

TECALSA DOUBLE TWIST BUNCHING TB-1250





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





Technical specs:

For the manufacture of naked conductors, with or without compaction and to bunch the isolated phases.

For reels of diameter 1.250 mm, DIN 46395 Norm.

Hard steel frame, with the frontal side open.

The reel is mounted on pointless, aligned with machine axis. It permits easier loading/unloading.

Simultaneously operated pointless driven by motorreductor from loading position.

The cradle forms one structure where are placed, on her sides, all the kinematics parts concerning the draw wheel, the reel and the wire-guide.

Draw by two channelled wheels with transmission by pair of gearing.

Winding by D.C. motor.

Adjustable pitch traverse unit Uhing type.

Rotating part formed by two rotors jointed by two special bows having adequate curvature to obtain high speed.

Measuring group with pre-selection electrical meter-counter.

With automatically stops placed on the machine inlet. There is, besides, an electrical stop in the machine interior. All the stops acting on the pneumatic stop installation that have filter, lubricator, pressure regulator, manometer, safety presostato, and reserve tank.

Breaking in approximately 5", needing 3 Atm. It must be connected to the compressed air net.

Load device formed by an oleo-dynamic motorised movable platform that doesn't need special foundation.

Load/unload reel from the operator side and placed by rolling on the platform. Safety micro-switches to fix the bow position where permits the reels load. There are some sensors that determinates the exactly load position. The platform is fixed to the structure.

Soundproof carter with slipping doors, interior lighting and forced ventilation for inside machine circulation air.

There is an internal die-holder for the compaction.

Speed machine tachometer indicator.

Rotor with pneumatic braking.

The machine can turn in both directions.

On the driven panel there is all the start and stop push buttons and the push button of potentiometers to first motor speed regulation, draw winding motor, step regulation and wire-guide run.

Electrical equipment in independent cabinet controlled by PLC.

Technical features

Stranding of copper or aluminium rigid naked wires of maximum section..... 50 mm².

Copper and aluminium compacting and rolling

- maximum section..... 35 mm².

- maximum diameter 7,5 mm.

- maximum production 130 Mt'.

Naked wires

- copper: maximum diameter 3 mm.

- aluminium: maximum diameter 3 mm.

Flexible naked copper or aluminium little wires of maximum section..... 70 mm².

Isolated cables

- rigid: maximum section 50 mm².

- flexible: maximum section 100 mm².

Maximum speed 800 r.p.m. = 1.600 twists'

Bunching maximum production 250 m/min.

Maximum draw on the wheels (for a production of 130 Mt') 500 Kg.

Stranding/bunching steps..... 50 to 478 mm.

First motor..... 65 Kw D.C.

Motor winding 11 Kw. D.C.

Weight machine 10.700 Kg.

Reels (DIN 46395)

- diameter	1.250 mm.
. width	950 mm.

Sound level 85 dBA.

Maximum diameter step wire

- normal bows	28 mm.
- special bows	18 mm.

Maximum step wire-guide 25 mm/rev.

Wire direction left/right

Change pair gear 10

“TB 125/A” RELATION OF PITCH RATIO

Gears

A	B	mm.
17	66	50
20	63	62
24	59	79
28	55	99
32	51	122
36	47	149
40	43	181
43	40	209
47	36	254
51	32	310
55	28	382
59	24	478

- Steps (mm.) = 194,5 x A / B

- Production (m/min.) = (R.P.M.) x Step / 500