**1Winding machine parameters**

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**Shanghai Qipang Industrial Co., LTD**

"Quality first, customer first" Shanghai Qi Pang Industrial Co., Ltd. is a high-tech enterprise that integrating R&D, design, manufacture and service of wire equipment. Our company has its own import and export rights. The company was founded in 2003 and has passed ISO9001:2008 quality management system certification and SGS third-party authority certification. The company's main customers come to Central Europe, South America, South Africa, most of Asia. The company adhere to the quality of survival, integrity to win the customer's operating principles, down-to-earth to actively listen to the valuable opinions of users.

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**1Chapter 1---TC series winding machine：**

1. Application Materials**: wire and soft copper wire, core wire, rope, cloth, etc., 0.1-5mm wire winding.**

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**2. Selection parameter**

|  |  |  |  |
| --- | --- | --- | --- |
| Model | TC300 | TC 400 | TC 500 |
| Wire diameter | φ0.1-φ3mm | φ1-φ5mm | φ0.1-φ5mm |
| Spoolsize(flange OD) | ≤φ300mm | ≤φ400mm | ≤φ500mm |
| Coiling speed | 110r/min | 280r/min | 280r/min |
| Take-up motor | 1\*0.18KW | 1\*0.37KW | 1\*0.37KW |
| Winding type | Traverse unit | Traverse unit | Traverse unit |
| Winding  tension | 8N/M | 10N/M | 10N/M |
| Load bearing | 20KG | 30KG | 30KG |

3.Specific configuration：

Standard ：

1. Base Frame: square steel, it is strong
2. 1 pair of tapered tips (compatible with a variety of inner hole bobbin).
3. One power distribution cabinet( include the power supply and Frequency converter).
4. Adjustable speed (120 revolutions per minute, other speeds can be customized)
5. There are 4 fixed expansion screw eyes in the bottom
6. There is anti-slip device at the top, bearing weight 30KG.
7. 1The winding part choose precision rolling ring drives.
8. **1**220V power.

|  |  |
| --- | --- |
|  |  |
| **Standard configuration** | **Select configuration** |
| Square steel, it is strong | A. meter counter (set the number of meters to stop and alarm) |
| 1 pair of tapered tips (compatible with a variety of inner hole bobbin). | B. magnetic powder tension device (to match The production line, so that the speed is constant, will not strain your wire.) |
| One power distribution cabinet include the power supply and Frequency converter). |  |
| Adjustable speed (about 120N turns per minute, other speeds can be customized) |  |
| 4 fixed expansion screw eyes in the bottom |  |
| Anti-slip device at the top, bearing 30KG |  |
| Precision rolling ring drives |  |
| 220V Power and customized Power. |  |

TC series pay-off device：

1. With belt brake function

2. The standard optical axis is 30mm diameter and the bearing capacity is 30KG.

3. Suitable for different size bobbin (compatible with a variety of inner hole bobbin).

4. Good stability, there are 4 fixed screw eyes below.

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**1hapter 2----QP series wire winding machine**

|  |  |  |  |
| --- | --- | --- | --- |
| Model | QP 300 | QP 400 | QP 500 |
| Wire diameter | φ0.1-φ3mm | φ1-φ5mm | φ0.1-φ5mm |
| Spoolsize(flange OD) | ≤φ300 | ≤φ400 | ≤φ500 |
| Coiling speed | 280r /min | 280r /min | 280r /min |
| Take-up motor | 1\*0.37KW | 1\*0.37KW | 1\*0.37KW |
| Winding type | Traverse unit | Traverse unit | Traverse unit |
| Winding  tension | 8N/M | 10N/M | 10N/M |
| Load bearing | 40KG | 43KG | 50KG |

