

Product Specification C-Coil Annealing Device AT-CCAD

Product: C-Coil Annealing device working with protective gas
Type: AT-CCAD
Edition: 12/15

1. Description

This C-Coil annealing device works with protective gas.

The protective gas annealing has the advantage that it is a clean process. No finishing work is necessary.

After removing the coils from the annealing station, the ends of the C-Coils are about 80°C or less. This depends on the cooling time.

2. Technical Data

CU strands:	28–40 mm x 6–10 mm
Inside bend radius (90°):	40 – 80 mm
Max. length of the bent arm:	1100 mm
Capacity:	2 bar ends / annealing unit
Cycle time:	4 to 5 minutes
Tightening:	pneumatic
Annealing temperature:	max. 800°C

3. Scope of supply

The C-Coil annealing device consists of:

1 or 2 pcs. annealing device including inductors (controlled by Siemens S7)

1 or 2 pcs. medium frequency generator with control interface

1 or 2 pcs. cooling unit for inductor

1 or 2 pcs. water cooling system

To be supplied by the customer:

Inert gas (CO² or equivalent)

4. Operation

Two pieces of copper bars (c-shape) are inserted into the annealing device. When they are in the correct position – optical display – the annealing process begins. During the whole process, CO₂ is supplied.

After shut down of the MFG-system, the bars are cooled down to a temperature of approx. 80°C with the aid of a coolant (elapsed time adjustable). After the end of the cooling down (optical display) the bars can be taken out of the device. The correct heating period and power must be established through preliminary tests.

5. Packshot

