Automatic Straightening Machine from coil

RH 13-16

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MEP

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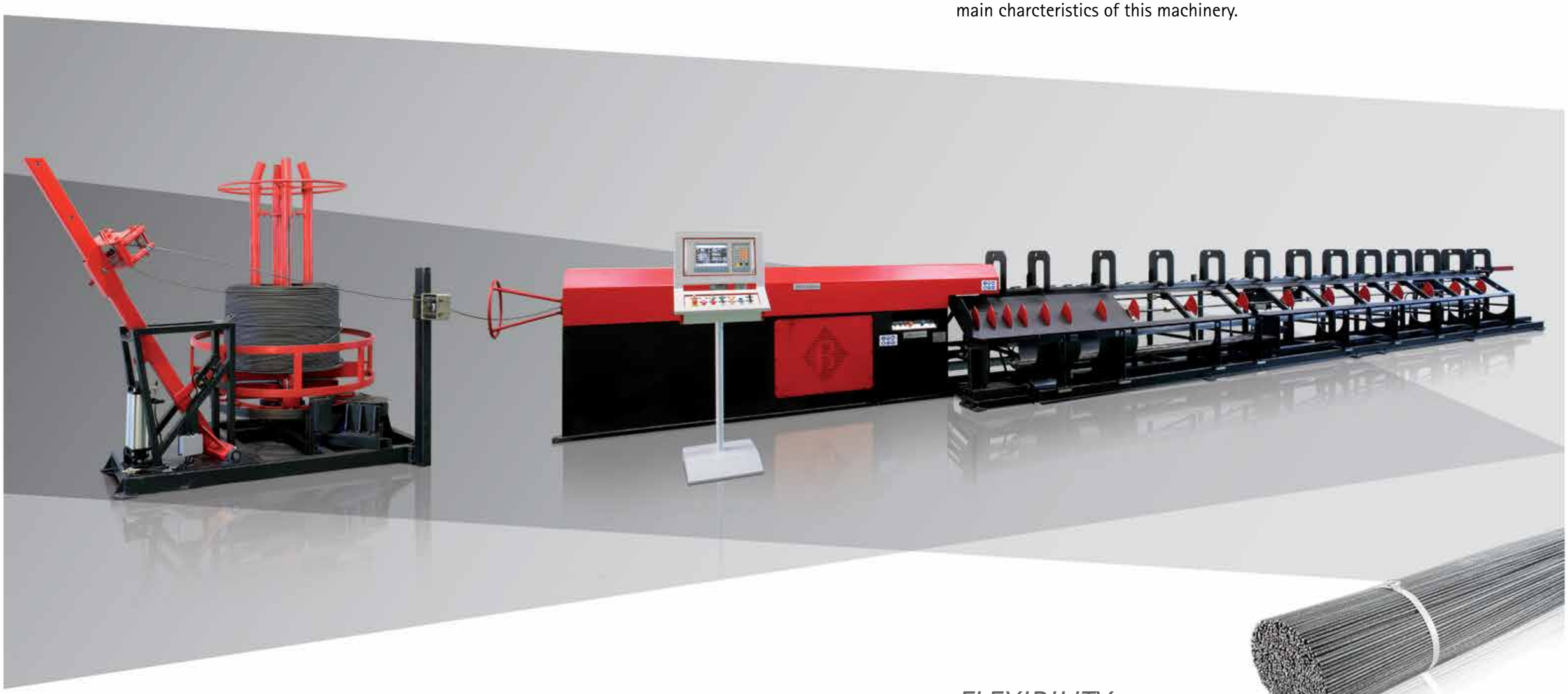
QUALITY STRAIGHTENING

The **RH** series straightening machines are designed for straightening and cutting of wires up to a maximum length of 12 meters. Product quality, usability and sturdiness are the main charcteristics of this machinery.



FLEXIBILITY

The different configurations allow to set the production according to specific needs: high volume productions (same diameter and length), flexibility (different diameters and lengths).

