



## **Professional Grade 1+6(630F)+12(650B) Double Twist Bunching Machine with 2 Year Warranty!**

The quality of our **1+6(630F)+12(650B) Double Twist Bunching Machine** is second to none. Can do conductor stranding from 0.38mm<sup>2</sup> to 6.0mm<sup>2</sup>. products are widely used in **IT communications, aerospace, military, medical, locomotives, automobiles, robots, ships, 5G cloud databases and other fields.**

**1+6(630F)+12(650B) Double Twist Bunching Machine** apply for the bunching of aerospace, medical instrument, cellphone, notebook PC and ultra fine conductor (above seven pcs of alloy wires, tinned wires, silver jacketed wires and enamelled wires.

### **Merits:**

1. **1+6(630F)+12(650B) Double Twist Bunching Machine** is Our latest design to completely replaces 200 tubular stranding machine, mainly for BVR and high-temperature conductor wires (such as: 19/0.41, 19/0.52, 19/0.64) Stratified Stranding (according to customer needs S+S or S+Z ), since can do the 1+6 and (1+6)+12 at the same time, with large drum multi-wire pay-off, lower drum replacement frequency, reduced the cost, and improved the work efficiency. Capacity is 6 times of 200 tubular stranding machine, which saves 50% of electricity per hour. Meanwhile, it can be used for multiple purposes. The host of the high-speed stranding machine can be used for stranding multiple conductors separately, which is energy saving, small geographic location and low noise.

2. IoT(optional):**1+6(630F)+12(650B) Double Twist Bunching Machine** information of multiple devices can be integrated on multiple mobile phones or computers, and Monitor the machine status at real time, such as speed, stranding specifications, line speed, output, equipment maintenance, etc., and remote system do online Diagnosis, and maintenance, etc., to achieve refined management, reduce production and maintenance costs

3. Internal precision traverse(optional): **1+6(630F)+12(650B) Double Twist Bunching Machine** can use stepper motor + precision ball screw traverse, internal and external PLC data sharing through wireless communication module, collection of wiring data and take-up shaft speed, through PLC precise calculation, guarantee The wiring accuracy, and the wiring width and row spacing are set on the touch screen at real time, no need to stop adjustment, reduce downtime and improve production efficiency.



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**4. Range:**

**1+6(630F)+12(650B) Double Twist Bunching Machine** for 2.5mm<sup>2</sup> - 6.0mm<sup>2</sup>  
(please refer to Page 6-16)

**1+6(630F)+12(650B) Double Twist Bunching Machine** with 400 static pay-off  
for 2.5mm<sup>2</sup> - 6.0mm<sup>2</sup> (please refer to Page 17-18)



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This **1+6(630F)+12(650B) Double Twist Bunching Machine** is CE approved



