

WELDED WIRE MESH MACHINE

MODEL: BW2M01

BY

BOKADIA WIRES

Quality product every time

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» HIGH PRODUCTIVITY «

» EASY OPERATION «

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WELDED WIRE MESH MACHINE MODEL – BW2M01

TECHNICAL DETAILS

1.1 Application of Machine:

Manufacturing of Welded Wire Mesh in sheets and rolls form with MS or GI wire pulled directly from coils.

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1.2 Welding Range:

Line Wire Diameter: 1.60 mm – 6.00 mm

Cross Wire Diameter: 1.60 mm – 6.00 mm

Wire Diameter	Min Line Wire Spacing
3.15 X 3.15 mm (or Less)	25 mm
4.0 X 4.0 mm (or Less)	50 mm
6.0 X 6.0 mm (or Less)	100 mm

1.3 Working Range:

Mesh Width	Max 2000 mm; Min 500 mm
Center distance between the two outermost line wires	Max 2000 mm
Line wire Spacing	From 25 mm to 250 mm
Cross Wire Spacing	From 10 mm to 150 mm

1.4 Working Speed:

Maximum speed of machine is 70 strokes per min. However, the speed of machine depends on various factors namely, wire straightening quality, spacing between wires, wire diameter.

1.5 Material:

Material should be of fusion quality. Low carbon & un-alloyed steel is highly recommended. However, commercial quality of wire available in market can also be used till certain extent.

1.6 Working Procedure:

The line wires are pulled from coils and cross wires pre-straightened and cut to length are fed to the welding stations one after the other automatically.

1.7 Electrical Connection:

Three Phase Current	415 V, 50 Hz
Circuit Breaker	400 Amps

1.8 Welding Transformers:



Nominal Rating of each transformer	100 KVA
Secondary open circuit Voltage	7.5 V
Connection Voltage	415 V, 50 Hz

1.9 Cooling Water:

Inlet Temperature	Max 30 Degree Celsius
Pressure	4 Bar
dH Value	8
Ph Value	7 – 8
Quantity	Approx 150-200 Ltrs/Min
Recommended Water Pump	Kirloskar GMC 116

1.10 AC Drive:

Comprising of 7.5 HP AC Induction Motor with AC frequency drive for speed regulation of the main welder unit.

1.11 Method of operation:

Line wires are pulled through collet table with a predetermined length (distance between cross wire) and cross wire are dropped by a highly reliable system of wire dropper. Fusion of line wire with cross wire is done by resistance welding transformers which is controlled by micro-processor based digital welding controllers.

1.12 Key Features of our machine:

- 1) Rigid, robust and very accurately machined body structure which gives unmatched performance and mesh of superior quality and finish.
- 2) Highly reliable cross wire dropper system.
- 3) All moving part suspended on roller bearing, no use of brass.
- 4) Precise control of wire fusion.
- 5) Higher visibility of all the welding points enables greater control.
- 6) Ergonomically designed space for easy in operation.
- 7) Temperature sensors are provided at every heat generation points and in occasion of over heat the machine automatically stops and prevents undue damage to machine and electrical systems.



1.13 SCOPE OF SUPPLY:

The following equipment will be supplied and will be a part of machine/plant:

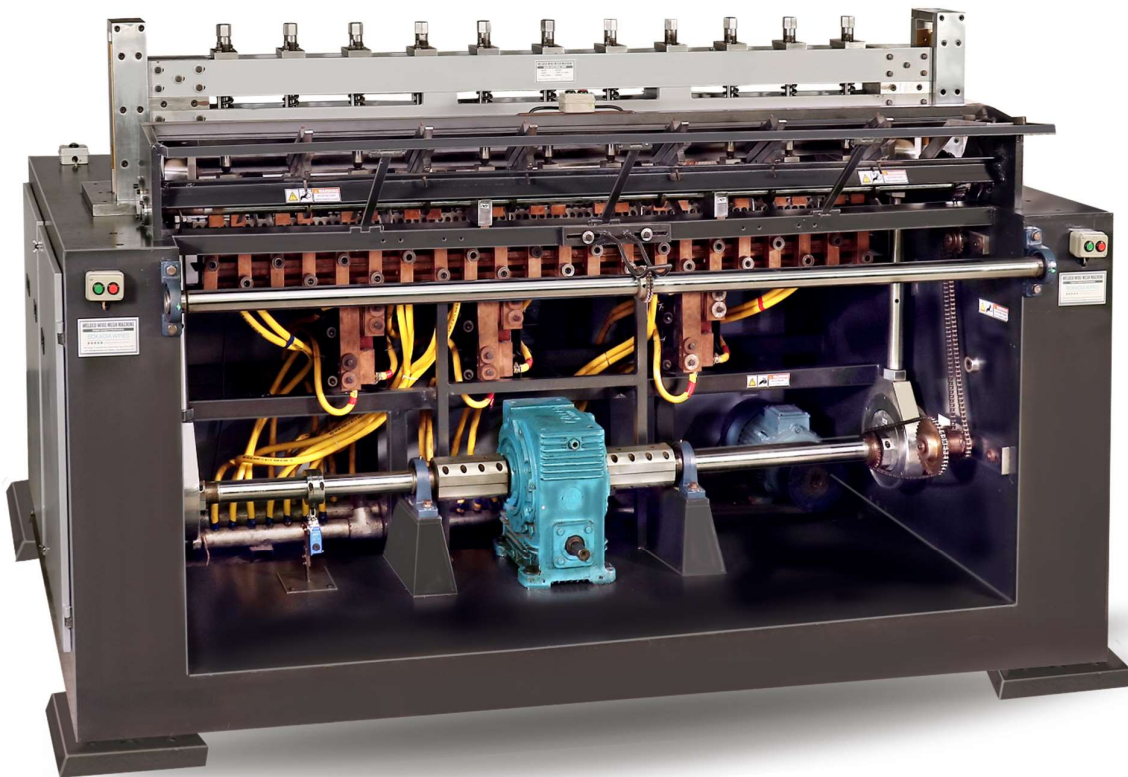
1) **Main Welding unit: 1 unit**

This will comprise of 3 resistance welding transformers, automatic cross wire dropper and automatic long wire feeder. Page | 3 of 7

The Dimensions of machine is as follows: 3100(L) X 1575(W) X 1770(H)

The following accessories will be supplied and will be a part of main welding unit:

- a) Pressure heads along with welding bridge: **16 units**
- b) Upper bank holder with electrode: **16 units**
- c) Lower bank holder with electrode: **16 units**
- d) Wire pushing collets upto 3.0 mm wire: **30 units**
- e) Electromagnets : **7 units**



Main Welding Unit (Model: BW2M01 / BW2M51)



2) **Welding Control Panel: 1 unit**

Welding control panel is separate from main welding unit and is responsible for controlling the welding time and welding power.

Control panel is divided into three sections and follows principles of micro-processor control which is the most advanced and precise form of controlling welding. Our new design of control panel has in-built MCCB of 630 Amps with a fuse unit and power distribution arrangement. The new design requires less cable for power distribution.



Thyristor Based Micro-processor Welding Control Panel (Model: BW630V1800A)

3) **Line wire straightener: 2 units**

4) **Pay-off: 30 units**

30 payoff units capable of loading 2 coil each of 50kg each. The total payoff unit will be capable of holding 60 line wires.

5) **Repair Welding Machine: 1 unit**

It comprises of a resistance butt welding transformer, 1 welding gun and actuator unit including a 2 phase 150 Amp contactor unit.

6) **Wire Mesh coiling machine: 1 unit**



Mesh Coiling Machine (Model: BW2R01)

1) **Main Welder Drive Control Panel: 1 unit**

This panel controls the speed of main welding machine with the help of variable frequency drive. Various controls and indicators are available in this panel which shows welded count and machine speed.



VFD Control Panel for Main Welding Unit (Model: BW75V3D)



1.14 Optional Accessories/Equipment: (Not part of Standard Equipment)

- Wire Straightening & Cutting-off Machine: **Model 2C01**
Working Range: 1.60mm to 3.00mm Wire Diameter
- Wire Straightening & Cutting-off Machine: **Model HC01-2D**
Working Range: 3.00mm to 6.00mm Wire Diameter
- Wire Pushing Collets:
Working Range: 3.0mm to 6.0mm Wire Diameter

1.15 Things to be arranged by buyer:

- 1) Cooling water circulation system for the wire mesh welder and control panel including, piping and water pump.
- 2) Foundation of machine.
- 3) Power connection from 250 KVA step-down supply transformer.
- 4) All cables and wiring required for installation
- 5) 300 sq mm, 3.5 core aluminum armored cable from electricity source to point of consumption (Maximum length of Supply Cable = 35 meter).
- 6) 150 sq mm flexible copper cable from control panel to Machine.
- 7) Tools and spanners.

1.16 Our offer does not include:

- 1) Building / lighting / foundation / brick work etc.
- 2) All civil engineering works, foundations, foundation bolts and tranches etc.
- 3) Material handling equipment's such as crane, hoist etc.
- 4) Anything not specially mentioned in the offer.
- 5) Any kind of freight / cartage / loading / unloading charges etc.
- 6) Any kind of packing for transit. Packing is provided at extra charges depending upon the requirement.

For price & delivery lead time please contact us at:

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