

Accessories Catalogue





GEKA ACCESSORIES

Since 1919, GEKA Group has been manufacturing Ironworkers for angle work, flats and profiles - for black iron, metal workshops, metal constructions, telecommunication and electrical towers and, generally all that is related with civil and industrial construction.

Many years of effort and work of studying and resolving problems and also years of continuous contact with clients: GEKA Group has a profound knowledge of the product, and this makes them different.

From their first ironworkers things have changed a lot. Market necessities, new technologies and improvement in metal production, have made GEKA Group adapt its machinery to new times. Like this, the first manually operated shears became mechanically operated, later hydraulically, and now these have a new version in automatic lines or CNC.

Geka offers more than 7,000 accessories to its clients. Standard accessories, optional accessories and special accessories. The standard accessories are integrated in the machines with the purchase. The optional ones can be bought easily and the special ones are specifically designed and made for the clients who order them.

Our versatility and continuous innovation allows us to continue being faithful to our goal of adapting to the needs of our customers.



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01.

STANDARD ACCESSORIES

Geka currently has a complete range of over 7,000 personalized designs of accessories for special applications.

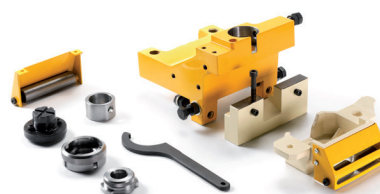
On many occasions, our users need to carry out special jobs, which do not fit in with any of the classical options of Conventional Ironworkers. For this reason, GEKA makes available to its users a team of engineers, with extensive experience in the development of all kinds of tools and special applications.



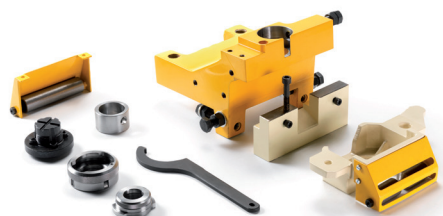
Microcrop standard punching equipment



Minicrop & Multicrop standard punching equipment



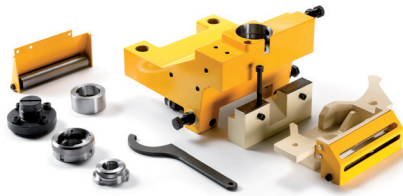
Hydracrop 55 standard punching equipment



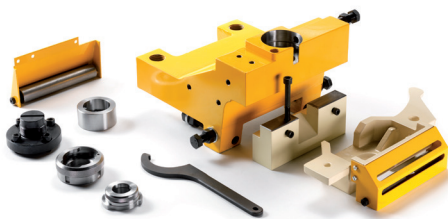
Hydracrop 80 standard punching equipment

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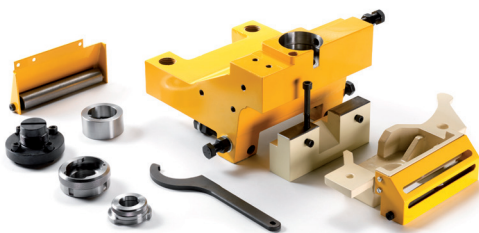
STANDARD PUNCHING EQUIPMENT



Hydracrop 110 standard punching equipment



Hydracrop 165 standard punching equipment



Hydracrop 220 standard punching equipment



Bendicrop standard punching equipment

Standard punching equipment

This equipment allows punching / forming in different materials using a punch and a die in the likeness of a press. The maximum capacity for each machine is given by the punching station power.

These values are expressed in Kilo Newtons or Metric Tons.

Machine	Punching Power (KN)	Maximum Capacity (mm)
Microcrop	360	Ø 27 x 10
Minicrop	450	Ø 27 x 13
Multicrop	450	Ø 27 x 13
Bendicrop 50	500	Ø 31 x 12 Ø 28 x 13
Bendicrop 60	600	Ø 31 x 12
Bendicrop 85	850	Ø 28 x 13
Hydracrop 55/110	550	Ø 40 x 10 Ø 20 x 20
Hydracrop 80/150	800	Ø 40 x 14 Ø 24 x 24
Hydracrop 110/180	1100	Ø 40 x 20 Ø 28 x 28
Hydracrop 165/300	1650	Ø 40 x 30 Ø 34 x 34
Hydracrop 220/300	2200	Ø 40 x 40 Ø 40 x 40

Capacities based on material resistance of 45 Kg/mm²

NOTCHING STATION

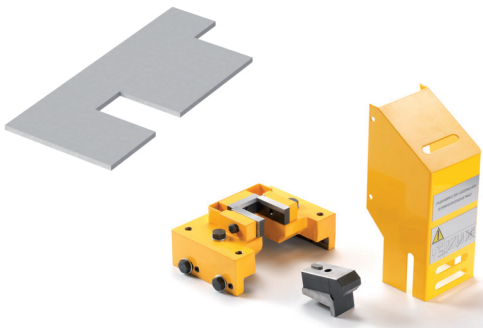
Standard rectangular notching equipment

This accessory allows obtaining rectangular cuts on the outer perimeter of a sheet or profiles.
(Open notches)

The maximum capacity for this equipment is:

Machine	Width (mm)	Lenght (mm)	Material Thikness (mm)
Minicrop	40	50	7
Multicrop	40	50	7
Bendicrop 50	42	90	10
Hydracrop 55/110	42	90	10
Hydracrop 80/150	52	90	12
Hydracrop 110/180	52	90	13
Hydracrop 165/300	58	110	16
Hydracrop 220/300	58	110	16

Capacities based on material resistance of 45 Kg/mm²



Minicrop & Multicrop standard rectangular notching equipment



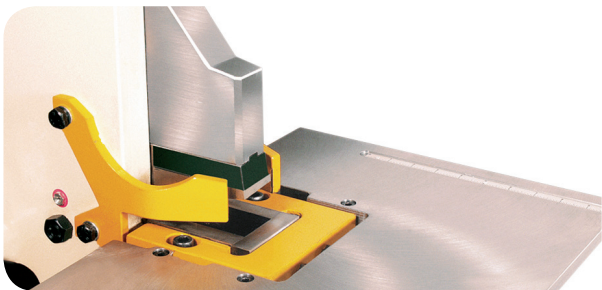
Hydracrop 55 standard rectangular notching equipment