5. Can fit 380V to 440V, 50HZ to 60HZ, color can be customize

3 phase 4 wires, R, S, T, PEN

3 phase 5 wires, R, S, T, PE, N

6. **Some option:**

**Set-up:**

China standard: Veinview HMI + Inovance PLC & Invertor + Siemens Motor

Siemens standard: Siemens HMI & PLC & Invertor + Siemens Motor



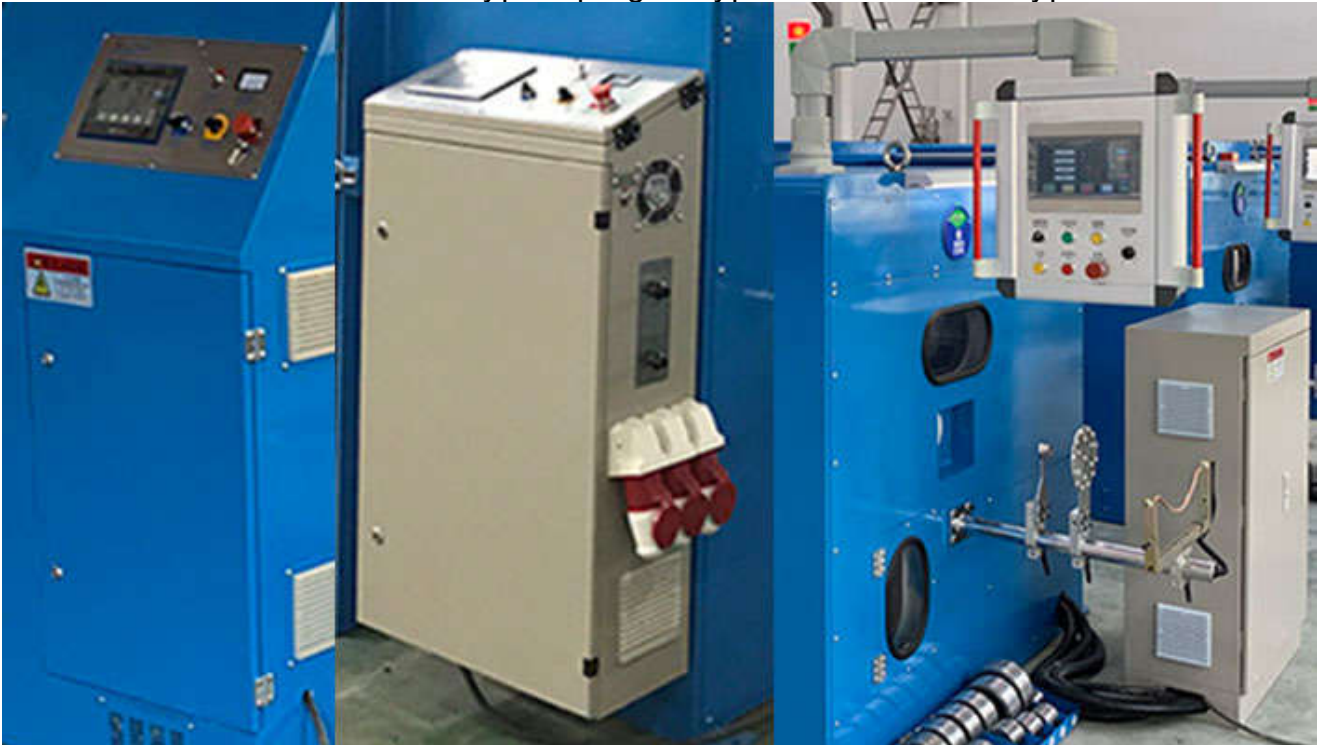


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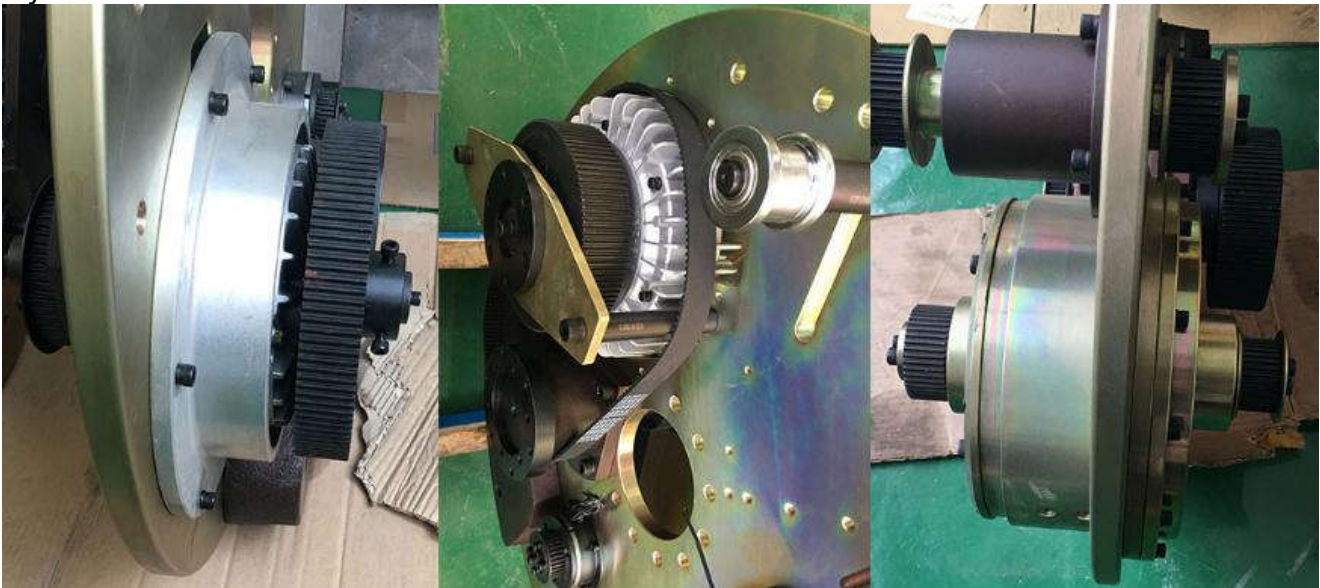
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**Power Cabinet:** Embedded type / plug in type / Stand alone type



**Take-up tension type:** Magnetic powder clutch / Hollow shaft clutch / Hysteresis clutch





**IOT remote system and temperature sensor**



状态	名称	数值	地址	寄存器	描述	操作
<input type="checkbox"/>	主机转数		VD 1060	VD	主机转数	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	当前米数		VD 330	VD	当前米数	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	当前张力		VW 5000	VW	当前张力	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	当前线速		VD 1190	VD	当前线速	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	节距设定		VD 170	VD	节距设定	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	设置米数		VD 740	VD	设置米数	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	设定张力		VW 360	VW	设定张力	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	排程设定		VW 1420	VW	排程设定	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	左轴1#温度		VD 3230	VD	左轴1#温度	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	左轴2#温度		VD 3250	VD	左轴2#温度	<a href="#">↕</a> <a href="#">🗑</a>
<input type="checkbox"/>	右轴3#温度		VD 3270	VD	右轴3#温度	<a href="#">↕</a> <a href="#">🗑</a>

**Trade terms: T/T,L/C**

**Package:**

- 1) Simple water-prof package
- 2) Pallet package
- 3) Pallet with Vacuum package
- 4) Wooden box package





