

Specifications for the RMG In-Line Wire Processing Machines

All RMG variable frequency and hydraulic wire drawers are fully automatic throughout their complete speed range. AUTODRAW[®] automatically regulates drawing speed to match wire consumption rate

AUTODRAW[®]

Utilized with both variable frequency and hydraulic drives, AUTODRAW is the automatic speed control system for in-line wire drawing developed by RMG in 1982. AUTODRAW eliminates the necessity of precisely hand-regulating the capstan speed to the wire consumption rate of the production machine. Utilizing the AUTODRAW system, the capstan speed automatically matches the wire speed. All control functions are automatically executed starting and stopping whenever the production machine starts and stops.

RMG's Patented Wire Relaxer

The Wire Relaxer is a grooved, one-way clutched roller used to continually clamp the last loop of wire around the capstan. It keeps all the loops tightly wrapped around the capstan, and prevents the wire from springing away. Greater traction can be developed with a given capstan diameter. This allows heavier drafts or larger wire diameter to be drawn with little or no wire slippage. This feature also keeps the wire firmly in place while allowing safe removal of the gripper chain.

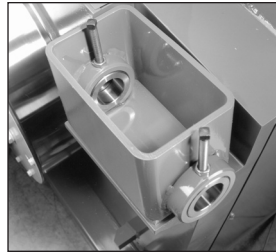
Machine Enclosures

Utilizing single side panels, as well as access doors when necessary, all RMG enclosures are easy to remove for periodic service. Smooth enamel finishes contribute to reduced housekeeping and maintenance expenses.



Draw Box

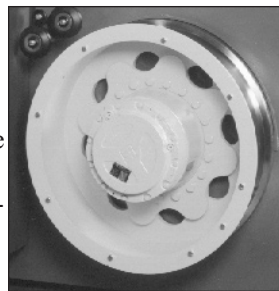
Large capacity powder box may be used for either wet or dry lubricants. On Models 12 through 910, the draw box is inclined to prevent spillage of liquid lubricants and is provided with a gasket for sealing the die end of the draw box. The



draw box is set up for 3" (75 mm) diameter die casings. Bushings are available for smaller dies. On the Model 1011 and larger machines, the draw box is horizontal and is equipped with a return port for circulating liquid lubrication systems. These larger models are set up with a 5" (125 mm) die pocket to accommodate larger dies and pressure holder die assemblies. All draw box entrances are set up to accept an old draw die as an entrance guide bushing. Additionally, all RMG draw boxes come with a clear plastic cover for housekeeping purposes.

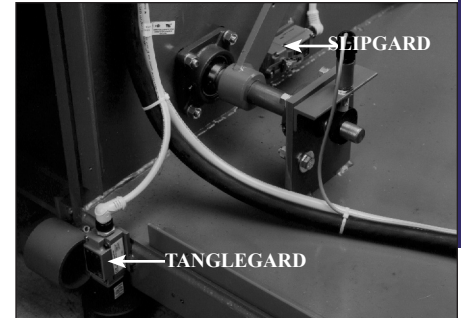
Capstan

RMG high quality polished capstans made from D2 tool steel, through-hardened to maximum hardness are the most reliable in the industry.



Gear Boxes

Extremely rugged high-torque gear boxes support and drive the capstan assemblies on all RMG machine models.



Electrical Interconnects

These three unique control features stop short feeds before they occur:

STARTGARD prevents starting of the production machine if the operator has forgotten to place the wire drawing machine in a *ready* condition.

SLIPGARD signals the production machine to stop if the capstan cannot produce wire as fast as required.

TANGLEGARD provides a signal to stop the production machine if a tangle develops on the uncoiling unit and the wire drawer moves.

Variable Frequency (VF) Drives

Variable frequency drive technology provides smooth, maintenance-free, fully-automatic speed control and is available on all RMG Wire Drawers.

Hydraulic Drives

RMG's fully-automatic hydraulic drives are designed and built by RMG and include many features normally associated with heavy-duty hydrostatic transmissions including forced-cooling, filtration, low fluid level protection, and dynamic braking. All low-maintenance RMG hydraulic drives have an infinite speed range from zero to maximum speed.

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Operating Controls

All RMG Wire Drawers are equipped with pushbutton controls and pneumatic regulators for ease of operation and adjustment. All controls are conveniently placed for easy access. Larger models are equipped with swing-arm pushbutton pendant.

Pneumatic Systems

The main components of an RMG pneumatic system include pneumatic cylinders, valves, solenoids and regulators.

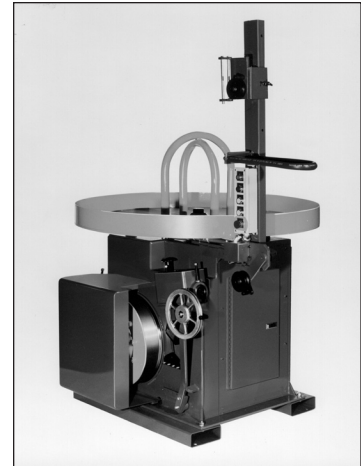
All cylinders used on RMG machines are provided with lifetime lubrication. Field lubrication is not required. Pneumatic cylinders are used to load the compensator arm and Wire Relaxer on any machine equipped with a 10hp (7.5 kW) or larger motor (smaller machines use springs for loading these devices). Wire relaxer pneumatic systems are designed to maintain pressure even when the air supply is shut off.

Standard pneumatic equipment includes an air filter, and each actuator is equipped with its own pressure gage.

**Spacesaver Configuration**

RMG Wire Drawer Models 12-89 are available in the Spacesaver configuration which provides an integral turntable either behind or on top of the machine, depending on space requirements.

All Spacesaver versions include the TANGLEGARD snag detection system.



RMG Model 34/45 Spacesaver



RMG Model 89 Spacesaver

**ROCKFORD MANUFACTURING GROUP INC.**

14343 INDUSTRIAL PARKWAY • SOUTH BELOIT, ILLINOIS 61080

PHONE 815.624.2500 • FAX 815.624.7254 • EMAIL: rmgfelm@rmgfelm.com • Website: www.rmgfelm.com