



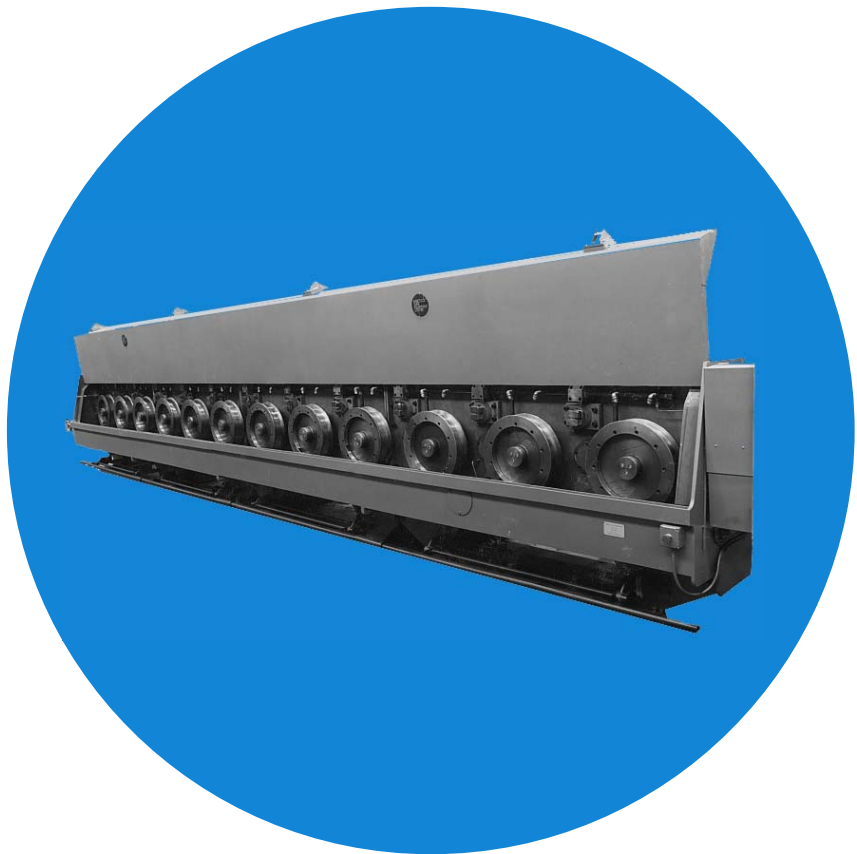
Babcock Wire

450T Tandem Rod Breakdown Machine

This machine is available in 4, 7, 10, 13 or 16 die versions. It is built up of combinations of fabricated housings carrying 3 pullblock shafts. These housings are rigidly connected to form a single unit.

The pullblocks and the finishing capstan have a diameter of 450mm. They are fitted with chrome plated, replaceable steel bands. Chrome plated or 'Coast Metal' rings can be supplied at additional cost. Each pullblock is offset progressively along the wire line to provide a nearly straight wire entry into each die.

Die holders are fully adjustable to the natural arc of the wire. The finishing die holder is of the motorised revolving type.





450T Tandem Rod Breakdown Machine

The capstan is equipped with an integral 4-speed gearbox so that up to 3 dies may be omitted at the finished end of the machine. Facilities for driving a continuous annealer are provided at the rear of the capstan shaft.

The motor is positioned behind the machine and is connected by flexible couplings to an internal gearbox. Dependent upon requirements this gearbox may have up to four speeds, thus providing in combination with the capstan gearbox a maximum of 16 finishing speeds.

Spray lubrication of the wire and pullblocks is employed on this machine. Dies being lubricated by jets at entry and exit. Feed and drain connections are provided for connection to a lubricant storage system (which is not supplied).

A separately motorised gear pump provides correct gear and bearing lubrication. It has a safety interlock with the main drive to avoid damage in the event of pump failure.

Standard equipment includes an inching pedal stretching the length of the machine and a broken wire switch. The one piece solution cover is raised and lowered by pneumatic cylinders.

General specification	
Maximum number of dies	up to 16, depending on specification
Drafting	31% elongation per die
Maximum Entry	10mm soft copper or 12.7mm E.C. aluminium
Finish Diameter	1.0mm to 5.18mm diameter
Pullblock & Capstan Diameter	450mm
Maximum Die Case Accommodated	52mm diameter x 38mm thick
Maximum Finishing Speed	40 m.p.s.
Maximum Motor	350 h.p.
Services	
Wire drawing lubricant (maximum flow rate dependent upon duty)	1.15 m ³ /minute at 1.4 kg/cm ²
Recommended storage capacity*	11.5 m ³
Compressed air to operate front cover	0.028 m ³ @ 3.0 kg/cm ²
*Note: Filtration with cooling facilities can reduce this volume	

Disclaimer

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