



Professional Grade 800B Double Twist Bunching Machine with 2 Year Warranty!

The quality of our **800B Double Twist Bunching Machine** is second to none. Can do conductor stranding from 1.0mm² to 16.0mm². products are widely used in **IT communications, aerospace, military, medical, locomotives, automobiles, robots, ships, 5G cloud databases and other fields.**

800B 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. **800B Double Twist Bunching Machine** is High speed, constant tension from empty reel to full reel, excellent quality of stranded wire, which can be used for stranding instead of stranding to meet customer's requirements for stranding of small cross-sectional area. The whole machine is driven by a synchronous belt, and only the take-up wheel needs to be replaced when changing the lay length, easy to use

2. IoT (optional): **800B Double Twist Bunching Machine** information of multiple devices can be integrated on multiple mobile phones or computers, and the operation of the machine can be checked at any time, such as speed, stranding specifications, line speed, output, equipment maintenance, etc., and can be online at the same time Diagnosis and remote maintenance, etc., to achieve refined management and reduce production and maintenance costs.



This 800B Double Twist Bunching Machine is CE approved



3. 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

4. Type:

800B Double Twist Bunching Machine apply for single wire 0.2-1.7mm stranding, cross section 1.0-16.0mm², pitch range 23-160mm (please refer to page 6-12)

800B Double Twist Bunching Machine apply for single wire 0.2-1.7mm stranding, cross section 1.0-16.0mm², pitch range 23-160mm (please refer to page 13-19)



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5. Some option:

Set-up:

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

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



Spindle lubrication: manual lubrication / PLC lubricator





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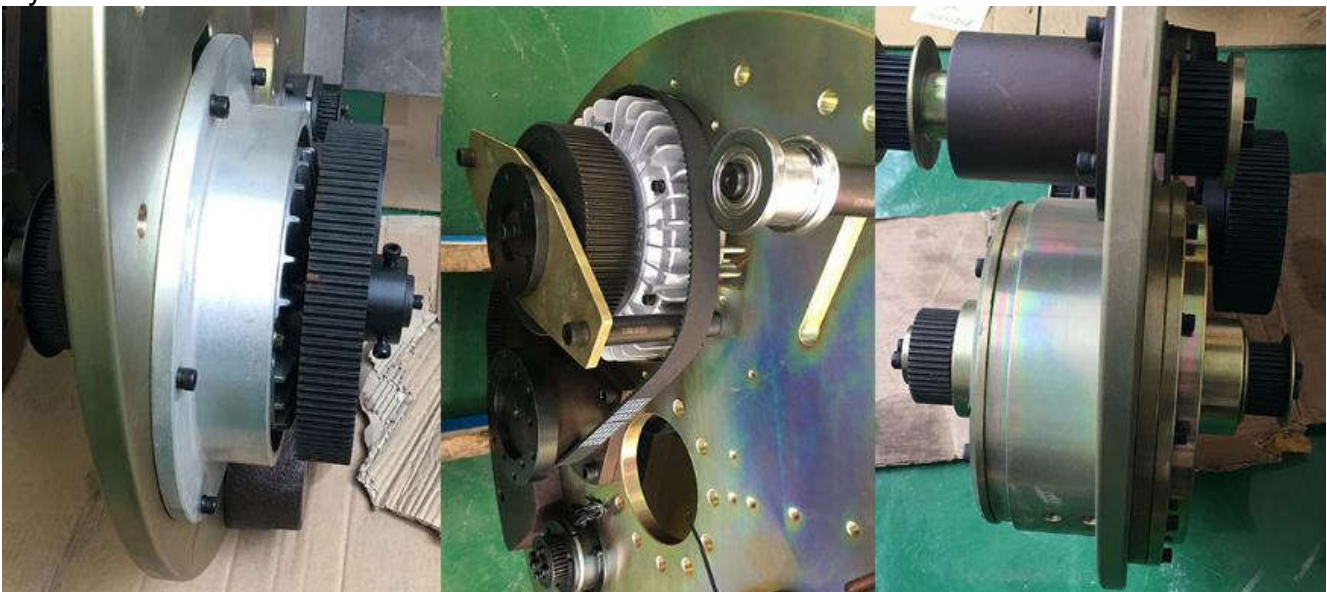
Power Cabinet: Embedded type / plug in type / Stand alone type / Synoptic panel type



Spool Lift: manual hydraulic pump / electrical hydraulic pump / electrical screw rod



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





IOT remote system and temperature sensor



Pay terms: T/T, L/C.

