



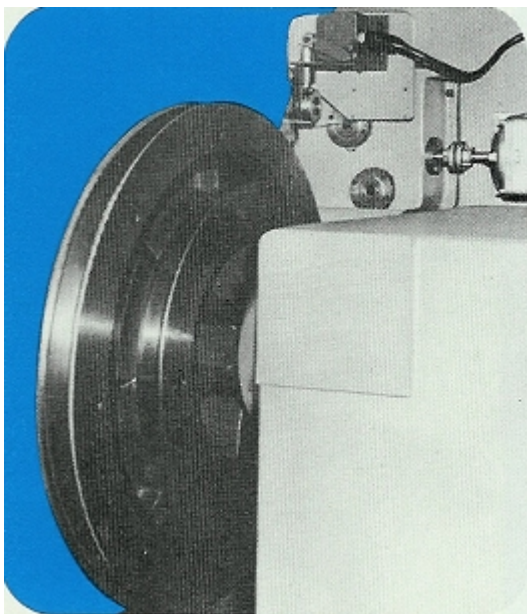
Winget Syncro Rod Breakdown & Intermediate Wire Drawing Machines

Features Bulletin 1

Double finishing capstan

Standard for F, D and C type machines

Winget Syncro Rod Breakdown and Intermediate (capstan type) Wire Drawing Machines are fitted with a double finishing capstan. This permits two finishing wire speeds to be obtained for each main gearbox speed, giving the machine increased flexibility and generally permitting the maximum motor hp and maximum speed to be utilised at all times.



Split replaceable pull block tyres

Standard for F, D and C type machines

For standard applications the machine is fitted with rolled replaceable split tyres.



These give a good wear life and have the advantage of being inexpensive and easily replaced. This feature permits all pullblocks to be maintained at their true diameter, thus retaining minimum slip conditions and reducing die maintenance.

Replaceable pull block steel rings

Optional alternative for F, D and C type machines

For special applications both the Rod Breakdown and Intermediate Machines can be fitted with replaceable rings of hard-wearing material.



Revolving finishing die holder

Standard for F and D type machines

On Rod Breakdown Machines provision is made to revolve the final sizing die to ensure even wear and longer life.

A double revolving finishing die holder is provided when the double finishing capstan is employed.

Wire drawing solution

Standard for F, D and C type machines

All Machines are designed for connection to a central solution system and are not supplied with storage tanks or pumps unless specifically requested. Piping inside the machine ensures that the solution is directed into the nose of all dies and on to all drawing blocks. This system has been designed to overcome the build-up of copper dust in the entry of the dies together with cavitation that normally takes place on high speed machines employing fully immersed drawing cones.

Machine oil lubrication

Standard for F, D and C type machines

The machine is provided with a lubricant pump to ensure adequate oil is delivered to all moving components.

The unit includes an oil pressure switch which prevents the machine from operating should the oil pressure fall below a pre-set level.

Jog pedal

Standard for F, D and C type machines

This is foot-operated running the full length of the machine permitting convenient inching from any position.

Broken wire switch

Standard for F, D and C type machines

All machines are fitted with a broken wire switch, which automatically stops the machine in the event of a wire break.



Drives

Standard for F, D and C type machines

The standard drive equipment now fitted solves many of the problems previously encountered on Wire Drawing Machines.

An AC slip-ring motor, controlled by a *saturable reactor* ensures that both acceleration and deceleration are linear.

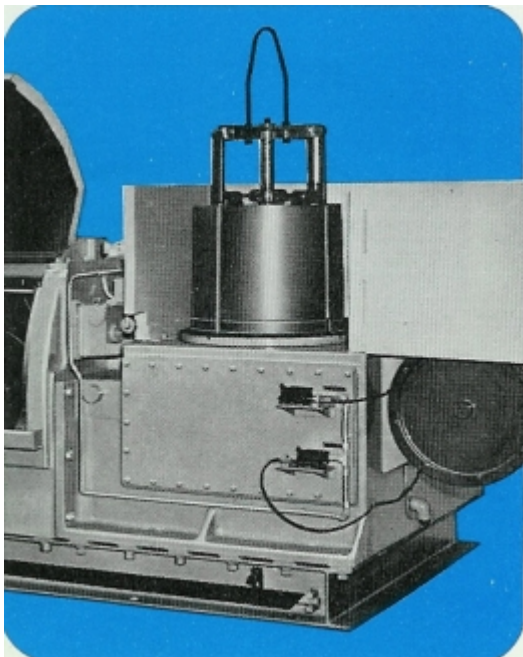
This system gives the following advantages:

1. Improved synchronization of machine and take-up irrespective of machine loading.
2. Improved surface finish during acceleration and deceleration periods.
3. Considerable decrease in wire breaks.
4. Smooth application of power eliminates shock loading to machine and drawing dies.

Coiler block

Alternative equipment on F, D and C type machines

The machines can be supplied with an integral coiling block and associated stripper.



This method of coiling restricts the maximum operating speed and the finishing range of the wire drawing machine. Modern practice is to employ the higher speeds of a capstan type machine with a separate continuous coiling unit. When operated in conjunction with a spooler the coiling block is replaced by a spooling ring.

Disclaimer

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