



DEYANG XINGDONGGANG MECHANICAL &  
ELECTRICAL EQUIPMENT CO.,LTD

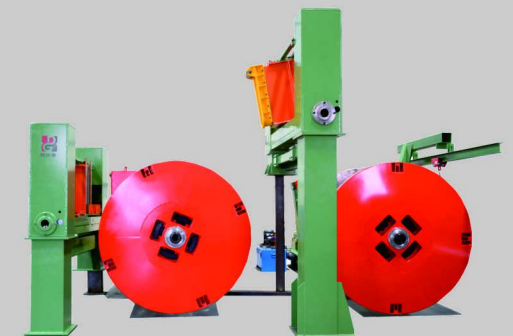
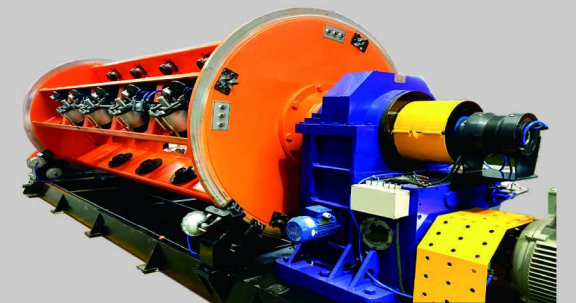
Add: No.132 Jialingjiang Road,Deyang,Sichuan61800China  
Tell: 0838-02233396  
Fax:0838-02233396  
Email: michaellove88@163.com



## 产品手册

PRODUCT MANUAL

德阳欣东港电工科技有限公司  
Deyang Xindonggang Mechanical and Electrical Equipment Co.,Ltd



中国 · 四川 · 德阳  
Deyang · Sichuan · China



Creating value for customers , Initiating Top service for customers



DONGJIAGANG Vision: leading brand in the manufacture of wire and cable machinery and equipment in China



Company Introduction

XDG Vision : scientific and technological innovation is the soul of the enterprise; the quality of the product is the life of the enterprise and the demand of the market is the goal of the enterprise.

XDG Vision: honesty and integrity, respect for individuals, making win-win success and maximizing customer satisfaction

XDG Vision: surviving on integrity, being practical on development, making best products, and carrying out innovations

Deyang Xindonggang Mechanical and Electrical Equipment Co.,Ltd/XDG (hereinafter referred to as XDG) established in September 2017, is a High Tech Enterprise and Specialized in the research and development, XDG have more technical expert ,and senior Engineers ,and organized research and development team ,In the absorption of the latest foreign technology, through in-depth research and exploration, to create a function, structure, technology, materials to update products.

XDG mainly manufacture Continuous Casting and rolling mill for copper rod ,Aluminum alloy rod ,Pure aluminum rod . Copper ,and Aluminum alloy ,Pure Aluminum rod breakdown machine , 630/500 Fully Automatic Pneumatic Dual spooler take up ,and 500/630 Rigid strander machine and 400-630 tubular strander .

XDG put the enterprise culture as the motive power and spiritual support to promote the development of enterprises, focus on cultivating the common value outlook and the cohesion of employees, adhere to customer demand as the goal in the market development and technological innovation, adhere to the "serving diligently" principle in service, make XDG Characteristic enterprise culture.

Creating value for customers , Initiating Top service for customers



Honor Dongjiagang





# 产品介绍

## PRODUCTS INTRODUCTION

### High Configuration Production Line-Aluminum Rod Continuous Casting and Rolling Line



#### Features:

It's applicable to the production of EC grade aluminum rod and aluminum alloy rod for other industries.

#### Configuration:

Casting machine, straightener, front drive, rotary shears, induction heating furnace, roughing mill, finishing mill, quenching unit, automatic dual spooler coiler, lubricating system for the gearbox, emulsion cooling system, and electric control system;

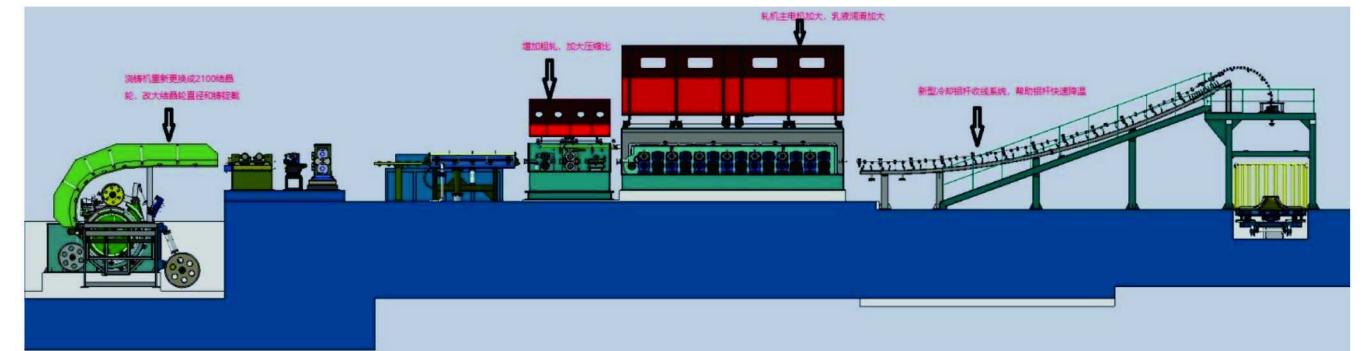
#### Technical Parameter:

Model	Cross Section of Cast Bar (mm <sup>2</sup> )	Outlet Diameter (mm)	Max. Final Rolling Speed (m/s)	Max. Output (t/h)		No. of Stands	Layout form of rolling mill	Coiler type
XDG 3400/9.5 - (400/4) + 180/10-IType	3400	φ 9.5, φ 12, φ 15	12.3m/s	Al alloy 4.5t	Al rod -8t	14 (4+10)	Two rollers+ three rollers	Dual spooler

# 产品介绍

## PRODUCTS INTRODUCTION

### High output production line-Aluminum And Alloy Rod Continuous Casting and Rolling Line



#### Features:

1.It's applicable to the production of EC grade aluminum rod and aluminum alloy rod for other industries.

