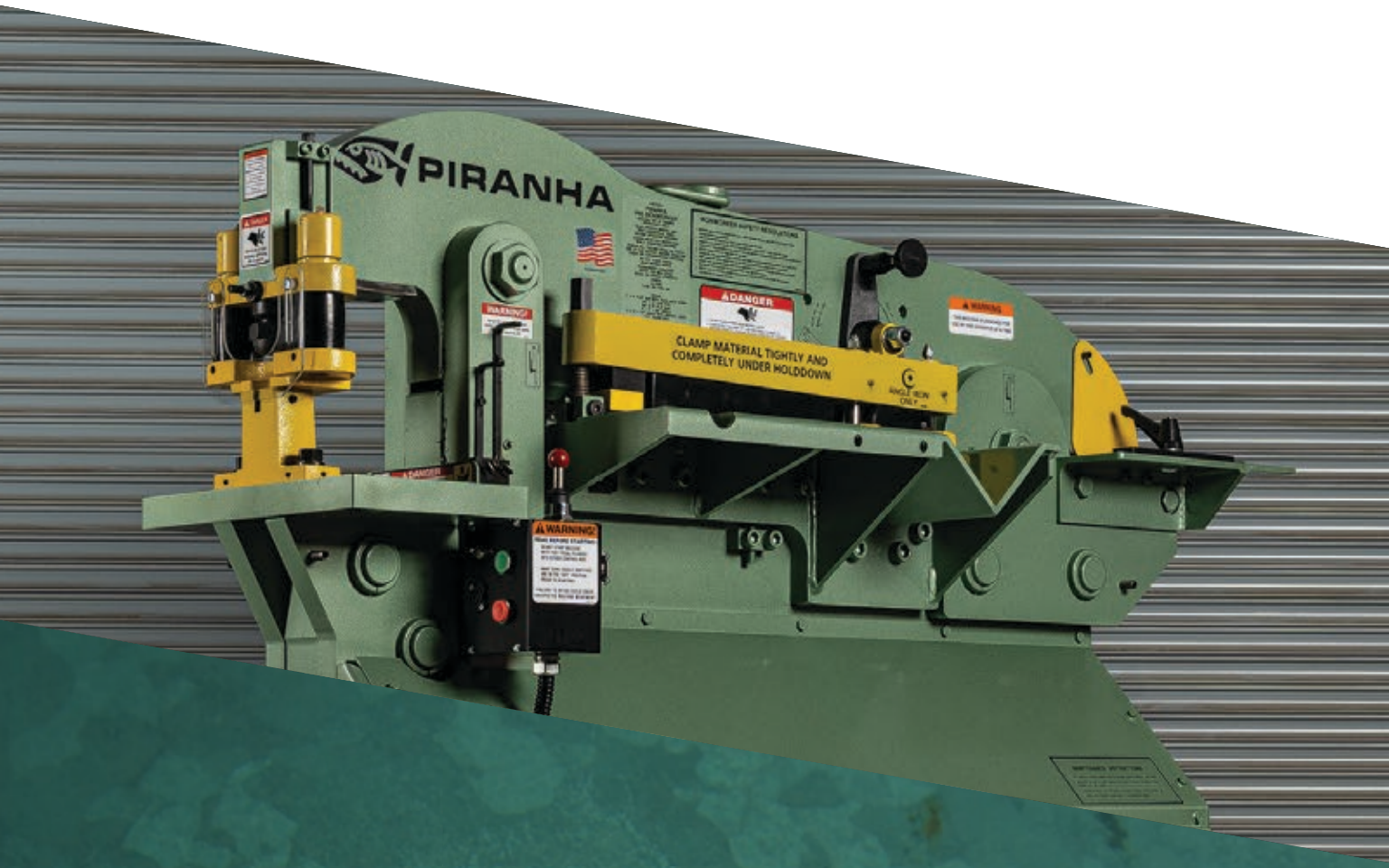
PIRANHA



IRONWORKERS

SINGLE/DUAL OPERATOR/SINGLE END PUNCH

IRONWORKER PRESS BRAKE LASER WELDER SHEAR BENDING ROLL FIBER LASER PLASMA COMBINATION

P SERIES

MADE IN USA



P-50

P-65

P-90
P-110
P-140

SEP-120

PII-88

PII-140

BII SERIES



BII-225

BII-132

BII-88

BII-66

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IRONWORKER Comparison Chart





+ = KEY FEATURE



FLAGSHIP SINCE 1974 (OVER 20K SOLD!)

