

MEŞE MAKINA MÜH.İTH.İHR.SAN.VE TIC.LTD.ŞTİ.

ORGANİZE SANAYİ BÖLGESİ 75.YIL BULVARI
DEMİRCİLER SANAYİ SİTESİ E BLOK NO:6
NİLÜFER / BURSA

BAST



+90224 241 24 01



www.mesemakina.com



info@mesemakina.com

www.bastmachine.com

BAST® SHEET METAL LEVELING MACHINE

Nowadays processes such as laser cutting flame cutting perforated sheet production applied on metal sheets cause defects. Roller based precision sheet leveling is rapidly replacing old methods of eliminating these defects.

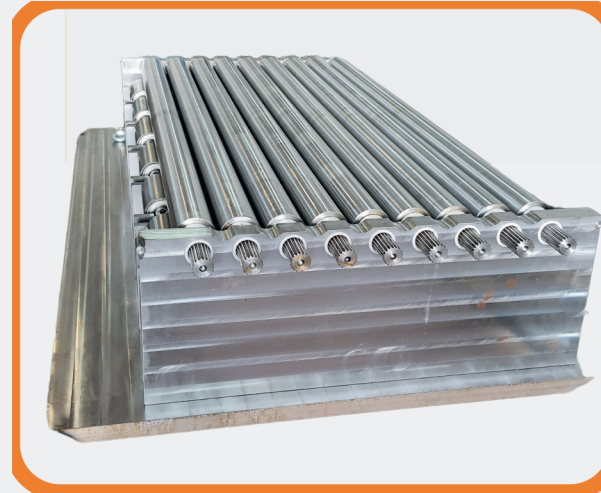
These machines can level sheet metal plates and parts after laser or precision press cutting by reducing their internal stresses. In this way, the quality of processes such as welding and bending is improved and contributes positively to all production processes. Compared to other leveling processes, precision roller sheet leveling is fast, economical, short, simple and can be performed with short training for technical personnel



MACHINE SPECIFICATIONS

LEVELING ROLLERS

Straightening shafts are the basic components that gradually straighten the metal. By applying gradually decreasing pressure in constantly changing directions, they reduce internal stresses and ensure that the metal comes out flat at the final station. The hardness of the rollers is critical for durability, especially with hard metals. BAST® models are manufactured with correction shafts with excellent surface roughness, ground to 62 HRC hardness with increased wear resistance for long life. For models wider than 1000 mm, double sided straightening shafts are available as standard.



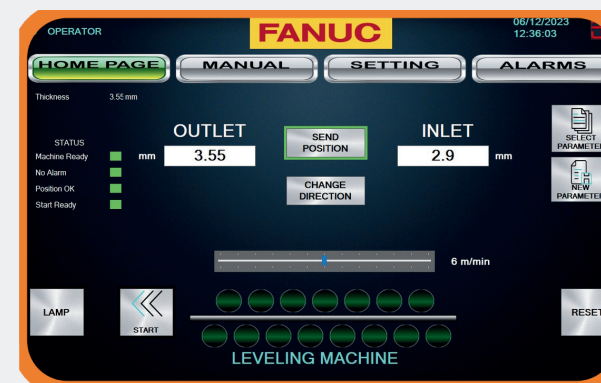
SUPPORTING ROLLERS

These rollers distribute pressure evenly to balance the straightening rollers. They prevent deformation of the straightening rollers and ensure stable output quality. They are made from hardened bearing steel, they undergo precise machining and are assembled after run out checks, ensuring tolerances of ± 0.02 mm.



SMART CONTROL SYSTEM WITH SERVO MOTORS

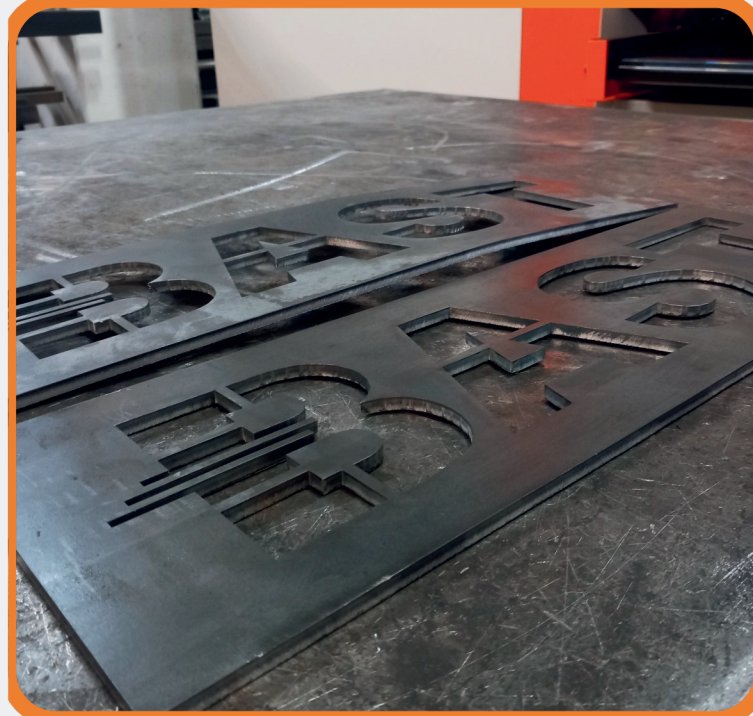
In BAST® machines, users can input the thicknesses at the entry and exit points, as well as the machine speed, allowing for automatic adjustments based on these parameters. High precision servo motors enable extremely fast and practical adjustment of the straightening gap with pinpoint accuracy. This precision ensures consistent straightening performance across varying sheet metal dimensions. For identical sheets, no additional adjustments are required. Saved settings can be reused whenever needed, streamlining the operation process.



