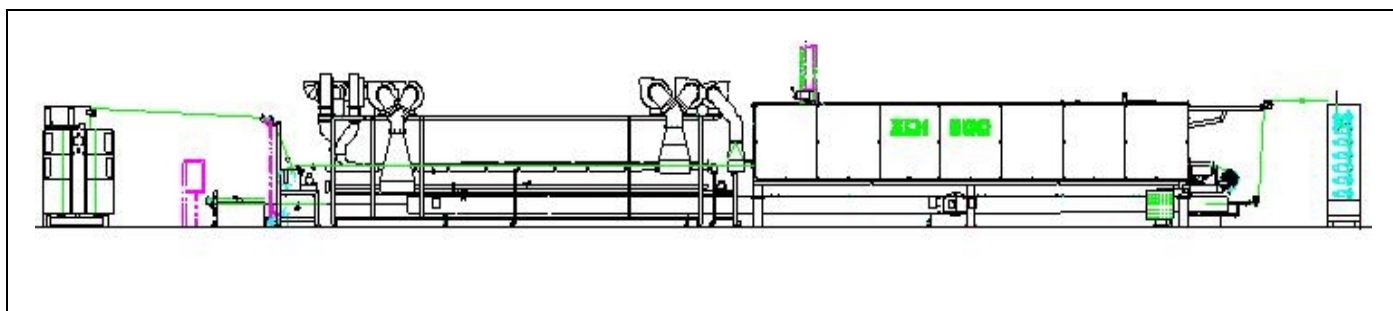
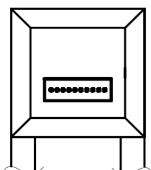
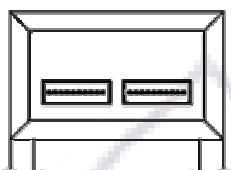
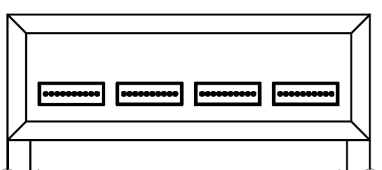


XCH 500

(RANGE 0,50-1,20 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. = 26,4	W. = 0,8	H. = 2,5		L. = 26,4	W. = 1,2	H. = 2,5		L. = 28,4	W. = 2,2	H. = 2,5	

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,5	0,56	0,63	0,71	0,8	0,9	1	1,1	1,2
PEI KW	1,10	1,03	0,97	0,91	0,87	0,83	0,78	0,74	0,70
PU KW	0,80	0,75	0,69	0,65	0,64	0,61	0,58	0,55	0,53

- **Bare wire pay-off with braking system - whiskers - or brake pulley**
- **Drawing machine ring type, ring dia. 120mm capstan 200mm, 15 passes - 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 8,7 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	
		[m/min]	V*D	[m/min]	V*D

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

0,5	24	362	181	378	189
0,56	23	313	175	327	183
0,63	22	268	169	281	177
0,71	21	228	162	239	170
0,8	20	193	154	201	161
0,9	19	161	145	169	152
1	18	136	136	142	142
1,1	17	115	127	121	133
1,2	16½	97	116	102	122

38,7	39,9
43,1	43,6
47,2	48,1
51,1	51,5
54,6	55,9
56,8	59,8
59,9	63,7
63,6	65,8
66,4	67,2

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%.