

# Velocity Engineers Private Limited



Add: B 49/1, Industries Area, SITE IV, Sahibabad Industrial Area, Ghaziabad, Uttar Pradesh- 201010

Tel : +91-011-43503165      Mobile Phone : +91-9999313315  
E-mail : [Info@velocityengineers.com](mailto:Info@velocityengineers.com)

## VE-28DHA Fine Wire Drawing Machine

### 1. Main Technical Parameters

No.	Parameter	Details
1	Inlet Wire Diameter	Φ0.8 – Φ1.6 mm
2	Outlet Wire Diameter	Φ0.12 – Φ0.45 mm
3	Fixed Speed Capstan Diameter	Φ208 mm
4	Max. No. of Drawing Dies	28
5	Drawing Slip Ratio	1.15
6	Max Drawing Speed	200 m/min
7	Main Motor Power	18.5 kW AC (also stated as 18.5 kW in parts)
8	Take-up Motor Power	4 kW AC
9	Take-up Spool Size	Φ300 × Φ217 × 290 mm (50 KG)
10	Total Installed Power	23 kW
11	Drawing Capstan Diameter	Max Φ242 mm
12	Fixed Capstan Diameter	Φ206 mm
13	Area Reduction Ratio (Machine)	13%
14	Area Reduction Ratio (Fix Capstan)	8%
15	Take-up Range	Φ0.10 – Φ0.45 mm
16	Take-up Speed	Up to 2500 m/min
17	Frame Structure	Iron Cast (HT200), Annealed
18	Drawing Capstan Surface	Ceramic Spray Coating
19	Lubrication Type	Spray (60 L/min)
20	Voltage	380V, 50Hz
21	Brake	20KG Magnetic Brake
22	Machine Weight	2000 KG



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### 2. Machine Components

Component	Specification
<b>Pay-off Unit</b>	1 Set, Overhead Type
<b>Main Drawing Unit</b>	1 Set
<b>Drawing Drums</b>	13 Steps, 4 pcs + 1 final Capstan; ceramic coated, horizontal
<b>Die Base</b>	1st die separate, 2nd–27th are cast adjustable units
<b>Tension Control</b>	Weight balance type with ceramic guiding wheels
<b>Take-up System</b>	Expansion shaft, sealed cover with viewing window
<b>Transmission Type</b>	Timing + Flat Belts
<b>Traversing System</b>	Synchronous Motor + Belt
<b>Control</b>	Dual Inverter, PID Speed Control
<b>Monitoring</b>	Tension indication, wire break sensors (approaching switches)

### 3. Key Materials and Construction

Part	Material / Feature
Machine Frame	HT200 iron casting with annealing and precision boring
Axles	42CrMo + 40Cr, precision tempered
Inlet Hole Eyes	Ceramic
Stepcones	Ceramic-coated, fixed by conical screws



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## 4. Main Component Brands

Part	Brand	Origin
Main Bearings	NSK / SKF	Japan / Sweden
Inverter	Yaskawa	Japan
Main Motor	WN Motor	Anhui, China
Air Switch	SHILIN	Taiwan
Buttons & Relays	Schneider	France
Approaching Switch	TEND	Taiwan

## 5. Production & Power Consumption (Based on EC Grade Copper)

Wire Size (mm)	Speed (m/min)	Production (kg/24hrs)	Power Usage (Units/kg)
0.12	1800–2000	220	0.45
0.15	1800–2000	340	0.32
0.20	1800–2100	650	0.215
0.25	1800–2000	900	0.178
0.30	1400–1800	1120	0.15

## Key Advantages

- High production efficiency (up to 2.5x Indian machines)
- Low power consumption
- Low manpower: One operator can run 2–3 machines
- Advanced monitoring systems for tension and wire break detection

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