For nearly half a century
COMEQ has been North America’s leading importer of metal fabricating machinery!

Our mission has always been to help our customers maximize the return on their investments by providing the best technology available for their applications.

We believe that through technology, innovation and communication, we can help deliver the positive results our customers demand. Our sales team is experienced, qualified and backed up by our “we stand behind every machine we sell” philosophy! This allows us to offer our customers specific solutions to meet their fabricating machinery needs.

Your vision and our world-class machinery, combined with a great support staff, equals success! Let us help you shape the world!
Since 1919, GEKA Group has been manufacturing ironworkers for angle work, strips and profiles – for metal workshops, metal construction, telecommunication and electricity towers, and generally, all that is related with fabrication and manufacturing.

Almost 100 years of effort, hard work and dedication have earned GEKA the position of THE WORLD’S NUMBER ONE SELLING IRONWORKER.

From their first ironworkers, things have changed a lot. Market needs, new technologies and improvement in metal production, have made GEKA Group adapt its machinery to match the ever-changing times.

GEKA has a history of innovations, evolving from the first manually operated shear and punching machines to mechanically operated and now, hydraulic machines with CNC controls and automated systems.

**EXPERIENCE**
Over 90 years of manufacturing ironworkers. GEKA has been a pioneer in developing ironworkers, continually adapting and improving them to meet market and clients’ needs.

**QUALITY**
GEKA machines all of its parts and tooling in-house, to quality standards that are much higher than any of their competitors.

**EVOLUTION**
GEKA’s CNC solutions for automatic processing of profiles combines their large experience in punching and shearing with state-of-the-art electronics. As a result, they offer to the market advanced machines with an excellent value-to-quality balance.

**VERSATILITY**
GEKA’s technical department can design and provide almost any accessory so that your machine can face any job that is thrown at it.

**R & D**
GEKA continues to research, develop and innovate to fulfill customer and market requirements.

**IRONWORKERS**

**SINGLE CYLINDER**
SINGLE-CYLINDER HYDRAULIC IRONWORKERS feature 40 & 50-ton punch, 3” x 3” x 5/16” angle and 12” x 3/8” plate shear capacity. The design of the GEKA punching and shearing machine makes the tool replacement procedure easy, quick and practical.

**THIS PUNCHING MACHINE FEATURES 3 WORK STATIONS:**
- Punching  • Shear for Flat Bar  • Angle Cutting
Excellent cutting quality on the shearing of flat bar station.

<table>
<thead>
<tr>
<th>FEATURES</th>
<th>MICROCROP</th>
<th>MINICROP</th>
<th>BENDICROP 50</th>
</tr>
</thead>
<tbody>
<tr>
<td>SHEARS FOR FLAT BAR</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Flat Bar (with slight deformation)</td>
<td>8” x ½”</td>
<td>8” x ½”</td>
<td>14” x ¾”</td>
</tr>
<tr>
<td>Length of Blade</td>
<td>14”</td>
<td>12”</td>
<td>14”</td>
</tr>
<tr>
<td>Round Bar Ø</td>
<td>1 ⅜”</td>
<td>–</td>
<td>1 ¾”</td>
</tr>
<tr>
<td>Square Bar Ø</td>
<td>1”</td>
<td>–</td>
<td>1 ¼”</td>
</tr>
<tr>
<td>SHEARS FOR SECTION IRON</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L at 90˚</td>
<td>3” x 3” x ⅜”</td>
<td>3” x 3” x ⅜”</td>
<td>3” x 3” x ⅜”</td>
</tr>
<tr>
<td>PUNCHING</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Punching Power</td>
<td>40</td>
<td>50</td>
<td>55</td>
</tr>
<tr>
<td>Maximum Capacity</td>
<td>Ø 1 ⅜” x ¾”</td>
<td>Ø 1 ⅜” x ½”</td>
<td>Ø 1 ⅜” x ½”</td>
</tr>
<tr>
<td>Throat</td>
<td>6⅜”</td>
<td>6⅜”</td>
<td>7”</td>
</tr>
</tbody>
</table>
BENDICROP

In addition to the five usual punching shearing stations (punching, notching, shear for flat bars, angle cutting, counting of round and square bars), GEKA’s NEW Bendicrop models feature a permanent built-in bending section and safety system.

