

Second-hand wire mesh welding line SCHLATTER type “MG24/303” for the production of mesh sheets for concrete reinforcing.

This welding line, is composed by:

- N. 26 horizontal pay-off
- Guide and control line wire
- Line wire straightening unit
- Line wire pull-off and balancing unit
- Line wire straightening unit
- Line wire advance system (roller advance)
- Welding machine
- Cross wire feeding system
- Line wire shear
- Turning and stacking unit
- Table of motorized rolls
- Consoles and electrical cabinet

The machine frame/body is from 1990, however this machine was continuously updated in these years, for example, there were changed “LAR” and “Turning and Stacking unit”.

And in 2003 it was mechanically overhauled. Electrical parts were changed in 2011, so they are substantially new and the SIEMENS S7 300 PLC was installed.

Working procedure: the line wires are pushed by spools and cross wires pre-straightened and cut to length are fed to welding machine one after the other automatically.

Working range:

Longitudinal wire diameter	4 – 8 mm
Cross wire diameter	4 – 10 mm
Max. number of longitudinal wires	24
Min. longitudinal wire spacing	Variable from 100 mm
Cross wire spacing	Variable from 50 mm in increments of 0.1 mm
Width of wire mesh	Max 2500 mm Min. 1400 mm
Wire mesh length	Max. 6000 mm Min. 4000 mm
Weight of the mesh sheet for turning and stacking Stack height	Max. 200 Kg Max. 600 mm
Wire material	Type SAE 1006 – SAE 1016
Working speed max.	110 strokes per minute