



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

VE-26DWT Fine Copper wire drawing machine with online annealing



VE-26DWT Fine Cu wire drawing machine with online annealer is used to draw and anneal Copper wire from 1.6mm to 0.2-0.5mm..

I.Components

Name	Quantity
1.Pay-off stands	1 set
2.VE-26DWT main drawing machine	1set
3.Electrical control system	1set
4.Spare parts	
5.HIM PLC+Touch screen(optional)	1set

II.Main Technical parameters

- 1.Usage: fine Cu wire drawing and annealing
- 2.Inlet diameter: 0.95-1.6-mm
- 3.Outlet diameter: 0.11-0.5mm
- 4.Max. mechanical speed: 2000m/min drawing with annealing speed 0.11mm 1500m/m 0.2-0.25mm 1300m/m, 0.3mm 1200m/m, 0.5mm 600-700m/m.
- 5.Dies: 26 dies



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6.Slip ratio: 13%, Finished capstan slip ratio: 8%

7.Frame: Welded by steel plate

8.Capstans: Ceramic plasma

9.Capstans diameter: 242.85mm

10.Fix speed capstan: 206.85mm

11.Spool bobbin size: 300mm, Iron spool.

12.Spool capacity: 50-60KG

13.Bobbin loading&unloading: Shaft type

14.Annealing method: Three Section Annealing

15.Main motor: AC 3 Phase 18.5KW, Inverter control

16.Take up motor: AC 3 Phase 5.5kw, Inverter control

17.Traversing:110W synchronous motor

18.Annealing pulley:diameter 200mm

19.Annealing volt:DC0~60V

20.Annealing current:DC600A

21.Annealing motor power:36KVA

22.Air pressure: 0.4-0.6MPa, 15L/min

23.Brake : 25KG-M Electromagnetic brake

24.Power source: (customize)

25.Spool control:PID

26.Tension control:Weight balance

27.Lubrication: Spray

III.VE-26DWT Main drawing machine

1.Material:Q235A

2.Structure

2-1.Frame is weld by steel plate, sand blasting and anneal to eliminate the inner stress.

2-2.Further processed by exactitude milling machine.

3.Wire inlet location:Located on the left of machine, 6 bores.

4.Axes Material:45# steel. Precision: HRC25/27 4-3.Eliminate inner stress, improve the rigidity.

5.Capstan Ceramic coating, 4pcs. Loading&unloading the capstans, fixed tightly by cone model, capstan could be displaced according to the die location, avoid break the precision of axes.

6.Die Seat

6-1.The 1st die is independent.The 2nd -20die are founded by milled iron, small, increase operating room.

6-2.Die seat could be displaced according to the location of capstan.

7.Lubricating

7-1.Over the capstan and dies,set floating water pipe, won't impact the wire pointing.

7-2.The 1st and 20 die, lubricated separately.

8.Bobbin size:300mm(customize)

9.Bobbin speed control

9-1.By swing arm, revising the spooler automatically.



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9- 2.Regulating the tension according to the different sizes of outlet diameter.

10.Traversing unit:

10-1.110W synchronous motor, traverse width 270mm (Max)

10-2.The bearing is slippery, high rigidly and fray slowly

VE-26DWT Back





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V. Electrical system



VI. Operation panel (Language can be English or customize)

Containing length meter, speed, voltage, ammeter, button switch, indicator light, control switch, alarm light, etc.
Operation panel and electric cabinet buildup complete electrical system.

IV. Main components list

No.	Item	Specs	Origin	Brand
1	Main Inverter	18.5 kW	China	Inovance
2	Take-up Inverter	5.5 kW	China	Inovance
3	Main Motor	18.5 kW	China + Germany	Deneng
4	Take-up Motor	5.5 kW	China + Germany	Deneng
5	Proximity Switch	E0	China	Inovance
6	Electric Cabinet	60V / 600A	China	
7	Precision Resistance	WDD	Shanghai	Military Enterprises
8	Bearing	NSK	Japan	NSK
9	Capstan	Tungsten Carbide	Guangdong	—
10	Low Voltage Equipment	—	France / Shenzhen	Schneider
11	Instrument	Hengxie	China	Inovance
12	Frame	26DWT	China	