

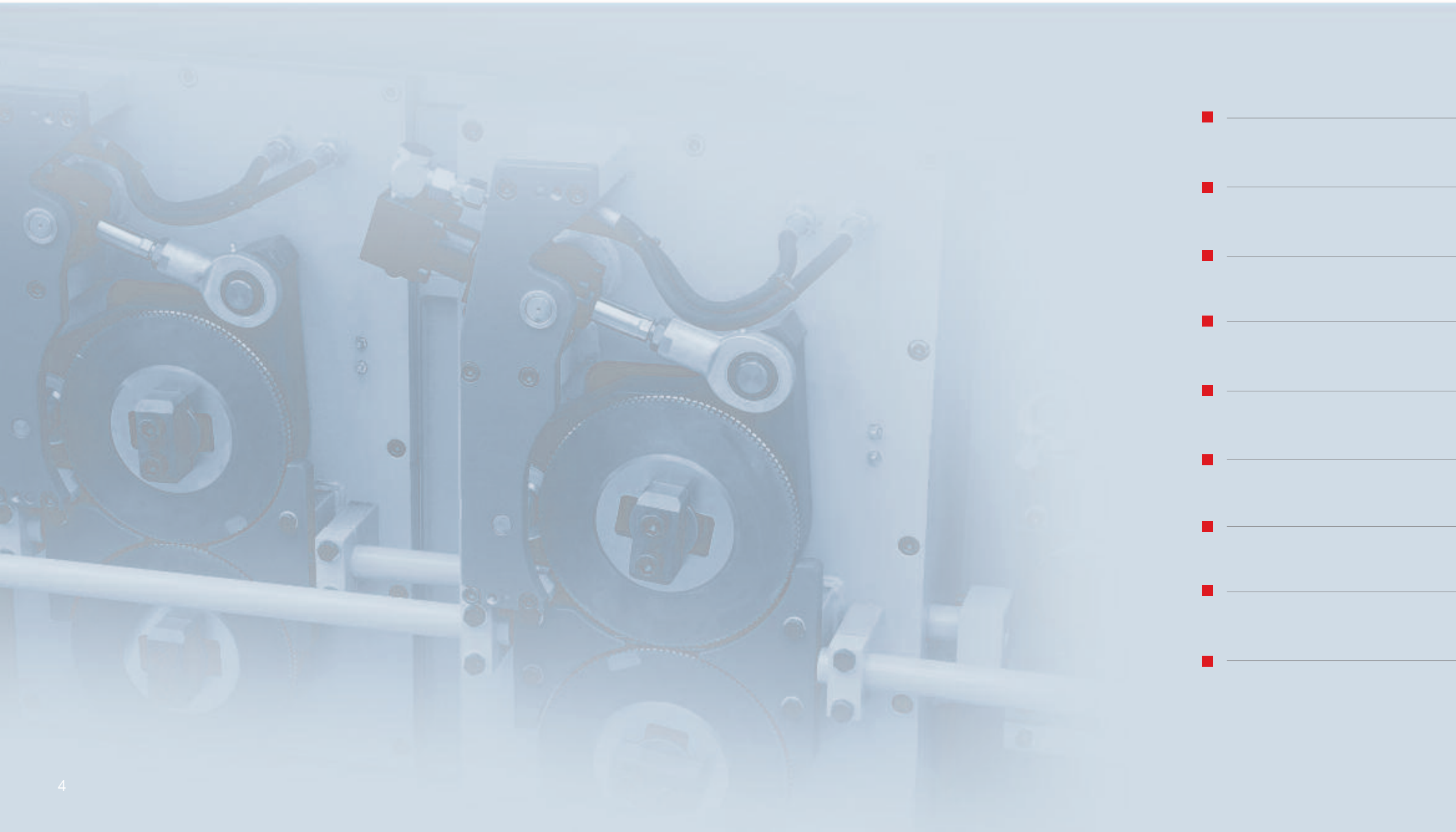
ATT

Reinforcing Mesh Welding Lines



Entwicklungs- und Verwertungs-Gesellschaft m.b.H., Raaba-Austria

Wire Mesh Welding Lines ATT



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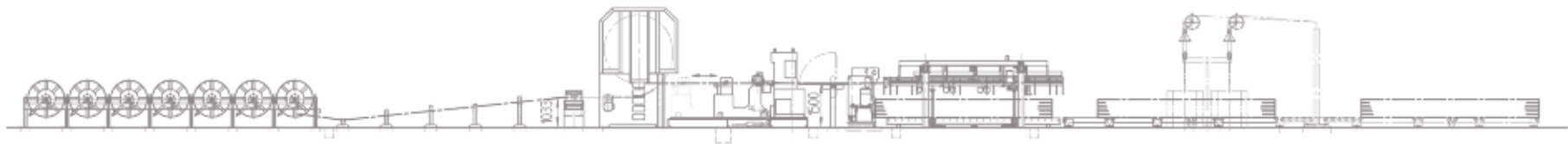
Technical Data



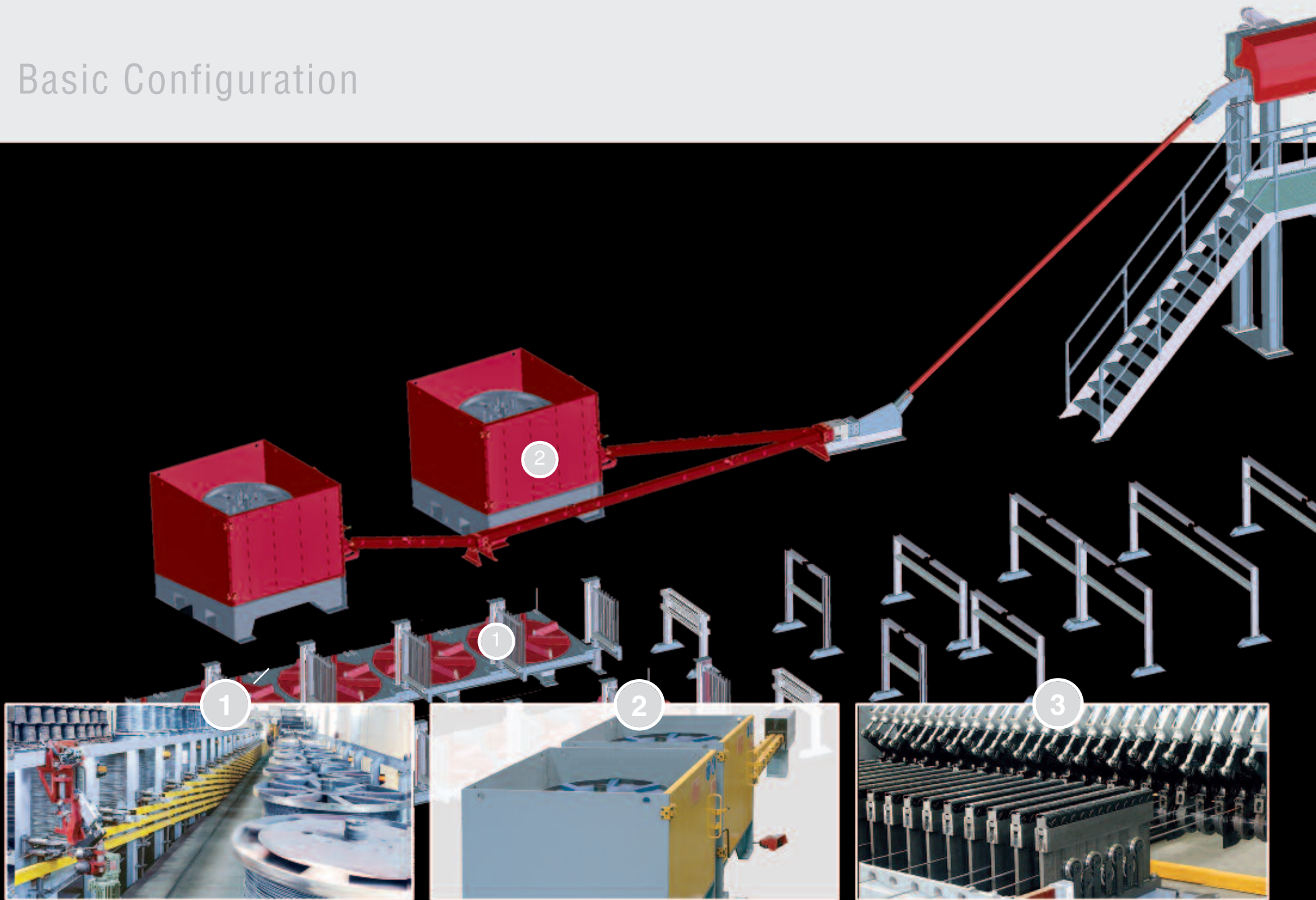
- Fully automatic welding lines for the production of standard reinforcing mesh in sheets and rolls. Programmable feeding and welding of cross wires above and below the line wires, thus, turning of sheets is not required.

