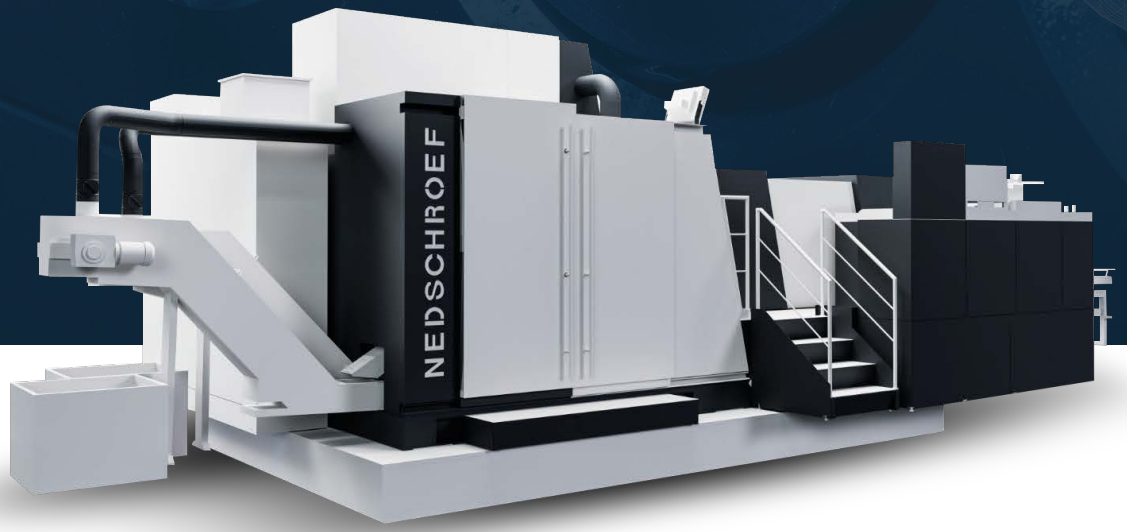
Complete range · Technical specifications

Machine Overview



NEDSCHROEF MACHINERY

built to perform

Multi-station cold formers

Headers

NH ·NE series | 13 machine types

Machine type*	Unit	NHx12S	NHx12	NHx15	NHx15L	NHx18	NHx18L	NHx22M	NHx22L	NHx22EL	NH625	NHx30	NHx33M	NE524
Number of dies	/	5-6	5-6	5-6	5-6	5-6	5-6	5-6	5-6	5-6	6	5-6	5-6	5
Max. forging load	kN	800	800	1400[1]	1400[1]	2300	2300	2750[2]	2750[2]	2300	4000	5500	6500	3600
Cut-off diameter @ 600 N/mm²	mm	12	12	17	17	20	20	22	22	22	28	30	36	27
Max. cut-off length	mm	90	125	150	162	170	190	190	250	310	305	265	265	247
Max. die / kick-out	mm	65	100	125	135/140[3]	145	160	160	200	280	250	210	200	205
Speed	rpm	275	240	210	210	180	160	160	140	120/140[4]	120	105	90	105

* The x in a machine type indicates the number of stations as specified in the table, for example NHx12 becomes NH512 or NH612 (x = 5 or 6 stations).



Selection Guide

Up to Ø22 mm - NHx12S to NHx22EL. Speed falls as diameter rises; the L and EL types trade speed for cut-off length and kick-out.

Ø27 mm and above - NE524, NH625, NHx30 and NHx33M, from 3600 to 6500 kN.

[1] Max. individual forging load per station limited to 650 kN.
[2] Forging load per station limited to 1150 kN.
[3] 135 mm in the final station in case of a trimming operation installed.
[4] 140 rpm for parts up to 200 mm, 120 rpm above 200 mm, to ensure stable part transfer.

Forming and threading in one cell

Boltmakers

NB · NEB series | 9 machine types

Machine type*	Unit	NBx12	NBx15	NBx15L	NBx18	NBx18L	NBx22M	NBx22L	NBx22EL	NEB524
Number of dies	/	5-6	5-6	5-6	5-6	5-6	5-6	5-6	5-6	5
Max. forging load	kN	800	1400[1]	1400[1]	2300	2300	2750[2]	2750[2]	2300	3600
Cut-off diameter @ 600 N/mm²	mm	12	17	17	20	20	22	22	22	27
Max. cut-off length	mm	125	150	162	170	190	190	250	310	247
Max. die / kick-out	mm	100	125	135/140[3]	145	160	160	200	280	205
Speed[5]	rpm	240	210	210	180	160	160	140	120/140[4]	105
Thread diameter	metric	M5-M10	M6-M12	M6-M12	M8-M16	M8-M16	M8-M20	M8-M20	M8-M20	M12-M24
Max. thread length	mm	80	100	100	120	120	135	135	135	95

* The x in a machine type indicates the number of stations as specified in the table, for example NBx12 becomes NB512 or NB612 (x = 5 or 6 stations).