Hydracrop 80 & 110 standard rectangular notching equipment



Hydracrop 165 & 220 standard rectangular notching equipment



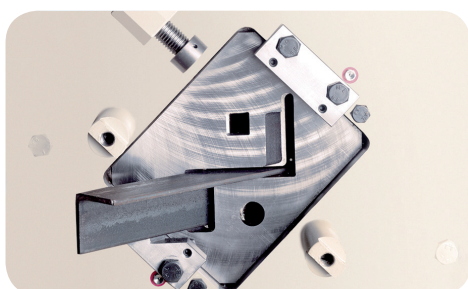
Bendicrop standard rectangular notching equipment

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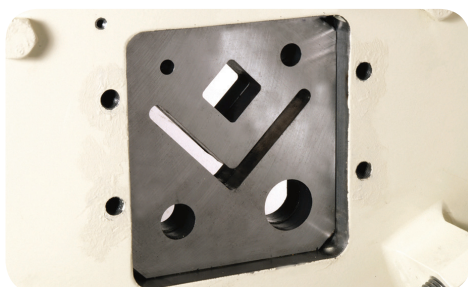
CUTTING STATION OF Ø AND ▣



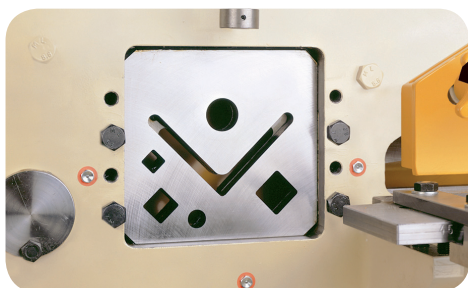
Hydracrop standard cutting of Ø and ▣



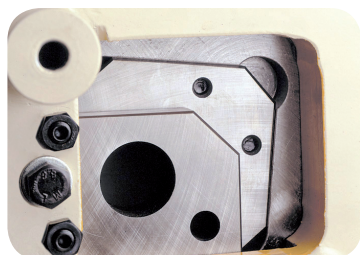
Multicrop standard cutting of Ø and ▣



Bendicrop standard cutting of Ø and ▣



Minicrop standard cutting of Ø and ▣



Microcrop standard cutting of Ø and ▣

Standard cutting of Ø and ▣

This station allows cutting round and square bars.

Each type of machine has a different capacity for the maximum size of round and square bars.

These capacities are shown in the following table.

Machine	Round bar (mm)	Square bar (mm)
Microcrop	35	30
Minicrop	30	30
Multicrop	25	22
Bendicrop 50	35	30
Bendicrop 60	45	40
Bendicrop 85	45	40
Hydracrop 55	40	40
Hydracrop 80	45	45
Hydracrop 110	50	50
Hydracrop 165	60	60
Hydracrop 220	60	60

Capacities based on material resistance of 45 Kg/mm²

This station allows, under special design cutting other bars, several profiles and various combinations.

L CUTTING STATION

Standard cutting of L 90°

This equipment allows cutting L profiles at 90 °. In some models, such equipment can excel at 45° mitering.

The capacities are as following ones for shearing WITHOUT deformation:

Machine	Capacity (mm)	Excel
Microcrop	80 x 80 x 8	50
Minicrop	80 x 80 x 8	-
Multicrop	80 x 80 x 8	60
Bendicrop 50	80 x 80 x 8	-
Bendicrop 60	120 x 120 x 10	-
Bendicrop 85	120 x 120 x 10	-
Hydracrop 55	120 x 120 x 10	70
Hydracrop 80	130 x 130 x 13	70
Hydracrop 110	152 x 152 x 13	70
Hydracrop 165	205 x 205 x 18	70
Hydracrop 220	205 x 205 x 18	70

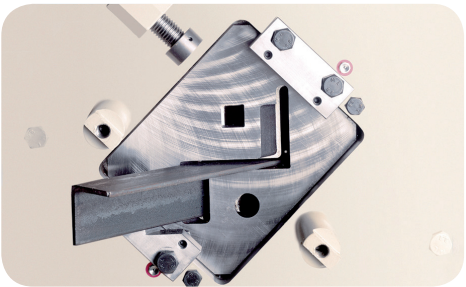
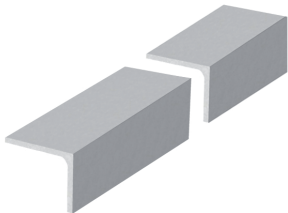
Capacities based on material resistance of 45 Kg/mm²

There is a possibility of shearing in larger profiles but with a slight deformation.

The capacities of these profiles are shown in the following table.

Machine	Capacity (mm)
Microcrop	-
Minicrop	100 x 100 x 10
Multicrop	-
Bendicrop	-
Hydracrop 55	130 x 130 x 13
Hydracrop 80	152 x 152 x 13
Hydracrop 110	160 x 160 x 16
Hydracrop 165	205 x 205 x 25
Hydracrop 220	205 x 205 x 25

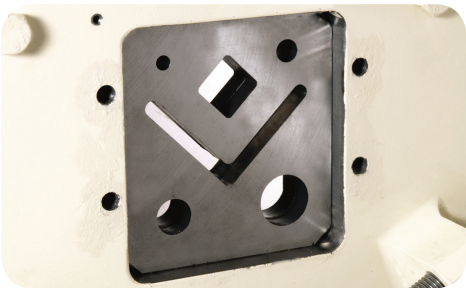
Capacities based on material resistance of 45 Kg/mm²



Multicrop standard cutting of L



Minicrop standard cutting of L



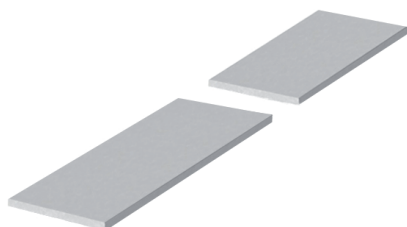
Bendicrop standard cutting of L



Hydracrop standard cutting of L

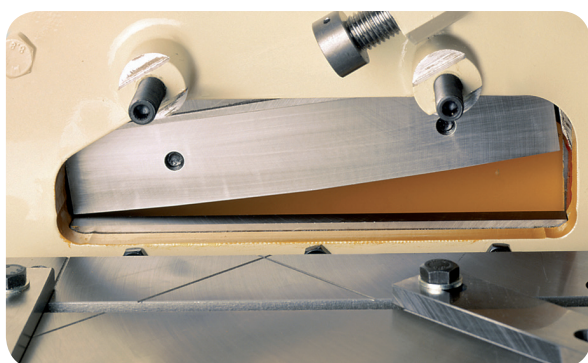
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FLAT BARS CUTTING STATION

