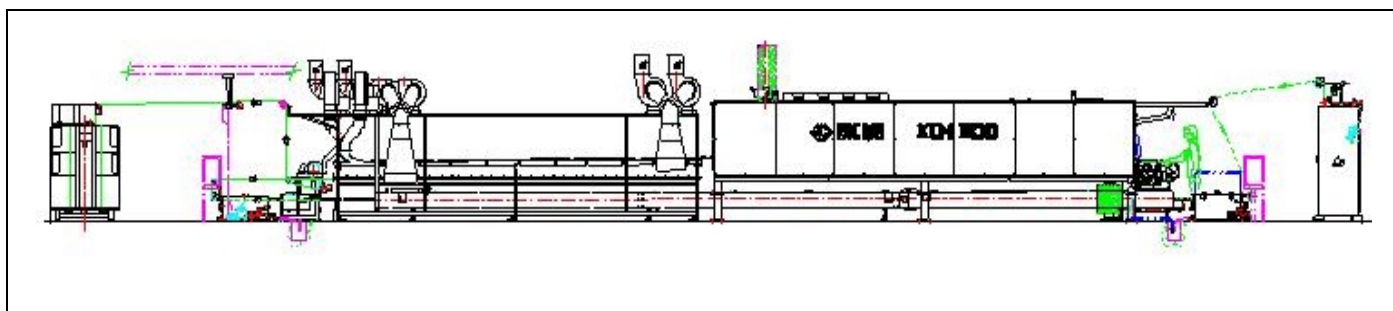


XCH 300

(RANGE 0,30-0,80 IEC)

CONFIGURATION - ELECTRICAL DATA - OVERALL DIMENSION IN METER



ONE OVEN ONE LINE				TWO OVENS TWO LINES				FOUR OVENS FOUR LINES			
Thermal	Kw 52	Cable	mm ² 25	Thermal	Kw 104	Cable	mm ² 50	Thermal	Kw 208	Cable	mm ² 120
Motive	Kw 24	Cable	mm ² 10	Motive	Kw 48	Cable	mm ² 16	Motive	Kw 96	Cable	mm ² 35
L. = 27	W. = 0,8	H. = 2,5		L.=27	W. = 1,2	H. = 2,5		L. = 29	W. = 2	H. = 2,5	

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	1,20	1,16	1,10	1,02	0,93	0,84	0,74	0,65	0,56	0,50
PU KW	0,90	0,87	0,83	0,77	0,70	0,63	0,55	0,49	0,42	0,37

- **Bare wire pay-off with braking system - whiskers - or brake pulley**
- **Drawing machine ring type, ring dia. 80mm capstan 120mm, 18 passes - 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	721	216	738	221
0,315	28	685	216	699	220
0,355	27	611	217	623	221
0,4	26	535	214	545	218
0,45	25	461	207	470	212
0,5	24	411	205	420	210
0,56	23	364	204	372	209
0,63	22	317	200	323	204
0,71	21	273	194	279	198
0,8	20	236	189	241	193

OUTPUT kg/h per line

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

27,20	27,84
28,49	29,07
32,28	32,91
35,88	36,55
39,13	39,90
43,07	44,01
47,85	48,90
52,74	53,74
57,69	58,96
63,31	64,66

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%.