#### Configuration

1.Basic: casting machine, front drive, rotary shears, straightener, roughing mill, finishing mill, quenching unit, coiler, lubricating system for the gearbox, emulsion cooling system, and electric control system;

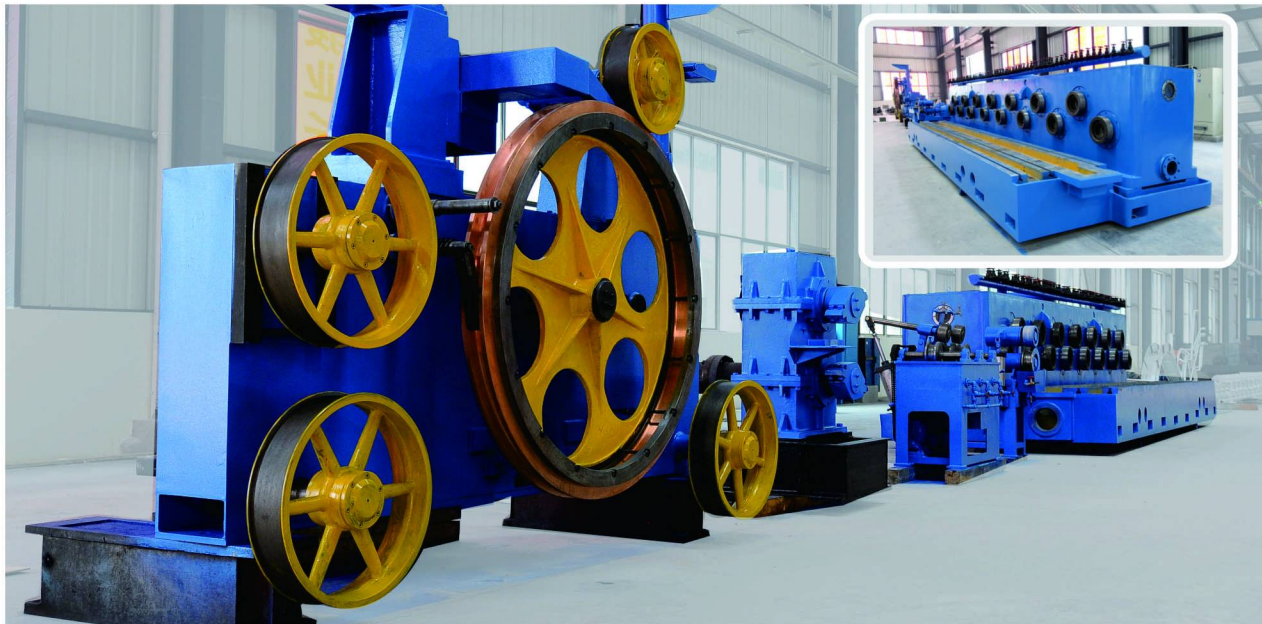
2.At user's option: 8-ton melting furnace, 8-ton/10-ton holding furnace, electromagnetic stirrer, oil hydraulic shears, rollers made of H13 material, and dual basket coiler.



#### Technical Parameter:

Model	Cross Section of Cast Bar (mm <sup>2</sup> )	Outlet Diameter (mm)	Max. Final Rolling Speed (m/s)	Max. Output (t/h)		No. of Stands	Layout form of rolling mill
XDG2100+(2H+14F)	3400mm <sup>2</sup>	9.5, 12, 15 (Alrod)	12m/s	Al alloy 4.5	Alrod 7.5	16 (2+14)	Two rollers+ three rollers





## Features

- 1.It's applicable to the production of EC grade aluminum rod and aluminum rod for other industries.
- 2.The production line needs a small investment capital, occupies a small area, produces no pollution to the worksite, consumes less energy and costs less labor intensity. Rate of finished product and productivity is high;
- 3.The casting machine is in a four-wheel design and so rigidity is good. It's easy to install,commission,operate and maintain it at the factory site. Speed regulation is achieved by AC inverter;
- 4.The casting machine casts molten aluminum at zero o'clock, thus avoiding turbulent flow and tumbling flow of the molten aluminum;
- 5.Casting wheel has an H-shaped cross sectional area, which is cooled from four sides with cooling intensity controlled in separate zones, each of which is controlled individually by valve, with pressure display;
- 6.Cast bar is pushed out by an extractor, and there is an oil smearing device to apply oil to the steel tape so that the cast bar can get off easily;
- 7.Rolling mill is provided with Y-shaped three-roller stands, with upper drive and lower drive working in turn;
- 8.A grease-free coiler is provided so that energy is saved and production cost is reduced;
- 9.Coiler is designed to have a vertical spinning head to lay down the rod into basket. It's easy to operate and control. Rod is laid out in coils in a proper size and weight;
- 10.Fully digital DC speed regulator and PLC are used to perform intelligent control over the whole production line, which is also equipped with measurement, indication, fault display, and human-machine interface (HMI) to show the running condition of the machine and to facilitate human-machine dialogue.

## Configuration

- 1.Basic: casting machine, front drive, rotary shears, straightener, rolling mill, quenching unit, coiler, lubricating system for the gearbox, emulsion cooling system, and electric control system;
- 2.At user's option: 5-ton melting furnace, 8-ton/10-ton holding furnace, electromagnetic stirrer, oil hydraulic shears, rollers made of H13 material, and dual basket coiler.

