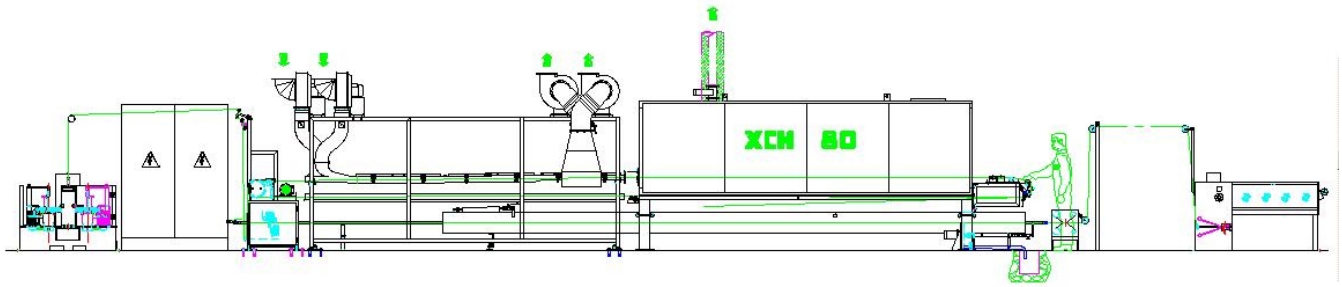
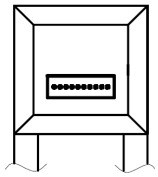
XCH 80 (RANGE 0,08-0,18 IEC)

CONFIGURATION – ELECTRICAL DATA – OVERALL DIMENSION IN METER



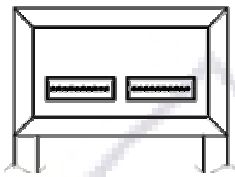
ONE OVEN ONE LINE



Thermal Kw 40 Cable mm² 25
Motive Kw 21 Cable mm² 10

L. = 19,5 W. = 0,8 H. = 2,5

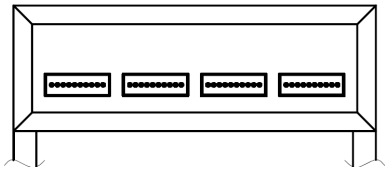
TWO OVENS TWO LINES



Thermal Kw 80 Cable mm² 50
Motive Kw 42 Cable mm² 16

L.=19,5 W. = 1,2 H. = 2,5

FOUR OVENS FOUR LINES



Thermal Kw 160 Cable mm² 95
Motive Kw 84 Cable mm² 35

L. = 24 W. = 2 H. = 2,5

APPROX ELECTRICAL CONSUMPTION

range[mm]	0,08	0,09	0,1	0,112	0,125	0,14	0,16	0,18
PEI KW	3,75	3,25	2,80	2,50	2,20	1,85	1,60	1,40
PU KW	2,90	2,70	2,30	2,00	1,75	1,55	1,30	1,20

- **Bare wire pay-off** with braking system - whiskers - or brake pulley
- **Drawing machine** cones type, dia. 60/173 mm, 21 passes - max Inlet dia 0.743 - machine elongation 12,5% + 2%
- **Wire cleaning system** after drawing machine
- **Annealing oven** total length: mt 9 - 2 temperature control
- **Double felts applicator** wire pitch 8 - 22 base - 8 top - volumetric pump droved by laser system
- **Two enamel tanks** in stainless steel 45/90 lt - two bypass filters, motors, pumps etc.
- **Enamelling oven** chamber length 5 mt
- **Wires cooling system**, length 4,5mt counterflow fresh air
- **Wire lubricating system** felts type stainless steel tank capacity 0,5 lt.
- **Take up** automatic change over - spool min Din 200 max 315/400 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		PEI Grade 1	PU Grade 1
[mm]	[---]	[m/min]	V*D	[m/min]	V*D	[kgh/line]	[kgh/line]
0,08	40	1150	92	1450	116	3,09	3,89
0,09	39	1033	93	1322	119	3,51	4,49
0,1	38	930	93	1250	125	3,90	5,24
0,112	37	839	94	1134	127	4,41	5,96
0,125	36	752	94	1040	130	4,93	6,81
0,14	35	664	93	950	133	5,46	7,81
0,16	34	575	92	850	136	6,17	9,12
0,18	33	511	92	733	132	6,94	9,96

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%.