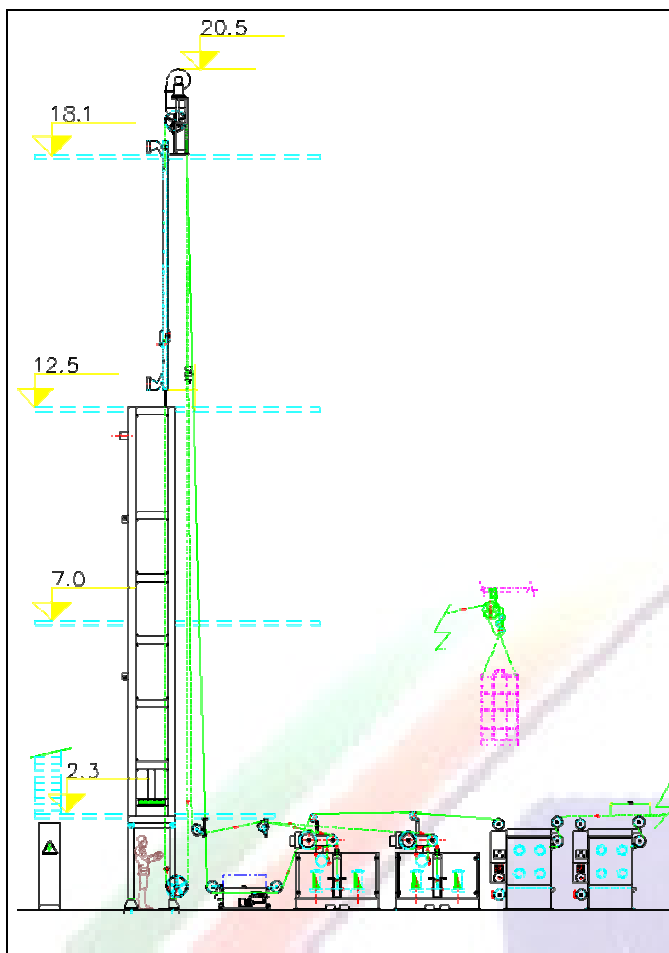
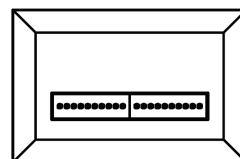


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN TWO LINES



Thermal KW 122 Cable mm² 70
Motive KW 40 Cable mm² 16

Lenght = 11 Width = 1 Height = 20,5

TWO OVENS FOUR LINES



Thermal KW 244 Cable mm² 120
Motive KW 80 Cable mm² 35

Lenght = 14 Width = 1,7 Height = 20,5

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,71	0,80	0,90	1,00	1,12	1,25	1,40	1,60	1,80	2,00	2,24
PEI KW	1,15	1,07	1,02	0,96	0,92	0,87	0,82	0,77	0,72	0,68	0,63
PU KW	0,99	0,95	0,91	0,87	0,83	0,79	0,74	0,69	0,64	0,59	0,55

- Bare wire pay-off with braking system - whiskers - or brake pulley
- Drawing machine skin pass type 11 passes - ring dia. 120mm capstan 200mm - max Inlet dia 3,55 - scalar elongation from 40% to 24%
- Wire cleaning system after drawing machine
- Annealing oven total length mt 16 - 3 temperature control
- Double dies applicator wire pitch 15mm - 14 base - 4 top -
- Two enamel tanks in stainless steel 45/90lt - two bypass filters, motors, pumps etc.
- Enamelling oven chamber length 10 mt - preheating 2,5 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

IEC	AWG	PEI Grade 1		PU Grade 1	
[mm]	[---]	[m/min]	V*D	[m/min]	V*D
0,71	21	182	129	189	134
0,80	20	165	132	175	140
0,90	19	136	122	143	129
1,00	18	112	112	119	119
1,12	17	95	106	99	111
1,25	16	77	96	82	102
1,40	15 ½	62	87	66	93
1,60	14	49	79	54	87
1,80	13	40	71	44	79
2,00	12	32	64	35	70
2,24	11	24	55	27	60

OUTPUT kg/h per line

PEI Grade 1	PU Grade 1
[kgh/line]	[kgh/line]
38	40
44	47
46	49
47	50
50	52
50	54
51	54
53	58
54	60
54	59
50	57

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 38÷40% for PEI and 31÷34% 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%.