

Invention relates to the metallurgical production, in particular, to the branch of manufacture of the cord with wire spiral insert, which is used for reinforcement of tires of conveyer lines; the high pressure hoses and other mechanical rubber goods, and ropes and cables. The method for manufacture of two-layered twisted wire articles contains the simultaneous lay of core and external layer. Central core and finished article are twisted by the method of dual winding with different pitches in one technological operation, moreover, central core is twisted with previous t_o and then twisted (at identical direction of core lay and external layer SS or ZZ) or untwisted (at opposite directions of core lay and external layer ZS or SZ) simultaneously with the operation of lay of two-layered flat wire article in accordance with the following dependence:

$$\frac{t_m}{t_o} = \frac{t_m \pm t_k}{t_k} = \frac{t_m}{t_k} \pm 1,$$

where t_o - previous pitch of core lay;

t_k - final pitch of core lay;

t_m - pitch of twisted wire article;

(-) - for twisted wire article with identical direction of core lay and external layer SS or ZZ (at left-side winding of core S and external layer S, or with right-side winding of core Z and external layer Z);

(+) - for twisted wire article with opposite direction of core lay and external layer ZS or SZ (at right-side winding of core Z and left-side winding of external layer S or at the left-side winding of core S and right-side winding of external layer Z). Method ensures the high rate of working finished article, increases the service life of mechanical rubber goods during operation, and the lower cost of articles.