



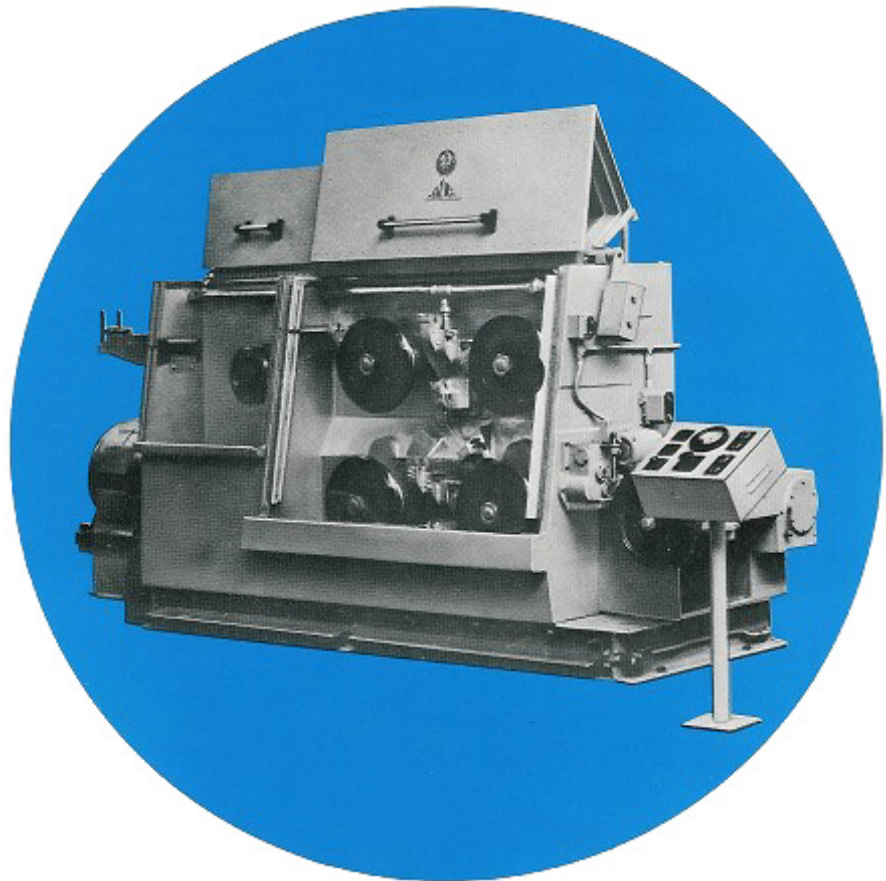
Winget Syncro

D Type Heavy Intermediate Wire Drawing Machine

for the drawing of non-ferrous metals

Winget Syncro D Type machines can be supplied with 5, 7, 9, 11, 13 or 14 dies, according to requirements. This bulletin applies to the 13 and 14 die machines when processing copper or aluminium and should be studied in conjunction with Features Bulletin 1C.

Machines with 5, 7, 9 and 11 dies are normally employed for drawing heavy gauge non-ferrous wires. Details of these are available on request.





D14 machine

Maximum number of dies: 14

Maximum entry diameter: 5/16" (8mm) soft copper rod

5/16" (8mm) E.C. aluminium

Copper	0.040" to 0.057" at 3,500 fpm	1.0mm to 1.45mm at 17.75 mps
	Up to 0.067" at 2,750 fpm	Up to 1.70mm at 14.0 mps
	Up to 0.081" at 2,250 fpm	Up to 2.06mm at 11.4 mps
	Up to 0.091" at 2,000 fpm	Up to 2.31mm at 10.15 mps
	Up to 0.102" at 1,770 fpm	Up to 2.59mm at 9.5 mps
Aluminium	Up to 0.114" at 1,285 fpm	Up to 2.90mm at 6.6 mps
	0.060" to 0.093" at 3,500 fpm	1.5mm to 2.36mm at 17.75 mps
	Up to 0.103" at 2,750 fpm	Up to 2.62mm at 14.0 mps
	Up to 0.114" at 2,250 fpm	Up to 2.90mm at 11.4 mps

D13 machine

Maximum number of dies: 13

Maximum entry diameter: 1/4" (6.35mm) soft copper rod

1/4" (6.35mm) E.C. aluminium

Copper	0.040" to 0.057 in at 3,500 fpm	1.0mm to 1.45mm at 17.75 mps
	Up to 0.070" at 2,750 fpm	Up to 1.78 mm at 14.0 mps
	Up to 0.087" at 2,250 fpm	Up to 2.21mm at 11.4 mps
	Up to 0.102" at 2,000 fpm	Up to 2.59mm at 10.15 mps
	Up to 0.114" at 1,770 fpm	Up to 2.90mm at 9.5 mps
Aluminium	Up to 0.128" at 1,285 fpm	Up to 3.26mm at 6.6 mps
	0.060" to 0.093" at 3,500 fpm	1.5mm to 2.36mm at 17.75 mps
	Up to 0.103" at 2,750 fpm	Up to 2.62mm at 14.0 mps
	Up to 0.128" at 2,250 fpm	Up to 2.90mm at 11.4 mps

General specification

Finish wire speeds available on D14 and D13 with 3 speed gearbox and double finishing capstan:

when using large capstan	3,500	2,750	2,000	f.p.m.
	17.75	14.0	10.15	m.p.s.
when using small capstan	2,250	1,770	1,285	f.p.m.
	11.4	9.5	6.6	m.p.s.

Area reduction per die: 20.65%

Number of draw block shafts: D14 - 5, D13 - 4

Elongation per die: 26%

Motor: D14 - 150 h.p., D13 - 125 h.p.

Maximum die case accommodated: 2" dia. x 1" thick 51mm dia. x 25mm thick

Quantity of wire drawing lubricant required for copper and aluminium 2,000 gal. 9,000 litres

Flow of wire drawing lubricant required: Copper 100 gal. 455 litres per minute

Aluminium 75 gal. 340 litres per minute

Pressure of lubricant required at machine: copper & aluminium 20 p.s.i. 1.4kg/cm²

Floor space required 15ft long x 5ft wide 4.6m long x 1.35m wide

Approximate net weight including motor and control system 21,460 lb 9,750 kg

Continuous spoolers and coilers together with resistance annealers are available for continuous and co-ordinated operation with either the D13 or D14 machines. Details available on request.

Disclaimer

Whilst we have endeavoured to ensure that the information contained herein is accurate, Winget Syncro and Beaumont Machinery do not accept responsibility for any errors or omissions. This specification is subject to amendment.