

SCHEDULE C - D-510
 Single Spindle REELEX Coiling Machine for Rewind Operation

REVISION:
 03/03/10

OPERATING SPECIFICATIONS

A. Controller

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

Includes:

Speed Control: 10 presets for constant spindle speeds from 50 RPM to 500 RPM in 50 RPM increments with adjustable acceleration and deceleration. Line speed depends on the diameter of the coil. For an 8" 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)	1175 (358)	1300 (396)
12 (30.5)	1300 (396)	1570 (479)
14 (35.6)	1440 (439)	1830 (558)
16 (40.6)	1570 (478)	2090 (637)
18 (45.7)	1700 (518)	2350 (716)

Length Control: Four digit footage/meter counter with two presets (slow down and stop).

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

Diagnostic Software: Four digit readout for trouble shooting and testing of all electronic and mechanical functions. Contains 24 programs that run all motors, energize all output relays and monitor all inputs.

Optional Controls: Twenty-four additional I/O ports available for customer specified controls.

Power: 230 Volt (+/- 10%,) single phase, 40 Amperes, 50/60 Hz.

B. D-510 Coiling Machine

Maximum speed 500 RPM. Single spindle with pneumatic endform removal.

Includes:

- Motors:** One 3 HP (2.25 Kw) DC, 1750 RPM spindle motor and one 2 HP (1.5 Kw) DC, 1750 RPM traverse motor.
- Traverse:** 6 in. (15 cm) to 12 in (30 cm) width.
- Mandrel/Endforms:** Standard 8 in (20.3 cm) collapsible mandrel and 18 in. (45.7 cm) endform set. Outer endform pneumatically removed (push-button controlled) when coil is completed. Other size mandrels and endforms available on special order or as auxiliary equipment. Changing of mandrel and endforms sizes is a very simple operation. Diameter of endforms is the maximum coil diameter.
- Air requirement:** 70 PSI (5 bar) for endform removal.
- Optional features:** Color. Spindle on left or right side of machine. Please specify when ordering.

PRICING

Base price includes coiling machine and controller.

Base Price: US\$54,180.00