## Aluminum Alloy Rod Continuous Casting and Rolling Line technical parameter

Model	Cross Section of Cast Bar (mm <sup>2</sup> )	Outlet Diameter (mm)	Max. Final Rolling Speed (m/s)	Max. Output (t/h)		No. of Stands
XDG1800+255/15H	2450	9.5, 12, 15 (Al rod)	6.5	Al alloy 3	Al rod 4.5	15 (7+8)



## Features:

- 1.It's applicable to the production of EC grade aluminum rod and aluminum rod for other industries.

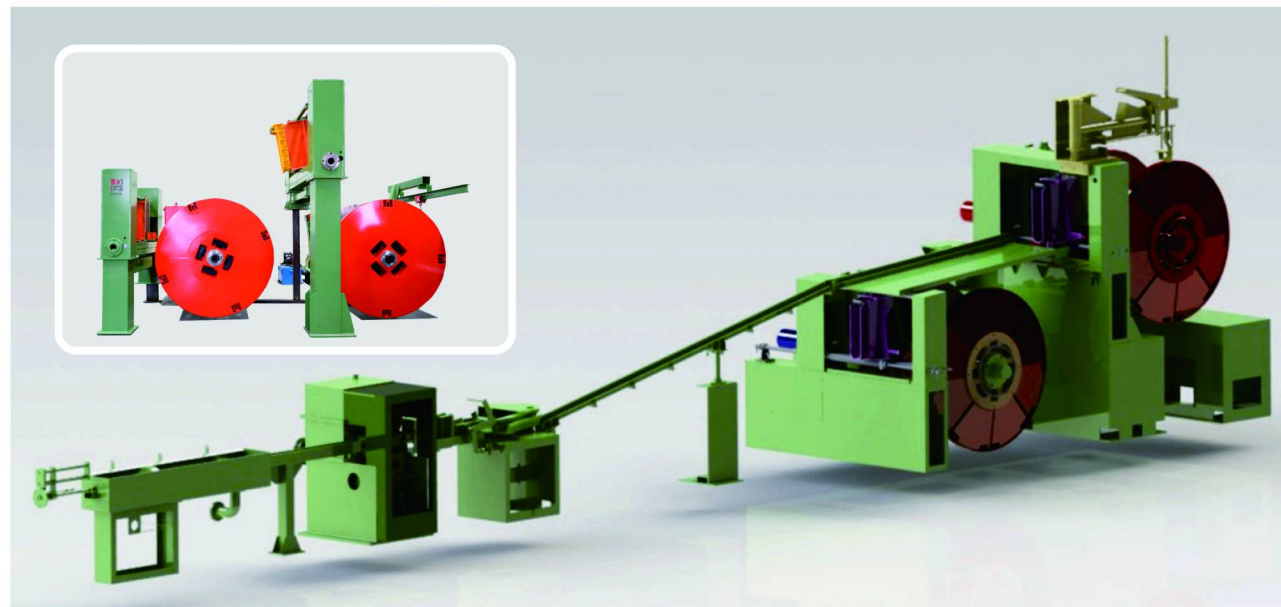
## Configuration

- 1.Basic: casting machine, oil hydraulic shears, rolling mill, coiler, cooling and lubricating system for the gearbox, and electric control system;
- 2.At user's option: melting furnace, holding furnace, rotary shears, front drive, rotary shears, straightener, roller (H13 material), and dual basket coiler.

## Technical Parameters

Model	Cross Section of Cast Bar (mm <sup>2</sup> )	Outlet Diameter (mm)	Max. Final Rolling Speed (m/s)	Max. Output (t/h)	No. of Stands
XDG1800+255/15H	2450	9.5, 12, 15	6.5	4.5	15 (7+8)





**1.Name and Model**  
Dual rod coiler SGS800/1600

**2.Application**  
This machine is applicable to coiling aluminum and/or aluminum alloy rod for continuous casting and rolling line (CCR).

**3.Description**  
This machine is used as a compact coiler to continuous casting and rolling line for aluminum and/or aluminum alloy rod, from which a coil of rod without a basket is produced. It's capable of taking up aluminum rod or aluminum alloy rod from diameter  $\phi 9.5 \sim \phi 12\text{mm}$  at a speed of 7m/s. It's composed of cooler, shears, divider, scrap drive unit, scrap rod collecting rack, guide groove, dual rod coiler, pneumatic system, and electric control. As a compact coiler, it's capable of changing the reel automatically without causing the rod tangled.

It's equipped with forced cooler to prevent sharp difference of temperature between the inner coil and the outer coiler that affects the quality of the aluminum rod, particularly aluminum alloy rod. The shears work not only to cut off the rod at the time of changing the reel, but also cut the waste rod into short sections in case of fault or inferior quality of the rod during the casting and rolling process. Then it guides the waste rod into the material stacking basket via the divider and the waste rod guide; the divider guides the rod to the waste rod drive unit or the guide groove; the guide groove connects the divider with the rod coiler and guide it to the rod coiler. Once the rod coiler completes a coil, it straps the coil and pushes it off the reel.