Package:

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





800B Double Twist Bunching Machine Specification

➤ **Merits:**

- 1.High rotation speed and high stability(motor is connected with transmission shaft directly by butt-muff coupling).
- 2.Automatic tension control:When stranding, the tension of the take-up reel needs to be continuously increased when the take-up reel is moved from the chassis to the full reel. (Data set by the touch screen) this machine can automatically track and adjust the take-up tension to make the entire reel of take-up tension even and consistent. Can adjust the tension without stopping the machine (on the touch screen)
- 3.Adopt advanced wire guiding device, bow belt adopt unique half slot design, match up with semicircle ceramic ring to wire guiding, lead wire guiding to bow belt directly from spindle idler pulley to avoid the wire scratch, core mess while high running because of wind drag.
- 4.Way of spindle lubrication: grease lubrication, (automatic lubricator is controlled by the PLC programmer to avoid the lack of oil and damage to the main shaft bearing caused by human factors without regular refueling.)
- 5.Safety Protection: Main axis bearing oil level is controlled by limited switcher. If it lower the setting oil level, auto-alarming or can't start on touch screen. All doors and lifting platform can not be opened when any of them is not in exact position. External break will auto-alarming or can't start on touch screen.
- 6.Spindle and Rotation Arm had be treated by high-speed balancing devices, noise index is approx 82dB.
- 7.Appliance control: Touch screen friendly surface personalize operate and controlled by PLC +inverter.
- 8.The bow is excellent quality SK5 of Japan, which imported in Taiwan and is heat treatment and plating chrome on surface.
- 9.Driven by Timing Belt ensure the exact lay, no any lubricating point in machine ensure cleanness inside machine result of refueling pollution, there are not defective wire and ripped wire in machine.
- 10.Pitch change: easy to operate, only need to change one capstan wheel for reference pitch sheet.

➤ **(Capstan wheel change pitch)Main performance parameters**

- 1.Usage: It is applied to the stranding of bare twisted wire, tinned, copper covered aluminum, lacquer wire and alloy wire. 1+6 may twisting instead of bunching.
- 2.Range of copper wire: $\phi 0.2 \sim \phi 1.7 \text{mm}$, Range of core wire: $\phi 1.0 \sim \phi 4.0 \text{mm}$
- 3.Outer diameter: Copper $\phi 1.0 \sim \phi 5.5 \text{mm}$; cores $\phi 2.0 \sim \phi 8.0 \text{mm}$
- 4.Cross section area: $\phi 1.0 \sim \phi 16 \text{mm}^2$
- 5.Size of take up spool: $\phi 800 \text{mm} \times \text{length} 600 \text{mm} \times \text{inner core} \phi 80 \text{mm}$ (or customize).
- 6.Normal production speed up to 1400RPM(2800TPM),different diameter, different speed



7. Traverse: $\phi 40$ mm Polish rod bearing type, traverse width and row space are adjustable.
8. Pitch range: 23~160mm .
9. Main motor: 15KW AC motor +Invertor
10. Weight of copper load: about 800kg
11. Direction of stranding: free optional for S and Z direction, only need to pull the reverse rod of the traverse bar by hands to adjust the lay-length, easy to operate.
12. Brake: electromagnetic brake for external break, automatic stop when wire reach setting meter.
13. Tension control: take up tension is controlled by magnetic powder clutch, PLC follows up and regulates tension ,constant tension.
14. Drive bearing:Spindle use SKF,others use imported Japan bearing.
15. Timing Belt: it is adopted high quality product.
16. Spool lift: electrical screw lifting .
17. Spindle lubrication:grease lubrication(automatic lubrication by PLC programmer).
18. Index of noise:less than 82dB
- 19.Dimension: (length×breadth×height): 3200×2000×1730
20. Weight: 5500Kg
21. Coating: RAL 5015 sky blue (or customize).
22. Package: simple waterproof packing
23. Direction:from right to left, i,e, facing the operate panel, pay-off on your right (or customize).
24. Sealing of machinery door: seal of plastic.
25. Spindle housings sealing: mechanical block oil ring

