

VIOLI MECCANICA INDUSTRIALE Technology for cold drawing



TRI series hydraulic drawing benches

Violi srl is a leading company specialized in the design and production of industrial machinery for the manufacturing of metal tubes, bars and wires, typically used in the processes of **drawing, winding, straightening and cutting**.

Founded in 1992, building upon Mr. Giorgio Violi's long experience in the national and international jewellery market, Violi srl today boasts an established presence in the main international markets, offering a range of comprehensive and reliable products fostering the fidelity and trust of many customers.

Research and innovation have always characterized the company's strategy; it is distinguished for having developed technologically advanced machinery capable of meeting the highest requirements



TRI series Hydraulic drawing benches

Features

- GPLC-controlled
- Joystick control
- Adjustable speed traction
- Hydraulic opening and closing of pliers
- Safe opening of pliers
- Quick replacement of jaws
- Traction in line with the drawing hole
- Easy to use
- Optional opposite bench
- Compliance with the required standards



The TRI series is a full range of hydraulic equipment for the drawing of tubes or rods with circular cross sections or complex profiles, capable of meeting very high quality standards and delivering a precise final product.

Technologically advanced, thanks to the use of prime selected components and innovative design solutions covered by patent, the TRI drawing benches are **fully PLC-controlled** both for working phases and safety protection; **the pliers-carrying truck** is perfectly aligned with the drawing hole in order to avoid the formation of bending effects on the metal structure.

The **speed of traction** is adjustable and the use of the bench is extremely simple via the use of a **joystick** on the control panel which allows the operator to manage all the steps of the process easily.

Replacement of the jaws is immediate and is achieved through a system of fast anchorage.

The TRI series has a **very compact design** with a total length of about 1.5 meters beyond the useful working draft, and each model may be equipped with an opposite bench for the use of anchored spindles.



pliers-carrying truck



mandrel-die group

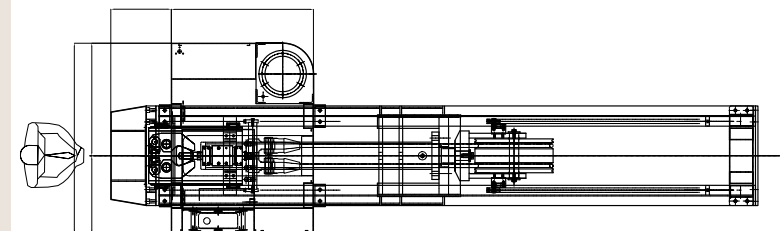
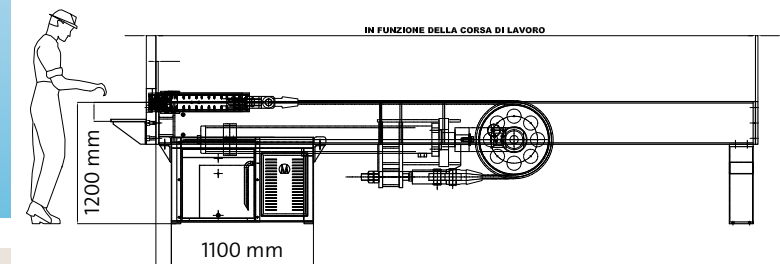


drawing of a copper bar



calibrating opposite bench

TRI30 Model



Technical data

	TRI5	TRI10	TRI30	TRI30P
DRAWING POWER	daN 5.000	daN 10.000	daN 30.000	daN 30.000
SPEED	0-6 mt./min.	0-6 mt./min.	0-5 mt./min.	0-5 mt./min.
IN AIR GAP	60 mm	60 mm	120 mm	120 mm
MAIN MOOR POWER	5,5 kW	9,5 kW	30 kW with pump with fix flow	15 kW with proportional pump with adjustable flow
POWER SUPPLY	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
LENGTH	1500 mm beyond the traction	1800 mm beyond the traction	2000 mm beyond the traction	2000 mm beyond the traction
OTHER DIMENSIONS	1000 x 1100 mm (Lxh)	1000 x 1100 mm (Lxh)	1100 x 1200 mm (Lxh)	1100 x 1200 mm (Lxh)
WEIGHT	Approx. 950 kg	Approx. 1500 kg	Approx. 2500 kg	Approx. 2500 kg

KTF10 Hydraulic drawing kit



KTF10 is a very compact draw bench for processing semi-finished tubes or bars having a maximum total length of 1 meter.

