



Automatic Straightening Machine from coil

RH 13-16

Automatic Straightening Machine from coil



MEP

the history of innovation



www.mepgroup.com



RH 13-16

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 characteristics 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 achieved 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:**

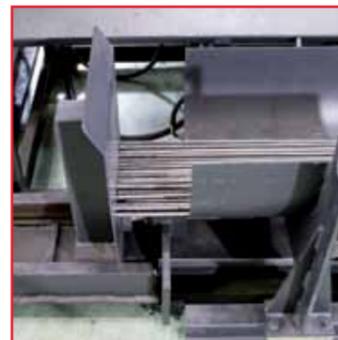
- Inputting bars production data and memorizing several batches to be produced in sequence.
- Displaying production status.
- Adjusting production speed and decoiler rotation speed through potentiometers.
- Control of all the machine parameters depending on the diameter used.
- Utilizing an "active diagnostic" 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).

PRODUZIONE			
1	Lotto n.	13	Sensore
4888	Lunghezza	8	Velocità
18	Diametro	8	Pezzi tot. fatti
1888	Pezzi tot.	8	Pezzi can. fatti
188	Pezzi can.	8	Pezzi can. fatti
8	Kg	8	na

OUTFEED CHANNEL WITH ALIGNMENT 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
	$f_y = 600 \text{ N/mm}^2 - f_t = 700 \text{ N/mm}^2$ (other loads upon request)	from # 2 to # 4	from # 2 to # 5
	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 (up 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"

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
BRASIL

MEP Brasil
Rua Bom Jesus da Cachoeira, nº 100
Parque Edu Chaves
CEP 02236-020 - Sao Paulo - BRASIL
Tel. +55 11 2240.4610 - 2240.4553
Fax +55 11 2240.4610 - 2240.4553

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
NORD-EUROPE

MEP Nord-Europe GmbH
Brienner Strasse 55
D-80333 München GERMANY
Tel. +49 089 41610829

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
Ул.Новаторов, 36 корп.3 Офис XXIV
119421 Москва Россия
Tel./Fax: +7 495 745 04 90

www.mepgroup.com
sales@mepgroup.com