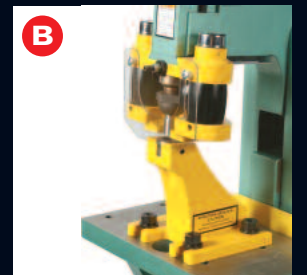
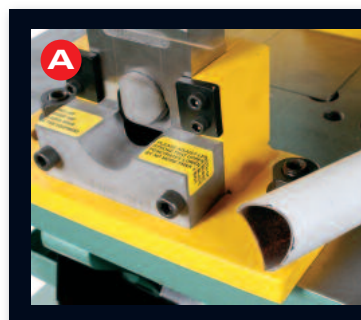
## Piranha Single Operator Ironworkers provide:

- Industry leading cycle times—punch holes in less time than other ironworkers
- Urethane Strippers—Results in less part distortion, faster cycle times, no need for stripper height adjustment
- Integrated notching station—Low shear removes fillet for precise, burr-free cuts and clean notches.
- Quick-Change Tooling—Split dovetail slide mountings—make tool changes from punching to bending in less than one minute
- Automatic Urethane Hold-Downs—This unique Piranha feature, coupled with a low rake angle, keeps parts from deforming or shifting during the shearing process. The hold-downs work automatically, eliminating the need for time-consuming adjustments between cuts.
- Ergonomics—Convenient work height and visibility for all stations. The single work height also provides added benefits when using roller feed tables.

## Piranha Ironworkers All Share These Standard Features

- Complete punching attachment with stripper
- 10 Punch and Die Sets appropriate to machine tonnage (14 included on the P-50!)
- Set of Round Bar Knives—2-way
- Two Chip Buckets
- Extra Oil Filter Element
- Coupling Wrench
- Integral lifting lug system for instant portability

**Available Accessories:** A, B, D, E, F, G, H, I, J, K, L, M



# Dual Operator Ironworkers



PII-35



PII-65  
PII-88



PII-110  
PII-140

Piranha Single Operator Ironworkers are capable of performing most applications. However, when two simultaneous operations are required (e.g. punching and notching), a dual operator ironworker fits the bill.

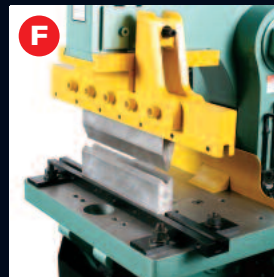
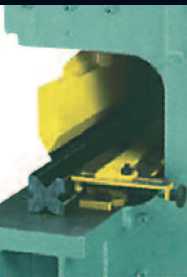
## All Dual Operator Ironworkers have:

- Large, open punch station—allows unlimited range of optional equipment and special tooling
- Longer strokes/deeper throat depths
- Large platen—for options and special tooling applications
- Long bending capability—optional bending attachments up to 48"
- 10 punch and die sets appropriate to machine tonnage
- One chip bucket
- Automatic 3-position Urethane Hold-Down on Plate, Angle and Bar Shear Stations (Manually adjustable hold-downs are standard on PII-35)
- Dual Operator Controls—punch station and shear/coper station. Each station has both a foot pedal and joystick (PII-35 has manual control only on shear/coper station)
- Front and Rear Three-Position Electric Joystick Controls (PII-35 has manual joystick valve on shear/coper station)
- Set of Plate Shear Knives (4-way)
- Set of Angle Shear Knives (8-way top/4-way bottom)
- Set of Coper Knives (2-way top/4-way bottom)
- Set of Three Coper Table Guides

## Available Accessories

PII-35: A, B, D, E, G, H, I, J, L, M

All others: A, B, C, D, E, F, G, H, I, J, K, M



# Single End Punch Presses



Whitney 1524

## Full Range of Presses—from portable presses to CNC controlled

Piranha and Whitney Single End Punch Presses lead the way for those applications that require more punching capability, larger platens or deeper throats.

The **Whitney 1524** provides precision punching using a simple **CNC control** that automatically moves the X and Y gauge position. This workhorse machine provides:

- Flexible 28XX tooling system
- Accurate parts—no more layout work!
- Canned cycles for bolt holes, line and angle, slot nibbles, window cuts, arcs, circles and grid patterns
- Ability to use forming tools such as louvers, countersinks and knockouts (requires pressure switch option)
- Process channel and angle iron (optional)
- Multiple program storage—up to 200 programs
- Offline programming (optional)



SEPP-35



SEPP-65  
SEPP-88

The **Piranha Single End Punch Press (SEPP) Series** has capacities ranging from 35 to 140 tons. Large open throats accommodate a variety of tooling and accessories.

