Winget Syncro

Type DF Three Phase Continuous Resistance Annealer

The model DF continuous resistance annealer, for electrolytic copper wire, is arranged for co-ordinated operation with Winget Syncro Rod Breakdown machines.

Advantages of Winget Syncro Continuous Resistance Annealing

1. Occupies comparatively small floor space.
2. Eliminates costly batch annealing equipment, with its attendant large space requirements.
3. Eliminates double handling of wire and spools.
4. No lost time: annealed wire is available when drawn, minimising stock holding.
5. Eliminates warped spools and extends spool life.
6. Low operating and maintenance cost.
7. Bright clean product.
9. Uniformly annealed product.
10. Efficient: power consumed is effectively used in the annealing process.
11. All operational functions are readily controlled.
12. Elongation of product to BSS 4109.
Specification Type DF Continuous Resistance Annealer

<table>
<thead>
<tr>
<th>Annealing Transformer</th>
<th>94 KVA</th>
<th>150 KVA</th>
<th>225 KVA</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>At 5,000 fpm</strong></td>
<td>0.040&quot; to 0.064&quot;</td>
<td>1.01mm to 1.63mm</td>
<td>0.040&quot; to 0.079&quot;</td>
</tr>
<tr>
<td><strong>At 4,000 fpm</strong></td>
<td>0.065&quot; to 0.071&quot;</td>
<td>1.65mm to 1.80mm</td>
<td>0.080&quot; to 0.090&quot;</td>
</tr>
<tr>
<td><strong>At 3,000 fpm</strong></td>
<td>0.072&quot; to 0.082&quot;</td>
<td>1.81mm to 2.08mm</td>
<td>0.091&quot; to 0.104&quot;</td>
</tr>
<tr>
<td><strong>At 2,600 fpm</strong></td>
<td>0.083&quot; to 0.088&quot;</td>
<td>2.09mm to 2.23mm</td>
<td>0.105&quot; to 0.112&quot;</td>
</tr>
<tr>
<td><strong>At 2,000 fpm</strong></td>
<td>0.089&quot; to 0.101&quot;</td>
<td>2.24mm to 2.56mm</td>
<td>0.113&quot; to 0.128&quot;</td>
</tr>
<tr>
<td><strong>At 1,300 fpm</strong></td>
<td>0.102&quot; to 0.125&quot;</td>
<td>2.57mm to 3.18mm</td>
<td>0.129&quot; to 0.159&quot;</td>
</tr>
</tbody>
</table>

**Annealing Transformer Capacity (3 phase)**
- 94 KVA
- 150 KVA
- 225 KVA

**Power Required**
- 110 KVA
- 165 KVA
- 240 KVA

**Approx Weight of Annealer**
- 11,800 lb
- 11,800 lb
- 11,800 lb

**Approx Weight of Transformer**
- 5,500 lb
- 7,210 lb
- 7,550 lb

**Cooling Water Required**
- To extract per hour: 300,000 BThU's, 75,000 calories
- To extract per hour: 500,000 BThU's, 125,000 calories
- To extract per hour: 700,000 BThU's, 175,000 calories

**Floor Space Required**
- see floor plan
- see floor plan
- see floor plan

**Compressed Air Required**
- 5 cu ft per hour at 40 psi (140 litres at 2.8 kg/cm²)

**Steam Required**
- Approx 20 lb (9 kg) per hour at atmospheric pressure

The above quoted wire speeds are used to indicate wire ranges within the KVA and current capacities of the annealers. The finished wire range quoted against a particular wire speed could be reduced due to restrictions imposed by the wire drawing machine capabilities. Finished wire ranges against finishing speeds not quoted can be supplied upon request. Bus-bars for connection between transformer and annealer are not supplied.

**Features**

**Drive** These annealers are self contained units, driven from the wire drawing machine by belts and pulleys. Alternatively, they can be supplied with a separate synchronised drive, where it is not possible to drive the annealer direct.

**Replaceable Tyres** This feature has the advantage of easily and inexpensively retaining the contact sheaves at their true diameter, thus maintaining their correct peripheral speed.

**Closed Circuit Cooling** Employs a reservoir and a thermostatically controlled circulating pump. The closed circuit permits the use of an additive to the coolant, eliminating the possibility of water marked wire and aiding wire pay-off from the spool.

**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.

© 2006 Beaumont Machinery Ltd 115-119 Bury Road, Radcliffe, Manchester, M26 2UT Tel: 00 44 161 724 8989 Fax: 00 44 161 724 8855 E-mail: sales@beaumontmachinery.co.uk www.wingetsyncro.co.uk