## **1+6(630F)+12(650B) Double Twist Bunching Machine Specification**

### **1+6(630F) Technical specification**

#### **➤ Merits:**

1. Latest High-Tech products, completely replace the 200 tube bunching machine, especially for the production of 1 +6 +12 regular twisted products, 4.5 times capacity than tubal buncher, while energy-saving, smaller size and lower noise.
2. Brake: electromagnetic brake.
3. The internal pay-off tension is controlled by the belt tension.
4. Wiring system: with the latest structure, the conductor from the spool directly through the wire roller to the bow, The bow material with SK5 material, Using a unique semi-circular groove design, with semi-circular porcelain eyes to through the wire, to avoid twist scratches, jumping phenomenon while high-speed rotation wind resistance
5. Spindle lubrication: automatic lubrication(PLC programmer control the lubrication).
6. Security protection: If the door contact is not in place, internal and external wire broken error display in the touch screen with automatic alarm or can not start to work
7. Spindle and rotation arm: With high-speed dynamic balance processing; rotating part and separated from the cover, the noise is less than 75 dB.
8. Electrical control: user-friendly touch screen interface, control by the PLC programmer + inverter.
9. Flyer Bow use Imported SK5 material.
10. Transmission system: drive with synchronous belts, laying accurate, no internal lubrication position, no waste products effect by refueling and machine cleaning
11. Change the lay length: Cooperate with the host, with continuously variable transmission, easy to achieve customers' requirement of lay length.
12. Meter mode: the use of encoder and host synchronization meter.
13. The machine should be used with our 650B double twist bunching machine to complete the 1 +6 +12 one pass twist effect.

#### **➤ (stepless Speed lay length change) Main performance parameters:**

1. Application: conductors 1 +6 +12 regular twisting
2. Conductor diameter range:  $\varphi 0.41 \sim \varphi 0.64\text{mm}$
3. 1 + 6 Stranded outside diameter range:  $\varphi 0.1.23 \sim \varphi 1.92\text{mm}$
4. Spool size: PND630 Spool ( $\varphi 630\text{mm} \times \varphi 127\text{mm} \times 475\text{mm}$ )
5. Twist Maximum speed: 2200RPM
6. Tension: dancer (By displacement sensor) send the signal to inverter and control the motor speed, when link to the host, can keep the pay-off tension stable and uniform.
7. 1 +6 strands lay length: Link to the host, with infinitely variable speed to change the twisted pitch



8. Main motor: 15KW AC motor inner pay-off motor: 1.1KW
9. Loading capacity: about 500Kg per spool
10. Twist direction: Change motor running direction to change the twist direction
11. Brake: use electromagnetic brakes, can automatic braking when internal and external wire cut off and reach meters
12. Machine drive bearings: Main spindle with Sweden SKF bearings , the others with Japan NSK bearings
13. Timing belt: import from US GATES
14. Spool Loading: Electric lift
15. Spindle lubrication: butter lubrication
16. Noise index: less than 80 dB
17. Dimension/MM: (Length×width×height): 3700 × 1750 × 1900
18. Weight: 2500 Kg
19. Coating: RAL 5105 Sky Blue(Or customize)
20. Packing: waterproof simple packaging
21. Direction: from right to left, i.e, facing to the operate panel ,pay-off on the right (or customize)
22. Door seal: plastic seal
23. Spindle bearing Seal: Mechanical oil retaining ring
24. Sliding doors

### ➤ **Mechanical Performance**

#### 1. Body structure:

- (1) Material: low carbon steel welded together.
- (2) Structure: the body by annealing and aging, to eliminate internal stress, and then boring by a precision boring machine to forming a molding.

#### 2. Bunching Entry part:

- (1) Bunching Entry position: facing to the front door, at the right side of the machine (can be customization according to customer requirements to change to the left side).
- (2) Bunching Entry Mode : from the pay-off device through the disconnection sensing area, first to the total sub-line board (sub-hole by 1 +6 distribution), through first pressure mold, then entering the right spindle within the wire guide wheel. From the Cantilever arm and bow's porcelain ring to the left spindle within the wire guide wheel, and then through the center corner's guide wheel to the Left spindle, then through the corner guide wheel to the second bunching machine, to achieve 1+6+12 twisting

#### 3. Spindle:

- (1) Material: 40Cr steel forging after quenching and tempering treatment.
- (2) Accuracy: The shaft core outer face diameter and the bearing end face are ground to ensure concentricity and verticality with the axis.
- (3) Dynamic balance: Standard of G2.5

#### 4. Rotation arm:

- (1) Material: 45 # steel quenched and tempered
- (2) Accuracy: All end faces are positioned relative to the locating holes



(3)Dynamic balance: Accuracy of G2.5

5.Flyer Bow

(1)Material: SK5 Material.

(2)Shape: special appearance, reduce the wind resistance.Light weight.

(3)Weight tolerance : less than 0.03 grams per pair

6.Transmission part: with high quality timing belt drive, laying length accurate

7.Wire entry wheel:

(1).Material: # 45 steel finished with heat treatment HRC30-40.

(2)Hard chrome plated on the surface, not easy to wear

8.Spindle housing:

(1)Material: Alloy cast iron.

(2)Processing: CNC machine tooling

(3)Accuracy: one processing hole end molding, to ensure concentricity.

9.Spindle bearing lubrication system:

(1)Lubrication method: Butter sealed lubrication, automatic refueling.