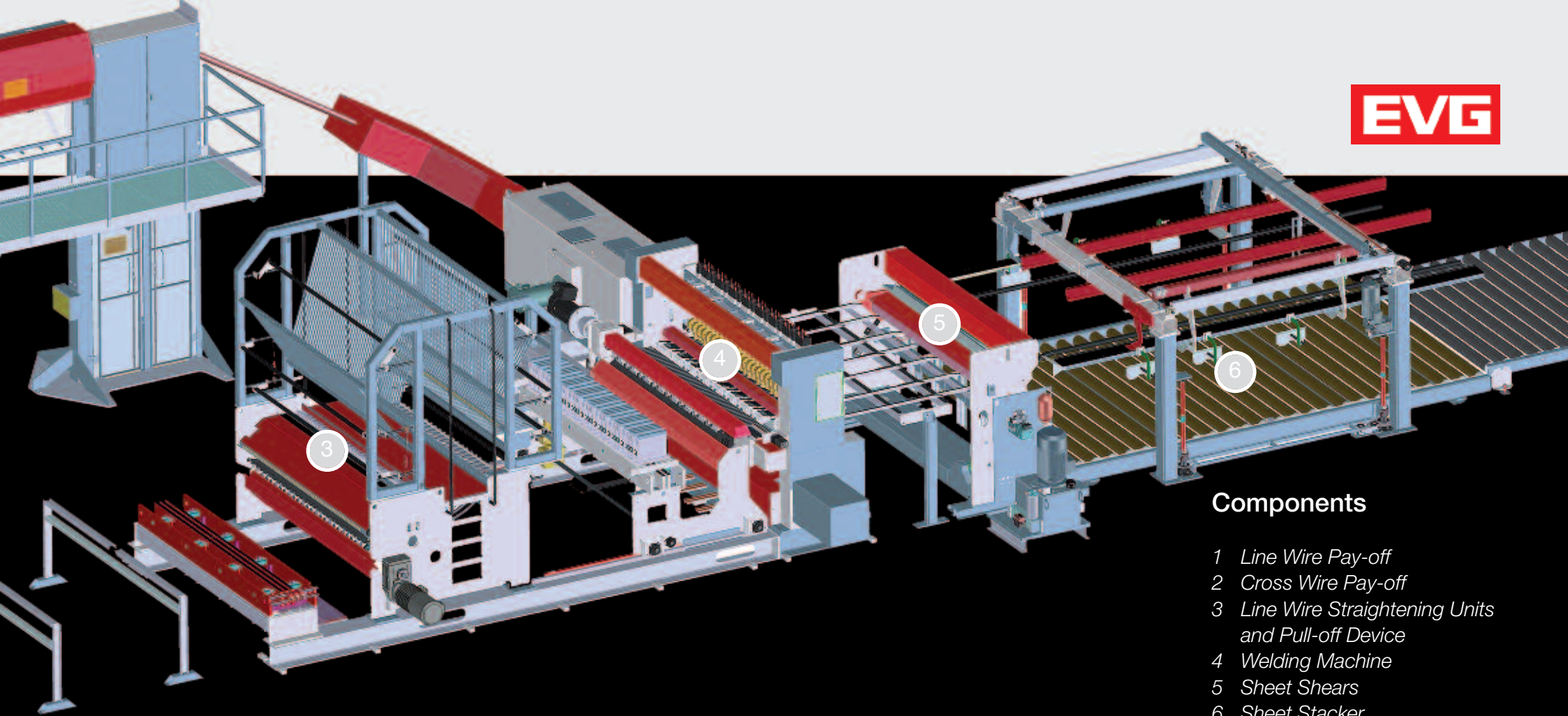
The technical data refer to standard welding lines which, however, can be adapted to our customers' specific requirements.

		ATT 8	ATT 10	ATT 12
Welding width	mm	2.400, 2.600, 3.200	2.400, 2.600, 3.200	2.400, 2.600, 3.200
Line wire:				
Diameter range	mm	3 - 8	4 - 10	5 - 12
Spacings	mm	(50), 100, 150, 200	(50), 100, 150, 200	(50), 100, 150, 200
Cross wire:				
Diameter range	mm	3 - 8	4 - 10	5 - 12
Spacings	mm	50 - 400	50 - 400	50 - 400
Max. total diameters	mm	16	20	24
Max. working speed	cw/min.	180	180	180



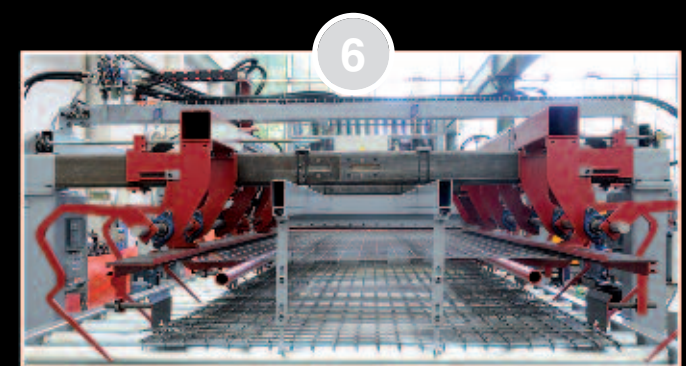
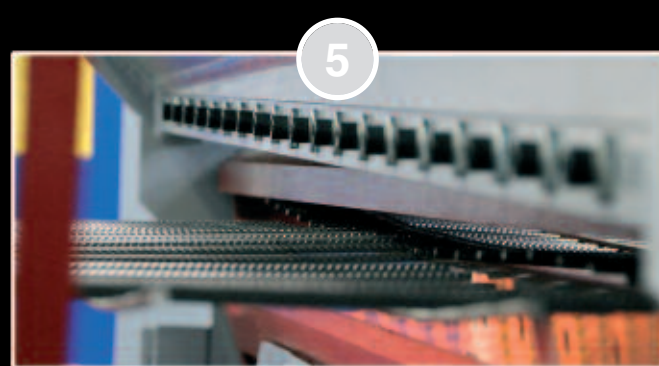
Basic Configuration

