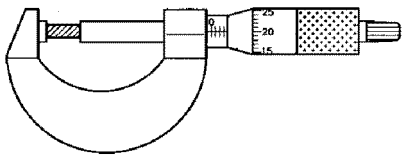


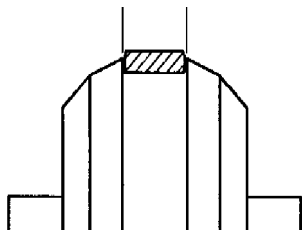
009 I have very irregular seams, what could be the reason?



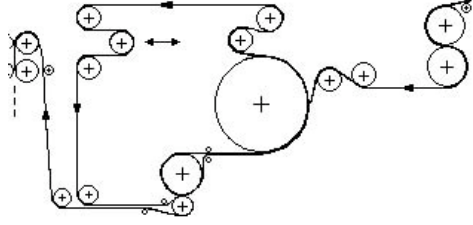
Clean the carbide steel surfaces of the wire-profiling unit. Check with your fingernail whether „tyre effects“ are already present.




Measure wire width every 10 cm and make sure it is constant within 0.02mm.



Measure wire width and welding roller groove in welding roll for correct profiles.



Monitor wire during wire run and check if the small wire guide pulleys (last pulley before welding rolls) are off-line creating a situation like shown on the right of this picture.



NOTE:
The setting of the wire profiling unit is probably the most important setting on the whole installation. A correct wire profile, and in particular a wire profile that is perfectly matched to the wire slot in the welding rollers are the elementary basic prerequisites for good welding.

The shape of the wire, the wire width to be set up and the insertion depth into the roller head for this wire are dependent, on the one hand, on the wire that you are using and, on the other, on our specifications and the insertion tool delivered, and can be seen in the table below.

Wire- \varnothing	Overlap	Wire width	Radius	Insertion depth
1,24 mm	„WIMA“	1.78 (+0/-0.02) mm	-	0.28 (+0.02/-0) mm
1.38 mm	„Butterfly“	1.78 (+0/-0.03) mm	2.25 mm	0.50 (+0.05/-0) mm
1.5 mm	„Butterfly“	1.78 (+0/-0.03) mm	2.25 mm	0.55 (+0.05/-0) mm
1.38 mm	„WIMA“	2.1 (+0/-0.02) mm	-	0.35 (+0.03/-0) mm
1.5 mm	„WIMA“	2.1 (+0/-0.02) mm	-	0.40 (+0.03/-0) mm
1.8 mm	„Butterfly“	2.28 (+0/-0.03) mm	3.0 mm	0.72 (+0.03/-0) mm
1.8 mm	„WIMA“	3.2 (+0/-0.03) mm	-	0.40 (+0.03/-0) mm