**Main Technical Parameters**

1	Rod diameter (mm)	$\phi 9.5, \phi 12$
2	Take -up speed (max)	6.5m/s, 12.5m/s
3	Take-upreeldiameter	570mm or 780mm
4	Size of coil (mm)	$\phi 570/\phi 780\text{mm} \times \phi 1600 \times 850$
5	Weight of coil (kg)	2000
6	Overall dimension (m)	15x8.6x4
7	Brakemode	pneumatic brake

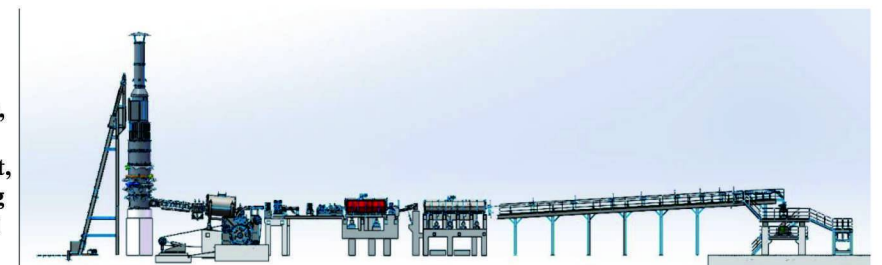


**Features:**

Applicable to making glossy copper rod from copper cathode

**Configuration:**

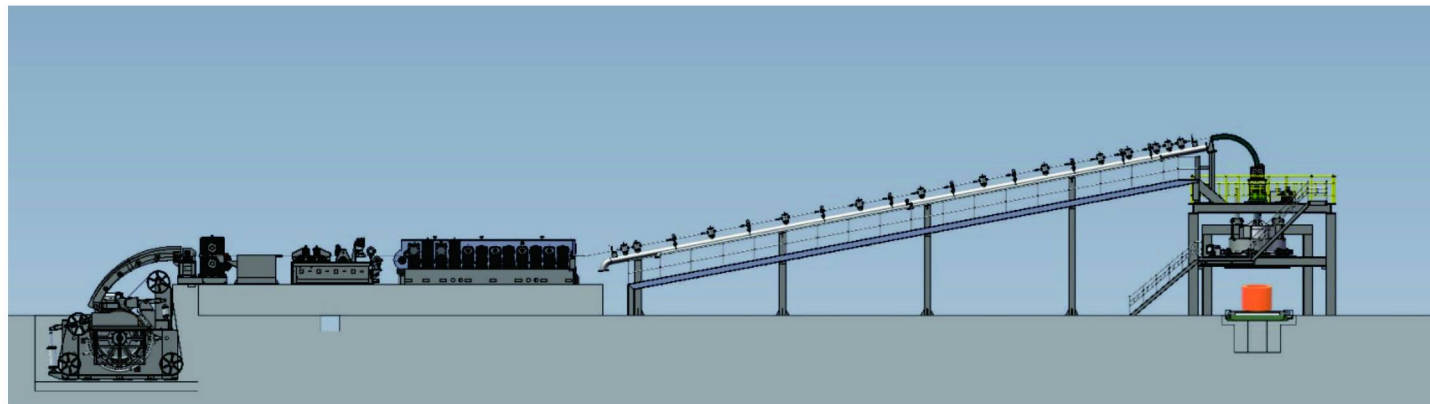
Casting machine, front drive, rotary shears, straightener and trimmer, burr shaver, roughing mill ,finishing mill,quenching unit, hydraulic coiler, lubrication system, cooling and lubricating system, and electric control system;



**Technical Parameters:**

Model	Cross Section of Cast Bar $\text{mm}^2$	Outlet Diameter mm	Output (t/h)	No. of Stands
XDG $\phi 8-406+305+203/11\text{B}$	3800-7100	$\phi 8$	20t-45t	2+8, 3+8, 3+10





### Features

1. Applicable to making glossy copper rod from copper cathode or red copper scraps;
2. The production line needs a small investment capital, occupies a smaller area, produces no pollution to the worksite, consumes less energy and costs less labor intensity, but rate of product and output are high;
3. Casting wheel is cooled from four sides, with outer coolers and inner coolers in three sections and side coolers in two sections. According to the process requirements for the crystallizing process, nozzles in sector shape with different flow rates supply water to each section at adjustable volume with pressure displayed. This is helpful to the cast bar to be cooled evenly, crystals to get finer;
4. Casting machine is in five-wheel integral construction. It's easy to install, position, and commission it at the worksite;
5. Facilities are available to handle and protect the casting wheel from being damaged in case of accidental power failure;
6. Rolling mill is equipped with first four stands with two rollers and the last eight stands with Y-shaped three rollers;
7. Cleaning and reduction device also performs cooling in-line in order to maintain the temperature and glossiness of the rod;
8. Fully digital DC speed regulator and PLC are used in the control system of the whole production line, which is also equipped with measurement, indication, fault display, and human-machine interface (HMI) to show running condition of the machine and to facilitate human-machine dialogue.

### Configuration

1. Basic: casting machine, front drive, rotary shears, straightener and trimmer, burr shaver, rolling mill, coiler, cleaning and reduction unit, rosette coiler, gearbox lubrication system, cooling and lubricating system, and electric control system;
2. At user's option: melting furnace (shaft furnace or horizontal furnace), holding furnace, rollers made of H13 material, and hydraulic coiler.

