



## EXTRUSION MACHINERY

### EXTRUDER-LAB MODEL EXTRUDER

The machine consists of three major assemblies.

1. Hopper
2. Gear box &
3. Extrusion press.

The Gear box, hopper and extrusion press are mounted on a table. The cut wires loaded in the hopper descending down one by one through hopper liners assisted by an agitating mechanism driven by a cam and connecting rod.

The agitating mechanism is powered by a standard motorized reduction gear box.

The descended wire pushed into a wire feed gear box by a set of rotating hardened and ground pickup rollers through hopper wire guide. The wire feed gear box feeds the wires by a set of hardened and ground rotating feed rollers to the extrusion press through wire guides. The feed pressure on the wire can be controlled by a hand wheel provided on the top of the feed gear box. The pickup rollers and wire feed rollers were powered by an electric motor controlled by an AC variable speed drive. The wire feed speed can be varied by varying the supply frequency to the motor by the AC variable frequency drive. In the extrusion press the core wire is coated with flux and the outside diameter of the coated flux is controlled by a coating die. The concentricity between the wire and the flux coated over the wire can be controlled by four adjusting screws provided on the coating die holder. The flux pressure can be varied by adjusting the hydraulic system pressure. The Lab model extruder is designed to extrude electrodes of wire diameter ranging from 2.0 mm to 5 mm with variable feed rates.



## WELDING ELECTRODE MACHINE

### WIRE PREPARATION MACHINERY

1. Wire Straightening & Cutting Machine

### FLUX PREPARATION MACHINERY

1. Dry Mixer
2. Wet Mixer
3. Slug Press

### EXTRUSION MACHINERY

1. Wire Feeder
  - A. Wire Feeder Vertical
  - B. Wire Feeder Horizontal
2. Extruder
  - A. Lab Model Extruder
  - B. Horizontal Bell Housing
  - C. Horizontal Twin Cylinder
3. Conveyor
4. Electrode Name Printing Unit.

### BAKING MACHINERY

1. Drying Oven

### DE-COATING MACHINERY

1. Flux Reclamation Machine

### PACKING MACHINERY

1. Shrink Packing Machine

### TESTING MACHINERY

1. Eccentricity Tester

Wire feeding speed	7 – 20 Rods / Min ( 2.5 to 7 Meters / Min)	
Wire size	2.0 mm to 5 mm	
Input power to wire feeding unit	Pick Up	0.5 HP
	Feed	1 HP
Pickup roller	2 Sets ( Hardened and Ground)	
Pickup roller diameter	98 mm	
Feed roller	1 set ( Hardened and Ground)	
Feed roller diameter	104 mm	
Oil cylinder bore	160 mm	
Flux cylinder bore	70 mm	
Flux cylinder length	250 mm	
Flux cylinder volume	950 cc	
Max Flux flow rate	250 cc / Min	
Hydraulic system pressure	200 Kg / Sq.cm	
Specific pressure on flux	1045 Kg / Sq.cm	
Input power Hydraulic system	3 Hp	
Oil tank volume	50 lit	

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