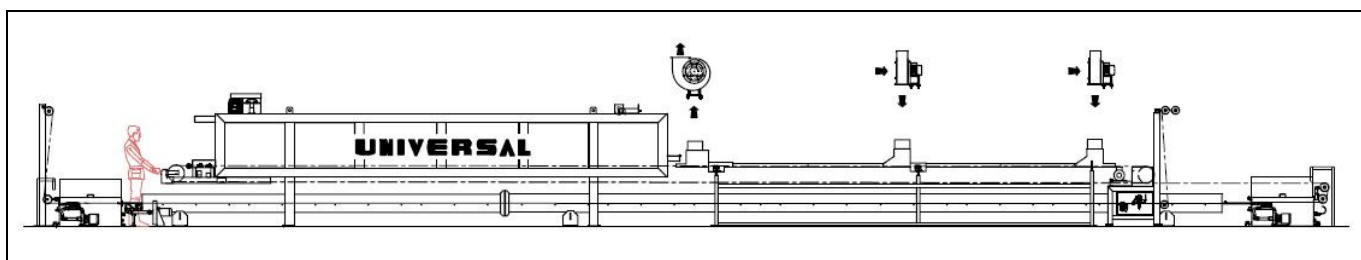
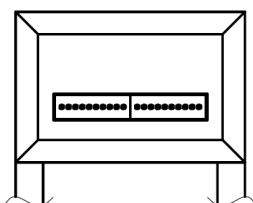


CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



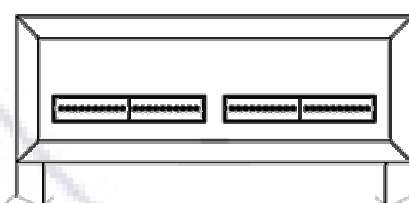
ONE OVEN TWO LINES



Thermal KW 93 Cable mm² 50
 Motive KW 37 Cable mm² 16

Lenght = 27,5 Width = 1 Height = 2

TWO OVENS FOUR LINES



Thermal KW 186 Cable mm² 95
 Motive KW 74 Cable mm² 25

Lenght = 29,5 Width = 1,7 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	0,63	0,71	0,75	0,8	0,85	0,9	0,95	1
PEI KW	1,6	1,45	1,3	1,15	1	0,93	0,87	0,82	0,78	0,74	0,7	0,64	0,6	0,57	0,54	0,52	0,5
PU KW	1,35	1,2	1,05	0,9	0,8	0,7	0,66	0,62	0,59	0,56	0,53	0,5	0,48	0,46	0,44	0,43	0,42

- **Bare wire pay-off with braking system - whiskers - or brake pulley**
- **Drawing machine cones type, dia. 86/240 mm capstan dia. 220 mm, 19 passes**
 Inlet dia 2,0 - machine elongation 23% + 2%
- **Wire cleaning system after drawing machine**
- **Annealing oven total length: mt 15 - 3 temperature control**
- **Double dies applicator wire pitch 12 - 14 base - 4 top -**
- **Two enamel tanks in stainless steel 45/90 lt - two bypass filters, motors, pumps etc.**
- **Enamelling oven chamber length 7,5 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 [mm]	AWG [---]	PEI Grade 1		PU Grade 1	
		[m/min]	V*D	[m/min]	V*D

0,200	32	500	100	550	110
0,224	31	438	98	482	108
0,250	30	384	96	424	106
0,280	29	332	93	368	103
0,315	28	286	90	317	100
0,355	27	248	88	276	98
0,400	26	213	85	238	95
0,450	25	184	83	207	93
0,500	24	160	80	180	90
0,630	22	124	78	140	88
0,710	21	106	75	120	85
0,750	21	97	73	111	83
0,800	20	88	70	100	80
0,850	20	82	70	94	80
0,900	19	76	68	87	78
0,950	19	68	65	79	75
1,000	18	62	62	72	72

OUTPUT kg/h per line

PEI Grade 1 [kgh/line]	PU Grade 1 [kgh/line]
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8,4	9,2
9,2	10,1
10,1	11,1
10,9	12,1
11,9	13,2
13,1	14,6
14,3	16,0
15,6	17,6
16,8	18,9
20,6	23,3
22,4	25,4
22,9	26,2
23,6	26,8
24,8	28,5
25,8	29,5
25,7	29,9
26,0	30,2

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%.