### Technical Parameters

Model	Cross Section of Cast Bar (mm <sup>2</sup> )	Outlet Diameter (mm)	Final Rolling Speed (m/s)	Output (t/h)	No. of Stands
XDG2100+255/4+8T	2340	8	9.5	~17	12 (4+8)



### Features:

1. Applicable to drawing  $\phi 9.5$ mm pure aluminum rod into  $\phi 1.6$ mm~ $\phi 4.5$ mm single wire;
2. Pneumatic dual spooler accelerates and decelerates in a short time and when it decelerates to 8~12 m/s, it changes the bobbin. So production efficiency is high;
3. Error in the diameter of the wire end is  $\pm 0.01$ mm and its range of change is narrow when the dual spooler is changing the bobbin, so loss of wire is small;
4. Main gearbox casing is made one-whole piece of casting, which is good in absorbing shock while retaining good stability, and will not deform over a long-term; process holes are set in the oil tank to make it easy for dismantling;
5. As the pneumatic dual spooler for the machine is free from oil leakage, no pollution is caused to the worksite. It's conducive to the environment;
6. Dual support to the traversing rack so that it moves smoothly; motorized adjustment to the position for change of direction can be made even when it is under in-line condition;
7. Contactless potentiometer is used in the wire accumulator, which has a longer service life and good adjustment to linearity in order to change the bobbin at a high speed;
8. The rotary arm stand has two working positions to receive and pay off the rod continuously and it will automatically stop working in case of tangled rod;
9. Automatic control available as photoelectric control and electric control are integrated with mechanical function; fully digital DC speed regulator and PLC are used to perform intelligent control. It's complete with measurement, indication and fault display function as well as alarming for fault and automatic stop function.

### Configuration

1. Basic: two-position rotary arm pay-off stand, host drawing machine, accumulator, automatic dual spooler, Siemens PLC, DC speed regulator, touch screen, electric control cabinet, operation desk, cooling and lubrication system for drawing dies and gears, and inclined oil collecting tray.

#### Technical Parameters:

Model	No. of Draft	Inlet Diameter(mm)	Outlet Diameter(mm)	Max. Delivery Speed (m/s)	Technical Features
LHD450/9H	9	Al alloy9.5	3.5~4.5	16	Drawing both al and al alloy wire
		Al 9.5	3.3~4.5	20	
		Al 12	3.9~4.5	20	
LHD450/11H	11	Al alloy9.5	2.8~4.5	20	Drawing both al and al alloy wire
		Al 9.5	2.6~4.5	23	
		Al 12	3.4~4.5	23	
LHD450/13H	13	Al alloy9.5	2.3~4.5	21	Drawing both al and al alloy wire
		Al 9.5	2.1~4.5	25	
		Al 12	2.8~4.5	25	

#### Technical Parameters:

Model	No. of Draft	Inlet Diameter (mm)	Outlet Diameter (mm)	Max. Delivery Speed (m/s)	Technical Features
LHD450/9P	9	9.5	2.8~4.5	20	Drawing al wire
LHD450/11P	11	9.5	2.3~4.5	22	
LHD450/13P	13	9.5	1.6~4.5	25	





## Features

- 1.Applicable to draw  $\phi 8.0\text{mm}$  copper rod into  $\phi 1.2\text{mm}\sim\phi 4.5\text{mm}$  wire;
- 2.After copper wire is annealed and wound up in the bobbin, its temperature drops below  $50^{\circ}\text{C}$ , not oxidized or changed in diameter. Its elongation meets the Chinese national standard;
- 3.Guide sheaves in the annealer and the accumulator are made of aluminum alloy, whose groove is sprayed with ceramic for higher hardness, wearability, and longer service life;
- 4.Annealer is synchronized with and controlled by the drive from the final capstan of the main machine; it's possible to shift between annealing mode and non-annealing mode easily, which is also provided with anti-reverse device;
- 5.Pneumatic dual spooler accelerates and decelerates in a short time; when it decelerates to  $8\sim 12\text{ m/s}$ , it changes the bobbin. So production efficiency is high;
- 6.Error in the diameter of the wire end is  $\pm 0.01\text{mm}$  and its range of variation narrow, so loss of wire is small;
- 7.The main gearbox casing is cast from resin sand, which is good to offset shock while retaining good stability, and will not deform over a long term. The drawing fluid tank has holes for dismantlement to make it easy for service and maintenance;
- 8.Contactless potentiometer is used in the wire accumulator, which has a longer service life and is good for adjustment of the linearity in order to change the bobbin at a high speed;
- 9.The rotary arm pay-off stand has two working positions so that it can receive and pay off the rod continuously and it will stop in case of tangled rod;
- 10.Pneumatic dual spooler matching with the main machine is free from oil leak, so no pollution is caused to the worksite, which is good to the environment;
- 11.The traversing rack has dual support so that it moves smoothly; motorized adjustment to the position for change of direction can be made even when it is under in-line condition;
- 12Automatic control is available as photoelectric control and electric control are integrated with mechanical function; fully digital DC speed regulator and PLC are used for intelligent control. It's complete with measurement, indication and fault display functions as well as alarming for fault and automatic stop.

## Configuration

- 1.Basic: Two-position rotary arm pay-off stand, host drawing machine, accumulator, annealer, pneumatic dual spooler, Siemens PLC, DC speed regulator, touch screen, electric control cabinet, operation desk, cooling and lubrication system for drawing dies and gears, inclined oil collecting tray, etc.
- 2、At user' s option:Downcoiler

## Technical Parameters

Model	No. of Draft	Inlet Diameter (mm)	Outlet Diameter (mm)	Max. Delivery Speed (m/s)	Technical Features
LHD450/9T	9	8	2.1~4.5	20	Drawing copper wire
LHD450/11T	11	8	1.7~4.5	22	
LHD450/BT	13	8	1.2~4.5	25	



