

# Velocity Engineers Private Limited



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## MODEL: 24DW HIGH SPEED FINE WIRE DRAWING MACHINE (HORIZONTAL)

### A. COMPONENT ELEMENT:

1. 24DW drawing machine 1 SET
2. PAY-OFF 1 SET
3. Cart 1 SET
4. User's manual 1 SET
5. Spare parts

### B. MAIN SPECIFICATION:

1. Application: Bare copper wire drawing
2. Inlet diameter:  $\Phi 1.4\text{mm}$ - $\Phi 0.6\text{mm}$
3. Outlet diameter:  $\Phi 0.5\text{mm}$ - $\Phi 0.08\text{mm}$
4. Maximum drawing speed: 2500MPM/MAX
5. Dies: 24 dies (provide by customer self)  $\Phi 25\text{mm}$ \*8
6. Ratio of M/C: Dies No. 1 to No.23 13% Die No.24 8%
7. Drawing method: 4 shafts horizontally arrangement; sliding continuous drawing
8. Power: Main motor: 20HP (15KW) AC motor + frequency converter

Take-up motor: 5HP (3.7KW) AC motor + frequency converter

9. Frame: Cast

10. Transmission: Transmit by flat belts
11. Capstan: Coating by ceramic, horizontally arrangement
12. Lubricant system: Lubricant demand: 40L/MIN (without pump water and tank)
13. Spool dimension:  $\varphi 300\text{mm}$ ( made according to customer)

Take-up capacity: 40-60KG

14. Bobbin loading & unloading; Screw pressing type, with cart
5. Traversing: 110W synchronizing motor traversing; 270mm/Max width
16. Spooling control method: Weight balance by swing arm; automatically revise spooling tension
17. Protection cover: Grille for transmission area;
- Stainless steel plate for drawing area;
- Sealed cover with 3 inspection windows for spooling area.

18. Brake: 20KG electromagnetic brake
19. Weight: 2500K
20. Dimension: 2300L\*1300W\*1700H (mm)

### C. EQUIPMENT TECHNICAL STANDARDS

#### 1. Frame:

1-1 Material: HT-250

1-2 Structure: Cast, annealed

#### 2. Inlet area:

2-1 Position of inlet: On left of machine, 6 inlet holes

2-2 Alumina hole for inlet, there is collecting tank on the inlet area.

#### 3. Shaft: made in 42 Chromium-molybdenum steel

#### 4. Transmission: All transmission by flat belt;

#### 5. Capstan: Ceramic plasma; four 11-tier capstans; one single tier capstan for final drawing

#### 6. Dies

#### 7. Lubrication system: Spray type; lubrication oil 40 liter/min (without water pump & tank); independent lubrication pipe for No.1 & No.23 Die

#### 8. Spool dimension: Outer diameter $\Phi$ 300mm; (according to customer's requirements)

Outer diameter	Inner diameter	Outer wide	Inner wide	Bore Diameter
$\Phi$ 300	$\Phi$ 215	290	270	$\Phi$ 127

#### 9. Traversing unit:

Traversing system: 110W synchronizing motor traversing;

Traversing width: 270mm/Max

#### 10. Bobbin loading & unloading type: single bobbin fixed with screw (with loading & unloading cart)

#### 11. Spooling control method: Weight balance by swing arm; automatically revise spooling tension

#### 12. Brake: 20KG magnetic brake

#### 13. Protection cover: Grille for transmission area;

Stainless steel plate for drawing area; Sealed cover with 3 inspection windows for spooling area.

#### 14. Electric parts: Electric control parts made in China and Taiwan or overseas, top-class brand;

#### 15. Power source: Three-phase 415V 50HZ (according to customer's requirements)

#### 16. Dimension: 2300L\*1300W\*1900H (mm)

#### 17. Weight: 2800KG

## D. CONFIGURATION

### 24D

No.	Name	Specification	Brand
1	Frequency Converters of main machine	11KW	Yaskawa, Made in Japan ,dedicated to wire drawing machine
2	Frequency Converters of spooling	3.7KW	Yaskawa, Made in Japan, dedicated to wire drawing machine
3	Transformer		TAIHAO, made in Suzhou
4	Main Motor	11KW	WANNAN, made in ANHUI
5	Spooling Motor		WANNAN, made in ANHUI
6	Low Voltage Apparatus	3.7KW	OMRON
7	Position limit switch		SHILING, made in Taiwan
8	Switching push button		TEND, made in Taiwan
9	Bearing		NSK, made in Japan
10	Belts		NITA, made in Japan, or made in Switzerland
11	Capstans		Coated by ceramic
12	Frame		Cast

## D. CONFIGURATION

### 1. Paint:

Paint after rustproof production according to clients' requirements.

### 2. The consumables:

Capstan; Distributing guide pulleys; Traversing guide pulleys; Flat belts

### 3. Guarantee:

a. The guarantee period of the machine shall be 13 months counting from the date of the Bill of loading date.

### 4. Commission:

Idle-running test will be carried out at our plant with no rough material fed. An acceptance test will be carried out with rough material fed at the buyer's request. A separate quotation for test Rough material will be offered .this charge shall be borne by the buyer. (Test-run at maker's plant). Running-test is carried out at buyers' plant, all of the charges for the testers including flight ticket, traffic, salary, accommodation outside makers' plant shall be paid by the buyer.

## 5. Accessory:

The prices are for machinery only, price for foundation work installation for machines and distribution of electric wiring & piping outside are excluded. Bobbin(Drum), gear oil, Lubricant oil, Dies, Butt welder, Raw Material, Air compressor, test equipment ,etc. are excluded.



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