

Hilgeland  
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Cold Former HC  
Type HILGELAND



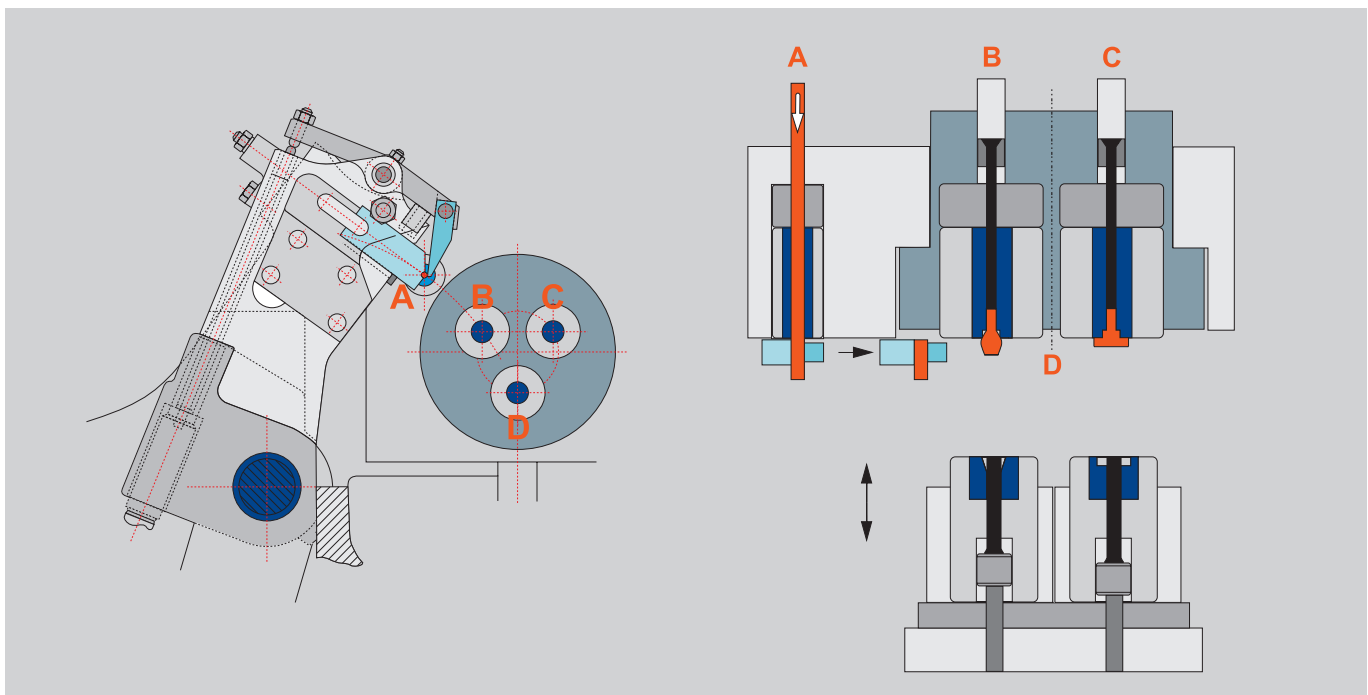
HC

### Cold Former HC Type HILGELAND with rotating die block and 2 forming stations

- Collision-free ejection of finished pieces below the punch
- Long service life due to precise positioning of rotor being securely locked into its working position
- Short set-up time though single-screw die wedge clamping (one clamping for all three dies)
- High output, one finished product with every stroke
- Optimized set-up times by quick change equipment for tooling



#### ▼ Working principle



# Cold Former HC Type HILGELAND



| Technical Data   | HC 4-15            | HC 4-35 | HC 6-40 | HC 6-60            | HC 6-70 |
|--|--------------------|---------|---------|--------------------|---------|
| Machine system   | SIZE 4 mm          |         |         | SIZE 6 mm          |         |
| ● = Double-Stroke Rotary Technology  | ●                  | ●       | ●       | ●                  | ●       |
| Number of dies   | 3                  | 3       | 3       | 3                  | 3       |
| Number of punches  | 2                  | 2       | 2       | 2                  | 2       |
| Max. output up to pieces/min.*)  | 850                | 800     | 600     | 560                | 500     |
| Wire-Ø-range in mm **)   | 1-4                | 1-4     | 2-6     | 2-6                | 2-6     |
| Cut-off knife system:<br>⊙ = closed ◆ = open   | ◆                  | ◆       | ◆       | ◆                  | ◆       |
| Max. wire cut-off in mm  | 39                 | 52      | 60      | 80                 | 88      |
| When using a movable punch the length of the wire-cuts is reduced by the length of the movable punch stroke (formula – see below)                            |                    |         |         |                    |         |
| Ejection lengths in mm   | 15 (25)            | 35 (40) | 40      | 60                 | 70      |
| Punch ejector stroke in mm   | 6                  | 6       | 10      | 11                 | 12      |
| Heading force in kN  | 50                 | 50      | 125     | 125                | 125     |
| Main motor in kW   | 7.5                | 7.5     | 11      | 11                 | 11      |
| <b>Tool dimensions</b>   |                    |         |         |                    |         |
| Die-Ø in mm  | 30                 | 30      | 40      | 40                 | 40      |
| Max.die length in mm with backing plate  | 55                 | 55      | 85      | 85                 | 85      |
| Ø in mm of bores of punch holders  | 25                 | 25      | 30      | 30                 | 30      |
| Max. punch length with backing plate   | 74                 | 74      | 90      | 90                 | 90      |
| Depth of punch holder in mm  | 60                 | 60      | 74      | 74                 | 74      |
| Cut-off-Ø max. mm  | 16                 | 16      | 20      | 20                 | 20      |
| <b>Feeding Date</b> For pieces calculation of feeding requirement, feed diagrams for the a.-m. machines can be placed at your disposal                       |                    |         |         |                    |         |
| Min. feeding length in mm<br><b>Knife 3 mm in the case of fixed punch</b>  | 12                 | 15      | 15      | 17                 | 19      |
| Max. feeding length <b>Z</b> <sup>1)</sup> in mm<br><b>Cut-off knife resp. transfer lever in front of the die</b> <sup>2)</sup> (in the case of fixed punch) | 38                 | 56      | 58      | 75                 | 84      |
| <b>Dimensions and weights</b>  |                    |         |         |                    |         |
| Dimensions in mm incl. cover and single-wire straightener without exceeding length of conveyor belt (L x W x H)  | 2970 x 1700 x 2210 |         |         | 3850 x 1820 x 2210 |         |
| Weight approx. in kg   | 4300               |         |         | 7200               |         |

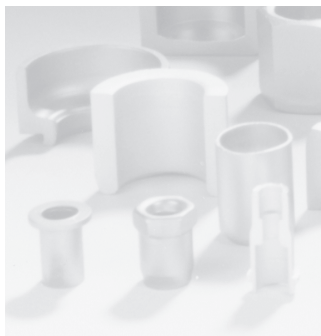
\*) Output dependent on product and material.

\*\*) Statements as to max. wire diameter apply to materials with a tensile strength of up to 600 N/mm<sup>2</sup>.  
For materials with a higher tensile strength upon request.

1) The feeding length (**Z**) makes calculation of max. feedable wire-cut possible (**L**) for your special tool construction using the formula **A + h + V = L < Z**  
**A** = Shank length; **h** = wire-length to be punched; **V** = Sliding stroke of first punch.

2) Rotor or swivel locks (130° before front dead point in the case of HC) (140° before front dead point in the case of HD) (150° before front dead point in the case of HE)

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The specifications are not binding as  
these could vary on account of technical  
developments.

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