

BARBED WIRE



Production capacity/annum

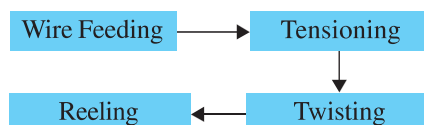
600 Tones

Production process

The two line wires and wires for the barbs are fed from four stands. The line wires pass through tensioning unit and stator in the bore of the twisting shaft to the twisting tool. Adjustable segment rollers pull the required length of wire for the barbs off the bundle and this is fed through the wire guide and counter cutter between the two line wires. The driver of the twisting tool grips the free ends and twists these around the line wires. The ends, which have not been cut off, yet held during the twisting by the wire guide. Only after the barb has been completed, a pair of cutters produces the end points and the starting points of the next barb. The number of twists of the barb is set on Cam drive. Two-pointed barbed wire is made in a similar way by feeding in only one wire for the barbs.

The transport wheel advances the barbed wire prior to twisting by the required barb spacing before the wire passes via two guide rollers to the reel. As the coiling frame, in which the reel is located, revolves, the barbed wire is twisted in one direction prior to being wound onto the reel. There is an in-built mechanism that regulates the coiling up tension.

Process flow chart



Machinery & equipment required

- Barbed wire making automatic machine 1
- Wire coil stands 4
- Workshop equipments / Hand Tools 1

Raw material/consumables required

- GI wire 10 to 14 SWG

Utilities required

Power required (load)	:	8 KW
Water required (per shift basis)	:	Normal supply

Manpower required

Manager	:	1 No.
Supervisor	:	1 Nos.
Skilled	:	2 Nos.
Unskilled	:	4 Nos.

Area required

Total Area	:	30 Sq. Mtr.
Covered Area	:	25 Sq. Mtr.

Investment required

Machinery & Equipment	:	} ₹ 44.30 Lakhs
Working Capital for 3 Months (Raw material, utilities & salary)	:	

For further details on training programme in entrepreneurship being conducted at NSIC Training cum Incubation Centre, you may contact NSIC-TSC, Okhla Industrial Estate, New Delhi 110020, Ph.: 011-26826801