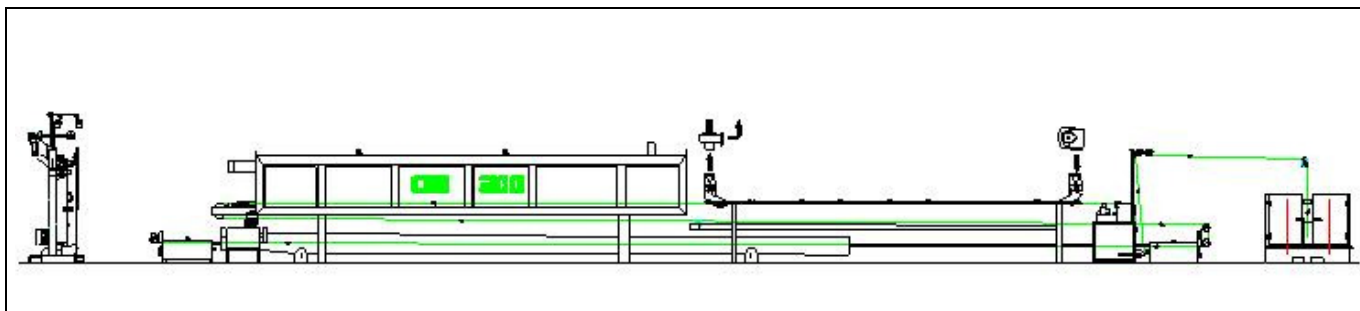
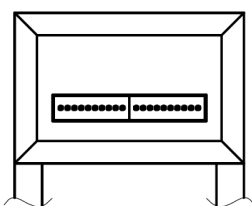


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



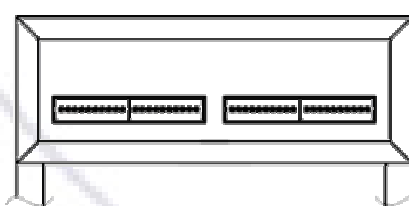
ONE OVEN TWO LINES



Thermal	KW	93	Cable	mm ²	50
Motive	KW	37	Cable	mm ²	16

Lenght = 21,5 Width = 1,2 Height = 2

TWO OVENS FOUR LINES



Thermal	KW	186	Cable	mm ²	95
Motive	KW	74	Cable	mm ²	25

Lenght = 23,5 Width = 2,2 Height = 2

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,3	0,315	0,355	0,4	0,45	0,5	0,56	0,63	0,7	0,8
PEI KW	1,00	0,95	0,90	0,87	0,82	0,77	0,72	0,67	0,61	0,55
PU KW	0,80	0,76	0,72	0,69	0,66	0,62	0,59	0,56	0,51	0,45

- **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 16,5 - 3 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 8,7 mt**
- **Wires cooling system, length 7mt counterflow fresh air**
- **Wire lubricating system, felts type, stainless steel tank, capacity 0,5 lt.**
- **Take up automatic - change over min spool Din 160 spool 400/630 or similar**
- **All Sheaves - cones - rollers are ceramic oxide covered**
- **Continuity tester with measurement field: until 1500 Volts**

PRODUCTION SPEEDS

IEC	AWG	PEI Grade 1		PU Grade 1	
[mm]	[---]	[m/min]	V*D	[m/min]	V*D
0,3	28 ½	402	121	443	133
0,315	28	389	122	427	135
0,355	27	352	125	387	137
0,4	26	319	128	351	140
0,45	25	293	132	322	145
0,5	24	257	128	282	141
0,56	23	228	128	250	140
0,63	22	193	122	212	134
0,71	21	168	119	184	131
0,8	20	143	115	158	126

OUTPUT kg/h per line

PEI Grade 1	PU Grade 1
[kg/h/line]	[kg/h/line]
15,17	16,71
16,18	17,76
18,60	20,44
21,40	23,54
24,87	27,33
26,93	29,55
29,97	32,86
32,11	35,27
35,50	38,88
38,36	42,39

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%.