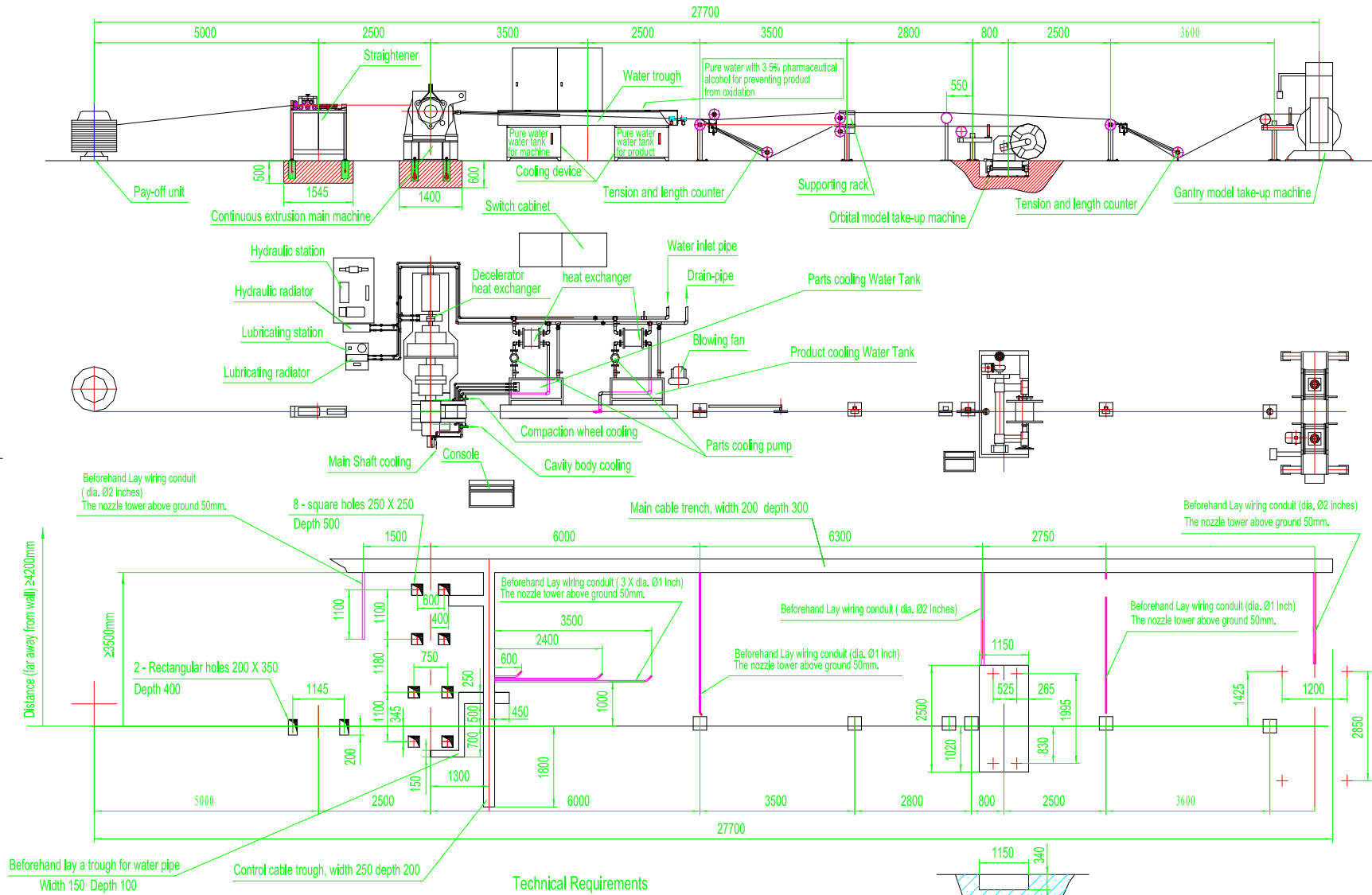


# Layout of TBJ300 continuous extrusion product line for flat copper wires and civil engineering drawing for mounting the machine

(Right hand)

