

Hilgeland
Kieserling
EWMenn
Nutap

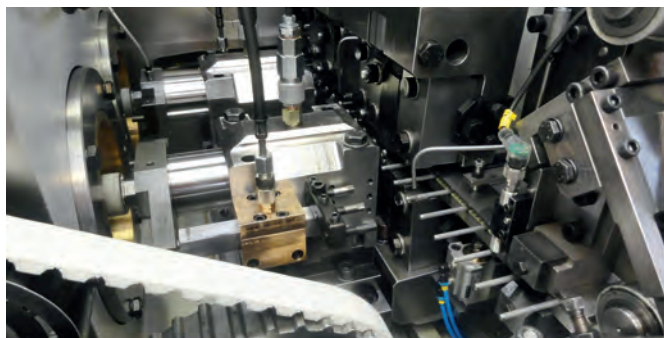
Tandem Double-Blow Cold Former ND Brand WAFIOS



ND

Tandem Double-Blow Cold Former ND

- Separate preform and finish punching of the head shape on both sides of the blank
- Short stroke punching; the travel of the punch slide is only as long as the wire length necessary for the forming operation
- Symmetrical or asymmetrical cutting of the blank that is formed on both sides, so that two blanks with finished head shapes are produced per working cycle
- Use of standard material instead of phosphated wire. The previously necessary operation „intermediate wash“ of the blanks before thread rolling is no longer necessary



Workflow and drive

Tandem Double-Blow Cold Formers of the ND series produce blanks for chipboard screws, wood screws, sheet metal screws according to DIN 7970 and similar parts made of wire from 2.2 to 5.2 mm diameter. For these dimensions the ND is the fastest machine on the market.

The ND 90 produces 1400 blanks per minute for screw nominal sizes of 3 to 5 mm from wire 2.2 to 3.7 mm in diameter.

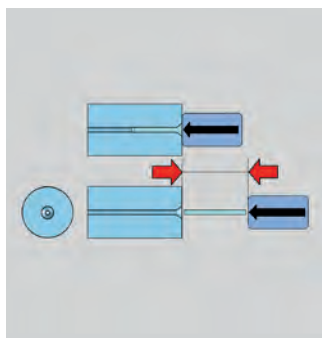
Environmental aspects

The ND series processes bare wire, i.e. an environmentally friendly and inexpensive raw material. For forming the head, only the wire section to be reshaped is moistened with a minimum volume of oil, which oil consumption is reduced.

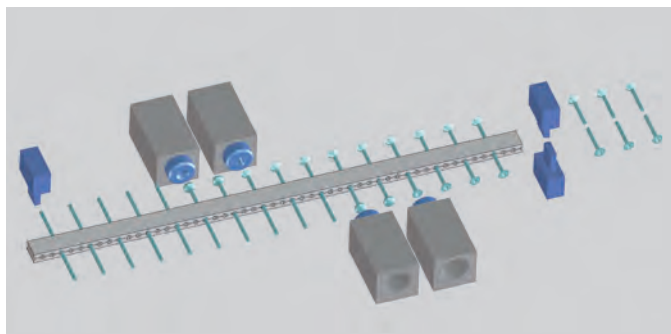
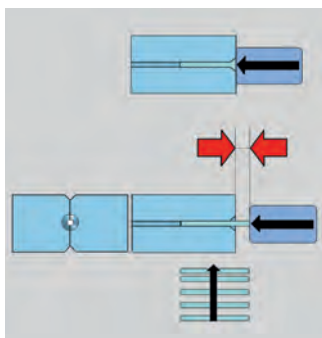
Quick change-over

The machines of the ND series are low-maintenance and light set up. For change-over to a different length of the blanks with the same diameter are only a few minutes. Punch tool changing cassettes reduce the time required to switch to another wire diameter.

► Common punch stroke



► Punch stroke series ND



Tandem Double-Blow Cold Former ND

Brand WAFIOS



	ND 90			
	Single Short Infeed	Single Long Infeed	Tandem Short Infeed	Tandem Long Infeed
Technical Data	ND 90S	ND 90SL	ND 90T	ND 90TL
Wire diameter mm	2.2 – 3.7	2.2 – 3.7	2.2 – 3.7	2.2 – 3.7
Single blank length max. mm	170 ²⁾	310 ³⁾	170 ²⁾	310 ³⁾
Output for single blank depending on length ¹⁾ pcs./min	700	300 – 500	700	300 – 500
Double blank length with symmetrical cut mm			30 – 80 ²⁾	30 – 90 ⁴⁾
Double blank length with asymmetrical cut mm			10 – 150 ²⁾	10 – 170 ⁴⁾
Output for double blank ¹⁾ max. pcs./min			1400	1000

	ND 91			
	Single Short Infeed	Single Long Infeed	Tandem Short Infeed	Tandem Long Infeed
Technical Data	ND 91S	ND 91SL	ND 91T	ND 91TL
Wire diameter ⁵⁾ mm	2.8 – 4.5	2.8 – 4.5	2.8 – 4.5	2.8 – 4.5
Single blank length max. mm	170 ²⁾	310 ³⁾	170 ²⁾	310 ³⁾
Output for single blank depending on length ¹⁾ pcs./min	500	300 – 500	500	300 – 500
Double blank length with symmetrical cut mm			30 – 90 ²⁾	30 – 90 ⁴⁾
Double blank length with asymmetrical cut mm			10 – 150 ²⁾	10 – 170 ⁴⁾
Output for double blank ¹⁾ max. pcs./min			1000	1000

1) Output depends on product and material.

2) Depends on volume of the head (Feeding length max. = 180 mm)

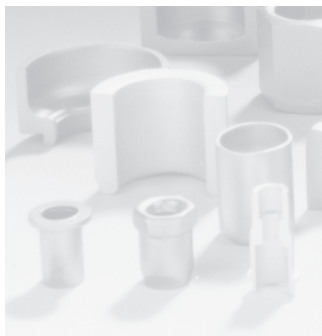
3) Depends on volume of the head (Feeding length max. = 320 mm)

4) Depends on volume of the head (Feeding length max. = 200 mm)

5) Wire diameter max. up to 5.2 mm with limited head volume.



Hilgeland
Kieserling
EWMenn
Nutap



WAFIOS
Umformtechnik GmbH

Precision Parts
Forming Machinery

Made in Germany

Im Rehsiepen 35, 42369 Wuppertal
Phone +49 (202) 46 68-0
Fax +49 (202) 46 68-225

sales@wafios-umformtechnik.de
www.wafios-umformtechnik.com
Germany

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

03.2020