



## Medium-Voltage Conductors Made by Double Twist Bunchers

By: **Producing high-quality conductors**  
Lint Top **of lager cross-sectional area suitable**  
[www.linttop.com](http://www.linttop.com) **for MV cable manufacture**

Large-size Double Twist Buncher has been designed and developed more than 20 years ,allowing the production of high-quality conductors of large cross-sectional area suitable for MV cable production.

The practical experience in the production of such conductors types that has been carried out in many factories all around the world,and cable manufacturers has ability to produce a wide range of products by the Double Twist Bunchers.And these products were considered possible only with rigid of planetary standers just a few years ago.

The following products specifications are presented for four models of the larger-sized Double Twist Bunchers. Of course, special models for even larger take-up sized and/or conductors are possible and available upon request.

### Double Twist Buncher Product Specifications

The LT-1600/XC Double Twist Bunchers has been designed for a maximum take-up reel size of 1600mm(DIN46395). Standard machine specifications are as follows:

- Seven wires conventional or compact conductors usually up to 20mm  $\varnothing$ (#2) with either Cu or Al wires.
  - 19 wires unilay stranded conductors,entire compressed or combination, up to 150mm  $\varnothing$ (#4/0) with either Cu or Al wires.
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- From 10 to 19 wires compact round unilay stranded conductors, up to 150 mm<sup>2</sup> with either Cu or Al wires. Compaction by external rotation die.
- Seven and 19 wires straight sectors shaped conductors, up to 150 mm<sup>2</sup> (#4/0) with either Cu or Al wire. With shaped roller head within the cradle.

The models LT-1800, LT-2000 and LT-2500 Double Twist Bunchers have been designed for a maximum take-up reel size of 1800 to 2000 and 2500mm (DIN46395). Standard machine specifications are as follows:

- Same as LT-1600/XC detailed above.

Double Twist Buncher machine equipped with external rotating capstan CE-900:

- 37 wires unilay compressed conductors up to 254 mm (500MCM) with either Cu or Al wires.
- Up to 37 wires compact round unilay stranded conductors, up to 185 mm (350MCM) copper and up to 300 mm (500MCM) aluminum

Machine equipped with an external rotating capstan CE-1000. Same as the CE-900 and:

- Up to 61 wires compact round unilay stranded conductors, up to 300 mm (600MCM) copper and up to 400 mm (800MCM) aluminum
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Machine that is equipped with external rotating capstan CE-1200. Same as CE-900 and :

- Up to 61 wires compact round unilay stranded conductors, up to 500 mm<sup>2</sup> (1000MCM) copper and up to 630 mm<sup>2</sup> (1250MCM) aluminum

The high compaction degree necessary for medium voltage conductors is achieved by simply using compaction dies, mandatory PCD or Nano dies for aluminum conductors, supported by driven or idle rotating die-holder.



With normal aluminum wires, the high compaction degree is possible, without annealing, simply applying on-line paraffin wax.



When requested, the insertion of water-swellable yarns among the layers of wires is possible. The insertion of water-swellable yarns is a special lay-plate assembly, which can be supplied by the company for the application of one or more yarns.



Of course the a.m.bunchers, equipped with proper accessories, can produce many other type of conductors such as:

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- AAAC, with just prepost formers for up to seven wires and with back-twist payoff and pretwister for more layers constructions in more passes. Also necessary for ACSR conductors.
  
  - Flexible conductors ,with special roller path/pretwister where not present the external rotating capstan. The cables can be done starting from multi-wire bundles or prebunched strands .Up to 400 mm (800MCM) has already been experienced.
  
  - Straight sector shaped conductors. With the installation of shaped rollers pairs and up to 185 mm<sup>2</sup> copper and 240 mm<sup>2</sup>aluminum 37 wires conductors.
  
  - Prespiralled sector shaped conductors with up to 61 wires,still to be tested.
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