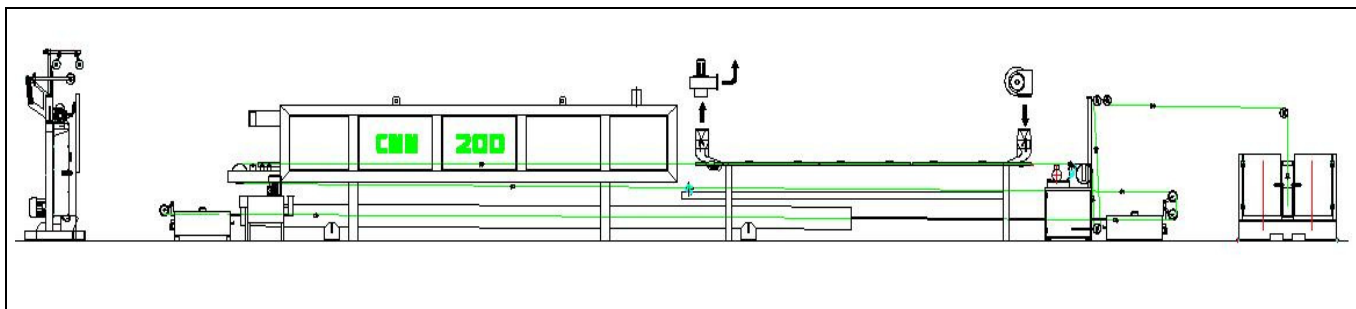
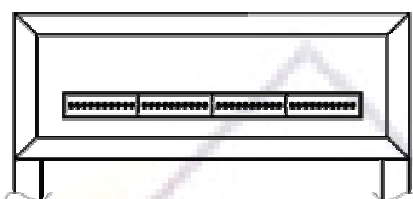


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN FOUR LINES



Thermal KW 137 Cable mm² 70
Motive KW 61 Cable mm² 25

Lenght = 23,5

Width = 2

Height = 2

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,2	0,224	0,25	0,28	0,315	0,355	0,4	0,45	0,5
PEI KW	0,85	0,81	0,77	0,74	0,72	0,70	0,67	0,65	0,63
PU KW	0,70	0,67	0,65	0,63	0,60	0,58	0,56	0,54	0,52

- **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 2,0 - 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 - 16base - 8 top -**
- **Two enamel tanks in stainless steel 45/90 lt - two bypass filters, motors, pumps etc.**
- **Enamelling oven chamber length 8 mt**
- **Wires cooling system length 6 mt 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

0,2	32	536	107	589	118
0,224	31	495	111	545	122
0,25	30	459	115	505	126
0,28	29	415	116	457	128
0,315	28	359	113	395	125
0,355	27	310	110	341	121
0,4	26	266	106	292	117
0,45	25	228	103	251	113
0,5	24	200	100	220	110

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

8,99	9,88
10,41	11,46
12,03	13,23
13,64	15,02
14,93	16,43
16,38	18,01
17,84	19,58
19,35	21,31
20,96	23,06

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%.