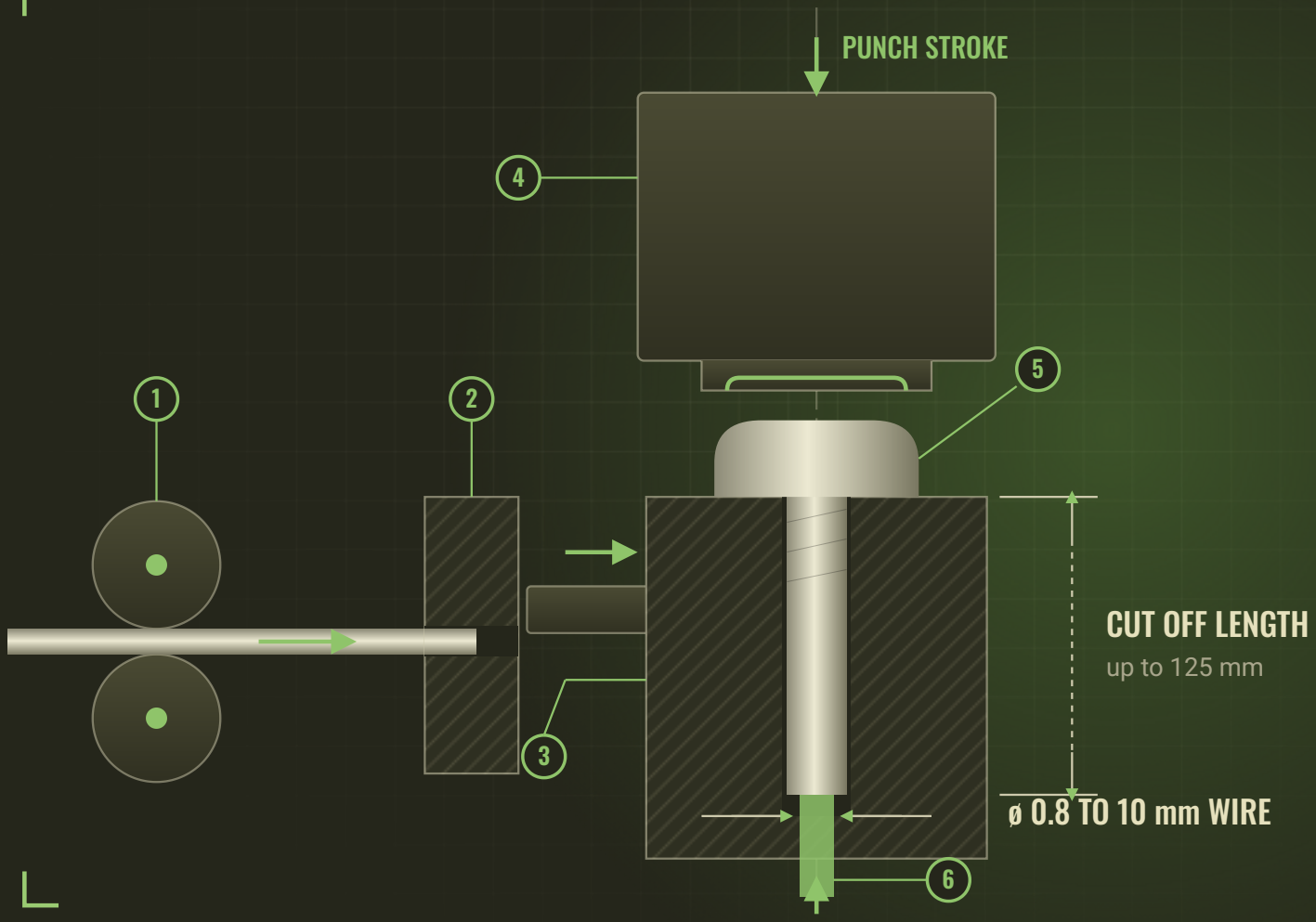
ADHUNIK ENGINEERS
Quality Machines. Trusted Performance.

