



Cutting and shaping equipment

Syntax Line **25-28-32** Syntax Line **28M-32M**

Cutting and shaping equipment



MEP
the history of innovation



www.mepgroup.com

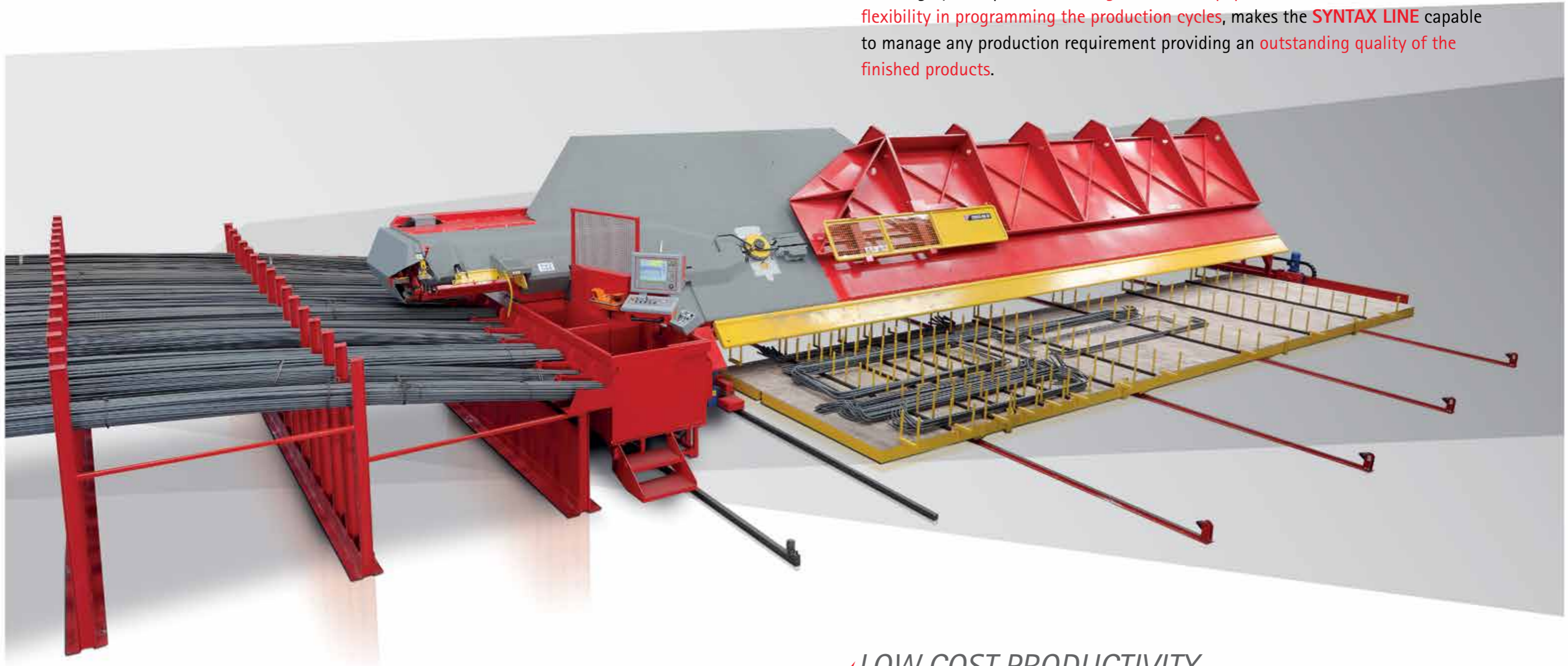


Syntax Line 25-28-32

Syntax Line 28M-32M

WE AUTOMATE THE REBAR PROCESSING

The **SYNTAX LINE** is a complete and fully automated cut and bend station for processing of stock rebar. The complete production cycle (loading, cut and bend) is conceived to be carried out in full automation, without requiring any manual handling by the operator. The large extent of equipment functions and the flexibility in programming the production cycles, makes the **SYNTAX LINE** capable to manage any production requirement providing an outstanding quality of the finished products.



LOW COST PRODUCTIVITY

The **SYNTAX LINE** high productivity performance is guaranteed both in case of large series production (repeated forms of the same diameter) as well as for processing of individual building elements such as beams, columns (different diameters, shapes and sizes), when the "classification" of production is a must. The adoption of a full automated cut and bend unit such as the **SYNTAX LINE** allows to use less machines, to reduce the workforce and therefore to cut the cost per unit of weight of the finished products.



Patented solutions for an unmatched precision

The **SYNTAX LINE** is specifically designed to cover all production phases, that traditionally require manual activity, in a very **fast and full automated process**.