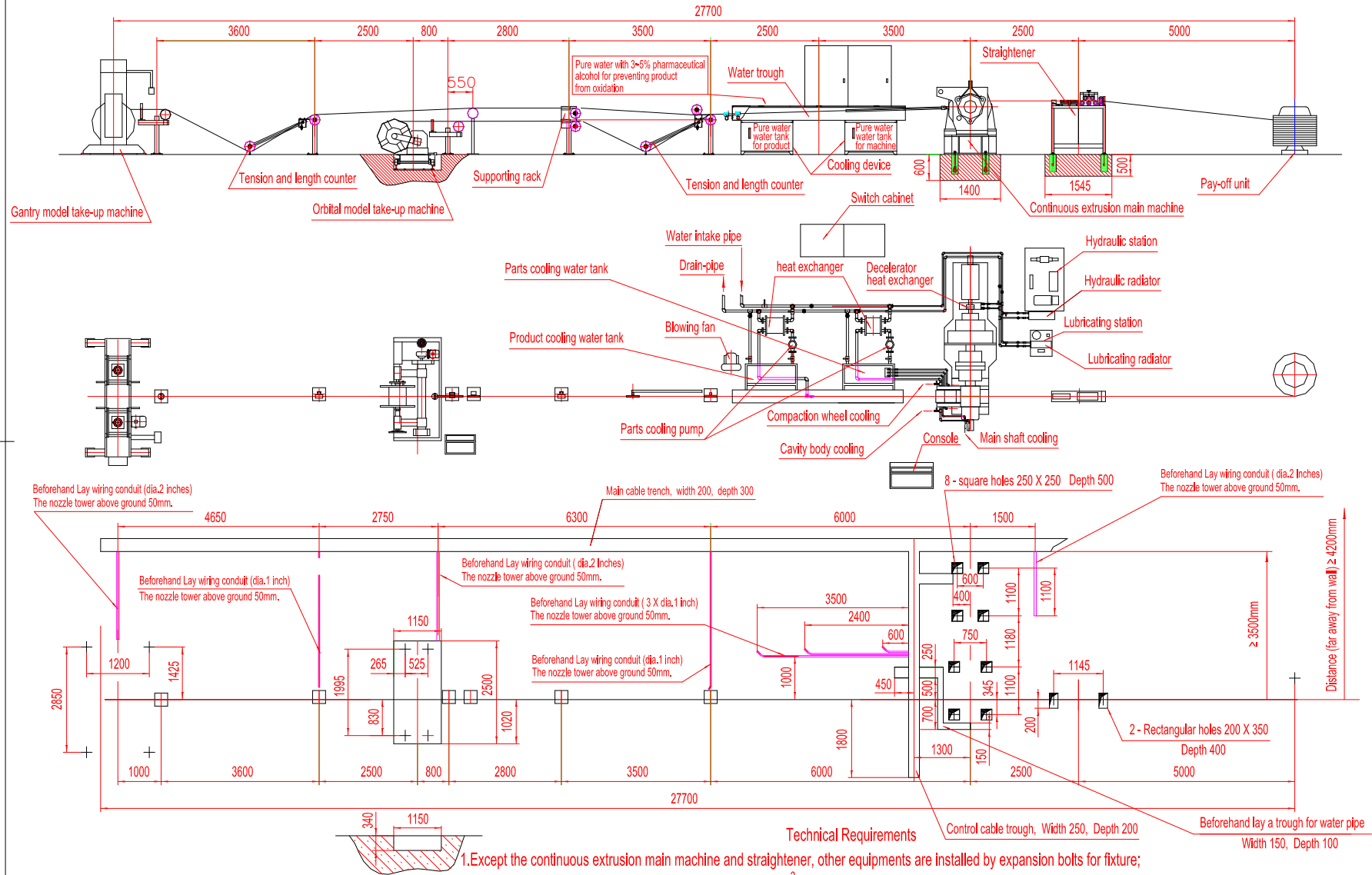


## Technical Requirements

- 1.Except the continuous extrusion main machine and straightener, other equipments are installed by expansion bolts for fixture;
- 2.The outer cooling water pressure  $\geq 0.2\text{MPa}$ , flowrate  $\geq 10\text{M}^3/\text{h}$
- 3.If the outer cooling water needs to be recycled for use, building a 30M<sup>3</sup> water tank, building a cooling water tower, and with a clear water pump of 12.5M<sup>3</sup>/h flowrate and 8m lift

# Layout of TBJ300 continuous extrusion product line for flat copper wires and civil engineering drawing for mounting the machine

(Left hand)



**(1) Technical parameters of TBJ300 copper extruder**

Model	TBJ300			
Extrusion wheel diameter	$\Phi 300$ mm			
Main motor power	90 kW			
Extruder Rev	4 ~ 12 rpm			
Feedstock material	Pure copper and copper alloy			
Feedstock diameter	$\Phi 10.00$ mm (for the production of all sizes in annex B) $\Phi 14.00$ mm (for the production of big sizes)			
Max. width of product	30 mm			
Thickness of product	1 ~ 8 mm			
Sectional area of Product	When feedstock is $\Phi 10.00$ mm, it is 5 ~ 100 mm <sup>2</sup> When feedstock is $\Phi 14.00$ mm, it is 10 ~ 150 mm <sup>2</sup>			
Production capacity	250 ~ 500 kg/h			
Scrap rate	1 ~ 3 %			
Take-up machine	Orbital model		Gantry model	
	Traverse range	Reel type	Traverse range	Reel type
	5 ~ 25	PN800	5 ~ 40	PN800~1000
Main parts consumption: easy wearing parts				
A) Die	Output of each wearing part			5 ~ 10 tons
B) The cavity body of die				30 ~ 50 tons
C) Extrusion wheel				100~200 tons

## (2) Application

For the production of flat copper strip, copper bus-bar, commutator connector, trolley contact wire and other solid copper conductor. Widely used in the area of transformer, bigger motor, switch, commutator manufacturing and the electrical railway transportation and civil train tracks.

## (3) Characteristics

- Feedstock can be pure copper and copper alloy
- Neither heating nor annealing process, saving energy
- One feedstock size, one process and one die for the product
- Smooth surface, no peel and small defect, high electrical and insulation property
- High and even quality product resulted by the hot deformation, solid dense and fine crystallization improving the property of the product
- The cooling process is treated in vacuum, no oxidation, the cooling water is common tap water, and the cooling water is circulation using, no any pollution (including environment pollution and product surface pollution)
- The product line can be used for the production on both flat aluminum wire and flat copper wire on the same machine, twin holes die, suitable for smallest strip production
- Saving site for equipment installation, saving energy, simple installation and building, higher usage factor, short cycle of production and manufacture, high availability for raw material, less processing loss and lower labor intensity.