

Hilgeland
Kieserling
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Cold Former HD and HE Type HILGELAND



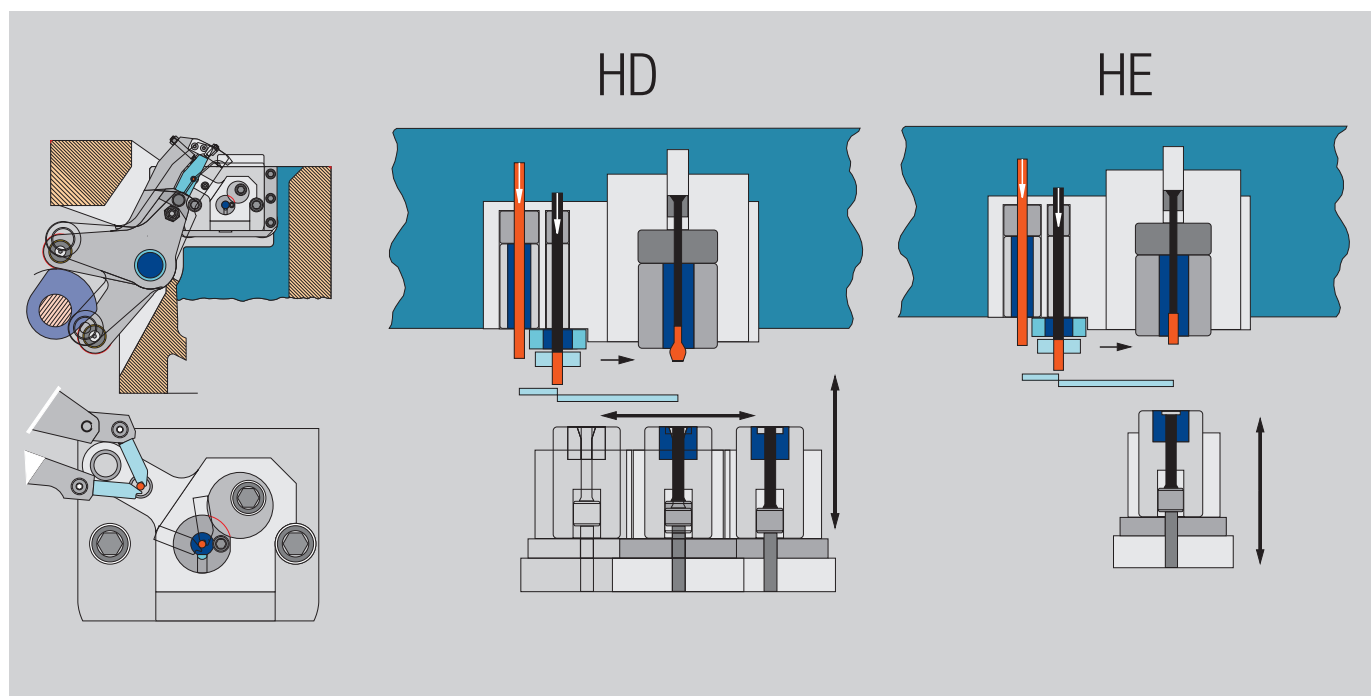
HD
HE

Cold Former with optimized set-up times HD (1-die-2-blow) and HE (1-die-1-blow) Type HILGELAND

- The use of preheating equipment optimizes the temperature of stainless wire parts in the machine between cut-off knife and wire infeed (also for Titan and Inconel) – Temperatures possible more than 900°C (1650°F)
- Achieving long tool life, high cycle times and a considerable increase in productivity, which is also possible in the production of demanding materials
- As result: Minimum heat loss and high energy efficiency
- The wire temperature is exactly controlled by means of regulation technology
- The induction heating process is scale-free and requires no special wire coating
- Hard steel materials can be formed with less force
- Optimized set-up times by data input of precise cut-off length at the control panel



▼ Working principle



Cold Former HD and HE Type HILGELAND



Technical Data	HD 4-25	HD 4-40	HE 4-25	HE 4-40	HD 6-40	HD 6-60	HD 6-70	HE 6-40	HE 6-60	HE 6-70	HD 7-160	
Machine system	SIZE 4 mm				SIZE 6 mm							
○ = Double-Stroke Swivel Technology ■ = Single-Stroke	○	○	■	■	○	○	○	■	■	■	○	
Number of dies	1	1	1	1	1	1	1	1	1	1	1	
Number of punches	2	2	1	1	2	2	2	1	1	1	2	
Max. output up to pieces/min.*)	460	460	710	670	380	355	335	630	600	560	160	
Wire-Ø-range in mm **)	1-4	1-4	1-4	1-4	2-6	2-6	2-6	2-6	2-6	2-6	3-7	
Cut-off knife system: ⊙ = closed ◆ = open	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	◆	
Max. wire cut-off in mm	39	52	39	52	60	80	88	60	80	88	175	
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	25	40	25	40	40	60	70	40	60	70	160	
Punch ejector stroke in mm	4	4	4	4	10	10	10	10	10	10	20	
Heading force in kN	50	50	50	50	125	125	125	125	125	125	200	
Main motor in kW	7.5	7.5	7.5	7.5	11	11	11	11	11	11	11	
Tool dimensions												
Die-Ø in mm	30	30	30	30	40	40	40	40	40	40	60	
Max. die length in mm with backing plate	55	55	55	55	85	85	85	85	85	85	185	
Ø in mm of bores of punch holders	25	25	25	25	30	30	30	30	30	30	40	
Max. punch length with backing plate	80	80	74	74	90	90	90	90	90	90	76	
Depth of punch holder in mm	66	66	60	60	74	74	74	74	74	74	60	
Cut-off-Ø max. mm	16	16	16	16	20	20	20	20	20	20	30	
Feeding Date												
For pieces calculation of feeding requirement, feed diagrams for the a.-m. machines can be placed at your disposal												
Min. feeding length in mm Knife 3 mm in the case of fixed punch	20	26	20	26	22	27	30	22	27	30	40	
Max. feeding length Z ¹⁾ in mm Cut-off knife resp. transfer lever in front of the die ²⁾ (in the case of fixed punch)	41	59	43	62	62	80	90	65	84	94	180	
Dimensions and weights												
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					4600 x 1990 x 1780		
Weight approx. in kg	4300				7200					9200		

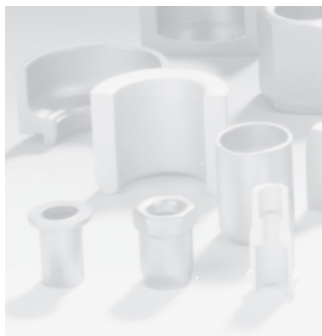
*) Output dependent on product and material.

**) Statements as to max. wire diameter apply to materials with a tensile strength of up to 600 N/mm².
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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