



OBSA MTC INDUSTRIE SRL

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HS CODE 84794000

DOUBLE TWIST BUNCHER MACHINE

DT 630 / 800 / 1250



This double twist bunching machine is a highly productive machine used for the assembly of the following cables:

- Bare copper or aluminium conductors solid, stranded or bunch
- Insulated cables solid, stranded or bunch
- Kevlar fillers or similar

The cable or bunch assembly is done freely or according to a specific geometry if the cable construction permit it.

In order to offer our customers solutions that fit the majority of cable assembly configurations, we have developed a complete range of double twist bunching machines which can be completed with a wide range of accessories such as taping equipment applicator for aluminum, PP or other taping materials, and tension controlled pay-off stations.

Thanks to its clever design, our double twist bunching machine provides the best result for bunching copper cable, for twin or quad telephone assembly etc...

Here are some of the advantage of our machine:

- ◆ Lay length set trough operator panel, any value can be given, no gear change (except on DT1250)
- ◆ One driving reel capstan (except on DT1250)
- ◆ Software flange detection, adjustable from operator panel

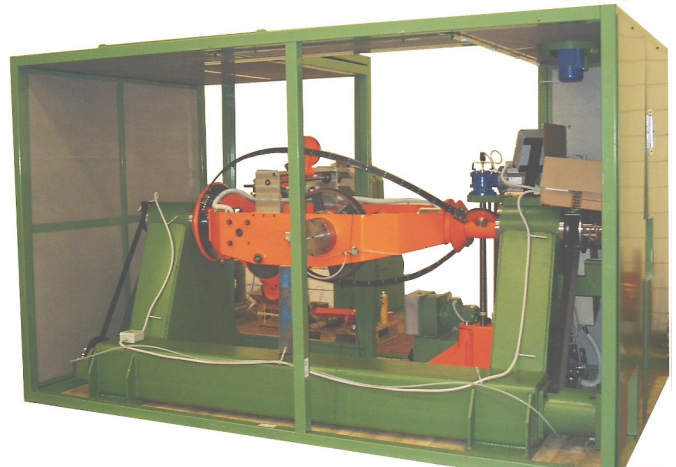
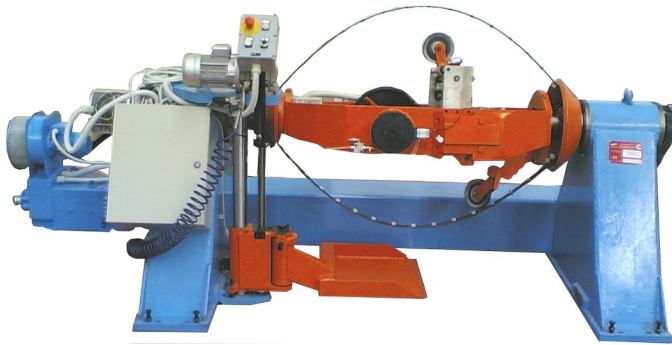
In addition, its versatility provides you with a production tool that can be adapted to a wide range of products and therefore generates flexibility and profitability of operation that not other machine can offer.



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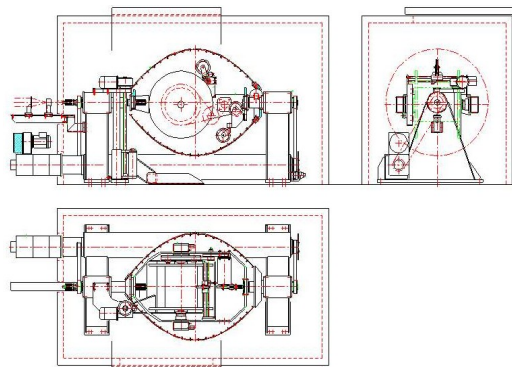
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TECHNICAL DATA:

TYPES	DT 630	DT 800	DT 1250
Maximum reel diameter (mm)	630	800	1250
Minimum reel diameter (mm)	400	630	1000
Maximum overall width (mm)	475	660	1000
Maximum reel bore diameter (mm)	80-127	80-127	127
Maximum reel weight (kg)	600	1000	3000
Maximum rotor speed (rpm)	3500	2500	1000
Maximum twist number	7000	5000	2000
Lay length (mm)	5 – 150	20 – 200	50 – 500
Maximum flexible cable diameter (mm)	4	6	20
Production speed max (m/min.)	900	1000	1000
Assembly direction	S - Z	S - Z	S – Z
Noise level (DbA)	72	72	72





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TECHNICAL DESCRIPTION

Assembling unit:

the assembling unit is composed of mechanical beam to hold the multi-holes discs and closing die holder.
This beam allow you to position all the different elements quickly, it is fitted with a quick lock/unlock system for all movable parts.
Included in the delivery are two discs for the wire distribution and closing die holder.
The dies are provided by the customer according to his production.

Body:

made out of electro welded steel, this allow a very solid and homogeneous structure of very good mechanical strength.

Bow assembly:

are mounted on two main shafts. On each shaft there are aluminium deviating wheels with ceramic treatment for the double twist assembly. Each of them is mounted on ball bearings to insure a minimum friction.

Bow support:

each bow assembly is supported on both side by high quality ball bearings type FAG or SKF.
The complete bow assembly is statically and dynamically balanced to the maximum rotational speed.

Bow:

Ceramic wire holder are placed all along the bow to hold the cable.
The bow made of carbon is aerodynamically shaped thus providing a very good air penetration factor.
To avoid further stretching of the cable along the bow, they are also equipped with a metallic plating.

