

SCHEDULE C - D-2000
 Automated REELEX coiling and boxing machine

REVISION:
 03/03/10

OPERATING SPECIFICATIONS

A. Controller

Microprocessor PC automatically controls coiling machine operations to wind REELEX coils.

Includes:

Two Speed Control Modes:

a. Constant RPM:

10 on screen presets available for constant spindle speeds from 75 RPM to 750 RPM with adjustable acceleration and deceleration. 10 presets for constant spindle speeds from 75 RPM to 750 RPM in 75 RPM increments with adjustable acceleration and deceleration. Line speed depends on the diameter of the coil. For an 8 inch (20.3 cm) mandrel at maximum speed, the line speeds for these coil diameters will be:

COIL DIAMETER INCHES (CM)	AVERAGE SPEED FPM (MPM)	OUTER LAYER FPM (MPM)
10 (25.4)	1760 (537)	1950 (594)
12 (30.5)	1950 (593)	2350 (718)
14 (35.6)	2160 (659)	2750 (837)
16 (40.6)	2350 (719)	3130 (955)
18 (45.7)	2550 (777)	3520 (1074)

b. Constant Line Speed:

10 presets available for constant line speed with adjustable acceleration and deceleration.

Length Control: On screen footage/meter counter display with three presets (slow down, stop and over length shutdown). Additional Inputs permit supply reel length and slow down point to establish the length of a production run. Sequential print modes are available, however printer speeds may limit output rate.

Coil Winding Control: Adjust payout hole size by degrees. Adjust spacing between crossovers (gain setting).

- Diagnostic Software:** Real-time displays and a supplemental program are available for troubleshooting and testing of all electronic and mechanical functions.
- Optional Controls:** 24 I/O's can be pre-programmed for additional optional stop, start, alarm or other control function desired.
- Power:** 230 Volt (+/- 10%), single phase, 60 Amperes, 50 or 60 Hz, (Optional: Three phase, 30 Amp or 380 - 415 VAC with neutral. A transformer may be required at additional cost.)

B. D-2000 Coiling and Packaging Machine

Maximum speed 750 RPM. Includes coiling and boxing sections. Dual-mandrels are mounted on a turret-style coiling head allows for one coil to be boxed and glued while one is being wound.

Includes:

- Motors:** One 5 HP (3.75 KW) DC, 1750 RPM spindle motor and one 2 HP (1.5 KW) DC, 1750 RPM traverse motor.
- Traverse:** 12 inch (30.5 cm) width.
- Mandrel/Endforms:** Standard 8 inch (20.3 cm) collapsible mandrel and 18 inch (45.7 cm) endform set. Can be ordered with 10 Inch (25.4 cm) mandrels with 21 Inch (53.3 cm) endforms. Diameter of endforms is the maximum coil diameter.
- Air requirement:** 70 PSI (483 Kpa) for automatic cutter and cross-over operations.
- Optional features:** Color. Please specify when ordering.
- Buffer:** Ring Sheave Buffer with 15-inch (380 mm) diameter Ring Sheaves.
- Anti-Reverse:** Automatic Anti Reverse AAR-1 mounted at output of buffer dancer.
- Safety Guarding:** Standard safety guarding included. Special Guarding available at additional cost.

PRICING

The D-2000 is currently only available for rent. Rental price includes coiling machine and controller.

- Rental Price:** US\$5,000 per Month