

# WIRE DRAWING PLANT (Continuous Plant) (Binding Wire Plant)

- (a) Wire Drawing Machine
- (b) Control Panel Board
- (c) Wire Pointing Machine
- (d) Butt Welding Machine
- (e) Descaling Machine
- (f) Die Polishing Machine
- (g) Wire Pay Off Stand
- (h) Continuous Coiling Device (Dead Coiler)
- (i) Stripper / Spider
- (j) Wire Annealing Furnace

## WIRE DRAWING MACHINES



### FEATURES

- Main body with base, drawing drum and drawing die box of close grain cast iron.
- Water cooling arrangement provided inside the Drawing Drum and the Die Box.
- Phosphorous bronze gears with high carbon axle steel worms.
- Suitable for making Nail wire 8 mm or 6 mm input rods upto 2 mm.
- Also suitable for making Wire used to make Barbed Wire, Wire Mesh, etc.
- Wet / Slip type fine Wire Drawing Machines also available. Details available on request
- Suitable for Mild Steel, High Carbon Steel, Non Ferrous Metals.

### OPERATION DETAILS

- The wire rod to be drawn is pointed in the Wire Pointing Machine. This pointed wire is inserted through the die of the first Wire Drawing Machine and fastened to a locking device on the drum. The drum is then started, as the drum rotates, the wire fastened to the drum gets pulled and coiled around the drum. Since the wire getting pulled is passed through the die having a higher inlet diameter and lower outlet diameter, the drawn wire diameter gets reduced.
- The starting end of the drawn wire is released from the lock of the first drum and then it's passed through the overhead loop and pulley provided. It is brought down and is inserted through the die of the second drum and drawn through this die for further reduction. Thus, the wire is drawn through all the wire drawing drums of the set in a continuous manner to get the required finished diameter of the wire.
- When the drum of the last wire drawing machine gets fully loaded with the drawn wire, the machine will be stopped to unload the finished material and then restarted. If one opts for the continuous coiling machine, then the drawing process will not have to be stopped for this purpose.
- When the bundle of the input rod finishes, the machine should be stopped. The end of this bundle is welded to the end of a new bundle rod using the butt welding machine. Then the process is to be continued.
- Also, in case of an accidental snapping of wire in between drums, the snapped ends are welded with the help of the butt welding machine and the process is continued.

### SPECIFICATION

Item Code No.	ABM-FM-6830	ABM-FM-6831	ABM-FM-6832	ABM-FM-6833	ABM-FM-6834
No. of Blocks	1 to 3	1 to 6	1 to 8	1 to 6	1 to 10
Diameter of Drum (mm)	750	610	560	460	305
Material to be Drawn	Mild Steel / High Carbon Steel / Non Ferrous Metals				
Inlet Wire Size (mm)	12	8	6	4	2.6
Finished Wire Size (mm)	6	3.37	2	1.68	0.7
Finishing Speed (RPM)	45	110	140	180	380 / 540
Motor for 1st Block	50	40	30	15	10
Motor for 2nd Block	40	30	25	10	7.5
Motor for 3rd Block	30	25	10	10	7.5
Motor for Rest Blocks	--	20	10	10	5
Approximate Block Weight	1850	1550	1450	800	500

### CONTROL PANEL BOARD



## FEATURES

- Suitable for Multi Blocker Wire Drawing machines.
- Supplied with Voltmeter & Ampere meter for individual blocks.
- Supplied with Pilot Lamp, Timer, Auxiliary Relay Starters, Contractors, Overload Relay, H.R.C. Fuses, etc.
- Fitted on a M.S. Fabricated cabinet.

## SPECIFICATION

Item Code No.
ABM-FM-6840

## WIRE POINTING MACHINE



## FEATURES

- This machine is suitable for pointing different types of material like Mild Steel, Aluminium, Copper, etc.
- The pointing rolls are made of EN-31 material and are ground finished.
- Rolls are driven by power as well as by hand.
- The machine is mounted on 4 wheels, makes it mobile and useful to serve several drawing machines.

### SPECIFICATION

Item Code No.	Wire to be Pointed	Motor H.P.
ABM-FM-6850	10 - 1.8 mm	3 H.P.
ABM-FM-6851	8 - 2.0 mm	3 H.P.
ABM-FM-6852	3.3 - 0.9 mm	1 H.P.
ABM-FM-6853	3.3 - 0.9 mm	Operation by Hand

### BUTT WELDING MACHINE



### FEATURES

- This is used to weld the rod / wire.
- It is used when the bundle of the input rod finishes, the machine should be stopped. The end of this bundle is welded to the end of a new bundle rod using the butt welding machine. Then the process is to be continued.
- Also, in case of an accidental snapping of wire in between drums, the snapped ends are welded with the help of the butt welding machine and the process is continued.

### SPECIFICATION

Item Code No.	KVA	Mild Steel	Aluminium	Copper	H.C. Steel
ABM-FM-6860	4	3 to 1	2.5 to 1	2 to 1	--
ABM-FM-6861	6	6 to 2	5 to 2	5 to 2	--
ABM-FM-6862	8	8 to 3	7 to 3	6 to 3	7 to 3
ABM-FM-6863	15	13 to 5	10 to 4	6 to 3	10 to 4

## DESCALING MACHINE



### FEATURES

- Suitable to fit with block of wire drawing machines to remove the scales from the inlet wire rods.

### SPECIFICATION

Item Code No.
ABM-FM-6820

## DIE POLISHING MACHINE

### FEATURES

- Supplied with 1 H.P. Electric Motor.

### SPECIFICATION

Item Code No.
ABM-FM-6870

## WIRE PAY OFF STAND



### FEATURES

- M.S. Fabricated, double hand movable system Pay-Off Stand.
- Suitable to feed the wire rods to the first block of the Wire Drawing Machines.

### SPECIFICATION

Item Code No.
ABM-FM-6875

## CONTINUOUS COILING DEVICE (Dead Coiler)



### FEATURES

- To be fitted to the final block of continuous Wire Drawing Machine.
- Capable to unload the drawn wire from the continuous system wire drawing system without stopping the machine.
- Supplied with 20 H.P. Electric motor.

### SPECIFICATION

Item Code No.
ABM-FM-6880

## STRIPPER / SPIDER



### FEATURES

- Unloading stand for unloading drawn wires through overload electric hoist.

### SPECIFICATION

Item Code No.
ABM-FM-6881

## WIRE ANNEALING FURNACE





## FEATURES

- Pit type electrically heated Annealing Furnace.
- Available in capacity of 75 KW with production of 1.5 Tons (per change of 6 hour cycle).
- Also available in capacity 60 KW with production of 1.0 Tons (per change of 6 hour cycle).
- Temperature : 900° C with temperature indicator.
- Lining of high quality insulation bricks.
- Inner pot of stainless steel with outer shell M.S. fabricated.
- Supplied with a control panel.

## SPECIFICATION

Item Code No.
ABM-FM-6882

All Specifications are subject to change towards improvements without any prior notice.

**Manufactured by ABM Fasteners (India) and Export Marketing by ABM Tools**



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