## Features

- 1.Applicable to drawing  $\phi 9.5\text{mm}$  high-strength, high-conductive, and heat-resistant aluminum alloy rod and/or pure aluminum rod into  $\phi 1.8\text{mm}\sim\phi 4.5\text{mm}$  wire. With some parts changed, it's also capable of drawing aluminum alloy rod and/or pure aluminum rod into shaped wires;
- 2.Each drawing capstan is provided with an independent motor and reducer; with multiple motor drive, the transmission ratio on each capstan is adjusted and maintained by the electric control system;
- 3.As there is only slight slipping between the surface of the wire and that of the capstan, wear to the drawing capstan is minimized but quality of the finished wire is brought up;
- 4.The main machine is provided with pneumatic covers, and an inclined oil collecting tray is used in the base, it's easy to clean the drawing trough;
- 5.The pneumatic dual spooler elevates up and down very quickly and when the speed drops to  $8\sim 12\text{m/s}$  it changes the bobbin; so production efficiency is very high;
- 6.Error in the diameter of the wire end is  $\phi 0.01\text{mm}$  and its range of variation is narrow, so loss ratio of waste wire is small;
- 7.Pneumatic dual spooler is free from leakage and causes no pollution to the worksite;
- 8.Dual support to the traversing rack so that it moves smoothly; motorized adjustment to the position for change of direction can be made even when it is under in-line condition;
- 9.Contactless potentiometer is used in the wire accumulator, which has a longer service life and good adjustment to linearity in order to change the bobbin at a high speed;
- 10.The rotary arm pay-off stand has two positions to receive and pay off the rod continuously. In case of tangled rod, the main machine will stop;
- 11Automatic control available as photoelectric control and electric control are integrated with mechanical function; fully digital DC speed regulator and PLC are used for intelligent control, complete with measurement, indication and fault display functions as well as alarming for fault and automatic stop.

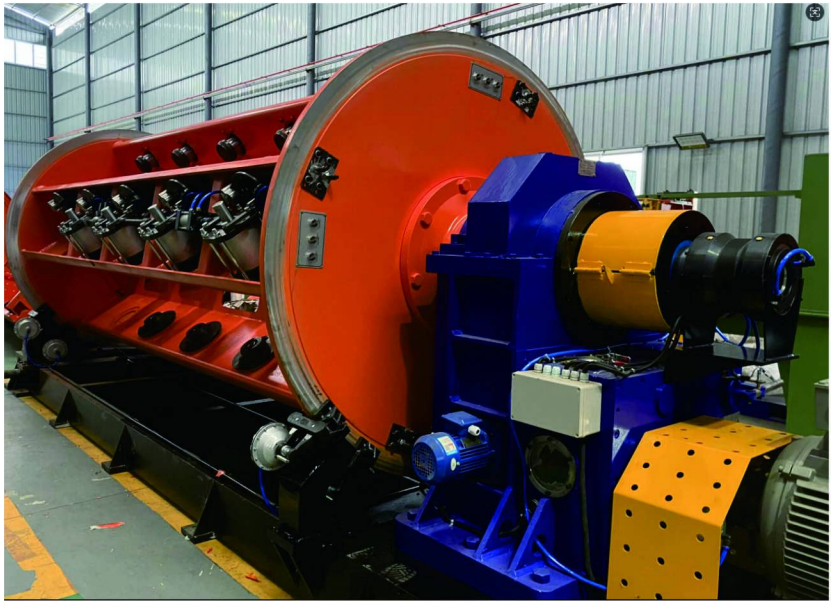
## Configuration

- 1.Basic: Rotary arm two-position pay-off stand, host drawing machine, accumulator, pneumatic dual spooler, Siemens PLC, DC speed regulator, touch screen, electric control cabinet, operation desk, cooling and lubricating system for drawing dies and gears, inclined oil collecting tray, and so on.
- 2.At user's option: AC variable frequency speed regulator.

## Technical Parameters

Model	No. of Draft	Inlet Diameter (mm)	Outlet Size		Max. Delivery Speed (m//s)	Technical Features
			Round Wire Diameter (mm), Shaped Wire Cross Section (mm <sup>2</sup> )			
LFD450/9H	9	9.5	2.8~4.5	7~16	20	Singlespooler for shaped wire
LFD450/11H	11	9.5	2.3~4.5	7~16	22	
LFD450/13H	13	9.5	1.8~4.5	7~16	25	





Features:

- 1.Each stranding cage is individually driven by a motor, which is independently controlled, with rotating speed separately adjusted, through toothed pulley;
- 2.Applicable to stranding copper conductor, aluminum conductor, and aluminum conductor steel reinforced (ACSR) without backtwist, as well as insulated wire and strand. Fitted with a compactor, it is also applicable to stranding round-shaped, semi-round-shaped, and sector-shaped copper conductor or aluminum conductor;
- 3.Applicable to PND 630 and PND 710 bobbins, provided with side-bottom batch loader to load and unload the bobbins altogether;
- 4.Bobbins are loaded separately in four equal positions on the circumference of the stranding cage to make it easy to load and unload. The machine features high rigidity, good integrity, and high running speed;
- 5.Pay-off tension for bobbins in the cage is controlled by mechanical and/or pneumatic means (proportional valve), and supersonic control;
- 6.Provided with motorized twin capstans with natural divider so as to prevent conductor from scratching each other during stranding;
- 7.Break stopper is set to enforce emergency stop to the machine automatically in case a conductor is cut off or broken;
- 8.Fully digital DC speed regulator and PLC are used in the control system of the whole production line, which is also equipped with measurement, indication, and fault display system, and human-machine interface (HMI) to show running condition of the machine, and possible to view it as well.

Configuration

- 1.Basic: FN1600 end-shaft pay-off stand, stranding cage, batch loader, adjustable closing die stand, compactor, length counter, twin motorized capstans with natural conductor divider, gantry travel pay-off with traverse, DC speed regulator, electric control cabinet and operation desk, vertical sliding safety fence.
- 2.At user's option: PND630, PND 710 pay-off stand, die-holder, pre-spiral device (line shaft transmission), shaped wire positioned, side-bottom batch loader, AC variable frequency speed regulator, motorized rotating safety fence.

