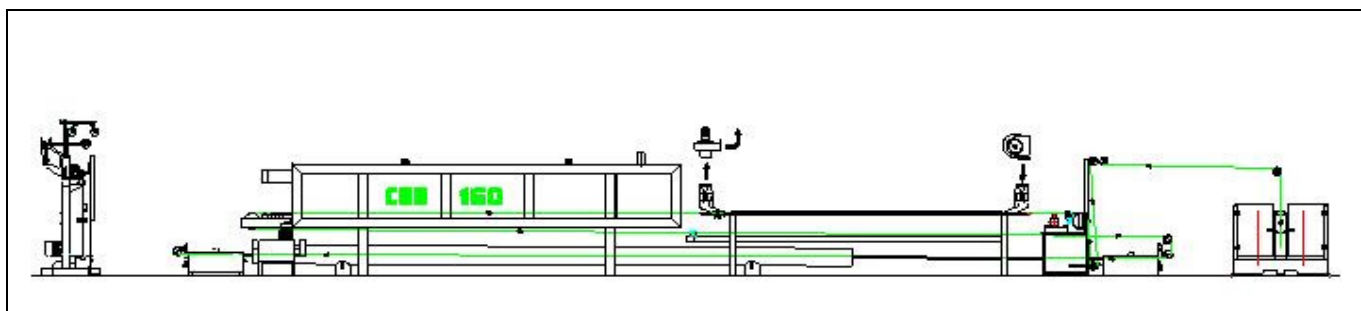
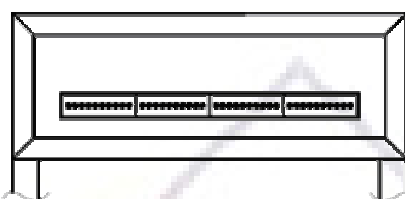


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN FOUR LINES



Thermal KW 120 Cable mm² 70
Motive KW 46 Cable mm² 15

Length = 25 Width = 2 Height = 2

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,16	0,18	0,2	0,224	0,25	0,28	0,315	0,355
PEI KW	1,700	1,556	1,326	1,190	1,063	0,935	0,808	0,723
PU KW	1,200	1,100	0,947	0,853	0,767	0,667	0,587	0,500

- **Bare wire pay-off** with braking system - whiskers - or brake pulley
- **Drawing machine** ring type 19 passes - ring dia. 80mm capstan 120mm max Inlet dia 1,6 - scalar elongation from 31,8% to 19,6%
- **Wire cleaning system** after drawing machine
- **Annealing oven** total length mt 13,5 - 2 temperature control
- **Double dies applicator** wire pitch 9 - 16 base - 8 top -
- **Two enamel tanks** in stainless steel 45/90 lt - two bypass filters, motors, pumps etc.
- **Enamelling oven** chamber length 6,5 mt
- **Wires cooling system** length 6mt counterflow fresh air
- **Wire lubricating system** felts type stainless steel tank, capacity 0,5 lt.
- **Take up** automatic change over - spool min Din 160 max 400/630 or similar
- **All Sheaves - cones - rollers** are ceramic oxide covered
- **Continuity tester** with measurement field until 1500 Volts

PRODUCTION SPEEDS

OUTPUT kg/h per line

IEC	AWG	PEI Grade 1		PU Grade 1	
[mm]	[---]	[m/min]	V*D	[m/min]	V*D

PEI Grade 1	PU Grade 1
[kgh/line]	[kgh/line]

0,16	34	478	77	526	84
0,18	33	435	78	479	86
0,2	32	383	77	421	84
0,22	31	333	75	367	82
0,25	30	292	73	321	80
0,28	29	254	71	279	78
0,32	28	217	68	239	75
0,355	27	185	66	204	72

5,13	5,64
5,91	6,51
6,42	7,06
7,00	7,72
7,65	8,41
8,35	9,17
9,03	9,94
9,77	10,78

Values for Grade 2 application, above guaranteed figures will be reduced by 10%

Values for second enamel (PAI or NY), above guaranteed figures will be reduced by 15%

Plant running speeds depend on various factors such as enamel characteristics, copper quality, number of passes and so on. Under normal running conditions, the plant will run the above indicated speed when using good quality materials and enamels by us suggested having solid content in this range 33÷36% for PEI and 25÷27% for PU.

The final quality level is in compliance with the IEC standards.

During commissioning acceptance test will be considered positive if production speeds values will be reached at the 90%.