**Specific configuration：**

|  |  |
| --- | --- |
| Standard configuration | Select configuration |
| Base Frame: square steel, it is strong for smaller than 500mm bobbins, inner width 330mm | 1. Meter (set the number of meters to stop and alarm) |
| One motor, 370 Watts | B. Reducer (recommended for installation below 800 rpm) |
| Manual clamping device, 1 pair of top | C.protective cover (plus safer) |
| One power distribution cabinet include the power supply and Frequency converter). | D.Magnetic powder tension device (to match The production line, so that the speed is constant, will not strain your wire.) |
| Adjustable speed (10-1400 rpm) |  |
| 4 pcs fixed expansion screw eyes on the bottom, the machine is more stable |  |
| Anti-slip device at the top |  |
| Precision rolling ring drives |  |
| 220V power (others are also available) |  |

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**Advantage:**

1. Frequency control

2. Independently develop hand-cranked chucks to facilitate the upper and lower discs. There are trays under the reels, not afraid to fall down.

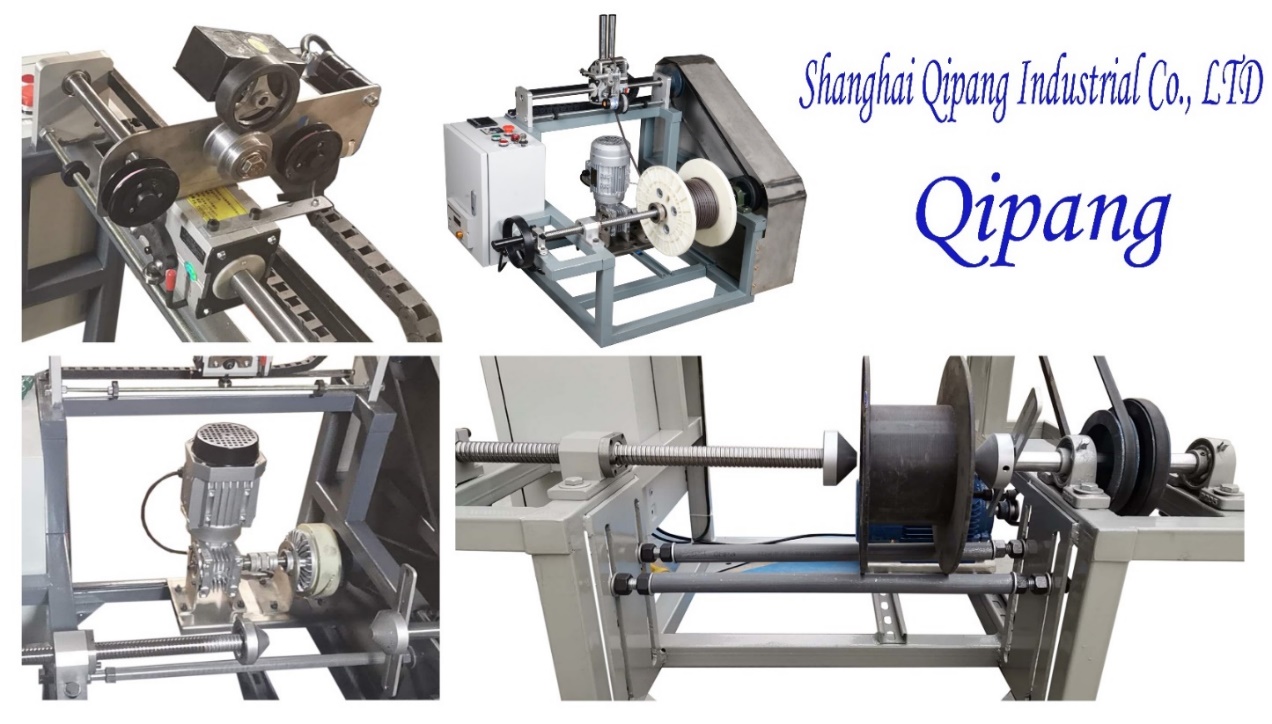
3. Conical tip (compatible with a variety of bobbins)

4. On both sides to bear the weight, the machine is more stable

5. The bottom plate L foot can be fixed and more stable.

6. Speed can match the pipeline, evenly winding.

7. Can be customized according to different needs.

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**1Chapter 3----Qipang – High speed Automatic Cable circling Equipment Series (lever-type)**

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**Application**

This equipment is used for 0.5-6mm² cable and small section cables’ circling and bundling.

