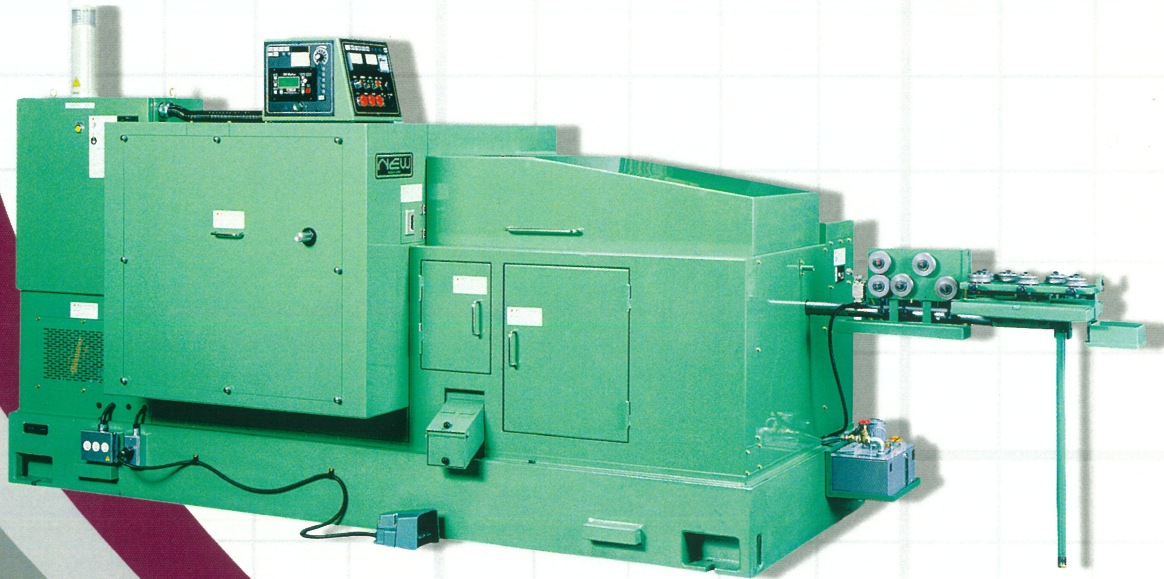


# NS

SERIES

ENGLISH

## 1 DIE 2 BLOW HEADERS

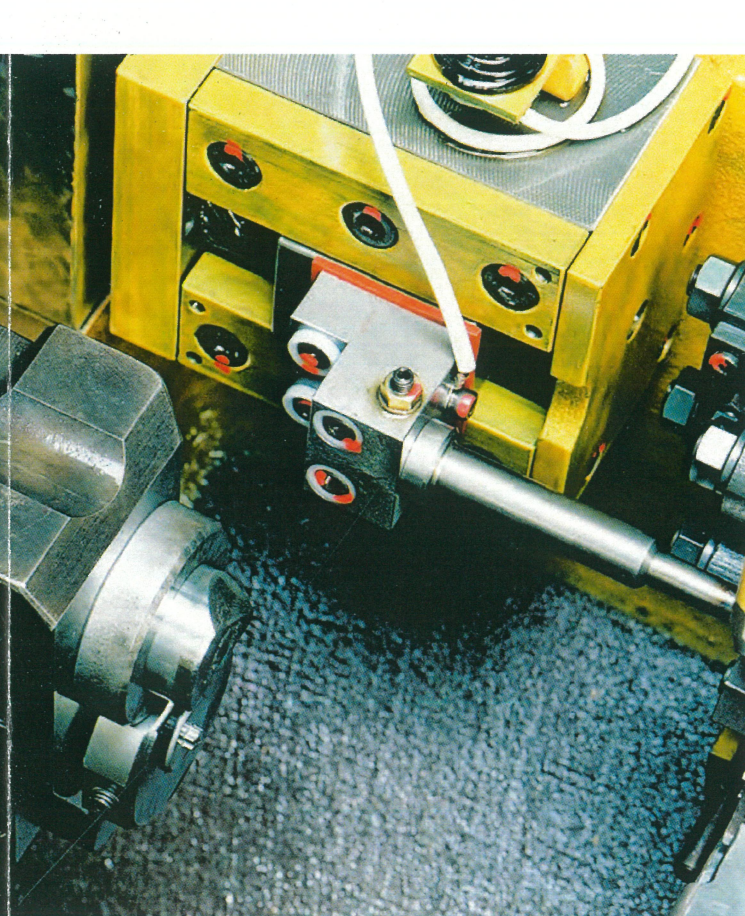
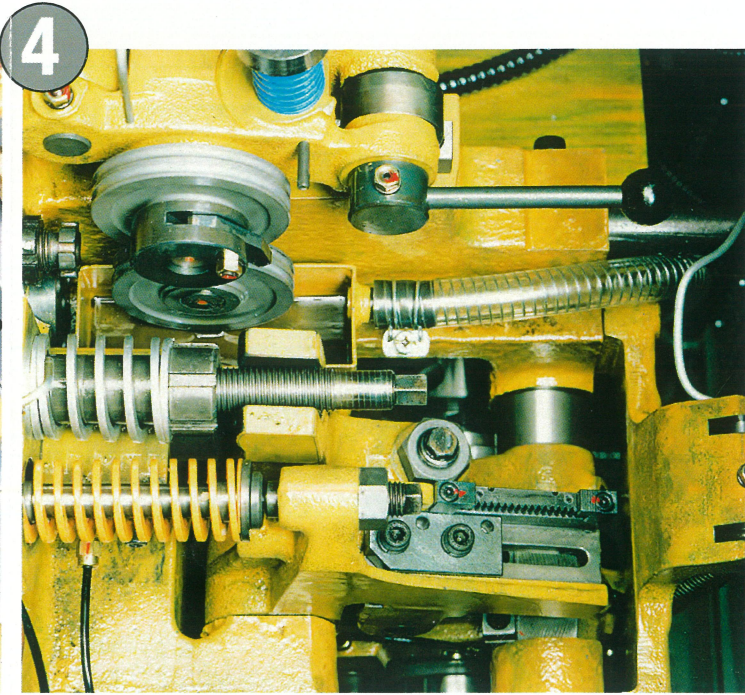
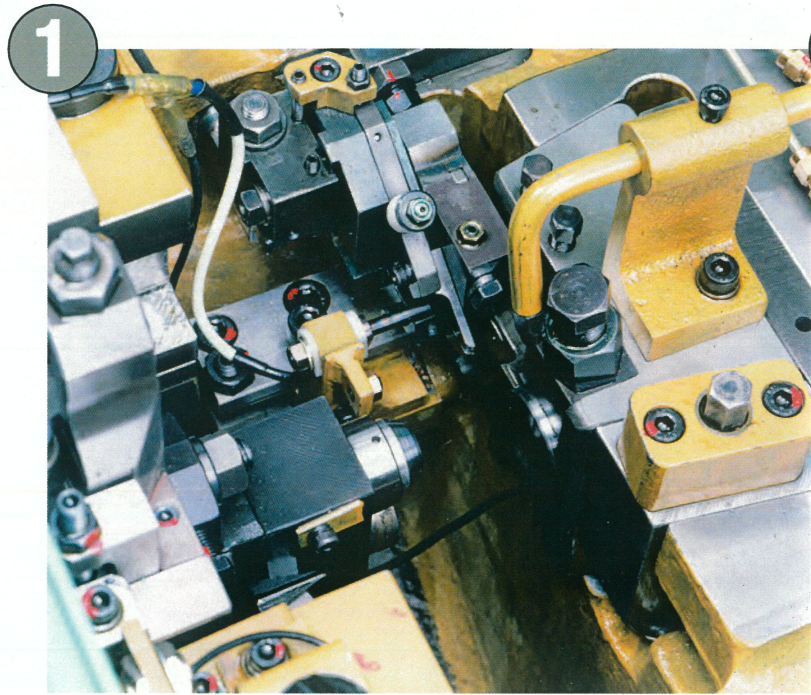


Nakashimada Engineering Works, Ltd.

# NS SERIES 1 DIE 2 BLOW HEADERS

Nakashimada NS Series 1 Die 2 Blow Cold Headers are developed for manufacturing high-precision components. With over 25 years of continuous improvement, we have already delivered more than 1000 sets of NS machines to major screw and rivet manufacturers world-wide.