Maintaining the technical characteristics and features of the TRI series, KTF10 is equipped with a **tapering machine (APT30)** for the reduction of the diameter of the tubes to be processed using a hydraulic pliers system. The activation is via foot pedal switch.



Technical data

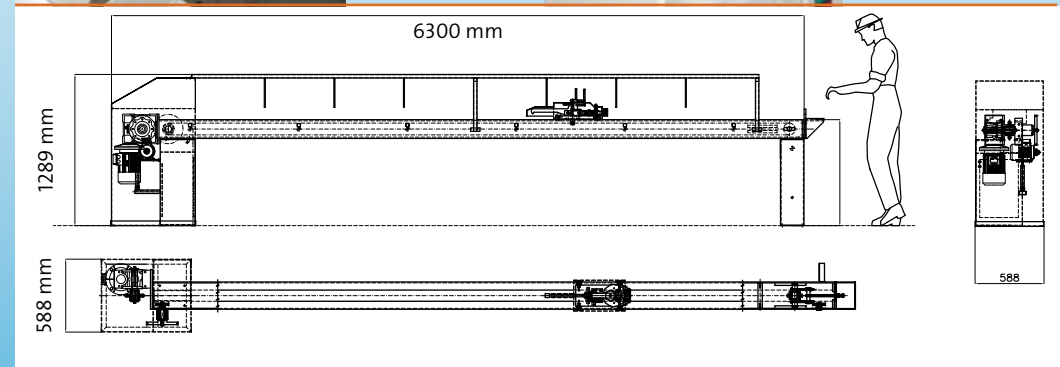
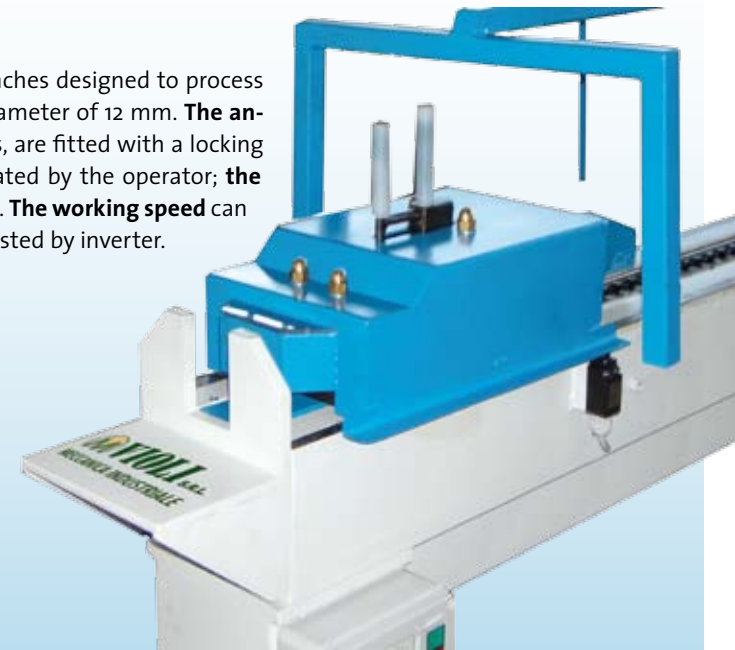
	KTF10
DRAWING POWER	daN 10.000
SPEED	2 mt./min.
IN AIR GAP	60 mm
MAIN MOOR POWER	4 kW
POWER SUPPLY	400 V/50 Hz
WORKING LENGTH	1000 mm
DIMENSIONS	950 x 2300 x 1200 mm (LxhxD)
WEIGHT	Approx. 1200 kg



drawn stainless steel tube

TR series Chain draw benches

TR series is a line of chain draw benches designed to process bars and tubes with a maximum diameter of 12 mm. The **anchorage pliers**, with adjustable jaws, are fitted with a locking system, with levers manually activated by the operator; the **return truck** is electrically controlled. The **working speed** can be fixed at one or two levels, or adjusted by inverter.



