



M 81
Rod Breakdown Machine

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Design:

- unidirectional wire path with no alternating bending (even with the drawing dies omitted)
- drawing capstan diameter matched to the wire diameter
- motor-driven drawing section cover for easy operation
- extremely smooth operation and uniform load transmission by helical precision gear

Increase in quality:

- high wire surface quality due to an ideal wire path (2° inclination of gears/drawing capstans)

Increase in productivity:

- high output
- reduced downtime via multi-motor drive technology when changing the wire diameter
- NMI (NIEHOFF Machine Interface) color touchscreen for data entry, display of production parameters and maintenance instructions

Energy and cost efficiency:

- intensive spraying of drawing capstans and high-pressure cooling of the drawing die holders for extended service life
- highly reliable separation of drawing emulsion and gear oil by mechanical sealing (long maintenance intervals)
- low energy consumption per ton of produced wire
- reduced media consumption
- long maintenance intervals and service lives of the drawing tools for minimized use and storage of spare parts

Technical data

max. production speed	m/s fpm	35.0 6,200						
finished wire dia.	mm AWG	0.8 18	1.6 14	1.8 13	2.3 11	2.6 10	3.0 8 ½	3.5 7 ½
at max. production speed	m/s fpm	35.0 6,890	31.5 6,200	31.5 6,200	20.5 4,035	17.0 3,346	12.0 2,362	7.4 1,457
max. production output	t/a	15,000 (with 7000 h and 80 % utilization)						
no. of wires		1						
max. inlet dia.	mm AWG	8.0 1						
for inlet strength	N/mm ²	250						
finished dia.	mm AWG	1.00 ... 3.56 18 ... 7 ½						
possible no. of drafts		11/13/15/16						
drawing capstan dia.	mm	4 x 355 and 4-10 x 224						
haul-off capstan dia.	mm	355						
drive technology		with quick drawing die change system						