

RI

Continuous Inline Annealer Inductive and Conductive

With contactless energy transfer



NBM

NIEHOFF-BÜHLER GmbH
Ziehen · Walzen · Glühen



For combinations with rod break-down and drawing lines

- functional and simple design
- wire guidance with only two deflections (short circuit pulley and deflection pulley/pulley arc), one-directional for round wire
- few wearing parts
- wearing parts with long service life
- cold contacting of the wire twice on the short circuit pulley
- no additional drive necessary, wire driven short circuit and deflection pulleys
- excellent surface quality through application of medium-frequency voltage
- high energy efficiency (80....90%)
- flat and profile wire annealing possible
- good processing and forming properties of the fine-grained, globular structure after annealing process

Technical data

type	RI 120	RI 170	RI 250	RI 420	RI 560
material	<ul style="list-style-type: none"> ▪ Cu alloys (e.g. brass, tin bronze, German silver) ▪ low-alloyed Cu alloys (e.g. CuMg, CuBe, CuCr) ▪ heating and resistance wires (e.g. CuNi44Nm1, NiCr10, Ni) 				
max. production speed round wire* (m/s):	30 (5905 fpm)	40 (7874 fpm)	20 (3937 fpm)	20 (3937 fpm)	20 (3937 fpm)
min. round wire diameter (mm):	0.150 (34 ½ AWG)	0.300 (28 ½ AWG)	0.800 (20 AWG)	2.000 (12 AWG)	2.000 (12 AWG)
max. round wire diameter (mm):	0.300 (28 ½ AWG)	1.500 (14 ½ AWG)	2.200 (11 ½ AWG)	4.600 (5 AWG)	5.600 (3 ½ AWG)
max. production speed flat wire* (m/s):	15 (2953 fpm)	15 (2953 fpm)	15 (2953 fpm)	15 (2953 fpm)	
min. flat wire height (mm):	0.035	0.075	0.100	0.500	
max. flat wire height (mm):	0.200	0.900	2.00	3.600	
min. flat wire width (mm):	0.600	0.800	1.500	2.000	1.500 (15 ½ AWG)
max. flat wire width (mm):	10.000	20.000	24.000	32.000	25.000 (3 ½ AWG)
min. cross section (mm ²):	0.008 (38 AWG)	0.018 (34 ½ AWG)	0.126 (26 AWG)	1.500 (15 ½ AWG)	560
max. cross section (mm ²):	2.000 (14 AWG)	4.000 (11 AWG)	8.000 (8 AWG)	16.000 (5 AWG)	
short circuit pulley diameter (mm):	120	170	250	420	

*depending on material, cross section

(We reserve the right to modify technical specifications according to technical improvement and advances)

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