

INTERMEDIATE DRAWING LINE NIEHOFF 2 WIRES

Niehoff 2 wire (Basic data)

- Niehoff drawing machine 2 wires, Model MM315.2.1.A.24.17
- Niehoff annealer 70 kw /1700 Amp, Model VG 30.
- Niehoff spooler 630 mm. dynamic, Model S630.2.F.3.E & built in dancer
- Niehoff second spooler 630 mm. separate, Model SNH 631
- Niehoff dancer VP 200 for second spooler
- Niehoff electrical panel with Siemens drives / Plc.

NIEHOFF Twin Wire Intermediate Line, Model MM315

Line suitable to draw 2 x 3,15 mm copper wire (250 N/mm²) and reduce it to 2 x 0,40 to 2 x 1,00 mm. Can also be used for single wire up to 1,30 mm finished diameter.

Capstan all same sizes: 315 mm, ceramic.

Machine is based on 24% wire elongation, with 17 dies.

It has a speed capability of 31,5 m/sec

Spooler is for 630 mm spool, taken on shaft, driven by separate motor.

Line from 1990, in top maintained condition as from Switzerland.



Maquinaria, equipamiento y accesorios para la fabricación del cable y alambre.



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Wichtigste Werte fuer die Einstellung
Approximate values for adjustment
Valeurs approximatives pour l'ajustement

v (m/s)	U (Volt)	Drahtdurchmesser d wire diameter diamètre de fil CU						Stromaufnahme current consumption consommation en courant I (A)
		2 x 0.40	2 x 0.60	2 x 0.70	2 x 0.80	2 x 0.90	2 x 1.00	
31.5	61.7	414	933	-	-	-	-	
25	55	369	831	1131	-	-	-	
20	49.1	330	743	1011	1321	-	-	
16	44	295	664	905	1182	1486	-	
14	41.1	276	622	845	1105	1399	1700	
Schaltstufe switch step écheleon de couplage U (Volt)		max. Gleichstrom max. direct current courant continu maxi I (Ampere)						
I		64						1230
II		56						1390
III		51						1540
IV		44						1700

$$U(\text{Volt}) = \sqrt{v} \cdot A$$

$$I(\text{Amp.}) = n \cdot d^2 \cdot \sqrt{v} \cdot B$$

$$P(\text{kW}) = n \cdot d^2 \cdot v \cdot C$$

A=11, B=230.9, C=2.54
P(max)=70kW



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