Ironworkers

Single & Dual Operator Hydraulic Ironworkers

American Made with 3-Year Warranty

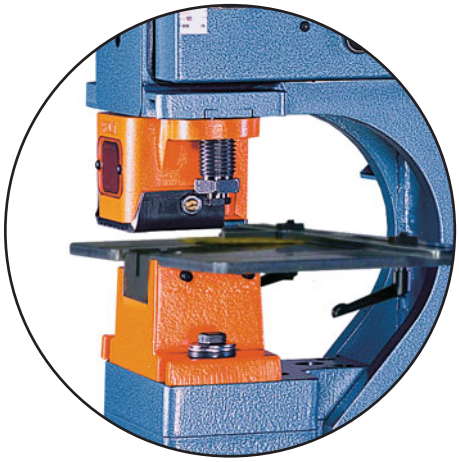
Backed by the Scotchman reputation of superior quality and dependability, our ironworkers are built tough to last generations. Models range in capacity from 45-150 tons and are available in two distinct styles.

- Our unique Component Tool Table style provides flexibility to swap-out tooling quickly for those quick turnaround jobs. The variety of tooling options available for this style gives it unmatched versatility to any other machine on the market.
- Fully-Integrated Ironworkers feature built-in tools and are suited best for repetitive, higher volume projects.

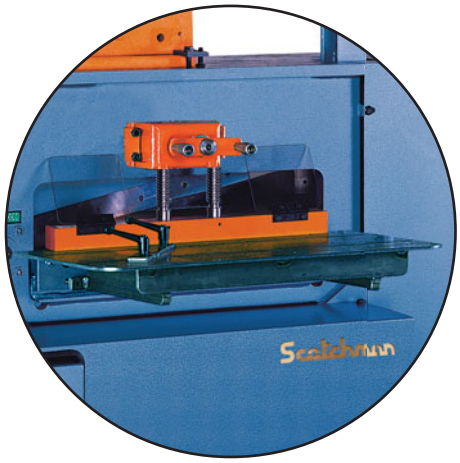
CAPACITY CHART QUICK REFERENCE GUIDE 5-6
45 TON 7-8
50 TON 9-10
65 TON 11
70 TON 12
85 TON 13-14
90 TON 15
95 TON 16
120 TON 17-18
135 TON 19
150 TON 20
OPTIONAL TOOLING 21-22
CUSTOM TOOLING 23
IN-STOCK PUNCH & DIES 24
PRODUCTION SHEAR 25

MADE IN USA

Component Tool Style Workstations

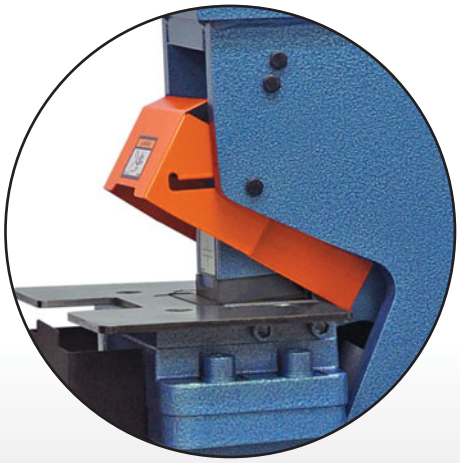


PUNCH:
The punch station is one of the most functional standard tools on any ironworker. A full range of punches & dies in standard shapes and increments are available in-stock for your various punching needs, plus tooling can be custom built for your special application. This workstation can also be used for additional applications beyond strictly punching.

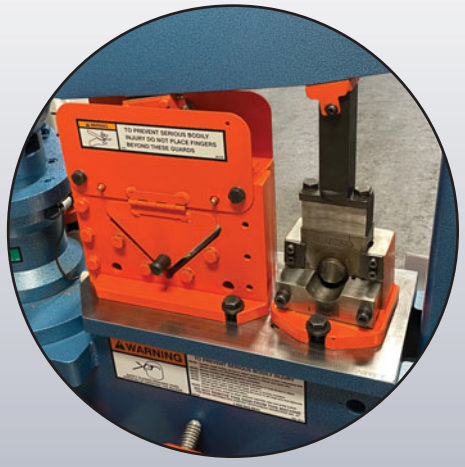


FLAT BAR SHEAR:
A flat bar shear is a standard workstation on all ironworkers, but not all bar shears are created equal. All Scotchman ironworkers have a shear with a variable rake angle which minimizes distortion of the cut and increases cut time for a faster shear cycle. From 6" to 24" in width, each Scotchman ironworker is equipped with the best shear for its capacity. Hold-downs are easily adjustable with good visibility, and the reversible shear blades provide a long life of plate shearing.

ANGLE SHEAR:
This useful tool is standard on every Scotchman ironworker. Produces a distortion free cut, and can easily & quickly 45° miter cut.



NOTCHER:
Ideal for notching and nibbling of plate and angle iron. When versatility is key, a coper notcher is essential. Standard workstation on most Scotchman ironworker models, but available as an option on the models it is not standard.



TOOL TABLE WORKSTATION FOR COMPONENT TOOLS:
When versatility and flexibility are key, our unique tool table workstation is indispensable! This tool table design is unique to Scotchman and creates a workstation that is fully customizable allowing an extensive variety of different tooling options to be used and switched out easily, without losing the punch station. This workstation acts as an additional power source which allows users to tailor the machine to their individual needs.

Scotchman has a variety of tooling options available as well as a full-time custom tooling department making the options nearly endless.

