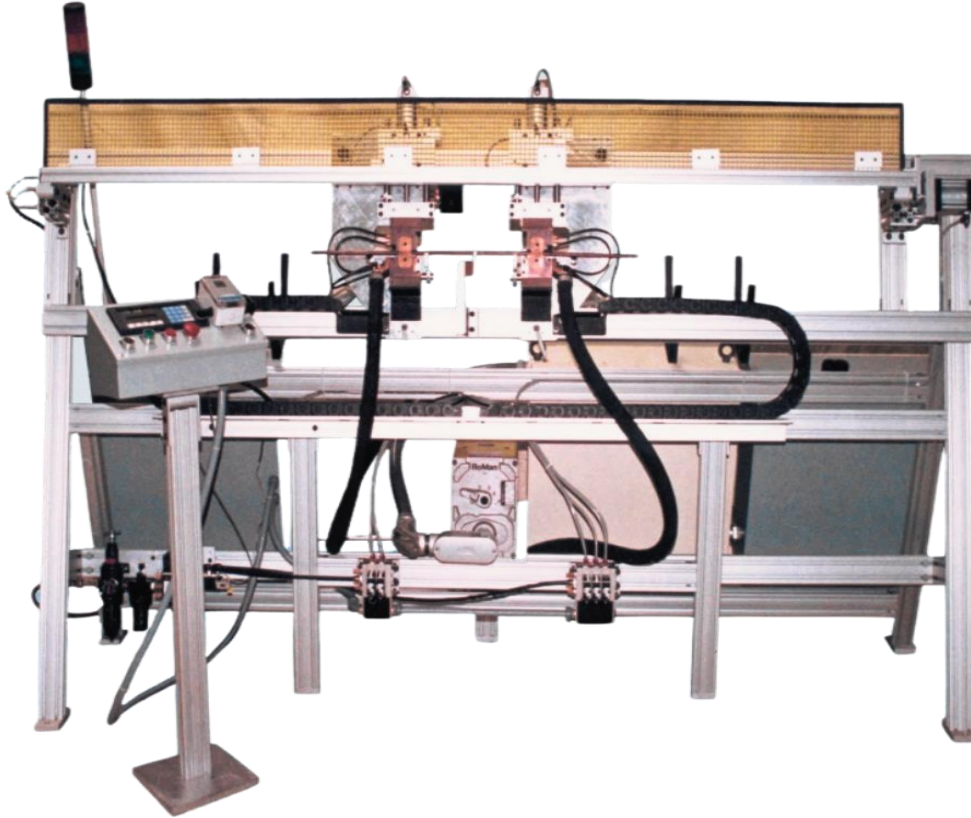
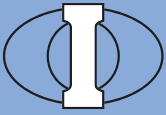


ANNEALING MACHINERY

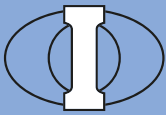


The **Oakley Spot Annealing Machine** is designed to quickly and efficiently anneal either particular sections of elements or their entire length after the elements have been reduced. Our system includes a weld transformer with a solid state weld control. The key to the system is an Infra-Red sensor system that measures the actual temperature of the elements as they are being annealed and then turns off the transformer when the appropriate temperature is reached.



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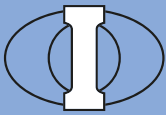
ADVANTAGES

- Fast and inexpensive method for annealing your elements
- Element length or diameter change takes less than 5 minutes
- Infrared sensor is used to accurately control the annealing temperature
- It can be used to anneal portions of the element or the entire length
- Transformer, cables and electrodes are water-cooled
- Message center provides machine diagnostics to assist in troubleshooting the machine
- Safety guard automatically covers the machine

CHARACTERISTICS

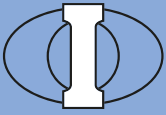
Unlike annealing machines that use time-based controls, the Oakley annealing machinery is not affected by fluctuations in plant voltage or by variations in tube materials or tube wall thickness. The preset temperature can be changed quickly using the operator interface, and the machine allows the operator to program the preset temperature in Celsius or Fahrenheit. To reduce the changeover time for different element diameters, four-sided indexable blocks are used as the clamping electrode, and each side can be supplied for a different diameter. The machine can accommodate different element lengths by manually moving the carriages and the eject hangers. A combined diameter change and length change can be completed in less than 5 minutes. While the machine is available in either 1 or 2 meter models, longer elements can be annealed in 1 or 2 meter sections.

The elements are hand-loaded into the machine and automatically unloaded if the element length is short enough to be ejected. If the element length is over the eject length, the element must be manually unloaded. The overall cycle time will depend upon the material and diameter of the element and also the length of the element or section being annealed. However, because we use a weld transformer that is considerably oversized, annealing times are extremely fast.



TECHNICAL CHARACTERISTICS

Element Diameters	.200 to .625 inch (5 to 16 mm)
Infra Red Accuracy	+/- 1% of Reading
Infra Red Repeatability	+/- 1% of Reading
Maximum Annealed Length	Two models are available. One will accommodate an element length up to 39.4" (1 meter) the other accommodates an element length up to 78.75" (2 meters). Longer elements may be annealed in 1 or 2 meter sections respectively.
Minimum Annealed Length	6 inch (150 mm)
Electrical Supply	440/380 v – 1 ph – 50/60 hz (100 amps)
Power Consumption	At 380 v – 60 amps At 440 v – 45 amps
Pneumatic Supply	5.6 bar (80 psi)
Water Supply	7.6 liters/min. (2.0gals/min.)
Length	5.7 ft (1745 mm) for 1 meter machine 9 ft (2745 mm) for 2 meters machine
Width	5.1 ft (1575 mm)
Height	5.3 ft (1625 mm)
Weight	1200 lbs (544 kg) for 1 meter machine 1400 lbs (635 kg) for 2 meters machine



LAYOUT