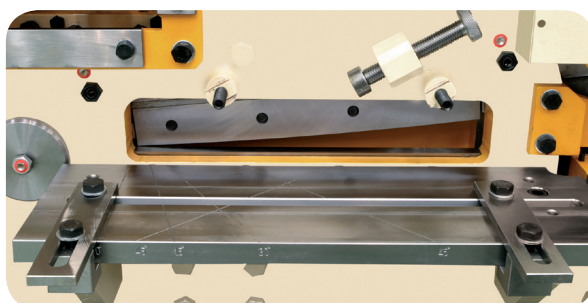


Standard cutting of flat bars

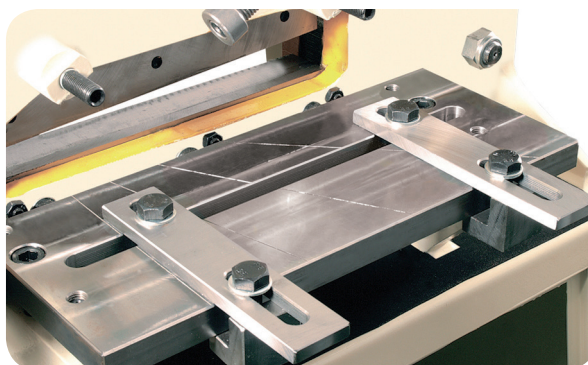
The cutting of the flat bars station is simple, and without any material waste.



Minicrop standard cutting of flat bars



Hydracrop standard cutting of flat bars



Bendicrop standard cutting of flat bars

Machine	Capacity (mm)
Microcrop	350 x 6 200 x 13
Minicrop	300 x 10 200 x 13
Multicrop	300 x 10 200 x 13
Bendicrop 50	350 x 10 350 x 15
Bendicrop 60	350 x 10 350 x 15
Bendicrop 85 SD	450 x 15 450 x 18
Hydracrop 55	300 x 15 200 x 20
Hydracrop 80	450 x 15 300 x 20
Hydracrop 110	600 x 15 400 x 20
Hydracrop 165	750 x 20 400 x 30
Hydracrop 220	750 x 20 400 x 30

Capacities based on material resistance of 45 Kg/mm²





02.

OPTIONAL ACCESSORIES

OPTIONAL ACCESSORIES

GEKA has a wide range of optional accessories that are easily installed, for the punching, cutting and notching stations that will allow you to increase your production levels and shorten your delivery deadlines.

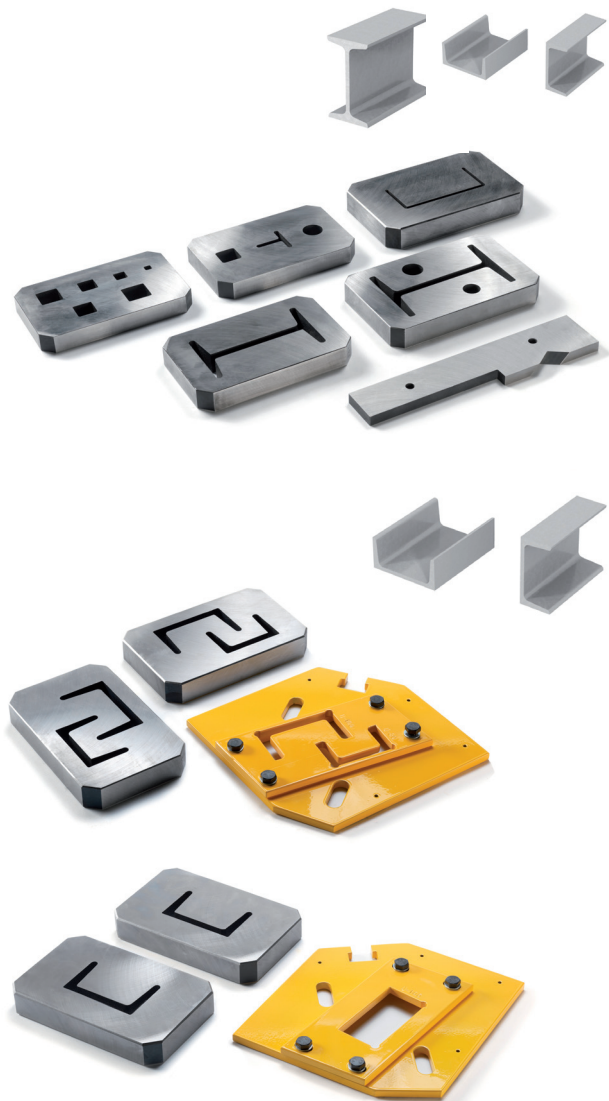
These accessories, available in stock, provide our customers with a fast and economical solution to their needs. Our philosophy is to cover the production needs of our customers with the best quality and in the fastest time possible.

U and I profile cutting

Another common combination in this station is the cutting of U and I profiles. Different combinations may also be obtained after close study. The following table gives the maximum dimension of the profile U and I.

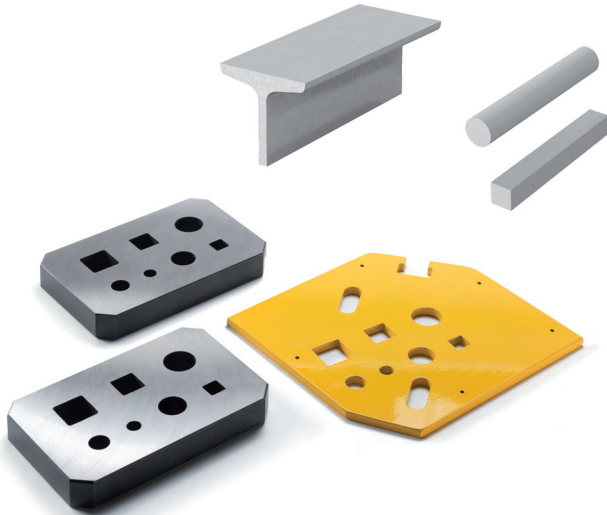
Machine	U & I cutting capacity (mm)	T cutting capacity (mm)
Microcrop	till 50	50
Minicrop	till 100	100
Multicrop	till 100	100
Bendicrop 50	till 100	100
Benicrop 60	till 120	100
Benicrop 85	till 120	100
Hydracrop 55	till 120 for U till 100 for I	80
Hydracrop 80	till 140	80
Hydracrop 110	till 160	100
Hydracrop 165	till 180	120
Hydracrop 220	till 180	120

Capacities based on material resistance of 45 Kg/mm²



02

OPTIONAL ACCESSORIES



T profile cutting & Round and square bar cropping

After study, you can get multiple combinations; the limitation is given by the shearing tonnage necessary or resulting sections in each combination.

