IMB (**Mechanical Industries Busseto**) was born in 1976 from the idea of Alberto Mora who designed new equipment for panel builders and electrical installers. Starting from a garage in Busseto, in the province of Parma, the company grew nationally and internationally developing cutting-edge solutions for processing electrical cabinets and copper bars. Today Alberto's sons carry on the father's legacy and ensure the continuity of IMB production.

For more than 4 decades, the company has invested in **quality**, **customization** and **innovation**.

Focusing on its workforce, IMB has been able to develop internally most parts of the production. This choice makes the production reliable and guarantees the highest standards of **quality and durability** of the product. The quality system is certified according to **ISO 9001: 2015** standards.

The winning aspect of the company's strategy is the customization. IMB's customers can rely on tailored solutions for every need. In addition to the standard offer, IMB remains unique for its collaboration with customers to create **special equipments** that allow them to achieve their goals.

IMB's commitment for the future is to create social and environmental benefits while ensuring continuous **innovation** and full customer satisfaction.

Choosing IMB today is the best decision for constant results over time.

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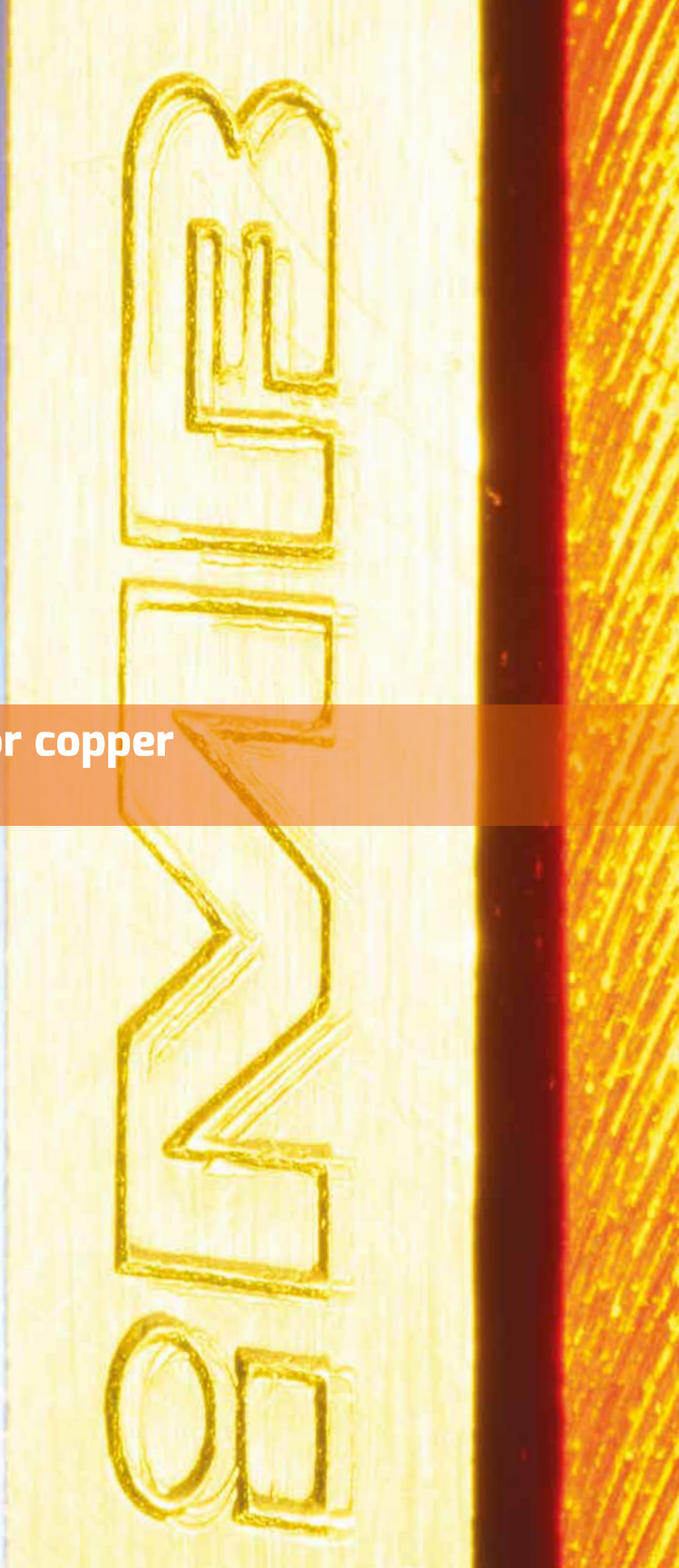
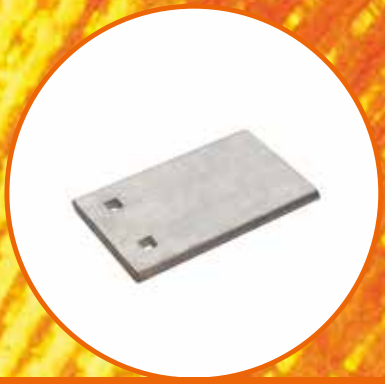
INDEX

Tris work unit for copper and metal bars



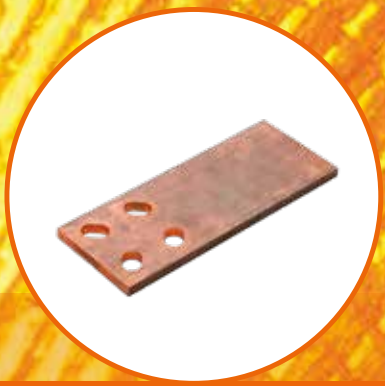
TECHNICAL APPLICATION



SQUARE HOLES ON ALUMINIUM

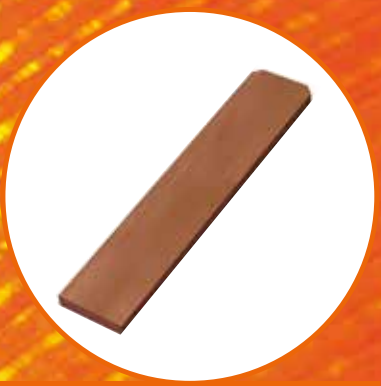
EXAMPLE OF BARS
BENDED WITH FLAT BAR BENDER

EXAMPLE OF MULTIPLE HOLES



EXAMPLE OF OVAL OBLIQUE
PUNCHING

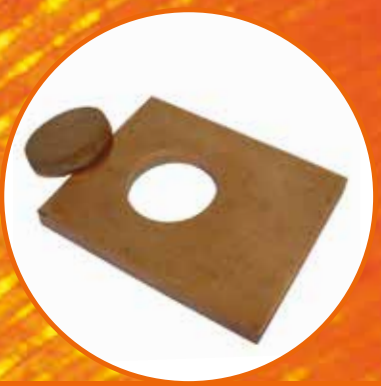
BENDING REALIZED WITH UNIT
ART.9046 ON BAR 200X20



BAR WITH BEVELLED EDGE

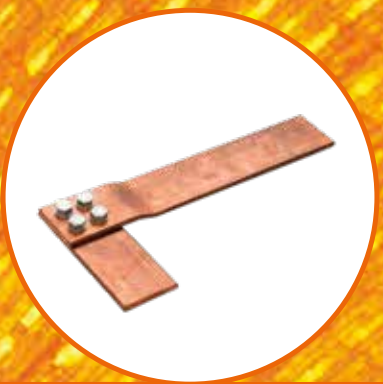
EXAMPLE OF MULTIPLE BENDING

HALF-OVAL HOLE FOR DIRECT
INSERTION OF THE BAR



HOLE Ø 58 REALIZED
WITH A SPECIAL TOOL

EXAMPLE OF BENDING
AND PUNCHING



BAR COUPLING

SPECIAL PUNCHING ON IRON

9042
Tris Work Unit

PATENTED

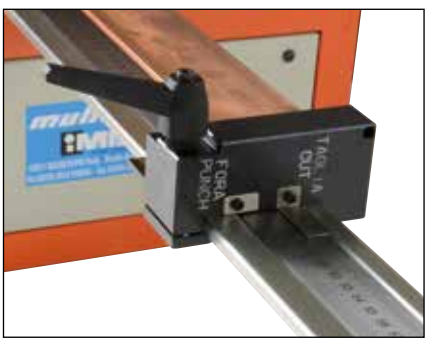
Suitable for small and large quantities.
Functional and time-saving, it makes the job easier

9042 TRIS WORK UNIT can be used with all MULTIFOR pumps and control units. It is extremely versatile for its different operations. Our tris unit is made up of :

- **a practical tool change-over system**.
- **a hinged tool frame fully opening**, which allows simple introduction and removal of bars.
- **a millimetric adjustment on the piston**, which regulates the stroke of the tools.
- a **protractor** for reading the bending angle of the bar (on request).

Once set up, this accessory can repeat the work cycle without checking every time lenghts and angles.
These characteristics are patented.
In order to achieve the maximum working precision, as well as to save time, the tooling is mounted on a workbench, which has been **designed specially** to be rational and practical in operation. It has all the necessary adjustments and references in order to position quickly the work pieces, avoiding measurements and engravings.

Technical Characteristics	
Power	200 kN
Max. Working pressure	700 Bars
Stroke	50 mm
Adjustable stroke	40 mm
Amount oil required for full stroke	0,180 lt.
Lenght	850 mm
Width	600 mm
Height	500 mm
Weight	90 Kg
Supplied with 1 meter ruler and protection carter.	



Adjustment distance for punching and cutting.

Positioning mechanical end-stroke

Drawer to collect metal swarf

Punching, bending, cutting copper bars, metal profiles and din-rails. All these operations with only one Tris work unit.

Punching

Copper bars, aluminium and steel bars, etc.
with max. thickness 12 mm - Round holes from Ø 5 to Ø 25 mm - Oval holes from 7X13 mm to 18x25 mm

Fot higher thickness than 12 mm, please contact our Technical Department.
It is possible to achieve equidistant punching on bars of maximum width 120 mm.
Using special punches, which have the automatic extraction from the bar, one obtains holes.

IN 4 SECONDS*

Bending

Copper bars, aluminium and steel bars etc.
with thickness from 3 mm to 12 mm and maximum width 120 mm.
On request, tools for 160 mm bars

IN 5 SECONDS*

Cutting

Copper bars, aluminium and steel bars, etc.
with thickness from 5 mm to 12 mm and max. width 120 mm.

For higher width than 120 mm and with thicker material than 12 mm , please contact our Technical Department.

IN 3 SECONDS*

TOOLS AND ACCESSORIES PAG. 12÷15

POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

*** Times are approximately, for unit already tooled and connected to the electric control unit.**

OUR TECHNICAL DEPARTMENT IS AT YOUR SERVICE FOR SPECIAL APPLICATIONS.

9042/AL
Swivel Tris work unit

PATENTED

For bars processing in cramped spaces (e.g. cabins).
9042/AL is used with all MULTIFOR pumps and control units.
It has the same characteristics of the TRIS 9042, but in horizontal position it can swivel on a vertical pin. By doing so, the bar remains stationary on its support surface, taking up less space in the working area.

Technical Characteristics	
Power	200 kN
Max. Working pressure	700 Bar
Stroke	50 mm
Adjustable stroke	40 mm
Amount of oil required for full stroke	0,180 lt.
Lenght	850 mm
Width	600 mm
Height	500 mm
Weight	90 Kg
Supplied with 1-meter ruler and protection carter.	

TOOLS AND ACCESSORIES PAG. 12÷15
POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9045
Horizontal Tris work unit

It has the same characteristics of the Unit 9042 and 9042/AL with horizontally fixed position. Small dimensions, it is lighter and economic. It uses standard tools. It is supplied with 1-meter ruler.
Not recommended for punching operations

Technical Characteristics	
Lenght	700 mm
Width	600 mm
Height	500 mm
Weight	77 Kg

TOOLS AND ACCESSORIES PAG. 12÷15
POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9045V
Vertical Tris Work Unit

It has the same characteristics of the Unit 9042.
Its cylinder is vertically fixed.
USED ONLY FOR CUTTING AND PUNCHING OPERATIONS.
It uses the same tools of the TRIS 9042.
Small dimensions and weight.
It is supplied with 1-meter ruler

Technical Characteristics	
Lenght	530 mm
Width complete with 1-meter ruler	1.310 mm
Height	720 mm
Weight	67 Kg

TOOLS AND ACCESSORIES PAG. 12÷15
POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9046
Tris Work unit 30 Ton

It is larger and more powerful than unit 9042.
The unit 9046 is recommended for processing large size bars, larger than the standard ones.
This unit has a 30 tons cylinder that allows to work bars until 200x20 mm.

It is also possible to make special tools for punching four holes in one operation.
It is supplied with 1 meter ruler, protection carter and adapters for the use of 9042 standard tools.
On request we can realize special punches for specific workings.

Technical Characteristics	
Power	300 kN
Max. Working pressure	700 bar
Stroke	65 mm
Adjustable stroke	50 mm
Amount of oil required for full stroke	0,300 lt
It punches bars up to 15 mm thickness	
It cuts bars up to 160 x 15 mm	
It bends bars up to 200x20 mm	
Lenght	1200 mm
Width	700 mm
Height	520 mm
Weight	192 Kg

TOOLS AND ACCESSORIES PAG. 12÷15
POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9044
Tris work unit

Coupled Tris cylinders

For specific works or a big production, we have made a special unit which uses two cylinders to avoid unnecessary changes of tools, allowing the realisation of punching and bending with a considerable reduction in time and labour costs. The cylinders have the same chatacteristics of the Tris Unit 9042.

Technical Characteristics	
Lenght	940 mm
Width	600 mm
Height	720 mm
Weight	122 Kg
It is supplied with 1 meter ruler and protection carter.	

TOOLS AND ACCESSORIES PAG. 12÷15

POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9043
Tris work unit

For occasional and on field workings. For bending, cutting and punching.

We have created it expressly for small quantities.
It differs from our Tris Units with bench for its simplicity and lightness as it has no specific accessories, making it simple and light.
Its structure is fixed and it is used in vertical position.
We recommend to fix it on a bench or on a working table, in order to have stability.
The cylinder has an adjustable run.
Bar benders are simplified with only one male punch supplied with n. 2 female dies of different dimensions for various thicknesses. (Max 10 mm) and different bending radius.
It is supplied complete with bending tools.
Tools for cutting and punching are the same of our standard tris unit 9042.
It can be used with all our power units present in our Catalogue.
Supplied with 1-meter ruler.
It has to be connected to our power units present in our catalogue.

Technical Characteristics	
General characteristics	as Tris Unit 9042
Power	200 kN
Max. Working pressure	700 bar
Width	130 mm
Lenght	230 mm
Height	610 mm
Weight	34 Kg

TOOLS AND ACCESSORIES PAG. 12÷15

POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9023
Punching cylinder

For flat and angular bars

It can be used with all MULTIFOR pumps and control units.
It is particularly practical and handy.
It allows the punching of flat and angular bars in difficult positions and on pylons.
It is used expecially for connections in transformer cabinets and for electrical switchboards.
This tool is very reliable like all our MULTIFOR equipments.

On request, we can realize special sizes.

For a correct use of the punches, the operator should not punch bars

thicker than the diameter of the same punch.

On request, it can be supplied with 90° connector.

Technical Characteristics	
Power	120 kN
Max. Working pressure	700 bar
Stroke	14 mm
Internal depth	30 mm
External depth	20 mm
Copper bar thickness	10 mm max
Thickness of other materials: according to the resistance and hole Ø	
Lenght	270 mm
Width	135 mm
Weight	5,7 Kg

It is supplied with metal case and n. 6 pairs of punches (odd sizes or even sizes).

Kit punching cylinder 9023D	
Odd size code	**Ø Punch mm.**
9511	7
9513	9
9515	11
9517	13
9519	15
9521	17

Kit punching cylinder 9023P	
Even size code	**Ø Punch mm.**
9512	8
9514	10
9516	12
9518	14
9520	16
9522	18

9047 Portable bar bender

Bar bender built for bending copper bars in workshops or in site.
Thanks to its structure and to its integrated protractor, it works on small and large quantities of bars until 100 mm width.
This tool is equipped with 2 female bending tools of different dimension for several thickness and bending radius.
It can operate with all our power units included in our catalogue.

Technical Characteristics	
Power	50 kN
Dimensions	78x150x190h mm
Weight	18 Kg
Stroke	50 mm
Adjustable stroke	30 mm
Material bending	copper 100x8/60x10 mm max.
Equipped with n. 2 bending tools and protractor.	

Mechanical end-stroke - maximum accuracy

Integrated protractor indicator

Punches for Tris unit

Round punches

They are composed by a male punch and a female die with stamped diameter to avoid mistakes during the assembly.
Punch extraction is automatic by means of special springs.
It is possible to request the female die, the male punch separately as spares and the inner part of the male punch

It is recommended to always regulate the stroke of the cylinder stem, in order to avoid excessive pressure.

N.B. For a correct use of round and oval punches, please do not use superior thickness to the diameter of the same punch.

Available punches for 15 mm thickness for 9046 Tris Unit.

SPECIAL SIZES ON REQUEST.

Round punches

Code	Ø mm	Male spare	Female spare	Inner spare
9100	5	9100M	9100F	9122/5
9101	6	9101M	9101F	9122/6
9102	7	9102M	9102F	9122/7
9103	8	9103M	9103F	9122/8
9104	9	9104M	9104F	9122/9
9105	10	9105M	9105F	9122/10
9106	11	9106M	9106F	9106S
9107	12	9107M	9107F	9107S
9108	13	9108M	9108F	9108S
9109	14	9109M	9109F	9109S
9110	15	9110M	9110F	9110S
9111	16	9111M	9111F	9111S
9112	17	9112M	9112F	9112S
9113	18	9113M	9113F	9113S
9114	19	9114M	9114F	9114S
9115	20	9115M	9115F	9115S
9116	21	9116M	9116F	9116S
9117	22	9117M	9117F	9117S
9118	23	9118M	9118F	9118S
9119	24	9119M	9119F	9119S
9120	25	9120M	9120F	9120S

Oval punches

These punches have the same characteristics as the round punches and in addition they are fitted with a positioning guide to avoid assembly errors.

It is recommended to always suggested to regulate the stroke of the cylinder stem, in order to avoid excessive pressure.

N.B. For a correct use of round and oval punches, please do not use superior thickness to the diameter of the same punch.

Available punches for 15 mm thickness for 9046 Tris Unit.

SPECIAL SIZES ON REQUEST.

Oval punches

Code	Ø mm	Male spare	Female spare	Inner spare
9130	7x13	9130M	9130F	9130S
9131	8x14	9131M	9131F	9131S
9132	9x15	9132M	9132F	9132S
9134	10x16	9134M	9134F	9134S
9136	11x17	9136M	9136F	9136S
9138	12x18	9138M	9138F	9138S
9140	13x19	9140M	9140F	9140S
9142	14x20	9142M	9142F	9142S
9144	15x21	9144M	9144F	9144S
9146	16x22	9146M	9146F	9146S
9148	17x24	9148M	9148F	9148S
9149	18x25	9149M	9149F	9149S

Special punches

Tool for multiple punching in only one operation

Bar cutter

It is a tool for our Tris units, made from special steel composed by a sharpened male and a female die. You can cut bars with maximum thickness 12 mm and maximum width 120 mm, or, on demand, bars with thinner thickness and of greater width (max 125 mm).
Bar cutting takes place by removing one section of material equal to the width of the cutting point (10 mm).

Bar cutter	
Code	**Description**
9155	Bar cutter 120x12
9155/30 Ton	Bar cutter 160x15 for 9046

Tool for radial bars with support guides for different bars.

Tool for the cutting of flexible bus bars 9158

It can be used on all our Tris Units. It cuts flexible bus bars max. 100x10 mm. Easy to assemble , as all our standard tools.

Din Rail Cutter 9055 for Tris unit

It has the same characteristics of the standard Din Rail Cutting Machine Model 9050.
The installation of this tool on the Tris Units is simple

SPECIAL TOOLS ON DEMAND

Standard bar benders

Bar bender

We have standard bar bender for different thickness and width. For bar bender selection, please consult the table enclosed.
We realize bar bender on demand.

Bar bender	
Code	**Description**
9150	V bar bender for thickness from 4 to 6 mm
9151	V bar bender for thickness from 5 to 8 mm
9152	V bar bender for thickness from 6 to 12 mm
9153	Special flat bar bender for bars from 20-40, thickness 5÷10 mm Internal radius 30 mm
9150/160	V bar bender for thickness from 4 to 6 mm for bars with width 160 mm
9151/160	V bar bender for thickness from5 to 8 mm for bars with width 160 mm
9152/160	V bar bender for thickness from 6 to 12 mm for bars with width 160 mm.
9154/30 Ton	Bar bender for bars 160x15 mm for Tris 9046
9154/200x20	Bar bender for bars 200x20 mm for Tris 9046

9150

9151

9152

9153
Flat bar bender

Special bar benders

9154/01

It is recommended for brackets, clamps and small bars of different material.
Max. Thickness 5 mm.
Higher thickness on demand.

9154/02

It is recommended for aluminium and lined bars

Special bar benders on demand

Accessories for Tris units

Mechanical protractor 9160

It is a very practical accessory to put on the tris cylinder for measuring bar bending angles up to 90°. It is made of steel with direct reading and eccentric corrector for resetting the rod according to the thickness and elasticity of the material to bend.

9160/30 Ton for 9046 Unit

Electrical protractor 9161

Similar to the mechanical one, the electrical protractor is equipped with a micro switch and a device to automatically stop the electric control unit.

N.B. It can be used only with electric control units 9008-9009-9010.

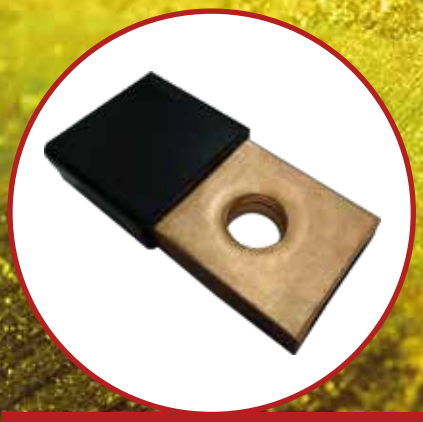
9161/30 Ton for 9046 Unit

Positioning valve 9162

The positioning valve is supplied with male and female rapid connectors for a rapid assembly. This two-way valve can be fitted to the Tris cylinder when you use electric control units as it permits small movements of the tools and therefore an easy positioning of the bars.

Units for flexible copper bars

TECHNICAL APPLICATION



EXAMPLE OF PUNCHING

EXAMPLE OF OVAL PUNCHING

BAR CUTS WITH ART. 9039
OR ART. 9158

SAMPLE OF BARS CUT

9020

Punching cylinder

For flexible copper bars and generic bars.

