

Narendra



SERIES NHF

HIGH SPEED HOT & WARM FORGING PRESSES

(250 to 1600 Tons)



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FRAME

The frame is rigid built from fusion welding quality steel plates with box-type structure duly stress-relieved & then accurately machined. The structure alongwith all its rigorously calculated key components and run through computer aided analysis for their load distribution, and inspected thoroughly after welding. This approach thus minimizes deformation, maximizes the accuracy of the product, and extends the service time of dies and die shoe to their limits, reduces the vibration during operation.

ECCENTRIC SHAFT

It is obtained from a forged piece of carbon alloy steel. Prior to the machining, the shaft undergoes an ultra-sound inspection and a chemical and metallographic test. Shaft is ground finished on bearing surfaces. Even in case of heavy load, the shaft won't be deformed. Its bearing area is large so that the stress can be decentralized to lengthen the serving life of the shaft.

SLIDE The slide is single piece cast steel and assembled with the link through pins housed and profusely lubricated inside the slides. Corner gibbing provides long parallel guiding surface that maintain slide parallelism under off centre load resulting increase of precision tooling life. The slide is fitted with replaceable bronze liners. The Gib Adjusting points are easily accessible.

HIGH TORQUE, LOW INERTIA SEPARATE TYPE CLUTCH / BRAKE

Clutch / Brake designed especially for high frequency intermittent cycle and heavy load press operation. High torque, smooth start-up, fast coupling. Unique brake designed to be fast heat dissipation and low noise. Non asbestos linings, abrasion resistant, easy maintenance, more environment protection conscious.

SLIDE ADJUSTMENT & STICK RELEASE MECHANISM

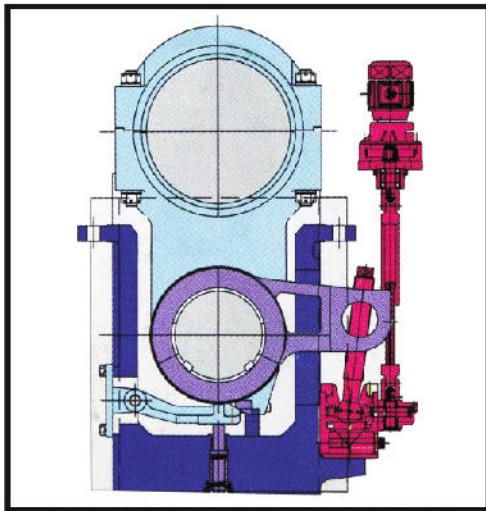
Motorised Slide to adjust the vertical Ram stroke, it can be adjusted with in the range 0.01 ~10mm. It is conveniently designed to facilitate installation or removal of the mold. Stick release device and upper knockout device are provided for higher productivity and work efficiency.

LUBRICATION

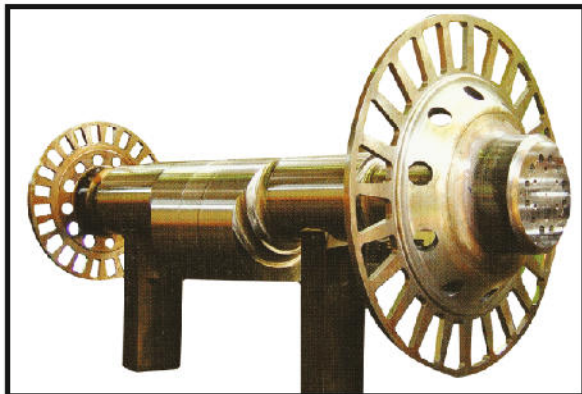
The fully automatic and centralized grease lubrication system can reduce friction between varied mechanical parts and extend the servicing life of the mechanical parts. A safety device is also available to help secure that all the mechanical parts are in a lubricant state to prevent the oil circuits from being blocked to prevent the lubricants from running out.