There is **no slow-down** in production, all working **cycles are carried out continuously and perfectly optimized**.

Maximum productivity is guaranteed at any working load condition.

WE ALIGN EVERY SINGLE BAR

The **bar alignment device** is essential when working **double bar** because it **guarantees correct measurement tolerances**.

The device aligns the bars before they are counted and loaded into the machine, without compromising the productivity of the equipment.



PRECISE COUNTING MATTERS

The optional **automatic loading system** (patented) **selects** the diameter of the bars, **aligns** and **loads** 1 or 2 bars depending on the program list, thus creating a **continuous optimized working cycle**.

The device uses a mechanical arm equipped with magnets that lift the bars from the bundle.

A magnet **draws and counts every single bar with extreme precision**, avoiding counting errors (loading one bar instead of two) which would distort the quantities to be produced, as well as compromising the optimization already programmed.

The reliability of the working cycle is thus guaranteed.



Surely extracted

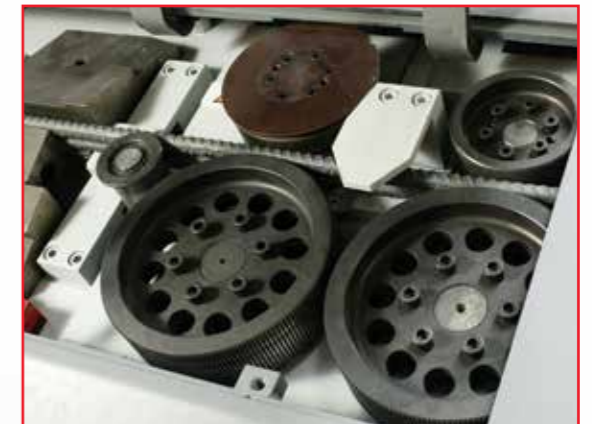
COMBINED FEEDING MULTIFUNCTIONAL METHOD



Two functions based on different technologies (the extraction feeding clamp and the roller infeed) are combined in the exclusive and patented "multifunctional feeding" system which pulls the bars with an extremely efficient control of the bar axial rotation. Stirrups are closed and large shapes processed in perfect planarity, reducing drastically the amount of discarded product.

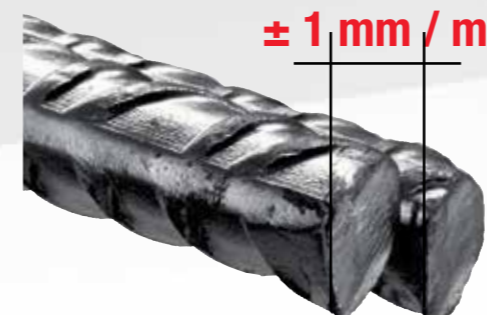
MAXIMUM PRODUCTIVITY

Once selected, the bars are dragged to the infeed roller group that, thanks to a feeding speed up to 3.2 m/s, ensures a very high productivity.



THE CLAMP DOES NOT SLIDE

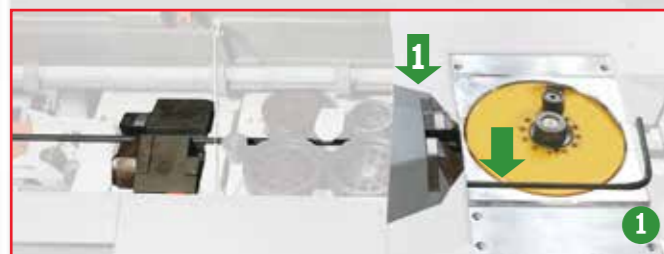
The feeding clamp can extract two bars out of the bundle avoiding any slippage and always respecting the measurement tolerances, regardless of the bundle quality and the processed bar diameter.



Two shears for maximum precision

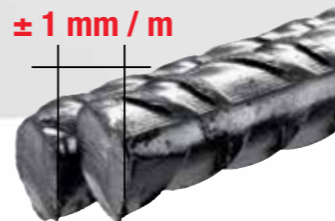
Generally the actual and exact length of stock rebars is not known, rather it is always longer than 12m or whatever is the nominal length.

Without having measured the length at first, it is uncertain to grant the tolerances on the following cut sequence. This patented method contemplates the use of two independent shears that ensure precision and maximizing the use of each individual stock rebar since the machine is designed to remove offcuts of any size.



While the first shear (1) makes the intermediate cuts (1), the second shear (2) cuts the tail of the bar (3) only after the achievement of the right development (2). In this way we avoid the classic method which provides a first alignment cut of the bars made completely random, which produces differences in the length not predictable.