A common combination is in T profile, bars. The table indicates the maximum T profile can be sheared on each machine model. The blades are easily changeable from one set to another.



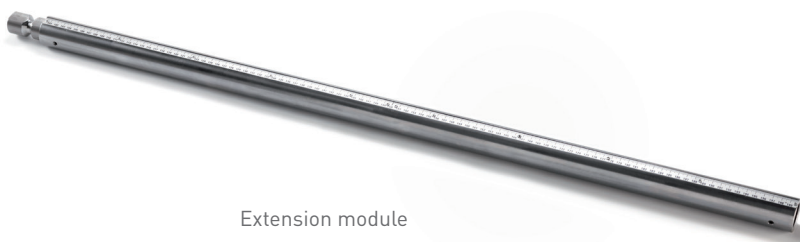
Hydraulic hold-down

Electric "Touch & Cut" length stop and extension module for angles and flats

Common element for all machine models. This tool allows us to make cuts of equal length automatically. You can lead all machine stations (profiles, carved, tires ...)

The base module can cut up to a meter or not doing repetitive work.

You can add quick connect extension modules, expandable meter by meter, needing support for these extensions.



Extension module

PUNCHING STATION

**Oversize punching unit
up to 100 mm in Diameter**

This equipment allows obtaining the cut of geometric figures on flat surfaces. The punch must have the desired shape and figure which should circumscribe up to a diameter of 100 mm. The die must have the same shape with proportional set to the thickness of the material.

The table provides the maximum in thickness to be punched or maximum perimeter values by corresponding thickness.

Machine	Ø x max. thickness (mm)	Ø max. x thickness (mm)
Microcrop 36	Ø 17 x 16	Ø 38 x 8
Minicrop / Multicrop	Ø 18 x 18	Ø 100 x 4
Bendicrop 50	Ø 19 x 19	Ø 100 x 4
Bendicrop 60	Ø 24 x 24	Ø 100 x 5
Bendicrop 85	Ø 24 x 24	Ø 100 x 6
Hydracrop 55	Ø 20 x 20	Ø 100 x 4
Hydracrop 80	Ø 24 x 24	Ø 100 x 6
Hydracrop 110	Ø 29 x 29	Ø 100 x 8
Hydracrop 165	Ø 34 x 34	Ø 100 x 12
Hydracrop 220	Ø 40 x 40	Ø 100 x 16
L50	Ø 20 x 20	Ø 40 x 9
L50P	Ø 20 x 20	Ø 50 x 7
Puma 55	Ø 20 x 20	Ø 100 x 4
Puma 80	Ø 24 x 24	Ø 100 x 6
Puma 110	Ø 29 x 29	Ø 100 x 8
Puma 165	Ø 34 x 34	Ø 100 x 12
Puma 220	Ø 40 x 40	Ø 100 x 16

Capacities based on material resistance of 45 Kg/mm²

**Oversize punching unit
up to 160 mm in Diameter**

This punch allows punching from ø 3 mm to ø 160 mm and or figures of various shapes: round, square, rectangular, slotted, hexagonal ... circumscribed in its various punches and dies.

The equipment is composed of different punches- and dies adapters for each tool in order to achieve an optimal position.

The punches can have in their cutting zone an angular termination, ie not completely flat or perpendicular to the motion. Achieving thereby a better cutting, reducing stress and increasing the cutting section.



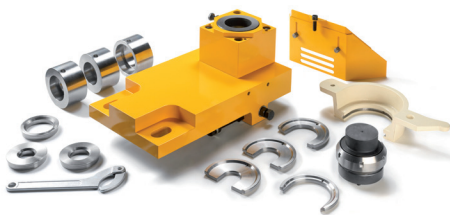
Microcrop oversized punching unit



Bendicrop & Multicrop oversized punching unit



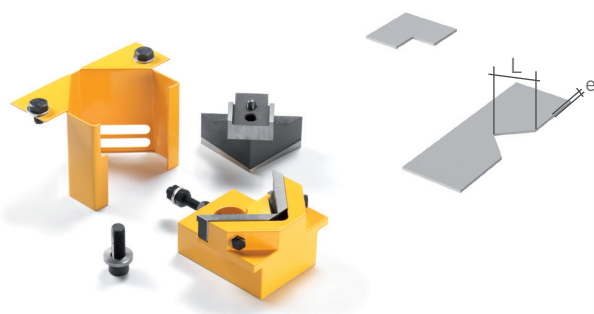
Hydracrop 55 oversized punching unit



Hydracrop 165 oversized punching unit

02

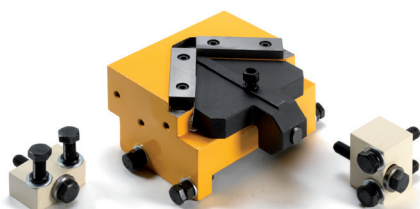
NOTCHING STATION



Microcrop triangular notching



Minicrop& Multicrop triangular notching



Hydracrop 55 triangular notching



Hydracrop 80 triangular notching



Hydracrop 110 triangular notching

Triangular notching

The notching is formed by a moving upper blade and two lower blades fixed to a lower die base. This accessory makes notches at 90°.

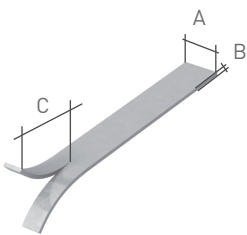
Machine	L x L x e (mm)
Microcrop	80 x 80 x 8
Minicrop	80 x 80 x 7
Multicrop	80 x 80 x 7
Bendicrop 50	100 x 100 x 10
Bendicrop 60 (STANDARD)	100 x 100 x 10
Bendicrop 85 (STANDARD)	130 x 130 x 12
Hydracrop 55	100 x 100 x 10
Hydracrop 80	130 x 130 x 12
Hydracrop 110	130 x 130 x 13
Hydracrop 165	155 x 155 x 16

Capacities based on material resistance of 45 Kg/mm²

NOTCHING STATION

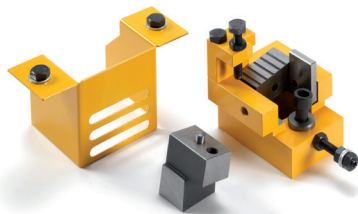
Claw equipment

This equipment allows opening the cut flat bars legs in a claw-shaped way (Separation in the cutted areas).

