

Hilgeland
Kieserling
MRP
Nutap

Cold Former HC
Type HILGELAND



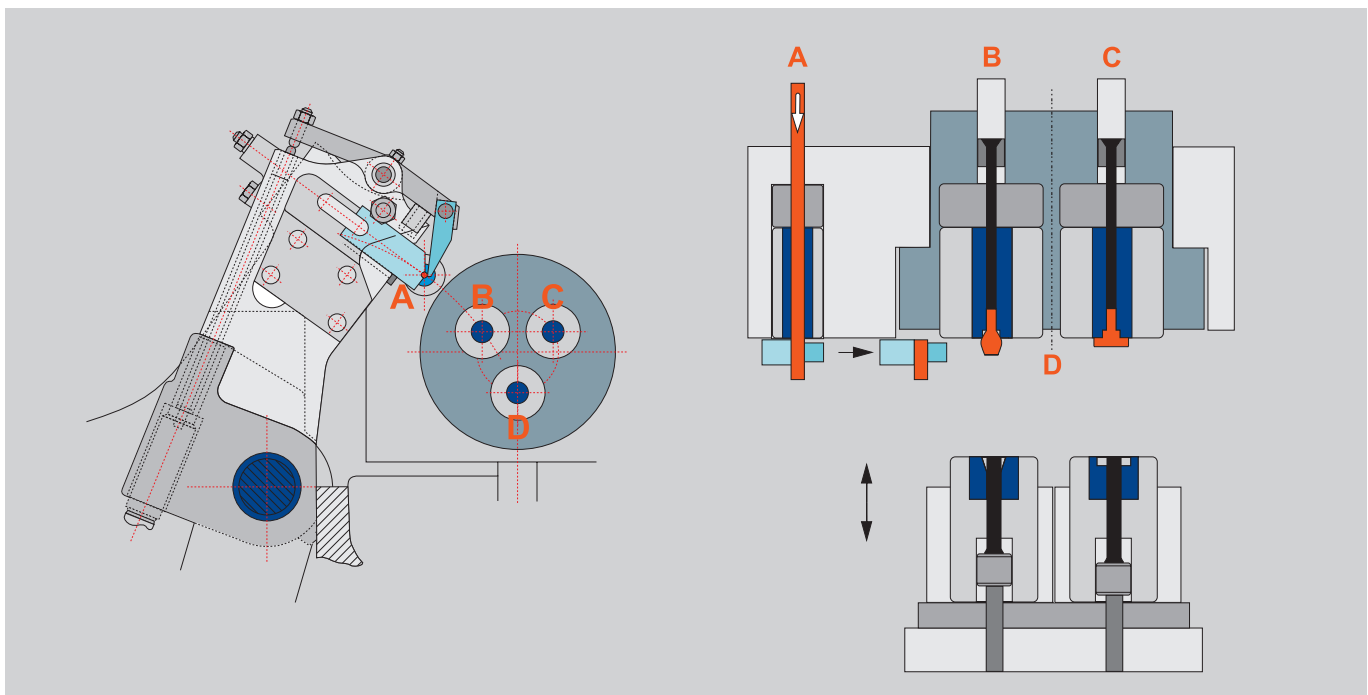
HC

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	HC 6-75	HC 6-80
Machine system	SIZE 4 mm			SIZE 6 mm			
● = Double-Stroke Rotary Technology	●	●	●	●	●	●	●
Number of dies	3	3	3	3	3	3	3
Number of punches	2	2	2	2	2	2	2
Max. output up to pieces/min.*)	850	800	600	560	500	450	380
Wire-Ø-range in mm **)	1-4	1-4	2-6	2-6	2-6	2-6	2-6
Cut-off knife system: ⊙ = closed ◆ = open	◆	◆	◆	◆	◆	◆	◆
Max. wire cut-off in mm	39	52	60	80	88	88	100
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	75	80
Punch ejector stroke in mm	6	6	10	11	12	12	12
Heading force in kN	50	50	125	125	125	125	125
Main motor in kW	7.5	7.5	11	11	11	11	11
Tool dimensions							
Die-Ø in mm	30	30	40	40	40	40	40
Max.die length in mm with backing plate	55	55	85	85	85	85	106
Ø in mm of bores of punch holders	25	25	30	30	30	30	30
Max. punch length with backing plate	74	74	90	90	90	90	90
Depth of punch holder in mm	60	60	74	74	74	74	74
Cut-off-Ø max. mm	16	16	20	20	20	20	20
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	12	15	15	17	19	20	21
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)	38	56	58	75	84	88	100
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			
Weight approx. in kg	4300			7200			

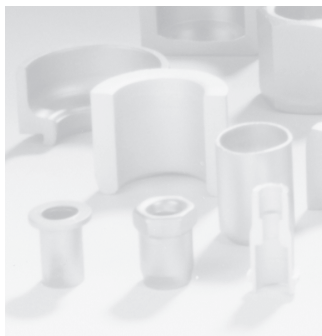
*) Output dependent on product and material.

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

Hilgeland
Kieserling
MRP
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.de
Germany

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

08.2024