PATENTED

This punching cylinder can be used with pumps and all MULTIFOR control units.
It is designed exclusively for punching packs of flexible copper bars. Its particular technical characteristics allow to punch easily this kind of bars. This tool is made up of two cylinders, one blocks the bar and the other makes the hole. This particularity ensures a rapid and precise punching, without burrs and deformation of the bar. This cylinder is mounted on a support which allows the punching in square and without traces. Brackets and millimetric positioning rulers allow punching in series avoiding mistakes.

Special punch sizes on request.

The 9020 is supplied with no. 2 lock nuts, one for punches up to 9 mm dia. max and one for punches from dia.10 mm to dia. 13 mm max.

References with millimetric ruler for the right bar positioning.

Special lock nut blankholder for a punching without burrs and marks

Technical Characteristics	
Power	120 kN
Max. Working pressure	700 bar
Max. Stroke	15 mm
Internal depth	29 mm
External depth	17 mm
Max.copper bar thickness	10 mm
Thickness of the other materials to define according with the resistance and hole Ø	
Lenght	390 mm
Width	300 mm
Height	160 mm
Weight	16,7 Kg

Kit punching cylinder for packs bars 9020 D	
Odd size set code	**Ø Punch mm.**
9531	9
9533	11
9535	13

Kit punching cylinder for packs bars 9020 P	
Even size set code	**Ø Punch mm.**
9541	8
9543	10
9545	12

POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

9039
Cylinder for cutting flexible bus bars

Complete and autonomous equipment.
It is equipped with ruler and adjustments for the bars measurement.

Bar dimensions:
Thickness from 2 to 10 mm
Width from 15 to 100 mm

This cylinder can work with all IMB power units.

Technical Characteristics	
Power	120 kN
Lenght	220 mm
Width	80 mm
Height	345 mm
Weight	20 Kg about


SLIDER FOR THE CENTERING OF BARS

POWER UNITS - PUMPS AND ELECTRIC UNITS PAG. 80÷87

Tools for flexible bus bars

Round punch with step

This solution for round holes has 3 standard measures : 9 - 11 - 13 mm with a special shape, which reduces the distance between the hole and the protective covering.
It also cuts down the specific pression on the bar to reach at the end a better result, both aesthetic and functional.

Can be used with all our Tris units

Technical Characteristics

Code punch	Ø mm	Range Center distance hole-protection	Range Edge hole-protection	Male spare	Female spare
9104 FLEX	**9**	18	13,5	9104M FLEX	9104F FLEX
9106 FLEX	**11**	18	12,5	9106M FLEX	9106F FLEX
9108 FLEX	**13**	18	11,5	9108M FLEX	9108F FLEX

Oval punches with step

This solution for oval holes has 3 standard measures: 9x15 - 11x17 - 13x18 mm with a special shape, which reduces the distance between the hole and the protective sheath.
It also cuts down the specific pression on the bar to reach at the end a better result, both aesthetic and functional.

Can be used with all our Tris units

Technical Characteristics

Code punch	Ø mm	Range Center distance hole-protection	Range Edge hole-protection	Male spare	Female spare
9132 FLEX	**9 x 15**	18	13,5 - 10,5	9132M FLEX	9132F FLEX
9136 FLEX	**11 x 17**	18	12,5 - 9,5	9136M FLEX	9136F FLEX
9140 FLEX	**13 x 18**	18	11,5 - 9	9140M FLEX	9140F FLEX

FOR DIFFERENT INTERAXIS, PLEASE CONTACT IMB TECHNICAL DEPARTMENT

9158
Tool for the cutting of flexible bus bars

Practical and accurate tool to cut flexible bars.
It is easy to assemble it on all our Tris Units.
Dimensions of the bars to cut:
Thickness from 2 to 10 mm
Width from 15 to 100 mm

It can cut bars with or without protection sheath.

Can be used with all our Tris units

Technical Characteristics	
Lenght	180 mm
Width	80 mm
Height	105 mm
Weight	8 Kg c.a.

Flex dies to combine with standard males

It is possible to realize with these dies, round and oval holes on flexible bus bars.
They are practical as they work combined with standard males.
This operation allows to reduce the time for changing the punch and tooling costs.
These Flex dies ensure a punching without burrs on flexible bus bars until 10 x 1 mm.

These dies have not the step and they can reach max. 27 mm with round dies and 32 mm with oval ones.

N.B. Don't use them for punching flat bars.

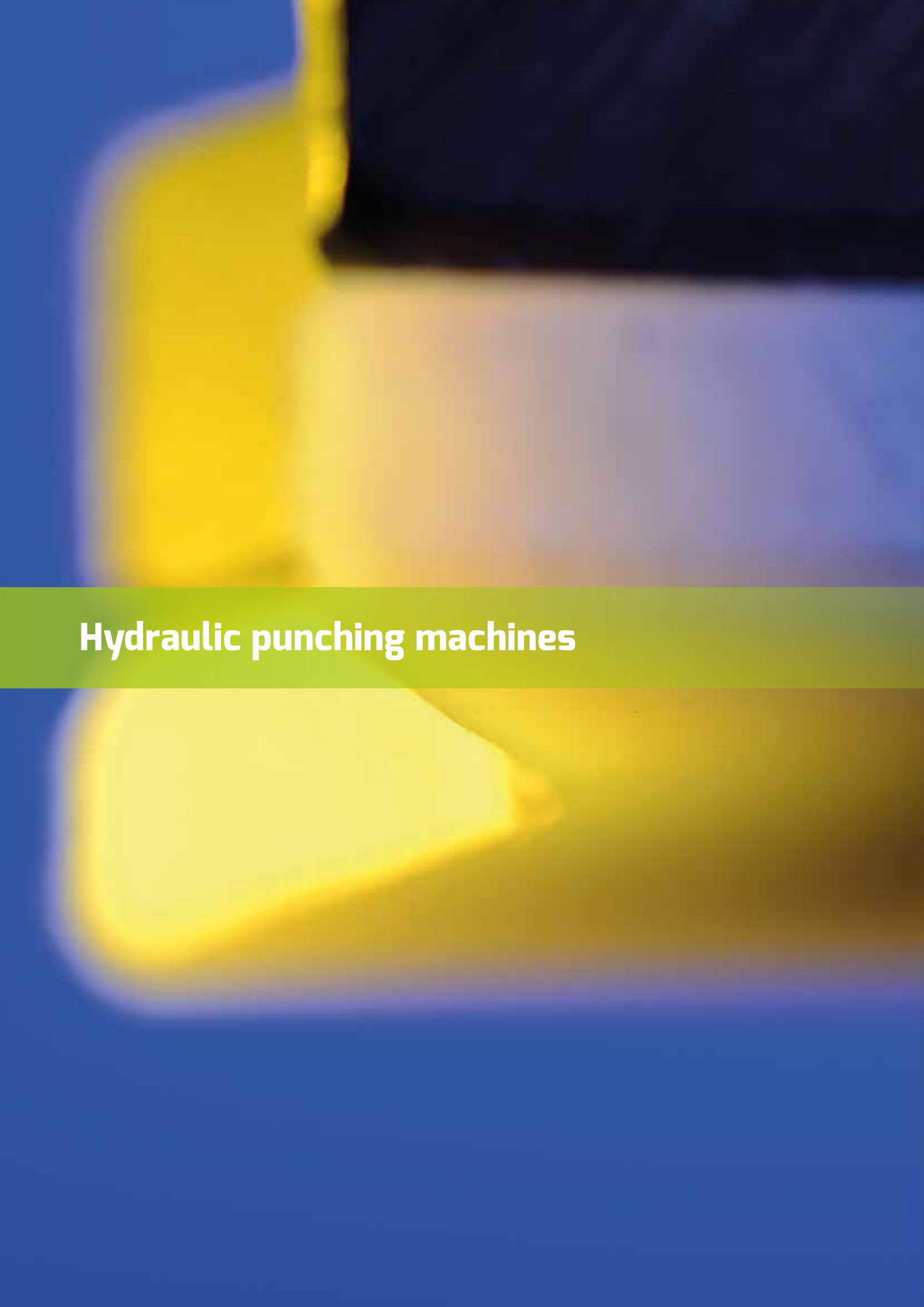
Can be used with all our Tris units.

Round FLEX dies

Code	Ø mm	Combined male
9121F/9 FLEX	9	9104M
9121F/10 FLEX	10	9105M
9121F/11 FLEX	11	9106M
9121F/12 FLEX	12	9107M
9121F/13 FLEX	13	9108M
9121F/14 FLEX	14	9109M
9121F/15 FLEX	15	9110M
9121F/16 FLEX	16	9111M
9121F/17 FLEX	17	9112M
9121F/18 FLEX	18	9113M

Oval FLEX dies

Code	Ø mm	Combined male
9129F/7x13 FLEX	7x13	9130M
9129F/8x14 FLEX	8x14	9131M
9129F/9x15 FLEX	9x15	9132M
9129F/10x16 FLEX	10x16	9134M
9129F/11x17 FLEX	11x17	9136M
9129F/12x18 FLEX	12x18	9138M
9129F/13x19 FLEX	13x19	9140M
9129F/14x20 FLEX	14x20	9142M
9129F/15x21 FLEX	15x21	9144M
9129F/16x22 FLEX	16x22	9146M
9129F/17x24 FLEX	17x24	9148M
9129F/18x25 FLEX	18x25	9149M



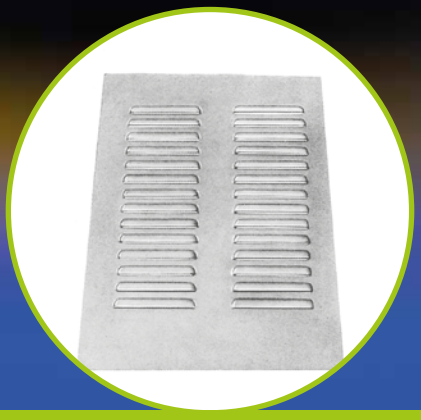
Hydraulic punching machines

TECHNICAL APPLICATION

EXAMPLE OF PERFORATED PANELS

EXAMPLE OF PUNCHING ON BOXES

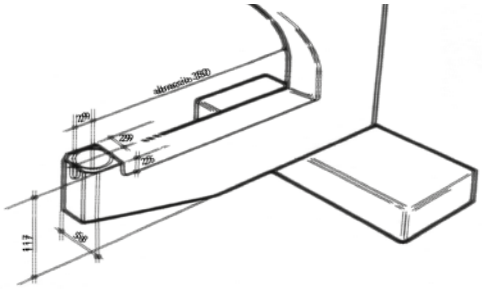
EXAMPLE OF SQUARE AND RECTANGULAR PUNCHING



VENTILATION SLOTS REALIZED WITH TOOLS CODE 10803-4

EXAMPLE OF PERFORATED BOX

10030L
Hydraulic punchig machine for panels and boxes



POWER UNITS
PAG. 80÷87

PUNCHES
AND ACCESSORIES
PAG. 30÷35

The punching machine **10030L** is planned for making holes of small dimensions; it is very versatile and it can be used for punching either the bottom or the sides of boxes, panels, lids, steel, aluminium, plastic and masonite sheets.
Its building characteristics are the same of the other MULTIFOR punching machines.
Punches are built in different shaped and sizes according to the power of the machine.
This punching machine can be used with all IMB power units: foot pedal and electric control units.
In order to reduce the working cycles, it is supplied with a **stroke regulator**, which cuts down the gap between punch and die.
It is equipped with safety device and protection cover.
It is also possible to assemble an adjustable end stroke during the descent phase

The punching machine is supplied with:

N. 1 punch holder Ø 11 (code 10101L) for round punches up to Ø 40,5.

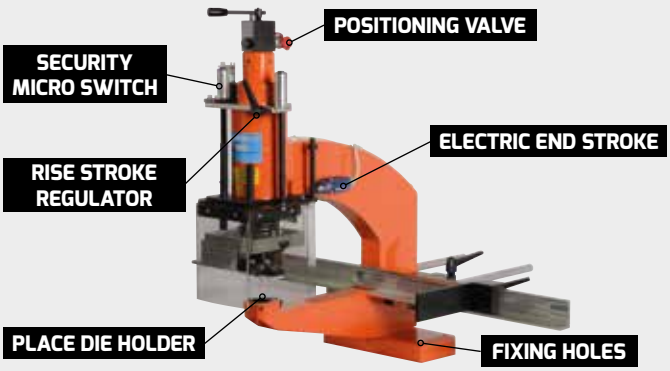
N. 1 punch holder lock nut Ø 28 (cod. 10171).

N. 1 set of extractors for the extraction of the punch from the material (cod. 10145).

N. 1 positioning valve (cod. 9162).

N.B. The punching machine does not need die holder flanges.
Max. diameter Ø 40,5 on mild steel sheet with thickness 2 mm.

Characteristics	
Max depth	350 mm
Power	35 kN (3,5 Ton.)
Working pressure	700 bar
Max dia of round hole	Ø 40,5 mm
Max square hole	26x26 mm
Max rectangular hole	within Ø 37 mm
Distance between punches	55 mm
Lenght	560 mm
Width with ruler	1.100 mm
Height	680 mm
Weight	113 Kg



Micro switch for laser pointing

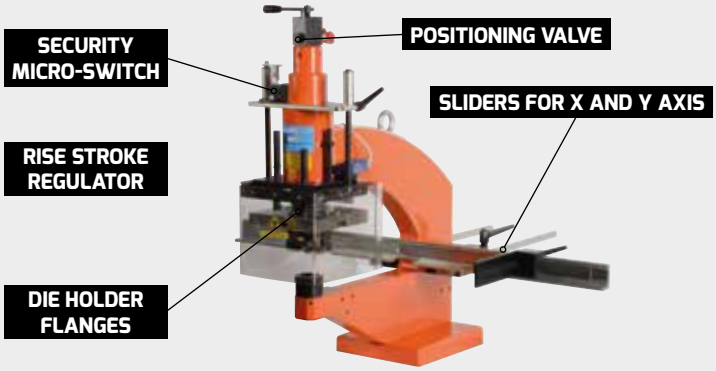
10040L
Simplified hydraulic punching machine

Technical Characteristics	
Max. depht	400 mm
Power	56kN (5,6 Ton.)
Lenght	1110 mm (max)
Width	1100 mm
Height	870 mm
Weight	136 Kg
Run positioning brackets	X Axe 500mm Y Axe 395mm
Max. round hole	Ø 68 mm
Max. square hole	68x68 mm
Max. rectangular hole	within Ø 96 mm
Die flanges	10131, 10132, 10133, 10134
MAX. THICKNESS	
Sheet steel	2,0 mm
Stainless steel	1,8 mm
Aluminium	5 mm
Plastic laminate	5 mm

The punching machine **10040L** has a system of brackets regulation with simplified X and Y-axis. The technical characteristics of this equipment are between the punching machine 10050L and 10030L.
With a new system of flanges, this punching machine can do round, square, rectangular and special punches. This hydraulic punching machine can operate on panel sheets, plastic and stainless boxes.
Practical and speedy use to avoid tracing, the machine has a system of guides for the X and Y axis. The punching machine is equipped with bracket regulations, protection carter and micro security.
On request, we can build an arm for the panel support.

The punching machine is equipped with:

N. 1 positioning valve (code 9162).
N. 1 punch holder (code 10101L) for round punches until Ø mm 40, 5 max.
N. 1 die holder flange (code 10131) for round dies Ø mm 40,5 max, for square dies until □ mm 26 and rectangular or special dies with dimensions within Ø mm 37.
N. 2 series of extractors (code 10141 - 10142) for the extraction of the punch from the steel
N. 1 lock nut punches holder Ø 28 mm (code 10171).
Mechanical end stroke for the rise of the punch: it reduces times
Protection carter: with an electric micro-switch
End down-stroke: with an electric micro-switch



Die holder flanges

10131 10132 10133 10134

POWER UNITS
PAG. 80÷87

PUNCHES
AND ACCESSORIES
PAG. 30÷35

10050L / 10050LV
Hydraulic punching machine

10050 L
(with laser pointing)

10050 LV
(with laser pointing and digital visualizer)

Technical Characteristics	
Max depth	500 mm
Power	85 kN
Working pressure	700 bar
Max round hole Ø	130 mm
Max square hole	92x92 mm
Max rectangular hole	within Ø 130 mm
Distance between punches	55 mm
Lenght	1.150 mm
Width	2.120 mm
Height	980 mm
Weight	331 Kg
Oil capacity for a complete stroke	0,08 lt.
Stroke	65 mm
Die flanges:	10161, 10162, 10163, 10164, 10165

The hydraulic punching machine **10050L** has the characteristics and performances in between the small 10035L and the big 10090L.
In order to reduce the working time, a stroke regulation allows to cut down the opening between punch and die. This equipment is supplied with protection cover and with an electric security micro switch.

It is not necessary to make a pre-hole. It is designed to operate with a system of axis X-Y shifting on prismatic guides, sleeves and panel supports complete with locking.

The 10050L is supplied with:

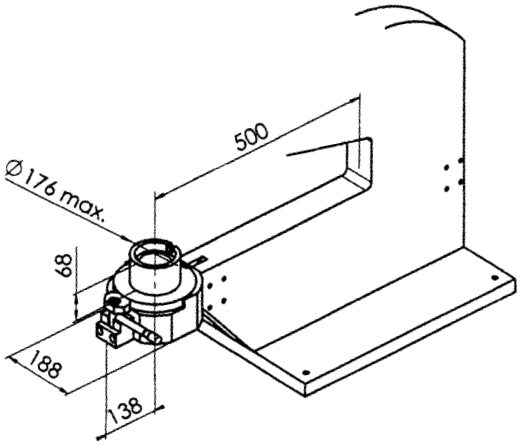
N. 1 positioning valve (code 9162).

N. 1 punch holder (code 10101L) for round punches up to Ø 40, 5 mm

N. 1 die flange (code 10161) for round dies up to Ø 40,5 mm, for square dies up to □ mm 26 mm, rectangular or special dies within Ø 37mm.

N. 2 sets of extractors (code 10141 –10142) for the extraction of the punch from the panel sheet.

N. 1 punch holder lock nut
(code 10171).



BASE
10100/50

Rise stroke and electric end stroke regulators

Fast system of die flanges locking

Axis reference and locking panel board

Hydraulic punching machine with digital visualizer and laser pointing.

Die holder flanges

10161 10162 10163 10164 10165

POWER UNITS
PAG. 80÷87

PUNCHES
AND ACCESSORIES
PAG. 30÷35

10090EL - 10090ELV
Economic hydraulic punching machine 20 Ton

Light system of brackets regulation with X - Y axis

Technical Characteristics	
Maximum depth	900 mm
Power	200 kN (20 Ton)
Oil capacity for a complete stroke	0,18 lt.
Max. round hole	Ø 170 mm
Max. square hole	138x138 mm
Working pressure	700 bar
Lenght	2100 mm
Width	2160 mm
Height with the base	1760 mm
Distance between punches	50 mm
Punch stroke	65 mm
X Axis stroke	1.000 mm
Y Axis stroke	900 mm
Approx. weight	1000 Kg
MAX. THICKNESS	
Sheet steel	2,0 mm
Stainless steel	1,8 mm
Aluminium	5 mm
Plastic laminate	5 mm

10090EL

The hydraulic punching machine 10090EL, is a high power machine with a simple system of brackets regulation for X and Y axis. It has the same characteristics and performance of the hydraulic punching machine 10090L.
The axis run is for X axe 1000 mm and for Y axe 900 mm. These units are studied exclusively for making holes. They are fast and practical to use, thanks to a special system of guides of axis X and Y. This system avoids tracing and the panel board is held up by a mobile support and fixed on X-Y axis.
The version **10090EL** has the laser pointing which indicates the center of the hole on the material to punch.
The version **10090ELV** has the laser pointing and the visualizer.

Die holder flange system

The punching machines are supplied with the following items:

N. 1 punch holder (code 10101L) for round dies up to Ø mm 40,5 max.
N. 1 die holder flange (code 10191) for round dies up to Ø mm 40,5 max, for square dies up to Ø mm 26 max and rectangular dies or specials with max dimension within 37 mm. dia.
N. 2 series of extractors (code 10141 - 10142) for the extraction of punch from the steel.
N. 1 punch holder lock nut Ø 28 mm (cod. 10171).
N. 1 positioning valve (code 9162).

Laser pointing

All punching machines are supplied with **LASER POINTING** which **indicates ONLY the centre of the hole** to realize on the control board door. The diode is protected inside the stem, to avoid breaking.

Laser	diode type class 1
Power	1 mW
Supply	direct current, battery 4,5 V.

For the operator who uses the laser pointing, there are no protection supplied. Please don't watch the beam of light, which comes out from the diode.

Die holder flanges

10191 10192 10193 10194 10195

10090 L - 10090 LV
Punching hydraulic machine 20 Ton

10090 LV

Technical Characteristics	
Maximum depth	900 mm
Power	200 kN (20 Ton)
Amount of oil required for a full stroke	0,18 lt.
Max. dia of hole	Ø 170 mm
Max round hole	138x138 mm
Working pressure	700 bar
Length max	1850 mm
Width	3020 mm
Height with base	1680 mm
Distance between punches	50 mm
Punch stroke	65 mm
X Axis stroke	1.500 mm
Y Axis stroke	900 mm
Approx. Weight	1527 Kg
MAX. THICKNESS	
Sheet steel	2,0 mm
Stainless steel	1,8 mm
Aluminium	5 mm
Plastic laminate	5 mm

In the **10090LV** the measures detector takes place through bidirectional heads on a measuring stripe (accuracy ± 0,1 mm)

N.B. Shifting of the axis is manual.

The hydraulic punching machine with visualizer is supplied with a plug.

Supply	220V/240V
Frequency	50/60Hz

The punching machine is supplied with the following items:

N. 1 punch holder (code 10101L) for round dies up to Ø 40,5 mm max.

N. 1 die holder flange (code 10191) for round dies up to Ø 40,5 mm max, for square dies up to Ø 26 mm max. and rectangular dies or specials with max dimension within 37 mm. dia.

N. 2 series of extractors (code 10141 - 10142) for the extraction of punch from the steel

N. 1 punch holder lock nut Ø 28 mm (cod. 10171)

N. 1 metal basement (code 10100/90)

N. 1 positioning valve (code 9162).

The MULTIFOR hydraulic punching machines, which combine high power with compact dimensions, are built to resolve the problems of making holes in panels, lids, sheet steel, aluminium strip or plastic. These units are studied exclusively for making holes. They are quick and practical as they avoids marks working on a special rail sysstem of X-Y axis, on which the panel board is fixed.
The pre-hole is not necessary.

