

General

Purpose of Machine

This spring coiling machine is for the manufacture of right and left-hand tension and compression springs of cylindrical or other shapes with and without the ends coiled flush.

Range of operation

Wire gauge	= .315" - .630" (8 - 16 mm)
Smallest outer diameter of springs	= 1.37/64" (40 mm)
Largest outer diameter of springs	= 7.7/8" (200 mm)
Smallest coiling ratio	= $\frac{\text{Spring dia.}}{\text{wire gauge}} = 5$
Smallest wire length	= 1.3/16" (30 mm)
Maximum wire length	= 106'4" (32380 mm)
Minimum production per minute	= 0,86
Maximum production per minute	= 26
R.p.m. of drive shaft	= n = 900
Motor	= N = 30 HP
R.p.m. of motor	= 2930

The performance, that is the desired number of springs per minute, is governed by the type and size of spring and by the nature of the wire surface. The machine has three feed rates. The most favourable speed is to be selected for each case. The following feed rates can be set:

Lever "C" positioned to 1	=	54'10.1/2"	(16 1/2 m)
Lever "C" " " 2	=	73'	(22 m)
Lever "C" " " 3	=	106'4"	(32 m)