

Title (en)

METHOD AND INSTALLATION FOR PRODUCING GRID MATS

Title (de)

VERFAHREN UND ANLAGE ZUM HERSTELLEN VON GITTERMATTEN

Title (fr)

PROCEDE ET INSTALLATION POUR FABRIQUER DES MATS DE TREILLIS

Publication

**EP 1075339 A1 20010214 (DE)**

Application

**EP 00904674 A 20000214**

Priority

- AT 0000035 W 20000214
- AT 35099 A 19990302

Abstract (en)

[origin: WO0051760A1] The invention relates to a method and installation for producing grid mats comprised of longitudinal and transversal rods (L, Q) which are welded to one another at crossing points. According to the invention, material billets made of hot-rolled material and serving to form the longitudinal and transversal rods are continuously drawn from each wire supply (1, 10), and in order to improve the mechanical-technological properties thereof, are stretched (27), subsequently temper rolled (30) and cut into lengths (3), whereupon the longitudinal rods (L) are introduced in a group by group manner into the grid welding machine (9) and are welded therein to transversal rods (Q). The material billets for forming the transversal rods (Q) are fed at a lower speed than that of the material billets for forming the longitudinal rods (L). The longitudinal and transversal rods are produced from material billets which run in a preferably parallel manner with regard to the direction (P1) of production, whereby all material billets used to form the transversal rods (Q) are turned around an angle of 90 DEG , and the number of material billets used to form the transversal (Q) rods is greater than that for the longitudinal rods (L).

IPC 1-7

**B21F 27/10; B21F 27/20**

IPC 8 full level

**B21F 27/10** (2006.01); **B21F 27/20** (2006.01)

CPC (source: EP)

**B21F 27/10** (2013.01); **B21F 27/20** (2013.01)

Designated contracting state (EPC)

AT CH DE IT LI NL

DOCDB simple family (publication)

**WO 0051760 A1 20000908**; AT 408196 B 20010925; AT A35099 A 20010215; AT E240173 T1 20030515; DE 50002151 D1 20030618; EP 1075339 A1 20010214; EP 1075339 B1 20030514

DOCDB simple family (application)

**AT 0000035 W 20000214**; AT 00904674 T 20000214; AT 35099 A 19990302; DE 50002151 T 20000214; EP 00904674 A 20000214