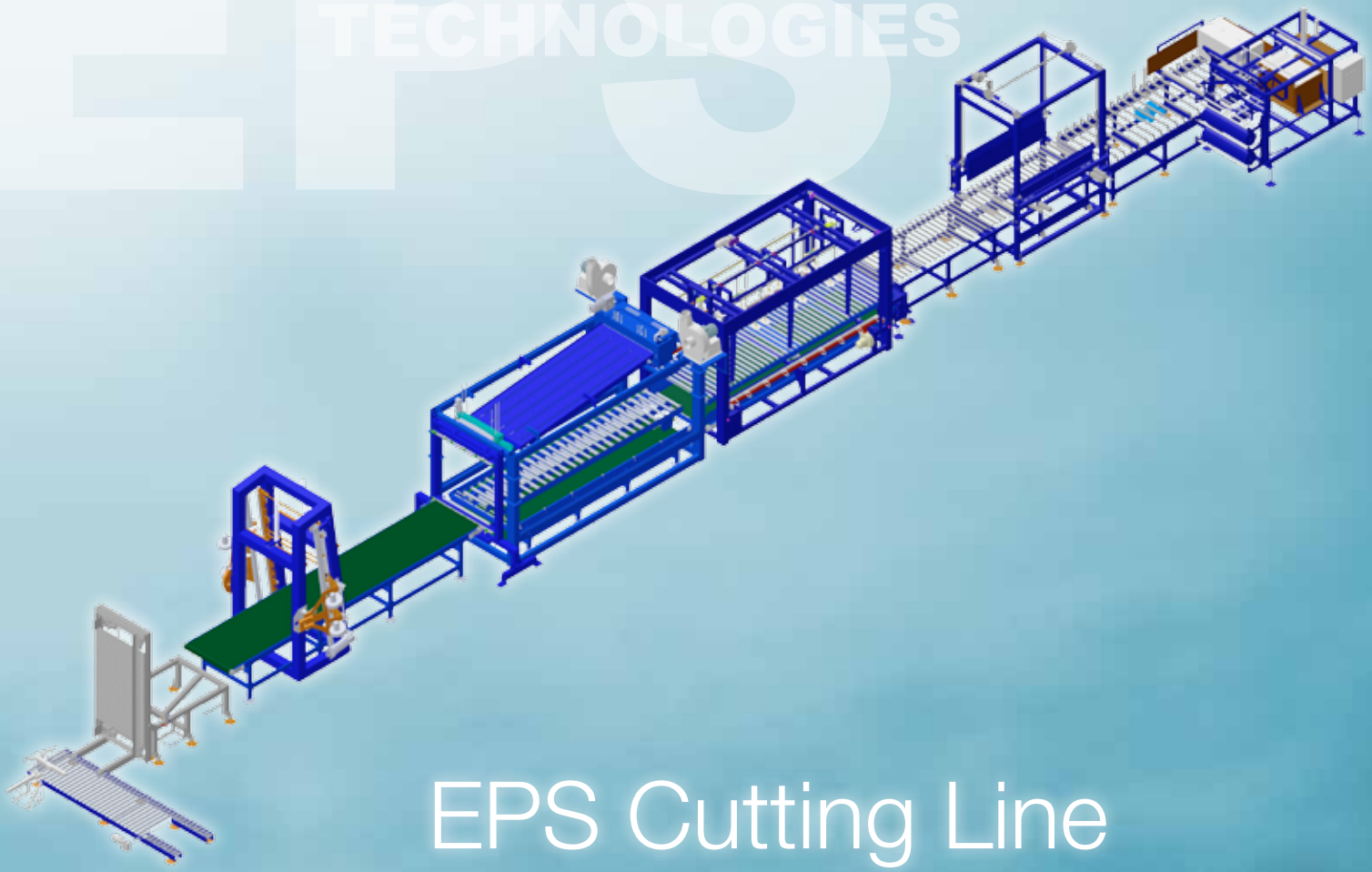

EPS Cutting Line

AKKAYA EPS cutting line, equipped with ossilating cutting, ridgid body, precise cutting properties. Modular system enables the line for upgrade whenever necessary, operator friendly control system for large productions.

