AN AMBRELL COMPANY

## Heating wire for hot heading

To heat multiple steel wires to 1350°F (732°C) for hot heading Objective

application

Material Steel wire 0.185" (4.4mm) OD

Temperature 1350 °F (732°C)

Frequency 141 kHz

Equipment • Ambrell 5.0 kW induction heating system, equipped with a remote workhead containing one 0.66µF capacitor

An induction heating coil designed and developed

specifically for this application.

A two turn channel coil is used to heat 12 wires at a time to Process reach the required 130 parts per minute. The wires are placed

0.5" (12.7mm) on center. The top 0.3" (7.6mm) of the wires are heated for 5 seconds to achieve the desired temperature.

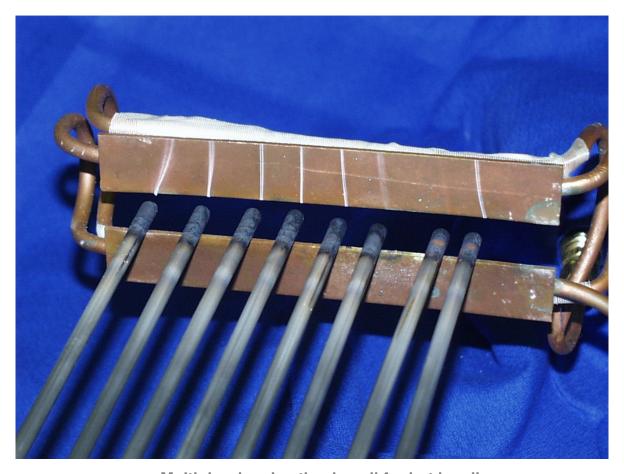
**Results/Benefits** Induction heating provides:

Hands-free heating that involves no operator skill for manufacturing

- Elimination of springback effect
- Extended die life
- Better grain flow and microstructure
- Even distribution of heating



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Multiple wires heating in coil for hot heading