**Main Features**

1. Loading and unloading pay -off wheel by lever –type: cantilever

combination guide wheel for, braking system with lever mechanism

2. With guide wheel and swell strength for automatically composing orderly and nice looking normally 30-40 seconds per circle.

3. Easy bundling and take out, more efficiency

1**1Technical Parameters:**

|  |  |  |
| --- | --- | --- |
| Model | A Type | B Type |
| Release form | Electric or passive | Electric or passive |
| Release form | ≤630mm | ≤800mm |
| Cable way | Automatic cable | Automatic cable |
| Number of wire grooving | 3 groove | 3 groove |
| Wire tie height | 30-100mm | 30-100mm |
| Wire tie outer diameter | ≤310mm | ≤400mm |
| Wire inner diameter | φ115mm-φ120mm-φ125mm | φ130mm- φ135mm-  φ140mm--φ145mm |
| Host revolutions | 0-500RPM/min | 0-360RPM/min |
| monitor rate | 2.2KW | 4KW |
| Production per shift | 700 t / 8 hours | 400 t / 8 hours |
| Loop diameter | BV、BVV、RV：0.3-6㎡  RVV,RVVP: ＜8mm  SYV75-3, SYV75-5 Coaxial | BV、BVV、RV：1-25㎡  RVV,RVVP: ＜12mm  SYV75-5, SYV75-9 Coaxial |
| Meter counter | Electronic high precision (adjustable length of meters) | Electronic high precision (adjustable length of meters) |
| Upper plate device | Lever type | Lever type |

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**Mounting Method:**

Steps: Unlocking handle-carry down bearing-fix continuity-rising cable wheel-lock handle. The design aims to improve the security of heavy wheel in high-speed running.

**Components of the equipment**

1. Storage line tension pay- -off shelve With lever for rising/downing the wheel, it is more efficiency, Tension is invariable, angle of rocker arm shaft drive the braking lever;

2. Electronic meter counter point sample is installed on the wheel of meter counter;

13. Initiative Wheeled Cable Drum Shelve The speed of circling is controlled by frequency conversion; the length of circling can be preset by meter counter, The equipment will be stopped after the preset length reached.

1**Chapter 4---High Speed Automatic Cable Circling Equipment Series(dedicated for flat-line)**

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**Application：**

This equipment is used for the circling and bundling of flat line , such as sheathed cable , parallel cable . audio cable. Etc.

**Main Features:**  
1.The swell-diminution and demount can be finished within 2-3 seconds. The bundle can be easily packed and take out The back board can be adjusted to realize the bundling height from 40-100mm (Universal bearing frame is optional configured for different line standard);

1. **1**The guide wheel which is the latest adjustable aluminum combination wheel,can realize line adjusting from 5 -17mm;  
   3.Driven cable composing device is used for precision cable composing,The  adjustable guide wheel base (one in front and one in back) are installed to ensure the stability of the process;  
   4.The mufti-function cable circling equipment can switch working style . Start up the driven cable composing device with the SWITCH 1when circling flat cable . and turn off the switch when circling round cable;  
   5.The equipment can be used without pay-off shelves. For some customers who don' t need circling or cable falling directly . it  is also applicable.

**Chapter5---QP-φ1250 Middle Section Automatic Circling Equipment**

**Application:**

This equipment is used for the circling and bundling of 10-50mm single cable and the round sheathed cable which the diameter is less than 200mm.