Ironworker Capacities

		45 ton	50 ton	50 ton	65 ton	70 ton	85 ton
		Single Operator	Single Operator	Single Operator	Single Operator	Dual Operator	Single Operator
Machine Design Style		Component Tool Table	Component Tool Table	Component Tool Table	Component Tool Table	Component Tool Table	Fully Integrated Tools
Punch	Throat Depth	4-1/4"	6"	4"	9"	9"	10"
	Tonnage	**45 ton**	**50 ton**	**50 ton**	**65 ton**	**70 ton**	**85 ton**
	Capacity	1-1/8" in 1/2"	1-1/4" in 1/2" 13/16" in 3/4"	1-1/4" in 1/2" 13/16" in 3/4"	1-1/16" in 3/4"	1-1/8" in 3/4"	1-1/16" in 1"
	Max. Hole	2-1/4"	2-1/4"	2-1/4"	4"	4"	4"
Bar Shear	Blade Length	**6"**	**14"**	**14"**	**24"**	**24"**	**20"**
	Max. Capacity	1/2" x 4" 3/8" x 6"	3/4" x 4" 1/2" x 8" 3/8" x 10" 1/4" x 14"	3/4" x 4" 1/2" x 8" 3/8" x 10" 1/4" x 14"	1" x 6" 3/4" x 10" 1/2" x 12" 3/8" x 16" 1/4" x 24"	1" x 6" 3/4" x 10" 1/2" x 14" 3/8" x 24"	1" x 12" 3/4" x 20"
Angle Shear	Angle Shear, 90°	3" x 3" x 5/16"	4" x 4" x 3/8"	4" x 4" x 3/8"	6" x 6" x 3/8" 5" x 5" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"
	Angle Shear, 45°	2" x 2" x 1/4"	2" x 2" x 1/4"	2" x 2" x 1/4"	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	4" x 4" x 1/2" (with bar shear)
Channel Shear	Size Avail.	up to 3"	up to 3"	up to 3"	2" to 5" adjustable	2" to 6" adjustable	2" to 6" adjustable
Rod Shear	Round Rod	1/4" to 1", 5 cavity	1/4" to 1", 5 cavity	1/4" to 1", 5 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	1-1/2", 1 cavity
	Square Rod	1/4" to 3/4", 1 cavity	1/4" to 3/4", 1 cavity	1/4" to 3/4", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	1-1/4", 1 cavity
Tube Shear	Square Tube	1/2" to 1", 12 gauge	1/2" to 1", 12 gauge	1/2" to 1", 12 gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 gauge
Notcher	Rectangle	2" x 1-3/4" x 1/4"	2-1/2" x 3" x 5/16" 2-1/2" x 2-3/4" x 3/8"	2-1/2" x 3" x 5/16" 2-1/2" x 2-3/4" x 3/8"	2" x 2-1/2" x 3/8"	3" x 5" x 3/8" 3" x 4" x 1/2"	3" x 5" x 1/2"
	90° V	6" x 6" x 1/8"	6" x 6" x 1/8" 3" x 3" x 1/4"	6" x 6" x 1/8" 3" x 3" x 1/4"	6" x 6" x 5/16"	6" x 6" x 5/16"	6" x 6" x 5/16" (Punch Station)
	Pipe (Sch. 40)	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"
Bending	Brake Size Avail.	6", 8", 12", 6" Open-End	6", 8", 12", 6" Open-End	6", 8", 12", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End
Picket Tool	Size	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)
Motor	Standard	110v	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph
	Optional	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph
***Not all functions & capacities are standard, but can be achieved with optional tooling.** ***Custom built tooling is available upon request.**							
Model Name		**Porta Fab 45**	**50514-EC**	**5014-ET**	**6509**	**DO 70**	**FI 85**
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85 ton	90 ton	95 ton	120 ton	120 ton	135 ton	150 ton	Production Shear
Dual Operator	**Single Operator**	**Dual Operator**	**Single Operator**	**Dual Operator**	**Dual Operator**	**Dual Operator**	**Single Operator**
Fully Integrated Tools	**Component Tool Table**	**Component Tool Table**	**Component Tool Table**	**Component Tool Table**	**Component Tool Table**	**Component Tool Table**	**Shear Only**
14"	12"	9"	12"	12"	12"	12"	N/A
85 ton	**90 ton**	**95 ton**	**120 ton**	**120 ton**	**135 ton**	**150 ton**	
1-1/16" in 1"	1-1/8" in 1"	1-3/16" in 1"	1-1/2" in 1"	1-1/2" in 1"	1-11/16" in 1"	1-7/8" in 1"	
4"	4"	4"	4"	4"	4"	4"	
20"	**24"**	**24"**	**24"**	**24"**	**24"**	**24"**	**24"**
1" x 14" 3/4" x 20"	1" x 8" 3/4" x 12" 1/2" x 16" 1/4" x 24"	1" x 8" 3/4" x 12" 1/2" x 16" 3/8" x 24"	1" x 12" 3/4" x 20" 1/2" x 24"	1" x 12" 3/4" x 20" 1/2" x 24"	1" x 12" 3/4" x 20" 1/2" x 24"	1" x 14" 3/4" x 24"	1" x 12" 3/4" x 16" 1/2" x 24"
6" x 6" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"	6" x 6" x 1/2"	N/A
4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	3" x 3" x 3/8" 4" x 4" x 1/2" (with bar shear)	
2" to 6"	2" to 6" adjustable	2" to 6" adjustable	2" to 6" adjustable	2" to 6" adjustable	2" to 6" adjustable	2" to 6" adjustable	
1/2", 3/4", 1", 1-1/2", 4 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	1/4" to 1-1/4", 9 cavity	
1-1/2", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	1/4" to 1", 1 cavity	
1/2" to 2", 12 gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 Gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 gauge	1/2" to 2", 12 gauge	
2" x 4" x 1/2"	2" x 2-1/2" x 3/8"	3" x 5" x 3/8" 3" x 4" x 1/2"	2" x 2-1/2" x 3/8"	3" x 5-3/4" x 1/2"	3" x 5-3/4" x 1/2"	3" x 5-3/4" x 1/2"	
3" x 3" x 1/2" (Notcher Station) 6" x 6" x 5/16" (Punch Station)	6" x 6" x 5/16"	6" x 6" x 5/16"	6" x 6" x 5/16"	6" x 6" x 5/16"	6" x 6" x 5/16"	6" x 6" x 5/16"	
3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	3/4" to 2"	
12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	12", 24", 6" Open-End	
1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	1/2", 3/4", & 1" (16 gauge)	
230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph	230/460v, 3 ph
220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph	220v, 1 ph
DO 85	**9012**	**DO 95**	**12012**	**DO 120**	**DO 135**	**DO 150**	**ShearMaster 610**
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45 Ton

IRONWORKERS

SINGLE OPERATOR

4 STATIONS

PORTA FAB 45

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	45 ton (41 mt) 1-1/8" in 1/2" (28 mm in 12 mm)
Special Tooling	2-1/4" (57 mm) Max. Dia.
Throat Depth	4-1/4" (108 mm)
Flat Bar Shear	6" Length (152 mm) 1/2" x 4" (12 x 102 mm) 3/8" x 6" (10 x 152 mm)
Angle Shear 90°	3" x 3" x 5/16" (76 x 76 x 8 mm)
Angle Shear 45°	2" x 2" x 1/4" (51 x 51 x 6 mm)
Round Rod Shear	3/4" (19 mm)
Brake 8"	25 ton (23 mt)
Brake 12"	20 ton (18 mt)
Open End Brake	Max. 1/4" x 3" (6 x 76 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 1-3/4" x 1/4" (51 x 44 x 6 mm)
90° V-Notcher	6" x 6" x 1/8" (152 x 152 x 3 mm)
Rod Shear Round (max.)	5 Cavity, 1/4" to 1" (6 mm to 25 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 3/4" (6 mm to 19 mm)
Unistrut Shear	Samples Required
Square Tube Shear	1/2" to 1" (12 mm to 25 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Strokes per minute in light material	10 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	4 spm (3/4" stroke) [Punch Station]
Hydraulics	2,500 psi (172 bar)
Motor Options (must specify)	2 hp 110 v 2 hp 1 ph (1.49 kW) 220 v
Dimensions	L-38-1/4" (97 cm) W-20" (51 cm) H-39-1/4" (100 cm) H w/base-56-3/4" (144 cm)
Shipping Weight (may vary)	710 lbs. (322 kg)

