



NF Wire Forum

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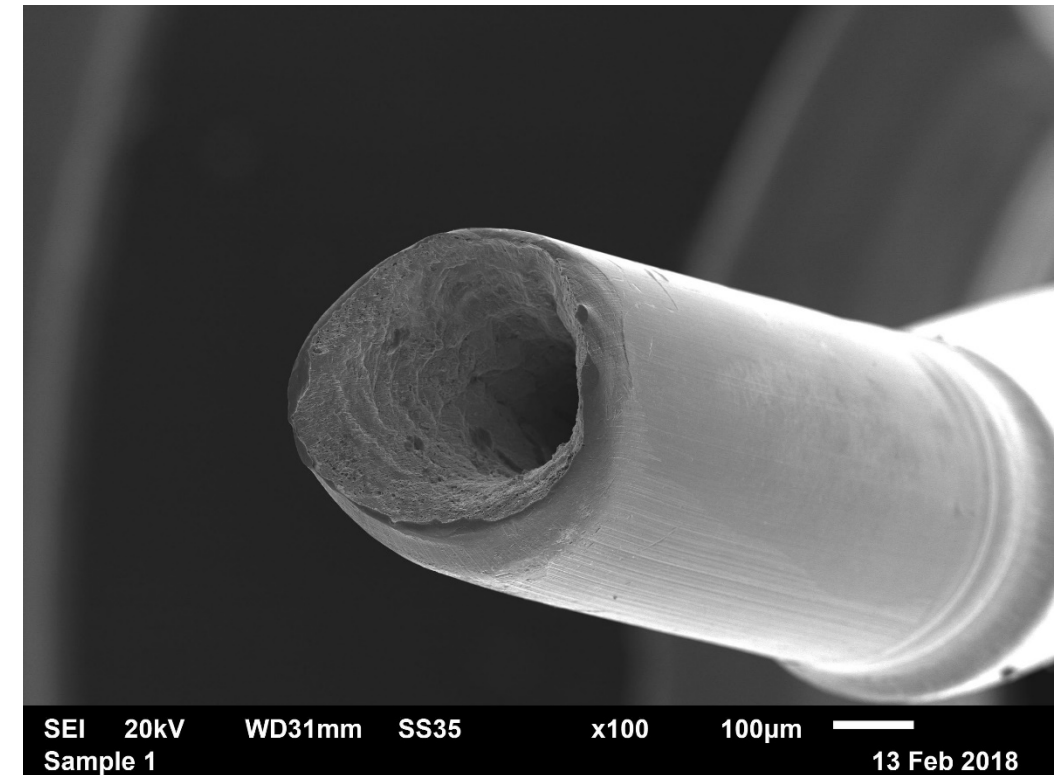


Cup and Cone breaks in relation with lubricants

Generally lubricants are not the first thing to point out for cup and cone breaks!

But, there can be breaks, which come from lubrication leaks in previous drawing steps.

Let me explain this on in the following minutes.



Cup and Cone breaks

Driving options on a rod break down system

- Typically driven with 12 – 18 % lubricant concentration
- Possible to drive with 5 – 8 % without serious problems in the rod system
- Cost saving calculation:
 - Estimated System of 10 m³ and pricing of Lubricant 5 €/kg (theoretically)

concentration	lubricant volume in liters	cost for set up in €
15%	1500	7500
5%	500	2500
	saving on set up	5.000 €
	+ saving on top up	~ 5.000 €
	annual saving	~ 10.000 €



Picture provided by Niehoff

Cup and Cone breaks

Impact of these options on the drawn quality

- Rod break down, maybe a little bit slower as usually
- Possible damages on rod wire
- Enhanced wire breaks in multi wire and fine wire drawing



Cup and Cone breaks

Impact of these options on the drawn quality

- Due to the breaks enhanced machine down time and scrap production
- Please estimate, how the costs would be for these standing times and the additional scrap material in comparison to the enhanced costs for higher concentration.