**Technical Specs:**

1. Pay-off shelve: end bearing, electronic elevator

2. Electronic elevator : deceleration motor 2HP (1.5KW)

3. High-accuracy meter counter: 0.1%

4. Max.rotative speed: 300r/min

5. Power of the machine: 5HP (3.7KW)

6. Control system; frequency conversion + SCM integration system

7. Circling wheel: Ф 130mm -Ф250mm (optional configuration in this range)

8.Pay-off Wheel:Ф 1250mm-Ф1600mm(optional configuration in this range)

9. Braking system: aerodynamic braking control

10. Applicable range: 10- 50mm single cable and the round sheathed cable which the diameter is less than 20mm

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1**Chapter6---QP-φ1600 large section intelligent circling equipment ( single-action, linked-action)**

**Application:**

This equipment is used for the circling and bundling of big section cable (10- -240mm²),and it can work with haulage machine Meter counter is also configured

Technical Specs:

1. Max, rotative speed: 300r/min

2. Power of the host machine; 5HP (3KW)

3. Power of the frequency conversion: 4KW

4. High- accuracy meter counter: 0.1%

5. Width of circling: 50- 250mm (adjustable)

6.Diameter of circling bearing; φ180--250mm(adjustable)

7.External diameter of circling wheel:φ700mm ( customizable )



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**1Chapter7 ---Φ630-Φ1000mm rewinding machine**

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1. **Φ630-Φ1000mm active pay-off machine**

Adapt to bobbin flange OD diameter: Φ630-Φ1000mm, Φ1000mm, overall width 475-750mm, inner hole 56/80

Top shaft mode: no shaft top cone pneumatic top tight

Pay-off speed: MAX200 m / min

Clamp the bobbin: 0.75KW electric screw lift

Power: 4KW motor drive spool release line

Brake: 10KG electromagnetic brake

Maximum load capacity: 3000 kg

1. **Vertical tension storage Accumulator/Dancer**

Total height of 2 meters;

The storage line volume is 0-15 meters, and the storage line wheel is Φ400mm (4 groups + 3 groups);

Adapt to the wire diameter: 0.5-10mm2 hard wire, Ф15mm soft wire;

Guide wheel material: aluminum alloy material, surface hardening treatment;

11Control mode: The sensor gives a 0-10V voltage signal to control the speed of the line.

**13. Meter counter**

Form: one-way stop;

The surface of the meter wheel and the pressure roller adopts a rubber wheel to ensure that the wire is not damaged.

**4. 400-630 shaftless winding machine**

Adapted to bobbin flange OD diameter: PN400-PN630, coil width 280-475mm, inner hole diameter Φ56mm

Applicable line speed: 200m/min

Top shaft mode: no shaft top cone

Clamp the bobbin: electric screw lifts, the upper and lower limits are safe and reliable

Cable: GP30 rolling ring drives, adjustable pitch. Wire winding : 10N.M torque motor winding wire

**Chapter8: Passive pay-off machine：**

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**1**Bilateral top axle power take-up machine**：**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Model** | **QPX630** | **QPX 800** | **QPX 1000** | **QPX 1250** |
| **Take-up line diameter** | **φ2-φ5mm** | **φ2-φ6mm** | **φ3-φ12mm** | **φ3-φ18mm** |
| **Take-up reel** | **≤630mm** | **≤800mm** | **≤1000mm** | **≤1250mm** |
| **Take-up speed** | **400m/min** | **400m/min** | **300m/min** | **200m/min** |
| **Take-up strength** | **25N/M** | **25N/M** | **36N/M** | **50N/M** |
| **Take-up motor** | **4KW** | **4KW** | **5.5KW** | **7.5KW** |
| **Cable way** | **Precision cable arranging device** | **Precision cable arranging device** | **Precision cable arranging device** | **Precision cable arranging device** |
| **Lifting of the reel** | **Electric/hydraulic** | **Electric/hydraulic** | **Electric/hydraulic** | **Electric/hydraulic** |
| **Cable clamping** | **Pneumatic / hand crank** | **Pneumatic / hand crank** | **Pneumatic / hand crank** | **Pneumatic / hand crank** |

