

A method for production of single twisted articles of layers of round wires includes three operations of twisting. The residual longitudinal forces in ready product are equal to zero due to tension of the elements (wires) at each operation with given, though different relations. The first twist operation is carried out with tension of wires of i -th layer, the second twist operation is carried out with tension of part of article twisted at the first operation and with tension of wires in the layers twisted in the second operation, the third operation is performed with tension of part of the article twisted in the first and the second operations with tension of the wires in layers twisted in the third operation.