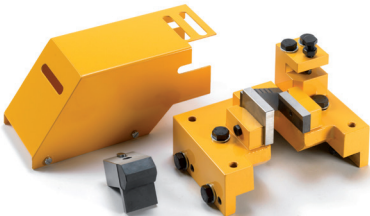


Machine	A (mm)	B (mm)	C (mm)
Microcrop	60	5	40
Minicrop	80	5	40
Multicrop	80	5	40
Bendicrop 50	50	6	43
Bendicrop 60	60	8	53
Bendicrop 85	60	8	53
Hydracrop 55	50	6	43
Hydracrop 80	60	8	53
Hydracrop 110	60	8	53
Hydracrop 165	60	8	59

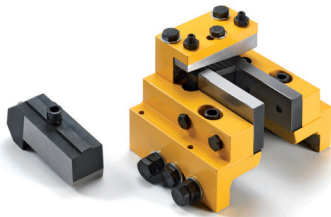
Capacities based on material resistance of 45 Kg/mm²



Microcrop claw equipment



Minicrop claw equipment



Hydracrop 55 claw equipment



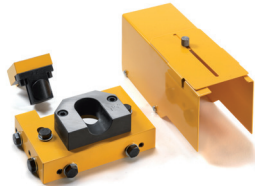
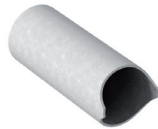
Hydracrop 80 & 100 claw equipment

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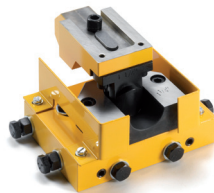
NOTCHING STATION



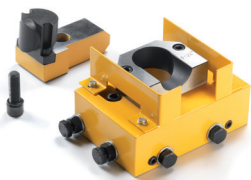
Microcrop tube notching



Minicrop tube notching



Hydracrop 55 tube notching



Hydracrop 80 tube notching



Hydracrop 165 tube notching

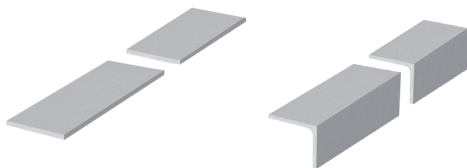
Tube notching

This equipment allows notching tubes at 90 ° with equal or different diameters. The standard equipment is designed for tubes up to Ø 2".

This option is available in punching unit of the machine and has appropriate equipment.

In the Microcrop the tube notching is only available in the punching station.

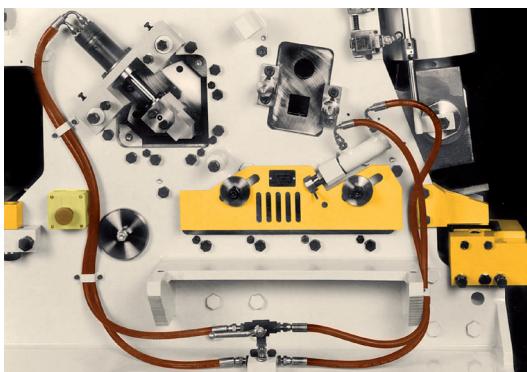
ANGLES AND FLAT BARS SHEARING STATION



Hydraulic hold-down for angles and flat bars

This accessory is only available in the Hydracrop range and must be mounted by GEKA in the original machine in the factory.

Its purpose is to secure angular sections and flat bars, using a hydraulic drive mechanism. This mechanism applies pressure to the material before it is cut to prevent movement of the material being processed. Once the material has been cut, the hold-down will withdraw to allow the entry of new material.

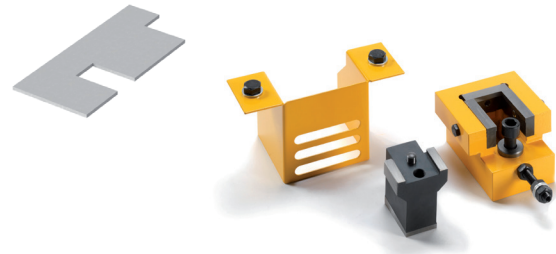


OPTIONAL ACCESSORIES

Rectangular notching – Microcrop

The rectangular notching is an optional accessory in the Microcrop.

The maximum capacities are the following ones: 36 mm of width, 53 mm length and 8 mm of thickness.

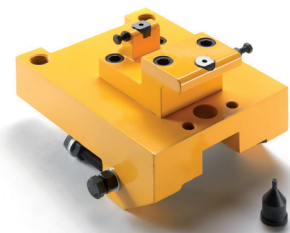
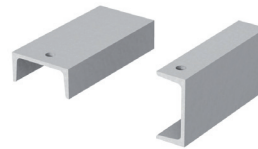


Punching unit UPN from 40 to 80 mm.

Substituting the lower base of the standard punching, this equipment allows punching in UPN from 40mm to 80mm in flanges and webs.

The maximum allowed diameter is 14mm. In rotating the die holder its design gives the possibility to use both options: flanges and webs

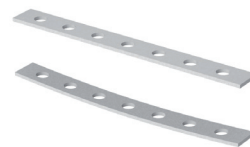
This equipment is only available for the range of Geka Hydracrop.



Urethane stripper

The urethane stripper attachment is designed to hold the flat material while being punched, in order to avoid deformation.

Designed and manufactured according to European regulations on safety.



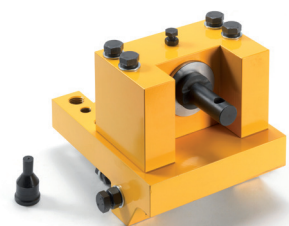
Punching at the end of tube

This optional accessory allows punching at the ends of round or square tubes.

Square tubes up to 38 mm in diameter.

Round tubes up to 70 mm in diameter.

This accessory is only available for Hydracrop series.



OPTIONAL ACCESSORIES

Flip Stop

It is a manually-adjustable mechanical stop unit to punch holes in a straight line.

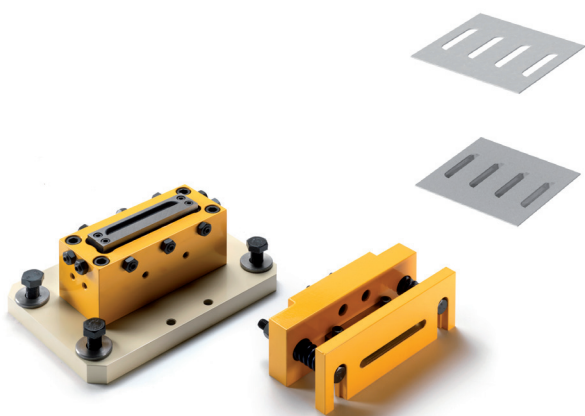
The unit consists of a work surface, to be mounted on the machine, with 2 stops to control depth and one ruler, 2 metres long per module, which is mounted after the die holder, with 8 additional retractable stops per module.