With the special punches, you can realize the following holes: **round, square, rectangular, shaped, round with more holes, square with round holes, rectangular with round holes, tools for ventilation slots,** etc.

The MULTIFOR punching machines can be connected with a rapid connector to the MULTIFOR electric units.
These units can be also used in small workshop due to their versatility and small size.
All our hydraulic punching machines are equipped with carter protection, safety micro switch and electric micro end-stroke.
The dies assembly is very simple and it is not necessary to take away the panel board.
In order to reduce the working cycles, a rise stroke regulator allows to reduce the opening between the punch and the die.

Electric cabinet for axis-control with PLC.

Hydraulic punching machine 10098 With PLC X-Y axis control

It is a punching machine with same features as the standard version.
In addition, it is equipped with re-circulating ball screw and motors for axis shifting.
This programmable logic control permits to carry out complete automatic working cycles with pauses for changing the tools. With the menu all the positioning operations, single or automatic, can be performed. Storage up to 96 programs of 30 steps each.
All operations are readable on a display. The control board is complete with feeding and start-stop-alarm, axis shifting manual control.

The hydraulic punching machine is equipped with safety barrier and photocells. The visualizer is calibrated by the manufacturer in order to visualize dimensions with absolute values. However the operator can set the value 0 (zero) and use the visualizer for movements with incremental values.

Accessories for punching machines

DIE FLANGES

The flanges are used for positioning the different dies. As shown in the list, based on the die flanges on the left column, you can see the possible dimensions.

Die flanges for 10040L

Die flanges	Round dies Ø mm	Square dies □ max mm	Rectangular Dies Within Ø mm
10131	2,5-40,5	26	37
10132	41-48,5	36	51
10133	49-68,5	48,5	68
10134	69-99	70	99

Dies flanges for 10050L

Die flanges	Round dies Ø mm	Square dies □ max mm	Rectangular Dies Within Ø mm
10161	2,5-40,5	26	37
10162	41-48,5	36	51
10163	49-68,5	48,5	68
10164	69-99	70	99
10165	143	92	143

Dies flanges for 10090

Die flanges	Round dies Ø mm	Square dies □ max mm	Rectangular Dies Within Ø mm
10191	2,5-40,5	26	37
10192	41-48,5	36	51
10193	49-68,5	48,5	68
10194	69-99	70	99
10195	100-143	101	143

N.B. The round dies for the 10090 with higher dimensions up to Ø 170 mm, are built to be inserted directly in the machine.
This is also the case of square and rectangular dies within Ø 144 mm to max. Ø 170 mm.

PUNCH HOLDERS

Punch holders are used to assemble the different round, square,rectangular and special punches. They are held in position by lock nut and must be chosen in relation to the type and dimensions of the punch to be used, as shown in the table. The reference pin is re-entering less the one code 10104.

10101 10102 10103 10104 10105 10106

10101L 10102L 10103L 10104L 10105L 10106L

Code	Ø mm	Used with
10101L	Ø 11	Round punches Ø 18,5-40,5 mm
10102L	Ø 16	Round punches Ø 41-72,5 mm
10103L	Ø 22	Round punches Ø 76-130 mm
10104L	10x10	Square punches min. 21,5 - max 29 mm Rectangular punches side min. 21,5 - max 29 mm
10105	14x14	Square punches min. 30 - max 46 mm Rectangular punches min. side 30 - max 35 mm
10106	20x20	Square punches min. side 48 - max 92 mm Rectangular punches min. side 36 mm and over

The punch holders for the hydraulic punching machines with laser pointing have not the central reference re-entering, but a passer-by hole.

Accessories for hydraulic punching machines

LOCK NUTS

10171

10172

10173

Code	Description	Application field
10171	Lock nut Ø 30	Punch holders 10101 - 10106
10172	Lock nut Ø 35	Special punch holders
10173	Lock nut for punches superior to 100 mm	

EXCTRACTORS

The extractors are used for extracting the punch from the steel after perforation. Their position can be adjusted so that they can be placed as close as possible to the punch.
Two series are supplied; one for round holes, the other for square, rectangular or special holes.

10141

10142

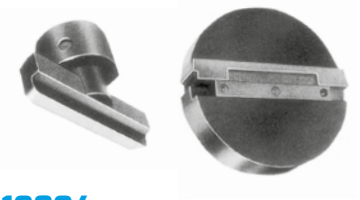
10145

Code	Normally used for
10141	Round punches
10142	Square and rectangular punches
10143	Big and special punches
10145	Round punches on 10030L

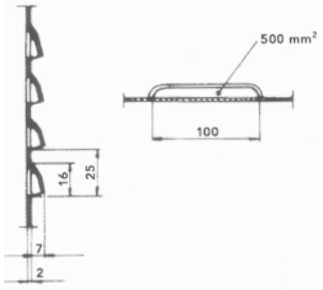
TOOLING FOR VENTILATION SLOTS

10804 for 10090

Tooll for ventilation slots of 500 sq. mm on sheet steel of max. thickness 2 mm. This tooling is equipped with blank holder. For different material thickness, please contact our Technical Department



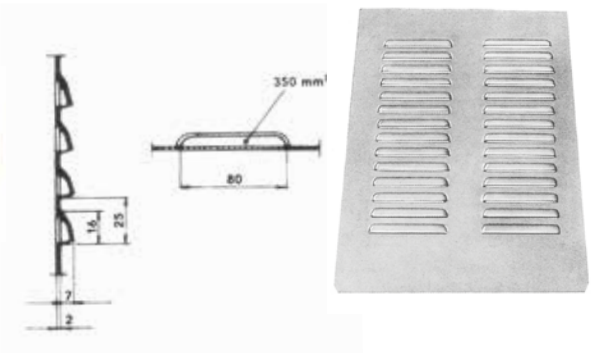
10804



10803 for 10050

Tool to realize ventilation slots of 350 sq mm on sheet steel of max. thickness 2 mm.
This tooling is supplied with a blank holder.
On request, we can realize tooling for small sizes.
For different thickness, please contact our Technical Department.

10803



Standard round punches for hydraulic punching machines

DIRECT PUNCH

PUNCH WITH THREAD

All our of round punches are made of special tempered steel. They have 3 cutting edges and they are used to punch holes on sheet steel max.thickness 2,0 mm and stainless steel max.1,8 mm. Aluminium plastic laminates and other material from 0,5 to 5 mm max.
The punching is carried out with maximum precision and without deformation of the material. The dia of the punches is clearly marked with the nominal Ø, in order to avoid mistakes.

The punches in the following list are mounted directly on the machine without punch holders.

PUNCH		Flange to use
code	Ø mm	code
10200/2,5	2,5	10191 / 10161 / 10131
10200/3	3	10191 / 10161 / 10131
10200/3,25	3,25	10191 / 10161 / 10131
10200/3,5	3,5	10191 / 10161 / 10131
10200/4	4	10191 / 10161 / 10131
***10200/4,25**	4,25	10191 / 10161 / 10131
***10200/4,5**	4,5	10191 / 10161 / 10131
***10200/5**	5	10191 / 10161 / 10131
***10200/5,5**	5,5	10191 / 10161 / 10131
***10200/6**	6	10191 / 10161 / 10131
***10200/6,75**	6,75	10191 / 10161 / 10131
***10200/7**	7	10191 / 10161 / 10131
***10200/7,75**	7,75	10191 / 10161 / 10131
***10200/8**	8	10191 / 10161 / 10131
***10200/8,5**	8,5	10191 / 10161 / 10131
***10200/9**	9	10191 / 10161 / 10131
***10200/9,5**	9,5	10191 / 10161 / 10131
***10201**	10	10191 / 10161 / 10131
***10203**	13	10191 / 10161 / 10131
***10205**	15,5	10191 / 10161 / 10131
***10207**	16,2	10191 / 10161 / 10131
***10209**	17	10191 / 10161 / 10131

When ordering punches, it is recommended to check the right column of the list to identify the kind of holders and flanges to use depending on the hydraulic punching machine.

PUNCH		Punch holder to use		Flange to use
code	Ø mm	code	Ø mm	code
10211	18,5	**10101**	11	10191 / 10161 / 10131
10213	19,5	**10101**	11	10191 / 10161 / 10131
10215	21	**10101**	11	10191 / 10161 / 10131
10217	22,5	**10101**	11	10191 / 10161 / 10131
10219	24	**10101**	11	10191 / 10161 / 10131
10221	25,5	**10101**	11	10191 / 10161 / 10131
10223	26,5	**10101**	11	10191 / 10161 / 10131
10225	27,5	**10101**	11	10191 / 10161 / 10131
10227	28,5	**10101**	11	10191 / 10161 / 10131
10229	30,5	**10101**	11	10191 / 10161 / 10131
10231	32,5	**10101**	11	10191 / 10161 / 10131
10233	33,5	**10101**	11	10191 / 10161 / 10131
10235	35,5	**10101**	11	10191 / 10161 / 10131
10237	37	**10101**	11	10191 / 10161 / 10131
10239	38,5	**10101**	11	10191 / 10161 / 10131
10241	40,5	**10101**	11	10191 / 10161 / 10131
10243	42,5	**10102**	16	10192 / 10162 / 10132
10245	45,5	**10102**	16	10192 / 10162 / 10132
10247	47	**10102**	16	10192 / 10162 / 10132
10249	48,5	**10102**	16	10192 / 10162 / 10132
10251	50,5	**10102**	16	10193 / 10163 / 10133
10253	52,5	**10102**	16	10193 / 10163 / 10133

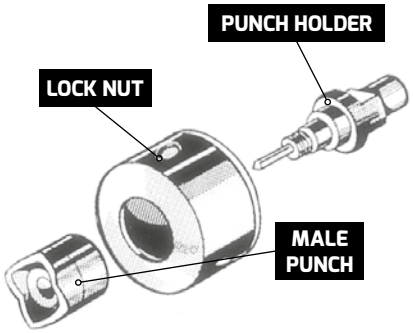
The punches in this list can be used on punching machine 10030L up to 10241; on our 10040L punching machine until code 10269 and on our 10050L until code 10301.

PUNCH		Punch holder to use		Flange to use
code	Ø mm	code	Ø mm	code
10255	54,2	**10102**	16	10193 / 10163 / 10133
10257	55,5	**10102**	16	10193 / 10163 / 10133
10259	57	**10102**	16	10193 / 10163 / 10133
10261	59,5	**10102**	16	10193 / 10163 / 10133
10263	60,5	**10102**	16	10193 / 10163 / 10133
10265	62,5	**10102**	16	10193 / 10163 / 10133
10267	65	**10102**	16	10193 / 10163 / 10133
10269	68	**10102**	16	10193 / 10163 / 10133
10271	70,5	**10102**	16	10194 / 10164
10273	72,5	**10102**	16	10194 / 10164
10275	76	**10103**	22	10194 / 10164
10277	78	**10103**	22	10194 / 10164
10279	80,5	**10103**	22	10194 / 10164
10281	82	**10103**	22	10194 / 10164
10283	87	**10103**	22	10194 / 10164
10285	90	**10103**	22	10194 / 10164
10287	92	**10103**	22	10194 / 10164
10289	96	**10103**	22	10194 / 10164
• **10291**	100,5	**10103**	22	10195 / 10165
• **10293**	103	**10103**	22	10195 / 10165
• **10295**	105	**10103**	22	10195 / 10165
• **10297**	113	**10103**	22	10195 / 10165
• **10299**	116	**10103**	22	10195 / 10165
• **10301**	120	**10103**	22	10195 / 10165
• **10303**	134	**10103**	22	10195
• **10305**	140	**10103**	22	10195

• To assemble with lock nut code 10173

When ordering punches, it is suggested to check the right column of the list to identify the kind of holders and flanges to use depending on the hydraulic punching machine.
Please verify, also, if the hydraulic punching machine has the LASER POINTING.

*** Please add to the code the letter "L" if the operator has an hydraulic punching machine with Laser**

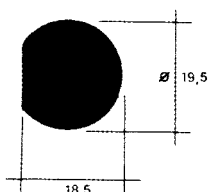


How to assemble a round punch

Shaped punches for handles, locks and push buttons

Special punches have been studied for the assembly of handles, locks and push buttons.

10811



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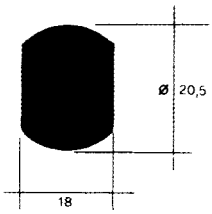

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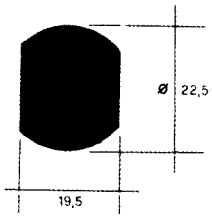

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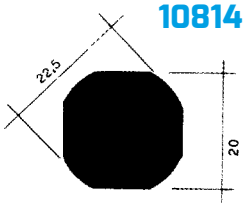

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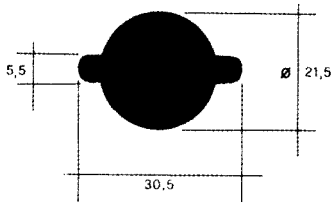

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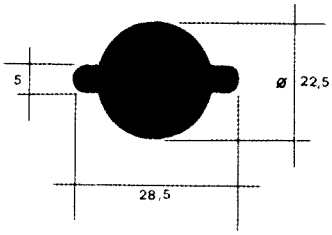

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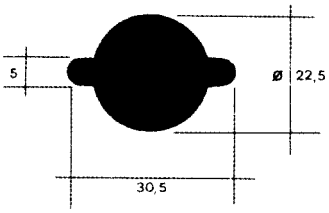

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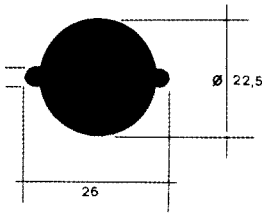

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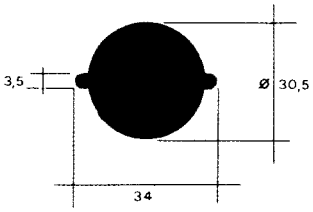

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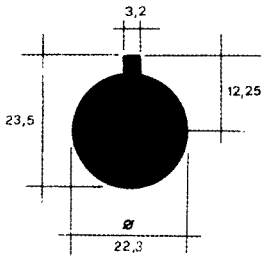

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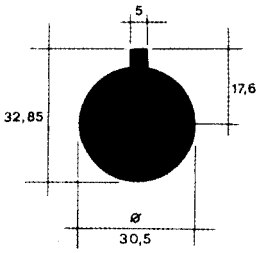


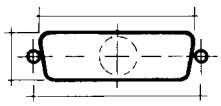
Measures on request

The punches of this list can be used on all our IMB hydraulic punching machines. **Special punches** are fixed directly on the hydraulic punching machine.

PUNCH			
Code	Slot dimension mm	Nut code	Lock Flange to use
* **10811**	19,5x18,5	10171	10191 / 10161 / 10131
* **10812**	20,5x18	10171	10191 / 10161 / 10131
* **10813**	22,5x19,5	10171	10191 / 10161 / 10131
* **10814**	22,5x20,5	10171	10191 / 10161 / 10131
* **10822**	21,5x30,5	10172	10191 / 10161 / 10131
* **10824**	22,5x28,5	10172	10191 / 10161 / 10131
* **10826**	22,5x30,5	10172	10191 / 10161 / 10131
* **10831**	22,5x26	10171	10191 / 10161 / 10131
* **10832**	30,5x34	10172	10191 / 10161 / 10131
* **10841**	22,3x23,5	10171	10191 / 10161 / 10131
* **10842**	30,5x32,85	10172	10191 / 10161 / 10131

* Add to the codes the letter “L” if the operator uses them with punching hydraulic machine with laser.

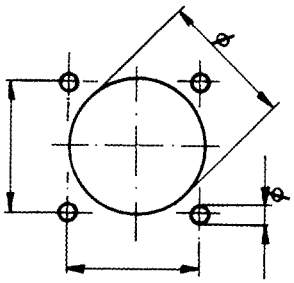
Punches for D-SUB connectors

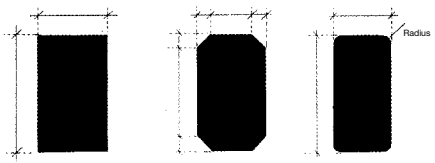


Position	Code
9	***10850**
15	**10851**
25	**10852**

* Assemble with lock nut 10172

Example of special punches





Square punches for hydraulic punching machines

They have four cutting edges on the mid point of each side. This patented technical innovation leads to a better auto-centering, an easier and fast punching on the sheet metal and less stress for a longer tool life.
These punches can be used on sheet steel thickness from 0,5 to 2 mm max.; on stainless steel from 0, 5 to 1,8 mm; on aluminium, plastic laminates or other materials from 0,5 to 5 mm.

For higher thickness, please call our Technical Department.

When ordering punches, we recommend to check the list for appropriate punch holders and flanges.
We remember you, to verify, if your punching machine has the LASER POINTING

PUNCH		Punch holder to use		Flange to use			
Code	side □ mm	Code	□ mm	10030	10040	10050	10090
*10401	12x12	Mounted directly on the piston	–	Direct	10131	10161	10191
*10403	15x15		–	Direct	10131	10161	10191
*10405	18x18		–	Direct	10131	10161	10191
*10407	19x19		–	Direct	10131	10161	10191
*10409	20x20		–	Direct	10131	10161	10191
* **10411	22x22		–	Direct	10131	10161	10191
10413	25x25	10104	10	Direct	10131	10161	10191
10415	26x26	10104	10	Direct	10131	10161	10191
10417	30x30	10105	14	X	10132	10162	10192
10419	35x35	10105	14	X	10132	10162	10192
10421	40x40	10105	14	X	10133	10163	10193
10423	45x45	10105	14	X	10133	10163	10193
10425	46x46	10105	14	X	10133	10163	10193
10427	48,5x48,5	10106	20	X	10133	10163	10193
10429	50x50	10106	20	X	10134	10164	10194
10431	55x55	10106	20	X	10134	10164	10194
10433	57x57	10106	20	X	10134	10164	10194
10435	60,5x60,5	10106	20	X	10134	10164	10194
10437	68x68	10106	20	X	10134	10164	10194
10439	80,5x80,5	10106	20	X	X	10165	10195
10441	90,5x90,5	10106	20	X	X	10165	10195
10443	92x92	10106	20	X	X	10165	10195
10445	96x96	10106	20	X	X	X	10195
•10448	112x112	10106	20	X	X	X	Direct
••10450	126x126	10106	20	X	X	X	Direct
••10452	138x138	10106	20	X	X	X	Direct

Other sizes available on request.

* Please add to the code the letter "L" if the user has a laser hydraulic punching machine.

** In order to assemble, use 10172 lock nut.

• Assemble with lock nut 10173.

•• Use extractors 10143 and the big lock nut 10173.

Rectangular punches for hydraulic punching machines

They have four cutting edges on the mid point of each side. This patented technical innovation leads to a better auto-centering, an easier and fast punching on the sheet metal and less stress for a longer tool life.
These punches can be used on sheet steel thickness from 0,5 to 2 mm max.; on stainless steel from 0, 5 to 1,8 mm; on aluminium, plastic laminates or other materials from 0,5 to 5 mm.

For higher thickness, please call our Technical Department.

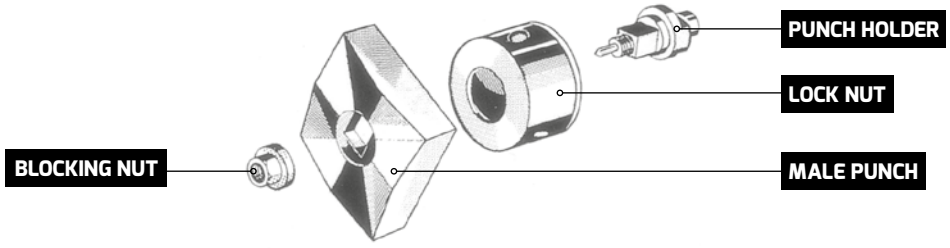
When ordering punches, recommend to check the list for appropriate punch holders and flanges.
We remember you, to verify, if your punching machine has the LASER POINTING

PUNCH		Punch holder to use		Flange to use		
Code	side □ mm	Code	□ mm	10040	10050	10090
*••10607	17,5x33,5	Direct		10132	10162	10192
10609	20x41	10104	10	10132	10162	10192
10611	22x30	10104	10	10132	10162	10192
10613	22x42	10104	10	10132	10162	10192
10615	24x36	10104	10	10132	10162	10192
10/29x71	29x71	10105	14	10134	10164	10194
10617	30x45	10105	14	10133	10163	10193
10619	32x60	10105	14	10133	10163	10193
10621	34x68	10105	14	10134	10164	10194
10623	36x46	10106	20	10134	10164	10194
10625	36x85	10106	20	10134	10164	10194
10627	36x112	10106	20	X	10165	10195
10631	44x92	10106	20	X	10165	10195
10632	45x93	10106	20	X	10165	10195
10633	46x53,5	10106	20	X	10164	10194
10635	46x71	10106	20	X	10164	10194
10637	50x98	10106	20	X	10165	10195
•10640	68x138	10106	20	X	X	Direct
•10642	81x117	10106	20	X	X	Direct

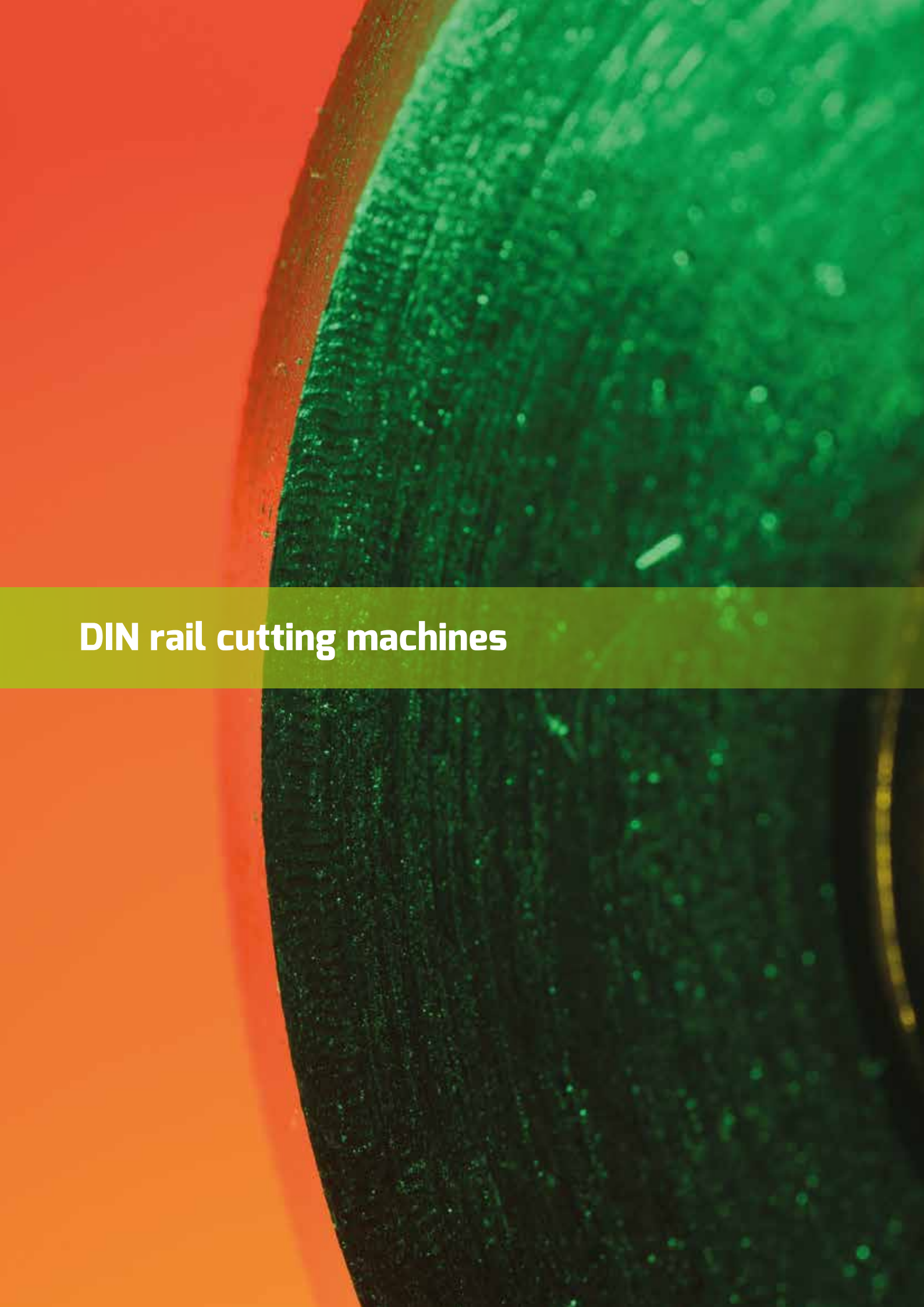
Other sizes available on request.
All rectangular punches are to be considered as specials.