= PREMIUM FEATURE

FEATURE/BENEFIT	COMPETITION BASE	BII-Series BASE +	P-Series PREMIUM
	The industry baseline — capable, but limited. Competitor ironworkers deliver only basic punching and shearing power, but often require more adjustments, more setup time, and more maintenance. They get the job done, but lack the fit, finish, and included features that we build into every machine.	Built for value. Designed to outperform. Our B-II Series bridges the gap between entry-level and premium ironworkers — offering a true dual-hydraulic system, automatic clamping, and productivity features that come standard, not extra. Supported by our nationwide parts and service team, it's the most capable value-class ironworker on the market.	The gold standard — Made in the USA since 1974, our flagship P-Series is precision-machined, overbuilt, and engineered for nonstop production. With quick-change tooling, same-level cutting ergonomics, and unmatched notching ability, it sets the benchmark for performance, reliability, and longevity in American fabrication.
Quickly and easily compare features, benefits, and more between our state-of-the-art products vs the competition with the chart below.			
Warranty & Service Support	Varies by Brand	Backed by Our USA Parts & Service	Priority USA Support
Heavy Duty Build Quality	Industry Standard Build	Enhanced Frame Design	Overbuilt for Nonstop Production
Precision Machining (No Shims Needed)	Standard Tolerances (Shims)	Improved Machining	Precision Machined (No Shims)
Cut Accuracy / Tighter Tolerances	Industry Standard	Improved	Industry Leading Precision
Quick-Change Tooling	Not Available on Most Models	Bolt-On Design	Dovetail Quick Change (Seconds, Not Minutes)
Ergonomic Design (All Stations at the Same Level)	Varies by Brand	Standard	All Operations at the Same Height
Low Rake Angles (Cleaner Cuts)	Varies by Model	Improved	Cleaner Cuts, Less Distortion
Dual Operator Capability	Available	+ True Dual Hydraulic System	Available
Automatic Hydraulic Clamping	On Select Models	+ Standard	Standard (Urethane Hold-Downs)
Punch Gauging Table (Optional)	Typical Setup	+ Enhanced Design	Fully Machined Work Table
Electric Back Gauge	Optional on Most Brands (Standard on Some)	+ Standard	Optional
Blade Maintenance	Shims Required on Some Models	Set-Screw Pockets	No Shims – Precision Machined
Adjustment for Thickness Changes	Yes	Yes	No Adjustment Required
Notcher Precision	Standard (Not All Precision Machined)	Improved Finish	Precision-Machined Notcher (Cuts ½" Steel & Business Card Cleanly)
Tonnage Range	40-180 T (Typical Range)	+ 66–225 T (Larger Tonnage Available)	65-140 T *Reference P50 webpage for some feature differences.
Ease of Use / Operator Simplicity	Standard Controls	Simple Layout & Clear Visibility	Optimized Controls for Throughput
Best For	Entry Level Shops	Entry Level Shops	High Volume / Versatile Requirements

PIRANHAFAB.COM

THE BENCHMARK FOR IRONWORKER PERFORMANCE

See our virtual demo and more at **piranhafab.com**

Conventional Ironworker:
Attachments and stations are at different heights. The height of a feed table requires manual adjustment for use with each station.

Piranha Ironworker:
All attachments and stations are at the same height; no need to adjust the feed table height between stations.



1. STRIPPING (PUNCH STATION)

Piranha Ironworker:
Urethane strippers keep material flat; Shorter stroke and no adjustment necessary.