Sizes available include 60 S, 60 SD, 85 S and 85 SD.

BENDICROP 60 SD

FEATURES

SHEARS FOR FLATBAR
Shears of Flatbar 14” x 9⁄16”

SHEARS FOR SECTION IRON
L at 90˚ 4” x 4” x ½”
Round Bar Ø 2”
Square Bar Ø 1 ½”
Working Height 42 ½”

PUNCHING
Punching Power 65
Maximum Capacity Ø 1 ½” x ¾”
Throat 20”

DUAL CYLINDER

HYDRACROP

Where production requires twin-operator machines, higher speeds, or greater capacity, GEKA provides the solution with the HYDRACROP range with five work stations.
• Punching
• Flat Bar Shearing
• Section Shearing
• Round Bar Ø and Square Bar Ø Shearing
• Notching

DUAL-CYLINDER HYDRAULIC IRONWORKERS feature 60, 88, 120, 185 & 240-ton punch, 4” x 4” x ½” up to 8” x 8” x ¾” angle and 12” x 5⁄8” up to 20” x 1” plate shear capacity.

HYDRACROP 110/180

FEATURES

Shearing of Flat Plate 24” x ½”
16” x ¾”

L Cut with Standard Blade (no distortion): 6” x 6” x ½”
L Cut with Optional Blade (minor distortion): 6” x 6” x ¾”

Shearing of Round Ø and Square bars Ø 2”
Punching Capacity Ø 1 ½” x ¾”

S and SD models. The SD Version has the same features as the S model, but with a deeper throat for larger plate and sheet metal applications.
CNC CONTROLLED PUNCH POSITIONING TABLES AND CNC CONTROLLED PLATE FEEDING & SHEARING SYSTEMS

CNC's save the time of costly layout & plate handling, improve hole accuracy, eliminate template preparation, increase production & reduce the high cost of inventory.

SEMIPAXY (POSITIONING)

GEKA's Semipaxy product line brings the newest touch screen CNC automation technology to punching. This unit is equipped with programmable stops along the X and Y Axis. This can be mounted on existing or new GEKA models with a minimum throat of 20". Standard X Axis is 40" and the Y Axis is 16" or 20" depending on the throat of the machine.

- Support Chassis
- Two Servo Motor-Driven Positioning Carriages
- Touch Screen
- Conveyor Assembly Consisting of Independent Servo Drives along each Axis, Spindle and Encoder Unit

SEMIPAXY X-Plus


ALRS System

The ALRS System is a CNC-controlled flat bar feeding and shearing system which can be mounted on the GEKA Hydracrop 80, 110 or 220 ton Dual-Cylinder Ironworkers.

This system is designed to feed flat bars automatically (using the CNC control and conveyor with hydraulic holddown) to the shearing station on the GEKA Hydracrop Ironworkers and eliminates the layout and manual positioning of the material resulting in a substantial savings in time and an increase in productivity and precision.

The unit consists of:
- Knurled drive roller with hydraulically controlled pinch roller
- DC Servo drive motor with rotary encoder
- Easily programmable Fagor 102 S CNC controller
- Positive hydraulic clamping
- Fixed conveyor rollers with adjustable straight guide rollers
- 19.5' roller bed conveyor. (Additional 10' sections of roller bed conveyor are also available.)
FULLY AUTOMATIC

GAMMA ROLLER SERIES

The GEKA GAMMA ROLLER SERIES features a full range of automated systems for punching and shearing flat plate, angle, beams and channel. Applications include steel truss structures, towers for electric transmission lines and telecommunication equipment, overhead railway power lines and any structure that requires a large amount of angular profiles.