All SEPPs feature:

- Complete punching attachment with stripper
- Extra oil filter
- Coupling wrench
- Integral lifting lug for instant portability



SEP-120

### Available Accessories

SEPP-35: A, B, D, E, G, H, I, L, M

SEPP-65/88: A, B, C, D, E, F, G, H, I, M

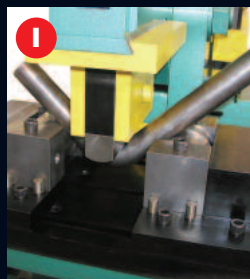
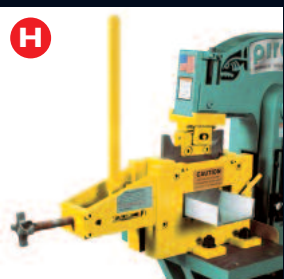
SEP-120: A, B, D, E, G, I, M

SEPP-140: A, B, C, D, E, F, G, H, I, M



SEPP-140

**Whitney's Portable Press** product line allows you to move your punching machine to the workpiece. These presses are great for structural shapes. Tonnages are available from 20 to 250 tons, in both web and flange styles.



# Accessories to Enhance Your Piranha's Versatility

## **A** Pipe/Tube Notching Attachment

- Mounts easily to platen
- Spring-loaded return
- Standard base die 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 for larger pipe 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-40, P-50, P-70, P-90 and P-120)

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

## **C** Bending Backgauge

- Produce repeatable parts with a backgauge specifically made for the bending attachment
- Use the bending backgauge as a hard stop to increase productivity when making multiple parts
- The backgauge eliminates the need for manually scribing bend lines

## **D** Bending Attachments

- Standard on P-40 (6"), P-50 (8"), P-70 (12"), P-90 (12") and P-120 (12")
- Optional sizes range from 12" to 48". See specifications chart for sizes available for each model.

## **E** 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 and without urethane stripper (shown)

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.

## **F** Press Brake Tooling Holders

- Available for models P-50, P-70, P-90, P-120, PII-65, PII-88, PII-110, PII-140, SEPP-65, SEPP-88 and SEPP-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)

## **G** 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

## **H** 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

## **I** Bar Bender

- Up to 2-1/2" depending on available tonnage
- Adjustable die for different radii

## **J** 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

## **K** Electrical Backgauge

- Electronic version automatically cycles the ironworker when material contacts the backgauge
- Available for models P-40, P-50, P-70, P-90, P-120, PII-65, PII-88, PII-110, PII-140
- 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.