Other Brands:
Fixed Stripper Plate needs adjustment for each material thickness; Requires extra stroke and finished part distorts.

2. HOLD-DOWNS (SHEARING)

Piranha Ironworker:
Urethane hold-downs clamp and unclamp the material automatically with each stroke (fast); Parts remain clamped during the entire shearing cycle; Complete clamping promotes long blade life.

Other Brands:
Fixed hold-down needs to be clamped/unclamped with each stroke; Material can shift while shearing. Inadequate clamping promotes short blade life.

3. VISIBILITY (SHEARING)

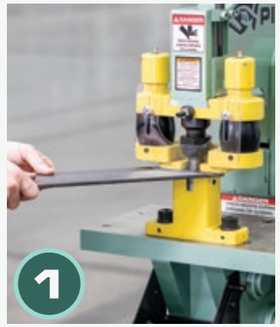
Piranha Ironworker:
Easily line up a cut line to the shear blade.

Other Brands:
Cannot see shear blade to line up a cut.

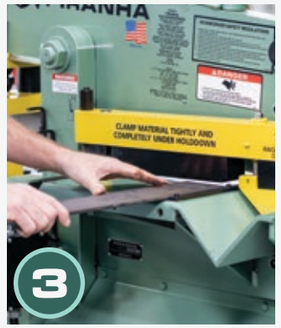
4. SHEAR BLADE

Piranha Ironworker:
Low rake angle shear blade results in flatter parts; Piranha provides four shear edges on most blades.

Other Brands:
High rake angle shear blade distorts the finished part; most manufacturers provide only two blade edges.









5. ANGLE SHEAR

Piranha Ironworker:
Floating upper blade seats in center of the angle eliminating distortion.

Other Brands:
Fixed upper blade does not seat in center of angle causing the cut piece to deform.

6. COPER NOTCHER

Piranha Ironworker:
Low rake angle blade keeps part flat and under control during notching.

Other Brands:
High rake angle blade deforms and moves part while notching.

7. BENDING ATTACHMENT

Piranha Ironworker:
Optional attachment open-ended allowing angle to be bent easily.

Other Brands:
Attachment guided on two sides and must be center loaded. Cannot bend angle iron.

8. INSTALLING BENDING ATTACHMENT

Piranha Ironworker:
The optional dovetail slide makes the bending attachment easy to install.

Other Brands:
Large, heavy attachment is awkward and time consuming to install.

