



## EQUIPMENT Type PD71S

### 1. Application



The **PD71S machine** serves to introduce cored wire into molten metal in ladle during the non-furnance treatment of steel, cast-steel, cast-iron (modification, spheroidization, desulphurization, introduction of alloying elements, etc.).

The equipment was designed for the needs of medium and small sized metallurgical plants.

### 2. Technical data

Limiting outline of feeding machine		Limiting outline of control		
			one machine	two machines
height	930 mm	height	1 000 mm	1 200 mm
width	450 mm	width	600 mm	800 mm
length	960 mm	length	300 mm	300 mm
mass	300 kg	mass	50 kg	80 kg
Power installed	2,2 kW			
Power supply	3x380 V (3x400V), 50 Hz			
Electric drive	Three-phase, asynchronous motors			
Velocity control	Frequency converter			

### 3. Operation parameters

- Diameter of wires injected: - 5 ÷ 13 mm
- Velocity of wire injection: - 1 ÷ 100 m/min, (5÷50), (2÷20)
- Velocity control: - 1 m/min step (0.1m/min for range 2÷20m/min)
- Setting range of meters: - 000.1 ÷ 999.9 m, every 0.1 m
- Number of feeding strands: - 1
- Number of powered rolls in one strand: - 3

### 4. Control

**Type PD71S has been equipped with PLC.** Control of feeding process is provided from keyboard on front Touch Panel of control cubic. In case when we use two machines PD71S on one stand screen looks like below. Control push bottoms are located only on the machine itself close to powered rolls. After the side-shield cover is opened PLC control is inactive and whole control (manual mode only) can be performed using bottoms close to the rolls.

Wire length to be fed into the ladle and velocity of feeding are set from keyboard (windows "LENGTH" and "SPEED"). During the feeding process the real parameters are displayed on monitor's screen which is placed on front panel of control cubic.