STANDARD FEATURES

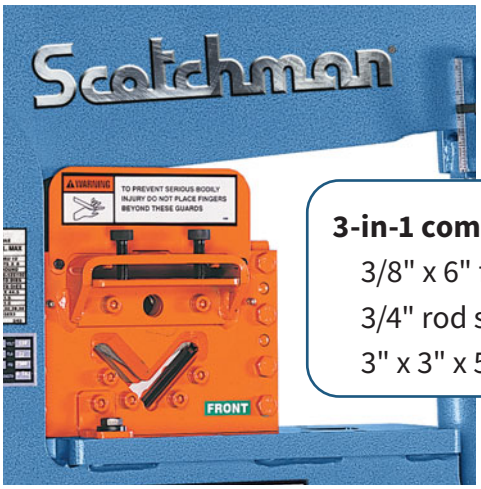
- 45 ton punch station
- Keyed punch ram for safety
- 2" die holder
- Punch nut with wrench and stripper
- One round punch & die: max. diameter 1"
- Electric remote foot pedal
- Adjustable electric stroke control with scale
- Three-in-one combination tool:
  Angle shear, Bar shear, and Rod shear
- 14" Tool table work area
- Slug receptacle
- Machine stand with punch & die & tooling storage rack
- 110 volt electrics
- Complies with ANSI B 11.5 safety standards
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

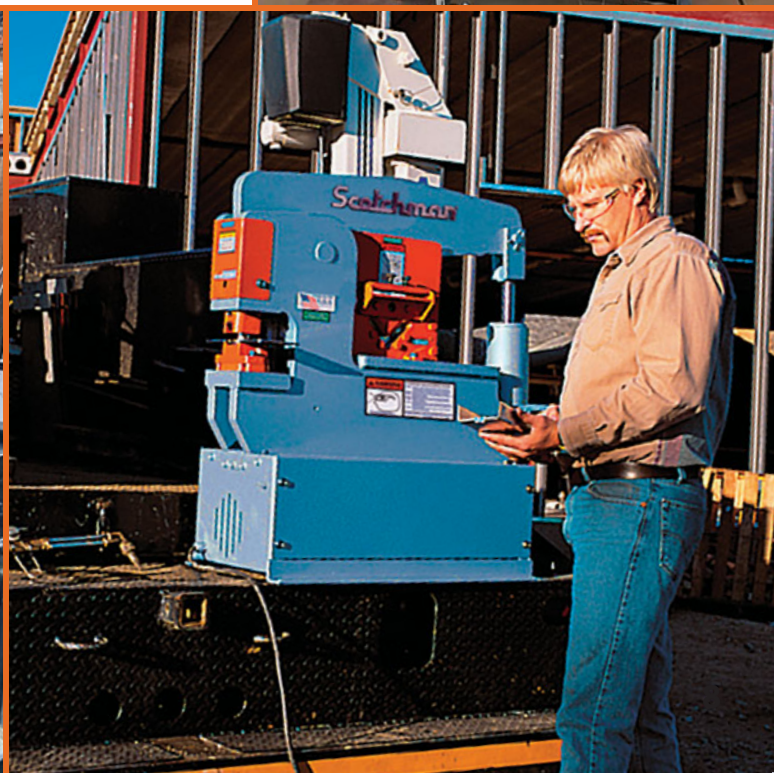
45 Ton

It's portable, versatile, and designed for in-plant or on-the-job operation; a perfect choice for the fabricator on-the-go!

With 45-ton punching capacity, this ironworker can punch 1-1/8" hole through 1/2" mild steel and runs on 110-volt power from your standard wall outlet or generator. A 3-in-1 combination tool comes standard and is located in our unique tool table area. This versatile workstation allows additional tooling to be easily swapped in and out so you can customize the machine to fit your needs.



3-in-1 combination tool:
- 3/8" x 6" flat bar shear
- 3/4" rod shear
- 3" x 3" x 5/16" angle shear



50 Ton

SINGLE OPERATOR
5 STATIONS

50514-EC

Single punch station

SINGLE OPERATOR
7 STATIONS

5014-ET

3-station revolving turret punch

STANDARD FEATURES

- 50 ton punch station
- 2" die holder (per punch station)
- Punch nut & stripper (per punch station)
- One round punch & die: max. diameter 1"
- Keyed punch ram for safety
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Angle shear
- Flat bar shear with 4-way reversible blade
- Rectangle notcher
- 14" Tool table work area
- Slug receptacle
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