$\pm 1 \text{ mm / m}$



UNIVERSAL BLADES



The two cutting units use universal knives, for all diameters processed with 4 cutting facets.

THE FASTEST BENDING PINS CHANGE



SYNTAX LINE is equipped with single block bending pins (patented) with self-locking device. They are made in accordance with the international regulations and allowing fast change at the same time as the diameter change a fast production restart.

SCRAP: NO MORE A PROBLEM



The scrap is managed according to its length. In case it is less than 700 mm, the end of the bar is cut and separated from the rest of the production by automatic collection in a dedicated outside bin. In the case of longer lengths, the piece is classified as offcut, then extracted and stored in a dedicated pocket of the mobile collection cart and prevented from being mixed up with the rest of running production. This process is full automated and it does not require any manual intervention by the operator with consequent downtime of the machine.

Secondary feeding unit: a patented system

A DOUBLE TRACTION FOR ANY SHAPE

The Secondary feeding unit lets you use a **patented method** that allow to produce shapes **bent on both sides** using one bending unit instead of two.

The **working cycle is considerably simplified and speed up**, having eliminated all the time related to transfer the wires at the second bending unit and those required for the change of two bending pins related bending angles calibrations.

NO RESTRICTIONS ON SHAPES AND DIMENSIONS

This **patented method** provides the simultaneous exit of the secondary feeding unit (1) and the bending unit (2) among the working plane, **avoiding the collision between the shape and the cutting unit (1 + 2)** during the pulling back progress.

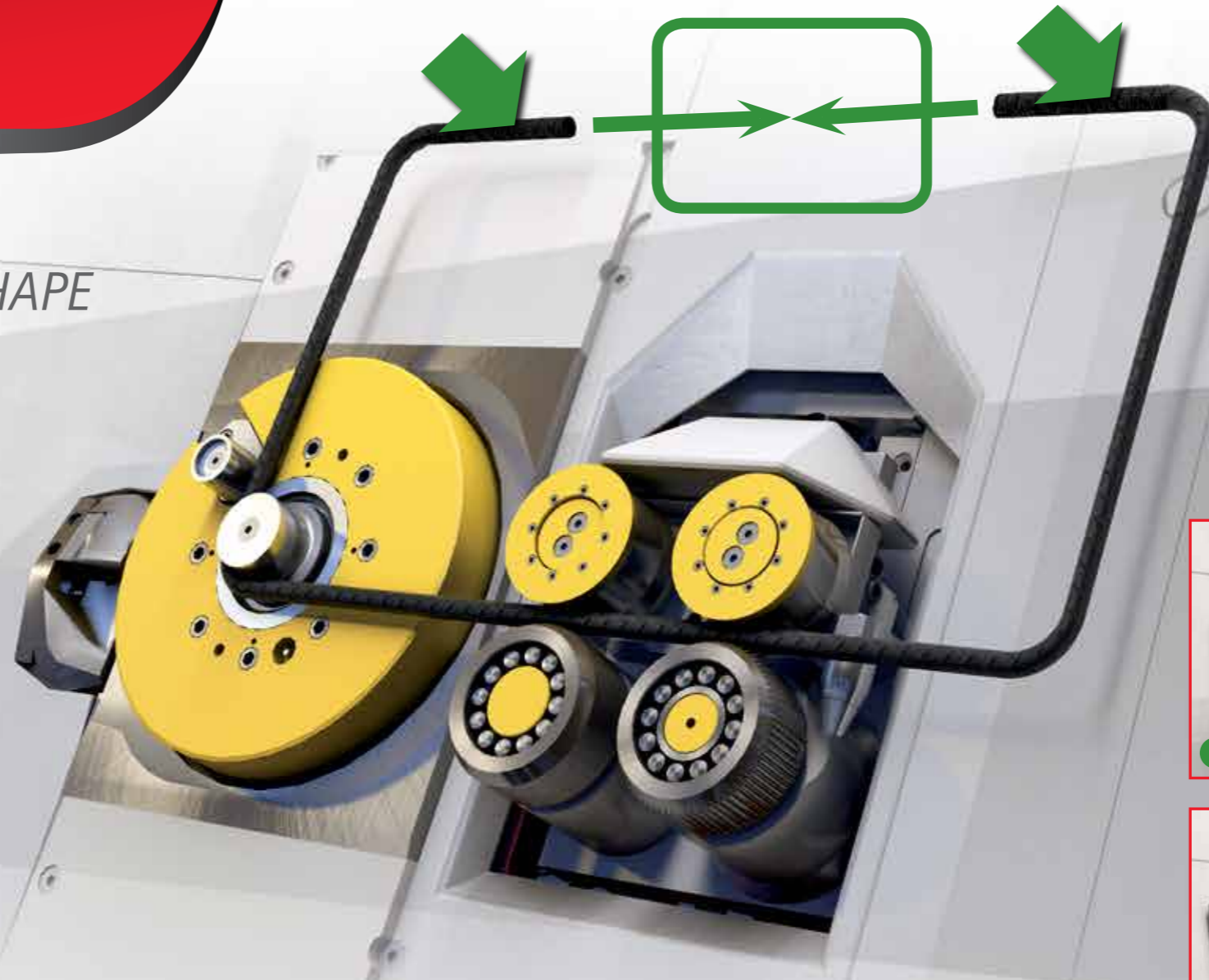
This solution enables the production of **shaped products of all forms and sizes** using **the entire working surface**.