H series product brochure

COLD HEADING MACHINES

Wire in, head formed, in one continuous cycle. Seven models for wire from 0.8 to 10 mm, built in Punjab since 1988.



1. Feed rolls straighten and feed the wire
2. Cut off die cuts the blank to length
3. Main die holds the blank
4. Punch upsets the wire into the head
5. Formed head, ready for the next stage
6. Knock out pin ejects the part

7	0.8 to 10 mm	145
Models, H-3 to H-10L	Cut off diameter	Pieces a minute, max

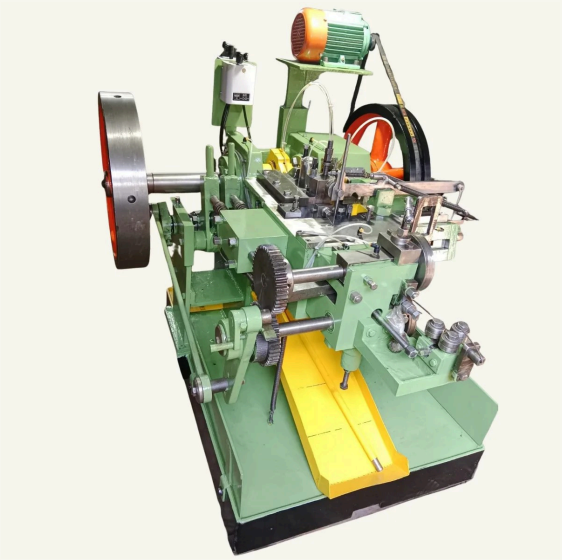
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ADHUNIK ENGINEERS	H SERIES	1988	PUNJAB, INDIA	1 OF 4

How it works

FROM WIRE TO HEAD IN ONE CYCLE

A cold header forms the screw head from cold wire, with no heating and no cutting away of metal. The wire is straightened, cut to the exact length the head needs, then pressed into shape by the punches.

Our H series covers the full range of small and medium fasteners, and is the first machine in every Adhunik screw line.



1
STRAIGHTEN
Feed rolls draw and straighten the wire.

2
CUT TO LENGTH
The blank is cut to the length the head needs.

3
FEED TO DIE
The blank is moved into the main die.

4
PUNCH AND FORM
The punches upset the wire into the head.

5
REPEAT
The part is ejected and the cycle repeats.

Built for long runs

FEATURES

LOW NOISE KNOCK OUT
Quieter ejection of every formed part.

SAFETY SHEAR PINS
Shear first if something jams, protecting the machine.

UP AND DOWN PUNCH SLIDE
Easy access and adjustment of the punch.

EASY KNOCK OUT ADJUST
Quick setting when you change the job.

RIGID HEAVY DUTY FRAME
Holds alignment under continuous heading loads.

HARDENED AND GROUND GEARS
For long life in round the clock running.

What it makes

Bolts · Screws · Rivets · Pins · Special fasteners · Cold formed components

Drawn for	Product	Section	Made in	Sheet
ADHUNIK ENGINEERS	H SERIES	HOW IT WORKS	PUNJAB, INDIA	2 OF 4