50 Ton

IRONWORKERS

	50514-EC	5014-ET
	Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	50 ton (45 mt) 1-1/4" in 1/2" (32 mm in 12 mm) 13/16" in 3/4" (20 mm in 19 mm)	50 ton (45 mt) 1-1/4" in 1/2" (32 mm in 12 mm) 13/16" in 3/4" (20 mm in 19 mm)
Special Tooling	2-1/4" (57 mm) Max. Dia.	2-1/4" (57 mm) Max. Dia.
Throat Depth	6" (152 mm)	4" (102 mm)
Flat Bar Shear	14" Length (356 mm) 3/4" x 4" (19 x 102 mm) 1/2" x 8" (12 x 203 mm) 3/8" x 10" (10 x 254 mm) 1/4" x 14" (6 x 356 mm)	14" Length (356 mm) 3/4" x 4" (19 x 102 mm) 1/2" x 8" (12 x 203 mm) 3/8" x 10" (10 x 254 mm) 1/4" x 14" (6 x 356 mm)
Opt. Sabre Blade	1/2" x 10" (12 x 254 mm) 3/8" x 12" (10 x 305 mm)	1/2" x 10" (12 x 254 mm) 3/8" x 12" (10 x 305 mm)
Angle Shear 90°	4" x 4" x 3/8" (102 x 102 x 10 mm)	4" x 4" x 3/8" (102 x 102 x 10 mm)
Angle Shear 45°	2" x 2" x 1/4" (51 x 51 x 6 mm)	2" x 2" x 1/4" (51 x 51 x 6 mm)
Brake 8"	30 ton (27 mt)	25 ton (23 mt)
Brake 12"	25 ton (23 mt)	25 ton (23 mt)
Open End Brake	Max. 1/4" x 3" (6 x 76 mm) [Flat or Angle Iron]	Max. 1/4" x 3" (6 x 76 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2-1/2" x 3" x 5/16" (63 x 76 x 8 mm) 2-1/2" x 2-3/4" x 3/8" (63 x 70 x 10 mm)	2-1/2" x 3" x 5/16" (63 x 76 x 8 mm) 2-1/2" x 2-3/4" x 3/8" (63 x 70 x 10 mm)
90° V-Notcher	6" x 6" x 1/8" (152 x 152 x 3 mm) 3" x 3" x 1/4" (76 x 76 x 6 mm)	6" x 6" x 1/8" (152 x 152 x 3 mm) 3" x 3" x 1/4" (76 x 76 x 6 mm)
Unistrut Shear	Samples Required	Samples Required
Rod Shear Round (max.)	5 Cavity, 1/4" to 1" (6 mm to 25 mm)	5 Cavity, 1/4" to 1" (6 mm to 25 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 3/4" (6 mm to 19 mm)	1 Cavity, 1/4" to 3/4" (6 mm to 19 mm)
Square Tube Shear	1/2" to 1" (12 mm to 25 mm) 12 gauge (0.105" / 2.7 mm)	1/2" to 1" (12 mm to 25 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)	2" wide x 3/8" (51 mm x 10 mm)
Strokes per minute in light material	34 spm (1/4" stroke) [Punch Station]	34 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	14 spm (3/4" stroke) [Punch Station]	14 spm (3/4" stroke) [Punch Station]
Hydraulics	2,350 psi (162 bar)	2,350 psi (162 bar)
Motor Options (must specify)	3 hp 3 ph (2.24 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v	3 hp 3 ph (2.24 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v
Dimensions	L-48-1/4" (122.5 cm) W-23-1/2" (60 cm) H-63-3/4" (161 cm)	L-48-1/4" (122.5 cm) W-23-1/2" (60 cm) H-70-1/4" (178.5 cm)
Shipping Weight (may vary)	1,580 lbs. (717 kg)	1,640 lbs. (744 kg)

65 Ton

IRONWORKERS

SINGLE OPERATOR
4 STATIONS

6509-24M

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	65 ton (58 mt) 1-1/16" in 3/4" (27 mm in 19 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	9" (229 mm)
Flat Bar Shear	24" Length (610 mm) 1" x 6" (25 x 152 mm) 3/4" x 10" (19 x 254 mm) 1/2" x 12" (12 x 305 mm) 3/8" x 16" (10 x 406 mm) 1/4" x 24" (6 x 610 mm)
Opt. Sabre Blade	1" x 6" (25 x 152 mm) 1/2" x 16" (12 x 406 mm)
Angle Shear 90°	6" x 6" x 3/8" (152 x 152 x 10 mm) 5" x 5" x 1/2" (127 x 127 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	40 ton (36 mt)
Brake 24"	30 ton (27 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 2-1/2" x 3/8" (51 x 63 x 10 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm)
Channel Shear	2" to 5" adj. (51 mm to 127 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity , 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	58 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	26 spm (3/4" stroke) [Punch Station]
Hydraulics	2,600 psi (183 bar)
Motor Options (must specify)	5 hp 3 ph (3.73 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v
Dimensions	L-60-3/4" (154.5 cm) W-30" (76 cm) H-64-1/2" (164 cm)
Shipping Weight (may vary)	2,984 lbs. (1,354 kg)

STANDARD FEATURES

- 65 ton punch station
- Keyed punch ram for safety
- Punch gauging table w/fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench and stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Flat bar shear with 4-way reversible blade
- Shear table with miter fence
- Angle shear
- 24" Tool table work area
- Slug receptacle
- Two-stage hydraulic pump
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

SCOTCHMAN 3YR. WARRANTY

MADE IN USA

▷ Additional tooling options see pages 21-24

70 Ton

DUAL OPERATOR
5 STATIONS

DO 70/110-24M

IRONWORKERS

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	70 ton (63 mt) 1-1/8" in 3/4" (29 mm in 19 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	9" (229 mm)
Flat Bar Shear (sabre blade-std.)	24" Length (610 mm) 1" x 6" (25 x 152 mm) 3/4" x 10" (19 x 254 mm) 1/2" x 14" (12 x 356 mm) 3/8" x 24" (10 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	65 ton (59 mt)
Brake 24"	45 ton (40 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5" x 3/8" (76 x 127 x 10 mm) 3" x 4" x 1/2" (76 x 101 x 12 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm) 3" x 3" x 3/8" (76 x 76 x 10 mm)
Notching in Leg of Channel	6" to 10" (152 mm to 254 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity , 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	38 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	15 spm (3/4" stroke) [Punch Station]
Hydraulics	3,000/3,000 psi (207/207 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-69" (175 cm) W-37-1/2" (95 cm) H-71" (180 cm)
Shipping Weight (may vary)	3,800 lbs. (1,724 kg)

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 70 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Two adjustable electric stroke controls with scale
- Two electric remote foot pedals
- Tandem hydraulic pump
- Two valves
- Angle shear
- Rectangle notcher with table, scale and guides
- Flat bar shear with sabre blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

SCOTCHMAN 3YR. WARRANTY

MADE IN USA

▷ Additional tooling options see pages 21-24

85 Ton

IRONWORKERS

SINGLE OPERATOR

5 STATIONS

FI 8510-20M

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	85 ton (77 mt) 1-1/16" in 1" (27 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	10" (254 mm)
Flat Bar Shear (sabre blade-std.)	20" Length (508 mm) 1" x 12" (25 x 305 mm) 3/4" x 20" (19 x 508 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° (with Bar Shear)	4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	85 ton (77 mt)
Brake 24"	85 ton (77 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5" x 1/2" (76 x 127 x 12 mm)
90° V-Notcher (Punch Station)	6" x 6" x 5/16" (152 x 152 x 8 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	1 cavity, 1-1/2" (38 mm)
Rod Shear Square (max.)	1 cavity, 1-1/4" (32 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	51 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	24 spm (3/4" stroke) [Punch Station]
Hydraulics	2,600 psi (179 bar)
Motor Options (must specify)	5 hp 3 ph (3.76 kW) 208/230/460, 380/575v 5 hp 1 ph (3.76 kW) 220v
Dimensions	L-67-3/4" (172 cm) W-32" (81.5 cm) H-78" (198 cm)
Shipping Weight (may vary)	4,554 lbs. (2,066 kg)

STANDARD FEATURES

- 85 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Punch jog control
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Slug-less angle shear
- Flat bar shear with sabre blade
- Shear table with miter fence
- Rod shear
- Slug receptacles
- Rectangle notcher with table, scale and guide
- Two-stage hydraulic pump
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

