



CNF Series Nut Former Specifications  
5 & 6 Forging Stations

Model	Unit	CNF-65SP	CNF-65LP	CNF-85SP	CNF-85LP	CNF-105SP	CNF-105LP	CNF-145SP
Forging station	No.	5	5	5	5	5	5	5
Forging force	kgs	52,000	52,000	70,000	70,000	105,000	105,000	190,000
Max. cut-off dia.	mm	φ10	φ10	φ14	φ14	φ17	φ17	φ22
Max.cut-off length	mm	8	15	12	20	14	21	17
Speed Range	pcs/min	180-300	120-200	140-230	90-150	115-190	75-125	90-150
P.K.O.Stroke	mm	8	10	10	12	12	15	15
K.O.Stroke	mm	11	35	16	40	20	38	24
Main slider stroke	mm	70	100	84	120	100	130	134
Main motor	kw	11	15	15	18.5	22	30	30
Cut-off die. dia.	mm	φ40	φ40	φ50	φ50	φ60	φ60	φ80
Punch die. dia.	mm	φ35	φ35	φ50	φ50	φ60	φ60	φ75
Main die. dia.	mm	φ50	φ50	φ60	φ60	φ75	φ75	φ100
Die pitch	mm	58	58	70	70	84	84	108
Approx. weight	kgs	7,800	8,500	8,500	10,000	16,000	16,500	26,000
Max size of hex.nut across	mm	11	11	13	13	17	17	22

Model	Unit	CNF-145SMP	CNF-165SP	CNF-165LP	CNF-205SP	CNF-106SP	CNF-106LP
Forging station	No.	5	5	5	5	6	6
Forging force	kgs	190,000	260,000	260,000	400,000	105,000	105,000
Max. cut-off dia.	mm	φ22	φ26	φ26	φ32	φ17	φ17
Max.cut-off length	mm	21	25	40	35	14	21
Speed Range	pcs/min	70-120	70-120	60-100	60-100	105-175	70-115
P.K.O.Stroke	mm	20	25	35	25	12	15
K.O.Stroke	mm	54	55	80	45	20	38
Main slider stroke	mm	160	160	230	160	100	130
Main motor	kw	37	55	55	75	22	30
Cut-off die. dia.	mm	φ80	φ89	φ89	φ92	φ60	φ60
Punch die. dia.	mm	φ75	φ85	φ85	φ90	φ60	φ60
Main die. dia.	mm	φ100	φ118	φ118	φ143	φ75	φ75
Die pitch	mm	108	129	129	148	84	84
Approx. weight	kgs	28,000	42,000	42,000	45,000	16,100	16,100
Max size of hex.nut across	mm	22	26	26	32	17	17

Remarks

1. Modification is subjected to be made without prior notice.
2. The minimum nut size should be determined on customer's request.
3. Applicable output speed may differ depending upon shape, size and material of the forged parts.
4. The material of cut-off and forming shown above are for low and medium carbon steel and high tensile alloy steel (Grade 10.9).



CNP Series Part Former Specifications  
5 & 6 Forging Stations

Model	Unit	CNP		CNP		CNP		CNP		CNP	
		45S	46S	65S	66S	85S	86S	105S	106S	145S	146S
Forging station	No.	5	6	5	6	5	6	5	6	5	6
Forging force	kgs	24,000		50,000		75,000		110,000		190,000	
Max. cut-off dia.	mm	φ 7		φ 10		φ 13		φ 16		φ 22	
Max.cut-off length	mm	40		45		60		60		80	
Speed Range	pcs/min	130–220		110–180		100–160		90–150		70–120	
P.K.O.Stroke	mm	10		15		20		21		25	
K.O.Stroke	mm	50		60		80		80		110	
Main slider stroke	mm	100		110		140		176		210	
Main motor	kw	11		18.5		22		30		55	
Cut-off die. dia.	mm	φ 24*35L		φ 32*45L		φ 42*60L		φ 70*75L		φ 70*100L	
Punch die. dia.	mm	φ 31*65L		φ 40*90L		φ 45*115L		φ 60*115L		φ 70*130L	
Main die. dia.	mm	φ 38*85L		φ 50*95L		φ 60*115L		φ 75*130L		φ 94*220L	
Die pitch	mm	46		60		80		94		110	
Approx. weight	Ton	9	10	14	16	18	20	22	25	35	40
Max open upset dia.	mm	φ 10		φ 14		φ 18		φ 22		φ 32	

Model	Unit	CNP		CNP		CNP		CNP		CNP	
		165S	166S	205S	206S	255S	256S	275S	276S	305S	306S
Forging station	No.	5	6	5	6	5	6	5	6	5	6
Forging force	kgs	260,000		390,000		500,000		730,000		880,000	
Max. cut-off dia.	mm	φ 26		φ 30		φ 35		φ 41		φ 45	
Max.cut-off length	mm	80		100		140		160		180	
Speed Range	pcs/min	60–100		50–80		40–70		35–60		30–55	
P.K.O.Stroke	mm	35		35		40		45		45	
K.O.Stroke	mm	110		125		150		165		185	
Main slider stroke	mm	210		250		280		300		320	
Main motor	kw	75		90		132		185		220	
Cut-off die. dia.	mm	φ 84*120L		φ 94*130L		φ 109*150L		φ 129*180L		φ 139*195L	
Punch die. dia.	mm	φ 85*160L		φ 95*180L		φ 120*230L		φ 138*270L		φ 158*290L	
Main die. dia.	mm	φ 108*220L		φ 125*200L		φ 148*250L		φ 178*270L		φ 195*290L	
Die pitch	mm	129		140		160		190		210	
Approx. weight	Ton	52	60	80	95	110	135	130	150	155	180
Max open upset dia.	mm	φ 38		φ 44		φ 50		φ 60		φ 65	

Remarks

1. Modification is subjected to be made without prior notice.
2. Applicable output speed may differ depending upon shape, size and material of the forged parts.
3. The material of cut-off and forming shown above are for low and medium carbon steel and high tensile alloy steel (Grade 10.9).