(2)Butter Model: Mobil Lux EP1 #

(3)Sealing method: mechanical oil retaining ring, to prevent butter exudation,keep the machine clean inside

10.Pay-off

Outer Dia (φD)	Hole (φd)	Outer Width (L1)	Inner Width (L2)	Fasten Hole	PCD
630	127	475	400	φ28	200

(The above specifications are factory standard )

11.Dynamic power : 7KW

12.Installed power : 15KW

➤ **Detail specifications:**

Description	Model	Origin
1.Host Motor	15KW 380V 50Hz	SFC
2.Inverter	18.5KW	INOVANCE
3.Inner Pay-off Motor	1.1KW-6P	SFC
4.Inner Pay-off Invertor	1.5KW	INOVANCE
5.PLC Expander		INOVANCE
6.Electromagnetic Brake	24KG	Taiwan
7.Spindle Bearings	1SET	SWEDEN SKF
8. Other Bearings	1SET	JAPAN NSK
9.Timing Belt	1SET	
10.Flyer Bow	1SET	Japan SK5 material
11.Half porcelain eye	1SET	Taiwan
12. Body	1SET	Self-processing
13. Spindle	2pcs	Self-processing
14. Rotation Arm	2pcs	Self-processing
15. Timing Pulley	1SET	Wu Xi
16. Bearing Housings	1SET	Self-processing



17. cradle	1pcs	Self-processing
18. Transmission Shaft	1pcs	Subcontracting
19. Wiring wheel	3pcs	Self-processing surface with hard chrome plating
20. Electrical Lift	1SET	Self-processing

## 12(650B) Double Twist Bunching Machine

### ➤ Merits:

1. High speed, good stability (the motor through the rigid coupling directly connected with the drive shaft)
2. Automatic tension control: When stranding, the reel take-up from the empty to the full , the tension must be increased (With the touch screen Free Set the data) The machine can automatically adjust the tension smoothly, keep the tension uniform variation ,Can achieve tension setting while working .
3. Over-line system: The latest structure, the wire from the spindle directly across the guide wheel to the bow belt, the bow (with) a unique semi-circular groove design, with the bow with a semicircle porcelain ring line to avoid high-speed operation due to wind resistance Caused by stranding scratch, jump shares phenomenon
4. Spindle lubrication: grease lubrication (Automatic lubrication)
5. Security protection: If the door contact is not in place, lift contact is not in place, internal and external wire cut off , the error display in the touch screen with automatic alarm or can not start to work
6. Spindle and aluminum disc finish: after high-speed dynamic balance processing; noise less than 80 decibels
7. Electrical control: user-friendly touch screen interface operation, control by the PLC programmer + inverter
8. Bow use Japan imported SK5, finished with heat treatment, the surface of hard chrome
9. Transmission system: drive with synchronous belts , laying accurate, no internal lubrication position, no waste products effect by refueling and machine cleaning
10. Change the lay length: easy to operate, just change the leading wheel according to the lay length sheet

### ➤ main performance parameters

1. Application: bare wire, tinned wire, copper clad aluminum, enameled wire, alloy wire and etc. 1 + 6 can replace twisting with stranding
2. Conductor diameter range:  $\phi 0.20 \sim \phi 0.70\text{mm}$
3. Twisted wire diameter range:  $\phi 1.0 \sim \phi 3.5\text{mm}$
4. Stranded cross-sectional area:  $0.6 \sim 6\text{mm}^2$
5. Spool specifications: PND630
6. Max speed : 1800RPM; (and 1350 RPM on-line with 1 + 6 (630F) bunching ); normal work up to 1800 RPM for stranding 7pcs conductors
7. Traverse:  $\phi 30\text{mm}$  polish rod bearing type ,traverse width and row space can



be accurately adjusted

8. Strand lay length: 11.6 ~ 100mm
9. Main motor: 7.5KW AC motor + inverter
10. Assembly volume: about 500Kg
11. Twisted direction: Free to change S and Z direction, pull the switch bar to change the direction, easy to operate
12. Brake: With electromagnetic brakes, can achieve automatic braking when internal /external wire cut off , and reach meters
13. Tension control: magnetic powder clutch control take-up tension, by the PLC program controller automatically adjust the tension value, keep the tension constant
14. Machine drive bearings: main shaft with Sweden SKF bearings , the others are Japan NSK bearings
15. Timing belt: high quality product
16. Spool loading : electric pump hydraulic lifting
17. Spindle lubrication: automatic lubrication ( Controlled by PLC )
18. Noise index: less than 80dB
19. Dimension (mm): 3300L × 1550W × 1800H
20. Weight: 4500 Kg
21. Painting: RAL5015 Sky blue (or customize)
22. Packing: waterproof simple packaging
23. Direction: left hand machine, i.e, facing to the front door, pay-off on the right (can be customization according to customer requirements)
24. Door seal: plastic seal
25. Spindle bearing Seal: Mechanical oil retaining ring

### ➤ **Mechanical Performance**

1. Body structure:

1-1. Material: low carbon steel welded together.

1-2. Structure: the body by annealing and aging, to eliminate internal stress, and then boring by a precision boring machine to forming a molding.

2. Bunching Entry part:

2-1. Bunching Entry position: facing to the front door, at the right side of the machine (can be customization according to customer requirements to change to the left side).

2-2. Bunching Entry Mode : from the pay-off device through the disconnection sensing area, first to the total sub-line board (sub-hole by 1 +6 +12 + ... distribution), through first pressure mold, then the second Pressure mold, after entering the right spindle within the wire guide wheel. From the aluminum arch with porcelain ring and then into the left spindle within the wire guide wheel, and then through the center corner's guide wheel to the leading wheel, Final to the aligner's guide wheel to cable laying

3. Spindle:

3-1. Material: 40Cr steel forging after quenching and tempering treatment.