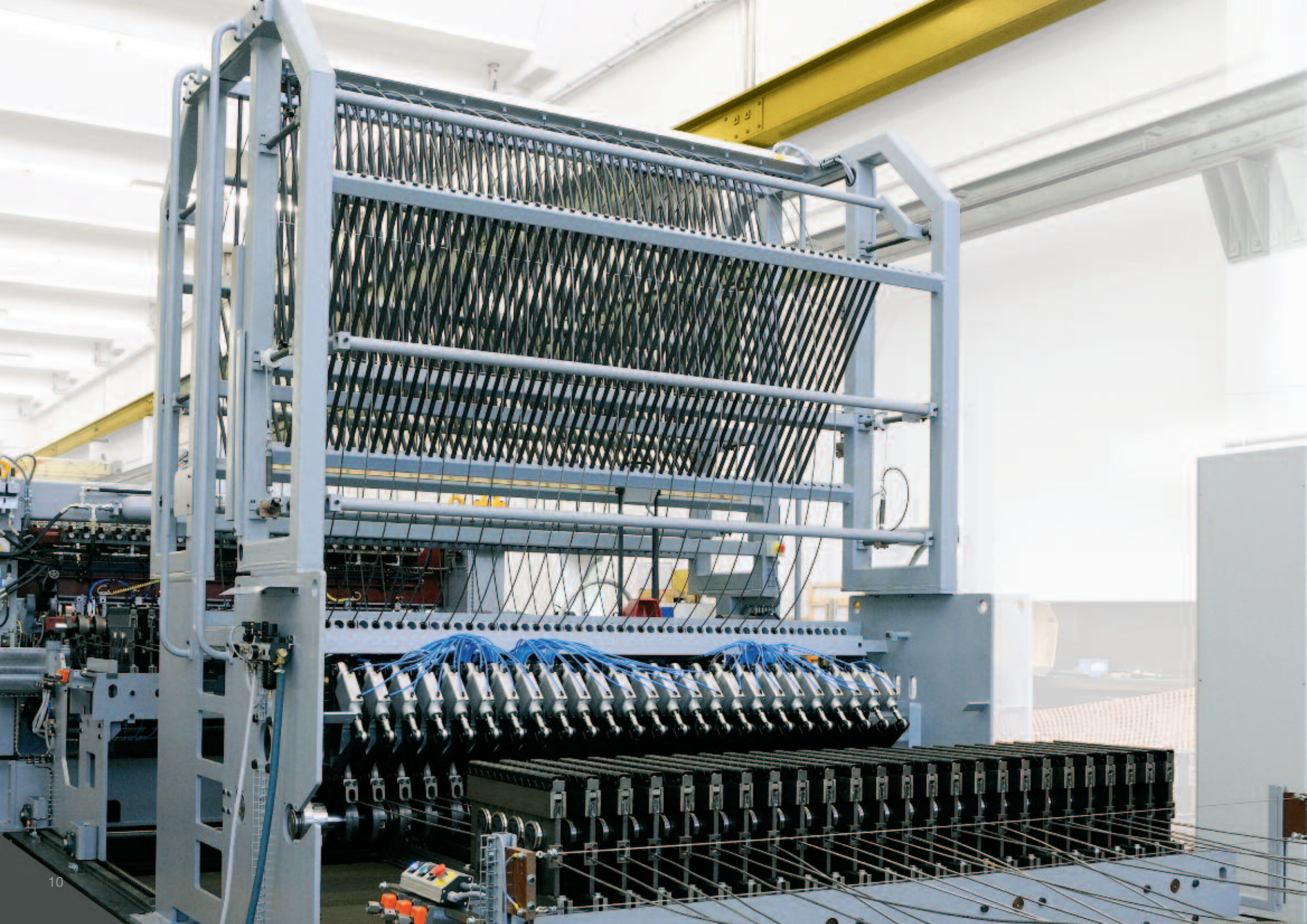




Components

- 1 Line Wire Pay-off
- 2 Cross Wire Pay-off
- 3 Line Wire Straightening Units and Pull-off Device
- 4 Welding Machine
- 5 Sheet Shears
- 6 Sheet Stacker with Lifting Table





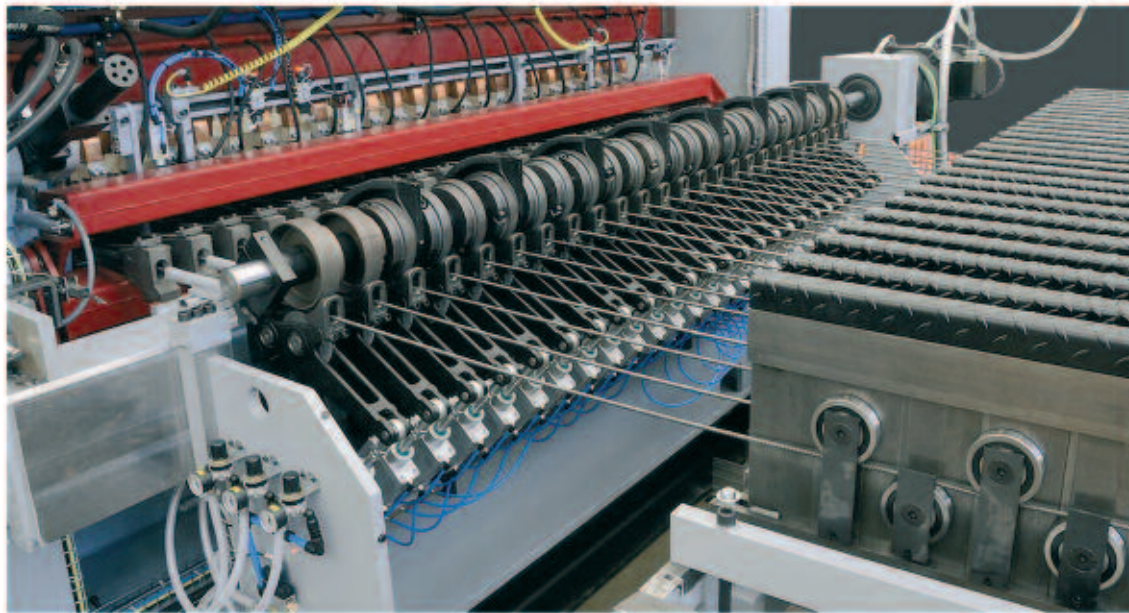
Line Wire Feeding



■ Line Wire Pull-off Device and Straightening Unit

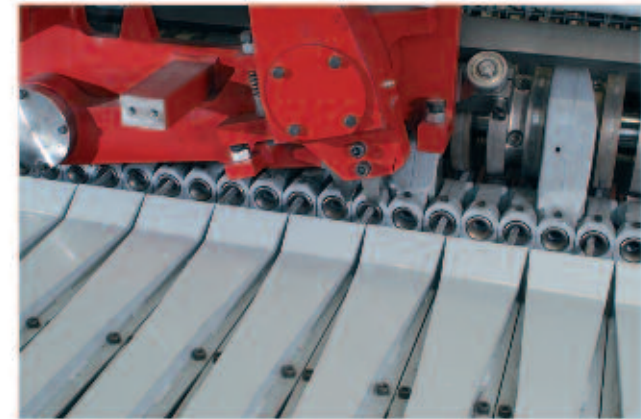
The line wires are pulled off automatically from spools or coils. The use of a loop accumulator ensures continuous pull-off of wires despite the intermittent operation of the welder.

Centrally and individually adjustable straightening units ensure optimum sheet quality even when producing sheets with large line wire overhangs.



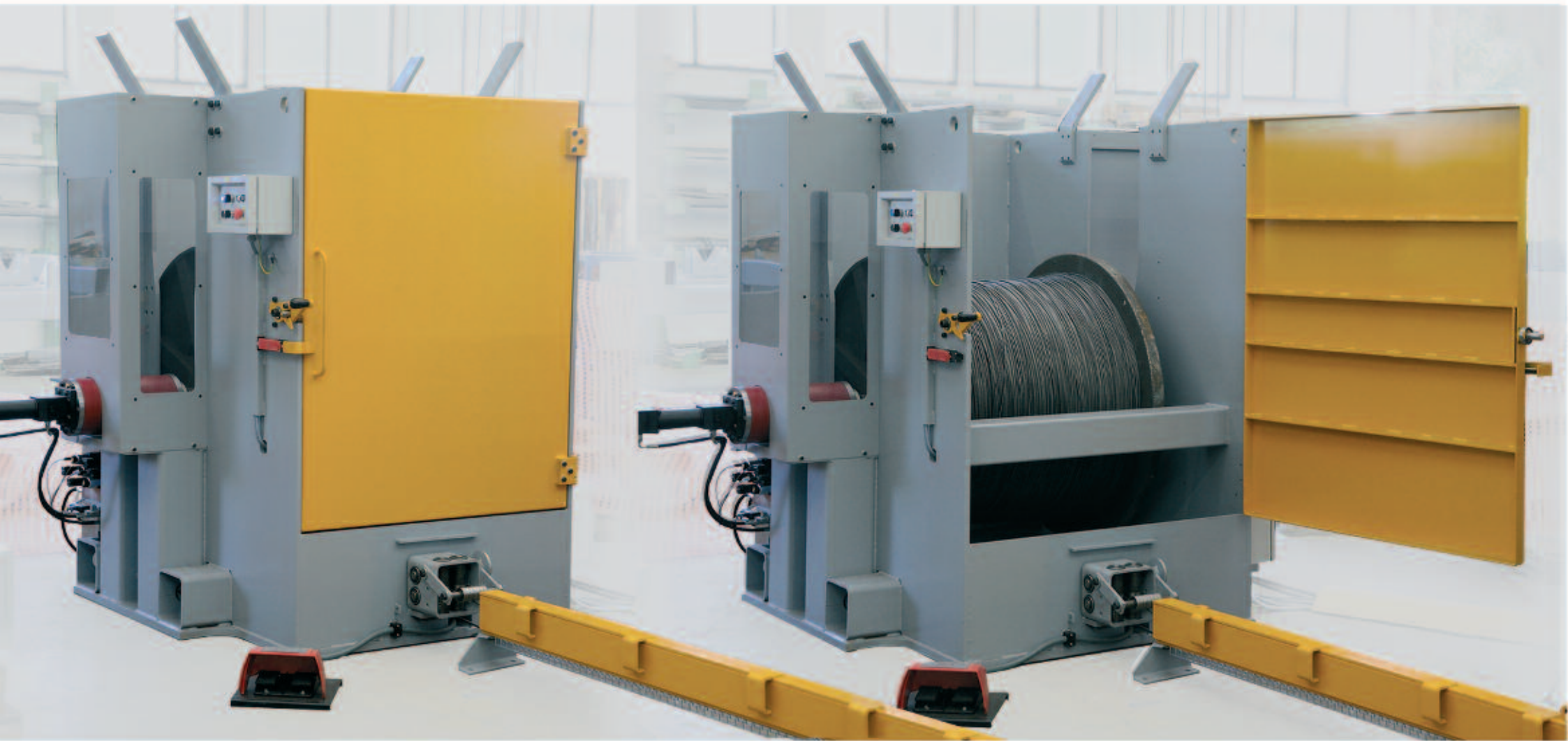
■ Roller Advance System

Maximum advance speeds are achieved by a servo-electrically driven roller advance system.