<table>
<thead>
<tr>
<th>GAMMA ROLLER C2PL80</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum L</td>
</tr>
<tr>
<td>Maximum L</td>
</tr>
<tr>
<td>Marking</td>
</tr>
<tr>
<td>No Punches</td>
</tr>
<tr>
<td>Maximum Diameter</td>
</tr>
<tr>
<td>Punching Force</td>
</tr>
<tr>
<td>Shear Station Tonnage</td>
</tr>
<tr>
<td>* Flat Bar and U Channel Punching and Shearing Available</td>
</tr>
</tbody>
</table>

ALFA 150 AUTOMATIC PUNCHING SHEARS

Ideal for all work involving metal and the processing of large quantities of flat bars above 1”.

GAMMA TRACTION 100

A new line by GEKA Automation is a complete processing system for Punching, Marking and Shearing of Angles, numerically controlled and programmable by means of the CNC – PC based control.

| Minimum Angle | 1 1/2” x 1 1/2” x 3/16” |
| Maximum Angle | 4” x 4” x 3/8” |
| Number of Punches | Up to 4 (2 per wing) |
| Maximum Punch Diameter | 1 1/4” |
| Marking       | Impact |
| Punching Power | 55 Tons |
| Shearing Power | 165 tons |
| Accuracy      | Error = ± (0.009” + 0.001” “L” + gap between blades) |

Options available
- Automated Feeder
- Marking Unit
- Double Punching Unit
- Material Unloading System
- Line Pro Software
PLATE ROLL BENDING MACHINES

RSP SERIES – 3-ROLL BENDING MACHINES
The RSP series is designed for simplicity and production in mind.
- Bearings on All Roll Journals
- Rolling Pedestal Control for Easy Operator Involvement
- Standard Cone Rolling Attachment
- Variable Pinch Pressure – Helps Minimize Effects of Crowning and Controls Flat Ends
- Standard Hardened and Ground Rolls 50 – 60 RC

RDP SERIES – 4-ROLL BENDING MACHINES
The RDP series is a solid workhorse with more standard features than most of its competitors. Designed to reduce labor and rolling time.
- Positive Gear Interaction Even When the Pinch Roll is Down
- Rexroth Hydraulics
- Hydraulic Drive on All Machines (200 Series and Above)
- Standard Hardened and Ground Rolls 50 – 60 RC

STANDARD FEATURES
- Rolling Pedestal for Easy Operator Use
- Hydraulic Drive on All Machines (200 Series and Above)
- Grooves - .250" - .375" & .500" on All Machines Except 80 & 200 Series Machine
- Rectilinear Guide Design (Best for Reducing Flat Spots) – Swing Arm or Planetary Type Increases the Flat Spots!
- Anti-Friction Material (On All Roll Supports to Reduce Maintenance and Friction During Roll Adjustment)
- Bearings on All Roll Journals
- Easy Tilt Control of the Rolls
- Standard Hardened and Ground Rolls 50 – 60 RC

Both machines outperform expectations and are a far greater value than their nearest competitors.
MBX 1250/30 2250

33 Tons up to 60 tools with 30-Auto-Index stations including one Multitool

<table>
<thead>
<tr>
<th>Y axis with Multitool/Monopunch (mm)</th>
<th>1250/30-2250</th>
<th>1250/30-1300</th>
</tr>
</thead>
<tbody>
<tr>
<td>Y = 1250</td>
<td>1300/1250</td>
<td>1300/1250</td>
</tr>
<tr>
<td>X axis (mm)</td>
<td>2250</td>
<td>1300</td>
</tr>
</tbody>
</table>

Max. hit rate (1/min – 1 mm stroke):
Punching with 20 mm pitch: 300/250
Nibbling with 1 mm pitch: 625/550

MTX FLEX

<table>
<thead>
<tr>
<th>Max. punching force (kN)</th>
<th>1250/30-1300</th>
<th>1250/30-2250</th>
<th>1250/30-2500</th>
<th>1500/22-2250-2500</th>
</tr>
</thead>
<tbody>
<tr>
<td>Y axis with Multitool/Monopunch (mm)</td>
<td>1300/1250</td>
<td>-</td>
<td>1300/2250/2500</td>
<td>-</td>
</tr>
<tr>
<td>Y = 1250</td>
<td>-</td>
<td>1550/1500</td>
<td>2250-2500</td>
<td></td>
</tr>
<tr>
<td>Y = 1500</td>
<td>-</td>
<td>1300/2250/2500</td>
<td>-</td>
<td></td>
</tr>
<tr>
<td>X axis (mm)</td>
<td>-</td>
<td>-</td>
<td>1550/1500</td>
<td>2250-2500</td>
</tr>
</tbody>
</table>

