M 85 / MM 85

Rod Breakdown Machine

NIEHOFF GRUPPE

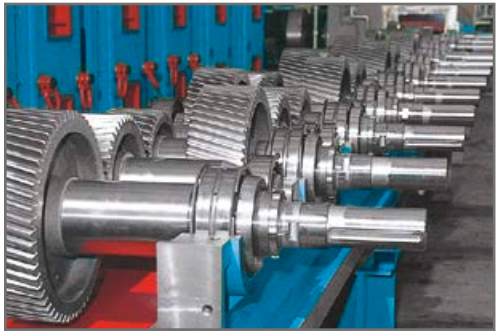
M 85 / MM 85

Design:

- optimized wire cooling/lubrication fully submerged drawing basin
- extremely smooth operation and uniform load transmission by helical precision gear
- vibration-damping grey cast iron housing for long service life
- highly reliable separation of drawing emulsion and gear oil via mechanical seal (long service intervals)
- user-friendly design

Increase in quality:

- inclination of the gearing/drawing capstans for high surface quality of the wires due to the optimized wire path



Increase in productivity:

- reduced downtime when changing the machine setup for different dimensions via multi-motor drive technology (quick drawing die change system)
- NMI (NIEHOFF Machine Interface) color touchscreen for data entry, display of production parameters and maintenance instructions

Energy and cost efficiency:

- production of wires with different finished diameters
- reduced consumption of electric energy per ton of produced wire
- long service intervals and extended drawing tool service life minimize the requirement to stock and use spare parts
- reduced consumption of oil and drawing lubricant

Technical data

type		M 85		MM 85		M 85		MM 85	
material		Cu		Cu		Al / Al-alloy		Al / Al-alloy	
max. production speed	m/s fpm	38 7,480		38 7,480		38 7,480	25 4,921	38 7,480	25 4,921
production output (7,000 h and 80 % utilization)	t/a	25,000		31,000		9,500/8,000		18,000/16,000	
no. of wires		1		2		1		2	
max. inlet dia.	mm AWG	8.0 1	10.0 2/0	8.0 1	10.0 2/0	12.5 4/0	9.5 1/0	12.5 4/0	9.5 1/0
at max. inlet strength	N/mm²	450	250	450	250	120	220	120	220
finished dia.	mm AWG	1.0 ... 4.5 18 ... 5		1.0 ... 4.5 18 ... 5		1.0 ... 5.5/1.2 ... 4.5 18 ... 4	 17 ... 5	1.0 ... 5.5/1.2 ... 4.5 18 ... 4	 17 ... 5
number of drafts		7 ... 15		7 ... 15		7 ... 15		7/8 ... 15	
wire elongation per draft	%	55 ... 26 (tapered)		55 ... 26 (tapered)		33/26		33/26	
drive technology / AC motors		2 motors		2 motors		2 motors		2 motors	