3-2. Accuracy: The shaft core outer face diameter and the bearing end face are



ground to ensure concentricity and verticality with the axis.

3-3.Dynamic balance: Standard of G2.5

4.Aluminum disc

4-1.Material: ZL104

4-2.Accuracy: All end faces are positioned relative to the locating holes

4-3.Dynamic balance: Accuracy of G2.5

5.Flyer Bow

5-1.Material: Japan imported SK5.

5-2.Shape: special appearance, reduce the wind resistance.

5-3. Weight tolerance : less than 0.03 grams per pair

6.Transmission part: with imported synchronous belt drive, laying length accurate

7.Wire entry wheel:

7-1.Material: # 45 steel finished with heat treatment HRC30-40.

7-2.Hard chrome plated on the surface, not easy to wear

8.Spindle housing:

8-1.Material: ductile iron QT42-10.

8-2.Processing: CNC machine tooling

8-3.Accuracy: one processing hole end molding, to ensure concentricity.

9.Spindle bearing lubrication system:

9-1.Lubrication method: butter lubrication(Automatic refueling device)

9-2.Butter Model: Lubricants Mobil lux EP1 #

9-3.Sealing method: mechanical oil retaining ring, keep the machine clean inside

10.Take up tension control: through the magnetic clutch control thread tension, by the PLC program controller automatically adjust the tension, keep tension constant

11.Traverse:.Special two-way cable laying device, φ30mm polish rod bearing type, traverse width and row space can be accurately adjusted

12.Pool Size :

Out Dia (φD)	Fix Hole (φd)	Outer Length (L1)	Inner Length (L2)	Position Hole	PCD
630	125	475	400	φ28	200

13.Dynamic power : 3.5KW

14.Installed power : 7.5KW

➤ **Detail specification:**

Description	Model	Origin
1.Host Motor	7.5KW-4P 380V 50Hz	SIEMENS
2.Inverter	7.5KW	INOVANCE
3.PLC Programmer	1SET	INOVANCE
4.PLC Expander	1SET	INOVANCE
5.Touch Screen	7 inches RGB	WEINVIEW
6.Electromagnetic Brake	24KG	TAIWAN



7.Magnetic Clutch	5KG	TAIWAN
8.Spindle Bearings	1SET	SWEDEN SKF
Other Bearings	1SET	JAPAN NSK
9.Timing Belt	1SET	
10.Cable Laying Device	GP30(Special bi-direction)	SHANXI
11.Electric hydraulic pump	1SET	TAIWAN
12.Tension Module	10V	TAIWAN
13.Bow	SK5	Japan
14.Round Porcelain Rings	1SET	Guang Dong
15. Body	1SET	Self-processing
16. Spindle	2pcs	Self-processing
17. Aluminum Plate	2pcs	Self-processing
18. Timing Pulley	1SET	Wu Xi
19. Bearing Housings	1SET	Self-processing
20. Disc	2pcs	Self-processing
21. Transmission Shaft	1pcs	Subcontracting
22. Leading Wheel	1SET	Self-processing with hard chrome plating
23. Wiring wheel	6pcs	Self-processing with hard chrome plating

➤ **630 dual shaft-less multi-wire active pay-off** :

a constant tension control and no twisting double spool pay-off, can be used for single-wire or twisted wire pay-off, no interfere with each other, independent release, easy to operate, and saving space.

1. wire diameter range:  $\phi 0.15-\phi 0.64\text{mm}$ ;
2. Speed: MAX 200m/min;
3. Spool Size: OD $\phi 630$  \* ID $\phi 125$  \* Outer Width 475 \* Inner width 400mm;
4. Tension control: In the pendulum mounted on the cylinder, through the regulator to adjust the pressure of the cylinder to change the pay-off tension, can also use the hammer to adjust the tension;
5. Drive: reel by the brake with 1.5KW three-phase Special motor + timing belt + inverter control;
6. Brake: the disc spring brake inside the motor control the motor stop;
7. Speed control: by the sensor to send pendulum signal to the inverter, control the pay-off speed and the host (such as stranding machine) to maintain synchronization;
8. Spool handling: With hydraulic fork lift (customer-owned) manual loading and unloading reel;
9. Painting: RAL5015 sky blue (according to the customer to provide color plate)
10. Weight: 600kg

**Main configuration**

No.	Description	Model	Brand	Remark
1	Inverter	1.5KW	Yaskawa	
2	Motor	1.5KW-6P Frequency	SFC/DANMA	
3	Bearing		NSK	
4	Motion detector	SYL18	FOTEK	
5	Precision regulating valve	IR2020-02	SNS	
6	Stainless steel cylinder	MA25*300	SNS	

**➤ Spare Part List**

No.	Description	Model	Qty	Remark
1	Spindle guide wheel	(with bearings)	1set	For 650B
2	Spindle guide wheel	(with bearings)	1set	For 630F(1+6)
3	Wire guide wheel	(with bearings)	1set	For 650B
4	Wire guide wheel	(with bearings)	1set	For 630F(1+6)
5	Loop in bow	Tungsten steel ring	3pcs	For 650B
6	Loop in SK5 Flyer bow	Half porcelain ring	3pcs	For 630F(1+6)
7	porcelain ring in Split plate		3pcs	For 650B
8	guide wheel for split plate		1pcs	For 630F(1+6)
9	Pusher hook	R03-022-B	3pcs	For pay-off
10	standing die		Pcs	19/0.41 19/0.52 19/0.64
11-13	Timing belt		1pcs	
14	Top shaft sleeve	According to reel drawings	1set	
15	Tool	With hex wrench, open wrench, etc	1set	
16	Operating instructions		1set	
17	Electrical schematics		1set	
18	Manual Lift		1set	
19	Sub-line guide wheel		2pcs	
20	Inverter manual		1set	