TECHNICAL SPECIFICATIONS

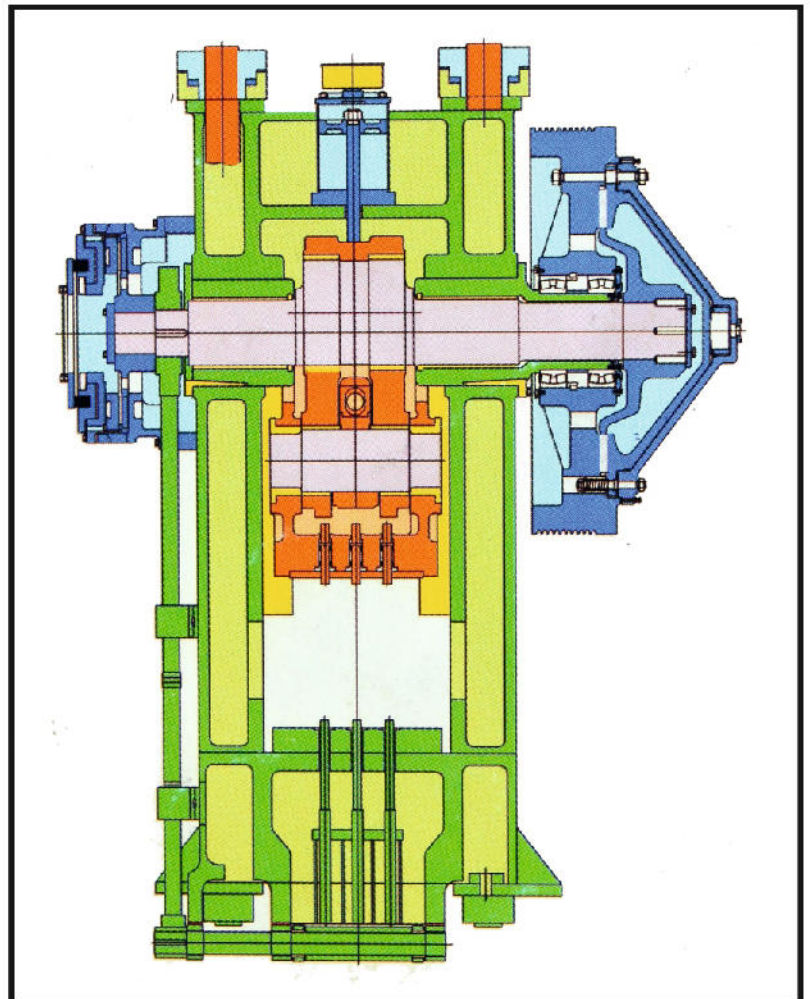
MODEL		NHF - 250	NHF - 400	NHF - 600	NHF - 750	NHF - 1000	NHF - 1350	NHF - 1600
CAPACITY	TON	250	400	600	750	1000	1350	1600
TONNAGE RATING POINT	MM	5	5	5	5	5	5	5
STROKE LENGTH	MM	150	160	170	190	220	240	270
STROKES PER MINUTE	SPM	110	110	105	100	90	85	80
DIE HEIGHT (S.D.A.U)	MM	400	530	560	580	640	700	780
ADJUSTMENT OF RAM	MM	08	08	08	08	10	10	10
BLOSTER AREA (LR X FB)	MM	600X700	600X700	670X780	850X900	900X1000	1000X1050	1200X1200
SLIDE AREA (LR X FB)	MM	580X600	580X600	640X680	740X780	830X880	880X920	1050X1000
SIDE WINDOW	MM	320X500	320X500	360X720	400X740	440X760	500X800	600X700
LOWER EJECTOR (TABLE)	TON X MM	2X40	2X40	2X40	2X40	2X50	3X50	3X50
UPPER EJECTOR (SLIDE)	TON X MM	1X20	1X20	1X20	1X20	1X25	2X25	2X30
MAIN MOTOR	Kw	18.5	30	37	45	55	75	90
AIR PRESSURE	kg/cm ²	4-5	4-5	4-5	4-5	4-5	4-5	4-5
SLIDE ADJUSTMENT MOTORISED	Kw	0.75	0.75	0.75	0.75	1.50	1.50	1.50
LUBRICATION AUTOMATIC		GREASE	GREASE	GREASE	GREASE	GREASE	GREASE	GREASE



