



HÜTTNER
MASCHINEN
Hüttner Maschinenfabrik GmbH

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Double-disc wire-drawing block with oscillating spooler



Designed for drawing profiled wires. The two wire-drawing disks are driven and cooled by water. For preventing the edge damaging of the wire windings on the wire drawing disks, the second wire drawing disk can be swivelled hydraulically. For manufacturing the profiles, alternatively can be used draw dies or also trailing cable devices. The oscillating layer-layer spooler has been equipped, for the coil manufacturing, with a dismantlable patent spool.

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|----------------------|-------------------------------------------------|
| Applied material | : alternatively steel, nickel, nonferrous wires |
| Run-in wire diameter | : max. 8,0 mm |
| Drawing speed | : 8 m/min |

Non-driven PAY-OFF of the SPOOL

- Pay-off material : profiled wires of copper
- Material cross section : 5,0 - 120 mm²
- Uncoiling speed : max. 100 m/min
- Spool supporting device : horizontal in conical sleeves
- Adjustment of the clamping sleeve : manually by means of hand wheel with threaded spindle
- Spool lifting and lowering device : manually by means of hand hydraulic
- Dimensions of spool : max. flange diameter 1500 mm
- Clear width : max. 1150 mm
- Spool weight : max. 3000 kg
- Material retaining : by means of ferromagnetic powder brake with adjustable continuous slip
- Material conduction : compl. profile conductive and guide system to the drawing machine

Double disc wire drawing block

- Execution of the wire drawing block : two disks in horizontal arrangement
- Manufacturing cross section : 5,0 - 120 mm²
- Drawing disk execution : two-stage drawing disks for double drawing
- Drawing stage diameter : 480 mm and 600 mm
- Drawing disk II is infinitely motor-slewable in the Y axis so that results a max. spreading of 4°
- Drawing stage useful width : approx. 200 mm
- Drawing disk cooling : water-cooled
- Drawing speed : max. 100 m/min

The drawing disks are welded disks, the cylindrical running surfaces of which are coated and ground so that they are wear-resistant. At the outside and at the centre flange of the drawing disk are mounted respective clevis-type eyes for drawing tongs. The drawing tool holding device will be mounted, on customer's request, to the drawing casing.

- Type of drive : three-phase geared motor
- Driving power : approx. 40 kW
- Drive control : frequency converter

Traversing PROFILE SPOOLER HSPL- 1000

- Material to be spooled : profiled wires of copper
- Manufacturing cross section : 5,0 - 120 mm²
- Pay-off speed : max. 100 m/min
- Spool supporting device : horizontal (flying)
- Spool clamping : by means of triple-threaded nut
- Spool change : by means of fork lifting truck
- Spool dimensions : max. flange diameter 1000 mm
min. core diameter 400 mm
clear width, max. 450 mm
- Spool weight : max. 1000 kg
- Type of drive : three-phase geared motor
- Driving power : approx. 10 kW
- Drive control : frequency converter
- Laying drive : frequency-controlled three-phase geared motor controlled in 4-Q-control techniques
- Laying slide guideway : hardened and ground roller slideways
- Laying change-over : adjustable by means of decade switch
- Guide of material to be coiled : compl. profile conductive and guide system to the spool
- Wire tension : between drawing machine and spooler, by means of wire drawing regulation



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