Special designed hot wire ossilation, has a automatic speed control system during cutting. This gives the change for fast cutting without any wire break. This option installed only on horizontal cutting station.

With long stroke ossilation and adjustable ossilation speed guratees the fastest cutting speed at all time with a smooth surface.

PLC control system SIEMENS S7- including 15" touch color display enables the operator to watch all the process parameters during cutting. Recipe and production parameters can be stored, recall or moved to any place via memory stick on the PLC.

Horizontal cutting unit equipped with wire break system, which stops the cutting for broken wire.

AKKAYA®

EPS-EPP TECHNOLOGIES

Block Loading Unit

System can be placed 90 with the suitable location fort he cutting line direction or in line. The blocks are positioned by operator using the forklift, the roller conveyor has a suitable inlet. When the tilting unit is free each block, moved to tilting unit for start cutting stage. Total length of the unt enables to load up to 5 blocks.

Block Tilting Unit

Block Tilting Unit to feed the cutting line with hydraulically operated platform. The blocks come to the begining of the line, after centering operaation made by pneumatic pushers, the unit lays the block down on the horizontal cutting chain conveyor. The gap between the blocks are 35-40 cm. The block is sent to horizontal cutting unit.

Auto Wire Setting Unit

Horizontal cutting unit with ossilation has a automatic wire setting system with servo motors. The wires set very fast, to desired thickness. With the ossilation cutting, the material consumption is less, and smooth surface on the sheets.

With the robot servo controlled, wires set to position and locked via pneumatic air lock. Wire setting unit can set 62 wires, less than 2 minutes. The total heigth of the unit is around 4 meters. The auto wire setting can be used for minimum 10 mm wire thichkness without any personell intervention

This system equipped with AWP (auto wire protection) automatic cutting speed control. The blocks on the chain conveyor cut with maximum speed at all time, but when the wires start to get tension due to cutting speed, this system detecs the tension and slow the speed until the tensin is finished. The system operates with PID control, which increase and decrease the cutting speed when needed. This helps fort he wires long life and better surface quality on the sheets.

Bottom and Side Scrap Recovery

With vacuum suction device located under the block, rest skin collected with a 1400 mm wide turning roller. The side scrap coming during the cutting, directed via the side cover cabin to under of the line with gravity. The pre-crusher positioned in the end of the coveyor recycles the scrap and send to recycling unit.

Top Scrap Recovery

Equipped with vacuum suction unit, the skin come out from the top of the blockmould collected via 1400 mm conveyor, then with chain drive directed to pre-crusher located on the top side of the cutting line. The pre-crushed material transferred through a fan to the recycling system.

Automatic De-stacking Unit

this unit can be used together with the auto wire setting option. After the vertical cutting stage, the packs come on the final motorized conveyor and prepared to enter the de-stacker. According to the wire thickness, the unit reconize the sheet thickness and quantity to adjust the rigth numbered eps packs. After the packs are done, via a motorized conveyor it is driven in the packing machine. The machine operates with two packs size.

Technical Specification

Machine Type	**AKH 2000**	**AKH 3000**	**AKH 4000**
Block Cutting Size (mm)	2075 x 1300 x 1300	3100 x 1300 x 1300	4100 x 1300 x 1300
Machine Line Size (m)	2,5 x 27 x 5	2,5 x 31 x 5	2,5 x 36 x 5
Cutting Speed			
10 kg/m³ (m/min)	1,8-2,0	1,8-2,0	1,8-2,0
16 kg/m³ (m/min)	1,5-1,9	1,5-1,9	1,5-1,9
20 kg/m³ (m/min)	1,2-1,6	1,2-1,6	1,2-1,6

For other sizes, please contact.
Bu değerler çok iyi dinlenmiş, geri dönüşümsüz bloklar ile otomatik hız kontrolüne sahip makinalarda tavsiye edilen hızlardır.

AKKAYA®
Makina İmalat Sanayi ve Ticaret A. Ş.

Büyükkılıçlı Köyü No 224 TR 34570 Silivri - İstanbul / TURKEY
Tel: +90 212 748 46 00 Pbx Fax: +90 212 748 46 05
www. akkaya-akkaya. com | www. akkaya. ru | E-mail: info@akkaya-akkaya. com