85 Ton

DO 8514-20M

DUAL OPERATOR
5 STATIONS

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 85 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Punch jog control
- Two adjustable electric stroke controls with scale
- Two electric remote foot pedals
- Tandem hydraulic pump
- Two valves
- Slug-less angle shear
- Rectangle notcher: can be converted to a V-Notcher, 50 ton punch station, or open end brake
- Flat bar shear with sabre blade
- Shear table with miter fence
- Rod shear
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	85 ton (77 mt) 1-1/16" in 1" (27 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	14" (355 mm)
Flat Bar Shear (sabre blade-std.)	20" Length, (508 mm) 1" x 14" (25 x 355 mm) 3/4" x 20" (19 x 508 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° (with Bar Shear)	4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	85 ton (77 mt)
Brake 24"	85 ton (77 mt)
Open End Brake (Notcher Station)	Max. 1/2" x 6" (12 x 152 mm) [Flat or Angle Iron]
Open End Brake (Punch Station)	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 4" x 1/2" (51 x 101 x 12 mm)
90° V-Notcher (Punch Station)	6" x 6" x 5/16" (152 x 152 x 8 mm)
90° V-Notcher (Notcher Station)	3" x 3" x 1/2" (76 x 76 x 12 mm)
Punch Attachment (Notcher Station)	50 ton 1-1/4" in 1/2" (32 mm in 12 mm)
Throat Depth w/ Punch attachment (Notcher Station)	4-7/16" (113 mm)
Channel Shear	2" to 6" (51 mm to 152 mm)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	4 cavities, 1/2", 3/4", 1", 1-1/2" (12 mm, 19 mm, 25 mm, 38 mm)
Rod Shear Square (max.)	1 cavity, 1-1/2" (38 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	45 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	18 spm (3/4" stroke) [Punch Station]
Hydraulics	3,350/3,800 psi (231/262 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-77-1/2" (197 cm) W-32-1/4" (82 cm) H-74" (188 cm)
Shipping Weight (may vary)	5,504 lbs. (2,497 kg)

▷ Additional tooling options see pages 21-24

90 Ton

IRONWORKERS

SINGLE OPERATOR
4 STATIONS

9012-24M

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	90 ton (80 mt) 1-1/8" in 1" (29 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	12" (305 mm)
Flat Bar Shear	24" Length (610 mm) 1" x 8" (25 x 203 mm) 3/4" x 12" (19 x 305 mm) 1/2" x 16" (12 x 406 mm) 1/4" x 24" (6 x 610 mm)
Opt. Sabre Blade	1/2" x 22" (12 x 559 mm) 3/8" x 24" (10 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	50 ton (45 mt)
Brake 24"	40 ton (36 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 2-1/2" x 3/8" (51 x 63 x 10 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	45 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	24 spm (3/4" stroke) [Punch Station]
Hydraulics	2,600 psi (179 bar)
Motor Options (must specify)	5 hp 3 ph (3.73 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v
Dimensions	L-76-3/4" (195 cm) W-31" (79 cm) H-71-1/2" (181.5 cm)
Shipping Weight (may vary)	4,204 lbs. (1,907 kg)

STANDARD FEATURES

- 90 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Angle shear
- Flat bar shear with 4-way reversible blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacle
- Two-stage hydraulic pump
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

SCOTCHMAN 3YR. WARRANTY

MADE IN USA

▷ Additional tooling options see pages 21-24

95 Ton

DO 95/140-24M

DUAL OPERATOR

5 STATIONS

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	95 ton (86 mt) 1-3/16" in 1" (30 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	9" (229 mm)
Flat Bar Shear (sabre blade-std.)	24" Length (610 mm) 1" x 8" (25 x 203 mm) 3/4" x 12" (19 x 305 mm) 1/2" x 16" (12 x 406 mm) 3/8" x 24" (10 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	80 ton (72.5 mt)
Brake 24"	55 ton (50 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5" x 3/8" (76 x 127 x 10 mm) 3" x 4" x 1/2" (76 x 101 x 12 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm) 3" x 3" x 3/8" (76 x 76 x 10 mm)
Notching in Leg of Channel	6" to 10" (152 mm to 254 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity , 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	38 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	15 spm (3/4" stroke) [Punch Station]
Hydraulics	3,500/3,500 psi (241/241 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-69" (175 cm) W-37-1/2" (95 cm) H-71" (180 cm)
Shipping Weight (may vary)	3,800 lbs. (1,724 kg)

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 95 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Two adjustable electric stroke controls with scale
- Two electric remote foot pedals
- Tandem hydraulic pump
- Two valves
- Angle shear
- Rectangle notcher with table, scale and guides
- Flat bar shear with sabre blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

120 Ton

IRONWORKERS

SINGLE OPERATOR

4 STATIONS

12012-24M

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	120 ton (108 mt) 1-1/2" in 1" (38 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	12" (305 mm)
Flat Bar Shear	24" Length (610 mm) 1" x 12" (25 x 305 mm) 3/4" x 20" (19 x 508 mm) 1/2" x 24" (12 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	83 ton (75 mt)
Brake 24"	65 ton (59 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	2" x 2-1/2" x 3/8" (51 x 63 x 10 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	47 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	19 spm (3/4" stroke) [Punch Station]
Hydraulics	2,600 psi (179 bar)
Motor Options (must specify)	5 hp 3 ph (3.73 kW) 208/230/460, 380/575v 5 hp 1 ph (3.73 kW) 220v
Dimensions	L-79" (201 cm) W-32" (81 cm) H-75" (191 cm)
Shipping Weight (may vary)	5,204 lbs. (2,360 kg)

STANDARD FEATURES

- 120 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Adjustable electric stroke control with scale
- Electric remote foot pedal
- Angle shear
- Flat bar shear with 4-way reversible blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacle
- Two-stage hydraulic pump
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

120 Ton

DO 120/200-24M

DUAL OPERATOR
5 STATIONS

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	120 ton (108 mt) 1-1/2" in 1" (38 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	12" (305 mm)
Flat Bar Shear (sabre blade-std.)	24" Length (610 mm) 1" x 12" (25 x 305 mm) 3/4" x 20" (19 x 508 mm) 1/2" x 24" (12 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	75 ton (55 mt)
Brake 24"	55 ton (40 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5-3/4" x 1/2" (76 x 146 x 12 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm) 3" x 3" x 1/2" (76 x 76 x 12 mm)
Notching in Leg of Channel	6" to 10" (152 mm to 254 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	39 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	15 spm (3/4" stroke) [Punch Station]
Hydraulics	3,500/3,500 psi (241/241 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-83" (211 cm) W-38-1/2" (98 cm) H-76-1/2" (194.5 cm)
Shipping Weight (may vary)	6,204 lbs. (2,814 kg)