* Please add the letter "L" if the user has a laser hydraulic punching machine.

• Assemble with the big lock nut 10173 and with extractors 10143.
•• Equipped with lock nut 10172.



How to assemble square and rectangular punches

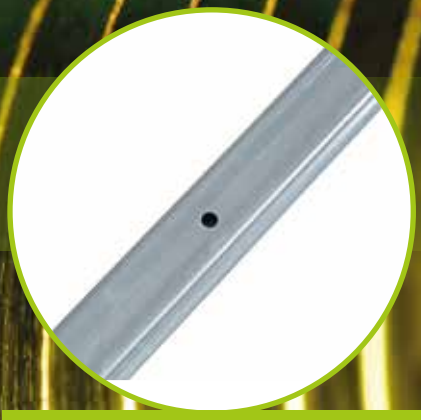


DIN rail cutting machines

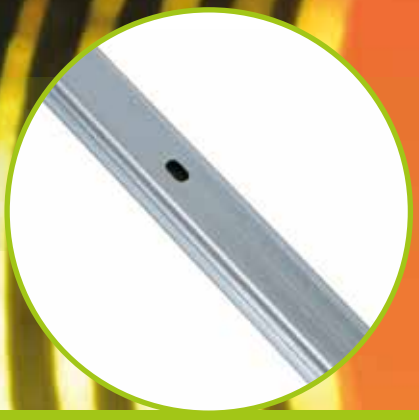
TECHNICAL APPLICATION

HOLES AND CUT ACHIEVABLE
WITH ART. 9050-52-54-55

HOLE AND CUT ACHIEVABLE
WITH ART. 9056 - 58



HOLE ACHIEVABLE WITH ART. 9056



HOLE ACHIEVABLE
WITH ART. 9050-52-54-55

HOLE AND CUT ACHIEVABLE
WITH ART. 9050-52-54

HOLES AND CUT ACHIEVABLE
WITH ART. 9050-52-54

Manual din rail cutting machines

For cutting and punching standard and special Din Rails

9050

It cuts four profiles in the desired positions and punches oval holes 6,5 x12 mm in longitudinal and transversal position.
It is equipped with 1-meter ruler and slider.

Characteristics	
Weight	19 Kg
Width	180 mm
Height complete with lever	990 mm
Lenght	1.160 mm (with ruler)

9056

It cuts 4 standard din rails and punches a round hole Ø 6,5 mm
It is equipped complete with 1 meter ruler and slider.

Characteristics	
Weight	14 Kg
Width	180 mm
Height complete with lever	990 mm
Lenght	1.160 mm (with ruler)

9058

It cuts two din rails impressions in the desired position and it punches a round hole Ø 6, 5 mm at the beginning of the din rail.
It is equipped with 1 mt. ruler and slider.

Characteristics	
Weight	11 Kg
Width	130 mm
Height complete with lever	870 mm
Lenght	1.150 mm (with ruler)

Din rail cutting machines

For cutting and punching standard and special Din rails

9052
Pneumatic

Very fast machine and effortless user experience.
It cuts with rapidity and with a low air consumption with a feeding pressure from 7 to 9 bars.
The pneumatic version is equipped with a foot pedal. It cuts four standard din rails in the desired positions and punches oval holes 6,5x12 mm in a longitudinal and transversal position.
It is equipped with 1 meter ruler and slider.

Characteristics	
Dimensions without ruler	180x110xh540 mm
Total Weight	31 Kg
Patented model.	

9054
Oleodynamic

It has the same features of the model 9050.
Very fast machine and effortless user experience.
This tool takes advantage of the strength of an oleodynamic cylinder, which acts directly on the cutting blade.
It can be used with all IMB pumps or electric controls units.
It is equipped with 1 meter ruler and slider.

Characteristics	
Dimensions without ruler	180x110xh300 mm.
Total Weight	14 Kg
Patented model.	

POWER UNITS PAG. 80÷87

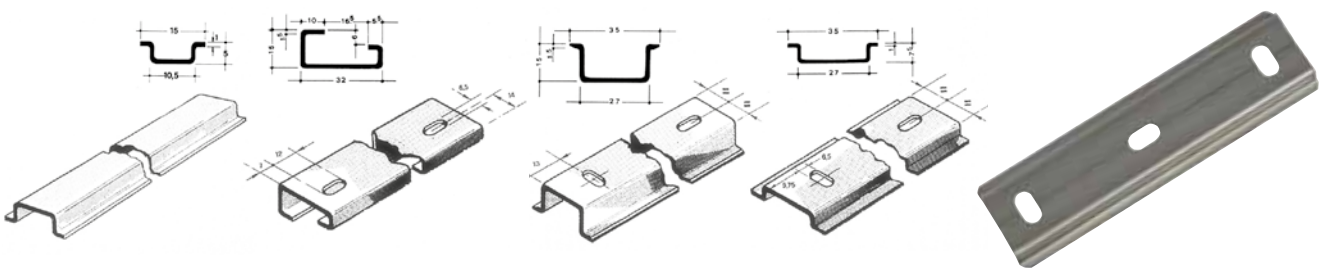
9055
For Tris unit

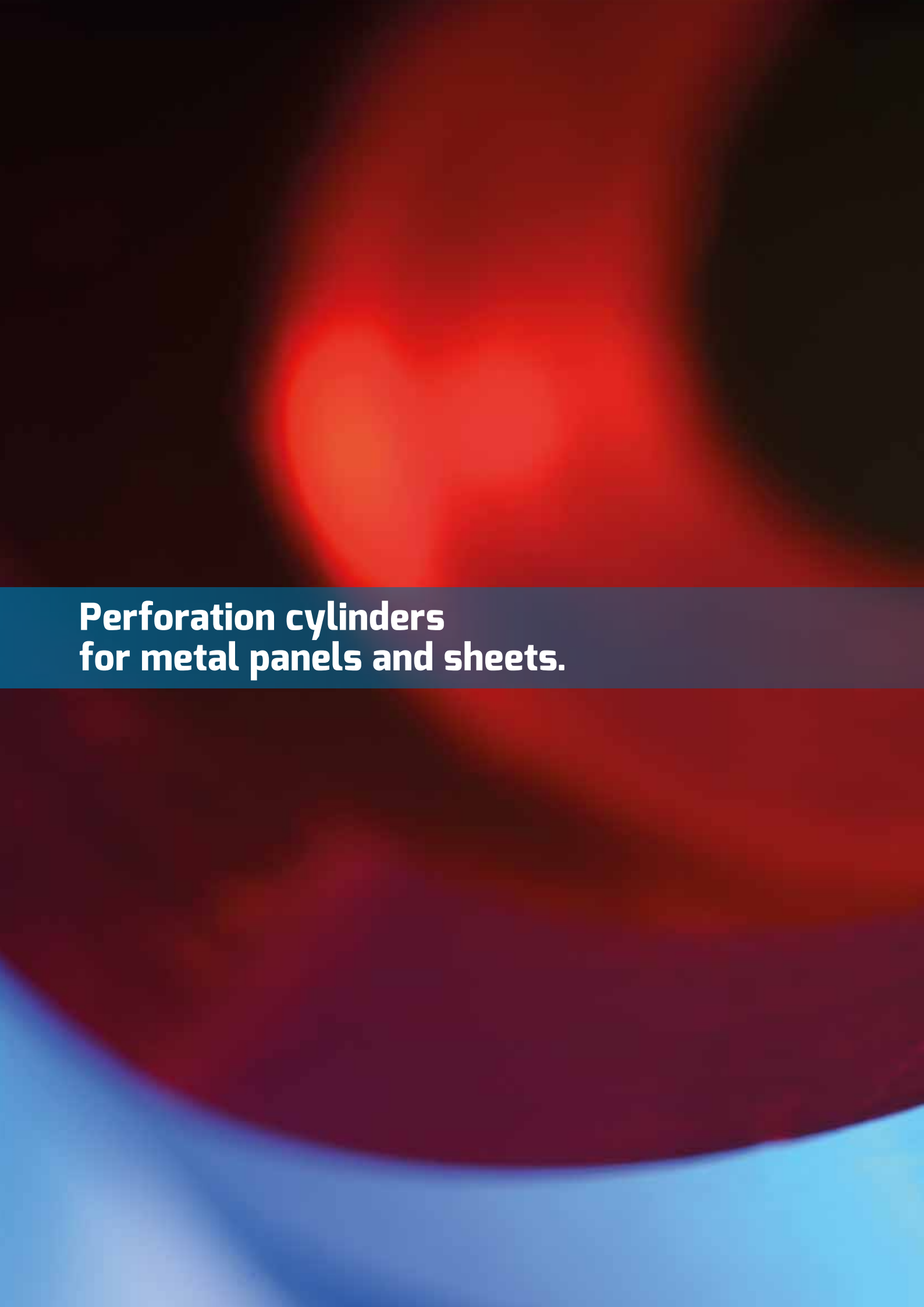
It has the same working characteristics of the din rail model 9050.
It is easy to install it on the Tris Unit.

Characteristics	
Lenght	180 mm
Width	70 mm
Height	120 mm
Weight	12 Kg

STANDARD DIN RAILS

Special rail shapes and holes on request. Also on aluminium.

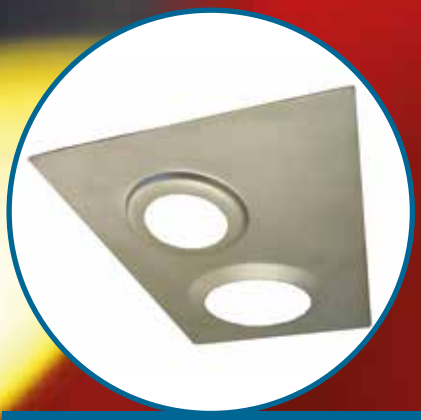




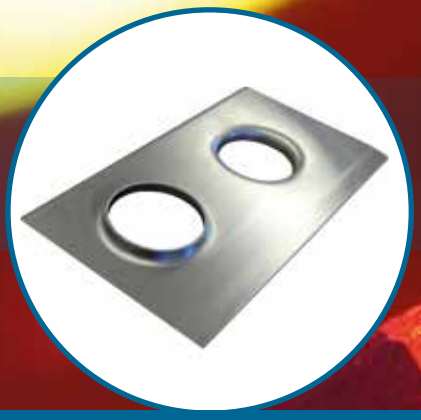
Perforation cylinders for metal panels and sheets.

TECHNICAL APPLICATION

EXAMPLE OF PUNCHING
WITH ART. 9022

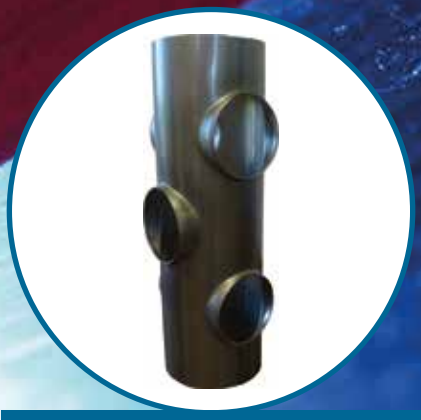


DRAWING FOR STAINLESS STEEL
KITCHEN SINKS



EXAMPLE OF FLAT DRAWING

EXAMPLE OF PUNCHING
WITH ART. 9070E



DRAWING ON PIPE

9070
Manual punching cylinder

Manual punching cylinder. It punches steel sheet from1 to 2 mm but it depends on the diameter of the hole.
For aluminium and plastic laminates max. 5 mm thickness.
For other material, please contact our Technical Department.
Supplied with a plastic case and complete of spacers for the use of pins of the perforation cylinder 9022.

Characteristics	
Power	50 kN
Weight	2,2 Kg
Round hole max	Ø 72,5 mm
Square hole max	68x68 mm
Stroke	20 mm

Kit

Kit Manual Punching cylinder PG 9861

Code	Description	Quantity
9070	Cylinder	1
9192	Punch Ø 15,5	1
9206	Punch Ø 18,5	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9222	Punch Ø 28,5	1
9224	Punch Ø 30,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9825	Case	1

Kit Manual punching cylinder ISO 9862

Code	Description	Quantity
9070	Cylinder	1
9202	Punch Ø 16,2	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9216	Punch Ø 25,5	1
9228	Punch Ø 32,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9603	Pin Ø 16	1
9825	Case	1

Kit Manual Punching Cylinder GAS 9863

Code	Description	Quantity
9070	Cylinder	1
9204	Punch Ø 17	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9214	Punch Ø 24	1
9218	Punch Ø 26,5	1
9224	Punch Ø 30,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9825	Case	1

ROUND PUNCHES PAGES 47-48 SQUARE PUNCHES PAGE 49 RECTANGULAR PUNCHES PAG. 50

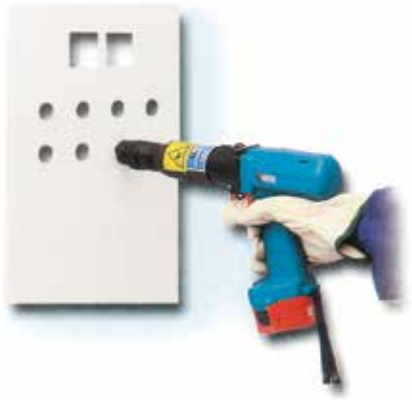
9070E
Punching cylinder with battery

Characteristics	
Power	63 kN
Weight	3,3 Kg
Max. round hole	Ø 120 mm
Max. square hole	92x92 mm

Cylinder with battery, provided with a trigger switch and manual lever for the cylinder return. Tool used for punching panels and sheets of steel max. thickness 2 mm; alluminium and plastic max. 5 mm.
Please contact our Technical Department for other material.
Supplied with a plastic case, battery charger and spacers for the use of series pins
of our cylinder perforation 9022.

Patented Model

Kit



KIT Punching cylinder with battery PG 9861E

Code	Description	Quantity
9070E	Cylinder	1
9192	Punch Ø 15,5	1
9206	Punch Ø 18,5	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9222	Punch Ø 28,5	1
9224	Punch Ø 30,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9829	Case	1
9843	Battery charger 18 V	1

Kit Punching cylinder with battery ISO 9862E

Code	Description	Quantity
9070E	Cylinder	1
9202	Punch Ø 16,2	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9216	Punch Ø 25,5	1
9228	Punch Ø 32,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9603	Pin Ø 16	1
9829	Case	1
9843	Battery charger 18 V	1

Kit Punching Cylinder GAS 9863E

Code	Description	Quantity
9070E	Cylinder	1
9204	Punch Ø 17	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9214	Punch Ø 24	1
9218	Punch Ø 26,5	1
9224	Punch Ø 30,5	1
9180	Drill for pre-hole	1
9601	Pin Ø 9	1
9602	Pin Ø 11	1
9829	Case	1
9843	Battery charger 18 V	1

9022
Perforation cylinder

For punching metals, inox, aluminium, masonite, plastic laminates panels and sheets

This is a hydraulic cylinder with simple acting made of high quality steel, which ensures maximum efficiency and constant results.
It is used in combination with pumps and all our MULTIFOR control units. It works with its relative punches to make holes in sheet metal, aluminium, masonite and plastic laminates.
This tool can use punches from Ø 13 to Ø 170 mm; square punches from □ 12 to dia. □ 145 mm and rectangular punches of equal dimensions.
This tool can punch sheet metal max. thickness 2,5 mm; stainless steel max.2 mm; aluminium and plastic laminates 5 mm.
It is equipped with male rapid connector ready to be used.

Characteristics	
Power	130 kN
Max. Working pressure	700 bar
Max. Stroke	30 mm
Oil capacity for full stroke	0,080lt.
Lenght	200 mm
Diameter	70 mm
Weight	2,9 Kg

External diameter in mm GAS, PG and ISO

GAS thread	Ø ext. GAS thread	Recomm. punch
1/4”	13,15	-
3/8”	16,66	17
1/2”	20,9	21
5/8”	22,9	24
3/4”	26,44	26,5
1”	33,24	33,5
1 1/4”	41,9	42,5
1 1/2”	47,8	48,5
2”	59,62	60,5
2 1/2”	75,18	76
3”	87,8	90
4”	112,5	113

PG thread	Ø ext. PG thread	Recomm. punch
7	12,5	13
9	15,2	15,5
11	18,5	18,5
13,5	20,4	21
16	22,5	22,5
21	28,3	28,5
29	37	37
36	47	47
42	53,9	54,2
48	59,3	59,5

ISO thread	Ø ext. ISO thread	Recomm. punch
16	16	16,2
20	20	21
25	25	25,5
32	32	32,5
40	40	40,5
50	50	50,5
63	63	65

ROUND PUNCHES PAG.47-48 SQUARE PUNCHES PAG. 49 RECTANGULAR PUNCHES PAG. 50 POWER UNITS PAGE 80÷87

9180
Drill for pre-hole

This special drill has been realized to carry out the pre-holes. It has to be installed on portable drilling machines with little chucks and it has a special cutting angle to soften and decrease the cutting strength avoiding strokes. The use is very easy. This drill has 3 working measures; one for the starting hole Ø 6.4; one for the pre-hole Ø 12 and one for the pre-hole Ø 17.
Chuck socket Ø 12.
Only one drill for two processing.

9022/18Ton
Perforation cylinder

It has the same features and the same use of the cylinder 9022 but it has a bigger power and stroke. This tool can punch bigger thicknesses and it realizes special works as for example, holes for drawing.

It is equipped with male rapid connector ready to be used.

Please contact our IMB Technical Department for any question.

Characteristics	
Power	180 kN
Max. Working pressure	700 bar
Max. Stroke	40 mm
Oil capacity for full stroke	0,110lt.
Lenght	265 mm
Diameter	92 mm
Weight	7,5 Kg

Round pins for 9022/18 Ton

They are composed by a special pin and a lock nut. This lock nut is screwed over the punch in order to lighten the strain of the punch.
They are suited for HD punches only.

Code	Ø mm	Ø pare-hole
9610/11	11	13
9610/16	16	12
9610/27	27	27,5

ROUND PUNCHES PAG.47-48 SQUARE PUNCHES PAG. 49 RECTANGULAR PUNCHES PAG. 50 POWER UNITS PAGE 80÷87

Manual punching kit

9853
Manual kit ISO

On request manual pins and punches of different diameters can be supplied.
The kit is equipped with a special pawl wrench to facilitate the punching operation.

Code	Description	Quantity
9202	Punch Ø 16,2	1
9210	Punch Ø 21	1
9212	Punch Ø 22,5	1
9216	Punch Ø 25,5	1
9228	Punch Ø 32,5	1
9642	Manual pins Ø 9	1
9643	Manual pins Ø 11	1
9644	Manual pins Ø 16	1
9180	Drill Ø 12 and Ø 17	1
9870	Pawl wrench with 2 bushes	1
9826	Case	1

Manual pins

For small needs or where it is impossible to use Multifor pumps, manual pins are available.
With the help of a wrench, they can punch thickness max. 1,5 mm.
These pins are suggested until a Ø 50,5 mm max.

Code	Ø mm	Ø pre-hole
9642	9	10
9643	11	12
9644	16	17

Punch with handle for thin sheets and down pipes

9570 Punch Ø 79

9572 Punch Ø 98

9875 Wrench

Standard round pins

Round punches use pins in the list. It is essential that the pre-hole is increased by about 1 mm.

Code	Ø mm	Ø Pre-hole
9601	9	10
9602	11	12
9603	16	17

Standard round punches

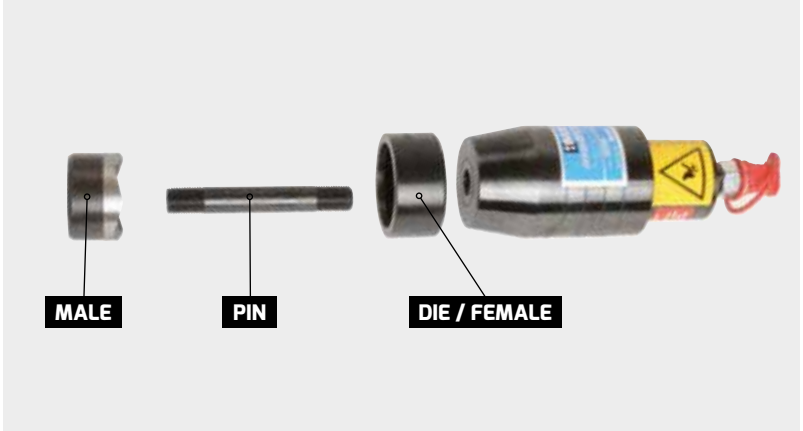
These round punches are made of special tempered steel. They have cutting edges with 3 or 4 bits and they can realize holes in sheet steel from 0, 5 to 2 mm. max.- in stainless steel from 0,5 to 1,8 mm max - in aluminium, plastic laminates or other material from 0,5 to 5 mm.

