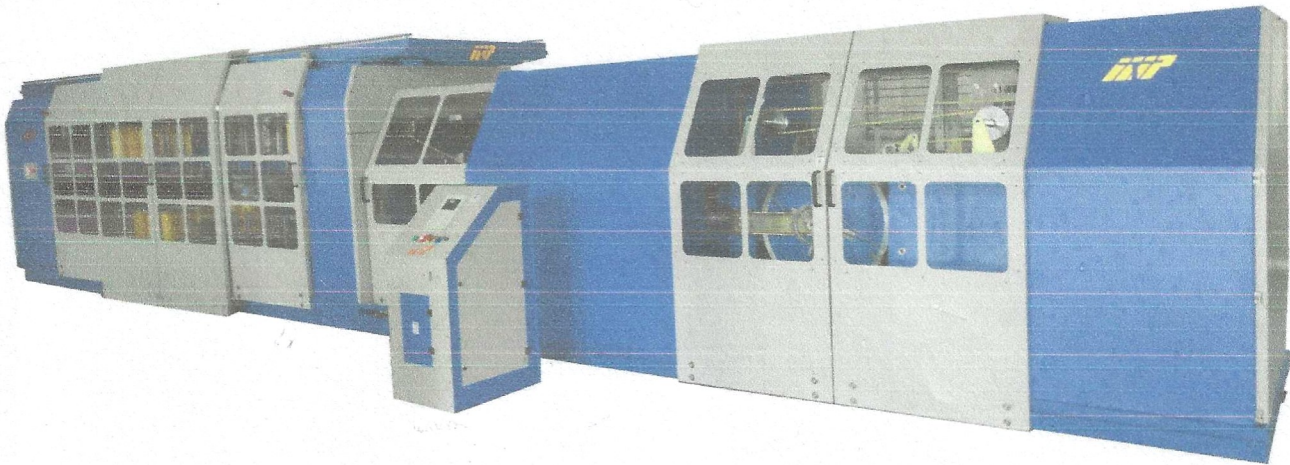




OPERATION MANUAL

Product: Rope making Machine
Model: MTP/E-16



Name and Address of Manufacturer

MAHESH TWISTO TECH PVT. LTD.
Plot No 349, Phase II, GIDC Chitra,
BHAVNAGAR – 364 004.

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Issued by : Mr. G.D.PATEL
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3 PRODUCT INTRODUCTION

Model MTP/E-16 is specially made for making rope of 16mm to 40mm diameter rope.

3.1 PRODUCT SPECIFICATION

Model	: MTP/E-16
Dimensions (L x W x H)	: 13300 mm X 2144 mm X 2260mm (MTP/16 FOR STANDARD MACHINE)
Weight	: 13000Kgs
Rope range	: 16mm to 40mm
Rope flyer RPM	: 200 (max.)
Strand flyer RPM	: 350 (max.)
Take up size	: 800 mm Dia. X 700 mm Traverse.
Rope Lay	: Z
Twist/Minute in strand	: Twice the flyer speed
Twist/Minute in Closer	: Twice the flyer speed
Twist Range	: 6 to 25 TPM
Twist in Strand	: Adjustable
Pay off package size	: 250 mm Dia. X 300 mm Traverse

3.2 INPUT ENERGY

Pneumatic	: Nil
Hydraulic	: Nil
Electric	: 37 KW, 3 phase. + N + E Volts/Hertz: - As per the corresponding country's power supply.

3.3 APPLICATION OF THE PRODUCT

3.3.1 Intended uses

Twisting of yarn & making it into a rope irrespective of material

3.3.2 Probable unintended uses

(Which may cause safety problems to operator or environment)

It is not used to twist the material which is not specified by the manufacturer. (For example:- metal, other brittle materials etc.)

3.4 Limitations

- Rope diameter range 16 to 40 mm.
- Diameter of coil not more than 800 mm.
- RPM not more than specified in article 7.4 for particular size of rope.



with strand balloon observation and above 30 dia. of rope, Selector switch should be at LOW position & the POT should be set on 20 for initial observation.

- 1) It is essential that the machine runs properly in ideal condition while starting the machine.
- 2) Very first select rope size and feed number of bobbin as per rope size in each strand cradle section for producing rope. For this calculation see Denier Chart below.

DENIER CHART								
SR NO	ROPE DIA MM	WT/220 MTR KGS	GRM/MTR	TPM	LAY LENGTH	ROPE DENIER	EACH STRAND DENIAR-3 PLY	EACH STRAND DENIAR 4-STRAND
1	2	0.4	1.8	135.1	7.4	16363.6	4200	3150
2	4	1.6	7.3	67.6	14.8	65454.5	16800	12600
3	6	3.6	16.4	45.0	22.2	147272.7	37800	28350
4	8	6.4	29.1	33.8	29.6	261818.2	67200	50400
5	10	10	45.5	27.0	37	409090.9	105000	78750
6	12	14.4	65.5	22.5	44.4	589090.9	151200	113400
7	14	19.6	89.1	19.3	51.8	801818.2	205800	154350
8	16	25.6	116.4	16.9	59.2	1047272.7	268800	201600
9	18	32.4	147.3	15.0	66.6	1325454.5	340200	255150
10	20	40	181.8	13.5	74	1636363.6	420000	315000
11	22	48.4	220.0	12.3	81.4	1980000.0	508200	381150
12	24	57.6	261.8	11.3	88.8	2356363.6	604800	453600
13	26	67.6	307.3	10.4	96.2	2765454.5	709800	532350
14	28	78.4	356.4	9.7	103.6	3207272.7	823200	617400
15	30	90	409.1	9.0	111	3681818.2	945000	708750
16	32	102.4	465.5	8.4	118.4	4189090.9	1075200	806400
17	34	115.6	525.5	7.9	125.8	4729090.9	1213800	910350
18	36	129.6	589.1	7.5	133.2	5301818.2	1360800	1020600
19	38	144.4	656.4	7.1	140.6	5907272.7	1516200	1137150
20	40	160	727.3	6.8	148	6545454.5	1680000	1260000
21	42	176.4	801.8	6.4	155.4	7216363.6	1852200	1389150
22	44	193.6	880.0	6.1	162.8	7920000.0	2032800	1524600

THIS CHART IS FOR POLYPROPYLENE ROPE (+/- 8%)

Denier chart for poly propylene yarn (+/-8%)

- 3) Number of bobbin and yarn denier must be equal in each cradle section of strand for Getting proper rope lay.