

GENERAL INFORMATION

1. GENERALITIES

1.1 Utilization

The all-purpose spring coiling machine type FS 6 is designed and constructed for the manufacture of lefthand or righthand coiled tension and compression springs, cylindrical springs, leg springs and springs of any kind and shape, with or without legs.

1.2 Scope of work and output

Wire gauge: 1.5 to 7.0 mm
 Exterior diam. of spring: max. 80 mm
 Coiling ratio: $W_m \cong 4$ at $d \cong 6$ mm
 Output: 16 to 160 springs/min.
 Power requirements: 15 kW

Wire diameter mm	Max. wire length per stroke of segment			Position of control lever
	$W_m \cong 6$	$W_m \cong 5$	$W_m \cong 4$	
1.5 - 7	1000	800	---	"1" $L_{Dr} \cong 1000$
1.5 - 6	1500	1200	1000	"2" $L_{Dr} \cong 1500$
1.5 - 5	1500		1200	

The output of the machine, i.e. the number of springs required (and manufactured) per minute, depends upon the kind, shape and size of the spring to be produced. The output can be set at the hand-wheel of the gear and is infinitely variable.