## **L** 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-40, P-50, PII-35 and SEPP-35 models

## **M** Roller Feed Tables

- 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

# Piranha Ironworkers Capacities & Specifications

## Rated on Mild Steel (60,000) PSI Tensile Strength

All machines subject to changes in specification



Piranha — A Division of MegaFab

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Throat Depth	P-40 5'	P-50 8'	P-70 10'	P-90 12'	P-120 12'	PII-35 7'	PII-65 9'	PII-88 9'	PII-110 20.5'	PII-140 20.5'	1524 24"	SEPP-35 7'	SEPP-65 9'	SEPP-88 9'	SEP-120 21.5'	SEPP-140 20.5'
Open Height	11-1/2"	13-1/2"	15'	15-1/2"	15-1/2"	10"	14"	14"	14"	14"	5-3/8"	10"	14"	14"	12-1/4"	14"
Closed Height w/o Die Block	7-1/2"	9-1/4"	10-1/8"	10-1/4"	10-1/4"	7-1/4"	7-3/4"	7-3/4"	7-3/4"	7-3/4"	3-3/8"	7-1/4"	7-3/4"	7-3/4"	10-1/4"	7-3/4"
Stroke Length	4"	4-1/4"	4-7/8"	5-1/4"	5-1/4"	4-1/4"	7"	7"	7"	7"	Z	4-1/4"	7"	7"	Z	7"
Platen Table Size (L-W)	8' x 10"	10' x 17"	12' x 21"	14-1/2' x 21"	14-1/2' x 21"	11' x 21-1/4"	11' x 38"	11' x 38"	16' x 36"	16' x 36"	24' x 36"	11' x 21"	11' x 38"	11' x 38"	20' x 10"	16' x 36"
Punch Hole Size (Max Material)	40 Tons 1" (1/2") 1-1/2" (3/16")	50 Tons 13/16" (3/4") 5" (1/8")	70 Tons 1-3/16" (3/4") 4-1/2" (3/16")	90 Tons 1-1/8" (1") 5" (3/16")	120 Tons 1-1/2" (1") 5" (1/4")	35 Tons 13/16" (1/2") 3-1/2" (1/8")	65 Tons 1-1/16" (3/4") 5" (1/8")	88 Tons 1-1/16" (1") 5" (3/16")	110 Tons 1-7/16" (1") 5" (1/4")	140 Tons 1-3/8" (1-1/4") 5" (5/16")	50 Tons 1-1/16" (1/2") 3-1/2" (1/8")	35 Tons 13/16" (1/2") 3-1/2" (1/8")	65 Tons 1-1/16" (3/4") 5" (1/8")	88 Tons 1-1/16" (1") 5" (3/16")	120 Tons 1-1/2" (1") 5" (1/4")	140 Tons 1-3/8" (1-1/4") 5" (5/16")
Max. Hole Size (Material)	13" Long 5/8" x 6" 1/2" x 8" 1/4" x 13"	15-1/2" Long +1" x 4" 3/4" x 10" 5/8" x 15"	18" Long 1" x 6" 3/4" x 12" 1/2" x 18"	20-1/2" Long 1" x 6" 3/4" x 18" 1/2" x 20"	20-1/2" Long 1" x 12" 3/4" x 18" 1/2" x 20"	13" Long 5/8" x 6" 1/2" x 8" 1/4" x 13"	24" Long 3/4" x 8" 5/8" x 12" 1/4" x 24"	24" Long 3/4" x 8" 5/8" x 12" 1/4" x 24"	18" Long 1" x 12" 3/4" x 18" 1/2" x 20"	20-1/2" Long 1" x 14" 3/4" x 18" 1/2" x 20"	N/A	Optional	Optional	Optional	N/A	Optional
Plate Shear	3-1/2" x 3-1/2" x 3/16"	5" x 5" x 3/8" 4" x 4" x 1/2"	5" x 5" x 1/2"	6" x 6" x 5/8"	6" x 6" x 5/8"	3-1/2" x 3-1/2" x 5/16"	5" x 5" x 3/8" +4" x 4" x 1/2"	5" x 5" x 3/8" +4" x 4" x 1/2"	5" x 5" x 1/2"	6" x 6" x 5/8"	N/A	Optional	Optional	Optional	N/A	Optional
Angle Shear	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional
Bar Shear	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional
Round (min. to max.) Square (min. to max.)	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional	Optional
Open-Notcher (Tons)	40	56	75	95	95	40	56	56	75	95	N/A	Optional	Optional	Optional	N/A	Optional
Bending Attach. (std.) (Optional Length)	6" 12"	8" 12", 14", 24"	12" 24"	12" 24"	12" 24"	Optional 24"	Optional 24", 36", 48"	Optional 24", 36", 48"	Optional 18", 24", 36", 48"	Optional 18", 24", 36", 48"	N/A	Optional 24"	Optional 24", 36", 48"	Optional 24", 36", 48"	Optional 18"	Optional 18", 24", 36", 48"
Punch End Strokes Per Minute Optional Speed-Up Kit	50 @ 1/2"	80 @ 1/2" N/A	30 @ 3/4" N/A	40 @ 3/4" N/A	40 @ 3/4"	28 @ 1" 37 @ 1"	19 @ 1" N/A	19 @ 1" N/A	25 @ 1"	24 @ 1"	30 @ 1.35"	28 @ 1" 37 @ 1"	19 @ 1" N/A	19 @ 1" N/A	16 @ 1" N/A	24 @ 1"
Work Station Height (Approx.)	42"	42"	42"	44"	44"	40"	41"	41"	44"	44"	41"	10-1/2" w/stand 41"	41"	41"	42"	44"
Hydraulics Pump GPM System RVV PSI	7.6 2000	10.5 2600	15 2600	15 2650	15 3500	4.4 3500	7.5 3500	7.5 3500	12.5 3700	15 3500	4.2 5000	4.4 3500	7.5 2500	7.5 3500	10.5 2650	15 3500
Fluid Capacity (gal.)	12	20	25	25	25	12	20	20	40	40	30	7	12	12	30	40
Motor Std. 230/460 3 Ph. 1800 RPM Opt. Phase & Voltage Available	5 HP 3 Ph.	10 HP 3 Ph.	15 HP 3 Ph.	15 HP 3 Ph.	20 HP 3 Ph.	5 HP 3 Ph.	10 HP 3 Ph.	10 HP 3 Ph.	15 HP 3 Ph.	20 HP 3 Ph.	10 HP 3 Ph.	5 HP 3 Ph.	10 HP 3 Ph.	10 HP 3 Ph.	10 HP 3 Ph.	20 HP 3 Ph.
Dimensions (Net) W-L-Approx.	24" x 55" x 58"	24" x 65" x 60"	31" x 79" x 64"	35" x 90" x 66-1/2"	35" x 90" x 68-1/2"	23" x 62" x 63"	38" x 90" x 72"	38" x 90" x 72"	38" x 112" x 85"	38" x 120" x 85"	94" x 71" x 67"	21" x 33" x 40"	38" x 42" x 72"	38" x 42" x 72"	48" x 60" x 72"	93" x 51" x 85"
Weight (Net) Lbs. Approx.	1700	2600	4250	5800	6200	2600	4000	4700	10,000	11,930	6000	950	2500	2900	4100	7800