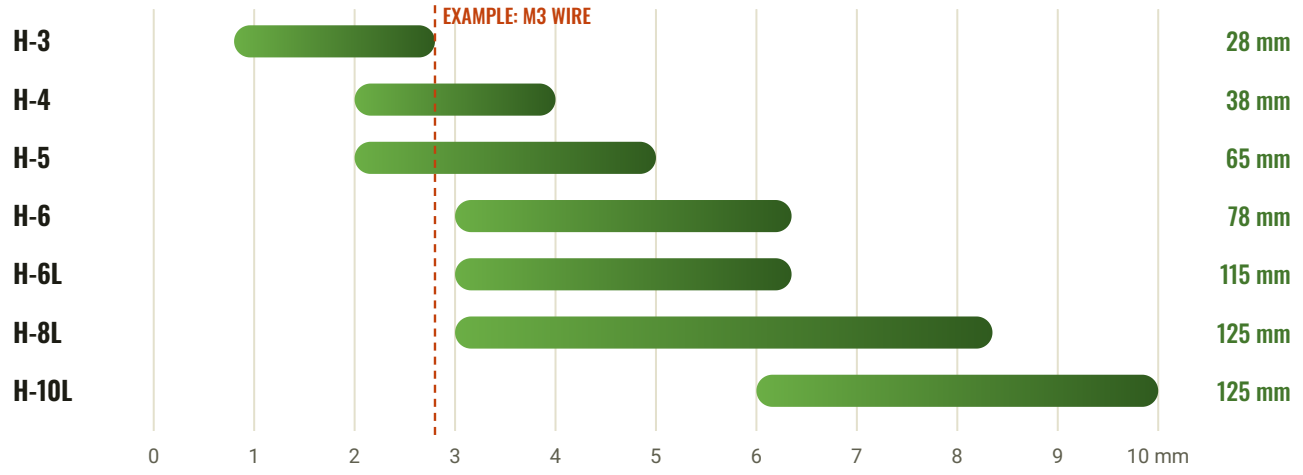
Specifications

SEVEN MODELS. ONE FOR YOUR SCREW.

Model	Cut off dia (mm)	Max cut off length (mm)	Motor (HP)	Max output (pcs/min)	Approx weight (kg)	PKO stroke (mm)
H-3	0.8 to 3	28	1.5	145	650	N.A.
H-4	2 to 4	38	2	125	1000	Optional
H-5	2 to 5	65	3	100	1100	5
H-6	3 to 6.35	78	5	80	1200	5
H-6L	3 to 6.35	115	5	70	1500	5
H-8L	3 to 8.35	125	7.5	80	3000	6
H-10L	6 to 10	125	10	70	4500	6

PICK A MODEL BY WIRE SIZE

Bar shows the cut off diameter range. Number shows max cut off length.



The blank must be longer than the finished screw because part of it forms the head. Send your drawing and our team confirms the model.

DIE AND PUNCH SIZES (DIA × LENGTH, MM)

Tool	H-3	H-4	H-5	H-6	H-6L	H-8L	H-10L
Main die	25×30	32×50	36×65	38×70	38×110	40×110	50×120
Cut off die	12×20	14×25	16×30	18×35	18×35	20×40	25×45
Punch 1	20×40	24×55	28×65	32×65	32×75	35×77	40×98
Punch 2	18×38	24×55	28×65	32×65	32×75	35×77	40×98

TYPICAL STARTING HEADER

For common sizes, before length is checked.

M2 to M3	**H-3**	M4	**H-4**
M5	**H-5**	M6	**H-6, H-6L**
M8	**H-8L**	M10	**H-10L**

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ADHUNIK ENGINEERS	H SERIES	SPECIFICATIONS	PUNJAB, INDIA	3 OF 4

ADHUNIK ENGINEERS
Since 1988

adhunikengineers.com

ONE LINE. ONE MAKER.

Stage 1
COLD HEADING
H-3 to H-10L
0.8 to 10 mm

Stage 2
TRIMMING
TM-5 to TM-10
Hex and flange heads

Stage 2
SLOTTING AND BT CUT
2 to 6 mm
Slots and BT notches

Stage 3
THREAD ROLLING
TR-3 to TR-12
2 to 12 mm

SPARES ALWAYS IN STOCK
Dies, punches, liners and shear pins kept ready for every model.

BUILT ON VMC, CMC AND HMC
Fully automated production, so parts repeat machine to machine.

ON TIME DELIVERY
Dispatch dates agreed up front and kept.

3,500+ MACHINES DELIVERED
At work in fastener plants in India and abroad.

“PRECISION ISN'T A FEATURE, IT'S THE STANDARD WE BUILT THIS COMPANY ON.”

Three generations of the Khokhar family, since 1988

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Mon to Sat, 9 AM to 7 PM

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Block C, Saidpura, Barwala Road, Derabassi, Punjab 140507

Chandigarh plant
36 Plot, 182 Line, Industrial Area 1, Chandigarh 160001

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