



Winget Syncro

Type J21 Wire Drawing Machine

for the drawing of non-ferrous metals

The Winget Syncro J21 type, as illustrated, is a combined high-speed breakdown and intermediate wire drawing machine.

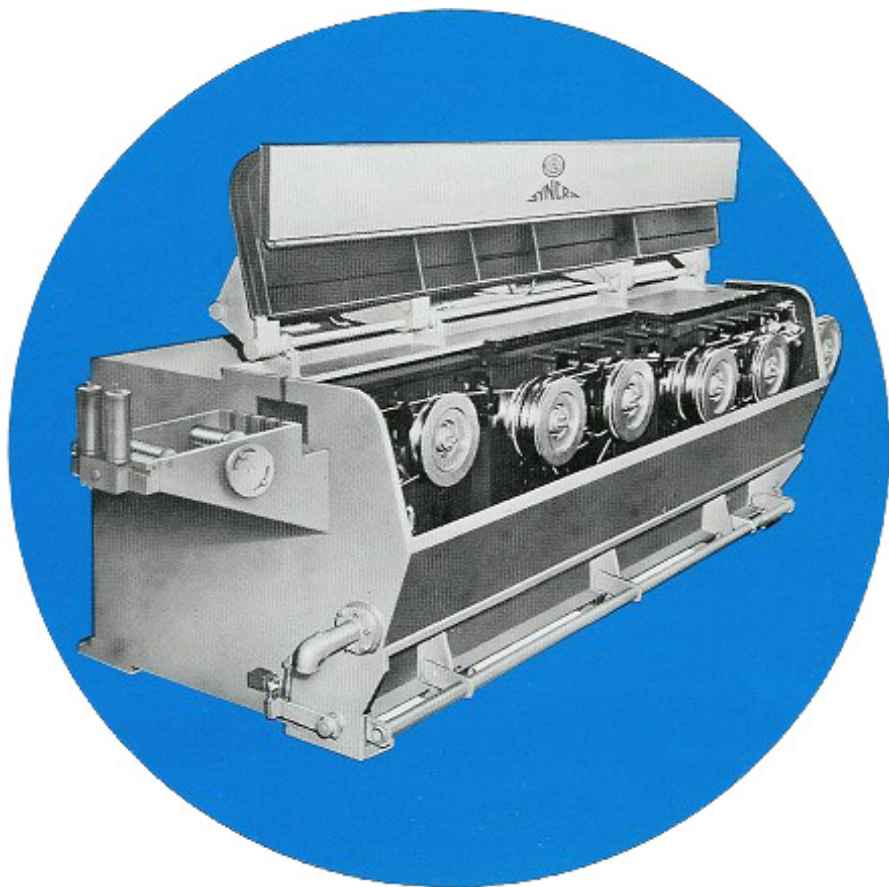
Pullblock Assembly

The J21 machine has ten double-step pullblocks grouped into six assemblies and up to 21 dies may be used. The first two assemblies each have one double-step pullblock mounted on the drive shaft. The remaining assemblies having two double-step pullblocks. The inner pullblock is mounted on a tubular drive shaft and has a solid shaft passing through it, onto which is mounted the outer pullblock. The large pullblock diameter is 14" (356mm), the smaller 9" (229mm) both are made of high grade chrome steel.

Wide Finishing Range

Provision is made for using between 8 and 21 dies by adjusting the speed of the finishing capstan. This is achieved by employing a double-step finishing capstan and a four-speed capstan gearbox giving the possibility of 8 finishing wire speeds.

Specifications for processing copper or aluminium are shown overleaf.





Specification J21 Machine (capstan type)

for the drawing of non-ferrous metals

Winget Syncro	Copper		Aluminium	
Maximum number of dies	21	21	21	21
Elongation per die	26%	26%	26%	26%
Area reduction per die	20.65%	20.65%	20.65%	20.65%
Maximum entry diameter	5/16"	8mm	5/16"	8mm
Finishing diameter range:				
Entry Rod ¼" (6.35mm)	0.020" to 0.128"	0.51mm to 3.25mm	0.025" to 0.128"	0.64mm to 3.25mm
Entry Rod 5/16" (8mm)	0.025" to 0.128"	0.64mm to 3.25mm	0.025" to 0.128"	0.64mm to 3.25mm
Operating speeds	5,070 fpm	25.7 mps	5,070 fpm	25.7 mps
Maximum power motor	150 hp	150 hp	150 hp	150 hp
Number of draw block shafts	6	6	6	6
Operating speeds when using large capstan:				
In forward position	5,070 fpm & 3,950 fpm	25.7 mps & 20.1 mps	5,070 fpm & 3,950 fpm	25.7 mps & 20.1 mps
In rear position	2,050 fpm & 1,680 fpm	10.4 mps & 8.55 mps	2,050 fpm & 1,680 fpm	10.4 mps & 8.55 mps
Operating speeds when using small capstan:				
In forward position	3,280 fpm & 2,550 fpm	16.7 mps & 13.0 mps	3,280 fpm & 2,550 fpm	16.7 mps & 13.0 mps
In rear position	1,335 fpm & 1,090 fpm	6.8 mps & 5.54 mps	1,335 fpm & 1,090 fpm	6.8 mps & 5.54 mps
Maximum die case accommodated	1¾" dia x 1¼" thick	45mm x 32mm	1¾" dia x 1¼" thick	45mm x 32mm
Required flow of wire drawing lubricant	150 gpm	700 litre /m	100 gpm	450 litre /m
Lubricant pressure	20 psi	1.4 kg/cm ²	20 psi	1.4 kg/cm ²
Quantity of lubricant required	1,500 gal	7,000 litres	1,000 gal	4,500 litres
Compressed air required to open front cover	2 cu ft at 80 psi	56 litres at 5.6 kg / cm ²	2 cu ft at 80 psi	56 litres at 5.6 kg / cm ²
Floor space required for motor, gearbox, machine and control panel	22 ft x 10 ft	6.7m x 3m	22 ft x 10 ft	6.7m x 3m
Approximate weight with motor, machine and control panel	31,500 lb	14,300 kg	31,500 lb	14,300 kg

Take-ups and annealers for continuous and co-ordinated operation are available for use with the J21 Type Machine, details of which are available upon request.

Other particular features such as Drive, Machine Oil Lubrication and Wire Drawing Lubrication are fully detailed on Bulletin 1C.

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.