**Louvre Notching**

The folding is to obtain a sheet metal part with straight edges and generatrices.

This unit of the Geka machines require, dismantling and clear the punching area. In this way we locate this useful tool to make this work.

This unit meets the European directives relevant to the manufacture of this type of industrial machines. In the European Union Geka sells only Bendicrop model.



PUNCHING STATION

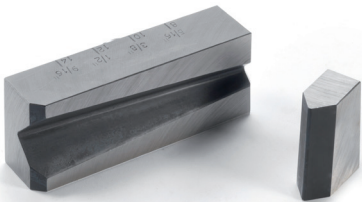
Standard Press Brake

The folding is to obtain a sheet metal part with straight edges and generatrices.

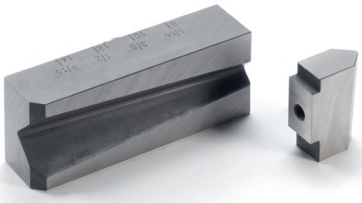
This unit of the Geka machines require, dismantling and clear the punching area. In this way we locate this useful tool to make this work.

This unit meets the European directives relevant to the manufacture of this type of industrial machines.

	Press brake power (KN)	Max. Capacity (mm)
Microcrop	360	80 x 12
Minicrop	450	80 x 14
Multicrop	450	80 x 14
Hydracrop 55 S	550	500 x 3 300 x 10
Hydracrop 80 S	800	600 x 3 350 x 10
Hydracrop 110 S	800	700 x 3 400 x 10
Hydracrop 165 SD	1650	700 x 3 400 x 12
Hydracrop 220	2200	700 x 3 400 x 12



Minicrop & Multicrop standard press brake



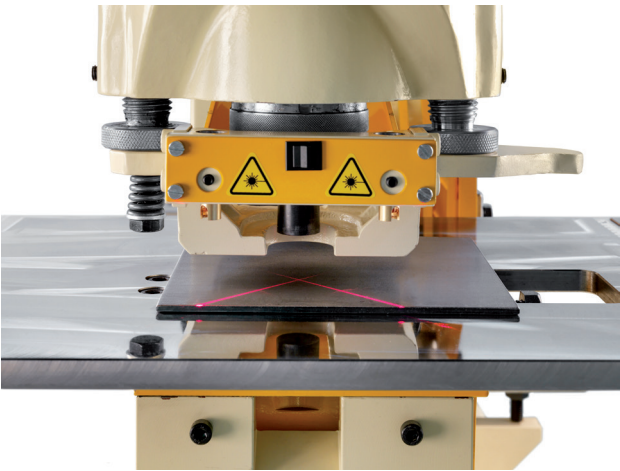
Minicrop & Multicrop standard press brake

Laser Positioner

This equipment has 2 linear lasers integrated in the Punching Stripper. Both laser beams cross in the middle of the punch & die. Therefore, you can lay the piece easily just placing the punching point exactly where the lines cross.

The feeding is independent from the electric box. The lasers are fed by a Lithium battery (long lasting) which are integrated in the Punching Stripper.

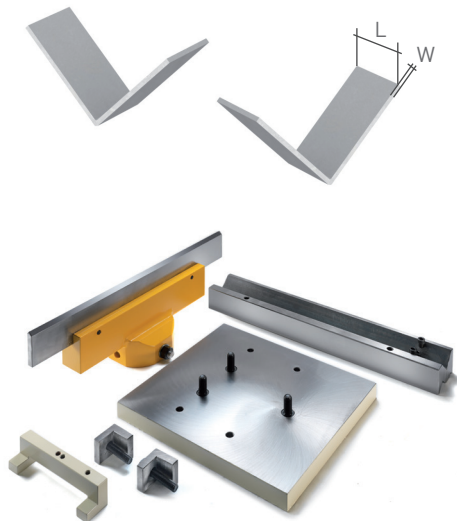
Because of this, to mount a laser positioning equipment in an Ironworker, you only need to change the standard punching stripper with another with the laser equipment incorporated.



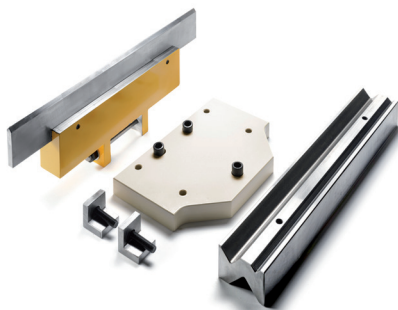
02

PUNCHING STATION

2 Positions Press Brake: Transversal and Longitudinal



Longitudinal press brake



Transversal press brake

This folding operation, gives the possibility of placing the tool parallel and transversely to the machine. The throat deep conditions the length of the bend.

Designed and manufactured in accordance with European regulations on safety. The transversal brake is only available for models of Geka Hydracrop and Puma's.

	L (mm)	W (mm)
Microcrop	80	12
Minicrop	80	14
Multicrop	80	14
Hydracrop 55 S	300	6
Hydracrop 55 SD	500	6
Hydracrop 80 S	400	6
Hydracrop 80 SD	600	6
Hydracrop 110 S	400	6
Hydracrop 110 SD	700	6

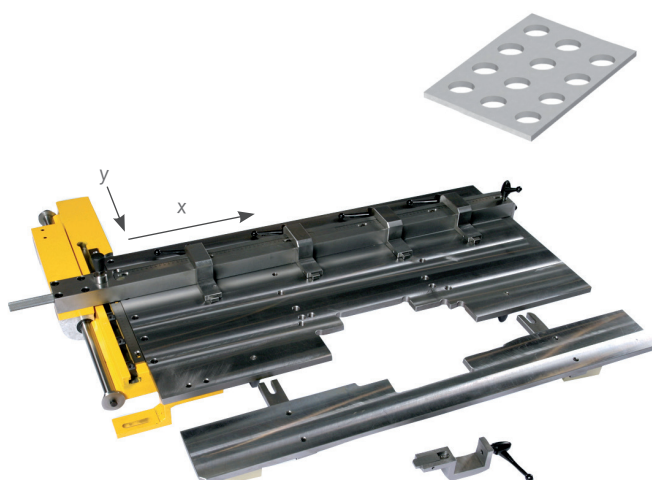
Multistop Table

This is a manual unit which is to be mounted on PUMA or Hydracrop SD machines with a minimum throat of 500mm/20".

It has 5 retractable keyed stops mounted on a cross bar which slides of a guided arm.

The front part of the table can be removed for punching angles and channels. The stops can be moved approx. 500mm/20" from the middle of the die to the left and approx. 500mm/20" to the right. The depth capacity is approx. 350mm/13-3/4".