For greater material thickness, recommend to use our HD series.

The holes are built with the maximum precision and without bucking; all punches are stamped with its nominal Ø for an easy selection and to avoid mistakes during the use.

Male and female spares are available. It is sufficient to add to the code "M "or "F".

Please contact our Technical Department for thicker material.



Code	Ø punch	Ø pin	Ø pre-hole	Male spare	Suitable with			
					9022	9022/18ton	9070	9070E
9200	13	9	10	9200M	✓	×	✓	✓
9192	15,5	9	10	9192M	✓	×	✓	✓
9202	16,2	9	10	9202M	✓	×	✓	✓
9204	17	9	10	9204M	✓	×	✓	✓
9206	18,5	11	12	9206M	✓	×	✓	✓
9208	19,5	11	12	9208M	✓	×	✓	✓
9210	21	11	12	9210M	✓	×	✓	✓
9212	22,5	11	12	9212M	✓	×	✓	✓
9214	24	11	12	9214M	✓	×	✓	✓
9216	25,5	11	12	9216M	✓	×	✓	✓
9218	26,5	11	12	9218M	✓	×	✓	✓
9220	27,5	11	12	9220M	✓	×	✓	✓
9222	28,5	11	12	9222M	✓	×	✓	✓
9224	30,5	11	12	9224M	✓	×	✓	✓
9226	30,5	16	17	9226M	✓	×	✓	✓
9228	32,5	16	17	9228M	✓	×	✓	✓
9230	33,5	16	17	9230M	✓	×	✓	✓
9232	35,5	16	17	9232M	✓	×	✓	✓
9194	37	16	17	9194M	✓	×	✓	✓
9234	38,5	16	17	9234M	✓	×	✓	✓
9236	40,5	16	17	9236M	✓	×	✓	✓
9238	42,5	16	17	9238M	✓	×	✓	✓
9240	45,5	16	17	9240M	✓	×	✓	✓
9196	47	16	17	9196M	✓	×	✓	✓
9242	48,5	16	17	9242M	✓	×	✓	✓
9244	50,5	16	17	9244M	✓	×	✓	✓
9246	52,5	16	17	9246M	✓	×	✓	✓
9248	54,2	16	17	9248M	✓	×	✓	✓
9250	55,5	16	17	9250M	✓	×	✓	✓
9252	57,5	16	17	9252M	✓	×	✓	✓
9198	59,5	16	17	9198M	✓	×	✓	✓
9254	60,5	16	17	9254M	✓	×	✓	✓
9256	62,5	16	17	9256M	✓	×	✓	✓
9258	65	16	17	9258M	✓	×	✓	✓
9260	68	16	17	9260M	✓	×	✓	✓
9262	70,5	16	17	9262M	✓	×	✓	✓
9264	72,5	16	17	9264M	✓	×	✓	✓

* The dimensions of the punches are suitable for our standard max. thickness. The possibility is reduced with different material and thickness.

Round HD punches

These punches have the same characteristics of our standard ones. These have the passer-by hole and not threaded, in order to lighten the strain of the punch. They are used with their pins and they make holes on the sheet steel from 0,5 to 2,5 mm max. and on stainless steel 2 mm max.

Male and female spares are availabe. It is sufficient to add the code "M" and "F". Please contact our IMB Technical Department for thicker material.

Code	Ø punch	Ø pin	Ø pre-hole	Male spare	Suitable with			
					9022	9022/ 18ton	9070	9070E
9201	13	9	10	9201M	✓	×	✓	✓
9193	15,5	9	10	9193M	✓	×	✓	✓
9203	16,2	9	10	9203M	✓	×	✓	✓
9205	17	9	10	9205M	✓	×	✓	✓
9207	18,5	11	12	9207M	✓	✓	✓	✓
9209	19,5	11	12	9209M	✓	✓	✓	✓
9211	21	11	12	9211M	✓	✓	✓	✓
9213	22,5	11	12	9213M	✓	✓	✓	✓
9215	24	11	12	9215M	✓	✓	✓	✓
9217	25,5	11	12	9217M	✓	✓	✓	✓
9219	26,5	11	12	9219M	✓	✓	✓	✓
9221	27,5	11	12	9221M	✓	✓	✓	✓
9223	28,5	11	12	9223M	✓	✓	✓	✓
9225	30,5	11	12	9225M	✓	✓	✓	✓
9227	30,5	16	17	9227M	✓	✓	✓	✓
9229	32,5	16	17	9229M	✓	✓	✓	✓
9231	33,5	16	17	9231M	✓	✓	✓	✓
9233	35,5	16	17	9233M	✓	✓	✓	✓
9195	37	16	17	9195M	✓	✓	✓	✓
9235	38,5	16	17	9235M	✓	✓	✓	✓
9237	40,5	16	17	9237M	✓	✓	✓	✓
9239	42,5	16	17	9239M	✓	✓	✓	✓
9241	45,5	16	17	9241M	✓	✓	✓	✓
9197	47	16	17	9197M	✓	✓	✓	✓
9243	48,5	16	17	9243M	✓	✓	✓	✓
9245	50,5	16	17	9245M	✓	✓	✓	✓
9247	52,5	16	17	9247M	✓	✓	✓	✓
9249	54,2	16	17	9249M	✓	✓	✓	✓

Code	Ø punch	Ø pin	Ø pre-hole	Male spare	Suitable with			
					9022	9022/ 18ton	9070	9070E
9251	55,5	16	17	9251M	✓	✓	✓	✓
9253	57,5	16	17	9253M	✓	✓	✓	✓
9199	59,5	16	17	9199M	✓	✓	✓	✓
9255	60,5	16	17	9255M	✓	✓	✓	✓
9257	62,5	16	17	9257M	✓	✓	✓	✓
9259	65	16	17	9259M	✓	✓	✓	✓
9261	68	16	17	9261M	✓	✓	✓	✓
9263	70,5	16	17	9263M	✓	✓	✓	✓
9265	72,5	16	17	9265M	✓	✓	✓	✓
9266	76	27	27,5	9266M	✓	✓	×	✓
9268	78	27	27,5	9268M	✓	✓	×	✓
9270	80,5	27	27,5	9270M	✓	✓	×	✓
9272	82	27	27,5	9272M	✓	✓	×	✓
9274	87	27	27,5	9274M	✓	✓	×	✓
9276	90	27	27,5	9276M	✓	✓	×	✓
9278	92	27	27,5	9278M	✓	✓	×	✓
9280	96	27	27,5	9280M	✓	✓	×	✓
9282	100,5	27	27,5	9282M	✓	✓	×	✓
9284	103	27	27,5	9284M	✓	✓	×	✓
9286	105	27	27,5	9286M	✓	✓	×	✓
9288	113	27	27,5	9288M	✓	✓	×	✓
9290	116	27	27,5	9290M	✓	✓	×	✓
9291	120	27	27,5	9291M	✓	✓	×	✓
9292	134	27	27,5	9292M	✓	✓	×	×
9293	140	27	27,5	9293M	✓	✓	×	×
9294	145	27	27,5	9294M	✓	✓	×	×
9295	160	27	27,5	9295M	✓	✓	×	×
9296	170	27	27,5	9296M	✓	✓	×	×

*The dimensions of the punches are suitable for our standard max. thickness. The possibility is reduced with different material and thickness.

Round pins for HD punches

They are composed by a threaded pin and lock nut, which is screwed over the HD punch in order to lighten the strain of the punch

Code	Ø mm	Ø pre-hole
9611	9	10
9612	11	12
9613	16	17
9614	27	27,5

Square punches

These punches have a special feature on male parts as they have four cutting edges on the mid points.
This patented technical innovation allows a better self-centring, a faster perforation with less strain. This is a guarantee for the tool life.
These punches realize holes on sheet of stainless steel from 0, 5 to 2,0 mm max. and on aluminium, laminated plastics or other sheet materials from 0,5 to 5 mm

Please contact our Technical Department for thicker material.

Code	Punch size	Pin size	Ø pre-hole	Suitable with			
				9022	9022/ 18ton	9070	9070E
9302	12x12	8x8	11	✓	×	✓	✓
9304	18x18	10x10	15	✓	×	✓	✓
9306	19x19	10x10	15	✓	×	✓	✓
9308	20x20	10x10	15	✓	×	✓	✓
9309	22x22	10x10	15	✓	×	✓	✓
9310	25x25	14x14	19,5	✓	✓	✓	✓
9312	26x26	14x14	19,5	✓	✓	✓	✓
9314	30x30	14x14	19,5	✓	✓	✓	✓
9316	35x35	14x14	19,5	✓	✓	✓	✓
9318	40x40	14x14	19,5	✓	✓	✓	✓
9320	45x45	14x14	19,5	✓	✓	✓	✓
9322	46x46	14x14	19,5	✓	✓	✓	✓
9324	48,5x48,5	20x20	27,5	✓	✓	✓	✓

Code	Punch size	Pin size	Ø pre-hole	Suitable with			
				9022	9022/ 18ton	9070	9070E
9326	50x50	20x20	27,5	✓	✓	✓	✓
9328	55x55	20x20	27,5	✓	✓	✓	✓
9330	57x57	20x20	27,5	✓	✓	✓	✓
9332	60,5x60,5	20x20	27,5	✓	✓	✓	✓
9334	68x68	20x20	27,5	✓	✓	✓	✓
9336	80,5x80,5	20x20	27,5	✓	✓	×	✓
9338	90,5x90,5	20x20	27,5	✓	✓	×	✓
9340	92x92	20x20	27,5	✓	✓	×	✓
9342	96x96	20x20	27,5	✓	✓	×	×
9344	112x112	22x22	28,5	✓	✓	×	×
9346	126x126	22x22	28,5	✓	✓	×	×
9348	138x138	22x22	28,5	✓	✓	×	×
9350	145x145	22x22	28,5	✓	✓	×	×

* The dimensions of the punches are suitable for our standard max. thickness. The possibility is reduced with different material and thickness.

Pins for square punches

Please use square pins for square punches (see the list).
It is essential to do the pre-hole indicated.

Code	Pin size	Ø pre-hole
9621	6x6	9
9622	8x8	11
9623	10x10	15
9624	12x12	17
9625	14x14	19,5
9626	20x20	27,5
9627	22x22	28,5

Pins for square punches 9022/18Ton

Code	Pin size	Ø pre-hole
9620/14	14x14	19,5
9620/20	20x20	27,5
9620/22	22x22	28,5

Rectangular punches

These punches have a special feature on male part as they have four cutting edges on the mid points.
This patented technical innovation allows a better self-centring, a faster perforation with less strain. This is a guarantee for the tool life.
These punches realize holes on sheet of stainless steel from 0, 5 to 2,0 mm max. and on aluminium, laminated plastics or other sheet materials from 0,5 to 5 mm.

Please contact our Technical Department for thicker material.

Code	Punch size	Pin size	Ø pre-hole	Suitable with			
				9022	9022/18ton	9070	9070E
9405	17,5x33,5	10x10	15	✓	×	✓	✓
9410	20x41	10x10	15	✓	×	✓	✓
9412	22x30	10x10	15	✓	×	✓	✓
9411	22x42	10x10	15	✓	×	✓	✓
9414	22x46	10x10	15	✓	×	✓	✓
9417	24x36	14x14	19,5	✓	✓	✓	✓
94/29x71	29x71	20x20	27,5	✓	✓	✓	✓
9421	30x45	20x20	27,5	✓	✓	✓	✓
9425	34x68	20x20	27,5	✓	✓	✓	✓
9428	36x46	20x20	27,5	✓	✓	✓	✓
9431	36x85	20x20	27,5	✓	✓	×	✓
9433	36x52	20x20	27,5	✓	✓	✓	✓
9434	36x112	20x20	27,5	✓	✓	×	✓
9443	44x92	20x20	27,5	✓	✓	×	✓
9452	45x93	20x20	27,5	✓	✓	×	✓
9450	46x53,5	20x20	27,5	✓	✓	✓	✓
9451	46x71	20x20	27,5	✓	✓	✓	✓
9459	50x98	20x20	27,5	✓	✓	×	✓
9478	68x138	22x22	28,5	✓	✓	×	×
9485	81x117	22x22	28,5	✓	✓	×	×

*The dimensions of the punches are suitable for our standard max. thickness. The possibility is reduced with different material and thickness.

Pins with reference mark for rectangular punches

Rectangular punches use square pins with a reference mark to avoid punch positioning mistakes.

Code	Lato x lato	Ø preforo
9631	6x6	9
9632	8x8	11
9633	10x10	15
9634	12x12	17
9635	14x14	19,5
9636	20x20	27,5
9637	22x22	28,5

Pins with reference mark for rectangular punches 9022/18Ton

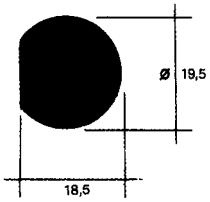
Code	Pin size	Ø pre-hole
9620/14R	14x14	19,5
9620/20R	20x20	27,5
9620/22R	22x22	28,5

Special and shaped punches

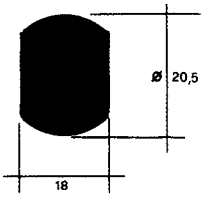
We have built special punches for mounting handles, locks and push buttons.
These punches can be used with our perforation cylinder 9022, with the manual puncher 9070 and with the electric puncher 9070E.

Code	Description	Pin	Pin type
9552	for 19,5 mm locks	10x10	**9633**
9554	for 20,5 mm locks	10x10	**9633**
9556	for 22,5 mm locks	10x10	**9633**
9557	for 22,5 mm locks	10x10	**9623**
9558	for 21,5 mm handle	10x10	**9633**
9559	for 22,5 mm handle	10x10	**9633**
9560	for 22,5 mm push button	10x10	**9633**
9561	for 22,5 mm handle	10x10	**9633**
9562	for 30,5 mm push button	14x14	**9635**
9564	with cave 22,3	10x10	**9633**
9565	with cave 30,5	14x14	**9635**
9566	for 16A CEE sockets	20x20	**9636**
9568	for 32A CEE sockets	20x20	**9636**

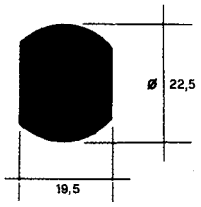
9552



9554



9556



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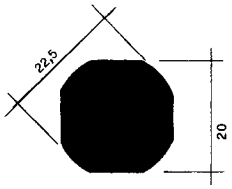

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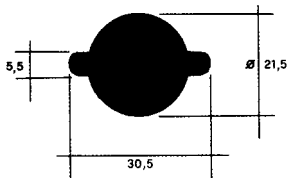

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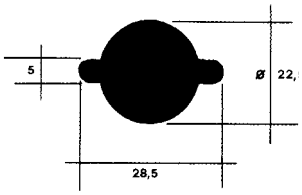

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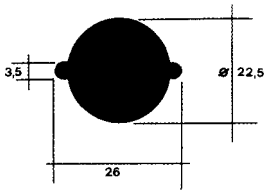

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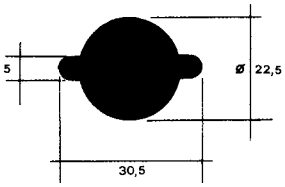
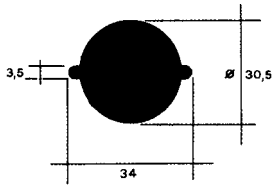
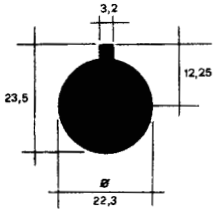


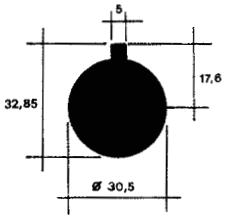
9562



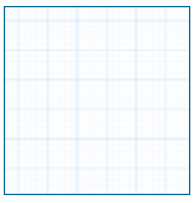
9564



9565



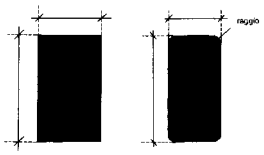
Sizes on request



Special rectangular punches

We designed with the same features of the standard punches, special punches but with bevelled or with radius corners in most of the common sizes. When ordering, it is important to specify the material and the thickness to punch.

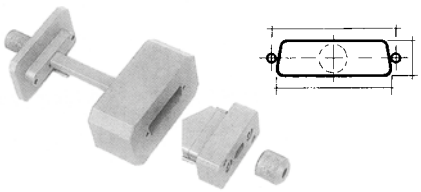
Code	Description	Pin size	Ø pre-hole
9495	70,5x117,5 with bevel L=15	20x20	27,5
9496	40x90 R=4 with radius	20x20	27,5
9497	51x118 R=4 with radius	20x20	27,5
9499	107x119 R=4 with radius	20x20	28,5

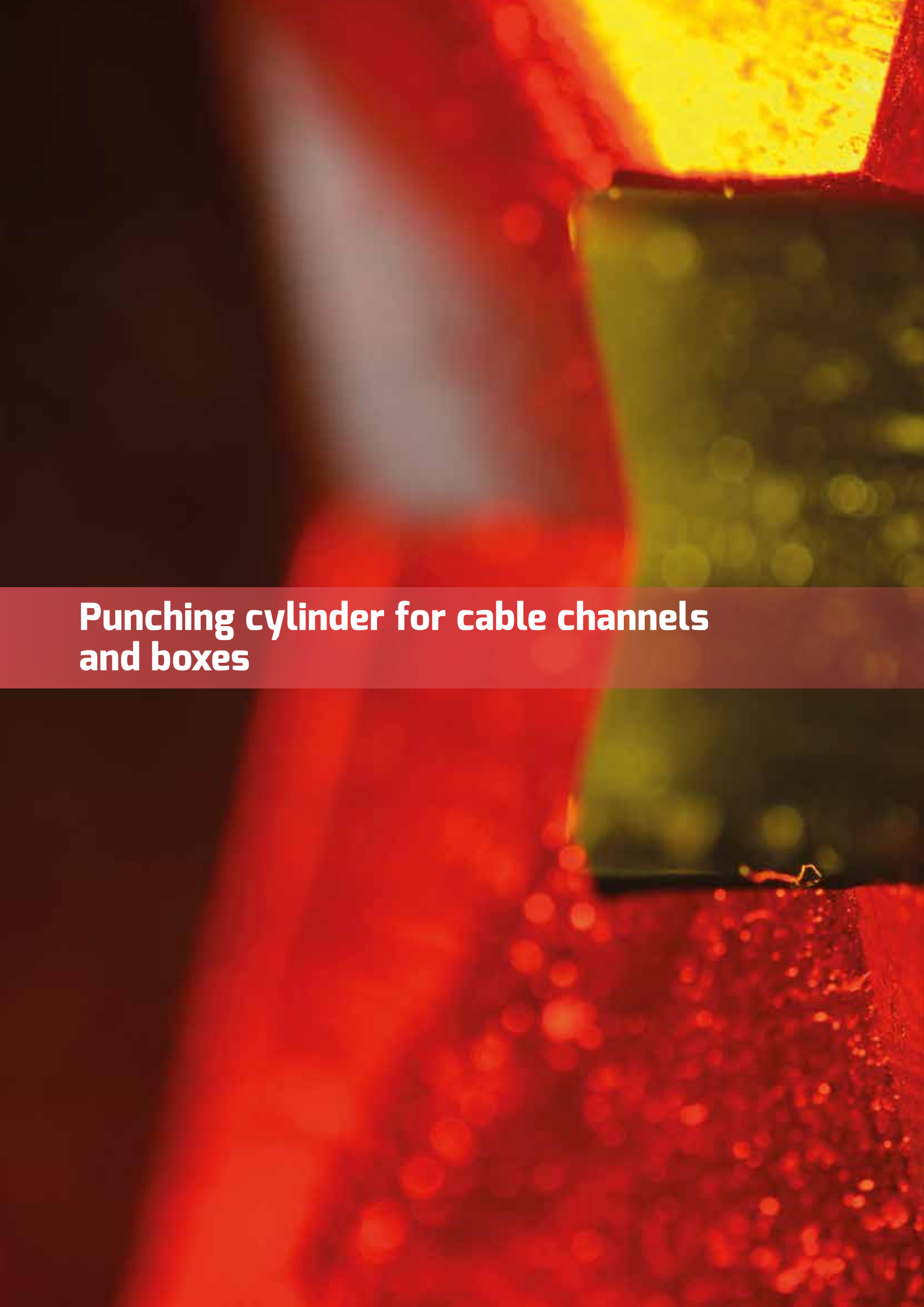


Punches for D-Sub connectors

Pin for cylinder 9022 -code 9648
Manual pin - code 9649
Pre-hole Ø 13

Positions	Code
9	**9574**
15	**9576**
25	**9578**





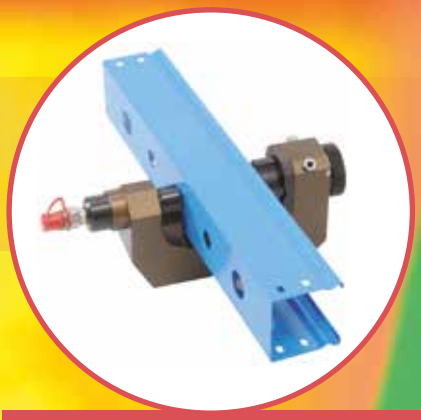
Punching cylinder for cable channels and boxes

TECHNICAL APPLICATION

EXAMPLE OF PUNCHED BOX

EXAMPLE OF A SPECIAL WORKING

WORKING ON PROFILES
FOR ALUMINIUM



PUNCHING ON THE BOTTOM
OF THE CHANNEL ART. 7060-1-2

PUNCHING WORKING

EXAMPLE OF BAR WITH RADIUS

7001
Manual punching cylinder for cable channels

Patented Model

Technical Characteristics	
Power	28 kN
Max. hole	41 mm
Internal depth	50 mm
External depth	25 mm
Max. thickness steel	1,2 mm
Stroke	16 mm
Weight	3,8 Kg
Rotating head	290°

Kit

It is a reliable and practical tool for punching cable channels in steel and plastic sheets without pre-hole.
It is composed by an hydraulic manual pump with incorporated cylinder. Light and easily handled. Designed for punching the edges of cable channels with max. thickness 1,2 mm. and maximum Ø 41 mm.
A special punch can be installed to make holes on the extremities of cable channels for junctions, without tracing wheelbases (7040).
Please specify the trademark of the cable channel when ordering.
It can punch several types of metal sheet.