■ Line Wire Switch System

The optional execution of the line with a line wire switch system ensures continuous production during butt welding of line wires.



■ **Cross Wire Pay-off**

Available with horizontal or vertical spool axis

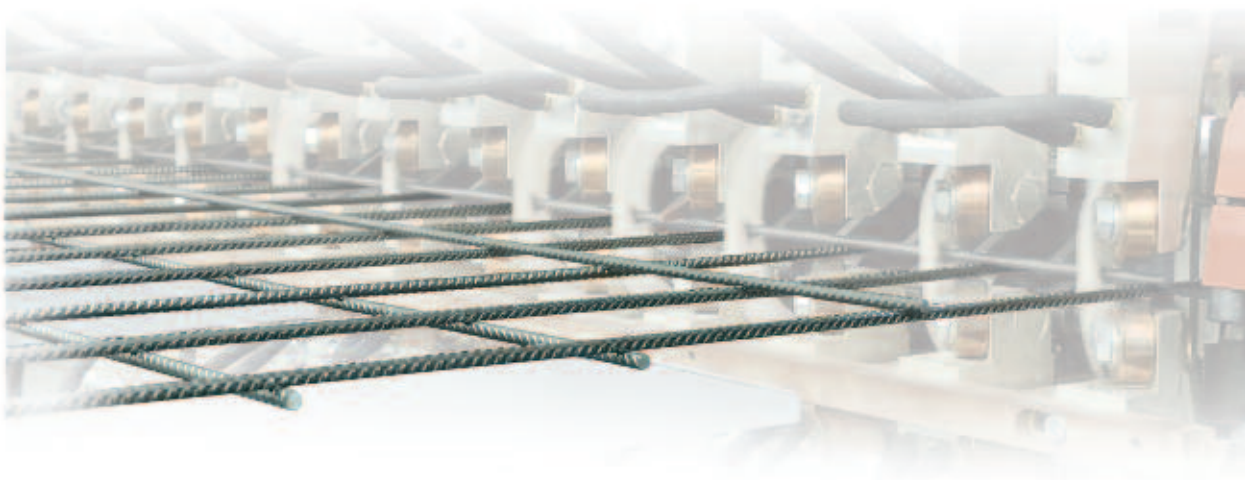
Cross Wire Feeding



- The cross wires are shot-in above or below the line wires. The highly dynamic electric servo drive of the cross wire shoot-in system allows working speeds of up to 180 cross wires per minute.

Thanks to this patent protected technology the turning of sheets is no longer necessary.

On account of the compact arrangement of the cross wire shoot-in channels and of the welding dies, cross wire feeding needs a very short distance only, both to the top side and to the bottom side of the line wires.



- **Cross Wire Pull-off Device**

With loop accumulator available in horizontal or vertical design



Welding Machine



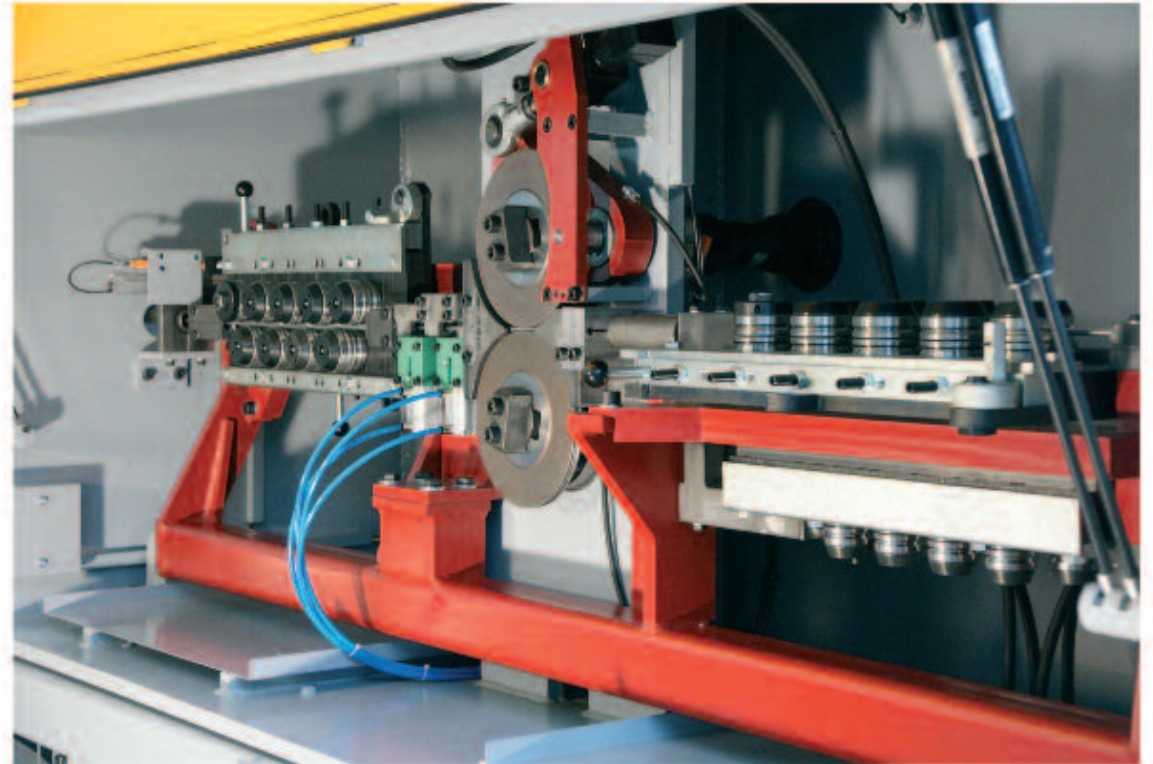
■ Welding Units

The electrode beam is equipped with hydraulically actuated welding units. This design ensures very tight control of the welding process and, as a consequence, minimum welding cycle times.

The single point welding units are connected firmly with the transformers via busbars. In case of a change of line wire spacing, the welder will hence be changed over fully-automatically. No modification of current bridges and no change of polarity is necessary.