Max. hit rate (1/min):
Punching with 20 mm pitch: 375
Nibbling with 1 mm pitch: 1000
Marking: 2000
TURRET PUNCHING SYSTEMS
CNC HORIZONTAL BENDING MACHINES
ELECTRIC PRESS BRAKES & NOTCHING MACHINES

STX FLEX

HYBRID TURRET PUNCHING SYSTEMS
Since their beginning, EUROMAC has been one of the leaders in Punching technology and design. With numerous patents to their name, their innovations have transformed the Punch market.

EUROMAC evolves the concept of the punching machine. It’s not just a Turret Punch, it’s a “Sheet Metal Working Center” – Punching, forming, bending, threading, and beading. Unbeatable versatility and a vast range of machine processes outperform laser machines.

Produced & Assembled in Italy

STX FLEX
The Flex 6 features and options include automatic positioning clamps, easy sheet load balls, a flexible turret system that is quick and easy to setup, and Flex Hybrid technology. Capable of employing up to 60 tools – 30 of which can be Auto-Indexed 360° in one single set up.

STX FLEX 6
STX FLEX 12
The Flex 12 includes six B sized stations that feature retractable dies which allow more forming capabilities.
Standard Active Form Stations
Capable of employing up to 66 tools – 30 of which can be Auto-Indexed 360° in one single set up.

STX FLEX

<table>
<thead>
<tr>
<th></th>
<th>1250/30-2500</th>
<th>1500/22-2500</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. punching force (kN)</td>
<td>300</td>
<td>220</td>
</tr>
<tr>
<td>Y axis with Multitool/Monopunch (mm)</td>
<td>1300/1250</td>
<td>-</td>
</tr>
<tr>
<td>Y = 1250</td>
<td>1300/1250</td>
<td>-</td>
</tr>
<tr>
<td>Y = 1500</td>
<td>-</td>
<td>1550/1500</td>
</tr>
<tr>
<td>X axis (mm)</td>
<td>2500</td>
<td>2500</td>
</tr>
<tr>
<td>Max. hit rate (1/min):</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Punching with 20 mm pitch</td>
<td>460</td>
<td>460</td>
</tr>
<tr>
<td>Nibbling with 1 mm pitch</td>
<td>1080</td>
<td>1080</td>
</tr>
<tr>
<td>Marking</td>
<td>2000</td>
<td>2000</td>
</tr>
<tr>
<td>Thickness range (mm)</td>
<td>0.6 – 6.5</td>
<td>0.6 – 6.5</td>
</tr>
</tbody>
</table>
FX BEND 1547 ELECTRIC PRESS BRAKE
Innovative design delivers all the power of a hydraulic machine in a clean, quiet press brake.

- FAST • EASY TO USE • SAFE • EFFICIENT
- Direct Drive Motor to Maximize Efficiency, Speed & Power
- Energy Saving
- Monoblock Frame
- 50 Tons

Configured with 4 or 6 Axis
Wila (New Standard) & European-Style Tooling Available

FX BEND 1023
High-level productivity with backgauges at 4 and 6 axis, fully automatic and with independent movements. Reaches speeds of up to 1,000 mm/sec with high decelerations to ensure maximum productivity.

- Monoblock Structure
- 25 Tons

Tooling
Wila (New Standard)
Promecam (European)

Optional Robotics Cell Available
THE DIGIBEND BENDS HORIZONTALLY on a flat bed, which is preferable when bending metal. When desired, you can bend a close loop. The Digibend is ideal for bending small parts, thick material or bus bars.

