

HGJ-200/6 Tubular Stranding Machine



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Machine Technical Parameter

NO	ITEM	DESCRIPTION
1	Maximum Working Speed (R.P.M)	2200
2	Normal Working Speed(R.P.M)	1800
3	Inlet wire diameter range(mm)	0.20-0.75
4	Maximum stranded rope diameter(mm)	3.2
5	Control method of lay-length	Electronic stepless lay-length control
6	Range of Lay-length(mm)	0-100mm(Customized)
7	Diameter of dual capstan wheel (mm)	φ 318x2
8	Core wire/strand bobbin size (mm)	Customized
9	Take-up bobbin size(mm)	Customized
10	Bobbin in cradle size (mm)	Φ 200
11	Main motor power(kw)	18.5
12	Traction motor power(kw)	7.5
13	Take-up motor power(kw)	5.5

Machine Configurations description

ITEM	DESCRIPTION
Load method of core pay-off bobbin	Shaft-fixed type
Tension control of core bobbin	Adopt mechanical damping adjust the tension with damping chain,
Pay-off bobbin size	Customized(The buyer supply the drawings)
Tube driving mode	Drive by the synchronous toothed belt which connecting with the main

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	motor.
The structure and process of tube	Made up of high quality seamless steel pipe, get the tempering treatment after cutting and welding. After finish machining,balanced by accurate adjustment balancer,ensure the balance of operation.
Wire guide dies	The wire guide dies are made up of carbonyl metal(YG8)
The support method of tubes	The tubes are supported by large bearings,each tube has three cradles.
The lubricate method of large bearing	Pumped oil lubrication
The brand of Large bearings	NBI
The brake system of tubes	Every tube possess one set of pneumatic brake devices. Normal Brake time:20-45s; Emergency Brake time:7-10s; Brake air pressure: 0.5 ± 0.5 Mpa Have wire break brake detection function,once the system detects the wire break,the machine will brake in a short time.
Load method of internal pay-off bobbin	Shaft fixed type with shaft lock structure
Tension control of internal bobbin	The tension is controlled by the damping block and the damping chain.
Machine safety cover	The machine safety cover adopt the enclosed type design,The cover adopt manually open type.The folded point of machine possess one machine inching switch.With the low-voltage safety light at the internal of the cover ,With one emergency stop button on the cover.
Stranding die holder structure	Up and down open type,controlled by the spring pressure
Stranding Die diameter	The buyer supply the specific dimension(LxWxH)
Stranding Die holder motion type	Moving range:250mm, the die holder can be moved by hand wheel through the adjustment nut.
Per-former apparatus	Provided by buyer,the supplier will prepare the necessary space for installation.
H+V straightener	Provided by buyer,the supplier will supply the steel platform for installation.
Separator of wire	The supplier will supply the separator of wire
The diameter of dual capstan wheel	318mm*2
Surface treatment of dual capstan wheel	Quenching treatment
Meter counter	A sensor count the length depend on the perimeter of the capstan wheel,operator can set the specified length through the touch panel,upon the length achieve the specified length,the machine stop.
Method of pitch control	Electronic stepless lay-length control
Range of lay-length	0-100mm(customized,the range can be set according to buyer's requirement)
Brand of Rolling rings unit	UHING
Take-up bobbin size	Customized(The buyer supply the drawings)

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Machine electrical control description		
NO	ITEM	DESCRIPTION
1	Brand of main motor	Drane
2	Brand of Panel&PLC	Siemens
3	Brand of Converter	Danfoss
4	Electric control cabinet	A set of install finished cabinet with necessary electrical apparatus element,converter,PLC and touch panel.
5	Touch panel for operation	A touch panel for operator to control the machine and get the machine status.
6	The information on the panel	The machine speed,the stranding direction,the setting length,the actual length,the machine malfunction,total working time,etc
7	The wire break detection system	Below the tubes,the steel pipes will detect the wire break.At the round of the separator of wire,the steel circle will detect the wire break as well.and once the system detects the wire break,the machine will brake in a short time.
8	The button on the machine	JOG;START;STOP;EMERGENCY STOP