It is equipped with a plastic case.

On request, we can design special punches for stainless steel channels.

We make punches for clinching on demand.

7002
Hydraulic punching cylinder for cable channels

It is a reliable and practical tool for punching cable channels in steel and plastic sheets without pre-hole.
It is composed by an hydraulic cylinder which works connected to our power units. Light and easily handled. It has been designed for punching the edges of cable channels with max. thickness 1,2 mm. and maximum Ø 41 mm.
It is possible to install a special punch in order to do holes on the extremity of cable channels for junctions, without tracing wheelbases (7040).
On request, we can realize special punches for stainless steel channels.

POWER UNITS PAGES 80÷87

Characteristics	
Power	34 kN
Max.hole	41 mm
Internal depht.	50 mm
External depht	25 mm
Max. thickness steel	1,2 mm
Weight	3 Kg
Stroke	16 mm

7009
Punching cylinder for cable channels with battery

It is a reliable and practical tool for punching cable channels in steel and plastic sheets without pre-hole. It is composed by an hydraulic pump supllied with an indipendent battery. Light and easily handled. It has been studied for punching the edges of cable channels with max. thickness 1,2 mm. and maximum Ø 41 mm.
A special punch can be installed to make holes on the extremities of cable channels for junctions, without tracing wheelbases (7040).
It can punch different types of metal sheets.

It is equipped with a plastic case and a battery charger code 9843

On request, it is possible to make special punches for stainless steel.

Characteristics	
Power	32 kN
Max. hole	41 mm
Internal depht	50 mm
External depht	25 mm
Max. thickness steel	1,2 mm
Stroke	16 mm
Weight	5 Kg
Rotating head	325°
Autonomy	about 140 punching

Accessories

9829
Case for punching cylinders with battery

7099
Adapter / Punch holder

9843
Battery charger 18 V (recharge 1 h.)

9841
Rechargeable battery 18 V.

9825
Case for manual punching cylinders

Punching cylinder for bottom channels

It is a tool designed for punching the bottom cable channels and edges of particular boxes.
It can also punch sheet in aluminium and plastic.
Principal characteristic, it is the possibility of punching without pre-hole.
It is built in light alloy; it is handy and the introduction of the cable channel is very simple.

The metal tube carrying the dies is sliding in order to facilitate the placement in channels already mounted.
With a simple manual operation, one takes the die on the part to punch, reducing the punching time in few seconds.

7060

It works with a pump with battery 18V CC.
The rotating cylinder is included.
Weight 7 Kg.

Characteristics	
Power	28 kN
Stroke	16 mm
Max.hole	ø 33,5 mm
Max.thickness steel	1,2 mm
Internal depth	50 mm
External depth	35 mm
Total depht	85 mm

7061

Manual tool, it works with a pump. The rotating cylinder is included.
Weight Kg. 5,2

Characteristics	
Power	28 kN
Stroke	16 mm
Max. hole	ø 33,5 mm
Max. thickness steel	1,2 mm
Internal depth	50 mm
External depth	35 mm
Total depht	85 mm

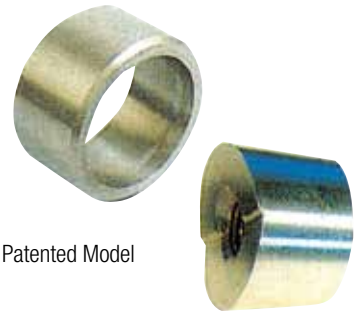
7062

It is composed by an oleodynamic cylinder, which can operate with all our power units: foot pedal, pneumatic pump or electric unit.
Weight kg. 4,8

Characteristics	
Power	28 kN
Stroke	16 mm
Max. hole	ø 33,5 mm
Max. thickness steel	1,2 mm
Internal depth	50 mm
External depth	35 mm
Total depht	85 mm

POWER UNITS PAG 80÷87

Round punches for punching cylinders for cable channels



Patented Model

Round Punches

Code	Ø	Type of punch	Die dischage
7010/13	13	Direct	Direct
7010/15,5	15,5	Direct	Direct
7011	16,5	Adapter	Direct
7012	17	Adapter	Direct
7013	18,5	Adapter	Direct
7014	19,5	Adapter	Direct
7015	21	Adapter	Direct
7016	22,5	Adapter	Direct
7017	24	Adapter	Direct
7018	25,5	Adapter	Direct
7019	26,5	Adapter	Direct
7020	27,5	Adapter	Direct
7021	28,5	Adapter	Direct
7022	30,5	Adapter	Direct
7023	32,5	Adapter	Direct
7024	33,5	Adapter	Direct
7010/37	37	Adapter	Direct
7010/41	41	Adapter	Front assembly

GAS Channel puncher kit - 7003 Battery - 7003E

Code	Description	Quantity
7001/9	Channel Puncher	1
7012	Punch Ø 17	1
7015	Punch Ø 21	1
7019	Punch Ø 26,5	1
7024	Punch Ø 33,5	1
9825/9	Case	1

PG Channel puncher kit - 7004 Battery - 7004E

Code	Description	Quantity
7001/9	Channel Puncher	1
7013	Punch Ø 18,5	1
7015	Punch Ø 21	1
7016	Punch Ø 22,5	1
7021	Punch Ø 28,5	1
9825/9	Case	1

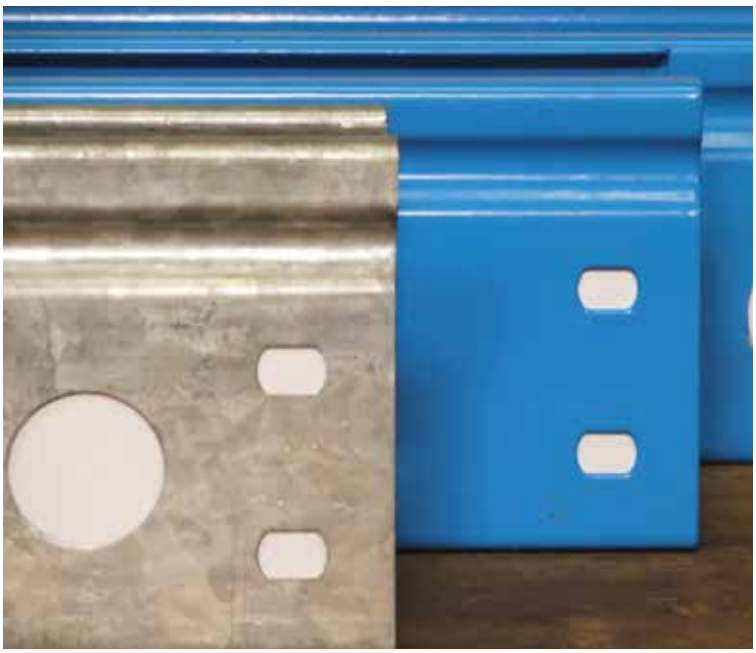
ISO Channel puncher kit - 7005 Battery - 7005E

Code	Description	Quantity
7001/9	Channel Puncher	1
7011	Punch Ø 16,5	1
7015	Punch Ø 21	1
7016	Punch Ø 22,5	1
7018	Punch Ø 25,5	1
7023	Punch Ø 32,5	1
9825/9	Case	1

On demand, we realise punches for clinching process. Please contact our Technical Department for special requests.

Special punch for double oval holes for channel junctions. 7040

With this special punch 7040 , it is possible to realize oval holes for channel junctions.
The die has a reference in oder to punch with the standard interaxis. Its performance is the faster as the one of standard punches.
It doesn't leave any burrs on the cable channels.
This punch 7040 can be used on all our standard heads 7000



Punching cylinders for boxes

Portable and rapid tool,without pre-hole

7050

It is a handy and rapid tool, particularly indicated for the punching of plastic boxes with internal ribbing.
It doesn't need the pre-hole and the extraction of the punch is easy. It is composed by a hydraulic system. It is equipped with a particularly head realized to enter in the little spaces between the ribbing.
It is used in workshops or on-site.
Patented Model

Technical Characteristics	
Power	28 kN
Weight	3,7 Kg
Head rotation	290°
Internal depth	50 mm
Round hole max	Ø 32,5 mm
Thickness sheet max.	1,2 mm
Thickness plastic max.	3 mm

7051

It is a handy and rapid tool, particularly indicated for the punching of plastic boxes with internal ribbing.
It doesn't need the pre-hole and the extraction of the punch is easy. It is composed by a hydraulic system which works with any of our power units.
It is equipped with a particularly head realized to enter in the little spaces between the ribbing.
It is used in workshops or on-site.
Patented Model

Characteristics	
Power	34 kN
Weight	3,2 Kg
Head rotation	360°
Internal depth	50 mm
Round hole max	Ø 32,5 mm
Thickness sheet max.	1,2 mm
Thickness plastic max.	3 mm

POWER UNITS PAG. 80÷87

7052

It is a handy and rapid tool, particularly indicated for the punching of plastic boxes with internal ribbing.
It doesn't need the pre-hole and the extraction of the punch is easy. It is composed by a hydraulic system which works with a battery 18 V.
It is equipped with a particularly head realized to enter in the little spaces between the ribbing.
It is used in workshops or on-site.
Patented Model

Characteristics	
Power	32 kN
Weight	4,9 Kg
Head rotation	325°
Internal depth	50 mm
Round hole max	Ø 32,5 mm
Thickness sheet max.	1,2 mm
Thickness plastic max.	3 mm

7053
Punching cylinder for boxes

With adjustments for positioning

It has the same characteristics of the other punching cylinders for boxes, but this tool has the rulers with sliders for repetitive working. These rulers simplify the work.

It can be used also without adjustments

It is an easy tool for punching in particularly uncomfortable positions. It can be used also for cable channels, panels, panel boards already in operation. It is very easy to disassemble the brackets.

Characteristics	
Power	34 kN
Weight	3,2 Kg
Head rotating	360°
Internal depth	50 mm
Round hole max.	Ø 32,5 mm
Plastic thickness max.	3 mm
Adjustment	min. 33 mm, max 300 mm

POWER UNITS PAG. 80÷87

Punches and kit

Kit manual puncher for boxes ISO - 7006

Code	Description	Quantity
7050	Puncher	1
7299/16,5	Punch Ø 16,5	1
7299/20,5	Punch Ø 20,5	1
7299/22,5	Punch Ø 22,5	1
7299/25,2	Punch Ø 25,2	1
9825	Case	1

Kit puncher for boxes with battery ISO - 7006E

Code	Description	Quantity
7052	Puncher	1
7299/16,5	Punch Ø 16,5	1
7299/20,5	Punch Ø 20,5	1
7299/22,5	Punch Ø 22,5	1
7299/25,2	Punch Ø 25,2	1
9829	Case	1

Kit puncher for boxes with adjustments ISO - 7007

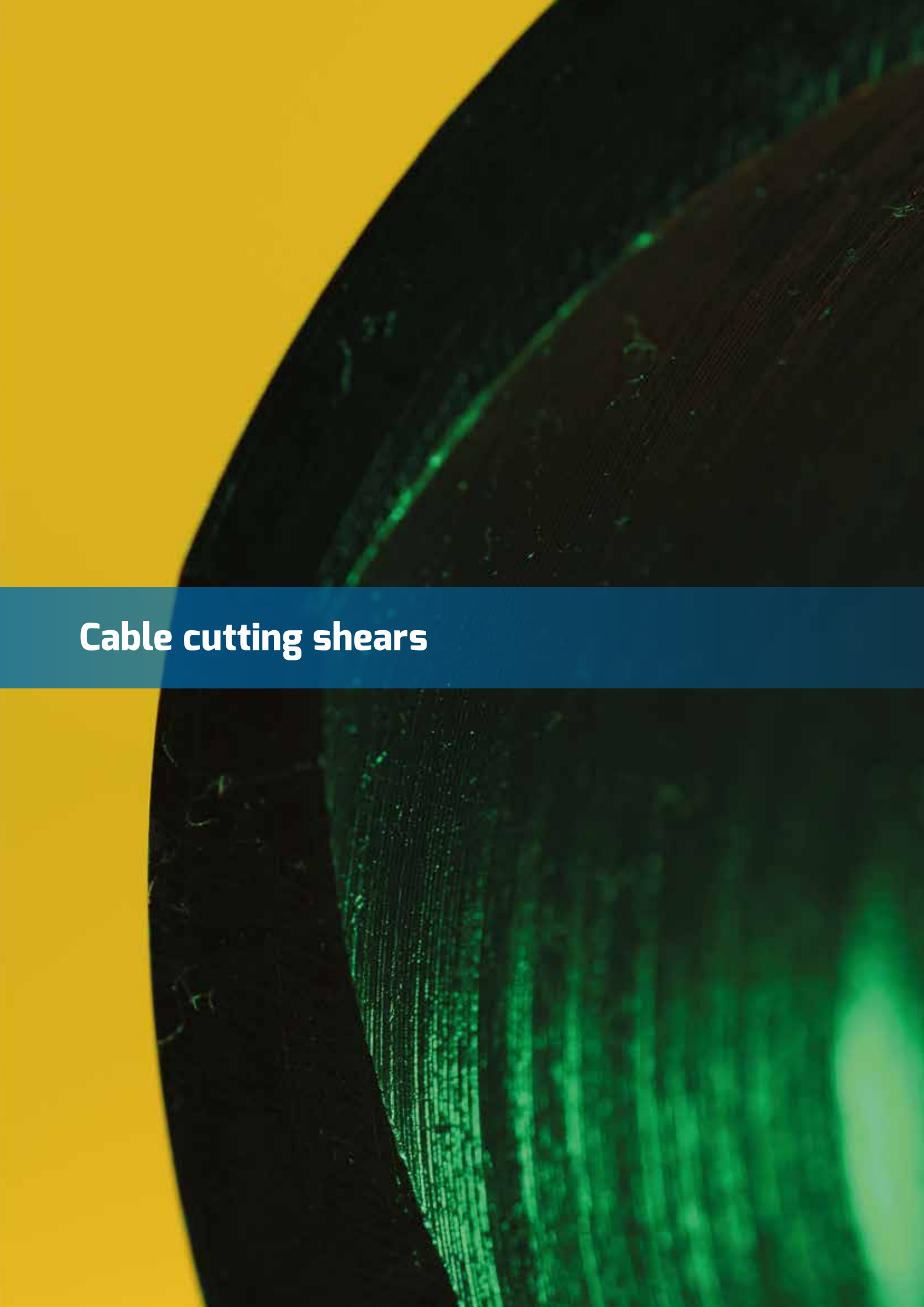
Code	Description	Quantity
7053	Puncher	1
7299/16,5	Punch Ø 16,5	1
7299/20,5	Punch Ø 20,5	1
7299/22,5	Punch Ø 22,5	1
7299/25,2	Punch Ø 25,2	1

Punches for punching cylinder for boxes

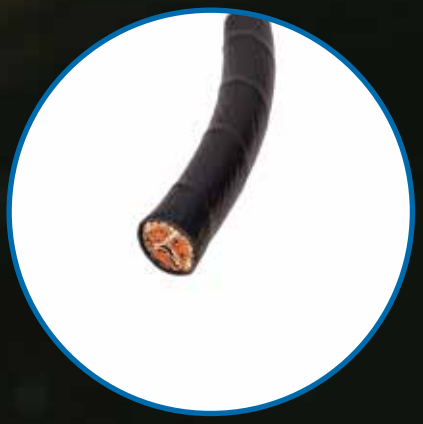
Code	Ø Diameter
7299/13	13
7299/15,5	15,5
7299/16,5	16,5
7299/18,5	18,5
7299/20,5	20,5
7299/22,5	22,5
7299/25,2	25,5
7299/26,5	26,5
7299/28,5	28,5
7299/32,5	32,5

Please contact our Technical Department for other diameters.

Cable cutting shears



TECHNICAL APPLICATION



Cable cutting shears

Copper and aluminium until Ø 95 mm.

The cable cutting shears are hydraulically operated tools for cutting copper and aluminium cables of different sizes or compositions, plain or insulated with PVC covering up to 800-mmq section.

These tools are also availble with insulated version with grounding cable.
All the cable cutting shears are equipped with protection carter.

9030

The 9030 cable cutting shears works with the **cylinder 9022** and with all our power units.
It is sufficient to screw well its pin on the cylinder before starting to work.

Characteristics	
Lenght	410 mm
Width	150 mm
Cable	Ø from 10 to 48 mm
Weight with cylinder	5,2 Kg
Power	80 kN
Max. working pressure	650÷700 bar
Oil capacity for a complete stroke	0,080 lt.

9032

The cable cutting shears 9032 cuts cables until Ø 48 mm.
Thanks to its rapid connector, it works with all our power units.
It is equipped with a clear protection carter which allows to see the working area.
It is handy thanks to its light weight.

Characteristics	
Lenght	300 mm
Width	150 mm
Cable	Ø from 10 to 48 mm
Weight	5,2 Kg
Power	80 kN
Max. working pressure	650÷700 bar
Oil capacity for a complete stroke	0,050 lt.

9034

The cable cutting shears 9034 cuts cables until Ø 95 mm.
Thanks to its rapid connector, it works with all our power units.
It is equipped with a clear protection carter which allows to see the working area.
The transport is easy thanks to its handle.
This cable is an insulated version with grounding cable.

Characteristics	
Lenght	400 mm
Width	270 mm
Cable	Ø from 30 to 95 mm
Weight	10,1 Kg
Power	150 kN
Max. working pressure	650÷700 bar
Oil capacity for a complete stroke	0,140 lt.
Fornita con cassetta 9823	

9035

The cable cutting shears with battery 9035 cuts cables until Ø 25 mm.
Thanks to its weight and to its balance, it is easy to handle it with a hand.
The battery has an autonomy of about 150 cuts (depending on working conditions).
It is equipped with a plastic case, a battery charger and a battery 18 V 2Ah.
A second battery can be delivered on demand.

Characteristics	
Lenght	300 mm
Width	75 mm
Height	280 mm
Power	55 kN
Weight	3,4 Kg
Cable	Ø 25 mm max
Battery	18V 2.0Ah
Autonomy	about 150 cuts

Cable cutting shears

HIGH QUALITY CABLE CUTTING SHEARS WITH BENDED AND INTERCHANGEABLE BLADES

9980
For copper and aluminium cables up to Ø 20 mm and max. section for connectors 120 mmq.
Lenght 370 mm
Weight 0,650 Kg

9981
For copper and aluminium cables up to Ø 35 mm and max. section for connectors 180 mmq.
Lenght 530 mm
Weight 1,5 Kg

9982
For copper and aluminium cables up to Ø 50 mm and max section for connectors 500 mmq.
Lenght 780 mm
Weight 3,2 Kg.

CABLE CUTTING SHEARS WITH INSULATED HANDLES

9983
For copper and aluminium cables up to Ø 20 mm and max section for connectors 120 mmq.
Lenght 370 mm
Weight 0,750 Kg

9984
For copper and aluminium cables up to Ø 35 and max section for connectors 180 mmq.
Lenght 530 mm
Weight 1,8 Kg

9985
For copper and aluminium cables up to Ø 50 mm and max section for connectors 500 mmq.
Lenght 780 mm
Weight 3,8 Kg

CABLE CUTTING SHEARS WITH FORGED BLADES

9986
It cuts aluminium and copper cables up to Ø 38 mm.
Maximum section 180 mmq.
Weight 0,8 Kg

9987
It cuts aluminium and copper cables up to Ø 45 mm.
Maximum section 240 mmq.
Weight 0,9 Kg

9988
It cuts rigid wire ropes up to Ø14 mm and flexible metal cables up to Ø16 mm.
Weight 0,8 Kg

Crimping tools

TECHNICAL APPLICATION

HEXAGONAL CRIMPING

"V" CRIMPING

HEXAGONAL CRIMPING REALIZED WITH MANUAL TOOL

EXAMPLE OF CRIMPING

EXAMPLE OF CRIMPING

EXAMPLE OF CRIMPING

CRIMPING OF A COPPER BRAID

TUBE TERMINAL CRIMPED WITH A "V" DIE AND PUNCH

SAMPLE OF TOTAL PERMEATION OF CRIMPED ELEMENTS

9028
Manual crimping tool

It is a tool operated with one hand.
Its power, capacity and lightness, make a tool fitted for all type of crimping for copper conductors.
It is equipped with a case.

Characteristics	
Power	35 kN
Capacity	until 120 mm^2
Stroke of the piston	adjustable from 5 to 8 mm
Hydraulic system	with two speeds
Valve	automatic of max. pressure audible with a “click”
Return of the piston	with the help of a discharge lever
Weight	1,5 Kg
Head	with 360° rotation with rapid opening and closing
Dies	interchangeable

9038
Crimping tool with battery

It is a tool operated with one hand.
Light and handy, it has the necessary strengh to crimp cables max.section up to 240 mmq.
It has a relief valve with automatic return when the crimping is completed and a valve for the manual return.
Available on request, “V” dies with semicircular or circular punch.

Characteristics	
Dimensions	285x60x270 mm
Weight	3,15 kg with battery
Power	55kN
Piston stroke	13 mm
Tempo di aggraffatura	3÷5 s
Autonomy	about 220 crimpings (on section 185 mmq)
Max.section cable	240 mmq
Valve for max.pression confirming the right crimping	
Head with rotation at 340° with rapid opening and closing.	
Dies	interchangeable
Equipped complete with a case, 1 battery 18 V-2Ah and battery charger.	

Dies and crimping kit 9028

V Crimping Kit 9867

Code	Description	Quantity
9028	Crimping tool	1
9912	Die 10	1
9913	Die 16	1
9914	Die 25	1
9915	Die 35	1
9916	Die 50	1
9917	Die 70	1
9918	Die 95	1
9919	Die 120	1
9910	Punch	1
9911	Punch	1

Hexagonal crimping Kit 9865

Code	Description	Quantity
9028	Crimping tool	1
***9901**	Die 10	1
***9902**	Die 16	1
9903	Die 25	1
9904	Die 35	1
9905	Die 50	1
9906	Die 70	1
9907	Die 95	1
9908	Die 120	1

* Not included in the kit. Supplied on request.

Hexagonal dies

They are used for the crimping of non-insulated tube terminals and head connectors. Supplied in pair.

Cable section mmq	Die code
10	**9901**
16	**9902**
25	**9903**
35	**9904**
50	**9905**
70	**9906**
95	**9907**
120	**9908**

V dies and punches

These are used for ther crimping of non-insulated tube terminals and head connectors. Supplied separately.