STANDARD FEATURES

• Programmable CNC Control
• Optional Graphical Control
• 2 Axis Control
• 360° of Bending Possible
• Tube Bending
• Punching
• Shearing

200 CNC

Max. pressure (kN) 200
Max. stroke (mm) 195
Max. working speed (mm/sec) 9.6
Min. working speed (mm/sec) 4.8
Return speed (mm/sec) 48
Average working speed (mm/sec) 28.8
Storable programs 255

400 CNC

Max. pressure (kN) 400
Max. stroke (mm) 245
Max. working speed (mm/sec) 9.6
Min. working speed (mm/sec) 4.8
Return speed (mm/sec) 62
Average working speed (mm/sec) 35.8
Storable programs 255

800 CNC

Max. pressure (kN) 800
Max. stroke (mm) 345
Max. working speed (mm/sec) 9.3
Min. working speed (mm/sec) 4.6
Return speed (mm/sec) 45
Average working speed (mm/sec) 27.2
Storable programs 255

THE DIGIBEND BENDS the metal horizontally on a flat bed. This is preferable when bending metal. When desired, you can bend a close loop. The Digibend is ideal for bending small parts, thick material, or bus bars.

STANDARD FEATURES

• Programmable CNC Control
• Optional Graphical Control
• 2 Axis Control
• 360° of Bending Possible

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Average working speed (mm/sec) 27.2
Storable programs 255

NOTCHER

Model | Capacity | Blade Length | Variable Angle | Rear Working Station
---|---|---|---|---
200/6 | .250” | 8” x 8” | 90° fixed | 16-Ton Rear Station Rectangle Notch, Press Brake, Corner Rounding
220/6 | .250” | 8.66” x 8.66” | 30°-140° | 30°-140°
220/6 VA Multi | .250” | 8.66” x 8.66” | 30°-140° | 30°-140°

• Automatic Blade Gap Adjustment
• Reversible Blades
• Standard Hold-Downs
• Standard Protractors
• Brass Graduated Scales
• Meehanite Mono Block Frame
PRESS BRAKES

FAST, ACCURATE AND RELIABLE

B SERIES
Features precision, simple programming and all of the options for your applications needs.

- Tonnages from 45 – 1,100
- Exceptional Open Height, Stroke and Throat Depth
- Up to 6 Axis Control
- Simple to Use Cybelec or Delem Controls
- German-Made Hydraulic Systems
- Configured to Your Application Needs

C SERIES
Equals Performance, Accuracy and Speed. The most flexible solution that Primeline offers.

- Long Stroke 11.81”
- Large Throat Depth 19.69”
- Tonnages from 45 – 1,100
- Up to 12 Axis Control
- Fast
- German-Made Hydraulic Systems
- Configured to Your Application Needs
SHEARS

- Guillotine and Variable Rake available
- Available in .250” – 1.00” capacity and lengths up to 20’
- Programmable backgauge
  Standard Elgo P40T
- Backgage range up to 40”
- Heavy duty rigid body and frame to reduce any deflection
- Automatic Swing-up backgauge after 40” to feed longer sheets
- Shadow light for cutting
- Fast
- Accurate

HYDRAULIC SHEARS

VR SERIES

- Blade rake angle is automatic and hydraulic
  Reduces twisting and torsion effect of thin and narrow parts
- Stroke Control
- Fast
- Accurate
- Optional Controls
  Cybelec
  Delem

MECHANICAL SHEARS

M Series

- Mechanical Guillotine Shears
- Available in 14 ga & 10 ga capacities
- Lengths from 4’ – 10’
- Rigid welded one-piece steel frame
- Motorized backgauge up to 29.5”
- 4 cutting edges for top and bottom blades
- Easy blade gap adjustment
- Ball transfers on the table
- Light guards on the rear of the machine
- Shadow light for cutting
- Digital NC control for the “go to” function and the backguage
GET THE DEMO

WE'LL COME TO YOU – ANYWHERE IN THE UNITED STATES

OUR TRUCK IS HEADED YOUR WAY

GEKA Ironworkers
Standard & CNC
Including the Revolutionary GEKA Semipaxy System

Euromac Digibend