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26DT Fine Copper wire drawing machine with annealing

1. Application

It is used for drawing copper and online annealing copper wire.

2. The equipment components

2-1. 26DT Drawing machine with annealing	1Set
2-2. Pay-off rack	1Set
2-3. Electric control system	1Set
2-4. Steam generator	1 Set
2-5. Random documents	

【Technical information】one specification. Including technical specification, operation notice, The machine structure, Mold fitting reference table, installation and Basic floor plan and details (including water/electricity/Gas connection diagram), trouble removal, maintenance, electricity schematic diagram, and so on, one Converter specification.

【Accessories】

Nickel strap 1 Set

3. Mechanical constitute performance analysis

1. The body structure

1-1. Material: Q235

1-2. Structure: Body shape made from sheet steel after annealing treatment to clear internal stress by the precision milling machines, one reaming completed.

2. Inlet part

2-1. Inlet position: on the body's left side panel, set 6 inlet holes.

2-2. Inlet holes position: Installed sump outside.

2-3. Inlet holes equipment: alumina magnetic eye.

3. Axis

3-1. Material: #40Cr

3-2. Accuracy: Axis of quenched and tempered, to ensure clear internal stress, improve the rigidity of the workpiece with the department through the ground to make sure concentricity and roundness balance.

4. .Transmission type: Timing belt

5. Drawing capstan:

5-1. adopt ceramic plasma capstan.12 layer 4, at last only one drawing capstan in the single-deck

5-2. The drawing capstan's load and unload adopt Conical pressing fixed, easy to operate.

6. The eye dies base:

6-1. The first eye die is independent

6-2. The second to 25 are iron cast, small bodies, it can increase the drawing space.

6-3. The eye dies base can be adjusted according to the drawing capstan's position.

7. Lubrication type:

7-1. The drawing capstan and eye die's lubrication, install the activity type pipe joint, so that not affect the threading

7-2. The first to 26, lubricated by pipe independently.

4. Annealing parts (DC Annealing)

The machine adopts four contact wheel three-step annealing mode, to be used with copper wire drawing machine, through the flat belt connected to the back of host, to make continuous annealing 0.1 -0.5 copper wire (refer to the host outlet diameter) more soft. The device adopts the vertical design, with a steam generator, annealing softening chamber using steam protection, an annealing slot, and a cooling chamber full of steam or cooling fluid, without air, to avoid annealed wire oxidation.

Annealing line speed max:600MPM-1500MPM(In line with main machine speed)

4Max annealing voltage: DC70V

Max annealing current: DC300A

Total power: 30KVA

6Annealing Control type: trace wire drawing machine line speed automatically.

Power:415V 50HZ (or according to the customer's requirement)

Steam consumption:6-8kg/h, 0.3-0.4Mpa

Cooling liquid consumption:3-5m³/h,0.2-0.25Mpa

Compressure air consumption: 20m³/h,0.4-0.6Mpa

5. Bobbin take up

5-1 Application: It is used for 0.11-0.5mm.

5-2 main technical parameters

Take up wire range ϕ 0.11~0.5 mm

Take up high-speed 25m/s

Take up motor 4KW

Traversing control: Separate reversible motor control, traversing adjust independently.

Traversing max-width: 300mm

Take up bobbin size:

Outer diameter(OD)	Barrel diameter(ID)	Outer width(OW)	Inner width(IW)	Hole
300	215	290	270	127

brake: magnetic type

6. Electrical control

The machine adopts PLC + HMI unified coordination control, host and take-up adopt transducer infinitely adjustable-speed, annealing with digital control, annealing voltage automatically follow the host speed and can be adjustable independently if the machine has a fault, bolt, and other automatic stop function;

Main-machine interface display voltage, drawing speed, length, annealing current and operation information of all kinds of data.

7. Technical parameter:

Inverter Control	Double inverter control
Max. Die No.	26
Max. Inlet Dia.(mm)	Φ0.95—Φ1.6mm
Outlet Dia.(mm)	Φ0.11-0.5mm
Max.Line Speed(m/min)	MAX1500m/min
Slip ratio of m/c(%)	13%
Fix speed capstan of m/c(%)	8%
Body Structure	Welded by steel plate
Drawing capstan	Ceramic plasma capstan
Main motor power(kW)	18.5KW
Take-up motor(kW)	4kw
Max annealing voltage	0-DC70V
Max annealing current	DC300A
Annealing protection type	steam
Take-up shaft size	Φ300
Traversing type	Reversible motor
Transmission type	Timing Belt
Take-up control	PID Displacement detection automatic control
Displacement detection setting	Sliding-type
Tension control type	Air type
Lubrication type	spray
Brake	Magnetic brake
Voltage	415V 50HZ
Lubrication oil	80liter/min
Pressure consumption	30m³/h



See the wire drawing machine in Action:

<https://youtu.be/geNNaW4b5Ms?feature=shared>