Technical Parameters of Model JLK Series with Individual Motor Drive

Motor	Single Wire(mm)	Stranding Diameter (mm)	Max. Rotating Speed of Cage (rpm)	Stranding Pitch (mm)
JLK630D/6+12+18+24	Copper 1.5~4.5; Al1.8~5	45	249	38~1100
JLK630D/12+18+24		45	210	45~1100
JLK630D/12+18+24+30		55	210	45~1297
JLK710D/6+12+18+24	Al 1.8~5; Al shaped wire (diameter equal to 2.8~6.0)	45	169	40~1136
JLK710D/12+18+24		45	210	45~1136
JLK710D/12+18+24+30		55	210	45~1340

Features:

- As a result of technical innovation and optimized design, rotating speed of the stranding cage increases by more than 15% and technical properties are more updated.
- Applicable to stranding copper conductor, aluminum conductor, and aluminum conductor steel reinforced (ACSR) without backtwist, as well as insulated wire and strand. Fitted with a compactor, it is also applicable to stranding round-shaped, semi-round-shaped, and sector-shaped copper conductor or aluminum conductor.
- Applicable to PND 630 bobbins, provided with hanger and electric hoist to load and unload the bobbin individually or side-bottom batch loader to load and unload the bobbins altogether.
- Bobbins are loaded separately in four equal positions on the circumference of the stranding cage to make it easy to load and unload. The machine features high rigidity, good integrity, and small inertia of rotation, and high running speed.
- A 36-stage gearbox is adopted with motorized twin haul-off capstans. Conductor is separated naturally on the divider to prevent scratching to the conductor during stranding.
- Wire-break stopper is available to force emergency stop to the machine automatically in case a conductor is cut off or broken.
- Fully digital DC speed regulator and PLC are used in the control system of the whole production line, which is also equipped with measurement, indication and fault display system, and human-machine interface (HMI) to show running condition of the machine and to facilitate human-machine dialogue. The control system is advanced, complete with protectors, reliable in performance, easy and convenient for operation.

Configuration

- 1.Basic: FN1600 end-shaft pay-off stand, stranding cage, hanger for individual bobbin loading, adjustable closing die stand, main reducer and 36-gearbox, length counter, twin motorized capstans with natural conductor divider, 2500 end-shaft take-up with traversing unit, DC motor and DC speed regulator, electric control cabinet and operation desk, sliding safety fence.
- 2.At user's option: shaft-type pay-off stand, batch loader, ultrasonic controller for tension from bobbin, closing die stand and roller compacting unit, gantry travel take-up with traversing unit, AC motor and variable frequency speed regulator, curved sliding fence or motorized rotating safety fence.



Technical Parameters of JLK 500 Series

Model	Single wire diameter (mm)	Stranding diameter (mm)	Rotating speed of cage (rpm)	Stranding Pitch (mm)
JLK500/6+12	Copper1.5~4.5; Al 1.8~5	25	190~68	35~761
JLK500/6+12+18		35	190~58	35~892
JLK500/12+18+24		45	162~49	41~1052

Technical Parameters of JLK 630 Series

Model	Single wire diameter (mm)	Stranding diameter (mm)	Rotating speed of cage (rpm)	Stranding Pitch (mm)
JLK630/6+12+18+24	Copper1.5~4.5; Al 1.8~5	45	207~54	38~1104
JLK630/12+18+24		45	176~54	45~1104
JLK630Z/6+12+18	Copper1.5~4.5; Al1.8~5	35	207~64	38~930
JLK630Z/6+12+18+24		45	207~54	38~1104
JLK630Z/6+12+18+24+30		55	207~45	38~1324
JLK630Z/12+18+24		45	176~54	45~1104
JLK630Z/12+18+24+30		55	176~45	45~1324

Technical Parameters of JLK 710 Series

Model	Single wire diameter (mm)	Stranding diameter (mm)	Rotating speed of cage (rpm)	Stranding Pitch (mm)
JLK710X/6+12+18	Al 1.8~5; Al shaped wire (diameter equal to 2.8~6.0)	35	156~48	37~924
JLK710X/6+12+18+24		45	156~42	37~1041
JLK710X/12+18+24		45	132~42	44~1041





Features

- 1.Widely applicable to stranding aluminum, aluminum alloy, copper, copper alloy conductors with individual diameter as well as steel stranded wire, and steel wire rope;
- 2.Three sets of large bearings are used to support the rotating tube of tubular strander JGG630 series so as to achieve higher rotating speed, smooth performance, and a longer service life of the bearings;
- 3.The stranding tube, which has three windows, is welded as one whole piece subject to tempering and flaw detection; the inner wall and the excircle are subject to precision machining so that it is good in rigidity and co-axiality that results in smooth performance;
- 4.The large bearings are lubricated with dedicated lubricating station that provides superb lubrication; as the seals are in labyrinth, sealing is perfect and free from leak;
- 5.Base of the main machine, which is made of cast iron and is subject to tempering, absorbs shock and has good stability. It's easy to transport, install and commission it;
- 6.The stranding cage is supported with bearings on the headstock, resulting in precision installation so that the main machine runs smoothly;
- 7.There are two capstan wheels and the length counter can work both mechanically and electronically;
- 8.Sliding safety hood is set with mesh steel plate, which is good in look and practical to use;
- 9Automatic control is available as photoelectric control and electric control are integrated with mechanical function, which is able to give alarm for fault and stop automatically.

Configuration

- 1.Basic: Pay-off stand, main machine, lubricating station, die-holder, capstan wheels, end-shaft take-up with traverse, DC speed regulator, Siemens PLC, touch screen, electric control cabinet, and operation desk.
- 2.At user's option: AC variable frequency speed regulator, gantry travel take-up with travel.

