



invernizzi presse

WE WORK BEST UNDER PRESSURE



NKN-B



NKN-B transfer presses the quintessential solution for your deep drawing needs

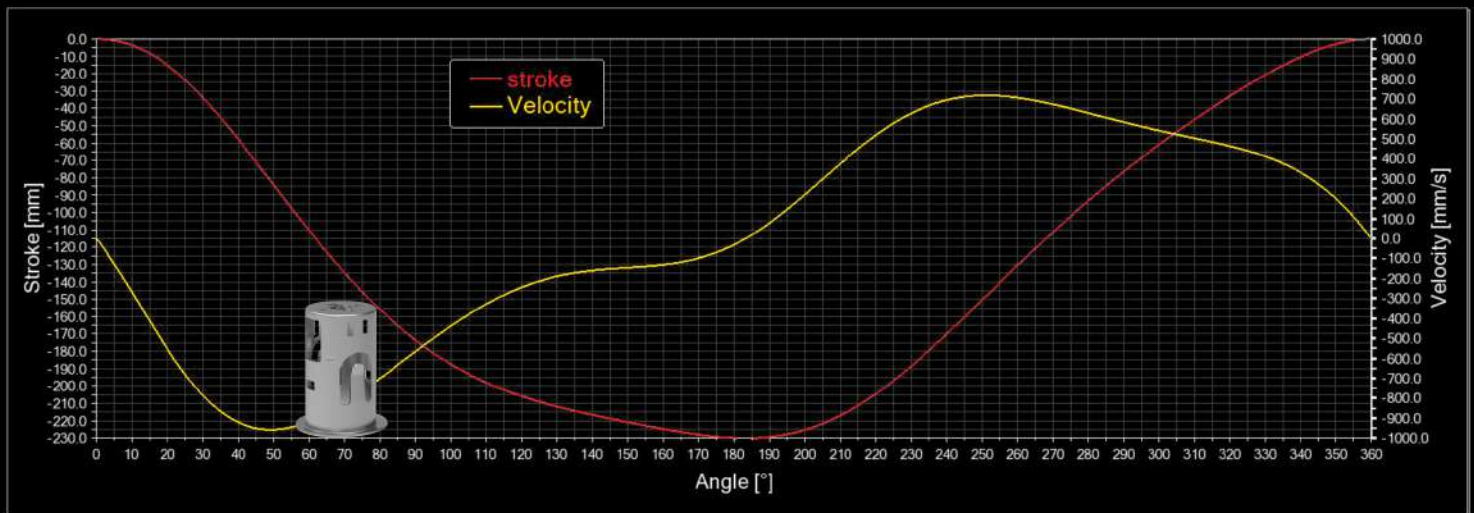
Introducing the NKN-B series, cutting-edge in deep-drawing transfer press technology, engineered to meet the dynamic needs of modern manufacturing.

NKN-B Series Key Features

Innovative Drive System for Controlled Ram Speed Reduction

The NKN-B series operate on levers joint drive.

This levers joint drive system allows for a slower and very smooth speed through the entire drawing-forming stroke area, which is particularly suited for deep drawing components, enhancing both the quality of the formed parts and the performance output. Better results even noticeable to any operator. Superior to traditional cam-driven Systems, which stopping at BDC and TDC, accelerate in the drawing cycle.



Higher Power

Increased Power and Structure in every workstation, even in the first station where Blank and Cup unit is, ensure outstanding rigidity and stability.

Advanced Blank and Cup Operation

NKN-B transfer presses are equipped with a advanced Blank and Cup unit at the first station, seamlessly integrating blanking and cupping processes to boost operational efficiency and precision.

Lower Ejection Mechanism

Equipped with spring-loaded pistons and lower ejection levers operated by cams,

Finger Opening Device

Mechanical Opening Fingers Slide, prevents surface damage due to friction.

Reduced Friction; Enables the use of aluminum/plastic inserts for delicate finishes, crucial for cosmetic components.

