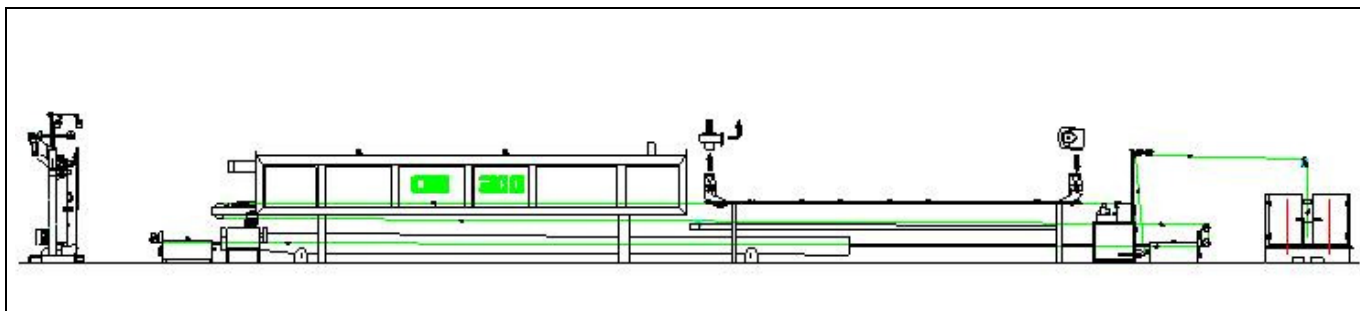
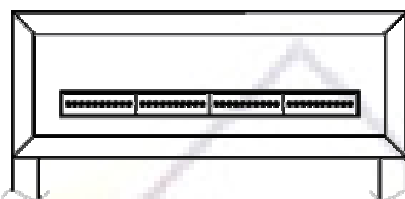


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN FOUR LINES



Thermal KW 138 Cable mm² 70
Motive KW 64 Cable mm² 25

Lenght = 23,5

Width = 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	0,85	0,81	0,77	0,74	0,70	0,66	0,62	0,57	0,52	0,47
PU KW	0,70	0,66	0,63	0,60	0,57	0,55	0,52	0,49	0,44	0,40

- **Bare wire pay-off** with braking system - whiskers - or brake pulley
- **Drawing machine** ring type 18 passes - ring dia. 80mm capstan 120mm max Inlet dia 2,5 - 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 - 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

IEC	AWG	PEI Grade 1		PU Grade 1	
[mm]	[---]	[m/min]	V*D	[m/min]	V*D
0,3	28 ½	362	109	398	119
0,315	28	350	110	385	121
0,355	27	317	112	348	124
0,4	26	287	115	316	126
0,45	25	264	119	290	130
0,5	24	231	116	254	127
0,56	23	205	115	225	126
0,63	22	174	109	191	120
0,71	21	151	107	166	118
0,8	20	129	103	142	114

OUTPUT kg/h per line

PEI Grade 1	PU Grade 1
[kgh/line]	[kgh/line]
13,66	15,02
14,56	16,01
16,75	18,38
19,25	21,19
22,41	24,62
24,21	26,62
26,95	29,58
28,95	31,78
31,91	35,08
34,61	38,10

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%.