Technical data

	TR1V	TR2V	TRVI
TRACTION POWER	daN 1500	daN 1500	daN 1500
SPEED	10 m./min.	5-10 m./min.	0-10 m./min.
IN-AIR GAP	15 mm	15 mm	15 mm
POWER	2,5 kW	2,5 kW	2,5 kW
POWER SUPPLY	400 V/50 Hz	400 V/50 Hz	400 V/50 Hz
STANDARD LENGTH	5000 mm beyond the traction	5000 mm beyond the traction	5000 mm beyond the traction
DIMENSIONS	6300 x 588 x 1289 mm	6300 x 588 x 1289 mm	6300 x 588 x 1289 mm
WEIGHT	Approx. 500 kg	Approx. 500 kg	Approx. 500 kg

APT series Tube tapering machine

Range of equipment designed for the tapering of tubes to be attached to the anchor group in the drawing process.

A **circular hydraulic pliers system** allows the diameter of the tube to be reduced to the required dimension; operation is easy and safe, thanks to the safety guards. The **activation** is via foot pedal switch.



Technical data	APT30	APT70
MAX. DIAMETER	35 mm	70 mm
MIN. DIAMETER	10 mm	20 mm
MAX. THICKNESS	7 mm	10 mm
POINT LENGTH	Up to 200 mm	Up to 200 mm
POWER	100 ton.	200 ton.
DIMENSIONS	1160 x 600 x 760 mm	750 x 100 x 1200 mm
WEIGHT	250 kg	350 kg



tapered tubes

AP series Bar and wire pointing machines

Full range of machines for pointing wires and bars with diameter from 3 to 20 mm

Technical data	AT10	AT14	AT16	AT20
MAX. DIAMETER	10	14	16	20
MIN. DIAMETER	3	4	5	10
POWER	3 kW	4 kW	7,5 kW	11 kW
WEIGHT	Approx. 250 kg	Approx. 350 kg	Approx. 1050 kg	Approx. 1050 kg

VM/3010A Motorized and manual cross-rolling reeling machine

3010A is a cross-rolling reeling machine designed to remove the tube from the mandrel after drawing; the reeler expands the tube and frees it from the mandrel.

A **motor** activates a set of rollers whose vertical position is manually adjustable and visible through a decimal indicator. The **activation** is via foot pedal switch. The range of products is completed by a series of simple, easy to use manual devices.

Technical data	3010A
POWER	0,75 kW
POWER SUPPLY	400 V/50 Hz
WEIGHT	140 kg
DIMENSIONS	500 x 700 x 1400 mm

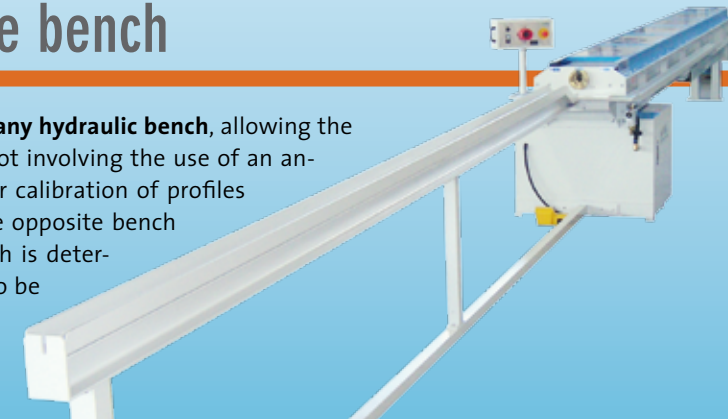


manual reeler



Drawing opposite bench

This is an **accessory adaptable to any hydraulic bench**, allowing the execution of drawing processes not involving the use of an anchored mandrel; it is also used for calibration of profiles of various size and diameters. The opposite bench is fixed to the draw and its length is determined by the size of the profiles to be processed.



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