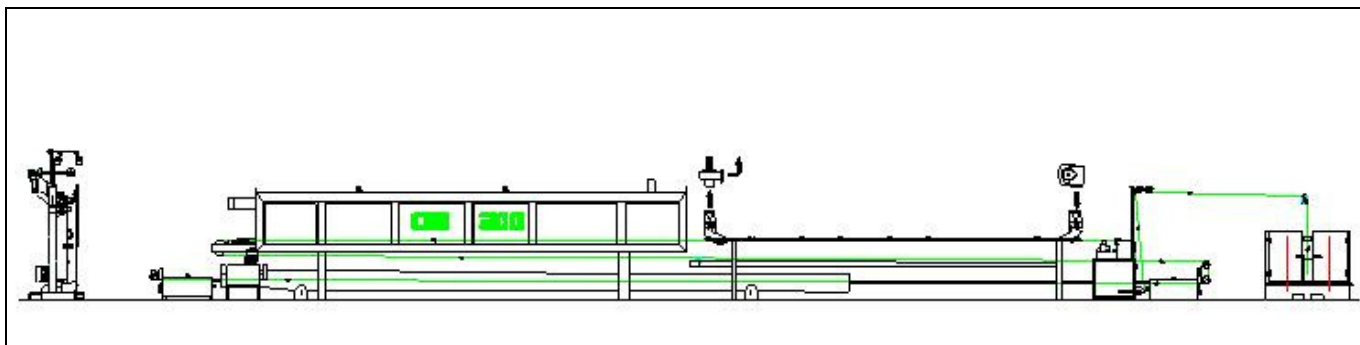
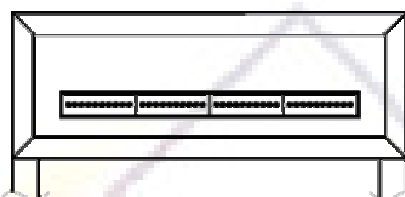


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN FOUR LINES



Thermal KW 138 Cable mm² 115
Motive KW 64 Cable mm² 35

Lenght = 24,5 Width = 2,2 Height = 2

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,5	0,56	0,63	0,71	0,8	0,9	1	1,1	1,2
PEI KW	0,81	0,75	0,70	0,66	0,65	0,61	0,58	0,56	0,54
PU KW	0,68	0,63	0,58	0,53	0,52	0,50	0,48	0,46	0,44

- Bare wire pay-off with braking system - whiskers - or brake pulley
- Drawing machine ring type 15 passes - ring dia. 120mm capstan 200mm max Inlet dia 2,8 - machine elongation from 23%
- Wire cleaning system after drawing machine
- Annealing oven total length mt 16,5 - 3 temperature control
- Double dies applicator wire pitch 10,6 - 17 base - 6 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 7 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

0,5	24	228	114	251	125
0,6	23	211	118	232	130
0,6	22	181	114	199	125
0,7	21	154	109	169	120
0,8	20	130	104	143	114
0,9	19	109	98	120	108
1	18	92	92	101	101
1,1	17	78	86	86	94
1,2	16½	65	78	72	86

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

23,89	26,30
27,74	30,50
30,11	33,11
32,54	35,71
34,88	38,36
37,01	40,75
38,57	42,34
39,56	43,62
39,24	43,46

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%.