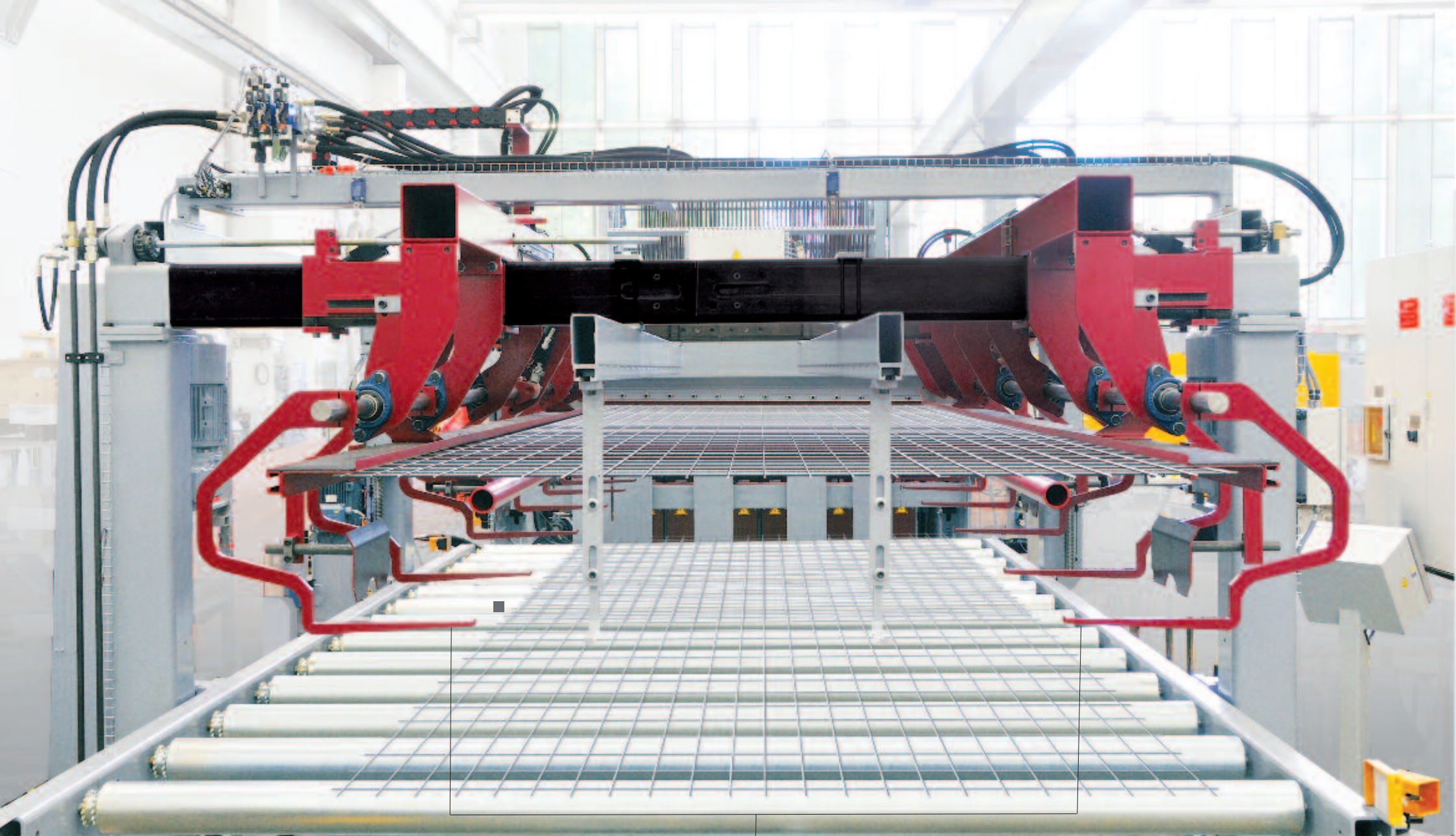
Cross wires are welded alternatively to the top side or to the bottom side of the line wires.

Maximum service life of electrodes is obtained by optimized welding pressure control (compression before and after welding).



■ Cross Wire Shoot-in Mechanism with Switch System

An optional cross wire switch system ensures continuous operation during butt welding of cross wires and helps to improve efficiency of the welding line significantly.

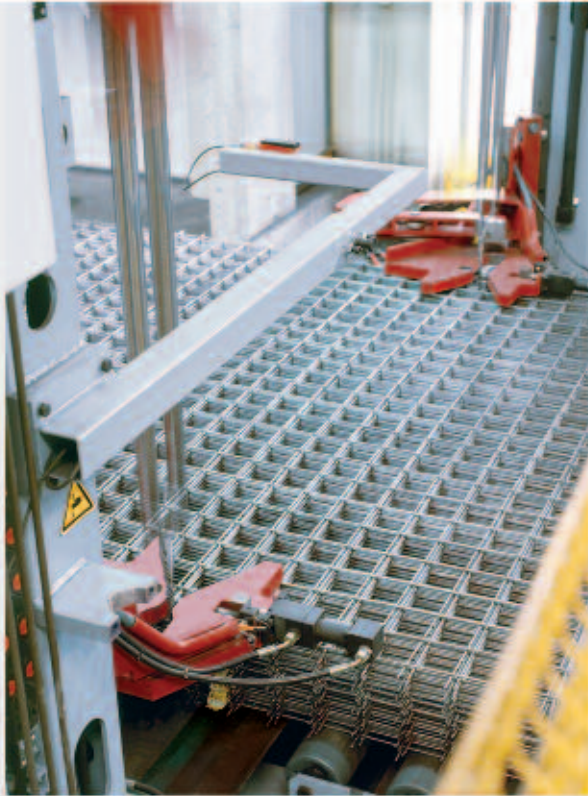


■ Sheet Stacker

After being cut by the shears, the mesh sheets are stacked automatically. Extremely short cycle times also for short mesh sheets and compact arrangement without the need of a sheet turner.

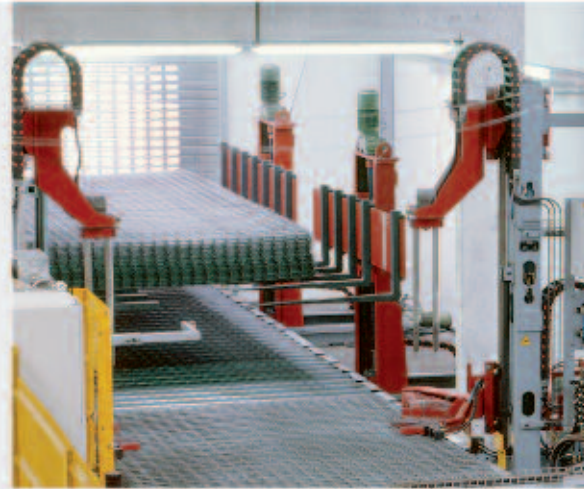
■ Intermediate Collector

Sheet stackers equipped with the optionally available intermediate collector allow for continuous production without any interruptions while the sheet stacks are being discharged.



■ Automatic Tying Station

For the fully automatic tying of sheet batches after the programmed number of sheets has been produced.