序号 Serial No.	绞距轮底径 Bottom Dia of Pitch Wheel	A传动绞距 A Drive Pitch	B传动绞距 B Drive Pitch
1	∅54.8	11.6	34.6
2	∅60.3	12.8	38.1
3	∅65.8	13.9	41.5
4	∅71.3	15.1	45.0
5	∅76.8	16.3	48.5
6	∅82.3	17.4	51.9
7	∅85.6	18.1	54.0
8	∅87.8	18.6	55.4
9	∅93.3	19.8	58.8
10	∅98.8	20.9	62.3
11	∅104.2	22.1	65.8
12	∅109.7	23.2	69.2
13	∅115.2	24.4	72.7
14	∅120.7	25.6	76.1
15	∅126.2	26.7	79.6
16	∅141.8	30.0	89.5
17	∅157.0	33.2	100

Theoretical production capacity, for reference only (Not including the replace spool time, the capacity may be different according to the actual production lay length )

Specification	19/0.41		19/0.52		19/0.64	
Host speed RPM	1350	1500	1250	1350	1150	1200
1+12 pitch	45	48	58.8	62	72	70
1+6 pitch	80	25	90	35	110	40
Twist Direction	Z+S /S+Z	Z+Z/ S+S	Z+S /S+Z	Z+Z/ S+S	Z+S /S+Z	Z+Z/ S+S
1 Hour Capacity kg/h	162	192	313	358	537	545
24 Hours Capacity kg/h	3880	4600	7550	8600	12888	13075



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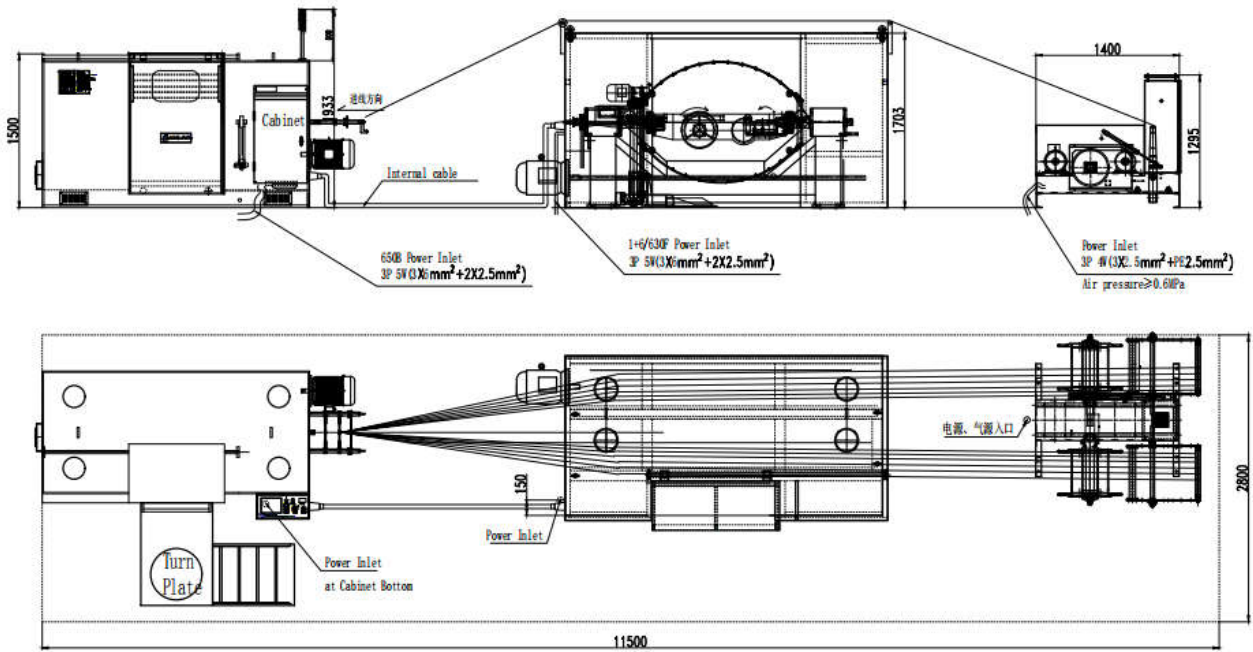
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650B Double Twist  
(PND 630 Spool)

1+6/630F Double Twist  
(PND PND630 Spool)

630 pay-off  
(PND630 Spool)

