



HSV Steelworkers

The Morgan Rushworth HSV hydraulic vertical steelworkers supplied with standard tooling including repetition support tables at punch, shear and the notch stations. This compact universal hydraulic steelworker features 5 work stations and have been designed for volume production with maximum efficiency. Punching, shearing, cropping, notching can be instantly carried out by pressing the movable foot pedal. Comprehensive safety guards are fitted as standard on all work stations. The system gives accurate power inching to all five work stations and allows the machine to be stopped at any position giving safe accurate tool setting and work positioning.

The vertical ram system ensures maximum shearing quality on angle material. A 1m auto crop ruled length stop is supplied as standard.

HSV 70



Machine Features

- Built-in LED Lighting System
- Punch station with fully adjustable ram stroke
- Low power inching for tool alignment
- Angle station for cropping angle iron at any angle from 90° to 45° with either internal or external mitres
- Section cutting station for cropping round and square bar
- Shear station for cutting both thin and thick material without requiring blade gap or cutting angle adjustment. Can also be used for cropping the leg of angle iron
- 1 metre ruled length stop covering all cropping/shearing stations for repetitive work
- Notching station with rectangular notch
- Comprehensive safety guards

Optional Equipment

- Tooling for special applications
- Flat bar bending unit at punch end



NOTCHING STATION



PUNCH STATION



SHEARING STATION



**SECTION &
ANGLE STATIONS**

TECHNICAL SPECIFICATIONS

STEELWORKER RANGE		HSW Steelworkers		Vertical Steelworker	HST Steelworkers			
MODEL		HSW 45	HSW 60	HSV70	HST 70	HST 95	HST 125	HST 175
STOCK CODE		M9001	M9002	M9017	M9003	M9004	M9005	M9006
PUNCHING								
Diameter x Maximum Thickness	mm	22 x 15	28 x 15	22 x 20	26 x 20	33 x 20	35 x 25	40 x 32
Maximum Diameter x Thickness	mm	38 x 8	38 x 11	38 x 11	57 x 10	57 x 12	57 x 16	57 x 22
Stroke Length	mm	50	55	40	55	80	80	80
Throat Depth	mm	175	220	240	305	355	355	625
Largest Hole Diameter - Standard	mm	38	38	38	38	57	57	57
Largest Hole Diameter - Optional	mm	110	110	N/A	160	160	225	225
SHEARING								
Flat Bar - Width x Maximum Thickness	mm	200 x 15	200 x 20	350 x 15	300 x 20	380 x 20	380 x 25	380 x 30
Flat Bar - Maximum Width x Thickness	mm	300 x 12	300 x 15	250 x 19	375 x 15	480 x 15	600 x 15	600 x 20
Angle Flange Trim - max 45°	mm	80 x 10	80 x 10	70 x 7	100 x 15	120 x 15	120 x 15	120 x 15
ANGLE CUTTING								
90° Cut	mm	100 x 10	127 x 12	130 x 13	130 x 13	150 x 15	150 x 18	200 x 20
45° Mitre (true int. / ext.	mm	70 x 6	80 x 8	70 x 7	70 x 10	80 x 8	80 x 10	80 x 10
SECTION CUTTING								
Round / Square	mm	30 / 25	40 / 35	40 - 38	45	50	55	65 / 55
Channel / Beam (Optional)	mm	80 x 45	80 x 45	N/A	120 x 58	160 x 74	200 x 100	300 x 125
Tee (Optional)	mm	40 x 5	40 x 5	N/A	90 x 11	100 x 11	120 x 12	150 x 15
NOTCHING								
Material Thickness	mm	8	10	8	10	13	13	16
Width - Rectangle	mm	35	42	50.8	45	52	60	60
Depth - Rectangle	mm	75	100	90	90	100	100	100
Depth - Vee	mm	60	60	60	60	70	80	80
TUBE NOTCH (OPTIONAL)								
Maximum Outside Diameter	mm	60	60	N/A	83	108	108	165
BENDING (OPTIONAL)								
Bar Bending - Maximum Capabilities	mm	100 x 12	150 x 12	100 x 12	250 x 13	250 x 20	250 x 22	250 x 25
Sheet Bending - Maximum Capabilities	mm	-	-	N/A	500 x 3	500 x 3	700 x 3	700 x 4
TECHNICAL DATA								
Motor Power	kW	4	4	5.5	5.5	7.5	11	11
Weight	kg	1180	1440	1215	1620	2430	3080	6000
Length	mm	1450	1520	1180	1700	1920	2040	2730
Width	mm	590	590	950	710	790	800	1120
Height	mm	1620	1700	1920	1800	1910	2030	2160

based on material strength of 450 N/mm²