➤ **Mechanical performances:**

1. Mechanical body structure:
 - 1)Material: low carbon steel welding form
 - 2)Structure: the mechanical body is treated by annealing , eliminate stress, precision boring machine through a molding process.
2. Inlet part:
 - 1)Inlet location: in the face of machine, on your right (may according to customer's requirements and correct to "left").
 - 2)Way of inlet: from pay-off device pass by wire breakage induction district, first through total sub-panels (hole-line distributed as 1+6+12+...) through the first isobar die, and through the second isobar die, at last get into wire guiding round of the right spindle. Through Al-arch belt ceramic ring enter wire guiding round of the left spindle , through center corner round to capstan wheel, after passing by the third isobar die to arrange wire (Details for way of thread diagram).
3. Spindle
 - 1)Material: #45 steel slag after quenching and tempering.
 - 2)Accuracy: cylindrical core shaft and bearing positioning end are all lapped,



ensure that the concentricity of axis core and the vertical degrees.

3)Balancing: the accuracy of balancing is G2.5 grade .

4 Rotation Arm

1)Material: 45# iron steel

2)Accuracy: all cylindrical end relative positioning holes beating 0.03.

3)Balancing: the accuracy of balancing is G2.5 grade.

5.Flyer Bow

1)Material: imported Japan quality SK5 heat treatment.

2)Shape: special appearance and reduce wind resistance.

3)The variance of weight: each variance of weight < 0.03 grams.

6.Drive part: Drive by synchronization strap, standard lay length is exact, synchronization strap is adopted imported product.

7.Wire guiding wheel

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

2)Plating hard chromium or spraying ceramic on surface, not been worn.

8. Spindle housings

1)Material: ductile iron QT42-10.

2)Processing: CNC machine tools

3)Accuracy: inner hole end, a molding process to ensure the concentricity.

9. Bearing spindle lubrication system:

1)Way of lubrication:grease lubrication(automatic lubrication by PLC programmer)

2)Model of grease: Mobil Flux ep1#

3)Way of sealing: mechanical retaining oil ring and back oil hole to prevent oil leakage and maintain internal cleaning of machine.

10.Take-up:Take-up tension control: take-up tension is controlled by magnetic powder clutch . PLC automatic follow-up and regulate tension, the tension is constant.

11.Special made bidirectional ϕ 30mm rolling ring traverse, winding pitch and breadth are adjustable.

12.spool size

Diameter (ϕ D)	Aperture (ϕ d)	Outer width (L1)	Inner width (L2)	Position hole	PCD
800	80	600	500	40	340

(The above specifications is factory standard specifications, may design according to customer's take-up spool size)

13. Dynamic power : 6.8KW

14. Installed power: 15KW

➤ **Detail Specifications**

Description of goods	Model	Remark
1.Main motor	15KW-6P	Siemens
2.Invertor	15KW	Inovance
3.PLC programmer	1SET	Inovance



4.PLCexpander	1SET	Inovancei
5.Touchscreen	RGB 10 Inch	WEINVIEW
6.Electromagnetic brake	24KG	Taiwan
7.Magnetic powder clutch	10Kgf	Taiwan
8.Spindle Bearing	1 set	Sweden SKF
Main Shaft Bearing	1 set	Japan NSK
9.Timing belt	1 set	
10.Traverse	Gp40(special made bidirectional)	Shanxi Dian Tou
11.Lifting Motor	0.75KW Motor+gear	Taiwan Shun Xing
12.Tension controller	10V	Taiwan
13.Fly bow	1set	Japan
14.Body	one set	Self-Processing
15.Spindle	2Pcs	Self-Processing
16.Rotation arm	2Pcs	Self-Processing
17.Timing Pulley	1set	Wu Xi
18.Bearing housings	one set	Self-Processing
19.Dics	2Pcs	Self-Processing
20.Transmission Shaft	1Pcs	Subcontracting
21.Capstan wheel	1set	Self-processing with hard chrome plating
22.Wire guiding wheel	6Pcs	Self-processing with hard chrome plating