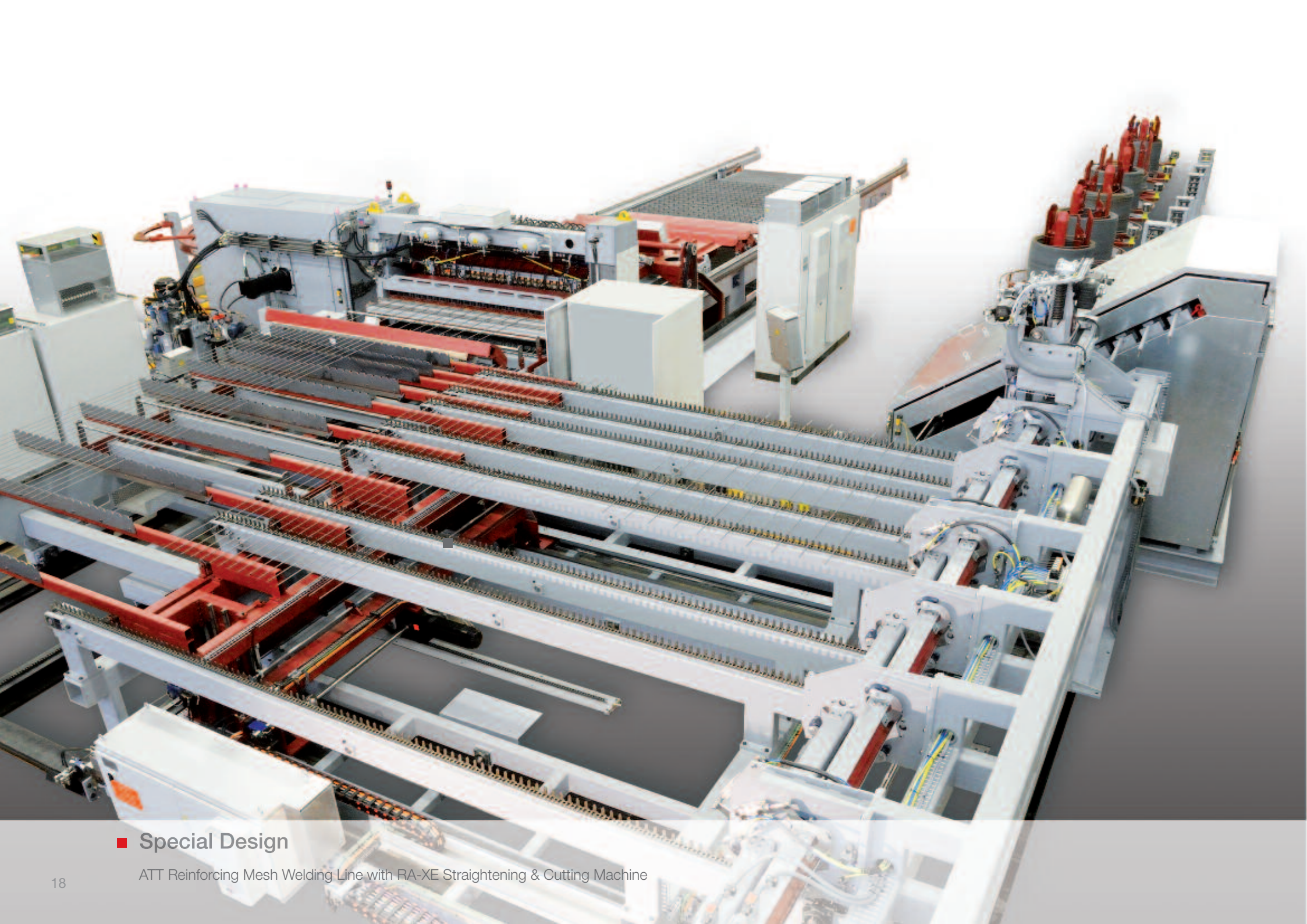
■ Mesh Pile Stacker

Precise and efficient stacking of sheet batches.



■ Roll Take-up Machine

Production of mesh rolls. Mesh coilers of different automation levels are available.



■ **Special Design**

ATT Reinforcing Mesh Welding Line with RA-XE Straightening & Cutting Machine

Technical Data



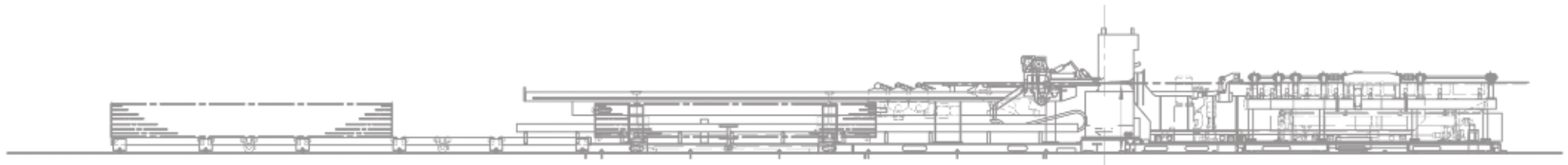
- Highly flexible welding plant for the cost-effective production of standard and special sheets from small batches to large production volumes, working in fully automatic mode with line and cross wires fed from coils.