GRAVITY FOR QUALITY

Exploiting the effect of **gravity** during the bending phase **we obtain shapes always coplanar**.

The rollers of the secondary feeding unit **open (1) and close (3) before each bend**, allowing the shape "to rely" on the work surface (2) and (4) as a result of gravity.

The subsequent bends will always aligned with those already executed, **canceling out** any residual phenomenon of rotation.



MANAGEMENT OF THE BUNDLES



The mobile holding rack allows the bundles' storage within 8 or more compartments that depending on the diameter to be processed aligns to the optional **automatic loading system reaching a continuous and automatic production cycle**. A **dedicated software** (available with the automatic loading system) **monitors the remaining quantity** of each compartment in order to plan the bundle loading for the completion of the programmed list.

In the **SYNTAX LINE 28M-32M** versions, **the machine automatically aligns itself to the bundle** according to the diameter and length selected. This way according to the optimized sequence, **bars of the same diameter having different lengths can be used**. The automatic mobile collecting cart, contextually but independently will line up allowing the discharge of the material produced in the selected compartment.



COLLECTING AUTOMATICALLY



The **automatic collection** devices allow to maintain an **high productivity level of the factory**, reducing the downtime normally required for the evacuation of the products produced.

The mobile collection cart allow the **selective separation** of finished products **according to the optimized list**. The process **automation** allows to **manage multiple open positions** (different sizes and shapes) that comes from the same bar, without any stop to the production cycle.



SAFETY AND ERGONOMICS



The combined feeding multifunctional method (extraction feeding clamp / roller infeed) allows to produce **coplanar shapes and stirrups always closed** making unnecessary the dangerous manual operator intervention during the bending phases. The **exclusive design of the tilted work surface** provided with a lower swinging device allows to **produce large sized stirrups and shapes** (a distance of 2300 mm between the central bending pin and the floor) in addition becomes **an intermediate storage level for all manufactured goods**. The operator always works in **optimal safety conditions** and in an **extremely ergonomic environment**.

WORLD SYSTEM: TOTAL CONTROL



The world system through an interface "user friendly" allows total control of all the devices of the equipment, enhancing performance.

- **MEP Industrial PC "World System" operator control panel is comprised of:**
 - LCD Touch Screen for the user friendly graphical visualization of all data.
 - Compact, "embedded" microprocessor with low power consumption and a compact flash disk with no moving parts (diskless).
 - Linux operating system.
 - Automatic backup saving system in case of accidental power interruption for safeguarding files and memory support integrity.
- **The custom software developed by MEP allows:**
 - Data input with graphic visualization of programmed and pre-memorized shapes with feasibility checks via a "dynamic simulation".
 - Control of all speed parameters in execution via a potentiometer.
 - Availability to program up to 7 different templates for each bar.
 - Availability to plan and automatically performs a sequence of different pieces together eg.: beams with variable pitch (optional).
 - Saving and archiving of data relative to work cycles and generation of daily production statistics (positions, diameters, times, weights, etc.).
 - Availability of cutting lists optimized creating automatic working cycles.
 - "Active diagnostic" system for a constant efficiency check of all machine devices.
 - Automatic activation of the scheduled maintenance program.
 - Interface compatible with optical bar code reader through RS 232 port.
 - USB connection port.
 - Possible to connect to Company Network through RJ45 Ethernet port (LAN port) or RS 232 port.
 - VPN Connection-ready for remote assistance via Internet (through Company Network).