Reel frame holder:

made of steel structure, it is supported on the main shafts by ball bearings.
Its construction permits the reel to remain stable during the production.

Reel fitting:

two pneumatic pintles are holding the reels.
Both pintles are moving, one is used to centre the reel in the frame, the second one to block it.
The spring locking device is guaranteed by both an electrical and pneumatic device.
Furthermore each pintle can move independently.

Reel driving system:

an independent motor is winding the product on the reel.
This motor is driven through an electronic regulation system that keeps the winding speed and the torque constant.
The reel angular speed is automatically adjusted to follow the filling on the reel.
The pulling force can be adjusted from the main control panel during the production by the operator.
The reel motor is driven by a 3 phases thyristors drive.

Traversing:

the traversing unit is composed of a flexion resistant wire guide mounted on a well dimensioned endless screw.
A gear-motor is driving this screw.
The traversing limits are set, and can be changed during production, from the control panel.

For DT1250:

two driven pulleys are placed on the reel frame holder acting as the capstan.
Thank to its perfect position, an excellent winding on the reel can be achieved.
On this machine a set of gear will allow you to change your lay length.

Loading platform:

an electric platform allows an easy handling of the reels.
It is located underneath the bow assembly, and fitted with limit switches.
The platform allows the start of the line only when it is in its low position

Protection cabin:

the protection cabin is build using soundproof material, equipped with windows and a secured access door.
An air fan is mounted in the frame to cool down the whole cabin.
A light is providing a clear view of the inside.



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Combined drive and control cabinet:

This cabinet contains all necessary element to perfectly drive this double twist line.

Synchronisation:

a Siemens PLC is used to synchronise and control all the parameters and following functions of the line:

Rotating signal (Master):

The bow angular speed is used as a master for the rest of the line.

The pre-set operating speed (reference value) is given to the PLC through the operating panel.

The rotating speed can be adjusted with push buttons.

The accelerating and decelerating ramps are generated by the PLC and are fixed.

A stop at pre defined length can be done thanks to a meter counter located at the entrance of the machine.

Traversing:

Synchronisation system with an electronic shaft linked to the reel angular speed.

The speed ration is set on the main operating board under the label: “traversing path” the correct functioning of the traversing system is checked by an encoder that gives the feedback to the electronic shaft.

Operator interface:

The on line operator interface permits to visualise in real time all the important machine parameters such as rotating speed, linear speed, cable length produced etc...

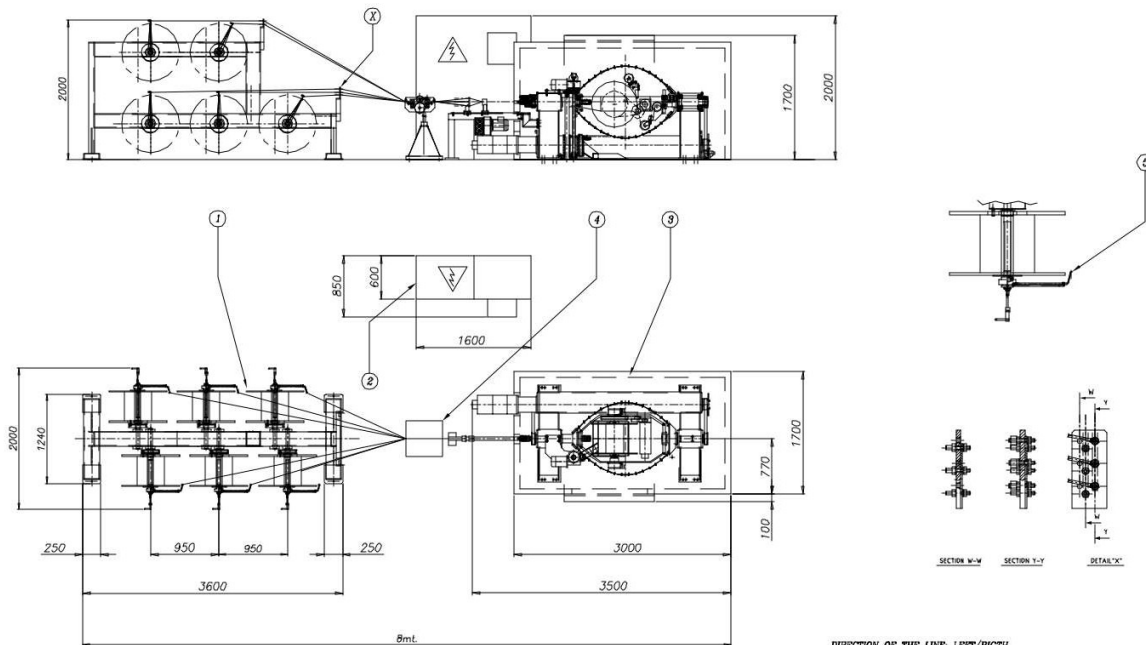
Using function keys, it is easy to access to the sub-menus which contain the machine parameters such as lay length, assembly direction etc...

Security:

all the rotating elements are permanently controlled to avoid all human or material damages.

All our machines are certified conform to the European Community norms.

All the necessary certificates are provided with the machine.



- ① Multi pay-off system with 10 positions for reels with Ø930mm.
- ② Electrical cabinet
- ③ Double twist buncher machine
- ④ Counting meters
- ⑤ Flyer
- ⑥ Breaking wire

DIRECTION OF THE LINE: LEFT/RIGHT
PULLING FORCE AT MAX SPEED: 0/500 N