This plant features high production speeds and the shortest changeover times to varying sheet styles and sheet geometries.

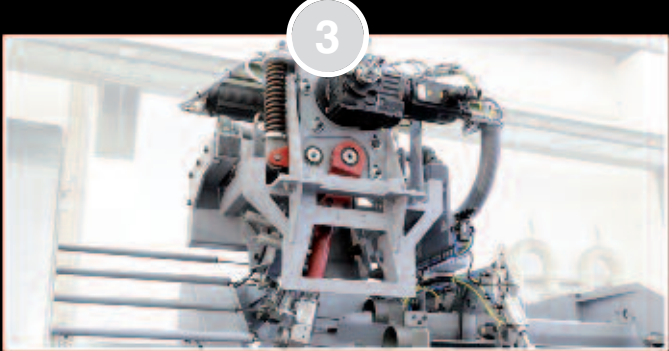
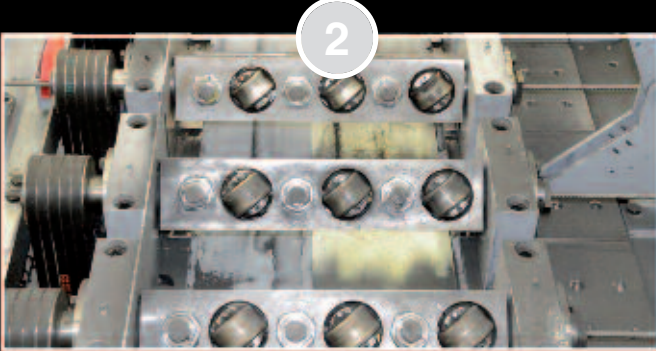
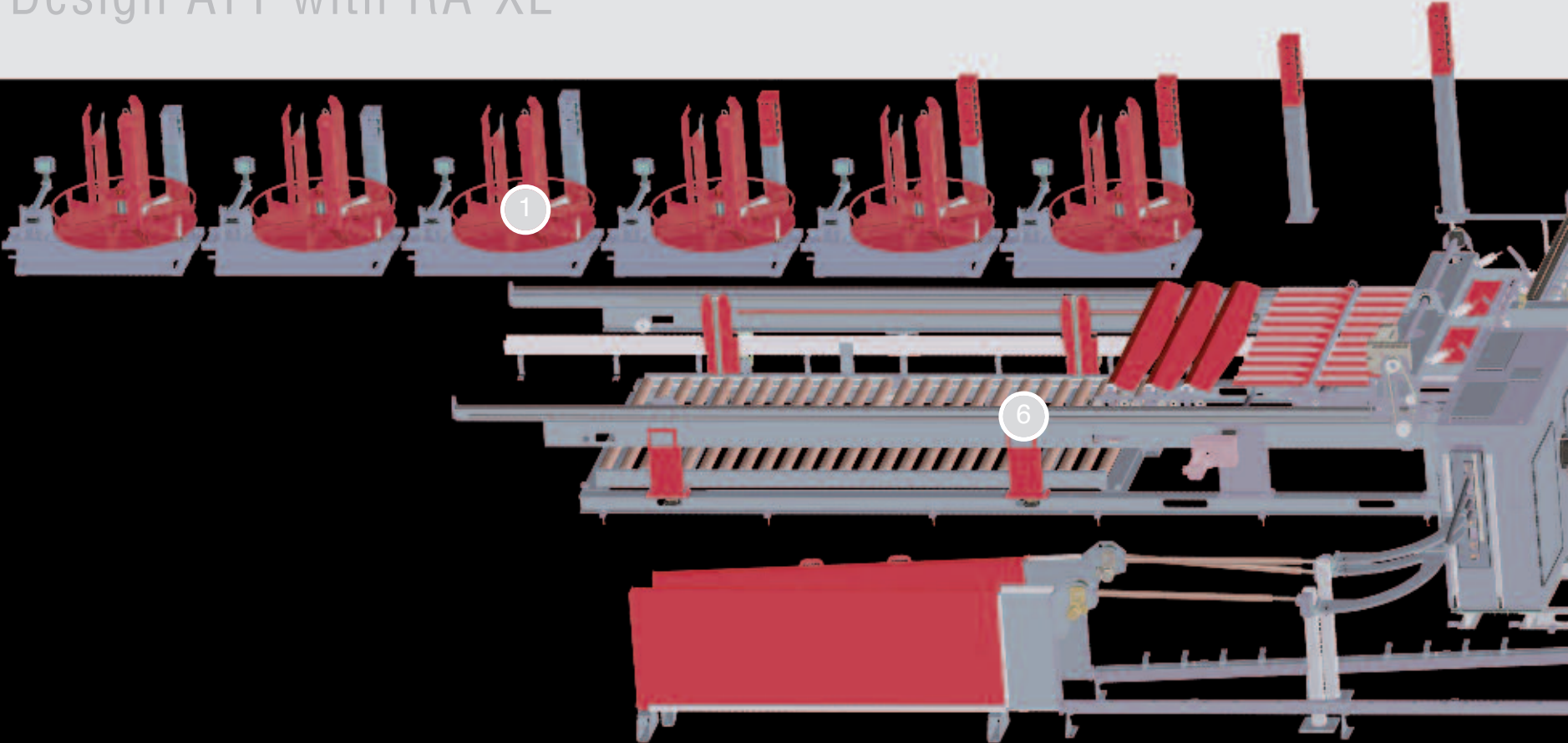
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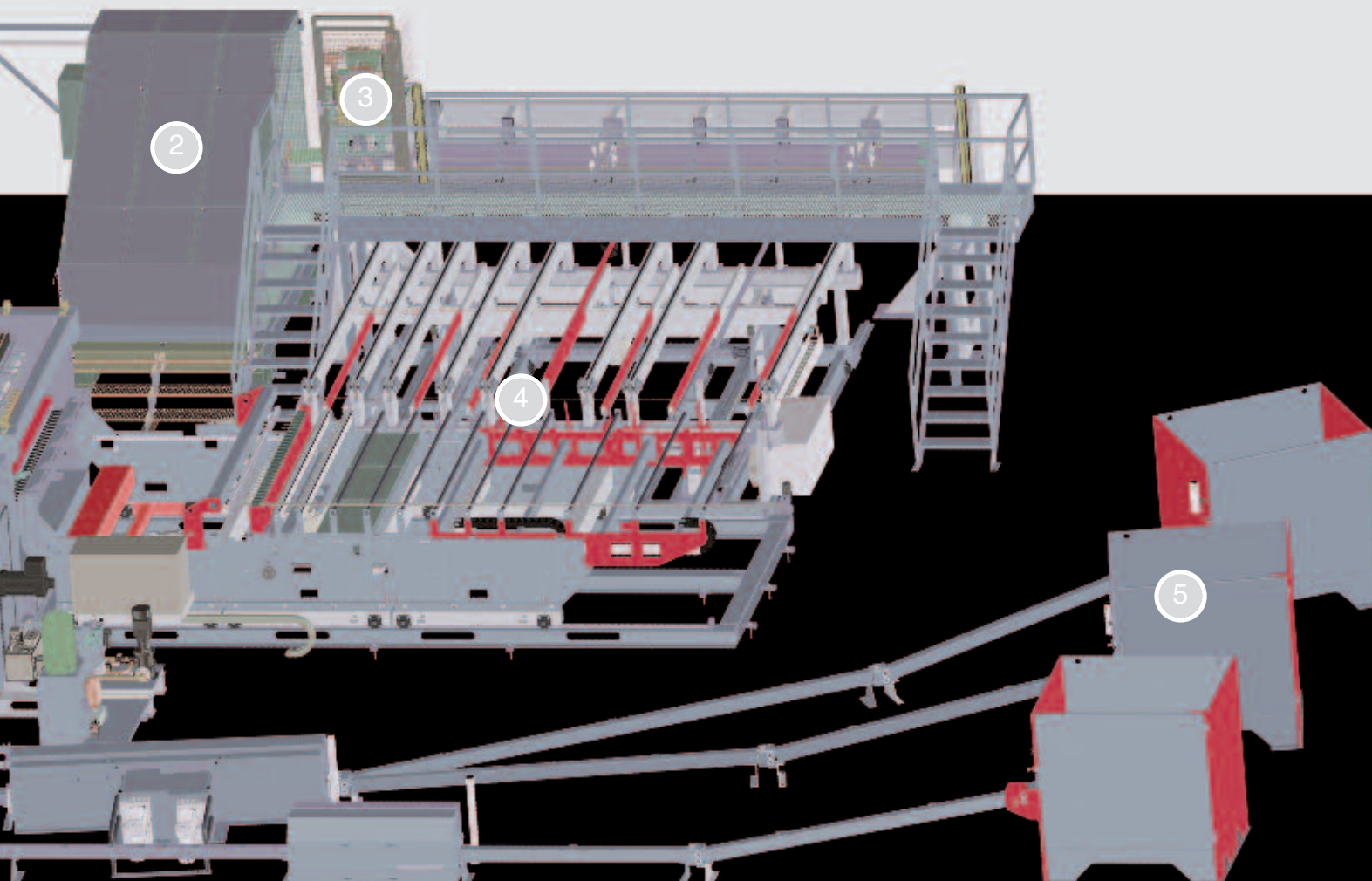
			ATT 10 with RA-XE 12	ATT 12 with RA-XE 12	ATT 13 with RA-XE 13
Welding width	mm		2.600, 3.200	2.600, 3.200	2.600, 3.200
Line wire:					
Diameter range	mm		6 - 12	6 - 12	6 - 13
Spacings	mm		50*	50*	50*
Cross wire:					
Diameter range	mm		(4) 6 - 10	6 - 12	7 - 13
Spacings	mm		50 - 400	50 - 400	50 - 400
Max. total diameters	mm		22	24	26
Max. working speed	cw/min.		150	150	130