ACCESSORIES



- **Third feeding unit**, (patented) for the extraction of the last bar segments L=850 mm. (OPTIONAL)
- **The mobile clamping device**, allow the production of shapes, with 180° angle bent with short side lengths. (OPTIONAL)

TECHNICAL AND PRODUCTION CHARACTERISTICS

		🇬🇧		🇺🇸
	SINGLE STRAND UP TO	SYNTAX LINE 25	SYNTAX LINE 28	SYNTAX LINE 32
	hot rolled, smooth or ribbed wire fy = 600 N/mm ² - ft = 700 N/mm ² (other loads upon request)	Ø 8 - Ø 26 mm # 2 - # 8	Ø 10 - Ø 28 mm # 3 - # 8	Ø 12 - Ø 32 mm # 4 - # 10
	DOUBLE STRAND UP TO			
	cold drawn, hot rolled, smooth or ribbed wire fy = 600 N/mm ² - ft = 700 N/mm ² (other loads upon request)	Ø 8 - Ø 16 mm # 2 - # 5	Ø 10 - Ø 20 mm # 3 - # 6	Ø 12 - Ø 20 mm # 4 - # 6
	DOUBLE BAR MINIMUM SQUARE STIRRUP DIMENSIONS			
	minimum with Ø 12 mm wire (optional bending pin)	350mm x 350 mm - 13-3/4" x 13-3/4"		
	maximum if clockwise maximum if counterclockwise (with eventual optional carter extension)	1500 mm x 1500 mm - 4"11" x 4"11" 3200 mm x 3200 mm - 10'6" x 10'6"		
	CENTRE FORMING TOOL DIAMETER			
	minimum maximum (other sizes upon request)	40 mm - 1 5/8" 200 mm - 7 7/8"		
	MAXIMUM DISTANCE BETWEEN CENTRAL BENDING PIN AND THE GROUND			
	standard optional upon request	2300 mm - 7-6" > 2300 mm - > 7-6"		
	MOBILE STORAGE RACK			
	8 compartments up to 12.000 mm length (other sizes and configurations available upon request)			
	MOBILE COLLECTION CART			
	8 +2 compartments with 12,000 mm length (other sizes and configurations available upon request)			
	OPERATING TEMPERATURE			
	standard optional upon request	-5° C / +40° C - 23° F / 104° F -15° C / +55° C - 5° F / 131° F		
	INSTALLED POWER			
	maximum (other sizes upon request)	27,6 kW 37 hp	37,7 kW 50.5 hp	45 kW

THE EQUIPMENT DOES NOT REQUIRE COMPRESSED AIR.

fy: Max. unit yield point - ft: Max. Tensile strength

Note: #2 = 1/4" ; #3 = 3/8" ; #5 = 5/8" ; #6 = 3/4" ; #8 = 1"

MEP

MEP Macchine Elettroniche Piegatrici
via Leonardo Da Vinci, 20
I - 33010 Reana del Roiale (UD) - ITALY
Tel. +39 0432 851455
Fax +39 0432 880140

MEP
ASIA

MEP Asia Co., Ltd.
1303 Ho, 301-Dong, Bucheon Techno Park
345 Sukcheon Ro, Ojung-Gu
Bucheon, Gyunggi-Do - SOUTH KOREA
Tel. +82 32 329 1956
Fax +82 32 329 1957

MEP
BRASIL

MEP Brasil Ltda.
COM. E SERV.DE MAQS.
Rodovia Sp-79, S/N Km 122 Bloco B
18170-000 - Liberdade - Piedade - Sp
Tel. + 55 11 2248-9800
Fax + 55 11 2248-9800

MEP
FRANCE

MEP France S.A.
8 bis, rue des Oziers
BP 40796 Zone d'Activités du Vert Galant
95004 St. Ouen L'Aumône FRANCE
Tel. +33 1 34300676
Fax +33 1 34300672

MEP
IBERICA

MEP Iberica
C/ Plàstic, 5 - Pol. Les Guixeres
08915 Badalona - Barcelona ESPAÑA
Tel: +34 934396800
Fax +34 934490013

MEP
NORD SERVICE

MEP Nord Service GmbH
Gewerbepark, 3
6068 Mills AUSTRIA
Tel. +43 664-88732022

MEP
NORTH AMERICA

MEP North America Corp.
11411 NW 122nd Street
33178 Medley
Florida United States Of America
Tel. +1 305 883 4385

MEP
POLSKA

MEP Polska Sp. z o.o.
ul. Józefowska 13/A
93-338 Łódź POLAND
Tel. +48 42 645 7225
Fax +48 42 645 7058

MEP
VOSTOK

MEP Vostok OOO
ul. Yasenevaya, 10, korp.1 kv.1
pos. Sosenskoe, der. Sosenki
142791 Mosca, RUSSIA
Tel./Fax: +7 495 745 04 90

www.mepgroup.com
sales@mepgroup.com