



PAN-PIONEER Co., Ltd.

民鋒股份有限公司

Name: 630mm-7B Bearing Type Tubular Stranding Machine

630mm-7B Bearing Type Tubular Stranding Machine

[CCCS: Central Computer Control System]

1.] Main specification:

- 1.1.) Type: Tubular rotor bearing surrounding type
- 1.2.) Application: Stranding of 7 wires for
 - 1.2.1.) Copper wire: 1.3-4.5mm soft or hard wire
 - 1.2.2.) Aluminum wire: 1.7-4.5mm EC grade or alloy wire
 - 1.2.3.) Steel wire: 1.0-4.0mm
 - 1.2.4.) Insulated wire: 2.0-5.0mm
- 1.3.) Stranded cable dia: 15mm Max.
- 1.4.) Stranding direction: S & Z.
- 1.5.) Stranding pitch: 20-200mm by MMI+PLC control
100HP+40HP two motors synchronization control
- 1.6.) 6B cage rotating speed: 700Rpm Max.
- 1.7.) Max. line speed: MPM
- 1.8.) Cradle bobbin size: DIN-46397(or buyer's option)
630/Odx355/IDx127/BDx475/Awx400/TWx140/PR
- 1.9.) Take up bobbin size: 1600mm
- 1.10.) Driven motor:
 - 1.10.1.) Main rotor: HP DC motor
 - 1.10.2.) Capstan : HP DC + 4Q Driver.
 - 1.10.3.) (3) Take-up : HP AC + Inverter(Torque module).
- 1.11.) CCCS: Central Computer Control System.
- 1.12.) Operation panel: Touch screen type (Monitor)
- 1.13.) Safety cover: Compact hydraulic lifter type.

2.] Machine composition:

- 2.1.) 630mm center wire pay off stand..... 1 set
- 2.2.) 630mm 6B tubular stranding rotor..... 1 set
- 2.3.) Stranding die stand..... 1 set
- 2.4.) Performing rollers unit..... 1 set
- 2.5.) Post former rollers unit..... 1 set
- 2.6.) Length counter..... 1 set
- 2.7.) 1000mm Dual wheel capstan..... 1 set
- 2.8.) 1800mm cantilever type take-up..... 1 set
- 2.9.) Lubricant circulation system..... 1 set
- 2.10.) Safety cover of machine 1 set
- 2.11.) Motors with control panel 1 set
- 2.12.) CCCS operation panel..... 1 set
- 2.13.) Loading/unloading hoist..... 1 set (option)

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3.] Standard spare parts:

- 3.1.) High speed fuse 3 pcs
- 3.2.) Carbon brush for DC motor 1 pc
- 3.3.) Brake shoes spare 6 pcs
- 3.4.) Sensor for auto counter 1 pc
- 3.5.) Tool box 1 set

4.] Detail specifications:

- 4.1.) Center wire pay off stand Type: shaft less type
 - 4.1.1.) Drum size: DIN-46397
630/Odx355/IDx127/BDx475/Awx400/TWx140/PR
 - 4.1.2.) Loading/unloading of bobbin:
 - 4.1.3.) Positioning: bobbin slided on to the loading position
 - 4.1.4.) Lock/un-lock: bobbin supported by two spindles on both sides of cradle, a ratchet with hand lever to be provided
- 4.2.) Tension control:
 - 4.2.1.) Type: Mechanical compensation type
 - 4.2.2.) Wire tension: 5-50kg adjusted by spring coil
 - 4.2.3.) Tension device:
 - a.) Tension brake: Special band rope for long life operation will be used in this tension device
 - b.) Tension selection: A screw provided to adjust the spring coil pitch which a variety tension force can be obtain.
 - c.) Compensation of tension: A touch arm provided to touch the barrel of pay-off bobbin, the tension will be maintain constant during the barrel change from full bobbin into empty bobbin.
 - d.) Tension brake: Cast iron with rubber coated for bobbin side of wheel to get enough brake force without driven pin and easy loading of bobbin.
 - 4.2.4.) Guide roller for wire path:
 - a.) Guide roller: Use a lot of guide rollers in the bend portions of wire path to avoid the scrape out of wire surface
 - b.) Guide die: Use a lot of tungsten carbide guide dies in the straight line of wire path to avoid the wire jump out from center
 - c.) Path hole dia: 10mm/ID to be provided.
- 4.3.) 630mm-6B tubular stranding rotor.
 - 4.3.1.) Type: Tubular type strander, the rotor supported by ball bearings which surrounding the tube outer diameter, there are 6 sets of cradle laying inside the tubular rotor.
 - 4.3.2.) Tubular rotor: 1000mm/OD, made of steel tube with excellent dynamic balance test.
 - 4.3.3.) Tubular rotor support: by 3 pcs of special ball bearings

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