One cell, finished bolt

Every boltmaker combines the header with an integrated pointing and threading station. Thread range **M5 to M24**, thread length up to **135 mm**. Forming data matches the corresponding header type.

[1] Max. individual forging load per station limited to 650 kN.
[2] Forging load per station limited to 1150 kN.
[3] 135 mm in the final station in case of a trimming operation installed.
[4] 140 rpm for parts up to 200 mm, 120 rpm above 200 mm, to ensure stable part transfer.
[5] Boltmaker speed depends on thread pitch and thread length.

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NEDSCHROEF MACHINERY

Ergonomic heavy-duty forming and complex parts

Nedmax · Partformer

Nedmax NM series | 4 machine types

Machine type*	Unit	NMx28M	NMx28S	NMx33M	NMx33L
Number of dies	/	5-6	5-6	5-6	5-6
Max. forging load	kN	4000	4000	6500	6500
Cut-off diameter @ 600 N/mm²	mm	28	28	36	36
Max. cut-off length	mm	265	165	250	375
Max. die / kick-out	mm	210	125	200	310
Speed	rpm	115	115	90	80

Partformer NC714 | 7 dies

Machine type	Unit	NC714
Number of dies	/	7
Max. forging load	kN	800
Cut-off diameter @ 600 N/mm²	mm	12
Max. cut-off length	mm	100
Max. die / kick-out	mm	100
Speed	rpm	160

* The x in a machine type indicates the number of stations as specified in the table, for example NMx33M becomes NM533M or NM633M (x = 5 or 6 stations).



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NEDSCHROEF MACHINERY

Cold and hot nut forming

Nut formers

Cold nut formers MM series | 3 machine types

Machine type	Unit	MM8	MM12	MM16
Number of dies	/	5	5	5
Max. forging load	kN	1300	2200	3300
Product range	metric	M10[6]	M16[6]	M24[6]
Cut-off diameter @ 600 N/mm²	mm	15	19	23
Cut-off length min – max	mm	5 - 19	7 - 25	8 - 35
Speed	rpm	250	200	150
WAF hex nuts min – max	mm	10 - 17	17 - 22	22 - 27
Max. product diameter	mm	21	26	36
Product height hex min – max	mm	5 - 19	6,5 - 22	7 - 35
Max. WAF square nuts	mm	13	18	24

Hot nut formers MW series | 3 machine types

Machine type	Unit	MW32	MW55	MW65
Number of dies	/	2	2	2
Max. forging load	kN	600	1300	2000
Product range	metric	M14-M22	M20-M36	M20-M42
Cut-off diameter @ 600 N/mm²	mm	26	44	55
Cut-off length min – max	mm	12 - 44	14 - 65	22-80
Speed	rpm	180	150	100
WAF hex nuts min – max	mm	22 - 33	30 - 53	max. 65
Max. product diameter	mm	36	55	72
Product height hex min – max	mm	9 - 27	13 - 45	16 - 52
Max. WAF square nuts	mm	30	41	51

[6] Product range depends on nut type. Stated for DIN 934 hex nuts; for flange nuts it depends on the flange diameter.

Long stroke, straightening, cutting and thread rolling

Cold headers · Wire preparation · Finishing

Cold headers | Long stroke BL series | 2 machine types

Machine type	Unit	BL2	BL4
Number of dies	/	4	4
Max. forging load	kN	800	1500
Cut-off diameter @ 600 N/mm²	mm	12	16
Max. die / kick-out	mm	200	300
Speed	rpm	150	90

Straightener RRA18 | 1 machine type

Machine type	Unit	RRA18
Min./max. product diameter	mm	6 / 20
Min./max. product length	mm	110 / 500
Maximum output	ppm	90
Floor space	m²	1,5

Roll former NT60 | 1 machine type

Machine type	Unit	NT60
Thread diameter	metric	M30
Shaft length	mm	300
Thread length	mm	200
Moving / Fix die length	mm	406 / 381
Speed	ppm	120

Wire cutter NS16 | 1 machine type

Machine type	Unit	NS16
Wire diameter	mm	16
Min. / Max. cut-off length	mm	120 / 500
Speed	ppm	max. 260



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Contact

Let’s talk about your next machine

Brigandstraat 10 | B-2200 Herentals | Belgium
+32 489 65 71 73 | sales@nedschroef.be

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