



**ALPER  
ELEKTRONİK**

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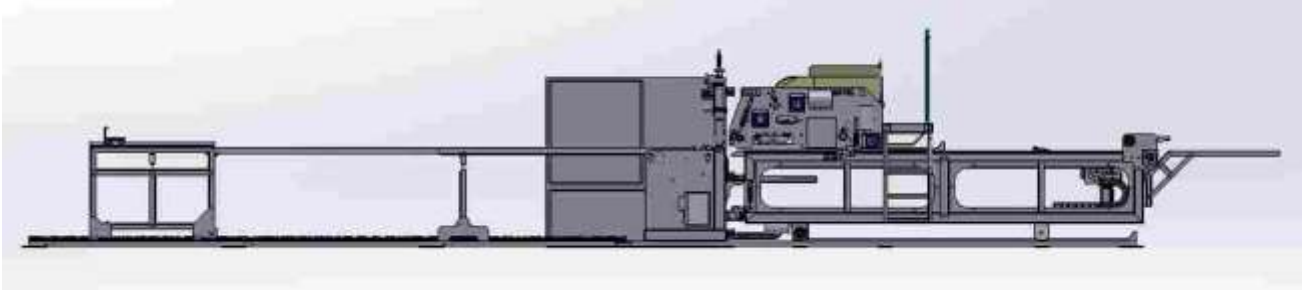
**BRAND : MESHMATIC**

**MODEL: HKM 24 S 10**

Width of the panel  
24- (2400mm)

Line wire feeding method  
S- (Automatic pulling  
From cross wire)

Weldable diameter  
10- max.10mm-10mm



Capacity :

Machine speed :	70 strokes per minute
Width of the panel:	2400mm
Lenght of the panel:	6000mm
Diam.of the crosswire:	4-10mm
Diam.of the line wire:	4-10mm
Space of cross wires:	50-300mm (adjustable on touch panel)
Space of line wires:	75-100-150-200-250mm

Needs :

Line Power	3x400V 630KVA
Cooling Water	Cooled, neutral, 80 liters per minute 1 -1/4"
Pressured Air	6 atm, 4 cubic meters per minute



Units of the Machine :

- 1) FEEDING MECHANISM OF LINE WIRES
- 2) WELDING UNIT
- 3) FEEDING OF CROSS WIRES
- 4) AUTOMATIC PACKING UNIT
- 5) ELECTRICAL CABINET

1) There are (max) 24 pcs magazines for line wires. The line wires inside the magazines can be throw to nozzles by manually pushing the table.  
When welding 8 mm line wires, you must use only 18 pcs magazines.

Feeding system:	Manually
Nozzles:	24 pcs

2) The welding unit includes upper and lower electrodes and 9 pcs 120KVA welding transformers. The line wires come on the upper electrodes and cross wires from magazine on the line wires connected to the magnets, then welding cylinders press, transformers send high current electrical power for welding.

Welding transformers:	9 pcs 120KVA
Welding press cyls:	24 pcs 90mm tandem
Valves:	24 pcs high flow
Upper electorde holders:	12 pcs 75-100mm 8 pcs 150mm 6 pcs 200-250mm
Welding bars :	24 pcs , water cooled cooper
Down electrode holders:	24 pcs water cooled
Magnets :	6 pcs (sensing capability)

3) The magnetic carrier takes a few cross wires to the mini magazine.

Servo motor activated seperator disc takes the cross wires one to one.

Pneumatic activattted strikers pushes the cross wire to the magnets

Capacity of the cross wire magazin :	600 kg
Motor of the magazin	1.1kw, AC
Motor for cross wires:	0.75kw Servo
Cross wire seperator:	4-8mm adjustable
Cross wire striker :	6 pcs

4) The panel pulling system has a servo carriage, on the linear guides. The grippers catch the cross wire and pull the panel step by step.

Pulling motor :	Servo
Carriage movement:	2700mm
Pense:	6 pcs pneumatic

5) Polyuretlan rolls pushes out the finished mesh panel.

Push out motor:	0.75kw AC
Push out rolls :	Polyuretlan coated , 8 pcs

6) There are 9 pair disc SCR in the cabinet. PLC and motor control system are connected together. The system can conect to internet by way of ethernet.

PLC:	Panasonic - Mitsubishi
Touch panel:	Delta -Mitsubishi
Inverters:	Mitsubishi
Servomotors:	Mitsubishi
Electrical components:	Schneider
Welding system:	PLC controlled SCR pairs 9 sets