Bilateral top axle power take-up**：**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Model** | **QPF 800** | **QPF1000** | **QPF 1250** | **QPF 1500** |
| **Take-up line diameter** | **≤10mm** | **≤15mm** | **≤20mm** | **≤30mm** |
| **Wire reel** | **φ630-φ800mm** | **φ800-φ1000mm** | **φ800-φ1250mm** | **φ1000-φ1250mm** |
| **Speed of release** | **＜600r /min** | **＜500r /min** | **＜400r /min** | **＜400r /min** |
| **Take-up motor** | **4KW** | **5.5KW** | **5.5KW** | **7.5KW** |
| **Lift motor** | **0.75KW** | **1.5KW** | **1.5KW** | **1.5KW** |
| **Release force** | **External force control** | **External force control** | **External force control** | **External force control** |
| **Lifting of the reel** | **Electric/hydraulic** | **Electric/hydraulic** | **Electric/hydraulic** | **Electric/hydraulic** |
| **Cable clamping** | **Pneumatic / hand crank** | **Pneumatic / hand crank** | **Pneumatic / hand crank** | **Pneumatic / hand crank** |

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1**Chapter 9---Take-up part: PND400-800mm active take-off (without shaft)**

The difference between active payoff and passive payoff: active take-up has motor, passive pay-off is no motor pull by pull-up machine, speed is uncontrollable.

1. Applicable wire reel PND400- 600mm

2. Discharge method: active release

3. Chuck mode: no shaft thimble clamping

4. Lifting method: oil pressure lifting

5. Take-up motor: 4KW

6. Inverter power, 4KW

7. Line speed: 0-300 m / min

8. Storage line guide wheel outer diameter: 250mn (aluminum alloy made up to five down four)

9. Line type: vertical type

10. Braking method: pneumatic brake

11. Linkage with the customer's previous equipment

12. Machine color: sea blue + beige orange





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1**Chapter 10 Release part: PND1000-1200mm active release line (the swing arm type)**

1. Applicable wire reel PND1000- 1250mm

2. Discharge method: active pay-off

3. Clamping type: no shaft thimble clamping

4. Lifting method: oil pressure lifting

5. Take-up motor: 5.5KW

6. Inverter power, 5.5KW

7. Line speed: 0-300 m / min

8. Storage line guide wheel outer diameter: 250mn (aluminum alloy made up to five down four)

9. Pay-off type: vertical type

10. Braking method: pneumatic brake

11. Linkage with the customer's previous equipment

12. Machine color: sea blue + beige orange



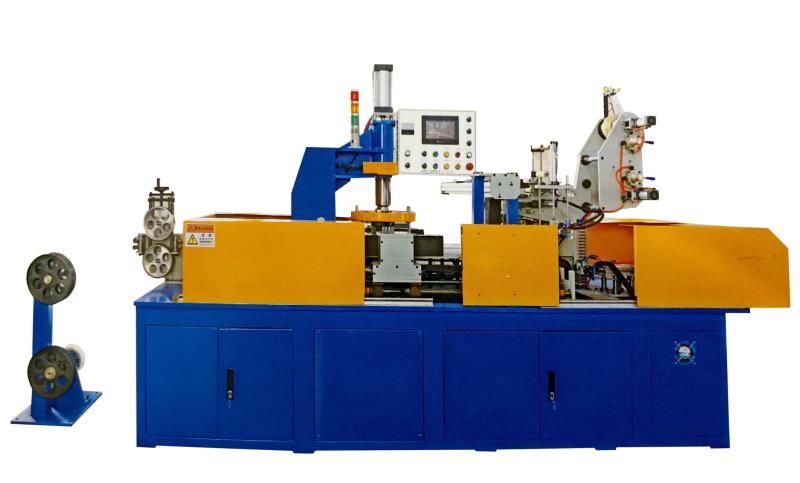
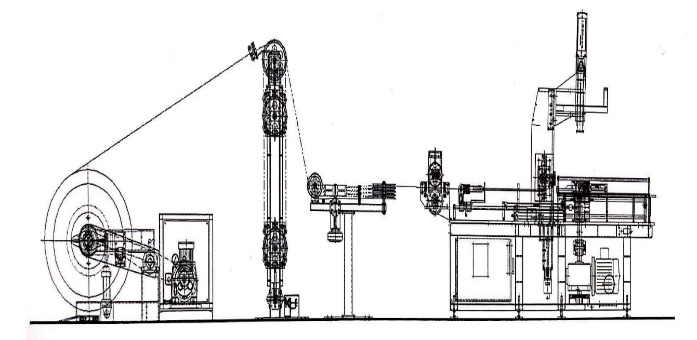
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11**Chapter 11---Two machines and one combination, automatic looping + ring micro-computer automatic winding and packaging machine：**

Equipment use: High-speed automatic looping + winding packaging for various wire and cable  
Packaging materials: PVC film / PE film / PP film / paper tape, braid  
Features:  
With Siemens PLC automatic control, touch-type human-machine interface, the operation is simple and clear.  
This use of the private service motor cable system, the cable effect is more ideal.  
The cable is wound, the packaging is completed in sequence, and the production speed is fast.  
Automatically adjust the hoop arm, free of manual adjustment.  
Automatic labeling machine, free of manual labeling, safer and more convenient.  
When there is a problem, an error is automatically detected and a warning is sent to alert the operator.  
It not only saves manpower expenditure, expands production capacity, but also boosts industrial automation.

Technical Parameters：

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| Machine Type | Height | Out diameterMM | Inner DiameterMM | Line DiameterMM | Packaging material | Average line volume output speed |
| QP1040 | 50-100 | 130-200 | 1.5-10 | 220\*400 | PVC/PE | 2-2.5 Volume/minute（100m） |
| QP1860 | 80-180 | 200-250 | 5-18 | 250-600 | PVC/PE | 1-1.5 Volume/minute（100m） |

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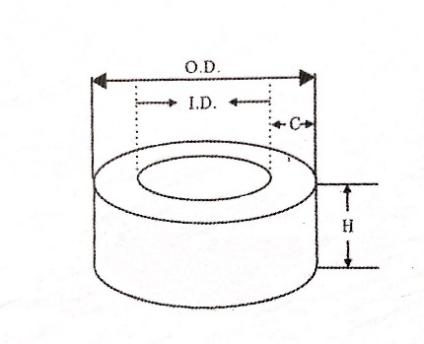
**Chapter 12--- Automatic coiling & wrapping machine**

Equipment use: High-speed ring for various wire and cable

Packaging materials: PVC film / PE film / PP film / paper tape, braid

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| Model | Height | Out diameter MM | Inner diameter MM | Line diameter MM | Packaging material | Average line volume output speed |
| Q1040 | 50-100 | 130-200 | 1.5-10 | 220\*400 | PVC/PE | 2-2.5 Volume/minute（100m） |
| Q1860 | 80-180 | 200-250 | 5-18 | 250-600 | PVC/PE | 1-1.5 Volume/minute（100m） |





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**1Chapter 13-- Wire take-up machine：**

Usage: The wire is neatly coiled, the material will be taken out, the wire reel is taken out, and the hollow roll is taken.

Specifications: wind from a big roll to a small roll

The specific plan is customized according to customer requirements.

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**1 Chapter 14--- Gantry type rewinding machine**

Usage: Mainly used for winding various large diameter cables

Mechanical specifications：

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| Machine Type | QP-2000 | QP-2500 | QP-3150 | QP-3500 | QP-4200 | QP-4500 | QP-5000 |
| Applicable coil specifications | PN1000-PN2000 | PN1600-PN2500 | PN1600-PN3150 | PN2000-PN3500 | PN2000-PN4200 | PN2500-PN4500 | PN3000-PN5000 |
| Applicable coil width | 750-1500 | 1180-1900 | 1180-2300 | 1500-2300 | 1500-2400 | 1900-2500 | 1900-2500 |
| Applicable cable outer diameter | ≤25 | ≤45 | ≤80 | ≤100 | ≤120 | ≤120 | ≤150 |
| Maximum load | 10T | 12T | 18T | 20T | 25T | 30T | 35T |
| Take-up speed | 6.2-25.6 | 4.9-20.6 | 3.3-13.8 | 3.3-13.8 | 3.3-13.8 | 3.3-13.8 | 3.3-13.8 |
| Take-up motor (DC) | 5.5 | 5.5 | 7.5 | 7.5 | 7.5 | 11 | 11 |

