

QUAKELOGIC

INDUSTRIAL HYDRAULIC IRONWORKER



QL-IronForce 100

QL-IronForce 100

Industrial Hydraulic Ironworker



QL-IronForce 100

HYDRAULIC IRONWORKER

Power. Precision. Performance.

QL-IronForce 100 is a compact yet powerful hydraulic ironworker built for maximum versatility and productivity. Designed to deliver superior performance in punching, shearing, notching, and bending operations, this machine is ideal for fabrication shops, metalworking professionals, and industrial applications.



MACHINE DETAILS



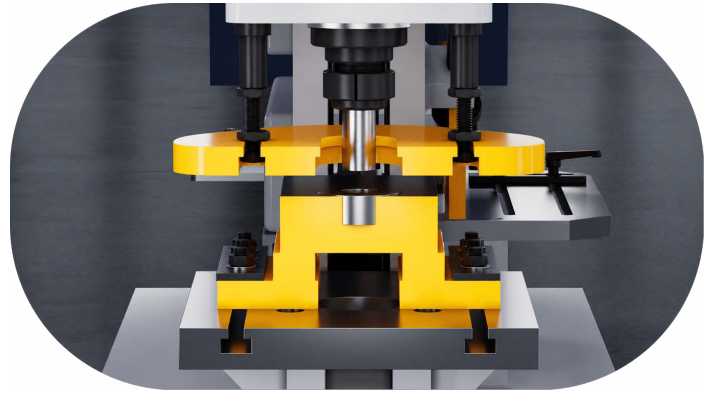
FRONT

With adjustable gauges and a robust hold-down system for precise material alignment.



BACK

With a sturdy support system and guide rails that allow for consistent and efficient cutting of longer angle sections.



HEAVY-DUTY FIVE-STATION HYDRAULIC IRONWORKER

The QL-IronForce 100 is a heavy-duty, five-station hydraulic ironworker built for high-capacity punching, flat-bar shearing, angle shearing, bar shearing, and coping/notching. Rated at 100 tons with a 30-stroke-per-minute cycle, it consolidates five fabrication operations into one welded structure. Supplied turnkey with standard tooling, hold-downs, waste collection, and UL-approved controls, it delivers versatile production for demanding metal-fabrication shops.

- Five integrated active workstations consolidate punching and shearing into a single machine, saving floor space and eliminating multiple standalone tools.
- 100-ton hydraulic capacity punches a 1-1/16 in hole through 3/4 in plate, covering the full range of structural fabrication work.
- 30 strokes per minute at nominal 3/4 in stroke sustains continuous throughput for high-volume production runs.
- Turnkey package ships with tooling, hold-downs, waste buckets, and UL-approved controls for immediate operation on arrival.

STANDARD FEATURES »

- 100-Ton Punch Station
- Five Active Workstations
- Flat Bar Shear Station
- Angle Shear Station
- Round/Square Bar Shear
- Coper/Notcher Station
- 20-Gallon Reservoir
- Dual-Stage Foot Pedal
- Emergency-Stop Controls
- Interlocked Notch Guard
- Material Hold-Downs
- Five Punch/Die Sets
- Structural Knife Set
- Chip/Slug Buckets
- Precision Front Gauge
- Integrated Work Lamp
- UL-Approved Controls
- Thermal Motor Protection
- Welded Steel Structure
- One-Year Warranty

Key Features

- 100-ton hydraulic punching station drives a 1-1/16 in hole through 3/4 in plate, handling the full spectrum of structural work.
- Five active workstations combine punching, plate shearing, angle shearing, bar shearing, and coping/notching in one welded frame.
- 355 mm (14 in) punch throat depth exceeds the 8 in requirement, allowing hole placement well inboard from plate edges.
- 30 strokes per minute at 3/4 in stroke sustains high cycle rates for continuous, high-volume fabrication throughput.
- Dual-stage low-voltage foot pedal gives the operator staged, controlled punching and shearing without releasing workpiece control.
- Automatic, mechanical, or urethane hold-down systems secure plate and angle stock, improving cut accuracy and operator safety.
- Electrically interlocked notching guard and integrated emergency-stop controls meet UL-approved safety requirements for continuous operation.
- Removable chip and slug buckets at every active station simplify waste management and keep the work area clear.
- Heavy-duty welded steel structure and 7.5 kW motor are engineered for sustained, continuous metal-fabrication duty cycles.