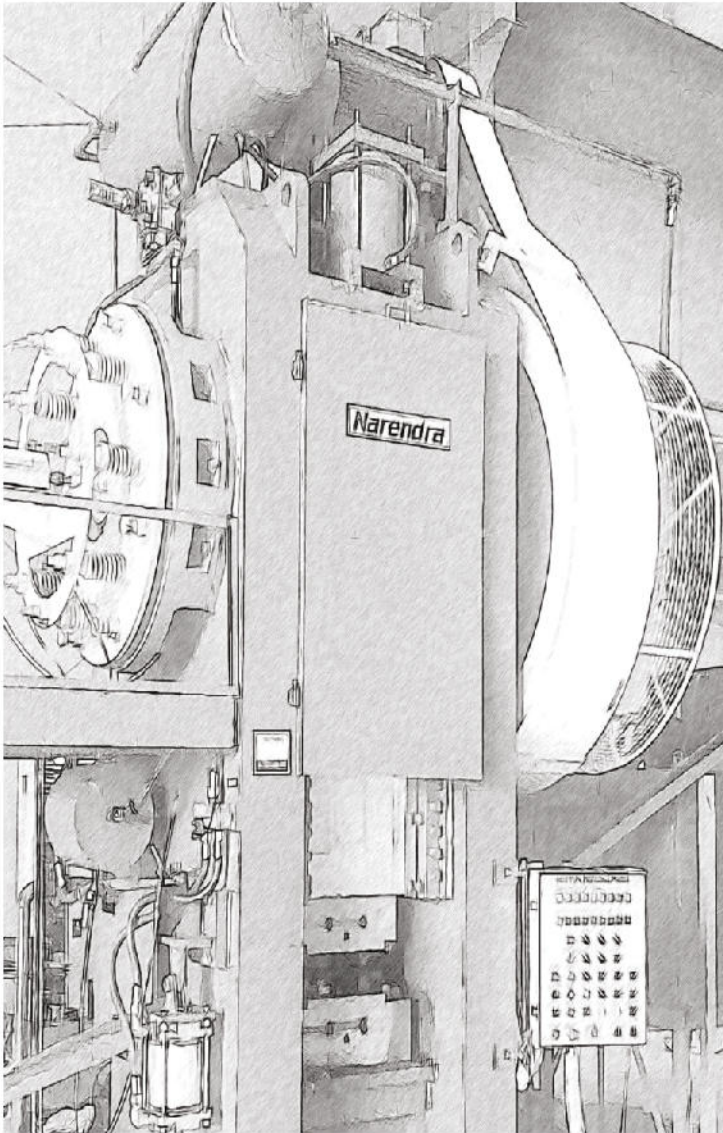
SEMI STICK RELEASE & SLIDE ADJUSTMENT DEVICE



BIG CLUTCH HUB + CRANK SHAFT+ BRAKE HUB ASSEMBLY



Narendra



STANDARD ACCESSORIES

- ◆ SLIDE ADJUSTMENT MOTORISED
- ◆ UPPER & LOWER EJECTOR
- ◆ PLC CONTROL
- ◆ CRANK TEMPERATURE SENSOR
- ◆ PRE-SET ELECTRON COUNTER
- ◆ AUTO LUBRICATION DEVICE

OPTIONS

- ☛ DIE SET
- ☛ QUICK DIE CHANGE DEVICE
- ☛ LOAD MONITOR

Manufactured and Marketed by:

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UNIT - 2

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We reserve the right to change, design and modify specification at the discretion of our engineering department