Simplified Insert Design; Makes combination inserts easier to produce, with less emphasis on complex angles and radii.

Prevents Jamming; Ensures parts do not get stuck in the tools.

Adjustable Finger Opening; Finger opening is adjustable from 0 to the maximum.

Rapid Transfer Slide Disassembly and Assembly; Ensures quick changes and maintenance.

Zero Clearance Ram

Ram fitted with Preloaded Roller Linear Guides achieving zero clearance for very high-precision, keeping the tool area clean from machine lubrication (no greasy machine).

Clean Tool Zone

Maintains a Tool zone uncontaminated by machine lubrication.

Reuse of Existing Tools

Thanks to vertical Hold-Down and Stripper movements without lateral and longitudinal deviations, so existing tools can be easily reused

Zig-Zag Feeding Device

For feeding material in 2 rows and 3 rows.

located at the rear of the tool, complete with inlet front guide to move in conjunction with the rear feeder for accurate strip centering.

Entering the blank diameter and strip width automatically calculates the feed length and swing distance, optimizing material usage.

Accidental Safety Release Widget in case of collision during transportation.

Blanking skeleton scrap shear

Backside mounted for cutting raw material scraps.

Tool lubrication circuit

Equipped with continuous lubrication pump, tool zone collector for lubricating all stations, and large collection tank with filtration.

Anti-vibration mounts.

Anti-vibration supports at machine feet.

Auxiliary devices connection

Auxiliary shaft for additional processing operations (e.g., thread rolling machine, beading machine, curling machine) thanks to the functional auxiliary motion transmission.