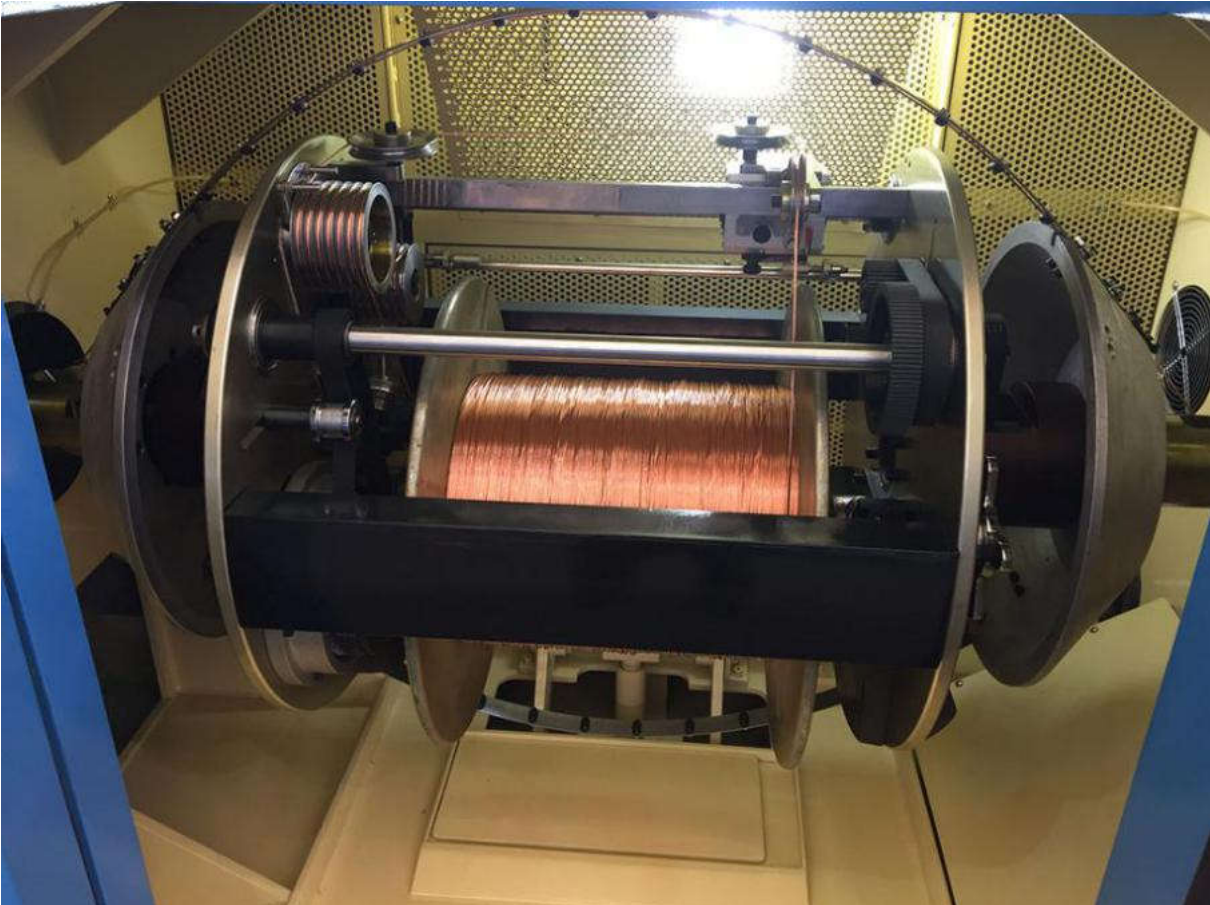
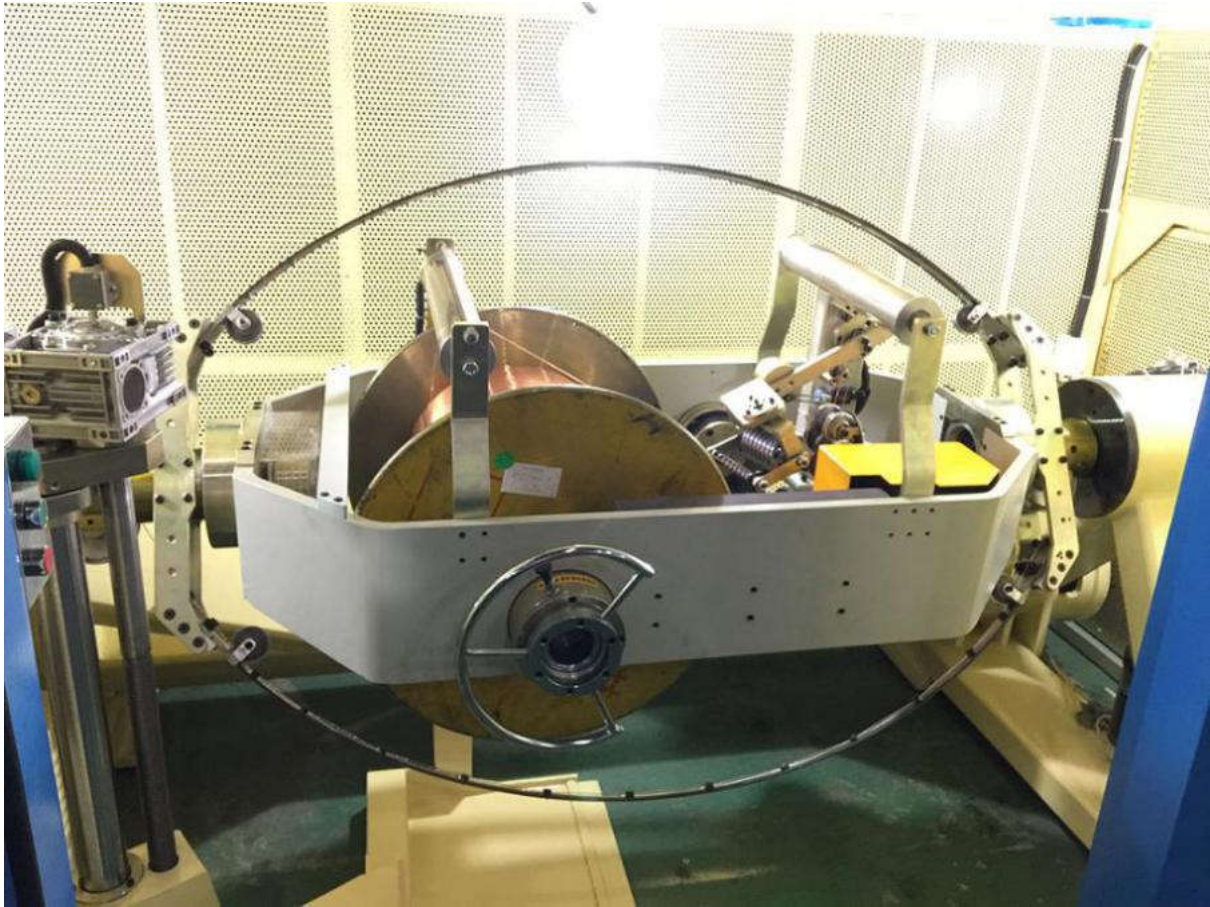