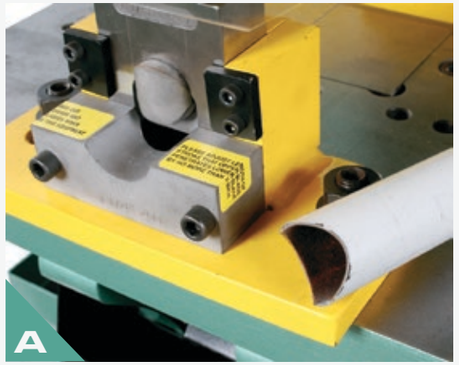




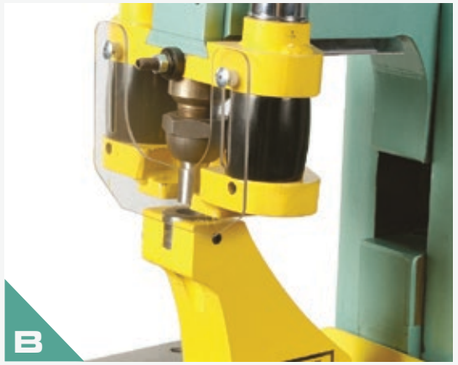




IRONWORKER ATTACHMENTS



PIPE/TUBE NOTCHING



CHANNEL DIE BLOCK



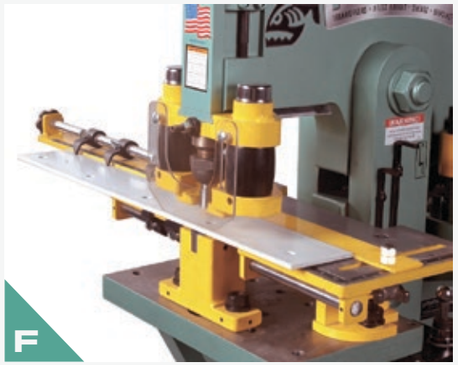
BENDING ATTACHMENT



28XX PUNCH ATTACHMENT



PRESS BRAKE TOOLING HOLDERS



QUICKSET GAUGING TABLES

PIRANHA TOOLING

MAKING YOUR IRONWORKER EVEN BETTER

We don't just stop at making an industry leading machine. We also manufacture our very own accessories and tooling, specifically designed to enhance the productivity of your ironworker. Below is a key indicating which accessories are available for each Piranha model:

P-50 ATTACHMENTS
A/B/C/D/F/H/I/J/K

P-65 ATTACHMENTS
A/B/C/D/E/F/G/H/I/J/K

P-90 ATTACHMENTS
A/B/C/D/E/F/G/H/I/K

P-110/P-140 ATTACHMENTS
A/B/C/D/E/F/G/H/I/K

PII-88 ATTACHMENTS
A/B/C/D/E/F/G/H/I/K

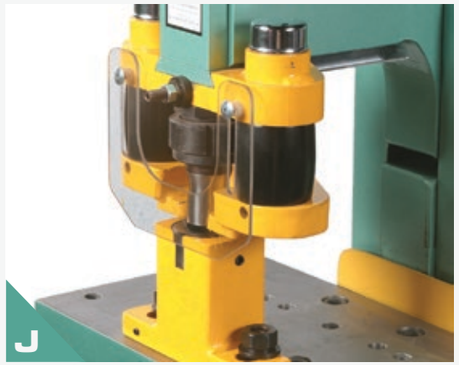
PII-140 ATTACHMENTS
A/B/C/D/E/F/G/H/I/K



CHANNEL SHEAR



MECHANICAL/ELECTRICAL BACK GAUGES



1-1/2" OVERSIZE PUNCH ATTACHMENT



ROLLER FEED TABLES

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P-SERIES SPECS & CAPACITIES

Rated on Mild Steel (60,000) PSI Tensile Strength

	Throat Depth	Open Height	Stroke Length	Closed Height w/o Die Block	Platen Table Size (D-W)	Punch Hole Size (Max Material) Max Hole Size (Material)	Plate Shear	Angle Shear **W/Special Blade	Bar Shear Round (Min-Max) Square (Min-Max)		Coper-Notcher (Max)	Bending Attachment (Opt Length)	Punch End Strokes/Minute Opt Speed-Up Kit	Work Station Height (Approx)	Hydraulics Pump GPM System R/V PSI	Fluid Capacity (Gal)	Motor Std. 230/460 3Ph. 1800 RPM (Opt Phase & Voltage Available)	Dimensions (Net) W-L-H Approx	Weight (Net) Lbs Approx
P-50	5”	11 1/2”	3 3/4”	7 3/4”	8” x 16”	50 Tons 13/16” (3/4”) 3” (3/16”)	13” Long 3/4” x 6” 1/2” x 10” 3/8” x 12” 1/4” x 12”	3” x 3” x 3/8” 3 1/2” x 3 1/2 x 5/16”	Optional 1/4” to 1 3/8” 1/2” to 1”	**P-50**	2 1/4” x 3” x 1/4”	Optional 6” / 12”	30 @ 1/2” N/A	42”	3.6 2800	12	3 HP 3 Ph.	24” x 55” x 58”	1,700
P-65	8”	13 1/2”	4 1/4”	9 1/4”	10” x 17”	65 Tons 1 1/16” (3/4”) 5” (1/8”)	15 1/2” Long 3/4” x 10” 5/8” x 15”	5” x 5” x 3/8” **4” x 4” x 1/2”	1/4” to 1 1/2” 1/2” to 1”	**P-65**	2 3/4” x 4” x 1/4”	Optional 8” / 12” / 14” / 24”	30 @ 3/4” 45 @ 3/4”	42”	7.5 3000	20	7.5 HP 3 Ph.	24” x 66” x 60”	2,600
P-90	10”	15”	4 7/8”	10 1/8”	12” x 21”	90 Tons 1.1/8” (1”) 5” (3/16”)	18” Long 1” x 8” 3/4” x 12” 1/2” x 18”	5” x 5” x 1/2”	1/2” to 2” 1/2” to 1 3/8”	**P-90**	3 1/2” x 5” x 3/8”	Optional 12” / 14” / 24”	32 @ 3/4” 45 @ 3/4”	42”	10.5 2900	25	10 HP 3 Ph.	31” x 79” x 64”	4,250
P-110	12”	15 1/2”	5 1/4”	10 1/4”	14 1/2” x 21”	110 Tons 1 7/16” (1”) 5” (1/4”)	20 1/2” Long 1” x 12” 3/4” x 18” 1/2” x 20”	6” x 6” x 5/8”	1/2” to 2” 1/2” to 1 3/8”	**P-110**	4” x 6” x 3/8”	Optional 12” / 14” / 24”	30 @ 3/4” 41 @ 3/4”	44”	10.5 3200	25	10 HP 3 Ph.	35” x 90” x 66 1/2”	5,800
P-140	12”	15 1/2”	5 1/4”	10 1/4”	14 1/2” x 21”	140 Tons 1 3/4” (1”) 5” (5/16”)	20 1/2” Long 1” x 14” 3/4” x 18” 1/2” x 20”	6” x 6” x 5/8”	1/2” to 2” 1/2” to 1 3/8”	**P-140**	4” x 6” x 3/8”	Optional 12” / 14” / 24”	30 @ 3/4” 35 @ 3/4”	44”	15 3500	25	15 HP 3 Ph.	35” x 90” x 68 1/2”	6,200
PII-88	9”	14”	7”	7 3/4”	11” x 38”	88 Tons 1 1/16” (1”) 5” (3/16”)	24” Long 3/4” x 8” 5/8” x 12” 1/4” x 24”	5” x 5” x 3/8” **4” x 4” x 1/2”	1/4” to 1 1/2” 1/2” to 1”	**PII-88**	2 3/4” x 4” x 1/4”	Optional 18” / 24” / 36” / 48”	19 @ 1” N/A	41”	7.5 3500	20	10 HP 3 Ph.	38” x 90” x 72”	4,700
PII-140	20 1/2”	14”	7”	7 3/4”	16” x 36”	140 Tons 1 3/8” (1 1/4”) 5” (5/16”)	20 1/2” Long 1” x 14” 3/4” x 18” 1/2” x 20”	6” x 6” x 5/8”	1/2” to 2” 1/2” to 1 3/8”	**PII-140**	4” x 6” x 3/8”	Optional 18” / 24” / 36” / 48”	24 @ 1” N/A	44”	15 3500	40	20 HP 3 Ph.	38” x 120” x 85”	11,930
SEP-120	21 1/2”	12 1/4”	2”	10 1/4”	20” x 10”	120 Tons 1 1/2” (1”) 5” (1/4”)	N/A	N/A	N/A	**SEP-120**	N/A	Optional 18”	16 @ 1” N/A	42”	10.5 2850	30	10 HP 3 Ph.	48” x 60” x 72”	4,100



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THE BII SERIES: DUAL OPERATOR PRECISION



Piranha Ironworker:
The BII Series is a complete Dual Operator Machine, utilizing two motors, pumps and valve bodies to enable the operator to run the punching and shearing/notching sections entirely independently of each other. These machines are available in capacities from 66 to 225 Tons and come equipped with standard features as follows:

- Automatic Hydraulic Clamping in the Flat and Angle Shear Section
- Magnetic Work Light
- Productivity Package for the punching, shearing and notching stations

HIGHEST VALUE DUAL-OPERATOR ON THE MARKET



BII-66
66 TON DUAL OPERATOR



BII-88
88 TON DUAL OPERATOR



BII-132
132 TON DUAL OPERATOR



BII-225
225 TON DUAL OPERATOR

Model	Punch Tonnage	Plate Shear	Angle Shear	Notcher	Weight
BII-66	66	15-3/4″ x 5/16″ 9-1/2″ x 5/8″	4.5″ x 4.5″ x 7/16″	2-1/4″ x 3-7/8″ x 3/8″	4,400 lbs
BII-88	88	18-1/2″ x 3/8″ 13″ x 3/4″	5.5″ x 5.5″ x 7/16″	2-1/4″ x 3-7/8″ x 1/2″	5,950 lbs
BII-132	132	18-1/2″ x 3/8″ 13″ x 1″	6-1/4″ x 6-1/4″ x 5/8″	2-1/4″ x 3-7/8″ x 9/16″	10,800 lbs
BII-225	225	27-1/2″ x 9/16″ 15-3/4″ x 1-3/8″	7-3/4″ x 7-3/4″ x 11/16″	2-1/4″ x 3-7/8″ x 3/4″	16,975 lbs

BII SERIES FEATURES



AUTO HYDRAULIC CLAMPING

Effortlessly secure materials with precision using the Automatic Hydraulic Clamping system. This feature minimizes setup time and ensures a firm hold, enhancing productivity and safety for every task.



COPER TABLE GAUGING

Achieve precise, repeatable cuts with the Coper Table Gauging system. Designed for accuracy and efficiency, this feature simplifies the alignment process, ensuring consistent results on every project.



PUNCH GAUGING TABLE

The Punch Gauging Table offers an easy-to-use platform for aligning and punching materials with exceptional accuracy. Built for durability and precision, it enhances workflow and minimizes errors.



ELECTRIC BACK GAUGE

Streamline your operations with the Electric Back Gauge, a highly adjustable feature that provides precise material positioning for cutting tasks. It's designed to save time and improve accuracy.



BENDING ATTACHMENT

Expand your capabilities with the versatile Bending Attachment. Ideal for creating accurate bends in various materials, this accessory integrates seamlessly into the ironworker for optimal performance.



DUAL HYDRAULIC SYSTEM

Boost productivity with the Dual Hydraulic System, enabling independent or simultaneous operation of the machine's components. This innovative system maximizes efficiency for complex tasks and reduces downtime.







ANGLE MITRE ATTACHMENT (OPTIONAL)

The Angle Mitre Attachment is engineered for precision and versatility, allowing for clean and accurate angled cuts on a wide range of materials. Its robust design ensures stability, while easy adjustability simplifies the process of achieving perfect miters, making it an indispensable tool for detailed fabrication projects.

COMPARE P & BII SERIES

FEATURE	P-SERIES	B-SERIES
Operation	Single-operator models; dual-operator versions available	Dual-operator machines with independent hydraulic systems
Tonnage Capacity	50 to 140 tons	66 to 225 tons
Standard Features	• Urethane stripper • Automatic hold-downs • Quick-change tooling	• Hydraulic clamping • Magnetic work light • Productivity package
Punching Capacity	Up to 140 tons	Up to 225 tons
Shearing Capacity	Flat bars up to 18" wide (Varies by model)	Flat bars up to 27-1/2" x 9/16"
Notching Capacity	Standard coper/notcher on models like P-90	Advanced notching with productivity enhancements
Additional Attachments	Optional: bending, pipe notching, gauging tables	Standard: punch gauging, bending, electric back gauges
Design Focus	Versatile, compact; single/dual operation options	High productivity; dual-operation for large scale needs



IRONWORKER

PRESS BRAKE

LASER WELDER

SHEAR

BENDING ROLL

FIBER LASER

PLASMA

COMBINATION



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