Rigid machine frame ensures greater stability at high speed, giving longer machine life and enhanced performance. Available for wire diameter from 2.5 mm to 14 mm, and shank length from 30 mm to 250 mm, NS Series presents a flexible choice for manufacturers of a wide variety of precision components.



## 1 Bush Cutter

Bush cutter and heavy duty shearing cam provide a clean and square cutoff, avoiding burrs and irregularities. All NS machines are equipped with Bush Cutters.

## 2 Vertical Punch Slider

Punch Block is securely mounted on a vertical punch slider. Alignment and timing would not be affected by production speed. This vertical punch shift mechanism ensures simple setup and maintenance, higher production speed, accurate and concentric parts production.

## 3 Ram Slider

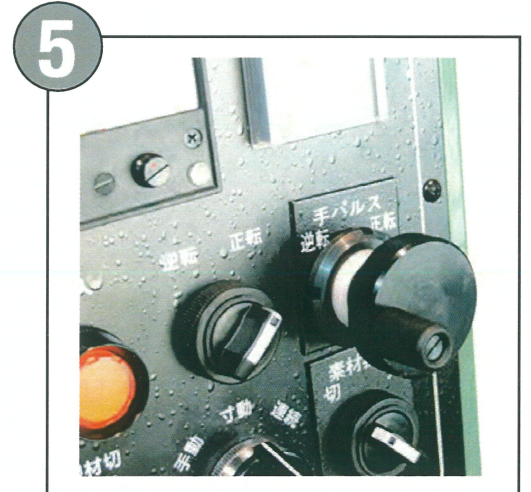
In order to maintain high accuracy in sliding movement, the ram slider is equipped with the tapered liner guide for clearance adjustment. In addition, all sliding parts are hand-scraped to micron level for high tolerance, durability and prevention of part wearing after long use.

## 4 Easy Operation

Tool changes and fine adjustment of all parts can be done at operator side, ensuring repeatable accurate setup and efficient trouble-free changeover.

## 5 Pulse Dial (standard for Ø8 mm or above)

Ram can be moved back and forth by turning a small dial (Nakashimada patent) on the control panel. Useful for critical timing adjustment and efficient setup.



## Major Standard Features

### Wire Feed Auto On/Off Device

A switch on control panel to start or stop wire feed.

### End of Coil Detector

Limit switch placed between the main machine and the wire straightener, detects the end of wire coil and stops the machine automatically.

### Wire Short Feed Detector

When wire does not reach the sensor, machine stops immediately to avoid defects and mixing with good parts.

### Vertical Wire Straightener

Pairing with horizontal straightener, it makes correction of wire more reliable for production. Roll positions can be adjusted by adjuster.

### Timed PKO

Timing type PKO device that reliably holds the blank on the die side during the forging process. Knock-out timing is fixed according to the movement of the machine. Stroke can also be adjusted by changing the PKO cam.

### Signal Tower

Error light mounted on top of the machine to inform the operator that an anomaly had occurred and the machine had stopped.

### Preset Counter

An easy production management tool that counts the quantity of parts produced up to 6 digits. When total output reaches the preset amount, machine stops automatically.

### Warning Light

Error indicator system warns of overload, end of wire, short feed, low air pressure and other anomaly.

### Blank Wiper

Wiper that sends finished part reliably to chute. Extremely effective during high-speed production.

### Jam-Release Hydraulic Pump

When blank is jammed between punch and die during forming operation in bigger machines, at the flick of a switch the hydraulic jack will force the ram to go backward releasing quickly punch and die.

## Major Optional Accessories

Total Counter

Separate Lubrication with Tank

Stripper Device

Phillips Punch Checker

Dead Point Checker (DM Monitor)

Variable Speed Drive (Inverter)

Catch Chute

DKO Relief

Wire Cutter

Oil Micro Separator

Die Block Hook

Pulse Dial (Standard for Ø8 mm or above)

Wire Power Loader

Defect Blank Separator

Standard and optional accessories vary depending on machine model.  
Please contact our Sales Rep for details.