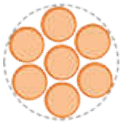


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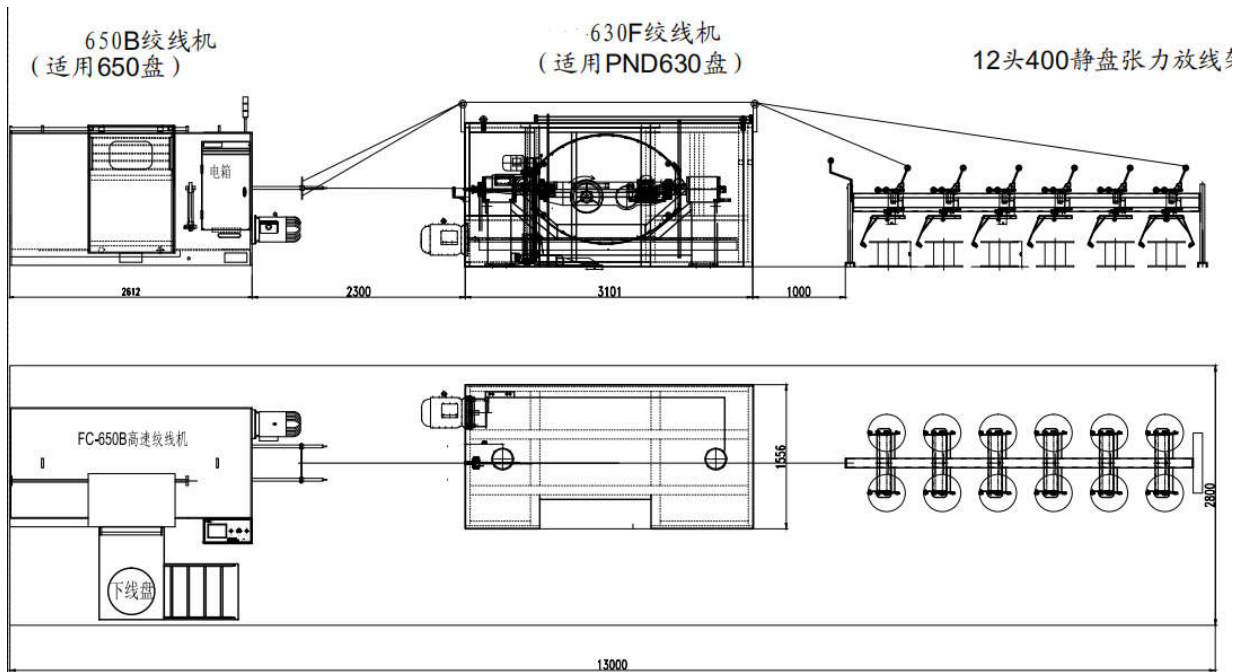
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➤ **400 static spool tension pay-off**

1. wire diameter :  $\phi 0.41 - \phi 0.64$ ,
2. Spool size:  $\phi 400 * 300 * \phi 125$
3. Head No.: 12 Head/ 1 set , 7 head/ 1 set.
4. Tension control: improved double reed tension gun control, keep tension constant, with 1006 combination guide wheel.
5. Brake: bevel gear, control with broken belt to achieve automatic brake





➤ **630 Rewinding**

1. Apply for: mutli wire rewinding
2. Spool : PND630
3. Wire range: 0.15-0.68mm
4. Speed: max 250m/min
5. Take-up motor: YLJ132-40-6;
6. Brake: 24KGF Electrical brake ( Tai Wan SHRY YIH )
7. Rewinding rod:GP 30(Shan Xi Dian Tou)
8. Spool fasten: Pneumatic
9. Spool lift: none
10. Bearings: NSK
11. Electrical meter counter

7头500静盘张力放线架

630并丝收线机