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**1Chapter 15---On line type machine：**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| Machine Type | QP-1250 | QP-1600 | QP-2000 | QP-2500 | QP-3100 |
| Applicable coil specifications | PN800-PN1250 | PN800-PN1600 | PN1250-PN2000 | PN1600-PN2500 | PN1600-PN3150 |
| Applicable coil width | 600-950 | 6000-1180 | 950-1500 | 1180-1900 | 1180-2300 |
| Applicable cable outer diameter | ≤25 | ≤35 | ≤50 | ≤60 | ≤100 |
| Maximum load | 4T | 5T | 10T | 12T | 18T |
| Take-up speed | 18.8-47.6 | 18.8-47.6 | 6-15.5 | 6-15.5 | 3..27-13.79 |
| Lift motor | 1.1 | 1.1 | 1.5 | 1.5 | 2.2 |
| Moving motor | 0.75 | 0.75 | 1.1 | 1.1 | 1.5 |
| Retracting force matrix motor | JLJ132-40/4 | JLJ132-40/4 | JLJ160-60/6 | JLJ160-60/6 | JLJ160-60/6 |
| Cable way | Screw wire | Screw wire | Screw wire | Screw wire | Screw wire |
| Cable pitch | 5-40 | 5-40 | 10-80 | 10-100 | 25-140 |

Uses: Mainly used for winding various large diameter cables

**Mechanical specifications:**

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1**Chapter 16---Accumulator/Dancer**：

1. **Type**: vertical or horizontal.

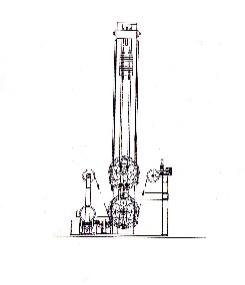
2. Used to connect the pay-off machine or the extruder to keep the linear tension

3. To ensure that the line is flat and beautiful.

4. The storage line frame can be designed and manufactured according to the needs of customers.

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Model | Storage wheel diameter | Number of reel wheels | Storage line | Line diameter |
| QP-0330V | 300 | 10+11 | 41 | 2-6 |
| QP-0335V | 350 | 9+10 | 38 | 4-11 |
| QP-0340V | 400 | 7+8 | 30 | 6-12 |
| QP-0345V | 450 | 7+8 | 31 | 8-13 |
| QP-0350V | 500 | 6+7 | 24 | 10-15 |
| QP-0360V | 600 | 6+7 | 24 | 12-20 |



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**1Peripherals：**



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**1 Chapter 17---Filament layer winding machine: single head and double head**

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|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Main technical parameters (QP-R 0.8 winding machine) | | | | |
| Name | Type | | Remarks | |
| Winding Machine | QP-0.2-1.5mm | |  | |
| The scope of work |  | | Tin, alloy | |
| Main electrical parameters | | | | |
| Name | Type | Place of origin | The scope of work | Remarks |
| Power |  |  | 2\*220v(Adding ground) | ±10v |
| working frequency |  |  | 50Hz |  |
| Frequency converter | 0.75kw | Shilin | 50Hz |  |
| AC contactor | Shilin | China | 3\*380v 50Hz |  |
| 1switch | Tracy | China | 220v 50Hz |  |
| Environmental conditions | | | | |
| Name | Conditional standard | | | **Remarks** |
| Electrical design standard | According to EN 60204-1 | | |  |
| Air humidity and temperature | ＋5/40℃ | | |  |
| Compressed air supply | 2-3bar | | |  |
| Peak consumption | 1N m³/h | | |  |

**1**Wooden box packaging **：**

**1**