

CUSTOMER INFORMATION REPORT

Topic : Solid Wires Cast & Helix Measurement

This information describes what the correct Cast & Helix measurements should be and how to measurement should be performed.

- Wrapped in drum wires cast & helix

Sampling:

1. 8-10 meters wire is taken that has not passed through the torch and has not been formed in drum.
2. *Wire is left freely on the ground without any bending process.*
3. *Wire is cut at intervals of 2-3 meters.*
4. *Helix measurement of cut wires done.*

***Cast (1):** It is not necessary to have a circular shape in the products wrapped in the drum as in the spool.
It is enough for the wire to get the "S" form.

****Helix (2):** After the "S" formed wire is cut at 2-3 meter intervals, the tip of any end is measured from the ground. This measurement is not expected to exceed a **maximum of 25mm** as indicated at the beginning of the document.

- Wrapped in spool wires cast & helix (D300, B300-K300, BS300-K300MS etc.)

- International standart requires minimum **cast*** (Figure-1) value **minimum 380mm** but this value is determined as **minimum 700mm** for our products.
- International standart requires **helix**** (Figure-2) value **maximum 25mm.**
- Sampling:
 1. 2-3 meters wire is taken that has not passed through the torch and has not been formed on spool.
 2. *Wire is left freely on the ground without any bending process.*

***Cast (1)**: A few meters of sample taken is placed on the ground and the diameter of the circular shape of the wire is measured.

****Helix (2)**: Height of the end of circular shape wire from ground.

