



Babcock Wire Rod Shaving Attachment

This process was devised to remove the majority of defects in Copper Rod caused by hot rolling.

These defects comprise (a) surface laminations and (b) rolled in oxides and other particles. Both give rise to problems when the rod is drawn, and can cause the majority of wire breaks in sizes 0.2mm and finer. Normally, the Babcock Rod Shaving Attachment is used in conjunction with a Double Deck Rod Block Machine where it replaces the Second Die. It can also be fitted to Heavy Duty Trolley Wire Machines.

In both machines, the first die is used to round the rod and at the same time concentrate the defects as close as possible to the surface. To achieve this effect, the die drawing angle should be 250° - 300° inclusive.

On a Double Block Machine, the wire is led from the first die via the lower block and guide pulley, to the Shaving Attachment which consists of an entry drawing die, a guide die, a shaving die and an exit drawing die.

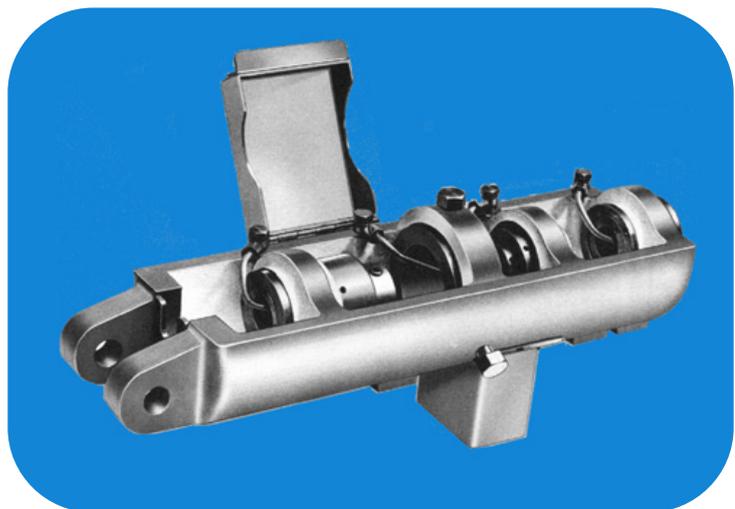
The drawing die, shaving die and exit die are on the centre line of the Attachment with the guide die being adjustable at a right angle to it.

The depth of shave is the difference between the adjustable guide die and the shaving die, normally between 0.25mm and 0.35mm.

A rotating indenter is provided which can be fitted to the exit side of the first die holder or in the Shaving Attachment.

This consists of 3 Tungsten Carbide blades mounted in a rotatable head. These are located at an angle to the rod line so that its forward motion causes the head to rotate. The depth of indent is set so that it is a small amount less than the shaving depth.

When these spiral indentations reach the shaving die they cause the streams of removed metal to break into short lengths which can fall freely into a container under the shaving attachment.



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