



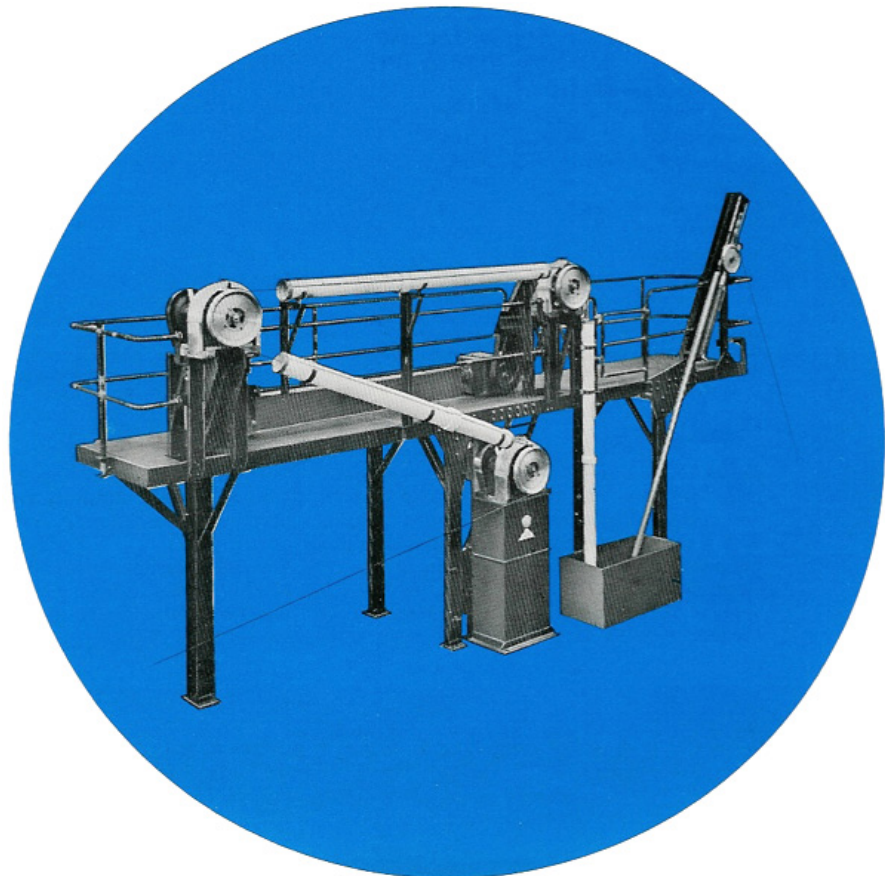
## Winget Syncro

### Type DF Three Phase Continuous Resistance Annealer

The model DF continuous resistance annealer, for electrolytic copper wire, is arranged for co-ordinated operation with Winget Syncro Rod Breakdown machines.

#### Advantages of Winget Syncro Continuous Resistance Annealing

1. Occupies comparatively small floor space.
2. Eliminates costly batch annealing equipment, with its attendant large space requirements.
3. Eliminates double handling of wire and spools.
4. No lost time: annealed wire is available when drawn, minimising stock holding.
5. Eliminates warped spools and extends spool life.
6. Low operating and maintenance cost.
7. Bright clean product.
8. High speed operation: high production efficiency.
9. Uniformly annealed product.
10. Efficient: power consumed is effectively used in the annealing process.
11. All operational functions are readily controlled.
12. Elongation of product to BSS 4109.





## Specification Type DF Continuous Resistance Annealer

Annealing Transformer	94 KVA		150 KVA		225 KVA	
Annealing Wire Range:						
At 5,000 fpm (25.4 mps)	0.040" to 0.064"	1.01mm to 1.63mm	0.040" to 0.079"	1.01mm to 2.00mm	0.040" to 0.099"	1.01mm to 2.52mm
At 4,000 fpm (20.3 mps)	0.065" to 0.071"	1.65mm to 1.80mm	0.080" to 0.090"	2.01mm to 2.29mm	0.100" to 0.110"	2.53mm to 2.80mm
At 3,000 fpm (15.25 mps)	0.072" to 0.082"	1.81mm to 2.08mm	0.091" to 0.104"	2.30mm to 2.64mm	0.111" to 0.128"	2.81mm to 3.25mm
At 2,600 fpm (13.2 mps)	0.083" to 0.088"	2.09mm to 2.23mm	0.105" to 0.112"	2.65mm to 2.84mm	0.129" to 0.133"	3.26mm to 3.38mm
At 2,000 fpm (10.15 mps)	0.089" to 0.101"	2.24mm to 2.56mm	0.113" to 0.128"	2.85mm to 3.25mm	0.134" to 0.142"	3.39mm to 3.61mm
At 1,300 fpm (6.6 mps)	0.102" to 0.125"	2.57mm to 3.18mm	0.129" to 0.159"	3.26mm to 4.04mm	0.143" to 0.159"	3.62mm to 4.04mm
Annealing Transformer Capacity (3 phase)	94 KVA	94 KVA	150 KVA	150 KVA	225 KVA	225 KVA
Power Required	110 KVA	110 KVA	165 KVA	165 KVA	240 KVA	240 KVA
Approx Weight of Annealer	11,800 lb	5,250 kg	11,800 lb	5,250 kg	11,800 lb	5,250 kg
Approx Weight of Transformer	5,500 lb	2,460 kg	7,210 lb	3,270 kg	7,550 lb	3,425 kg
Cooling Water Required To extract per hour	300,000 BThU's	75,000 calories	500,000 BThU's	125,000 calories	700,000 BThU's	175,000 calories
Floor Space Required	see floor plan		see floor plan		see floor plan	
Compressed Air Required	5 cu ft per hour at 40 psi (140 litres at 2.8 kg/cm <sup>2</sup> )					
Steam Required	Approx 20 lb (9 kg) per hour at atmospheric pressure					

The above quoted wire speeds are used to indicate wire ranges within the KVA and current capacities of the annealers. The finished wire range quoted against a particular wire speed could be reduced due to restrictions imposed by the wire drawing machine capabilities. Finished wire ranges against finishing speeds not quoted can be supplied upon request. Bus-bars for connection between transformer and annealer are not supplied.

### Features

**Drive** These annealers are self contained units, driven from the wire drawing machine by belts and pulleys. Alternatively, they can be supplied with a separate synchronised drive, where it is not possible to drive the annealer direct.

**Replaceable Tyres** This feature has the advantage of easily and inexpensively retaining the contact

sheaves at their true diameter, thus maintaining their correct peripheral speed.

**Closed Circuit Cooling** Employs a reservoir and a thermostatically controlled circulating pump.

The closed circuit permits the use of an additive to the coolant, eliminating the possibility of water marked wire and aiding wire pay-off from the spool.

### 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.