



Winget Syncro

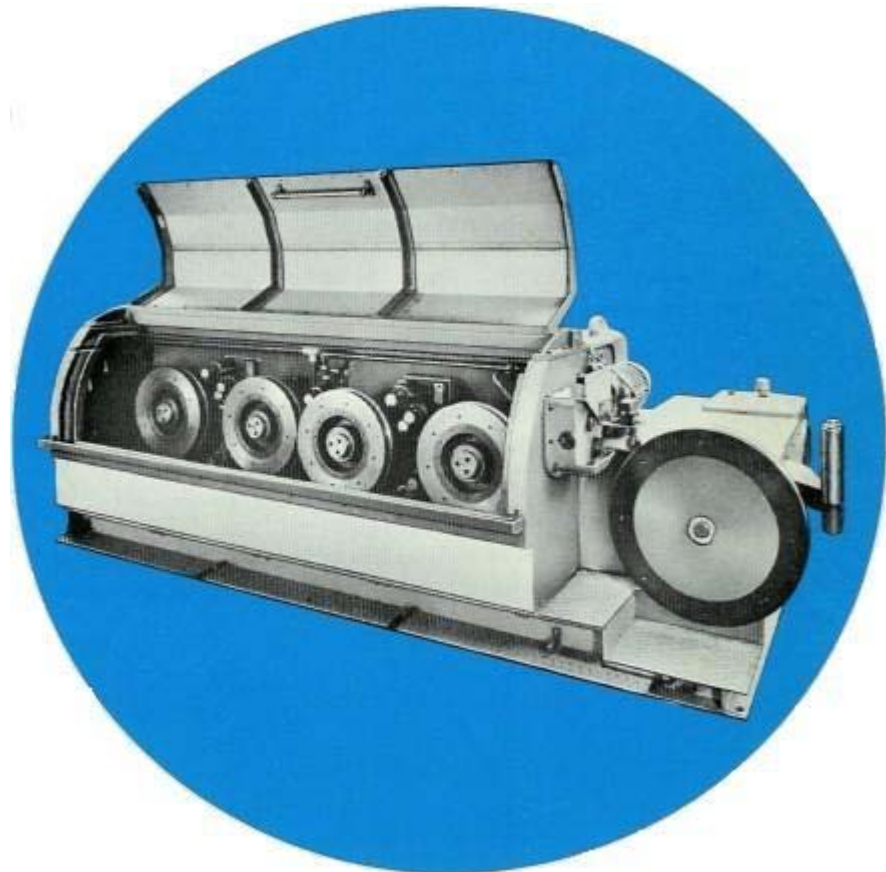
F Type Heavy Duty Rod Breakdown Machine

for the drawing of non-ferrous metals

The Winget-Syncro F Type machines illustrated below can be supplied with 5, 7, 9, 11, or 13 dies according to requirements.

This Bulletin applies to the 11 and 13 die machines when processing copper or aluminium and should be studied in conjunction with features bulletin No. 1B.

Machines with 5, 7 and 9 dies are normally used for processing heavy gauge non-ferrous wires, details of these are available on request.





Specification F13 and F11 Machines (capstan type)

F13 Machine

Maximum number of dies: 13

Maximum entry diameter: 3/8" 9.5mm for soft copper or E.C. aluminium

Winget Syncro											
COPPER						ALUMINIUM					
Entry Diameter		Maximum Finishing Speed		Finishing Wire Range		Entry Diameter		Maximum Finishing Speed		Finishing Wire Range	
in	mm	f.p.m.	m.p.s.	in	mm	in	mm	f.p.m.	m.p.s.	in	mm
3/8"	9.5	4,000	20.3	.064 to .204	1.63 to 5.18	3/8"	9.5	5,000	25.4	.072 to .211	1.83 to 5.36
5/16"	8.0	5,000	25.4	.051 to .162	1.30 to 4.11	5/16"	8.0	5,000	25.4	.057 to .182	1.45 to 4.62
1/4"	6.35	5,000	25.4	.040 to .144	1.01 to 3.66	1/4"	6.35	5,000	25.4	.045 to .162	1.14 to 4.11

F11 Machine

Maximum number of dies: 11

Maximum entry diameter: 3/8" 9.5mm for soft copper rod; 1/2" 12.7mm for E.C. aluminium

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COPPER						ALUMINIUM					
Entry Diameter		Maximum Finishing Speed		Finishing Wire Range		Entry Diameter		Maximum Finishing Speed		Finishing Wire Range	
in	mm	f.p.m.	m.p.s.	in	mm	in	mm	f.p.m.	m.p.s.	in	mm
						1/2"	12.7	3,500	17.75	.114 to .211	2.90 to 5.36
3/8"	9.5	3,000	15.2	.081 to .204	2.00 to 5.18	3/8"	9.5	5,000	25.4	.072 to .211	1.83 to 5.36
5/16"	8.0	5,000	25.4	.064 to .162	1.63 to 4.11	5/16"	8.0	5,000	25.4	.057 to .182	1.45 to 4.62
1/4"	6.35	5,000	25.4	.051 to .144	1.30 to 3.66	1/4"	6.35	5,000	25.4	.045 to .162	1.14 to 4.11

General specification

4 speed gearbox for copper and aluminium					
when using large capstan	5,000	4,000	3,000	2,000	f.p.m.
	25.4	20.3	15.2	10.15	m.p.s.
when using small capstan	3,250	2,600	1,950	1,300	f.p.m.
	16.6	13.2	9.9	6.6	m.p.s.

Area reduction per die: 20.65%

Elongation per die: 26%

Maximum die case accommodated: 2" dia. x 1.3/16" thick 51mm dia. x 30mm thick

Quantity of wire drawing lubricant required for copper and aluminium 2,000 gal. 9,000 litres

Flow of wire drawing lubricant required: Copper 200 gal. 900 litres per minute

Aluminium 150 gal. 675 litres per minute

Pressure of lubricant required at machine: copper & aluminium 20 p.s.i. 1.4kg/cm²

Floor space required for motor, gearbox, machine and control system

20ft 0in long x 11ft 0in wide 5.9m long x 3.35m wide

Approximate weight including motor gearbox and control system 30,000 lb 13,500 kg

Take-ups and resistance annealers for continuous and co-ordinated operation are available for use with either of these machines.

Disclaimer

Whilst we have endeavoured to ensure that the information contained herein is accurate, Winget Syncro and Beaumont Machinery do not accept responsibility for any errors or omissions. This specification is subject to amendment.