➤ **Spare parts sheet**

No.	Description	Model	Qty	Remark
1	Operating instructions		1SET	
2	Electrical Schematic		1SET	
3	Inverter manual		1pcs	
4	Spindle guide wheel	with Bearings	1SET	
5	Wire guide wheel	with Bearings	1SET	
6	Pulley in Bow	φ34	14Set	With balance
7	Loop in Bow		3SET	With balance
8	Stranded Die	Client Provide		
9-11	Timing belt		1pcs	
12	Split plate porcelain ring	Φ9.8	3pcs	
13	Spool Top sleeve	PND 800	1SET	



14	Tool	With hex wrench, open wrench and etc	1SET	
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630 active pay-off machine

1. Pay-off reel size: 630 ~ 500 reels
2. Copper wire ϕ 0.41 ~ ϕ 1.70
3. Tension control: the upper and lower guide wheels of the storage rack (through the displacement sensor) return signals to the inverter to control the motor speed, which is linked with the main machine of the stranding machine to keep the pay-off tension stable and even
4. Reel loading and unloading: shaft-less
5. Lifting method: manual lifting
6. Main motor: 1.5KW AC motor + inverter
7. Protection: automatic shutdown after wire cut-off
8. Painting: RAL5015 sky blue
- 9.4 Left 3 right total 7 heads

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	ϕ 65	23	61
2	ϕ 75	26	70
3	ϕ 85	30	78
4	ϕ 96	33	88
5	ϕ 105	36	96
6	ϕ 118	40	107
7	ϕ 125	43	113
8	ϕ 138	47	125
9	ϕ 151	51	136
10	ϕ 163	55	147
11	ϕ 178	60	160



