



**ALPER  
ELEKTRONİK**

**HB ALPER ELEKTRONİK** MAKİNA San. Ve Tic. Ltd. Şti.  
Mersin-Tarsus Organized Industrial Zone 2. Street No:28 MERSİN/TURKEY  
Tel. +90 324 676 4486-87 Faks: +90324 676 4426 info@alperelektronik.com.tr  
www.alperelektronik.com.tr www.meshmatic.com www.collmatic.com

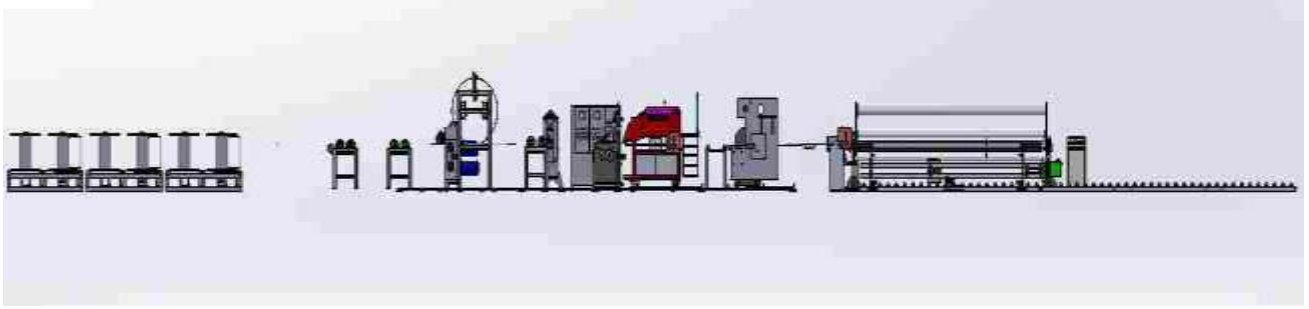
**BRAND: MESHMATIC**

**MODEL: HKM 24 C 08**

Width of the panel  
24- (2400mm)

Line wire feeding method  
C- (automatic from pulleys)

Weldable diameter  
08- max.8mm-8mm



Capacity :

Machine speed :	90 strokes per minute
Width of the panel:	2400mm
Length of the panel	6000mm
Diam.of cross wire:	4-8mm
Diam.of the line wire:	4-8mm
Space of cross wires:	50-300mm (adjustable on touch panel)
Space of line wires:	100-300mm

Needs :

Line Power	3x400V 400KVA
Cooling water	Cooled, neutral, 80 liters per minute 1 -1/4"
Pressured Air	6 atm , 4 cubic meter per minute



Units of the Machine:

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

1) Equipped by servomotor. 18 pairs feeding disks. Feeding length is adjustable on the touch panel. The line wires come from pulleys and continue into straightening unit and expansion unit.

Straightening Unit 1:	18 pcs rollers
Diam. Of the expansion guides:	Ø 1200mm
Expansion motor:	18 kw AC
Straightening Unit 2:	18 pcs rollers

2) The welding unit includes upper and lower electrodes and 6 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:	6 pcs 120KVA
Welding press cyls:	24 pcs 90mm tandem
Valves:	24 pcs high flow
Upper electrode holders:	12 pcs 75-100mm 8 pcs 150mm 6 pcs 200-250mm
Welding bars :	24 pcs, water cooled copper
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 separator disc takes the cross wires one to one.

Pneumatic activated strikers push the cross wire to the magnets.

Capacity of the cross wire magazine :	1000 kg
Motor of the magazine	1.1kw, AC
Motor for cross wires:	0.75kw Servo
Cross wire separator:	4-8mm adjustable
Cross wire striker :	6 pcs

4) The guillotine cuts the panel to determined length,

Cutting system:	Guillotine
Cutting motor :	11 kw AC



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5) Finished panel comes on the turning table by way of polyuretan rolls. The holders catch the panel. The table rotates when going up. The table waits at the top point. The new panel comes on the slides, the table start to go down. The slides let the panels to drop. Pneumatic activated walls align the panels. The panel quantity reaches to the programmed counts then the gate opens and conveyor starts to pack go out.

Push out system:	Polyuretan rolls
Push out motor:	1.1kw AC
Table motor:	4.5kw AC
Rotating motor:	1.1kw AC
Holders:	12 pcs pneumatic
Alignment:	4 pcs pneumatic
Gate:	2 pcs pneumatic

The position of the rotating table and the slides are adjustable for panel sizes, easy by using motors.

Conveyor:	6+6 12meters, Rolled
Motor for conveyor:	2,2 kw AC
Adjusting motors:	0.75kw 3 pcs AC

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

PLC:	Panasonic - Mitsubishi
Touch panel:	Delta -Mitsubishi
Inverters:	Mitsubishi
Servomotors:	Mitsubishi
Electrical components:	Schneider
Welding system:	PLC controlled SCR pairs 6 sets