Adjustments are made manually on the millimeter scale, on the two axes.







03.

SPECIAL ACCESSORIES

PUNCHING STATION

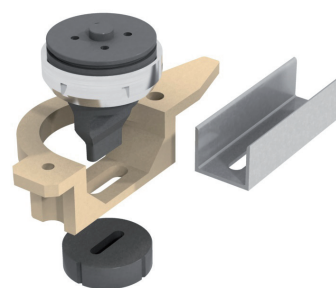
On many occasions, our users need to carry out special jobs, which do not fit in with any of the classical options of Conventional Punching Shears.

For this reason, GEKA makes available to its users a team of Engineers, with extensive experience in the development of all kinds of tools and special applications.

Our versatility and continuous innovation allows us to continue being faithful to our goal of adapting to the needs of our customers.

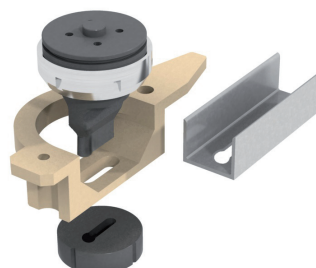
Punching Oblong Special L and U

This option allows the client using extra-long punches to punch the inside of L and U profiles in an oblong way.



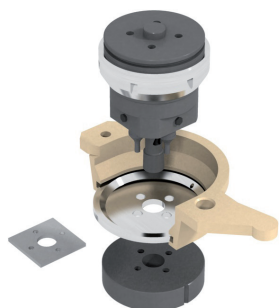
Key Notching in U

This accessory allows the client using extra-long punches to punch the inside of U profiles in a Key-shaped way.

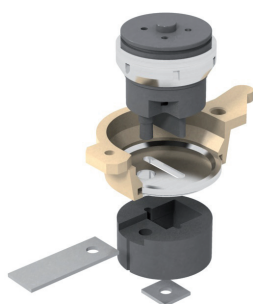


03

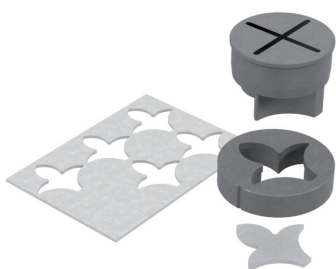
PUNCHING STATION

**Multiple Punching**

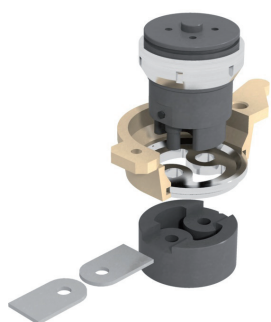
The multiple punching of this equipment allows making different combinations of diameters and distances.

**Cutting and Punch of Flat Bars**

By simultaneous cutting and punching of the flat bar, we can obtain small parts.

**Flower Shaped Punching**

It is possible to obtain simple and varied shapes by punching of the Oversize Punching units. It is useful for trellises, fences ...

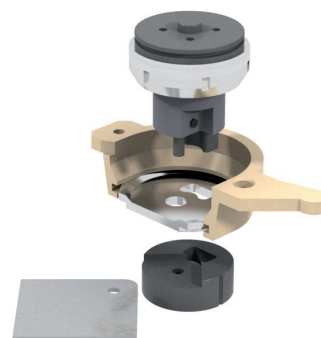
**Shearing, Notching and 2 Punches**

Shearing and Notching the flat bars is another possibility that can be made with the oversize punching units.

PUNCHING STATION

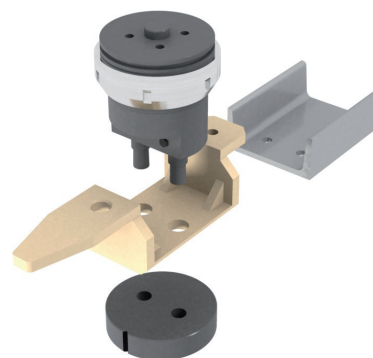
Flat bar rounding and punching

This tool allows rounding and punching flat bars at the same time.



Double punching UPN

This option allows making double punching in the webs of the profiles.



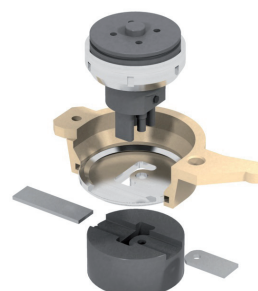
Punching + Emboss formed

Simple shapes can be punched and emboss form in only one stroke.



Flat Bars Rounding / Straight Cut + Punching

Rounding, straight cut and punching at the ends of flat bars is another possibility that can be made with the over-size punching unit.

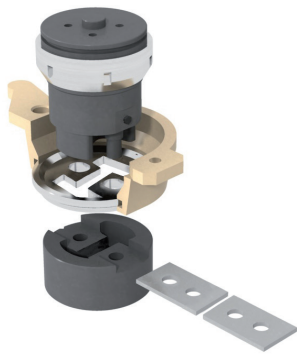


03

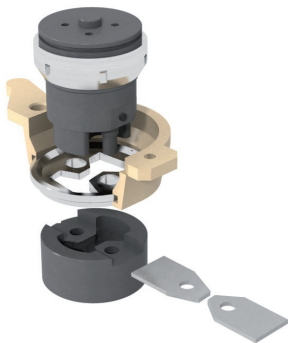
PUNCHING STATION

Straight Cutting + Punching

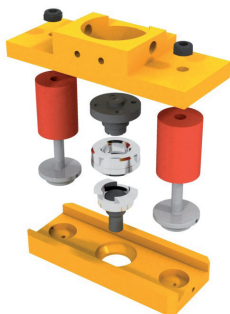
Flat bars can be punched and cut with a straight end.

**Radius and 2 Punches**

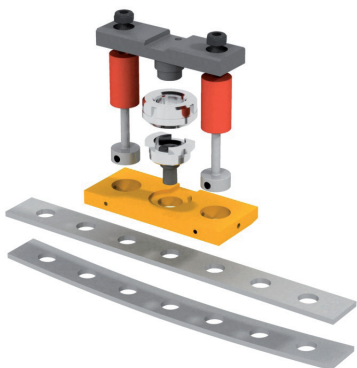
Flat bars can be punched twice and cut with a radiused end.

**Urethane Hold-Down for Hydracrop**

The punching of multiple holes close to each other in flat bars causes deformations on these bars. This stripper corrects this deformation generated by the tension of punching.

**Urethane Hold-Down for Microcrop and Minicrop**

The punching of multiple holes close to each other in flat bars causes deformations on these bars. This stripper corrects this deformation generated by the tension of punching.