Straightening system

WINNING POWER

The straightening process is achived through a rotating group equipped with hyperbolic rollers having adjustable tilt and pitch. During the rotation phase, the wire is simultaneously dragged and straightened. This feature minimizes the longitudinal ribs deformation and does not affect the mechanical characteristics of the steel material. The use of dedicated rotors, depending on the various diameters, additionally improves the finished product quality.
The (patented) tailstock system allows the operator to change rotors quickly and easily.

CONSTANT QUALITY CONTROL

The insertion and straightening unit has an independent infeed that allows a constant control of the wire speed, originated by the hyperbolic rotor, based on the different diameters. An optimal quality of straightening is thus achieved.

FLYING SHEAR

The flying shear cut to length the wire while is moving ensuring high speed performances and the respect of the measurement tolerances.

WORLD SYSTEM: TOTAL CONTROL

- **The MEP Industrial PLC operator control panel is composed of:**

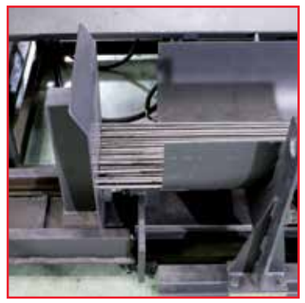
- LCD screen for data visualization in a "user friendly" graphic form.
- Low power consumption (embedded) microprocessor.
- Input/output and axes control electronic circuit boards equipped with short-circuit prevention system.

- **MEP's developed software allows:**

- Inputting bars production data and memorizing several batches to be produced in sequence.
- Displaying production status.
- Adjusting production speed and decoiler rotation speed through potentiometers.
- Control of all the machine parameters depending on the diameter used.
- Utilizing an "active diagnostic" system to verify constantly the efficiency of all the plant's devices.
- Predisposition for the memorization of the data related to the daily work cycles (diameters processed and daily weights processed subdivided by diameter).
- Predisposition for alarms history with related memorization of machine stop time and production time.
- Predisposition for production downloading through external computer or optical reader through serial port RS 232 (e.g. bar code reader).

OUTFEED CHANNEL WITH ALIGNEMENT DEVICE

- The guiding support available in several versions, allows the collection and separation of straightened bars according to their specific production needs.
The version that includes the automatic alignment device (optional) is particularly suitable for the production of bundles intended for welded mesh equipments.



ACCESSORIES

- GBO1-GBM decoilers equipped with a braking system controlled by the control panel, based on the production cycle. GBM version is provided with motorization.

WIRE BUTT WELDER

- Allows to weld the ends of two coils in order to reduce the handling time.
(OPTIONAL)

TECHNICAL AND PRODUCTION CHARACTERISTICS

	**BAR WORKABLE DIAMETER**	**RH13/1**	**RH 16/1**
	cold drawn, hot rolled, smooth or ribbed wire	from Ø 5 to Ø 12 mm	from Ø 5 to Ø 16 mm
		from # 2 to #4	from # 2 to #5
	fy = 600 N/mm² - ft = 700 N/mm² (other loads upon request)		
	**BARS PRODUCTION**		
	length	300 mm ÷ 14000 mm	11-8" ÷ 45'-11"
	length tolerance with encoder	± 5 mm (up to 6 m)	± 3/16" (on 19'8" bar)
	length tolerance with mechanical stop	± 2 mm (up to 6 m)	± 1/16" (on 19'8" bar)
	length tolerance with sensors	± 8 mm (fup to 6 m)	± 5/16" (on 19'8" bar)
	**STRAIGHTENING**		
	straightening system	hyperbolic rotors	
	diameter change	manual, through interchangeable rotors	
	quantity of interchangeable rotors included (other rotors on request at extra charge)	3	
	cutting system	flying shears	
	forward movement speed	0,6 ÷ 1,5 m/s	0,9 ÷ 1,5 m/s
		from 1.97 fps to 4.92 fps	from 2.95 fps to 4.92 fps
	**TEMPERATURE**		
	standard	+4° C / +40° C	39.2° F / 104° F
	**INSTALLED POWER**		
	maximum (other sizes on request)	41 kW	54.98 hp

THE PLANT REQUIRES THE USE OF AN AIR COMPRESSOR.

fy: maximum yield conventional limit – ft: maximum breaking point conventional limit

Note: #2 = 1/4" ; #4 = 1/2" ; #5 = 5/8"

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