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 120 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die holder complete with 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Two electric remote foot pedals
- Two adjustable electric stroke controls with scale
- Tandem hydraulic pump
- Two valves
- Angle shear
- Rectangle notcher with table, scale and guides
- Flat bar shear with sabre blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

SCOTCHMAN 3 YR. WARRANTY

MADE IN USA

▷ Additional tooling options see pages 21-24

135 Ton

IRONWORKERS

DUAL OPERATOR
5 STATIONS

DO 135/220-24M

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	135 ton (122 mt) 1-11/16" in 1" (42 mm in 25 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	12" (305 mm)
Flat Bar Shear (sabre blade-std.)	24" Length (610 mm) 1" x 12" (25 x 305 mm) 3/4" x 20" (19 x 508 mm) 1/2" x 24" (12 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	90 ton (81.6 mt)
Brake 24"	70 ton (63.5 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5-3/4" x 1/2" (76 x 146 x 12 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm) 3" x 3" x 1/2" (76 x 76 x 12 mm)
Notching in Leg of Channel	6" to 10" (152 mm to 254 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	39 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	15 spm (3/4" stroke) [Punch Station]
Hydraulics	3,500/3,500 psi (241/241 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-83" (211 cm) W-38-1/2" (98 cm) H-76-1/2" (194.5 cm)
Shipping Weight (may vary)	6,204 lbs. (2,814 kg)

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 135 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die Holder complete with a 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Two electric remote foot pedals
- Two adjustable electric stroke controls with scale
- Tandem hydraulic pump
- Two valves
- Angle shear
- Rectangle notcher with table, scale and guides
- Flat bar shear with sabre blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

150 Ton

DO 150/240-24M

DUAL OPERATOR
5 STATIONS

Capacities and Specifications Rated On: A36 Mild Steel / 65,000 PSI Tensile	
Punching Capacity	150 ton (136 mt) 1-7/8" in 1" (47 mm in 25 mm) 2-1/2" in 3/4" (64 mm in 19 mm)
Special Tooling	4" (102 mm) Max. Dia.
Throat Depth	12" (305 mm)
Flat Bar Shear (sabre blade-std.)	24" Length (610 mm) 1" x 14" (25 x 356 mm) 3/4" x 24" (19 x 610 mm)
Angle Shear 90°	6" x 6" x 1/2" (152 x 152 x 12 mm)
Angle Shear 45° **w/Tool** **w/Bar Shear**	 3" x 3" x 3/8" (76 x 76 x 10 mm) 4" x 4" x 1/2" (102 x 102 x 12 mm)
Brake 12"	90 ton (81.6 mt)
Brake 24"	70 ton (63.5 mt)
Open End Brake	Max. 1/4" x 5" (6 x 127 mm) [Flat or Angle Iron]
Pipe Notcher Schedule 40	3/4", 1", 1-1/4", 1-1/2", 2"
Rectangle Notcher	3" x 5-3/4" x 1/2" (76 x 146 x 12 mm)
90° V-Notcher	6" x 6" x 5/16" (152 x 152 x 8 mm) 3" x 3" x 1/2" (76 x 76 x 12 mm)
Notching in Leg of Channel	6" to 10" (152 mm to 254 mm)
Channel Shear	2" to 6" adj. (51 mm to 152 mm adj.)
Unistrut Shear	Samples Required
Rod Shear Round (max.)	9 Cavity, 1/4" to 1-1/4" (6 mm to 32 mm)
Rod Shear Square (max.)	1 Cavity, 1/4" to 1" (6 mm to 25 mm)
Square Tube Shear	1/2" to 2" (12 mm to 51 mm) 12 gauge (0.105" / 2.7 mm)
Picket Tool	1/2", 3/4" & 1" (12 mm, 19 mm, 25 mm) 16 gauge (0.06" / 1.5 mm)
Weld Coupon Bender (max.)	2" wide x 3/8" (51 mm x 10 mm)
Offset Die Holder	Max. 40 ton (36 mt)
Strokes per minute in light material	44 spm (1/4" stroke) [Punch Station]
Strokes per minute in heavy material	17 spm (3/4" stroke) [Punch Station]
Hydraulics	3,500/3,500 psi (241/241 bar)
Motor Options (must specify)	10 hp 3 ph (7.46 kW) 208/230/460, 380/575v 10 hp 1 ph (7.46 kW) 220v
Dimensions	L-83" (211 cm) W-38-1/2" (98 cm) H-77-1/4" (196.5 cm)
Shipping Weight (may vary)	6,404 lbs. (2,905 kg)

STANDARD FEATURES

- Dual operator allows for two operators to work at the same time at full capacity
- 150 ton punch station
- Keyed punch ram for safety
- Punch gauging table with fence and scale
- Die Holder complete with a 2" die insert
- Punch nut with wrench & stripper
- Adjustable swing-away stripper
- One round punch & die: max. diameter 1-1/4"
- Jog control
- Two electric remote foot pedals
- Two adjustable electric stroke controls with scale
- Tandem hydraulic pump
- Two valves
- Angle shear
- Rectangle notcher with table, scale and guides
- Flat bar shear with sabre blade
- Shear table with miter fence
- 24" Tool table work area
- Slug receptacles
- Electrical box supplied with emergency palm button and lock-out tag-out accommodations
- Complies with ANSI B 11.5 safety standards
- Forklift accommodations
- Three-year warranty on parts
- Made in USA