Technical Parameters

Model	Individual wire diameter (mm)	Stranding diameter (mm)	Main machine rotating speed (rpm)	Delivery speed (m/min)
JGG500/6	Cu,Steel1.3~3.5; Al 1.7~4.6	15	650	90
JGG630/6	Cu 2~5, Al2.5~5; Steel1.8~4.5	15	600	90
JGG630/12	Cu 2~5, Al2.5~5; Steel1.8~4.5	15	450	70

Tubular Strander Model JGG+1

Technical Parameters

Model	Individual wire diameter (mm)	Stranding diameter (mm)	Main machine Max rotating speed (rpm)	Delivery speed (m/min)
JGG500/12+1000/1	Cu, Steel1.3~3.5 Al1.7~4.6	23	300	60
JGG630/12+1250/1	Cu 2~5, Al 2.5~5; Steel1.8~4.5	25	240	60
JGG630/18+1400/1	Cu 2~5, Al 2.5~5; Steel1.8~4.5	35	200	60



Features

- 1.Widely applicable to stranding aluminum, aluminum alloy, copper, copper alloy conductors and steel stranded wire, and steel wire rope;
- 2.Under-rollers are used to support the rotating tube;
- 3.Under-rollers are made of aluminum alloy that constitutes an excellent combination with the ductile iron rail on the tube, which results in better wearability, better heat radiation, longer service life; it is easy to adjust, maintain and repair;
- 4.Stranding tube is welded as one whole piece subject to flaw detection and tempering, and the inner wall and the excircle are subject to precision machining. So it's good in co-axiality and good balance;
- 5.Base of the machine is of cast iron and is subject to tempering treatment, which absorbs shock but retains high stability. It's easy to transport, install and commission;
- 6.Stranding cage is supported with bearings in the headstock in precision fit, so the main machine can run smoothly;
- 7. Sliding safety cover is set with mesh steel plate on rollers that slide easily on rail;
- 8. As the machine integrates photoelectric control and electric control together, fully digital DC speed regulator is used in the control system with functions such as alarm in case of fault and automatic stop.

Configuration

- 1.Basic for Models 500 and 630: Pay-off stand, main machine, die-holder, capstan wheel, end-shaft take-up with traverse, DC speed regulator, electric control cabinet, and operation desk.
- 2.At user's option: AC variable frequency speed regulator.

Technical Parameters

Model	Single wire diameter (mm)	Stranding diameter (mm)	Max. Rotating Speed (rpm)	Max. Delivery Speed (m/min)	Technical Features
JG400/6	Copper 1~2.5; steel1~2; Al 1~4	12	600	80	
JG500/6	copper,steel1.3~3.5; aluminum1.7~4.6	15	510	80	
JG500/12	copper,steel1.3~3.5; aluminum1.7~4.6	15	350	70	flexible transmission
JG500/12+1000/1	copper,steel1.3~3.5; aluminum2.0~5.0	25	300	60	flexible transmission
JG630/6	Copper2~5,aluminum2.5~5; steel1.8~4.5	15	300	70	





Features:

- 1.This machine is composed of frame, coiling mechanism, rosette wire-down mechanism, pneumatic system, and take-up trolley;
- 2.The rosette wire-down mechanism is composed of eccentric mechanism and accumulating mechanism. The eccentric mechanism pushes the wire to the inner circle of the basket, which falls into a rosette pattern into the basket; at the time of change, the accumulating mechanism receives the wire under the force of cylinder and works the inserting rod into motion in and out via a chain mechanism so as to change the coil without stop;
- 3.The pneumatic system can assist to fulfill actions such as brake, changing the coil and compressing the wire;
- 4.The take-up trolley is composed of base frame, traction wheels and transmission; when the length counter reaches the preset value, the trolley will move in and out to change the coil, such relieving the operator from hard labor.

Technical Parameters

1	Take-up Diameter	Soft copper wire 1.3~4.5mm	4	Load(Max)	2000kg
		Hard copper wire 1.38 mm and above	5	Basket size (mm) Supplier’s Standard	φ1000×φ600×1700
2	Take-up speed	Max 25m/s	6	Coiler basket	2 No. s
3	Take-up wheel	φ850mm			
1. In the case of soft wire, take-up speed is based on the speed of the annealer; 2. In case of hard wire, take - up speed is based on the linear speed of the main machine.					

Compact Coiler Model SXJ1000/590



Technical parameters

Description	Parameters
Take-up diameter	Finished wireφ1.8~φ3.5(mm)
Max. mechanical speed	25 (m/s)
Take-up reel size: OD×ID×IW	φ1000×φ610×590(mm)
Weight of coil(max)	Approx2200kg
Overall dimension of main machine	2710×1850×1565(mm)
Net weight of main machine	Approx5t

- 1.Name and Model  
Compact coiler Model SXJ1000/590
- 2.Application  
It's applicable to coiling soft copper wire after annealing, soft and hard aluminum wire, and coated finished wire by working in conjunction with wire drawing machines.
- 3.Description and Working Principle  
3.1 Compact coiler Model SXJ1000/590 is a high-speed take-up applicable to copper wire, aluminum wire, and coated wire;  
3.2 The clamp, pusher, and brake are worked by pneumatic system, among which the pintle is pushed by pneumatic cylinder. So it's easy to operate and does not cause pollution to the worksite. Besides, locking device is provided and traverse is by servo control; the take-up reel is subject to dynamic balance test so that stability can be achieved during running. It's safe and secure to lift the reel as it's done with pneumatic wrench;
- 4. Features of Model SXJ1000/590  
4.1 No need to use a separate reel, thus reducing the cost and saving the space;  
4.2 Tapered traverse makes the wire in good order and reliable;  
4.3.Due to its large diameter, the take-up reel is big in capacity.

