



Name: 630mm Double Twist Bunching Machine

630mm Double Twist Bunching Machine

1.] Main specification:

- 1.1.) Type: Double twist bunching without back twist
- 1.2.) Application:
 - 1.2.1.) Multiple wires bunching, up to 100 fine copper wires.
 - 1.2.2.) 7B wires accurate construction of annealed copper wires stranding.
- 1.3.) Individual wire diameter:
 - 1.3.1.) Flexible wire: multiple wires, up to 100 wires.
 - 1.3.2.) 7 wires stranding:Max. (7/0.4mm – 1.04mm)
- 1.4.) Rotor speed: Rpm.Max. (Twist/Min)
- 1.5.) Stranding pitch: 11-60mm
- 1.6.) Take up bobbin size: 630mm/OD x 475mm/AW DIN. Max.(Or customer's request) 560mm/OD x 425mm/AW DIN. Min.
- 1.7.) Driven motor: HP AC motor c/w INVERTER

2.] Machine composition:

- 2.1.) 630mm-7B Flyer pay-off..... 1 set (Option)
- 2.2.) 630mm bunching machine 1 set
- 2.3.) Length counter 1 set
- 2.4.) Bobbin loading/unloading 1 set
- 2.5.) Wire broken detector 1 set

3.] Excluding items:

- 3.1.) 315mm-Multi-wire pay-off..... 1 set(option)

4.] Standard spare parts:

- 4.1.) Lay pitch gears 1 set
- 4.2.) Steel bows with guider 1 pair
- 4.3.) Timing belt..... 1 set
- 4.4.) Flat belt 1 set
- 4.5.) Tools for operation 1 set



5.] Detail specifications:

5.1.) Bunching machine:

5.1.1.) Die plate:

- a.) Type: ratchet adjusting type.
- b.) Guider die: 5mm ID. ceramic die.
- c.) Moving distance: 100mm Max.
- d.) No.of die holes: as per request.

5.1.2.) Stranding bow:

- a.) Type: Flexible bow type.
- b.) Material: spring steel with dynamic balancing test.
- c.) Guider die: a number of ceramic dies fixed on the wire path to reduce friction force between bow and wire during stranding.
- d.) Driven: each end of flyer driven by a timing belt through the counter shaft.
- e.) S & Z stranding:
 - 1) Changing the motor rotating direction by selector inside the control panel.
 - 2) Changing the take-up direction gear which mounted inside the machine.

5.1.3.) Capstan:

- a.) Type: dual wheel type.
- b.) Capstan dia: 150mm dia with 4 & 5 grooves
- c.) Stranding pitch: 11-60mm. or as per customer's option pitch changed by change gears.
- d.) Material: Made of carbon steel, surface with hard chrome plated.

5.1.4.) Take up cradle:

- a.) Type: shaftless type, drum locked by screw spindles on both sides of cradle.
- b.) Take up drum: (DIN-46397)
630/ODx355/IDx475/AWx400/TWx127/BD Max. (500kg)
- c.) Driven system: driven by capstan shaft through a pair of slip clutch to spooler.
- d.) Pulling tension: adjusted by springs of slip clutch.
- e.) Traverse: Bearing type traverser having a 400mm traversing stroke made in Europe.
- f.) Traversing pitch: 2-16mm, both stroke & pitch are adjustable.

5.1.5.) Rotor:

- a.) Main shaft: 2 pcs of main shaft are supported by stands separated on each end of machine with heavy duty bearings surrounded on it, a gear pump for oil lubrication is provided on each support stand.
- b.) Rotor brake: Magnetic type disc brake on the counter shaft for emergency stop of machine, braking time 4-6 seconds

5.1.6.) Safety cover:

- a.) Type: front door open type with two layers cover. Inner side made of anti-noise material, working noise not over than 80dB.



- b.) There are a plastic glass windows on the front top side for easy inside viewing.
 - c.) A 20 watts fluorescent lamp installed inside the safety cover.
- 5.2.) Length counter:
- 5.2.1.) Type: 5 figures digital type auto-counter.
 - 5.2.2.) Counting unit: 1 meter/ counting
 - 5.2.3.) Counting wheel dia: 159mm. with 2 pcs of sensor teeth
 - 5.2.4.) Pulse detecting: $159\pi \times 2=1M$
 - 5.2.5.) Auto stop: when the counter length has been reached machine will stop automatically.
- 5.3.) Loading and unloading device:
- 5.3.1.) Front loading with hydraulic hand jack lifter.
 - 5.3.2.) Loading capacity: Kgs Max.
- 5.4.) Auto stop device:
- 5.4.1.) In case of wire broken.
 - 5.4.2.) In case of counter pre-set length has been reached.
 - 5.4.3.) In case of safety covers out of position.
- 5.5.) Electric operation panel:
- 5.5.1.) Power source control
 - 5.5.2.) Ampere/voltage meter
 - 5.5.3.) INVERTER control panel
 - 5.5.4.) Length counter
 - 5.5.5.) Rotor RPM indicator
 - 5.5.6.) Pilot lamps
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