PRODUCT FEATURES

Punching Station

100-ton hydraulic punching capacity · 1-1/16 in hole through 3/4 in plate · 355 mm (14 in) throat depth

Shearing Stations

Flat bar: 5/8 in x 15 in · Heavy flat bar: 3/4 in x 10 in · Angle: 5 x 5 x 3/8 in at 90°

Bar & Notching

Round bar up to 50 mm (1.97 in) · Square bar up to 45 x 45 mm · Coper/notcher: 2-3/4 x 4 x 1/4 in

Hydraulic System

22 MPa (approx. 3,190 PSI) operating pressure · 20-gallon reservoir capacity · 80 mm (3.15 in) maximum cylinder stroke

Drive & Electrical

7.5 kW (approx. 10 HP) industrial motor · 230 VAC, 3-Phase, 60 Hz input · Circuit breakers, contactors, thermal protection

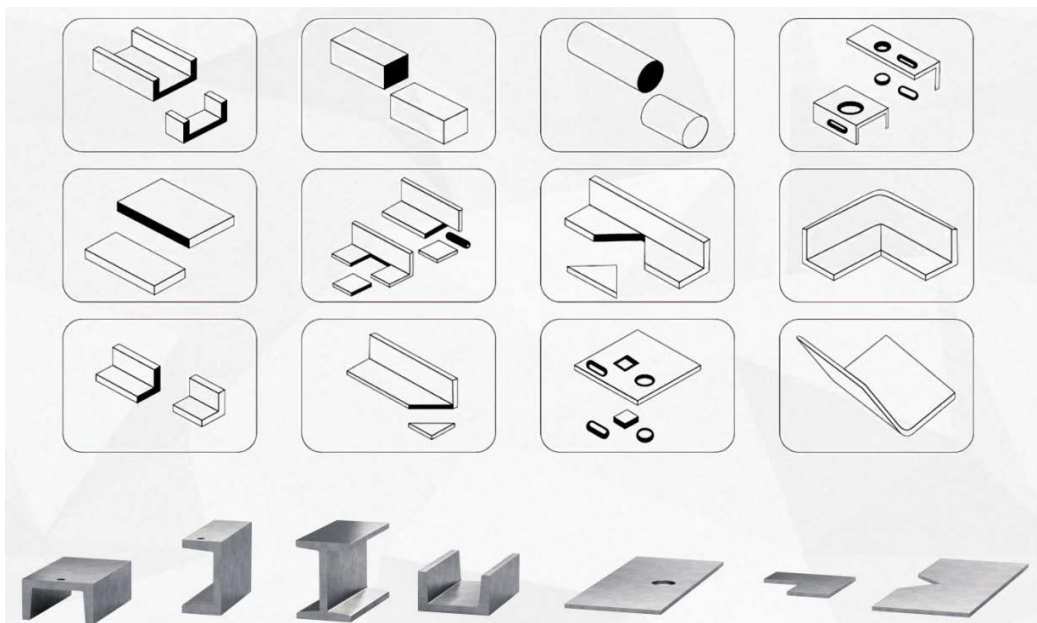
Safety & Controls

UL-approved control configuration · Dual-stage low-voltage foot pedal · Interlocked notching guard and E-stop

Productivity

30 strokes per minute at 3/4 in stroke · Automatic/mechanical/urethane hold-downs · Removable chip and slug collection buckets

For more information about the features, specifications, and available configurations of the QL-IronForce 100, please contact QuakeLogic.



MACHINE CONFIGURATION

COMPONENT	CONFIGURATION
System Type	Industrial-Grade Hydraulic Ironworker
Configuration	Integrated Five-Station Multi-Functional
Active Workstations	Punch, Flat/Plate Shear, Angle Shear, Bar Shear, Coper/Notcher
Drive Motor	7.5 kW (approx. 10 HP) Heavy-Duty Industrial
Electrical Input	230 VAC, 3-Phase, 60 Hz
Hydraulic Reservoir	20-Gallon Capacity
Operating Pressure	22 MPa (approx. 3,190 PSI)
Control System	UL-Approved Configuration
Foot Control	Dual-Stage Low-Voltage Foot Pedal
Safety Guarding	Electrically Interlocked Notching Guard + E-Stop
Material Hold-Down	Automatic / Mechanical / Urethane Systems
Construction	Heavy-Duty Welded Steel Structure