PUNCHING STATION

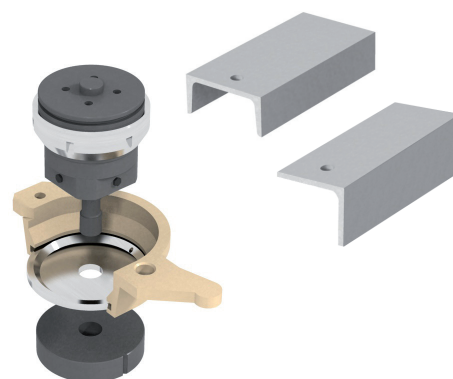
Rounding and Punching of Flattened Pipes

After previously flattening the tube, this equipment allows rounding and punching their flattened ends.



Profiles Punching

This option allows using extra-long punches and a stopper extractor to punch the inside of different profiles.



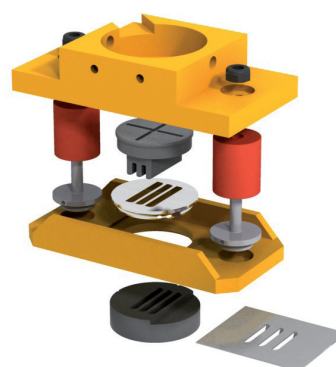
Notching of Louvres with No. 13 punch

With the Oversize Punching Unit, the customer can get Louvers of different size in their material.



Notching of Louvers with Hold-Down

With the Oversize Punching Unit the customer can get Louvers of different size in their material.
This option includes a hold-down to get a better finish.



03

PUNCHING STATION

Notching of Louvers

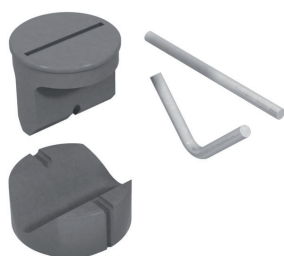
With the Oversize Punching Unit the customer can get Louvers of their material.

**Chain Shearing**

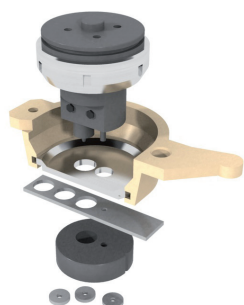
A Punch and Die with a triangular form, allow the cutting of chains.

**Bars Bending**

One or more bars can be bent with when adding this tool to the Oversize Punching Unit.

**Metal Ring Punching**

Through a guided and double Punch and Die small sized Washers can be obtained.



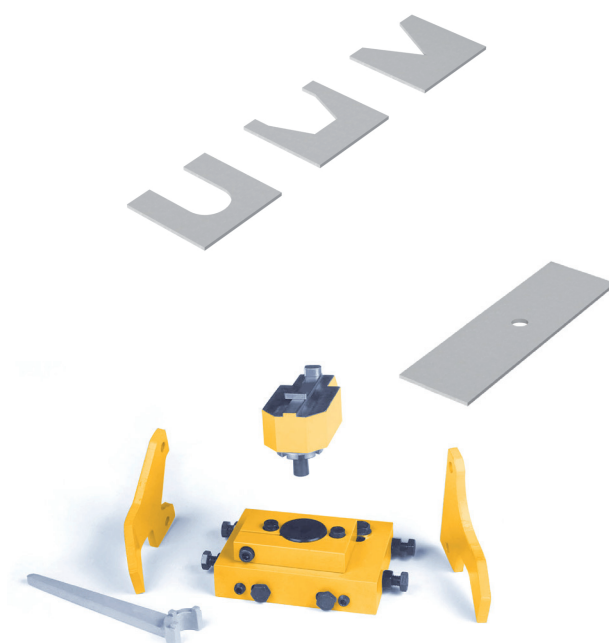
NOTCHING STATION

Special Notching per Drawing

The notching unit of the machine allows different shapes as needed.

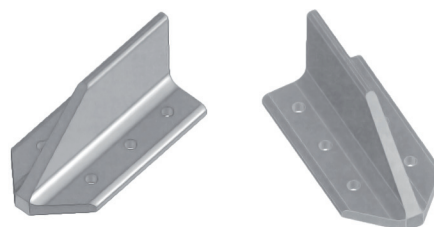
Punching in the Notching Unit

This tool allows us to punch in small widths materials or in the edges of flat bars with large dimension.



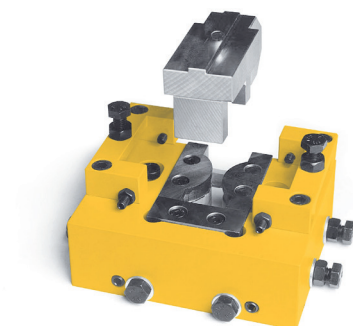
Flat bar Notching for T profiles

Some T profiles can be notched in the web and flanges after previous study.



Rounding of Flat Bars in the Notching Unit

This option allows rounding flat bars in the notching unit.



03



Should any of our registered accessories not be what the customer is looking for, our Technical Department is at your disposal to develop the necessary accessory.







World leader in punching and shearing solutions

With more than 80,000 happy and satisfied customers worldwide and more than 90 years experience.



Proven quality, design and craftsmanship

ISO 9001 and OHSAS certifications with 90 years experience and a continuous benchmarking policy.



Complete after sales service

Permanent stock and next day delivery of consumables, accessories and parts. After sales assistance by GEKA's qualified engineers.



Great versatility

More than 50 different machine models and over 8,000 different accessories. GEKA offers the highest range in accessories and optional equipment in the market.



Produced & manufactured in the European Union

Unlike other manufacturers, GEKA is the only ironworker fully produced by GEKA in the UE.



Continuous innovation

New Bendicrop 85, C2PL, Alfa 500, Alfa 150...



Worldwide distribution network

With more than 60 distributors and present in more than 85 countries in 5 continents.



All GEKA machines are special order

Every new GEKA machine is one of a kind. Our designers develop solutions suited to your specific needs. We manufacture each GEKA in our own facilities according to precisely defined standards.



GEKA Worldwide

Know-how and market share characterize our GEKA success story since our humble beginnings almost a century ago. In the first ninety years, the GEKA Group has forged for itself a proven track record of excellence and performance.

- Over 80% of our production is exported
- Our global network consisting of 60 local distributors all over the world
- Worldwide sales in over 85 countries
- On-demand customer care offering superior service and maintenance

On any given day, more than 80,000 GEKA machines are pounding away on five different continents. Now that's customer satisfaction!





geka-group.com

