



## DESIGN OF ROUND CONDUCTORS & SCHEDULE OF ROLLERS FOR COMPACTION PROCESS

ROUND COMPACTED CONDUCTORS FOR LOW, MIDDLE, HIGH & EHV MILLIKEN CABLES  
ONE CABLE CORE ROUND PROFILE

Table 07

Nominal cross-section (mm <sup>2</sup> )	Design Of wires n x d (mm)	Number of stranded layers	Arrangement of Rollers of pairs per Carriages						Number pairs of rollers	PCS of Rollers
			6	12	18	24	30	36		
1		2	3						4	5
50	18 x 2.12	2	2	3	-	-			5	10
70	18 x 2.52	2	2	3	-	-			5	10
95	18 x 2.92	3	2	2	4				8	16
120	34 x 2.40	3		2	2	4			8	16
150	34 x 2.67	3		2	2	4			8	16
185	34 x 2.97	3		2	2	4			8	16
240	34 x 3.38	3		2	2	4			8	16
300	34 x 3.78	3		2	2	4			8	16
400	54 x 3.46	4	2	2	3	4			11	22
500	54 x 3.87	4	2	2	3	4			11	22
630	54 x 4.35	4	2	2	3	4			11	22
800	78 x 4.08	5	2	2	3	4	4		15	30
1000	78 x 4.55	5	2	2	3	4	4		15	30
1200	78 x 4.99	5	2	2	3	4	4		15	30
1400	108 x 4.65	6	2	2	3	4	4	4	19	38
1600	108 x 5.00	6	2	2	3	4	4	4	19	38
1800	108 x 5.25	6	2	2	3	4	4	4	19	38
2000	108 x 5.53	6	2	2	3	4	4	4	19	38
2200	108 x 5.80	6	2	2	3	4	4	4	19	38
2500	108 x 6.20	6	2	2	3	4	4	4	19	38
2800	108 x 5.00	6	2	2	3	4	4	4	19	38
3000	108 x 5.95	6	2	2	3	4	4	4	19	38
3200	108 x 6.94	6	2	2	3	4	4	4	19	38
3400	108 x 7.15	6	2	2	3	4	4	4	19	38
3500	108 x 7.25	6	2	2	3	4	4	4	19	38
Total:			38	52	63	92	56	44	345	690





**NOTICE:**

- 1\*). The application of the dies are not necessary. We manufacture the dies with one or two parts on special Customers request.
2. All tools are made of hardened steel for long-life use.
3. The design and arrangement of the wires is in line with long-term practical experience producer in compaction of conductors.
4. We can to produce rollers also in accordance with special Customers design of conductors.

The net price of rollers it can easily be calculated for each type of conductor as follows:

1. Select the type of conductor from the previous tables and in the last column you can see how much rollers need for compacting process for selected conductor.
2. Select then type of roller that fits to your compacting heads.
3. Multiply the number of rollers with the price of selected roller and you get the total cost of the rollers for selected type of conductor.
4. If the dimensions of your roller is different from the proposed variants, then you can choose the roller that is most similar to yours and so again you get the approximate price of rollers for desired type of conductor.
5. Of course, if you are using rollers other different sizes we can produce rollers according to your drawings and with our working profiles.
6. schedule of compacting heads should be in accordance with the schemes given in "DESIGN OF ROUND CONDUCTORS".

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