▷ Additional tooling options see pages 21-24

Ironworker *Optional Tooling*

		PF 45	50514-EC	5014-ET	6509	DO70	DO85	FI85	9012	DO95	12012	DO120	DO135	DO150
A	6" Brake	◉	◉	◉										
B	8" Brake	◉	◉	◉										
C	12" Brake	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
D	24" Brake				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
E	Open End Brake	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
F	Pipe Notcher	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
G	Rectangle Notcher	◉			◉				◉		◉			
H	90° V-Notcher	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
I	Square Tube Shear	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
J	Rod Shear	◉	◉	◉	◉	◉			◉	◉	◉	◉	◉	◉
K	Unistrut Shear	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
L	Weld Coupon Bender	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
M	Picket Tool	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
N	Channel Shear				◉	◉		◉	◉	◉	◉	◉	◉	◉
O	Channel Shear Blades						◉							
P	6"x 6" Die Holder				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
Q	Offset Die Holder				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
R	Urethane Stripper				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
S	Hydraulic Hold Down				◉			◉	◉		◉	◉	◉	◉
T	4" Angle Iron Miter Guide		◉	◉										
U	6" Angle Iron Miter Guide				◉	◉			◉	◉	◉	◉	◉	◉
V	Optional Punch for Notcher End						◉							
W	Open End Brake for Notcher End						◉							
X	30" Material Stop	◉												
Y	48" Back Gauge		◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
Z	Brake Table w/ scale & squaring arm 12"	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
Z	Brake Table w/ scale & squaring arm 24"				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
Z	Brake Length Gauge w/ scale 8"	◉	◉	◉										
Z	Brake Length Gauge w/ scale 12"	◉	◉	◉	◉	◉			◉	◉	◉	◉	◉	◉
Z	Brake Length Gauge w/ scale 24"				◉	◉			◉	◉	◉	◉	◉	◉
AA	Shear Table w/ Miter Fence		◉	◉										
BB	Punch Gauging Table w/ Fence & Scale		◉	◉										
CC	Unequal Leg Blades for Angle Shear				◉	◉			◉	◉	◉	◉	◉	◉
DD	Multi-Loc Punch Gauging Extension: 36" & 85"				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
EE	Punch Table Extension				◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
FF	Tool table extension with punch & die drawer		◉	◉	◉	◉			◉	◉	◉	◉	◉	◉
GG	Laser Light (Shear)		◉	◉	◉	◉		◉	◉	◉	◉	◉	◉	◉
HH	LED Lights	◉ (P)	◉ (P, S, N)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)	◉ (P&S)
II	LG Measuring Device		◉	◉	◉	◉			◉	◉	◉	◉	◉	◉
JJ	24" x 5' Conveyor w/ angle iron support		◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉	◉
	Jog Control (Not Pictured)		◉	◉	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*	*Std.*

◉ Punch ◉ Punch & Shear ◉ Punch, Shear & Notch

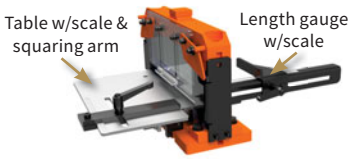
Ironworker *Optional Tooling*

6" Brake (A)

8" Brake (B)

12" Brake (C)

24" Brake (D)



Brake Options (Z)
(sold separately)

Open End Brake (E)

Pipe Notcher (F)

Rectangle Notcher (G)

90° V-Notcher (H)

Square Tube Shear (I)

Rod Shear (J)

Unistrut Shear (K)

Weld Coupon Bender (L)

Picket Tool (M)

Channel Shear (N)

Channel Shear Blades (O)
(DO85 only)

6" x 6" Die Holder (P)

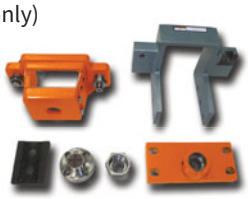
Offset Die Holder (Q)

Urethane Stripper (R)

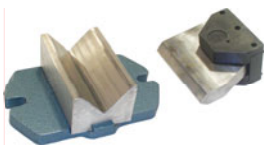
Hydraulic Hold Down (S)

4" Angle Iron Miter Guide (T)

6" Angle Iron Miter Guide (U)



Optional Punch for Notcher End (V)
(DO85 only)



Open End Brake for Notcher End (W)
(DO85 only)

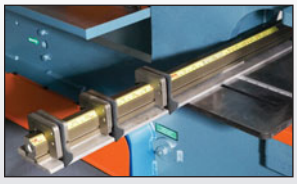
30" Material Stop (X)

48" Back Gauge (Y)

Shear Table w/ Miter Fence (AA)

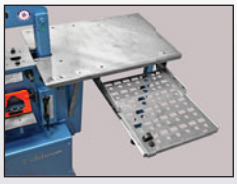
Punch Gauging Table w/ Fence & Scale (BB)

Unequal Leg Blades
for Angle Shear **(CC)**
66°, 70°, 74°, or 80°

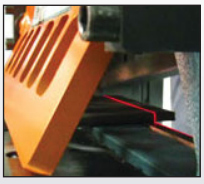


Multi-Loc Punch Gauging Extension: 36" & 85" (DD)

Punch Table Extension (EE)



Tool table extension with punch & die drawer (FF)



Laser Light (GG)

LED Lights (HH)

LG Measuring Device (II)
(add'l. tool info see page 44)

24" x 5' conveyor with angle iron support (JJ)
← (attached to DO 70)
(attached to 5014-ET) →

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IRONWORKERS

CUSTOMIZED TOOLING FOR A CUSTOM SOLUTION.

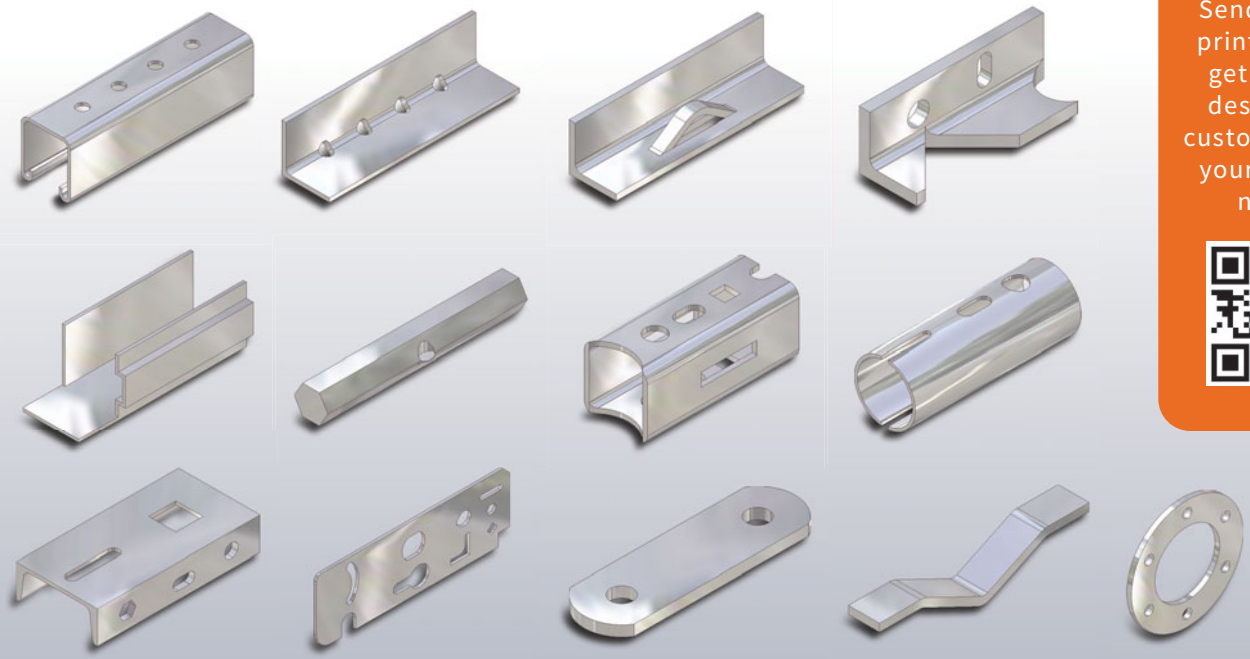
SOMETIMES, A UNIQUE APPLICATION REQUIRES A CUSTOM-BUILT SOLUTION.

