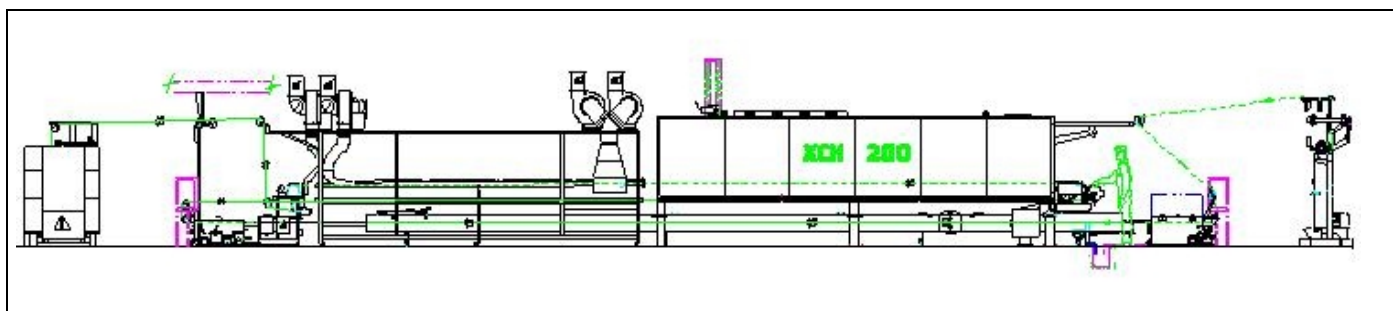
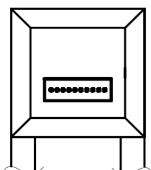
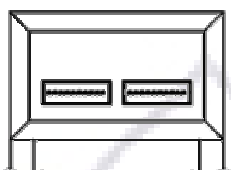
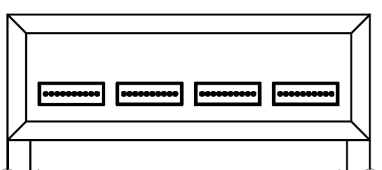


XCH 200

(RANGE 0,20-0,50 IEC)

CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN ONE LINE				TWO OVENS TWO LINES				FOUR OVENS FOUR LINES						
														
Thermal	Kw	51	Cable	mm ² 25	Thermal	Kw	102	Cable	mm ² 50	Thermal	Kw	204	Cable	mm ² 120
Motive	Kw	21	Cable	mm ² 10	Motive	Kw	42	Cable	mm ² 16	Motive	Kw	84	Cable	mm ² 35
L. = 25	W. = 0,8		H. = 2,5		L.=25	W. = 1,2		H. = 2,5		L. = 27	W. = 2		H. = 2,5	

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,2	0,224	0,25	0,28	0,315	0,355	0,4	0,45	0,5
PEI KW	1,20	1,18	1,16	1,14	1,12	1,10	1,08	1,08	1,06
PU KW	0,90	0,89	0,87	0,86	0,84	0,83	0,81	0,80	0,78

- **Bare wire pay-off with braking system - whiskers - or brake pulley**
- **Drawing machine ring type, ring dia. 80mm capstan 120mm, 19 passes - max Inlet dia 2,0 - scalar elongation from 31,8% to 19,6%**
- **Wire cleaning system after drawing machine**
- **Annealing oven total length: mt 13,5 - 2 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 mt**
- **Wires cooling system length 6 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	
		[m/min]	V*D	[m/min]	V*D

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

0,2	32	1131	226	1150	230
0,224	31	1000	224	1020	229
0,25	30	890	223	910	227
0,28	29	786	220	807	226
0,315	28	691	218	708	223
0,355	27	607	216	623	221
0,4	26	531	212	543	217
0,45	25	467	210	477	214
0,5	24	413	207	423	212

18,96	19,28
21,03	21,45
23,32	23,84
25,83	26,52
28,74	29,45
32,07	32,91
35,61	36,42
39,64	40,49
43,28	44,33

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%.