CAPACITY

SPECIFICATION	VALUE
Punching Capacity	100 Tons
Punching Hole/Plate	1-1/16 in dia. through 3/4 in plate
Flat Bar Shearing	5/8 in x 15 in (min)
Heavy Flat Bar Shearing	3/4 in x 10 in (min)
Angle Shearing	5 x 5 x 3/8 in at 90°
Round Bar Shearing	Up to 50 mm (1.97 in)
Square Bar Shearing	Up to 45 x 45 mm (1.77 x 1.77 in)
Coper/Notcher	2-3/4 x 4 x 1/4 in (min)
Cycle Speed	30 strokes/min at 3/4 in stroke

ADDITIONAL PUNCH & DIE SETS

Supplementary round, square, and oblong punch-and-die sets extend the standard 9/16 in to 1-1/16 in tooling range for specialized hole patterns.

URETHANE HOLD-DOWN UPGRADE

Non-marring urethane hold-downs protect finished and coated stock at the plate and angle shear stations during clamping.

EXTENDED MATERIAL GAUGING

Adjustable front and back gauge systems support repeatable positioning of long or high-volume production runs.

WORK AREA LIGHTING PACKAGE

Additional integrated industrial work lamps improve visibility at each active station for accurate layout and safe operation.

TECHNICAL SPECIFICATIONS

SPECIFICATION	DESCRIPTION
System Type	Industrial-Grade Hydraulic Ironworker
Hydraulic / Punching Capacity	100 Tons
Minimum Required Hydraulic Capacity	Exceeds 65-Ton requirement
Configuration	Integrated Five-Station Multi-Functional
Active Workstations	Punch, Flat/Plate Shear, Angle Shear, Bar Shear, Coper/Notcher
Punching Capacity	1-1/16 in dia. through 3/4 in plate (min)
Maximum Punching Diameter	1.18 in (30 mm)
Maximum Punching Thickness	0.79 in (20 mm)
Punch Throat Depth	14 in (355 mm)
Flat Bar Shearing Capacity	5/8 in x 15 in (min)
Heavy Flat Bar Shearing	3/4 in x 10 in (min)
Angle Shearing Capacity	5 x 5 x 3/8 in at 90°
Round Bar Capacity	Up to 1.97 in (50 mm)
Square Bar Capacity	Up to 1.77 x 1.77 in (45 x 45 mm)
Coper/Notcher Capacity	2-3/4 x 4 x 1/4 in (min)
Cycle Speed	30 strokes/min at 3/4 in stroke
Maximum Cylinder Stroke	3.15 in (80 mm)

SPECIFICATION	DESCRIPTION
Hydraulic Operating Pressure	3,190 PSI (22 MPa)
Hydraulic Reservoir	20-Gallon Capacity
Installed Motor Power	10 HP (7.5 kW)
Electrical Input	230 VAC, 3-Phase, 60 Hz
Electrical Components	Breakers, contactors, thermal protection
Safety Controls	UL-Approved Configuration
Foot Control	Dual-Stage Low-Voltage Foot Pedal
Emergency Stop	Integrated E-Stop Controls
Notching Safety	Electrically Interlocked Guard
Material Hold-Down	Automatic / Mechanical / Urethane
Punching Tooling	Five round punch/die sets, 9/16 in to 1-1/16 in
Shear Tooling	Factory knife set for angle, notcher, 1 in bar
Maximum Rated Material Strength	≤ 450 N/mm ²
Operating Noise	< 85 dB
Machine Dimensions	76.8 x 36.2 x 76.8 in (1,950 x 920 x 1,950 mm)
Machine Weight	5,732 lb (2,600 kg)
Warranty	One (1) Year Manufacturer Warranty

QL-IronForce 100

Corporate Headquarters:**QUAKELOGIC INC.**

2008 Opportunity Dr., Suite 130
Roseville, CA 95678, USA

Monday – Friday

9:00 AM – 5:00 PM (PST/PDT)

Contact Us:

Phone: +1 (916) 899-0391

Email: sales@quakelogic.net

Web: products.quakelogic.net

About QuakeLogic:

QuakeLogic Inc. is a California-based engineering and technology company providing innovative, reliable, high-quality solutions to customers worldwide.

Our Commitment

We are committed to quality, innovation, and customer satisfaction – building lasting partnerships through reliable solutions and dependable support.

Scan to View Product: