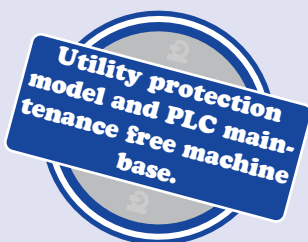


# MODEL RWE-STANDARD

The RWE-STANDARD is a PLC controlled bench model with LCD display modul with 2 text lines and incorporates the famous RUFF modular system with 24 interchangeable standard heads. It is designed with modern hi-tech components: PLC control, servomotor for head drive, servomotor for core drive, interface for PC and printer and much more... 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 load turns and start pitch are calculated and shown on the display screen. Teach-in buttons and an operator joystick enable to improve the winding program at any time. The user friendly PLC software guides the operator thru the programming with clear text commands. Typical jobs for the RWE-STANDARD are all general taping and winding applications.



**TECHNICAL DATA:**

**CONTROLLER:**  
PLC CONTROL WITH SOFTWARE  
LANGUAGES: E, D, GB, I, F, CZ, H, TR

**DISPLAY:**  
LCD WITH BACKGROUND ILLUMINATION CONTINUOUS READ OUT OF TURNS, SPEED, PITCH, PROGRAM NO., SEQUENCE NO. ETC.

**PRESETS:**  
200 PROGRAMS, EACH PROGRAM CONTAINING UP TO 30 PRESETS

**PROGRAMMING:**  
AUTOMATIC SET UP  
AUTO SAVE TEACH-IN-FUNCTIONS

**DATA MEMORY AND OUTPUT:**  
INTERFACES FOR PC AND PRINTER  
INTERFACE FOR MULTIMACHINE CONNECTION

**WINDING SPEED:**  
UP TO 1800 RPM  
FOOT OR AUTO CONTROL  
OPTIONAL HAND CONTROL UNIT

**CORE DRIVE:**  
POWER AC SERVO MOTOR

**WIRE PITCH CONTROL:**  
FULLY AUTOMATIC PITCH CHANGE,  
PROGRAMMABLE IN STEPS OF 0,001 MM

**CORE INDEX AND REVERSE CONTROL:**  
AUTOMATIC

**ACCELERATION:**  
AUTOMATIC

**DECELERATION:**  
AUTOMATIC

**STOPS FOR TAPS:**  
AUTOMATIC

**SECTOR / BANK WINDING CONTROL:**  
AUTOMATIC

**TAPING OPERATION:**  
FULLY AUTOMATIC

**WINDING HEAD DRIVE:**  
AC SERVO MOTOR 0,75 KW (BRUSHLESS)

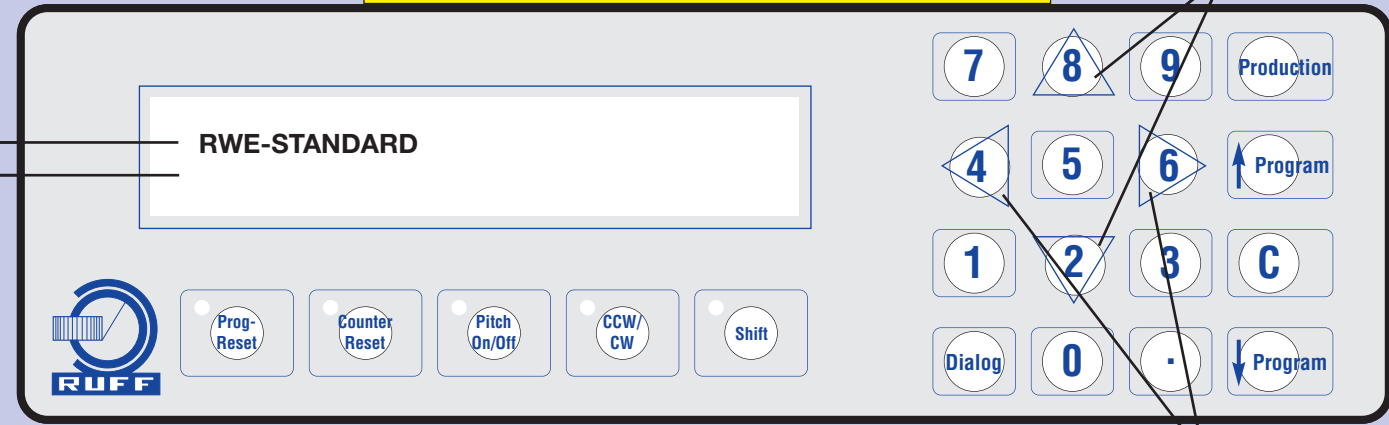
**SUPPLY VOLTAGES:**  
230 (110 AND 240) VOLT, 50 HZ AC

**MACHINE SIZE AND WEIGHT:**  
900 X 600 MM / 95 KG NET, 125 KG GROSS

<b>COMBINATION CAPABILITY:</b>	
<b>24 HEADS</b>	
6 GEAR HEADS	RW0,1,2,3,4,4-V
5 SLIDER HEADS	RW10,20,25,30,40
6 BELT HEADS	RW60-C,100-C,100,200,200-V,300
7 TAPING HEADS	RW0/B,1/B,2/B,3/B,4/B,200/B,300/B
6 ROLLER TABLES	RW111,111-V,112,222,222-V,332

**PRODUCTION CAPABILITY**

	inch/AWG	mm
- SINGLE WIRE SIZE:	11 - 44	0,05 - 2,5
- BIFILAR WIRE SIZE:	up to 2x13 1/2	up to 2x1,8
- FINISHED CORE O.D.:	0,2 - 14	5 - 350
- FINISHED CORE I.D.:	from 0,06	from 1,5
- FINISHED CORE HEIGHT:	up to 5,9	up to 150
- TAPE SIZES:	0,15 - 1,18	4 - 30



**PROGRAMMING SCREENS**

TEACH IN BUTTON PITCH

WINDING MACHINE PROGRAM	WINDING PROGRAM WITH CALCULATION	TAPING MACHINE PROGRAM	TAPING PROGRAM WITH CALCULATION
Operation method? (Tape, Wind=Shift) Wind 1	Core O.D.? (0-999.9mm) 100 mm S1/20	Operation method? (Tape, Wind=Shift) Tape 1	Core O.D.? (0-999.9mm) 30 mm S1/17
Head type? (Enter Menu=Shift) RW3 2	Core I.D.? (0-999.9mm) 50 mm S1/21	Head type? (Enter Menu=Shift) RW3/B 2	Core I.D.? (0-999.9mm) 20 mm S1/18
Table type? (Enter Menu=Shift) RW222-V 3	Core height? (0-999.9mm) 25 mm S1/22	Table type? (Enter Menu=Shift) RW222-V 3	Core height? (0-999.9mm) 10 mm S1/19
Roller O.D.? (0-999.99mm) 65.00 mm 4	Wire diameter? (0.001-9.999mm) 1.000 mm S1/23	Roller O.D.? (0-999.99mm) 65.00 mm 4	Tape width? (0.01-99.99mm) 9.000 mm S1/20
Auto Index speed? (0-100%) 20% 5	Winding method? (Cont.Segm,Prog.,Rev.=Shift) segm. S1/24	Auto Index Speed? (0-100%) 20% 5	Overlap on O.D.? (0-100%) 50% S1/21
Mag. Joystick speed? (0-100%) 20% 6	Winding sector? (0-360° degrees) 360° S1/25	Mag. Joystick speed? (0-100%) 50% 6	Culum.turns to next seq? (Yes,No=Shift) No S1/22
Core Joystick speed? (0-100%) 20% 7	No of turns? (0-99999) 250 S1/26	Core Joystick speed? (0-100%) 50% 7	Taping sector? (0-360°degrees) 360° S1/23
Load? (Yes,No=Shift) Yes S1/8	Cumul turns to next seq? (Yes,No=Shift) No S1/27	Load? (Yes,No=Shift) Yes S1/8	Core start dir? (CW,CCW=Shift) CCW S1/24
Load accel? (0=no, 100=max ramp) 20% S1/9	Core start dir? (CW,CCW=Shift) CCW S1/28	Load accel? (0=no, 100=max ramp) 20% S1/9	Stop after tape? (Yes,No=Shift) Yes S1/25
Load top speed? (0-100%) 80% S1/10	Stop after wind? (Yes,No=Shift) Yes S1/29	Load top speed? (0-100%) 80% S1/10	
Load slow turns? (0-9999) 0 S1/11	Core index? (CW,CCW,No=Shift) CW S1/30	Tape accel? (0=no, 100=max ramp) 20% S1/11	
Load decel? (0=no, 100=max ramp) 0% S1/12		Tape top speed? (0-100%) 80% S1/12	
Load finish speed? (0-100%) 0 S1/13	<b>WINDING PROGRAM WITHOUT CALCULATION</b>	Tape slow turns? (0-999) 2 S1/13	
Wind accel? (0=no, 100=max ramp) 5% S1/14	Load turns? (0-99999) 133 S1/20	Tape decel? (0=no, 100=max ramp) 90% S1/14	
Wind top speed? (0-100%) 80% S1/15	Wind turns? (0-99999) 250 S1/21	Tape finish speed? (0-100%) 20% S1/15	
Wind slow turns? (0-999) 2 S1/16	Cumul.turns to next seq.? (Yes,No=Shift) No S1/22	Automatic calc? (Yes,No=Shift) Yes S1/16	
Wind decel? (0=no, 100=max ramp) 70% S1/17	Core start dir? (CW,CCW=Shift) CCW S1/23		
Wind finish speed? (0-100%) 20% S1/18	Pitch per turn? (0-99.999 mm) 0,300 mm S1/24		
Automatic calc? (Yes,No=Shift) Yes S1/19	Wind CW turns? (0-99999) 0 S1/25		
	Wind CCW turns? (0-99999) 250 S1/26		
	Stop after wind? (Yes,No=Shift) Yes S1/27		
	Core index? (CW,CCW,No=Shift) CW S1/28		
	Distance index? (0-999.9 mm) 20,0 mm S1/29		
	Stop after index? (Yes,No=Shift) No S1/30		

