



MIG WIRE PLANT



MIG WIRE PLANT MACHINE

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PART-I

PAY OFF STAND



Pay off stand consists of vertical coil stand and Compensator. The coil stand wearing area is metal sprayed to make it hard for wear resistance. The compensator made of Steel frame having one set of fixed pulley and one set of moving pulley. All the pulley in both set is harden and T C guide provided to guide the wire to the pulley.

PRE BLOCK



The double deck block provided with vertical drum. It is made harden on wire drawing area to provide long life to the drum. It is also provided with internally water cooled arrangement. The Die box having facility to set in three planes that can ensure the perfect alignment and direct die cooling arrangement.

MODEL	Overhead Take off
TABLE SIZE	1000 mm * 800 mm
MATERIAL TO BE DRAWN	Mig wire
MAX. INLET SIZE	2.20mm to 2.40 mm for 1.2 mm 1.80 mm to 2.00 mm for 0.8 mm
NO. OF DIES	1
DRUM SIZE	420mm
GEAR	Worm Reduction Gear, Ratio 7.5:1
ELECTRICAL MOTOR	15 HP AC, 1440 RPM
DRIVE	AC Inverter
DIE BOX	Direct water cooled
DIE CASE SIZE	Dia.43 *

WET WIRE DRAWING MACHINE



The wet wire drawing machine is made of steel fabrication structure that can withstand heavy load at high speed. It consists of 10 dies that completely immersed in the lubricant. The lubricant circulations through heavy duty pump continuously 200lits/min.

The shaft bearing is provided with oil seal and made such arrangement to prevent lubricant contamination. The shafts and Bearing area precisely machined on high tech machinery. Accurate & high efficiently power transmission through timing belts that improves machine efficiency.

MACHINE	Slip type heavy duty wet wire drawing machine
INLET SIZE	2.2 mm max.
FINISHED SIZE	0.8 mm to 1.6mm
DRAWING SPEED	12.5 meters/sec max.
AREA REDUCTION	14-15.5% max.
BUILT IN AREA REDUCTION	13.50%
NO.OF DIES	10
DIE COOLING	Completely immerse in Lubricant
NO. OF SHAFT	5
CAPSTAN	C50 Forged 55-60 HRC (Optional -TC Rings)
ELECTRICAL MOTOR	60 HP AC motor, 1440 RPM.
DRIVE	AC Inverter
POWER TRANSMISSION	Timing Belts
LUBRICANT CIRCULATION	200 Liters/Min., 2HP Vertical Pump.

COPPER COATING UNIT



Copper coating tank is made of FRP (FIBRE REINFORCED PLASTIC) to hold the pulley to guide the wire throughout the coppering process of wire. The SS 316 Structure is operated by pneumatic cylinder.

The Pulleys are made of special material which gives acid resistance and also wearing resistance to prevent grooving. The vertical die holder provided for skin pass above the lubrication section on SS 316 structures.

Covers made of SS 316 are provided to prevent damage

due to acid and its fumes.

It consists of five sections for:

1. Pickling

2. Washing

3. Coppering

4. Washing

5. Lubricant for the last skin-pass die

The high quality Complete SS 316 material gives high resistance to the corroding action of acids with no maintenance cost.

CAPACITY

1. ACID PICKLING SECTION with 2KW heater -1 no	125 Liters
2. WATER SECTION	125 Liters
3. COPPERING SECTION With 2KW heater-2 nos.	500 Liters
4. WATER SECTION	125 Liters
5. LUBRICANT SECTION	125 Liters

*Maximum wire speed to be coated 12.5 meters /sec.

*Pneumatic tilting device is provided to lift the SS structure.

*A vertical die arrangement with Rotating (0.25 hp) is provided for Skin-pass above lubricant section.

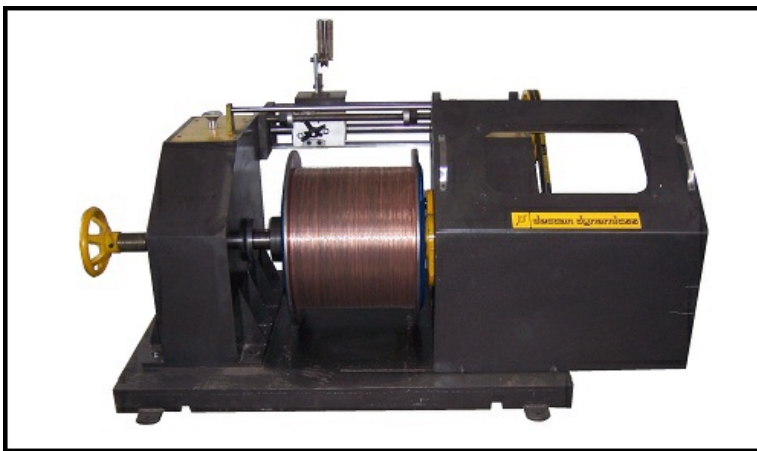
BB BLOCK



It is a non-slip type wire drawing machine. It provides power to pull the wire from skin pass die of the coppering unit. Its upper drum acts as an accumulator in order to give twist free wire without spoiling the copper coating and acts as an accumulator to feed the wire to the spooler. It also facilitates to reload the spool without stopping plant except spooler. Wire tensioner and Length sensor provided on the frame. It is equipped with caliper type pneumatically operated disc brake that stop machine when wire breakage and also in emergency.