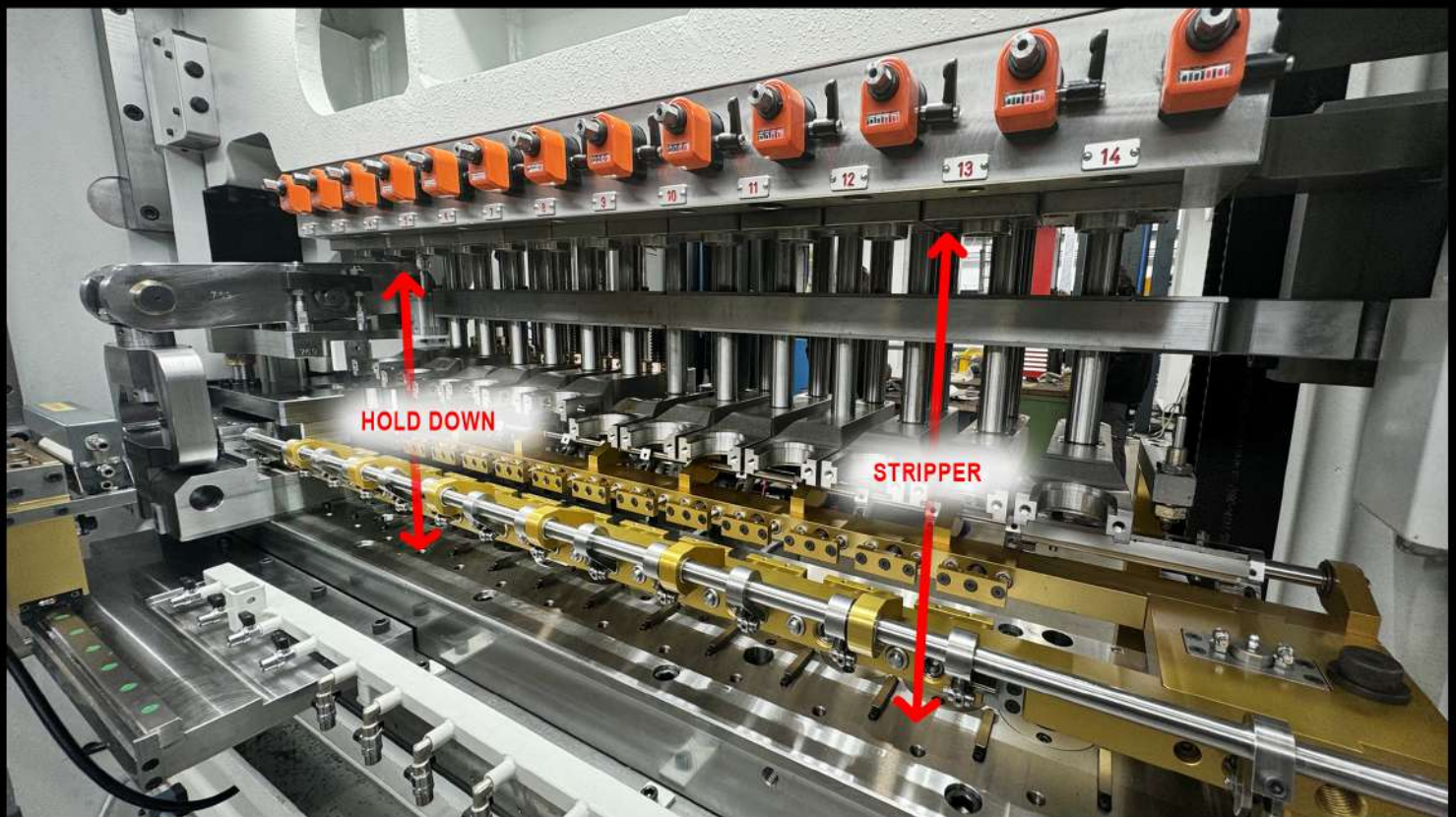
Refeeding Workableness

components can be transferred out of the press for a secondary operation, then reintroduced into the press.

The NKN-B series definitely set a new standard in transfer press technology, offering unprecedented control, quality, and flexibility.

Designed for efficiency and precision, it represents a significant leap forward, empowering manufacturers to achieve superior results.

Explore how the NKN-B series can transform your production capabilities and elevate the quality of your parts.



Thanks to the rectified and perfectly aligned references on each station, disassembling and reassembling the dies is simple and practical.

Repositioning repeatability is guaranteed for a fast and efficient tools change.

Vertical Hold-Down and Stripper movements without lateral and longitudinal deviations, existing tools can be easily reused.

Adjustments that are easy to learn and use.



Hold Down Position Adjustment



Punch position adjustment



Hold Down stroke adjustment



Blank/Cup Press Adjustment



Stripper position adjustment

NKN - B SERIES							
	NKN - B 314	NKN - B 615	NKN - B 617	NKN - B 915	NKN - B 1217	NKN - B 1515	NKN - B 1517
number of stations	14	15	17	15	17	15	17
number of ram	12+1 (slave)	14+1 (slave)	16 + 1 (slave)	14+1 (slave)	16+1 (slave)	14 + 1 (slave)	16 + 1 (slave)
capacity approximate on each ram	4	9	9	12	15	15	18
maximum shell height	30	56	60	80	90	100	125
standard ram pitch	63	85	85	100	100	110	125
double row diameter	45	80	80	95	95	100	115
shut height	80	196	196	260	294	326	392
shut height adjustment mm	15	40	40	40	40	50	50
motor kw	10	20	25	25	30	30	30
speed range	50 - 160	30-120	50-110	30-70	30-70	15-60	15-60
Transfer bars opening / fod - Adjustable opening	fixed	15+15	15+15	20 + 20	25 + 25	25 + 25	25 + 25
fixed bars with spring fingers	X	X	X	X	X	X	X
pressure arm	1	1	1	1	1	1	1
hold down	-	5	6	5	7	6	7
lower mechanical + spring extraction	11	13	15	13	15	13	15
stripper	12	7	9	7	9	7	9
blank and cup in first station	-	standard	standard	standard	standard	standard	standard



Mass production requires the efficient production of a large number of outputs.
For this purpose NKN-B with double line available.