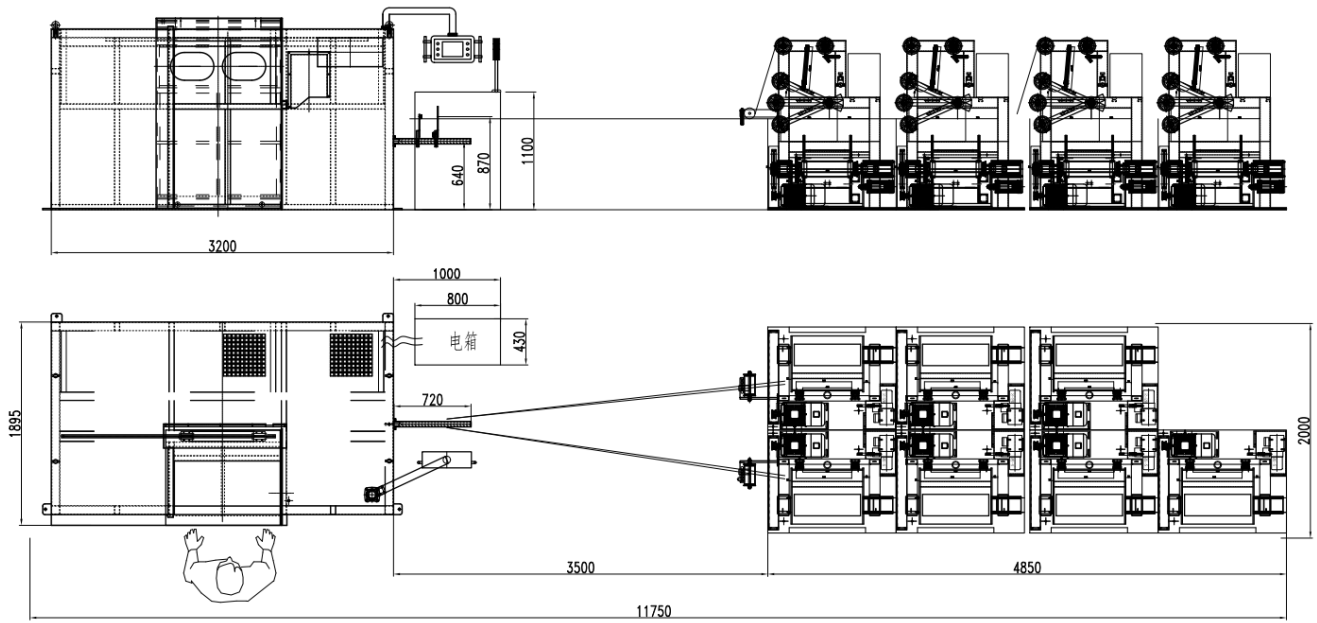
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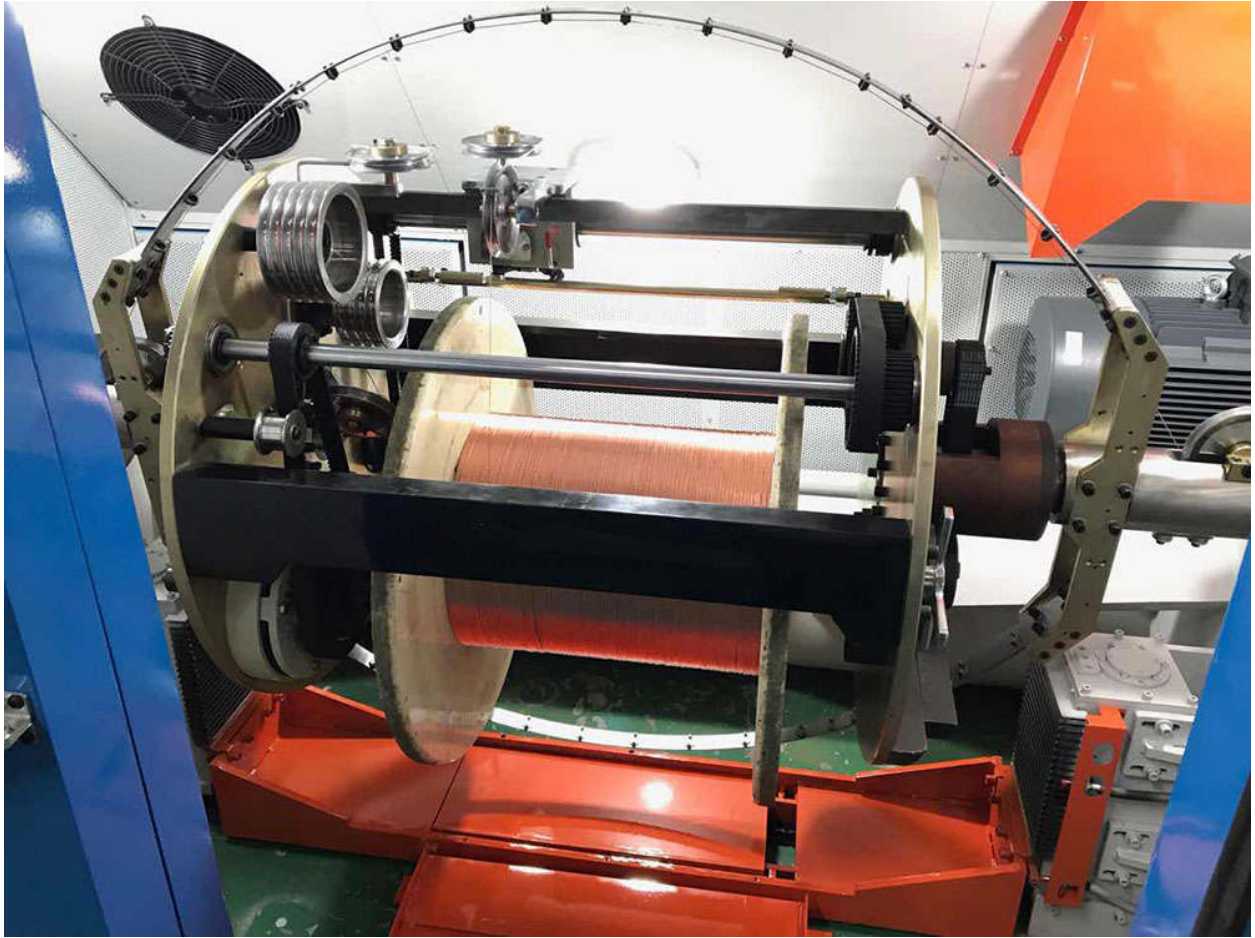




