



EPS Cutting Line

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

Special designed hot wire oscillation, has an 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 oscillation and adjustable oscillation speed guarantees 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 or network.

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





Block Loading Unit

System can be placed 90° with the suitable location for the 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 unit 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 beginning of the line, after centering operation 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 oscillation has an automatic wire setting system with servo motors. The wires set very fast, to desired thickness. With the oscillation 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 height of the unit is around 4 meters. The auto wire setting can be used for minimum 10 mm wire thickness without any human 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 detects 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 for the 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 covveyor 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 recognize the sheet thickness and quantity to adjust the righth 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/m ³ (m/min)	1,8-2,0	1,8-2,0	1,8-2,0
16 kg/m ³ (m/min)	1,5-1,9	1,5-1,9	1,5-1,9
20 kg/m ³ (m/min)	1,2-1,6	1,2-1,6	1,2-1,6

Please contact with us for other sizes.

These values are advice for machines with non-recyclable blocks and automatic speed control machines.