Cable sect. mmq.	Non-insulated		Pre-insulated	
	Code die	Code Punch	Code die	Code Punch
10	**9912**	9910	**9913**	9910
16	**9913**	9910	**9914**	9910
25	**9914**	9910	**9915**	9910
35	**9915**	9911	**9916**	9911
50	**9916**	9911	**9916**	9910
70	**9917**	9911		
95	**9918**	9911		
120	**9919**	9911		

Semicircular dies

These are used for “C” connectors. Supplied in pair.

Cable section mmq.	Die code
6	**9920**
10	**9921**
16-25	**9922**
35	**9923**
50-70	**9924**

DIES FOR 9038

Hexagonal dies

Cable section mmq.	Die code
6 / 35	**9925**
10 / 50	**9926**
16 / 70	**9927**
25 / 95	**9928**
4 / 120	**9929**
150	**9930**
185	**9931**
240	**9932**

On demand, dies for “V” crimping, semi-circular and circular are available.

9026
Manual C crimping tool 130 kN

It is used for the crimping of: Tube terminals and connectors non-insulated section 10-300 mmq.; tube terminals pre-insulated section 10÷120 mmq.; C connectors section 16÷185 mmq

Characteristics	
Weight	5,3 Kg
Power	130 Kn
Lenght	565 mm
Width	160 mm
Thickness	70 mm
Insulated handles	
Rotating head 180 °	
Supplied with case complete with compartment for dies.	

DIES PAG. 69

9025
"C" Crimping head

This hydraulic head works with all our pumps and control units. It is particularly practical with a frontal opening, which allows an easy positioning of the terminal to crimp. As the technical characteristics are similar to other Multifor tools, maximum reliability is assured. It uses dies for crimping terminals and connectors non-insulated with a section from 10 to 300 mmq; dies for crimping tube terminals pre-insulated section 10÷120 mmq; and for "C" connectors section 10÷185 mmq.

Characteristics	
Power	130 kN
Max. Working pressure	700 bars
Stroke	22 mm
Oil capacity for full stroke	0,040 lt.
Lenght	235 mm
Width	140 mm
Thickness	78 mm
Weight	4,5 Kg

POWER UNITS PAG 80÷87

DIES PAG. 69

Dies for the “C” head 9025 - 9026

Hexagonal dies

For the crimping of non- insulated tube terminals and head connectors. They are inserted on the “C” head 9025 “C” and they are manufactured with special steel in order to withstand the heavy load to which they are subjected. The standard impression is hexagonal. They are supplied in pairs

Cable section mmq.	Die code
10	**9771**
16	**9773**
25	**9775**
35	**9777**
50	**9779**
70	**9781**
95	**9783**
120	**9785**
150	**9787**
185	**9800**
240	**9801**

“V” punches and dies

For the crimping of non-insulated tube terminals and head connectors. The punches and dies are supplied separately

Cable section mmq.	Die code	Punch code
10	**9735**	9731
16	**9736**	9731
25	**9737**	9731
35	**9738**	9731
50	**9739**	9732
70	**9740**	9732
95	**9741**	9732
120	**9742**	9733
150	**9743**	9733
185	**9744**	9733
240	**9745**	9734
300	**9746**	9734

Pre-insulated “V” punches and dies

They are used for the crimping of pre-insulated power terminals. Punches and dies are supplied separately

Cable section mmq.	Die code	Punch code
10	**9736**	9731
16	**9737**	9731
25	**9738**	9731
35	**9739**	9732
50	**9740**	9732
70	**9741**	9733
95	**9742**	9733
120	**9743**	9733

Semicircular dies of medium tension

These dies are for circular crimping with automatic cutting of possible burrs.
They are supplied in pairs.

Cable section mmq.	Die code
25-40	9723
50-70	9725
95-120	9727
150-185	9729

Semicircular dies for “C” connectors

They are for the crimping of “C” connectors.
They are supplied in pairs.

Cable section mmq.	Die code
6	**9748**
10	**9749**
16-25	**9753**
35	**9755**
50-70	**9756**
95	**9757**
120-185	**9759**

N.B. The measures vary depending on the type of tube terminal and cable.

“U “ head for the crimping of tube terminals and connectors

9024

This hydrailic head crimps tube terminals on cables from 10 to 400 mmq.
Due to its compact size, the cramping tool is very practical.
It has been realized with high quality steel.
It is used with all our pumps and electric units.

This head with different dies can crimp tube terminals ,”C” connectors, cable joints and shunts.
It is supplied with male rapid connector, ready to use.

Characteristics	
Power kN	200
Max working pression bars	700
Stroke mm	23
Oil capacity for full stroke lt.	0,080
Lenght mm	250
Width Ø mm	90
Weight Kg	5,6

DIES FOR 9024

Hexagonal dies

These dies are for the crimping of: plein tube terminals , plein head connectors.

Cable section mmq.	Die code
10	**9770**
16	**9772**
25	**9774**
35	**9776**
50	**9778**
70	**9780**
95	**9782**
120	**9784**
150	**9786**
185	**9793**
240	**9795**
300	**9797**
400	**9798**

Pre-insulated and plein “V” dies

These dies are for the crimping of plein and pre-insulated tube terminals and head connectors

“V” dies

Cable section mmq.	Die code	Punch code
35	**9706**	9702
50	**9706**	9702
70	**9708**	9704
95	**9708**	9704
120	**9708**	9704
150	**9708**	9704
185	**9710**	9704
240	**9710**	9704
300	**9712**	9704
400	**9712**	9704

Pre-insulated

Cable section mmq.	Die code	Punch code
25	**9706**	9718/9702
35	**9706**	9702
50	**9706**	9702
70	**9708**	9702
95	**9710**	9702
120	**9710**	9704

Semicircular dies of medium tension

These dies are for crimping pre-insulated.

Cable section mmq.	Die code
25-40	**9722**
50-70	**9724**
95-120	**9726**
150-185	**9728**
240-315	**9730**

Semicircular dies for “C” connectors

These dies are for the crimping of “C” connectors

Cable section mmq.	Die code
16-25	**9750**
35	**9751**
50-70	**9752**
95	**9754**
120-185	**9758**

9036

This hydrailic head crimps tube terminals on cables from 10 to 630 mmq.
Due to its compact size, the cramping tool is very practical.
It has been realized with high quality steel.
It is used with all our pumps and electric units.

This head with different dies can crimp tube terminals, “C” connectors, cable joints and shunts.
It is supplied with male rapid connector, ready to use.
.

Characteristics	
Power kN	200
Max working pression bars	700
Stroke mm	30
Oil capacity for full stroke lt.	0,100
Lenght mm	290
Width Ø mm	90
Weight Kg	5,9

DIES FOR 9036

Hexagonal dies

These dies are for the crimping of: plein tube terminals, plein head connectors.

Cable section mmq.	Die code
10	**9770/36**
16	**9772/36**
25	**9774/36**
35	**9776/36**
50	**9778/36**
70	**9780/36**
95	**9782/36**
120	**9784/36**
150	**9786/36**
185	**9793/36**
240	**9795/36**
300	**9797/36**
400	**9798/36**
500	**9799/36**
630	**9800/36**

Pre-insulated and plein “V” dies

These dies are for the crimping of plein and pre-insulated tube terminals and head connectors

“V” dies

Cable section mmq.	Die code	Punch code
35	**9706/36**	9702/36
50	**9706/36**	9702/36
70	**9708/36**	9704/36
95	**9708/36**	9704/36
120	**9709/36**	9704/36
150	**9709/36**	9704/36
185	**9710/36**	9704/36
240	**9710/36**	9704/36
300	**9712/36**	9704/36
400	**9713/36**	9716/36
500	**9714/36**	9716/36
630	**9715/36**	9716/36

Pre-insulated

Cable section mmq.	Die code	Punch code
25	**9706/36**	9702/36
35	**9706/36**	9702/36
50	**9706/36**	9702/36
70	**9708/36**	9702/36
95	**9710/36**	9702/36
120	**9710/36**	9704/36

Semicircular dies of medium tension

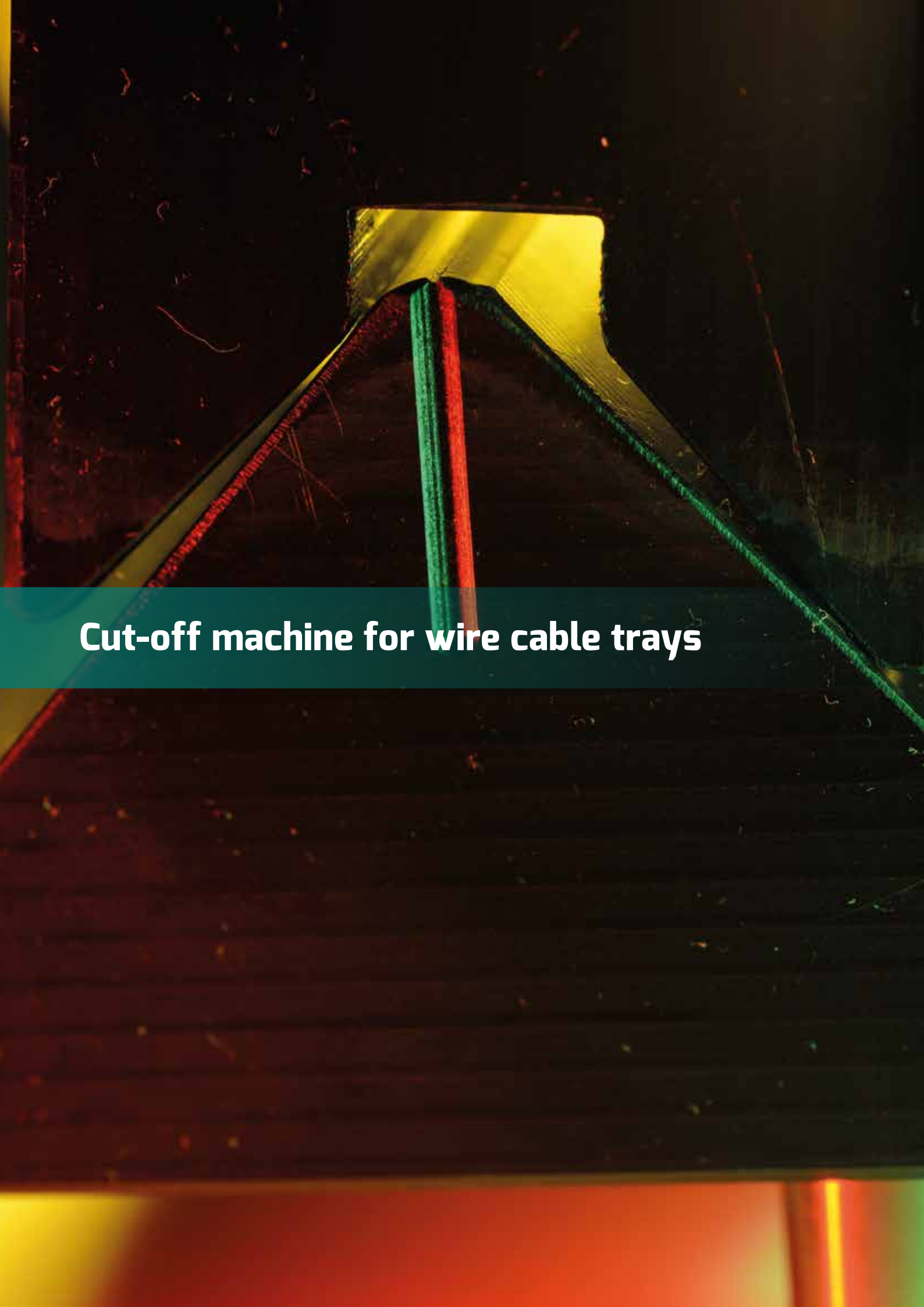
These dies are for crimping pre-insulated.

Cable section mmq.	Die code
25-40	**9722/36**
50-70	**9724/36**
95-120	**9726/36**
150-185	**9728/36**
240-315	**9730/36**
400	**9731/36**
500	**9732/36**
630	**9733/36**

Semicircular dies for “C” connectors

These dies are for the crimping of “C” connectors

Cable section mmq.	Die code
16-25	**9750/36**
35	**9751/36**
50-70	**9752/36**
95	**9754/36**
120-185	**9758/36**



Cut-off machine for wire cable trays

9077
Cut-off machine for perforating cylinder

Portable, rapid, easy to use

It is a little tool to cut in a fast way rod bars in iron with Ø 8 mm max.
and in stainless steel Ø 5 mm max.

This tool makes a clean and an exact cut and it is particularly indicated for the wire cable trays. It can be used on field or in a workshop.*

To combine with the cylinder **9022**
Total Weight
Tool + cylinder: 3,7 Kg

9075
For punching tools
9070E and art. 9070

9077
For cylinder 9022

Patented Model
9077 + 9022

* The life of the tool may be subject to changes due to the type of material and to the use.

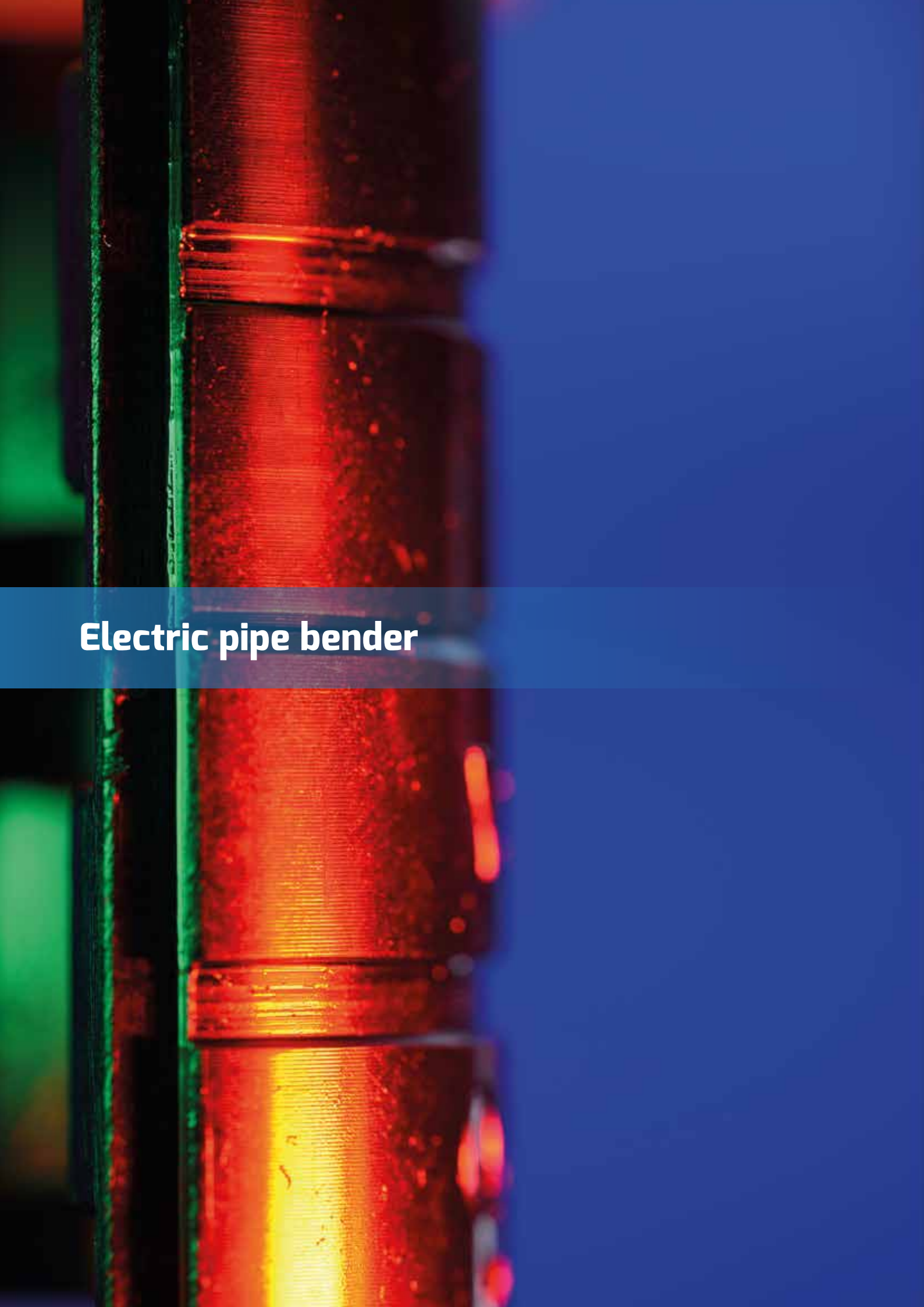
POWER UNITS PAG. 80÷87

9075
Cut-off machine for portabale tools

To combine with punching cylinders **9070E** and **9070**
Total Weight: 4 Kg
Execution time: 8 sec.

9075 + 9070E

Example of use art.9075+9070E



Electric pipe bender

9080
Electric pipe bender set

Handy tool, easy to use. It is a portable and electric tool, suitable for bending galvanized steel, stainless steel and copper pipes in cooling and air-conditioning technology, pipeline construction and industrial applications.

It is equipped with AUTOMATIC SWITCH OFF, when reaching the preset bending angle. Ideal for fast batch production of bends.
Set includes: basic 230 V unit, bending formers and guide shoes for respective pipe diameters (mm 16-20-25) and carrying case.
On demand, we can supply bending formers and guide shoes until Ø 35 mm.

Characteristics	
Power	1010W
Weight	13 Kg
Supply	230V 50/60Hz
Suitable for pipes	Ø 16-35 mm
Bending	Up to180°
Dimensions	590x145x215 mm

9080
Electric pipe bender set with bending formers and guide shoes.

9088
Tripod stand (optional)

Cutting machine for plastic channels

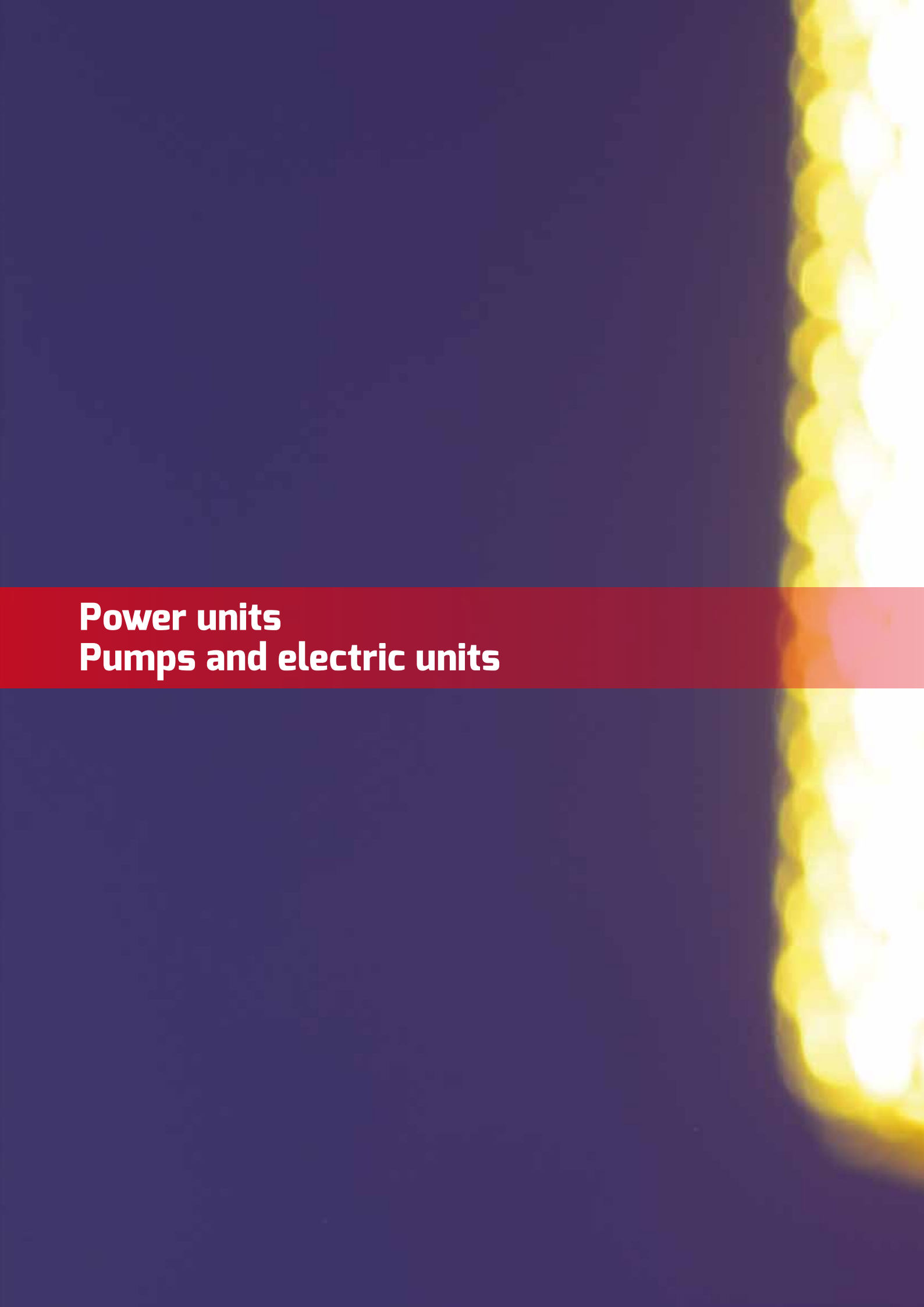
9062
Cutting machine for plastic channels

This cutting machine 9062 consists of a blade, which acting on the lever above, allows to cut trunking systems, lids and similar plastic or gummy products.