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800B Double Twist Bunching Machine Specification

➤ **Merits:**

- 1.High rotation speed and high stability(motor is connected with transmission shaft directly by butt-muff coupling).
- 2.Automatic tension control:When stranding, the tension of the take-up reel needs to be continuously increased when the take-up reel is moved from the chassis to the full reel. (Data set by the touch screen) this machine can automatically track and adjust the take-up tension to make the entire reel of take-up tension even and consistent. Can adjust the tension without stopping the machine (on the touch screen)
- 3.Adopt advanced wire guiding device, bow belt adopt unique half slot design, match up with semicircle ceramic ring to wire guiding, lead wire guiding to bow belt directly from spindle idler pulley to avoid the wire scratch, core mess while high running because of wind drag.
- 4.Way of spindle lubrication: grease lubrication, (automatic lubricator is controlled by the PLC programmer to avoid the lack of oil and damage to the main shaft bearing caused by human factors without regular refueling.)
- 5.Safety Protection: Main axis bearing oil level is controlled by limited switcher. If it lower the setting oil level, auto-alarming or can't start on touch screen. All doors and lifting platform can not be opened when any of them is not in exact position. External break will auto-alarming or can't start on touch screen.
- 6.Spindle and Rotation Arm had be treated by high-speed balancing devices, noise index is approx 82dB.
- 7.Appliance control: Touch screen friendly surface personalize operate and controlled by PLC +inverter.
- 8.The bow is excellent quality SK5 of Japan, which imported in Taiwan and is heat treatment and plating chrome on surface.
- 9.Driven by Timing Belt ensure the exact lay, no any lubricating point in machine ensure cleanness inside machine result of refueling pollution, there are not defective wire and ripped wire in machine.
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- 3.Outer diameter: Copper $\phi 1.0 \sim \phi 5.5 \text{mm}$; cores $\phi 2.0 \sim \phi 8.0 \text{mm}$
- 4.Cross section area: $\phi 1.0 \sim \phi 16 \text{mm}^2$
- 5.Size of take up spool: $\phi 800 \text{mm} \times \text{length} 600 \text{mm} \times \text{inner core} \phi 80 \text{mm}$ (or customize).
- 6.Normal production speed up to 1400RPM(2800TPM),different diameter, different speed



7. Traverse: $\phi 40$ mm Polish rod bearing type, traverse width and row space are adjustable.
8. Pitch range: 23~160mm .
9. Main motor: 15KW AC motor +Invertor
10. Weight of copper load: about 800kg
11. Direction of stranding: free optional for S and Z direction, only need to pull the reverse rod of the traverse bar by hands to adjust the lay-length, easy to operate.
12. Brake: electromagnetic brake for external break, automatic stop when wire reach setting meter.
13. Tension control: take up tension is controlled by magnetic powder clutch, PLC follows up and regulates tension ,constant tension.
14. Drive bearing:Spindle use SKF,others use imported Japan bearing.
15. Timing Belt: it is adopted imported American product.
16. Spool lift: electrical screw lifting .
17. Spindle lubrication:grease lubrication(automatic lubrication by PLC programmer).
18. Index of noise:less than 82dB
- 19.Dimension: (length×breadth×height): 3200×2000×1730
20. Weight: 5500Kg
21. Coating: RAL 5015 sky blue (or customize).
22. Package: simple waterproof packing
23. Direction:from right to left, i,e, facing the operate panel, pay-off on your right (or customize).
24. Sealing of machinery door: seal of plastic.
25. Spindle housings sealing: mechanical block oil ring