* Larger line wire spacings in steps of 50 mm



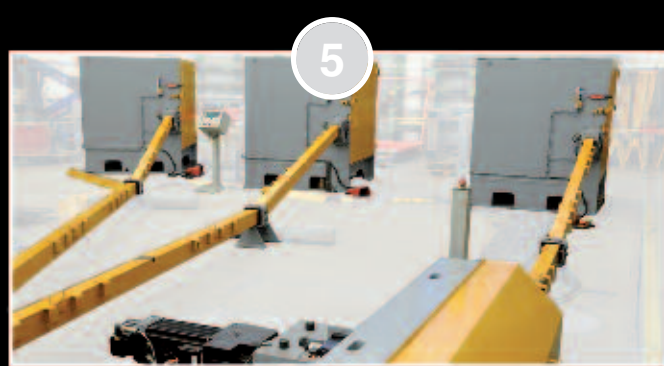
Special Design ATT with RA-XE





Components

- 1 *Line Wire Pay-off*
- 2 *Rotor Type Straightener*
- 3 *Flying Shears*
- 4 *Line Wire Distributor*
- 5 *Cross Wire Pay-off*
- 6 *Sheet Stacker*

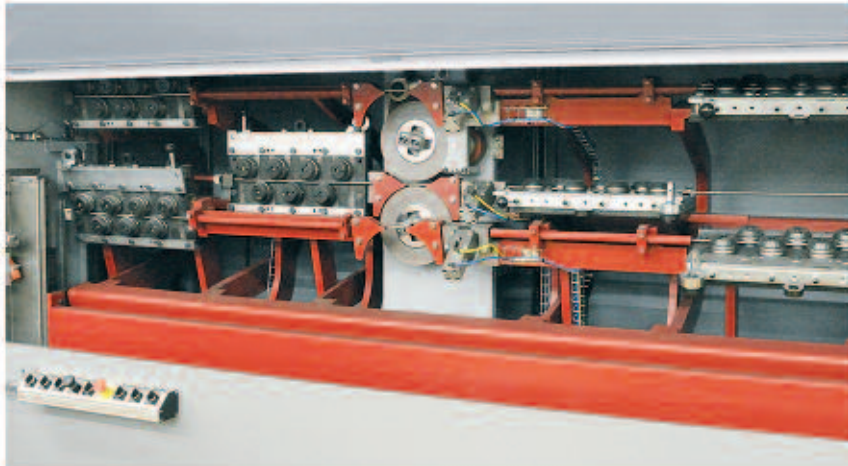


Function Principle



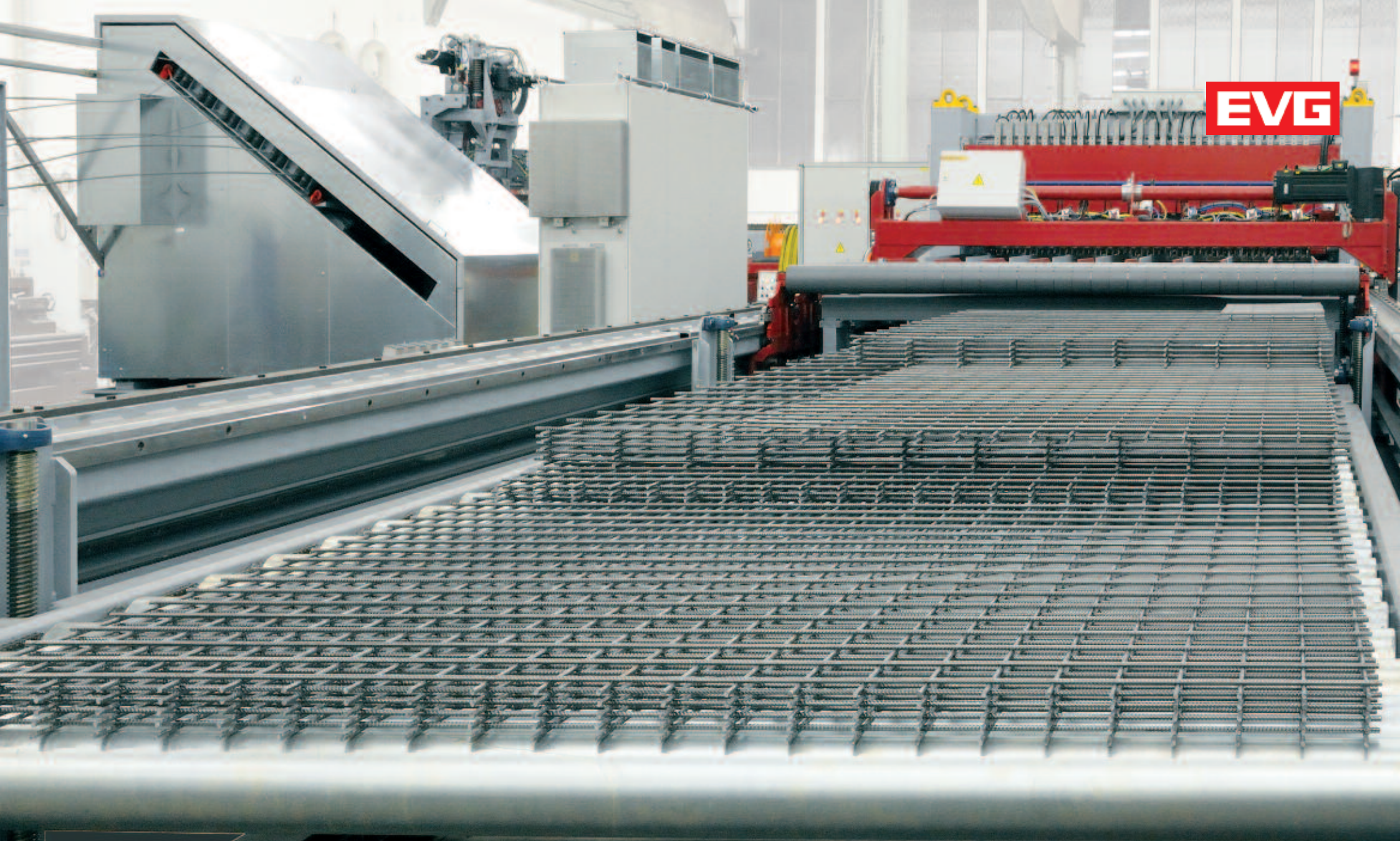
■ Line Wire Straightening & Cutting

A multi-strand rotary straightening machine type EVG RA-XE is synchronized logistically with the ATT welder to produce straightened and cut-to-length line wires just in time.



■ Cross Wire Shoot-in Mechanism

Cross wires are produced by means of a multiple-strand, cross wire feeding system which allows automatic switching between different wire sizes.



■ **Sheet Stacker**

Automatic stacking of sheets with varying geometries



Welding Line Control System



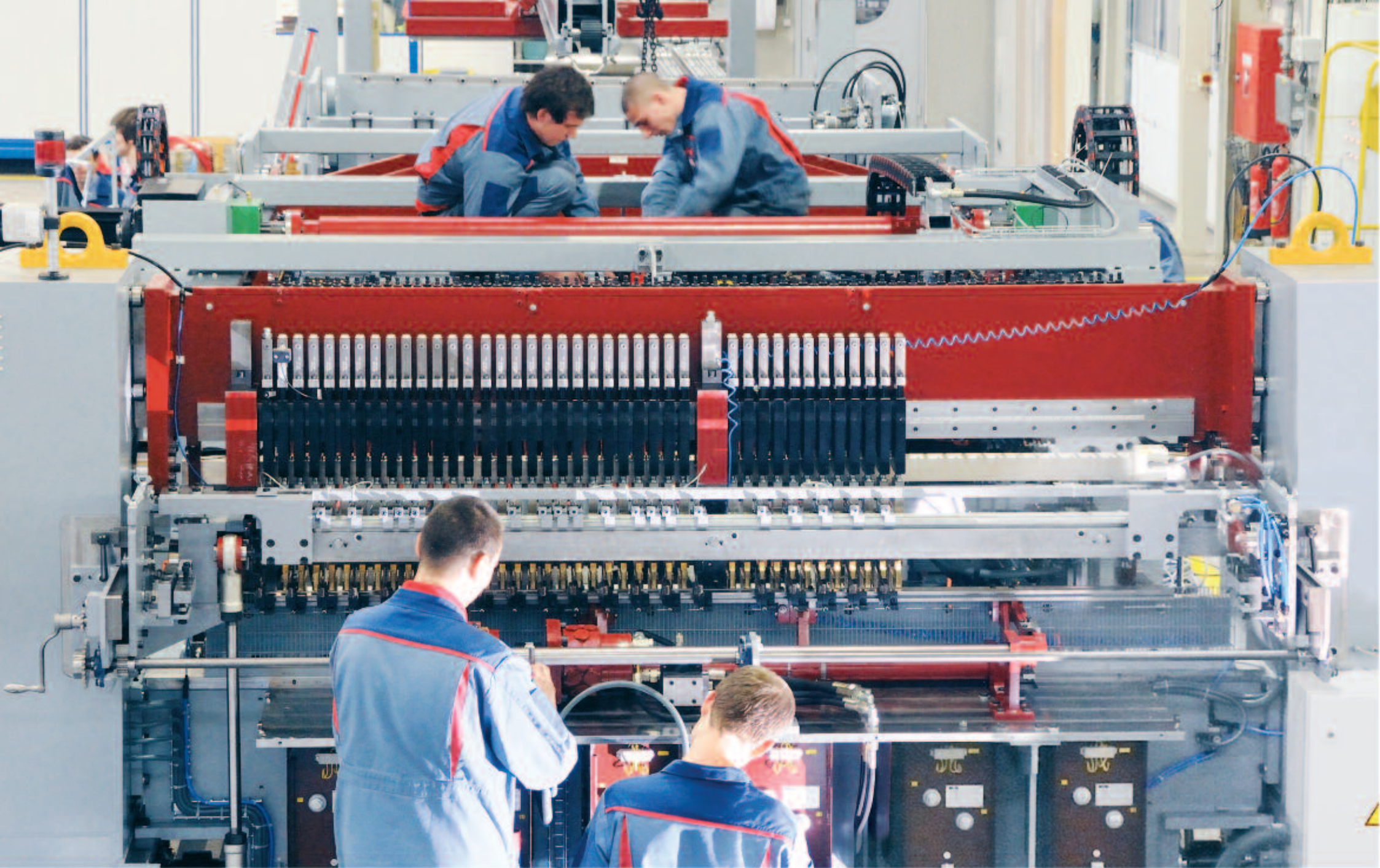
■ Control

The control system ensures the fully automatic operation of the entire production line. Easy handling through central data input via an input computer of state-of-the-art industrial PC design. Monitoring of the line via a diagnosis program with plain text display. Tabular input of product

data, production lists, welding parameters and line-dependent functions. Graphical representation of sheet types.

Owing to an integrated network communication feature it is possible to execute telemaintenance at the line.





Competence



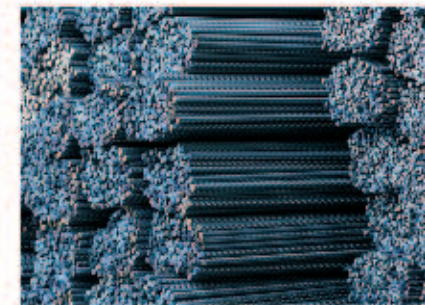
■ Group of Companies

The group of companies EVG - AVI - MARIENHÜTTE with its complete program for the production of reinforcing steel and welded mesh is your reliable and experienced partner when it comes to reinforcement of concrete, wire products, production equipment and knowhow.

- EVG and FILZMOSER as suppliers of complete production lines
- AVI and BSTG as producers of reinforcing steel sheets, cold-rolled reinforcing steel, truss girders, spacer strips and reinforcing cages
- Steel and rolling mill MARIENHÜTTE as producer of reinforcing steel
- H&S Zauntechnik as supplier of industrial and fencing mesh as well as complete fencing systems

The cooperation within our network of companies allows EVG to become aware of all major challenges inherent in the production and application of mesh and reinforcing products also from a machine operator's point of view. Any knowledge gained this way is constantly introduced in our new projects.

The most important foundations of our success are close co-operation with our customers based on partnership, highly-qualified staff and ongoing innovations.



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Subject to modification.

„The pictures shown are of exemplary nature and do not allow to draw any conclusions on the configuration of the line acquired by the buyer.“