



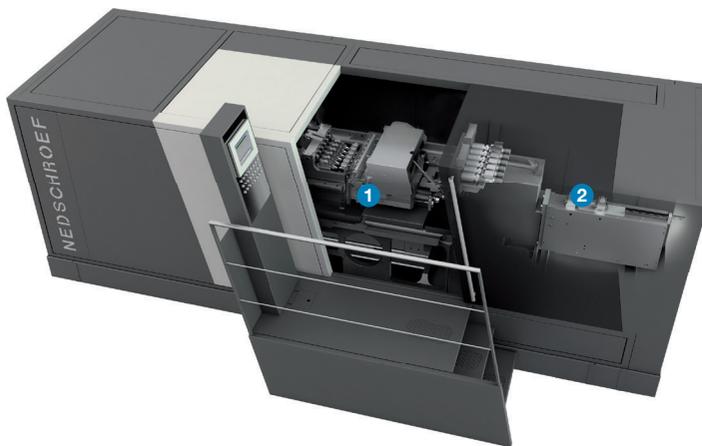
Nedform Hybrid

New forming capabilities and high productivity

The Nedform Hybrid is the latest development in the Nedform range. A multi station forming machine for diameters from 5 to 25 mm and product lengths up to 370 mm. This machine is equipped with servo direct drives in wire feeding and product transfer. This allows for quick product changeover, easy reproducibility of proven settings, short set-up times and precision. The Nedform Hybrid is a very flexible machine offering new forming capabilities and high versatility.

The machine can be extended with:

- Integrated pointing and threading station to form bolts (M5 to M24) in one cell operation
- Warm forming



Servo driven product transfer

Electronically set of individual finger opening and closing, and clamping pressure of each finger. Programming of these settings can be set in any position of the main slide. FOP transfer, the fingers open so far that they completely clear the punches. Makes pick-up of very short parts from punch or die possible, and allows the use of extra large punch diameters, hence more forming capabilities.

Servo direct drive linear wire feed

With servo-motor-actuated wire clamps, electronically adjustable at a length precision of 0.01 mm.

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Specifications

Machine type	NHX12	NHX15	NHX15L	NHX18	NHX18L	NHX22S	NHX22M
Number of dies	5-6	5-6	5-6	5-6	5-6	5-6	5-6
Maximum wire diameter (mm) (at 600 N/mm ²)	12	15	15	18	18	22	22
Maximum speed (parts/min.)	240	210	210	180	160	160	160
Maximum kick-out length (mm)	100	125	135	145	160	100	160

Machine type	NHX22L	NHX22EL	NHX25	NHX25XXL
Number of dies	5-6	5-6	5-6	5-6
Maximum wire diameter (mm) (at 600 N/mm ²)	22	22	25	25
Maximum speed (parts/min.)	140	120	120	90
Maximum kick-out length (mm)	210	280	250	370

X = Number of dies

High-speed cut-off station

Plane and precise shearing surface with a minimal of deformation and an accurate cut-off length (volume variation less than +/- 0,2%).

Automatic adjustment of kick-out and short wire feed length detection

Provides quick and accurate product changeover. Using servomotors and a touch screen control panel where all production settings are stored. Change-over from one product to another by one touch.

Punch side kick-out

The punch side kick-out movement is synchronized with the return stroke of the main slide. By doing this, complex shaped parts are kept inside the die and are easy to transfer.

Hydraulic die clamping

The hydraulic die clamping allows to (un)clamp the dies and cut-off quill directly from the operator position without reaching in the forming area. It makes the machine even more operator friendly and easy to use.

Inching motor for full-force slow motion adjustment

The full-force slow motion (or "Inching") motor is a unique solution providing controlled slow-motion movement of the main slide and yet still allowing forming a part.

Quick change punch block

The punch block is a highly accurate tool-jig. It quickly replaces and adjusts the punches, either inside the machine or on the side while the machine is producing. A simple lifting device is used to mount or dismount the punch block into or from the machine. Two blocks is recommended (one in the machine and one outside on the operator platform).

Trimming (through the punch)

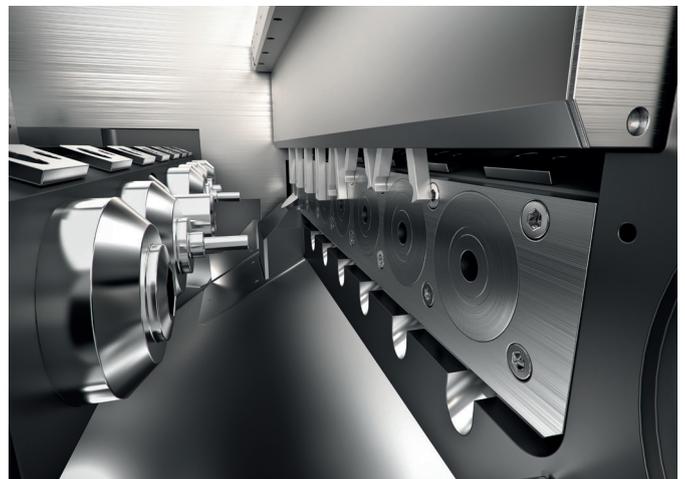
The machine is equipped with an extra trimming cam for the last station. This makes quick and easy changing possible from kick-out to trimming or vice versa without changing the cam.

Short product support

This option allows to transfer very short parts, stepped parts or other complex shaped parts at high production speed, without making special tooling arrangements. The support fingers hold the part during kick-out until they are taken over by the transfer.



Servo driven linear wire feed



FOP transfer