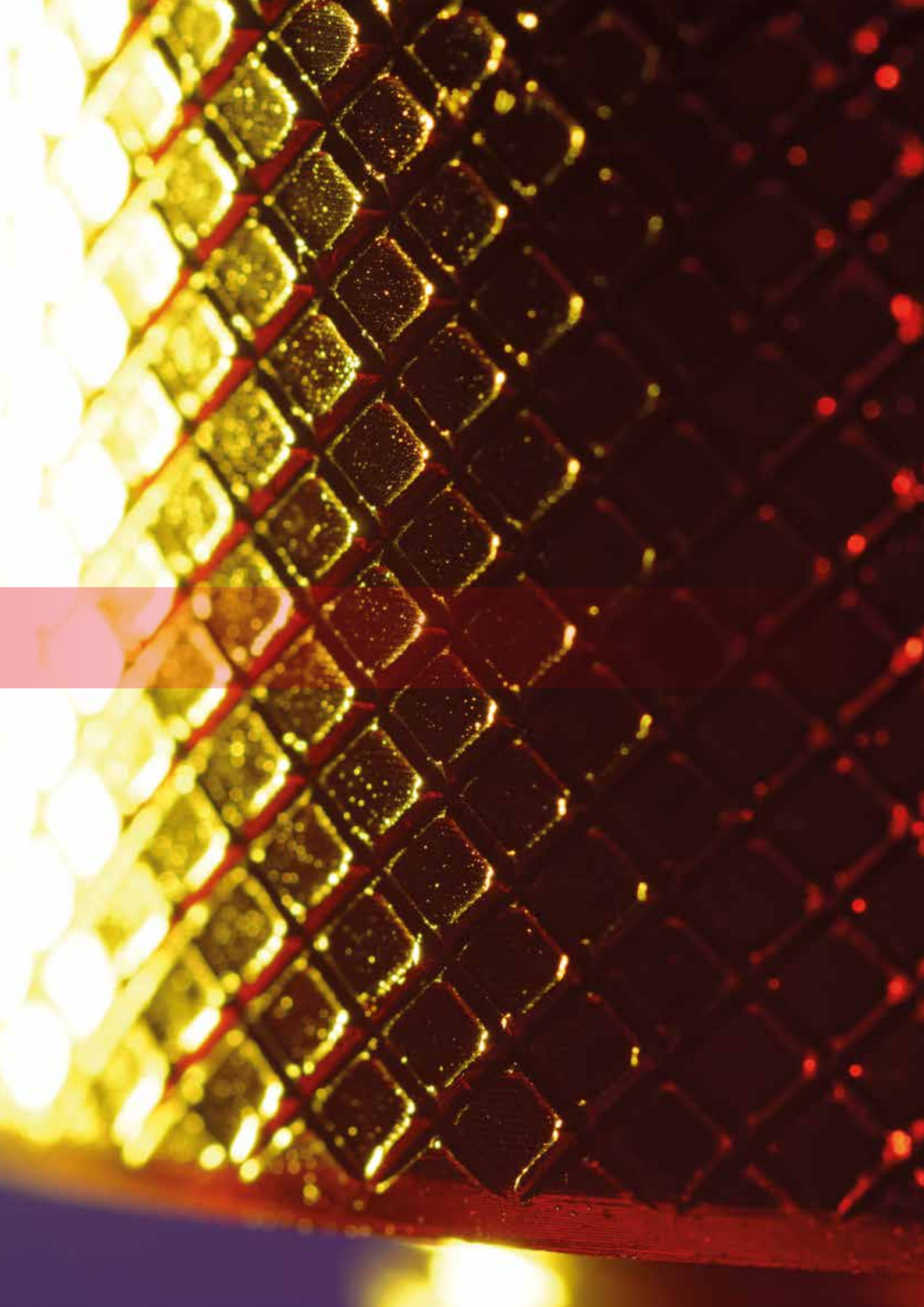
It cuts all the types of PVC sections, distance 4/8, from 25 mm to the maximum measure of 120 mm.

Maximum height is till 120 mm. The machine must be steadly screwed to a table or to a base.

Characteristics	
Trunking systems	25, 40, 60, 80, 100, 120 mm
Max. Width	120 mm
Max. Height	120 mm
Distance	4/8 mm
Blade lenght	125 mm
Dimensions	1450 x 310 x 260 mm
Weight	7 Kg



Power units
Pumps and electric units



9000
Foot pump

This is a hydraulic pump made completely of steel, whose internal components - pumping elements and valves - are all made of special hardened, temperated and rectified steel.
It has two speeds: one is the approach speed and the second is the working speed.
It has double pistons and double valves etc.
When this pump is used with crimping cylinders 9024 and 9036, its release valve enters in action. Infact when it reaches the pressure of 700 Bars, this valve allows the automatic return at zero. This operation facilitates the appropriate push foot pedal for piston return.
Supplied ready to use.

Characteristics	
Max. Working pressure	700 bars
Oil tank capacity	0,600 lt.
It supplies cylinder of max capacity	0,380 lt.
Pipe	from 2,50 mt. with female rapid connector
Oil	hydraulic oil AGIP ARNICA 22 (do not use brake or dielectric oil for transformer)
Weight	14,5 Kg

9004
Battery driven pump

Rechargeable battery

Battery operated hydraulic pump with ergonomic handle for works on filds.
It has a shoulder strap and thanks to its light weight, it can be used everywhere.
Two speeds :
- Approach (very fast)
- High pression (slow)

It is equipped with:
- Pipe 2,5 Mt.
- Carrying strap
- N.1 Battery 14,4 V 4.0 Ah
- Battery charger

Can be used with all IMB tools

Characteristics	
Weight	6 kg.(with battery and tank with oil)
Dimensions	240 x 120 x 190 mm
Tank	0,6 lt.
Min. pression	20bar
Max. pression	700bar
Working temperature	5÷50°C

ACCESSORIES FOR 9004

Battery 14,4V Li-ion 4.0 Ah (Weight 500 g)

Carrying strap for the transport of the pump (1,2 mt. about)

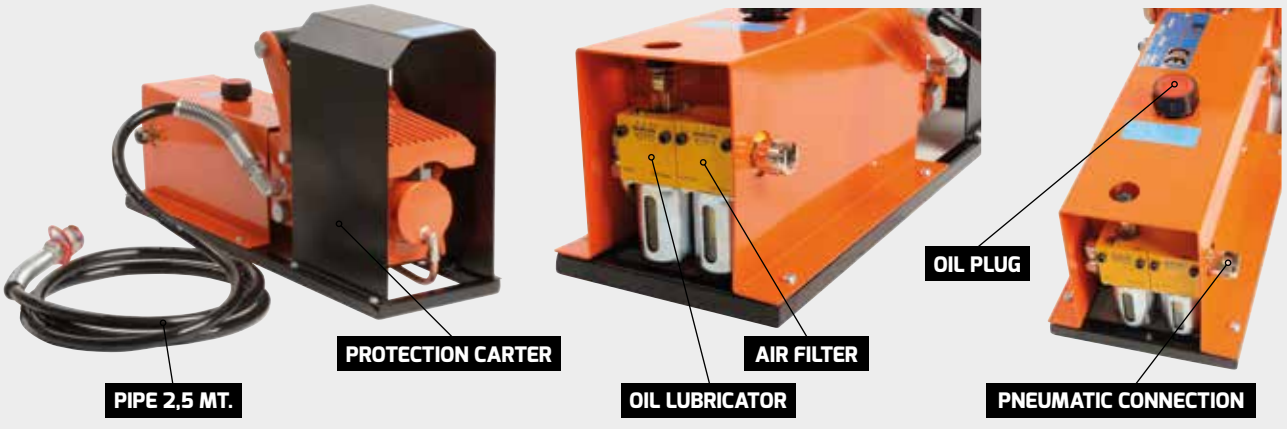
High pression hoose connected directly to the power unit (2,5 Mt.)

Rapid battery charger with operation self-cooled.

9002
Pneumatic control unit

The pneumatic pump 9002 is made with the same technology as the foot pump 9000, offering the advantage of more rapid operation as it uses compressed air to work with. It has two speeds, one for the approach and one for the working phase; it has therefore been equipped with double valves and double pistons. It is able to produce 700 bars when supplied with a constant pressure of 7÷10 bars by a suitable compressor or in-house centralised installation.
It is equipped with air filter and a lubricator already regulated. For the return, it is sufficient to reverse the movement of the foot pedal control. It is ready to use, after the assembly of the breather plug.
It is recommended to have a tank compressor superior to 200 lt. It is supplied with a pipe 2,5 Mt with a female rapid connector and a protection carter.
N.B. Do not use brake or dielectric oil for the transformer.

Characteristics	
Max. Working pressure	700 bars
Oil tank capacity	1,250 lt.
It supplies cylinder of max capacity	1,00 lt.
Air absorption with a continuous service	lt. 48/minuto
Hose	da 2,50 mt. with female rapid connector
Oil	hydraulic oil AGIP ARNICA 22 (do not use brake or dielectric oil for transformer)
Weight	19,5 Kg



9003
Simplified air-hydraulic pump

The hydraulic pump 9003 offers the advantage of a rapid operation as it uses compressed air. It has two speeds, one for the approach and one for the working phase.
It is able to produce 700 bars when supplied with a constant pressure of 7÷10 bars by a suitable compressor or in-house centralised installation.
For the return, it is sufficient to reverse the movement of the foot pedal control.

It is ready to use and it is equipped with a universal rapid connector for the air.
It is recommended to have a tank compressor superior to 200 lt.
Complete with a female rapid connector suitable for all our tools.
It is supplied with a pipe 2,5 Mt, a protection carter and a rubber handle for the transport.
N.B. Do not use brake or dielectric oil for the transformer.

Technical Characteristics	
Operated	throught pedal
Oil pressure	700 bars
Tank capacity	2,4 lt.
Max. noise	75 dbA
Air connection	G 1/4”
Air consumption	400 Nl/min
Connected to the pneumatic access	(5-10 bar)
Oil	Hydraulic oil AGIP ARNICA 22 (Do not use brake or dielectric oil)
Dimensions	410x295x175 mm
Weight	12 Kg

Pneumatic rapid connector

Operated through pedal

Return pedal

Porthole to check oil level

9005
Simplified electric unit 220V

Foot pedal included

This electric unit 9005 has the same characteristics and mobile components as the other units.
This simplified version is without protection carter, pressure gauge, connectors for accessories and a card system.
It is equipped with a direct control and with a standard foot pedal.
It is interchangeable with all our electric units and it can be used with all our equipments less then our hydraulic punching machines.
Supply 230 V 1 Ph
Max. working pression 700 Bar.

Characteristics	
Voltage supply	230V 1 Ph
Power	0.70 KW
Max. Working pressure	700 bar
Oil capacity	5.0 lt.
Supply cylinders max. capacity	3.0 lt.
Type oil	Agip Arnica 22
Weight	24 Kg

Do not use brake or dielectric oil for transformers.

9007
Simplified electric unit 380V

This simplified electric unit 9007 has the same characteristics than the 9005 but with a supply 400 V 3Ph.
It is equipped with direct control and a standard foot pedal.
It is interchangeable with all our electric units and it can be used with all our equipments less then our hydraulic punching machines.

Characteristics	
Voltage supply	400V 3Ph
Power	0.75 KW
Max. Working pressure	700 bar
Oil capacity	5.0 lt.
Supply cylinders max. capacity	3.0 lt.
Type oil	Agip Arnica 22
Weight	24 Kg

Do not use brake or dielectric oil for transformers.

9008/9009/9010
Electric control units with options

9156
Foot pedal included

These are high-pressure electric control units with radial pistons of high precision and a system with an electric motor in oil bath.
This performance has been widely tested to ensure maximum reliability.
They are available in different versions.

They are equipped with:

- **Electric system** on stamped circuit with a protection fuse
- **Motor protection switch**
- **Foot pedal** control included
- **Selector switch** for the security system.
- **Pressure gauge** with electric contacts, adjustable for automatic stop at the reached pressure and consequent cylinder return
- **Socket** for electrical protractor
- **Socket** for protection carter
- **Socket** for remote foot pedal control
- **Controls** 24 V direct current

Characteristics 9008	
Voltage	240 V single-phase
Power	0,55 kW
Max working pressure	700 bars
Adjustable pressure	400 ÷ 700 bar
Oil tank capacity	2,700 lt.
It feeds cylinders of the maximum capacity	2,200 lt.
Oil type	AGIP ARNICA 22
Weight	33 Kg
Dimensions	
Lenght	420 mm
Width	235 mm
Height	450 mm

Characteristics 9009	
Voltage	400 V three-phase
Power	0,75 kW
Max working pressure	700 bars
Adjustable pressure	400 ÷ 700 bar
Oil tank capacity	2,700 lt.
It feeds cylinders of the maximum capacity	2,200 lt.
Oil type	AGIP ARNICA 22
Weight	33 Kg
Dimensions	
Lenght	420 mm
Width	235 mm
Height	450 mm

Characteristics 9010	
Voltage	400 V three-phase
Power	1,4 kW
Max working pressure	700 bars
Adjustable pressure	400÷700 bar
Oil tank capacity	5,4 lt.
It feeds cylinders of the maximum capacity	4,100 lt.
Oil type	AGIP ARNICA 22
Weight	36 Kg
Dimensions	
Lenght	420 mm
Width	260 mm
Height	470 mm

All our electric control units are supplied with 2,50 meters hoose, female connector and hydraulic oil **AGIP ARNICA 22**, ready for use. They are also complete with safety protection socket.

Front panel electric control unit

Adjustable pressure switch

9013/9014/9015
Electric control units without options

9156
Foot pedal included

Electric control unit 9013

Electric control unit, voltage 240 V single-phase, with 24 V direct current, with motor protection switch and socket micro panel protection for punching machines.

Characteristics	
Voltage	240 V single-phase
Power	0,55 kW
Max. Working pressure	700 bars
Oil tank capacity	2,700 lt.
It feeds cylinders of the max capacity	di 2,200 lt.
Oil type	AGIP ARNICA 22
Weight	33 Kg
Dimensions	
Lenght	420 mm
Width	240 mm
Height	450 mm
Hoose	2,5 mt

Electric control unit 9014

Electric control unit, voltage 400 V three-phase, with 24 V direct current, with motor protection switch and socket micro panel protection for punching machines.

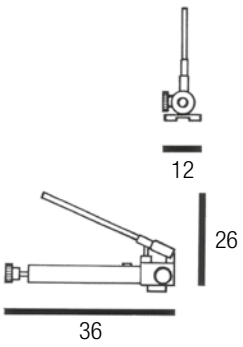
Characteristics	
Voltage	400 V three-phase
Power	0,75 kW
Max. Working pressure	700 bars
Oil tank capacity	2,700 lt.
It feeds cylinders of the max capacity	di 2,200 lt.
Oil type	AGIP ARNICA 22
Weight	33 Kg
Dimensions	
Lenght	420 mm
Width	240 mm
Height	450 mm
Hoose	2,5 mt

Electric control unit 9015

Electric control unit, voltage 400 V three-phase, with 24 V direct current, with motor protection switch and socket micro panel protection for punching machines.

Characteristics	
Voltage	400 V three-phase
Power	1,4 kW
Max. Working pressure	700 bars
Oil tank capacity	5,4 lt.
It feeds cylinders of the max capacity	di 4,100 lt.
Oil type	AGIP ARNICA 22
Weight	36 Kg
Dimensions	
Lenght	420 mm
Width	260 mm
Height	470 mm
Hoose	2,5 mt

9001
Hand pump



This is a hydraulic pump of simple construction, which is very light and easy to use. It is ready to use.
It is designed for small production or where there are difficult positions to reach.

Characteristics	
Max. Working pressure	450 bars
Oil tank capacity	0,250 lt.
It supplies cylinders of max. capacity	0,200 lt.
Hoose	2,50 mt. with female connector
Oil	hydraulic oil AGIP ARNICA 22 (don't use brake or dielectric oil for transformer)
Weight	5,5 Kg

MATCHING POWER UNITS -EQUIPMENT

	9000	9001	9002	9003	9004	9005	9007	9008	9009	9010	9013	9014	9015
Tris units													
Hydraulic punching machines													
Bench equipment													
Portable tools													
Crimping tools													

Recommended — **Not recommended**

Accessories and Work benches

Valves and accessories

9162
Positioning valve

The positioning valve is equipped with male and female rapid connectors, for a fast assembly.The valve can be connected to the TRIS cylinder when the electric unit is used. The small movements of the tool facilitate the positioning of the bars.

9163 for 2 cylinders
9164 for 3 cylinders
9165 for 4 cylinders

Branch valves

Branch valves for 2-3 and 4 cylinders are used when several cylinders have to work with one pump or electrical control unit. These valves avoid to connect or disconnect continually the respective hoses. By just moving a simple lever, the branch valves divert the hydraulic oil to the cylinder to use. All branch valves are equipped with hoses and rapid connectors.

9817/9819
Rapid Connectors

All MULTIFOR equipment, cylinders and hoses are supplied complete with rapid connectors with locking and rapid coupler. 1/4" standard version, 3/8" on request with screw connector

9817
Male

9819
Female

9810
Pipes and extensions

The spare pipe of the MULTIFOR equipment is complete with female rapid connector and it has a standard length of 2,5 mt. The working range of cylinders can be extended by a simple addition of a 2,5 mt. extensions hose (9812) or 5 mt.(9813). These are realised with highpressure pipe, already filled with oil AGIP ARNICA 22 and with rapid connectors.

9828
Hydraulic oil

All MULTIFOR equipment, and hoses contain hydraulic oil. AGIP ARNICA 22. Whenever topping up is required, it is essential to use the same type of oil. For a best working of the pumps, the level must be inspected at regular intervals by checking the oil dipstick.
Available in cans of 1 Kg.
It is highly recommended not to use oils other than those indicated by us, in particular do not use brake oil or dielectric oil for transformers.

Foot pedal and other accessories

9156
Remote foot pedal

Remote foot pedal for electric control units.

9157
Remote foot pedal with security

Remote foot pedal for electric control units with a total protection. It is equipped with a security device with a double approval in order to avoid accidental manipulation and with a double pressure switch.
The switch stops the electric control if the pressure on the pedal is too high.

9806
Bench clamp

A practical accessory for holding punching cylinder (9022) and crimping tools (9024-9036).

9808
Stand

Used to hold punching cylinders and crimping tool, where it is not possible to use a bench clamp. Equipped with a cylinder holding clamp, it is a folding and portablle accessory.

9809
Stand with roller

This tripod is for holding the heavy bars.
During the works, the roller allows a good support and the sliding of the bar without effort.
The height is adjustable for the different works.

Tool cases

9822
Metal case

The case 9822 is suitable for the transport of the MULTIFOR 9000, 9001 cylinders and different accessories.
Dim. mm 650x250x270 h

9823
Metal case

The metal case 9823 is suitable for the transport of shears, cylinders, pump 9001 and different accessories.
Dim. mm 600x270x220 h

9830
Portable tools case

This case 9830 is suitable for the transport of cylinders and accessories.

Dim. mm 330x170x110

9832
Honeycomb for 9822

9834
Honeycomb for 9823

9833
Honeycomb for 9830

9829
Case for electric tools

The case 9829 is suitable for the transport of the tools with battery.

9825
Portable tools case

The case 9825 is suitable for the transport of manual punching cylinders and its accessories.

9826
Portable tools case

The case 9826 is suitable for the transport of punches and different accessories.

9048
Work bench

The special MAXI work bench has been designed to enable several cylinders to operate from one single control unit within a small space. The TRIS unit is placed on the MAXI work bench, while on the lateral telescopic cylinder, the punching cylinder (9022) and crimping tools (9024-9036) can be supported.

The MAXI work bench is equipped with:

- **Branch valve**, which allows two or more cylinders to operate (cod.9163 valve for two cylinders).
  It is possible to assemble valves for the working of more cylinders.
- **Pressure gauge** for regulating the required pressure
- **Socket** for electrical protractor (9161)
- **Socket** for remote foot pedal control (9156)

Dimensions: mm 1300 x 960 x 870 h
Weight: 96 Kg. **without control unit and accessories**.
The unit is used only with control units type 9008-9009-9010
Available versions: 220 V (9048/220 V) and 380 V (9048/380 V)

Connectors for electric units with options

Branch valve with pressure gauge and general switch.

Work benches

10100/50

This base can be used for the support of all our equipment apart from than the hydraulic punching machines 10090L. it is a simple open bench for lodging the electric unit and other tools. It has a tool-holder drawer.

Dimensions
Lenght 750 mm.
Width 750 mm.
Height 803 mm.
Weight 55 kg.

10100/90E

It is a simple and inexpensive base. It can be used for all our equipments. It has a tool-holder drawer and a base for the electric units.

Dimensions
Lenght 906 mm.
Width 756 mm.
Height 786 mm.
Weight 45 kg.

10100/90

Specific base for the hydraulic punching machines type 10090 but it can be used also with the other smaller hydraulic punching machines and other equipment.
Equipped with a protection carter, there is the possibility to lodge an electric unit inside.

Dimensions
Lenght 1026 mm.
Width 800 mm.
Height 750 mm.
Weight 112 kg.

Notes

ZERTIFIKAT ◆ CERTIFICATE ◆ 認證書 ◆ СЕРТИФИКАТ ◆ CERTIFICADO ◆ CERTIFICAT

TÜV SÜD
Italia

CERTIFICATO

Nr. 50 100 3768 - Rev.006

Si attesta che / *This is to certify that*

IL SISTEMA QUALITÀ DI
THE QUALITY SYSTEM OF

I.M.B. S.r.l.

SEDE LEGALE:
REGISTERED OFFICE:

VIA MADRE TERESA DI CALCUTTA 9
IT - 29122 PIACENZA (PC)

SEDE OPERATIVA:
OPERATIONAL SITE:

STRADA DEL FORNO 66
IT - 43011 BUSSETO (PR)

È CONFORME AI REQUISITI DELLA NORMA
HAS BEEN FOUND TO COMPLY WITH THE REQUIREMENTS OF

UNI EN ISO 9001:2015

QUESTO CERTIFICATO È VALIDO PER IL SEGUENTE CAMPO DI APPLICAZIONE
THIS CERTIFICATE IS VALID FOR THE FOLLOWING SCOPE

Progettazione e fabbricazione di macchine, attrezzature e utensili per l'impiantistica elettrica e la lavorazione di quadri elettrici (IAF 18)

Design and manufacture of machines, tools and equipment for electrical plants and electric control boards (IAF 18)

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L'ENTE ITALIANO DI ACCREDITAMENTO
SGQ N° 049A

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Signatory of EA, IAF and ILAC Mutual Recognition Agreements

Per l'Organismo di Certificazione
For the Certification Body
TÜV Italia S.r.l.

Validità /*Validity*
Dal / From: **2018-12-10**
Al / To: **2021-12-18**

Andrea Coscia
Direttore Divisione Business Assurance

Data emissione / *Issuing Date*
2018-12-10

PRIMA CERTIFICAZIONE / *FIRST CERTIFICATION:* 2004-02-04
DATA DI SCADENZA DEL PRECEDENTE CERTIFICATO ISO 9001:2008: 2018-09-14
EXPIRATION DATE OF THE PREVIOUS CERTIFICATE ISO 9001:2008: 2018-09-14

"LA VALIDITÀ DEL PRESENTE CERTIFICATO È SUBORDINATA A SORVEGLIANZA PERIODICA A 12 MESI E AL RIESAME COMPLETO DEL SISTEMA DI GESTIONE AZIENDALE CON PERIODICITÀ TRIENNALE"

"THE VALIDITY OF THE PRESENT CERTIFICATE DEPENDS ON THE ANNUAL SURVEILLANCE EVERY 12 MONTHS AND ON THE COMPLETE REVIEW OF COMPANY'S MANAGEMENT SYSTEM AFTER THREE-YEARS"

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