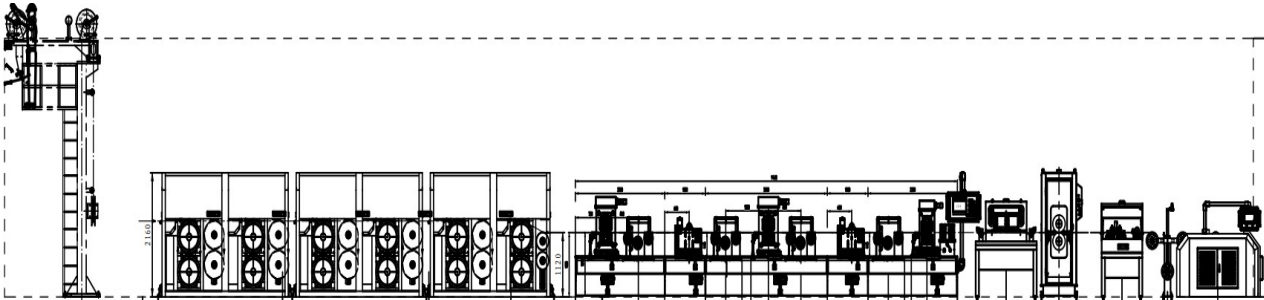




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MODLE	NAME
RDM6/5	6-dies drawing+five stations precision rolling mills



Equipment composition

1. Over-head pay off rack
2. Six die drawing machine
3. Five rolling mills (tension control, first pass 2-high rolling mill, tension control, second pass edging rolling mill , tension control, third pass 2- high rolling mill, tension control, fourth pass edging rolling mill, tension control, fifth pass 2-high rolling mill)
4. Degreasing and cleaning device
5. Polishing machine and vacuum cleaner
6. Inline measuring device,
7. Take-up machine
8. Cooling system Sheet metal casing
9. Electrical and automatic control system.



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Over-head pay off rack, six die drawing machine, 2-high mill 1, tension ,edge rolling 2 ,tension, 2-high mill 3, tension,edge rolling 4 ,tension, 2-high mill 5, tension degreasing cleaning ,polishing, measurement, tension ,take-up machine

Operation direction: According to the requirements of Party A

Equipment color: The equipment can be customized according to customer needs or matched with gold wheels

Power supply: $3 \times 380V+N+PE$, 50Hz

Maximum power: approximately 450KVA

Compressed air: pressure $\geq 0.5\text{Mpa}$, flow rate not less than 2000L/min

Require dryness, no impurities, no oil, and no water,

Used for blowing air, pneumatic tension wheel, with air source provided by Party A.

Equipment size of Party B: not exceeding 30 m (L) * 5.2 m (W) * 5 m (H)



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Venue requirements: The ground should be flat, well ventilated, and the entire rolling line should be installed in the workshop. The length direction should not be less than 35 meters, and the spatial position for installation, loading and unloading, transportation, maintenance, etc. should be ensured.

The equipment passage should not be less than 1.5 meters.

Rolling fluid: Emulsified fluid provided by the customer.

Basic Parameters

Production scope:

Suitable for rolling copper flat wire with rounded corners.

Finished product cross-section: 3-25 mm² wire R-angle and tolerance: in accordance with the latest version of GB/T 5584

Width: 2.2-14.0mm

Thickness: 0.5-4mm

R-angle: 0.5-1mm

$1 \leq b/a \leq 12$

Feed material: Low oxygen copper rod (SCR or equivalent).

Finished product size accuracy:

Inlet diameter: $\Phi 3 \sim \Phi 8$ mm, with no oil, dust or dirt on the inlet surface, and no intermediate annealing treatment;

Thickness direction: ± 0.005 mm;

Width direction: ± 0.01 mm.

Rounding radius: in accordance with GB/T 5584.

Acceptance criteria:

Feed material: Low oxygen copper rod (SCR or equivalent);

Incoming line: wire diameter $\leq \Phi 8$ mm, tensile strength ≤ 250 MPa; Line diameter range ≤ 0.01 mm;

Finished product thickness and dimensional accuracy: $\leq \pm 0.005$ mm;

Finished product width dimension accuracy: $\leq \pm 0.01$ mm;

Surface roughness: $\leq Ra0.8$ without bamboo joints

Size measurement method: The whole machine runs steadily at the set speed for 5 minutes before rolling



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for 200 meters, removing 50 meters of tail samples, taking 150 meters of samples, and measuring any size.

Wiring quality: The wiring is neat, the gaps are uniform, flat, and there are no defects such as buckling, stacking, or bending. The U-turn wiring is smooth;

Note: Acceptance of the status of the I-shaped wheel (based on the inner hole of the reel, radial runout $\leq 1\text{mm}$, inner side runout $\leq 1\text{mm}$). Acceptance quantity: Select three typical specifications (to be provided by the customer), with each specification not exceeding 3000Kg.

Tensile strength of incoming line: $\leq 250\text{MPa}$

Rolling passes: 5 passes

Operating speed: The maximum designed linear speed is 400m/min, and the rolling and drawing processes are determined through negotiation between both parties; Or refer to the production process of Party B in the same industry and similar models. (Party B shall cooperate with Party A to develop production processes and meet Party A's product process requirements)

Cable reel size (detailed drawings provided by Party A):

Type of cable reel	Outer diameter Ø mm	Total width mm	Maximum gross weight kg	Central axis hole Ø mm
1#				

Demand supply:

Compressed air: used for blowing air, pneumatic tension wheels, and online non-contact measuring devices. The air source is provided by Party A, with a pressure of 0.6-0.8Mpa, dry, free of impurities, oil, and water.

Venue requirements: The ground should be flat, well ventilated, and the entire rolling line should be installed in the workshop. The length direction should not be less than 35 meters, and the spatial position for installation, loading and unloading, transportation, maintenance, etc. should be ensured.

Emulsion: The emulsion is provided by the customer.

Center height: 1120mm