Wet Wire Drawing Machines
with drawing cones fitted on horizontal axles
Application

Our wet wire drawing machines are designed for drawing of high carbon steel and stainless steel wires as well as brass and bronze wires. In this regard we would like to mention especially tyre bead wire, hose wire and belt armouring wire.

Method of working

During the drawing process not only the wire but also the drawing dies and the cones are totally flooded by the drawing lubricant.

Mechanical design features

- 6 sets of drawing cones fitted on horizontal axles and arranged in pairs side-by-side.
- Axles of drawing cones with special slide seals towards the gear housing to avoid leakage of lubricant
- Drawing cone drive designed as high-efficiency tooth belt gear
- Drawing cones with tungsten-carbide coating for long-time operation and indifference against shocks
- Drawing basin with cover and overflow chamber made of stainless steel and additional front cover of aluminium-alloy as splash-proof enclosure
- Die holders arranged for drawing “from bottom upwards”. Concentric pass of wire through the dies guaranteed by turning of wire around lower and upper cone
- Die holder for final die cardanically hinged
- Pull-off capstan water-cooled and additional deflection roll to guarantee that wire is placed and runs on capstan “turn by turn”.
- Lubricant supply by individual tank and pump for each machine or connection to a central lubricant supply system
- Spray nozzles in drawing basin guarantee wetting of cones and dies during drawing-in process.
- Safety devices are designed according EN - Standard

Electrical design feature

- AC main drive motor, water cooled = low noise level and environment emission; Option: air cooled by individual fan
- SIEMENS frequency converter
- Stored program control SIMATIC S7
- Operator Panel OP
- Switch cabinet with air conditioner, attached to machine body and completely wired

Technical Data

<table>
<thead>
<tr>
<th>Size</th>
<th>Max. no. of drafts</th>
<th>No. of cone axles</th>
<th>Inlet dia. max. mm ( H8 )</th>
<th>Finish dia. mm</th>
<th>Draw. Speed max. met./sec.</th>
<th>Motor power ( kW )</th>
</tr>
</thead>
<tbody>
<tr>
<td>13</td>
<td>22</td>
<td>6</td>
<td>1,50</td>
<td>0,15 - 0,30</td>
<td>20</td>
<td>22</td>
</tr>
<tr>
<td>18</td>
<td>22</td>
<td>6</td>
<td>1,85</td>
<td>0,20 - 0,38</td>
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<td>30</td>
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<td>30</td>
<td>21</td>
<td>6</td>
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<td>0,40 - 0,50</td>
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<td>75</td>
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</tbody>
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