If you need something beyond the standard tooling we offer, our team of engineers is equipped to design and build a tailored solution built to your specifications.

From our plant in Philip, South Dakota, each step of this process from design and development to completion is done in-house.

We thoroughly test each tool to verify performance and ensure value for your investment. With quality manufactured into every tool, we assure that our tools will stand up to the tough demands of your applications.

Examples of Special Applications We've Built Tooling For



Send us your prints & we'll get to work designing a custom tool for your specific needs.

In-Stock Punches & Dies

#20 & #40 Rounds	
1/8	11/16
5/32	23/32
3/16	3/4
13/64	25/32
7/32	13/16
1/4	27/32
17/64	7/8
9/32	29/32
5/16	15/16
11/32	31/32
3/8	1
13/32	1-1/32
7/16	1-1/16
15/32	1-3/32
1/2	1-1/8
17/32	1-5/32
9/16	1-3/16
19/32	1-7/32
5/8	1-1/4
21/32	

Round Metric	
5 mm	19 mm
6 mm	20 mm
7 mm	21 mm
8 mm	22 mm
9 mm	23 mm
10 mm	24 mm
11 mm	25 mm
12 mm	26 mm
13 mm	27 mm
14 mm	28 mm
15 mm	29 mm
16 mm	30 mm
17 mm	31 mm
18 mm	32 mm

#49 Round Punches	
1-5/8	1-7/8
1-11/16	1-15/16
1-3/4	2
1-13/16	

Round Offset Dies
9/32
5/16
11/32
3/8
13/32
7/16
15/32
1/2
17/32
9/16
19/32

#45 Round Punches
1-9/32
1-5/16
1-11/32
1-3/8
1-13/32
1-7/16
1-15/32
1-1/2
1-17/32
1-9/16

Split Ring Round
1-5/8
1-3/4
2
2-1/4
2-1/2
2-3/4
3

Ovals	
1/4 x 1/2	3/4 x 1
9/32 x 1/2	25/32 x 1
1/4 x 3/4	13/16 x 1
9/32 x 3/4	7/8 x 1
5/16 x 3/4	15/16 x 1
11/32 x 3/4	1/4 x 1-1/4
3/8 x 3/4	9/32 x 1-1/4
13/32 x 3/4	5/16 x 1-1/4
7/16 x 3/4	11/32 x 1-1/4
15/32 x 3/4	3/8 x 1-1/4
1/2 x 3/4	13/32 x 1-1/4
17/32 x 3/4	7/16 x 1-1/4
9/16 x 3/4	15/32 x 1-1/4
19/32 x 3/4	1/2 x 1-1/4
5/8 x 3/4	17/32 x 1-1/4
1/4 x 1	9/16 x 1-1/4
9/32 x 1	19/32 x 1-1/4
5/16 x 1	5/8 x 1-1/4
11/32 x 1	21/32 x 1-1/4
3/8 x 1	11/16 x 1-1/4
13/32 x 1	23/32 x 1-1/4
7/16 x 1	3/4 x 1-1/4
15/32 x 1	25/32 x 1-1/4
1/2 x 1	13/16 x 1-1/4
17/32 x 1	7/8 x 1-1/4
9/16 x 1	15/16 x 1-1/4
19/32 x 1	7/16 x 1-1/2
5/8 x 1	9/16 x 1-1/2
21/32 x 1	11/16 x 1-1/2
11/16 x 1	13/16 x 1-1/2
23/32 x 1	15/16 x 1-1/2

Squares
1/4
9/32
5/16
11/32
3/8
13/32
7/16
15/32
1/2
17/32
9/16
19/32
5/8
21/32
11/16
23/32
3/4
25/32
13/16
27/32
7/8
29/32
15/16
31/32
1
1-1/32

Hexagon
7/16
1/2
11/16
3/4

Corner Turning
1/2
3/4

Trimming & Cut Off
3/4
1

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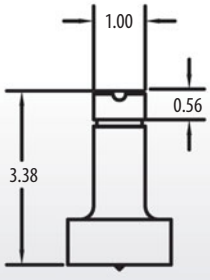
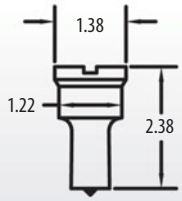
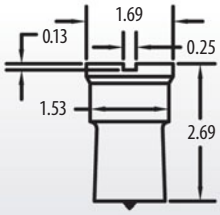


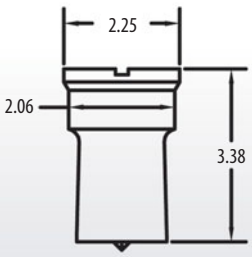
#20 Punch
1/8" Thru 1-1/4"
5 mm Thru 32 mm



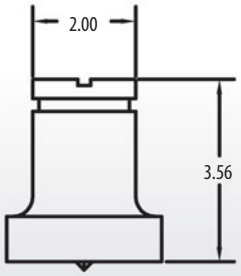
#40 Punch
1/8" Thru 1-1/4"
5 mm Thru 32 mm



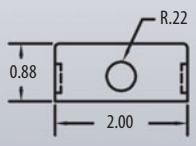
#45 Punch
1-9/32" Thru 1-9/16"



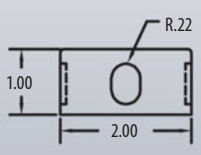
#49 Punch
12012, D0120, DO135, DO150 Machine Only
1-5/8" Thru 2"



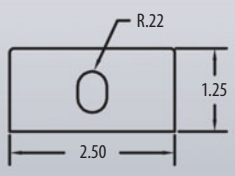
Split Ring Punch
1-5/8" Thru 3"



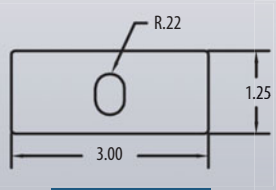
#20 Die



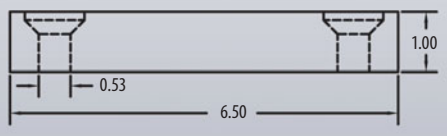
#82 Die



#86 Die



3" Die



6 x 6 Die