**DIALOG FUNCTIONS**

Special Start (Enter Menu=Shift)	1
Batch quantity? (No of Pcs for m/c stop)	3
Curr.No of Pcs= (Reset=key C)	0
Prod.time= (Reset curr time=key C)	0s
Gear rack locking? (On,off=Shift)	off
Print current Prog.No? (Print=Shift)	2
Del. current Prog.No? (Delete=Shift)	7
Trans. current Prog.No? (Transfer=Shift)	8

**PRINTOUT AFTER PRODUCTION**

Program No:	1	Method:	Wind
Head type:	RW3	Table Type:	RW222V
Roller O.D.:	65.00 mm	Core O.D.:	100.0 mm
Auto index speed:	20 %	Core I.D.:	50.0 mm
Idx Joystick speed:	25 %	Core height:	25.0 mm
Mag. Joystick speed:	20 %		
	S1	S2	S3
Load:	Yes	Yes	Yes
Load accel:	20 %	20 %	20 %
Load top speed:	80 %	80 %	80 %
Load slow turns:	2	2	2
Load decel:	90 %	90 %	90 %
Load finish speed:	20 %	20 %	20 %
Wind accel:	20 %	20 %	20 %
Wind top speed:	80 %	80 %	80 %
Wind slow turns:	2	2	2
Wind decel:	90 %	90 %	90 %
Wind finish speed:	20 %	20 %	20 %
Wire diameter:	1.000 mm	1.000 mm	
Load turns:	44	47	
Wind turns:	300	300	
Cumu. turns count:	Yes	Yes	
Winding method:	Cont.	Cont.	
Winding sector:	360°	360°	
Core start dir:	CCW	CW	
Pitch per turn:	2.052 mm	2.179 mm	
Wind CW turns:	0	0	
Wind CCW turns:	300	300	
Stop after wind:	Yes	Yes	
Core index:	CW	CCW	
Index distance:	26.1 mm	80.0 mm	
Stop after Index:	Yes	Yes	

