

TRAMEV presents the new tube-drawing machine for stainless steel pipes.

The TTR-16 is the new tube-drawing machine by TRAMEV with horizontal axis capstan and motorized drawing box suitable for tube-drawing not only stainless steel but other steels as well, with a maximal pulling strength of 5000 Kg.



Technical characteristics:

- horizontal axis monoblock
- diameter of the pulling capstan: 900 mm
- axial dimension of the capstan: 1200 mm
- maximum pulling strength: 5000 kg
- maximum diameter of the pipe: 16 mm
- weight of the hasp to be uncoiled: 200 kg
- internal diameter of the hasp to be uncoiled: 600 mm
- external diameter of the hasp to be uncoiled: 1200 mm
- adjustable drawing speed: 0-10 MPM
- output of the main motor: 11 KW
- output of the die-stock movement motor: 1 KW
- output of the die lubrication motor: 0,75 KW
- dimensions of the die: "special"
- estimated weight of the monoblock: 5000 Kg average



Operating

On the external side of the capstan there is a ring on which there are the holes for hooking the wire stretcher when the monoblock is inserted. The tube-drawing starts then, on the external extremity of the capstan and continues with the synchronized movement of the die-stock with the capstan, toward the structure. At every turn of the capstan, the die-stock advances according to the value of the diameter of the material, plus a 10%, in a way that the coils can be wound without touching each other. During the process of tube-drawing, the lubricating exchange sends some lubricant at low pressure, in the contact area between the pipe and the die. Before going back to the lubricating exchange through the drain conduit, the lubricant, held by an overfall side, fills an area of the die-stock, in a way that laps totally the surface of the material to be drawn, assuring a perfect lubrication

During the process, the upper roll is not operating and is far from the capstan. When the drawing is almost done, with a manual or an automatic control, the roll goes down and presses on the coils to contain the elastic return when the pulling stops. The drawing speed is adjustable through a manual potentiometer and is detected through a speed detector; it can be modified constantly, according to the needs. Before starting to draw it is necessary to set the feeding pitch of the die-stock according to the final diameter of the material, modifying the parameters with the electric components, found on the control board. The insertion of the material into the machine is supported by the impulse operating of the monoblock through a pedal.

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