MODEL	: DECCAN BB-420
MATERIAL DRAWN	: CO2 Wire
MATERIAL SIZE	: 0.8 mm TO 1.6 mm
DRAWING SPEED	: 12.5 meters/sec Max.
BRAKE	: Caliper type pneumatic disc brake
ELECTRICAL MOTOR	: 15 HP, 1440 RPM
DRIVE	: AC Inverter
KILLING ROLLER	: 7+7 Horizontal & Vertical

WINDER

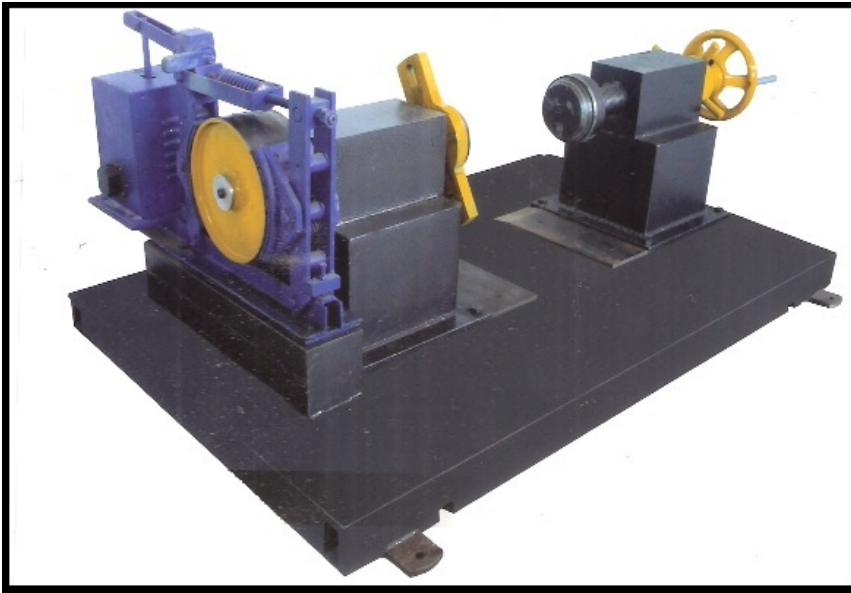


This machine is suitable to coil drawn steel wire coming from the respective drawing line. The winder is made of heavy steel structure. The Bearing with its housing and shafts are redesigned to take load of 500kg with reel at 12.5 meters/sec. The power transmission by v-belts using AC Variable drive to control the speed of wire. Braking of the machine is carried out in emergency by larger diameter disc calliper pneumatic brake instantly; the brake is also activated when the supply of electricity is cut off. The electrical panel is equipped with line speed meter.

FLANGE DIAMETER	: 630mm Max.
BARREL DIAMETER	: 355mm
BORE DIAMETER	: 127mm
MAX. WEIGHT REEL+ WIRE	: 500Kg
WINDING SPEED	: 12.5mtrs/sec
WINDING WIRE DIAMETER	: 0.8mm to 1.6 mm
BRAKE	: Calliper type pneumatic disc brake
ELECTRICAL MOTOR	: 5 HP AC Motor, 1440RPM
DRIVE	: AC Inverter
REEL/BOBBIN STANDARD	: DIN 46397

PART-II

UNWINDER



This is work as a powerless payoff for rewinding line. The unwinder is equipped with shoe type drum brake and it is also activated when the supply of electricity is cut off. The unwinder is capable for 500kg reel /bobbin.

DANCER



This Device is to be placed between spooler & unwinder to provide smooth feed to spooler. The pulleys are made of special plastic material that prevent the wire surface damage & also resist the grooving on the pulley.

SPOOLER



The final winding of wire is done on the spooler. This machine equipped with travers motion device with separate AC Variable drive to wind wire precisely. Its main motor is also equipped with AC Variable drive to synchronises the winding pattern. This machine is also equipped with length counter to reach exact wire length and stop the machine. The spool is provided with pneumatic operated tail stock to clamp the spool and it's also reduces the loading -unloadingtime for operator. Pneumatic cylinder is also provided to hold the wire during reloading operation of spool. The machine is provided with 9+9 vertical and horizontal killing rollers to set the better cast and helix.

PART-III

BUTT WELDING MACHINE WITH GRINDER



Butt Welding Machine with grinder for 2.5mm to 0.8mm

Rating	15 KVA
Wire Sizes	2.0mm to 6.00mm

ADDRESS

DECCAN DYNAMICS, No: 21, Deccan Estate,
Civil Aerodrome Post, Coimbatore-641014,
Tamilnadu,India.

CONTACT US

Moblie 1 :- +91-9443326696, Mobile 2 :- +91-8056977477
Landline 1 :- +91-422-2627288, Landline 2 :- +91-422-2628168
E-mail :- deccandynamics@yahoo.com