➤ **Mechanical performances:**

1. Mechanical body structure:
 - 1)Material: low carbon steel welding form
 - 2)Structure: the mechanical body is treated by annealing , eliminate stress, precision boring machine through a molding process.
2. Inlet part:
 - 1)Inlet location: in the face of machine, on your right (may according to customer's requirements and correct to "left").
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 - 1)Material: #45 steel slag after quenching and tempering.
 - 2)Accuracy: cylindrical core shaft and bearing positioning end are all lapped,



ensure that the concentricity of axis core and the vertical degrees.

3)Balancing: the accuracy of balancing is G2.5 grade.

4 Rotation Arm

1)Material: 45# iron steel

2)Accuracy: all cylindrical end relative positioning holes beating 0.03.

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5. Flyer Bow

1)Material: imported Japan quality SK5 heat treatment.

2)Shape: special appearance and reduce wind resistance.

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2)Model of grease: Mobil Flux ep1#

3)Way of sealing: mechanical retaining oil ring and back oil hole to prevent oil leakage and maintain internal cleaning of machine.

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11. Special made bidirectional $\phi 30$ mm rolling ring traverse, winding pitch and breadth are adjustable.

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Diameter (ϕD)	Aperture (ϕd)	Outer width (L1)	Inner width (L2)	Position hole	PCD
800	80	600	500	40	340

(The above specifications is factory standard specifications, may design according to customer's take-up spool size)

13. Dynamic power : 6.8KW

14. Installed power: 15KW

➤ **Detail Specifications**

Description of goods	Model	Remark
1. Main motor	15KW-6P	Siemens
1. Invertor	15KW	Inovance
3. PLC programmer	1SET	Inovance



4.PLCexpander	1SET	Inovancei
5.Touchscreen	RGB 10 Inch	WEINVIEW
6.Electromagneticbrake	24KG	Taiwan
7.Magnetic powder clutch	10Kgf	Taiwan
8.Spindle Bearing	1 set	Sweden SKF
Main Shaft Bearing	1 set	Japan NSK
9.Timing belt	1 set	American Gate
10.Traverse	Gp40(special made bidirectional)	Shanxi Dian Tou
11.Lifting Motor	0.75KW Motor+gear	Taiwan Shun Xing
12.Tension controller	10V	Taiwan
13.Fly bow	1set	Japan
14.Body	one set	Self-Processing
15.Spindle	2Pcs	Self-Processing
16.Rotation arm	2Pcs	Self-Processing
17.Timing Pulley	1set	Wu Xi
18.Bearing housings	one set	Self-Processing
19.Dics	2Pcs	Self-Processing
20.Transmission Shaft	1Pcs	Subcontracting
21.Capstan wheel	1set	Self-processing with hard chrome plating
22.Wire guiding wheel	6Pcs	Self-processing with hard chrome plating

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12	Split plate porcelain ring	Φ9.8	3pcs	
13	Spool Top sleeve	PND 800	1SET	
14	Tool	With hex wrench, open wrench and etc	1SET	



800 active pay-off machine

1. Pay-off reel size: 630~800 reels
2. Copper wire ϕ 0.41~ ϕ 1.70
3. Tension control: the upper and lower guide wheels of the storage rack (through the displacement sensor) return signals to the inverter to control the motor speed, which is linked with the main machine of the stranding machine to keep the pay-off tension stable and even
4. Reel loading and unloading: shaftless
5. Lifting method: manual lifting
6. Main motor: 2.2KW AC motor + inverter
7. Protection: automatic shutdown after disconnection
8. Painting: RAL5015 sky blue
- 9.4 Left 3 right total 7 heads

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	ϕ 65	23	61
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