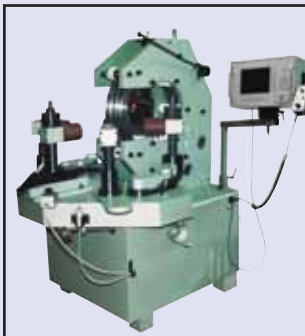


# MODEL RW 55-PC

The RW55-PC is a PC controlled extra heavy floor model with large industrial PC and can be fitted with 2 winding heads and 1 taping head. It is designed with modern hi tech components : 3-phase electronic motor for head drive, servomotor for core drive, Pentium III PC, interface for printer and more and it also incorporates RUFF's revolutionary machine drive technology. After input of the winding data the PLC will automatically set up the winding program: the pitch and turns are first calculated for each single layer, then displayed on the PC window and finally automatically changed from layer to layer during the winding process. The very sophisticated software fullfills the highest operator requirements whatsoever. The floppy disc-system enables flexible data management. Teach-in buttons and an operator joystick enable fast and easy improvement of the winding program at any time. Typical jobs for the RW55-PC are all usual extra heavy applications with thick wires and heavy cores.



Machine Combination:  
RW55-PC, RW55-DM, RW555-SO



**TECHNICAL DATA:**

CONTROLLER:  
PLC WITH PC  
SOFTWARE LANGUAGES: D, GB, I, CZ

DISPLAY:  
9" COLOUR MONITOR

PRESETS:  
800 PROGRAMS WITH  
PROGRAM LINKING FACILITY

PROGRAMMING:  
AUTOMATIC SET UP WITH  
TEACH-IN SYSTEM

DATA MEMORY:  
6,0 GB HARD DISC  
DATA INPUT/OUTPUT WITH 3,5" FLOPPY DISC

WINDING SPEED:  
UP TO 120 RPM  
AUTO CONTROL

WIRE PITCH CONTROL:  
FULLY AUTOMATIC

CORE INDEX AND REVERSE CONTROL:  
AUTOMATIC

ACCELERATION:  
AUTOMATIC

DECELERATION:  
AUTOMATIC

STOPS FOR TAPS:  
AUTO CONTROL OF TAP POSITION  
AUTO CONTROL OF START AND  
END POSITION OF WIRE LEAD

SECTOR / BANK WINDING CONTROL:  
AUTOMATIC

TAPING OPERATION:  
FULLY AUTOMATIC

CORE DRIVE POWER:  
AC SERVO MOTOR 1 HP

WINDING HEAD DRIVE:  
5,5 HP ELECTRONIC CONTROLLED  
3-PHASE MOTOR 5,5 AMP

SUPPLY VOLTAGES:  
230 (110 AND 240) VOLT, 50 HZ AC

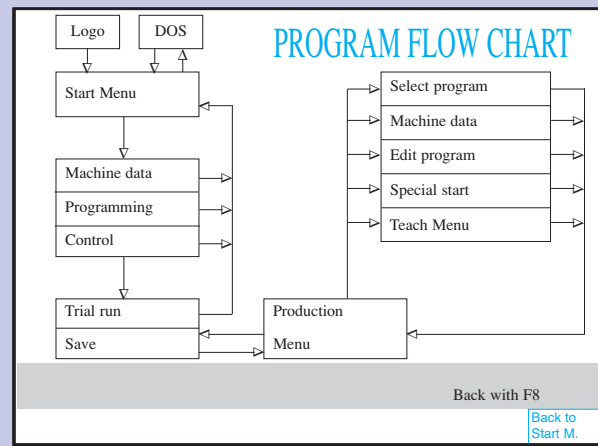
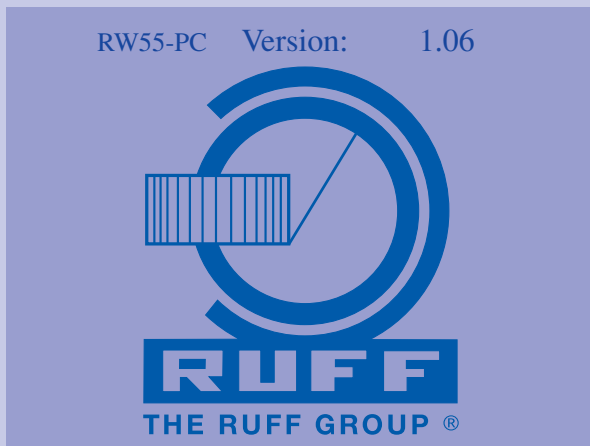
MACHINE SIZE AND WEIGHT:  
1.630 X 1.800 MM  
600 KG NET, 750 KG GROSS

COMBINATION CAPABILITY:
3 HEADS
2 GEAR HEADS RW55,55-DM
1 TAPING HEAD RW55/B
2 ROLLER TABLES RW555,555-SO

**PRODUCTION CAPABILITY**

	inch/AWG	mm
- SINGLE WIRE SIZE:	4 1/2 - 20	0,8 - 5,0
- BIFILAR WIRE SIZE:	up to 2x6 1/2	up to 2x4,0
- FLAT WIRE SIZE:	up to 0,2x0,5	up to 5x12
- FINISHED CORE O.D.:	4,0 - 59	100 - 1500
- FINISHED CORE I.D.:	from 2,36	from 60
- FINISHED CORE HEIGHT:	up to 11,8	up to 300
- TAPE SIZES:	0,6 - 1,18	15 - 30

# RW 55-PC TYPICAL INPUT AND PRODUCTION SCREENS



## START MENU

**START MENU**

F1 - HELP FILE  
 F2 - WINDING PROGRAM WITH CALCULATION  
 F3 - TAPING PROGRAM WITH CALCULATION  
 F4 - WINDING PROGRAM WITHOUT CALCULATION  
 F5 - TAPING PROGRAM WITHOUT CALCULATION  
 F6 - PRODUCTION MENU

DOS - Menu

Select with function keys  
 F1 - F6

Help	Wind prg W.Calc.	Tape prg W. calc.	Wind prg w/o calc.	Tape prg w/o calc.	Product menu	Flow chart	
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## INPUT MACHINE DATA

Product number  
 winding head type RW2  
 Table type RW222-V

**LOADING:**

Acceleration	20 %
Speed	95 %
Slowdown turns	2
Deceleration	97 %
Finishing speed	20 %

Rubber roller O.D. 67.00 mm  
 Core speed auto index 10%  
 Mag. speed pushbutton 15%  
 Core speed rockerswitch 5%

**WINDING:**

Acceleration	25 %
Speed	85 %
Slowdown turns	2
Deceleration	90 %
Finishing speed	20 %

Enter machine data.  
 Select with cursor keys.

Help	Head Type	Table Type	Special Heads	Special Tables	Product List	Forw. to Wind prg	Back to Start M.
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## PROGRAM WINDING DATA

**Winding Program with Calculation**

Core O.D.	80.0 mm
Core I.D.	40.0 mm
Core height	25.0 mm
Overall wire dia	1.150 mm
No. of windings	1
W 1 Winding method	Layer
W 1 No. of turns	500
W 1 Core start dir.	CCW
w 1 Wire layering system W/W on ID	
W 1 Stop between layers	Yes
W 1 Distance wire leads	355°
W 1 Stop after winding	Yes
W 1 Core index	CW
W 1 Index angle	180°
W 1 Stop after index	Yes

Enter the winding data with automatic calculation.  
 Select with cursor keys.

Help	Wire Chart	Previous Winding	Next Winding		View W. Method	Forward Calc.	Back to Start M.
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## CALCULATED WINDING PROGRAM

Product number 999999 Winding program

No. of windings	1	Loading turns				84
Winding No.	1					
Winding method	Layer	Layer	Layer	Layer	Layer	
Turns per winding	500					
Start dir. for core rot.	CCW	CCW	CCW	CCW	CCW	
Pitch per turn	2.370	2.611	2.857	3.137	3.502	
Layer number	1	2	3	4	5	
Turns per layer	106	99	93	87	80	
CW turns						
CCW turns						
Winding stop	Yes	Yes	Yes	Yes	Yes	
Start dir. for core index					CW	
Distance of core index					143.7	
Stop after core index					Yes	

Check calculated winding figures.  
 Select with cursor keys.

Help		Previous Winding	Next Winding	Previous Layer	Next Layer	Forw. to Product.	Back to Start M.
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## PRODUCTION MENU FOR TRIAL RUN

**Production menu** ENTER = change production screen

Product number	999999	Current:	Program End	Start
Loading turns	84	0	Waiting to Start Loading	Stop
No. of winding	1	1	Current speed 0%	
Winding No.	1	1	Programed speed 95%	
Winding method	Layer	Layer	Acceleration 20%	
Turns per windings	500	0	Deceleration 97%	
Core start direction	CCW	CCW	Auto index speed 10%	Program Reset
Pitch per turn	2.370	2.370	Core rotation On	
Layer number	1	1	Mag. rotation Backw.	Counter reset
Turns per layer	106	0	Production time 57 s	
CW turns			Production pieces 0	
CCW turns			Wire diameter 1.150 mm	
Stop after winding	Yes	Yes	Winding head RW2	Teach Menu
Core index direction	No	No	Roller table RW222-V	
Core index distance			Rubber roller 67.00 mm	Edit Program
Stop after core index				

Help	Core ON/OFF	Core CW	Core CCW	Special start	Machine data	Select program	Back to Start M.
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## PRODUCTION MENU FOR OPERATOR

**Production menu** ENTER = change production screen

**Winding**

Product number	999999	Start
Program End		Stop
Total turns	84	Program Reset
Turns per layer	0	
Current turns	0	Counter Reset
Current pitch	2.370	
Current speed	0%	Teach Menu
		Edit Program

Help	Core ON/OFF	Core CW	Core CCW	Special start	Machine data	Select program	Back to Start M.
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