

USE AND MAINTENANCE MANUAL

for an automatic shaping plant for processing reinforced concrete rods



Translation of the original instructions - Reserved document

SERIAL NUMBER OF THE PLANT	VERSION
730235	<i>MI/SLIN/06r00-GB</i>

1. GENERAL

1.1. MANUFACTURER DATA

Manufacturer:	MEP Macchine Elettroniche Piegatrici S.p.A.
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1.2. DOCUMENTATION DATA

Type of document:	Use and Maintenance Manual
Edition:	MI/SLIN//06r00-GB
Product:	Shaping plant for processing reinforced-concrete rods
Model:	SYNTAX <i>LINE 25</i>
Serial Number:	
Year of manufacture:	

2. TECHNICAL DATA AND FEATURES

2.1. SIZES AND WEIGHTS

<i>Unit/plant</i>	Length (mm)	Width (mm)	Height (mm)	Weight (Kg)
Shaping plant (with control panel)	17625	4100	3120	8520
Travelling rack (8 boxes for bars L=12 m, with tracks)	11227	9055	1500	4200
Collecting car (with tracks)	13000	8990	600	1670

Note: the plant components may be seen in detail in the drawing on Fig.1.

2.4. PRODUCTION FEATURES

2.4.1. Mechanical features of the workable materials

Deformed bar made of hot rolled steel made into straight bars that have the following mechanical features:

- Yield unitary load (max. limit allowed): 600 N/mm²
- Breakage unitary load (max limit allowed): 700 N/mm²

2.4.2. Rod diameters that may be used

- Single rod process: Ø 8÷25 mm
- Double rod process: Ø 8÷16 mm

! Precautions for double rod processing. Using two rods simultaneously is dependent on them having the same mechanical and geometric features as well as on the state of wear of the rollers.

- In any case, we advise against using two rods under the following operating conditions
- in the presence of stirrups or shapes with sides longer than 1 m;
- if the two rods are even only slightly different in shape and/or size;
- if the rods are from two different batches or suppliers of material, or if bars are obviously made up differently.

2.4.3. Bending pins

- To process the above materials, the bending pins indicated on chapter PROGRAMMING.

2.4.4. Stirrup functions (in the production page)

- The number of sides that may be set per pattern: 28
- The number of angles that may be set per pattern: 27
- The number of stirrups that may be processed by progressive: 9999

2.4.5. Sizes of stirrups and shapes

- Longest side: depending on the involved area indicated on fig. 2, page C2-5
- Shortest side: see paragraph 2.5. DIMENSIONAL LIMITATIONS OF THE SHAPES
- Shortest length of first hook.: see paragraph 2.5.3. Minimum dimensions of initial and final hooks
- Shortest length of last hook: see paragraph 2.5.3. Minimum dimensions of initial and final hooks
- Max shape length: depending on the size of the collecting table (dimension A, fig. 2)
- Max shape height: 1600 mm
- Max angle for clockwise bending: 180°
- Max angle for anti-clockwise bending: 180°

2.4.6. Dimensions of straight bars produced in cut to length mode

Max length: depending on the dimensions of the collecting table (dimension A, fig. 2)