MACHINE SPECIFICATIONS

PRECISE GAP ADJUSTMENT (Gap Control) PATENT

The first patent is aimed at ensuring the machine's precise positioning to prevent any waviness sheet metal processing that could be caused by different geometries, such as triangular or irregular perforations. This has led to the development of a unique cylindrical wedge system that precisely adjusts gaps. Our system processes information from linear scales with very short response times, enabling the machine to perform straightening with stable gap settings. This optional feature is recommended for more stable results.



DIE POSITIONING & MANUFACTURING METHODS PATENTS

The second patent involves improvements in the precise positioning of dies and the related manufacturing methods through the development of a special and patented manufacturing method, the machine can achieve highly precise (± 0.01 mm) adjustments even without the use of linear scales. Regardless of the deviation values entered in the Easy BAST® control panel, the machine can perform repeatable precise movements in every position. This allows our machine to always provide the most accurate adjustments



MACHINE SPECIFICATIONS

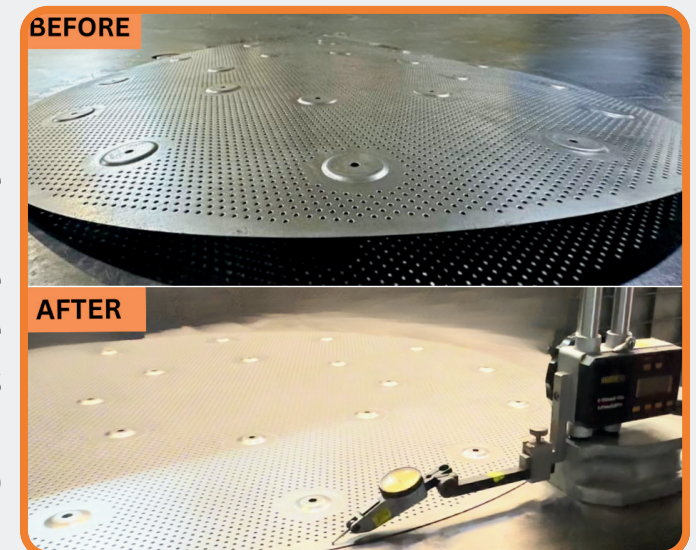
PREVENTIVE MAINTENANCE & CLEANING

Periodic cleaning on BAST® machines ensures proper operation and prevents errors from occurring by cleaning all components of the machine, including cylinders and other critical parts. This cleaning helps keep metal surfaces clean, reduces wear and extends the life of the machine. This ensures high quality results and easy maintenance, guaranteeing reliable and long-term performance. For easy mould cleaning, moulds are manufactured as a set in all models and optional quick mould removal systems are offered to users.



METICULOUS PRODUCTION PROCESS

BAST® machines are manufactured with the highest precision by skilled and qualified personnel. All components are meticulously processed, measured, and inspected. No product outside the tolerance range is used in the production process. The same care is taken during the assembly phase, ensuring that machines delivered to customers provide the best results.



SALES AND AFTER-SALES SUPPORT

BAST® is not only a leader in machine production but also stands by its customers with excellent sales and after-sales service. With its expert team, BAST offers fast, effective, and solution-oriented support, always making it a reliable business partner. Meşe Makina has obtained patents that enhance the innovative capabilities of BAST sheet leveling machines

MACHINE SPECIFICATIONS

OVER LOAD PROTECTION SYSTEM

The BAST® overload protection system ensures that the machine prevents any potential damage caused by incorrect inputs or unmanageable sheet properties. If a user enters an erroneous value or attempts to feed a sheet that cannot be corrected, the machine will not accept it. The system detects excessive load on the motor, dies, and servo motor system, and automatically switches to an error mode to prevent further damage. Users are responsible for ensuring that the sheet falls within the acceptable limits defined in the correction diagrams. The machine's main body is made of high-quality ST52 material to ensure durability and stability.

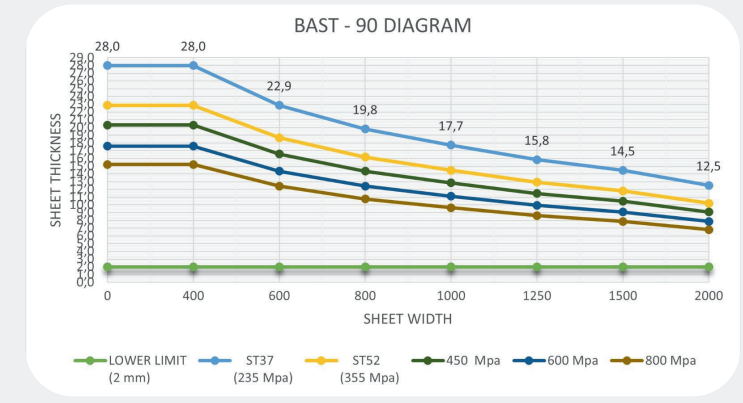
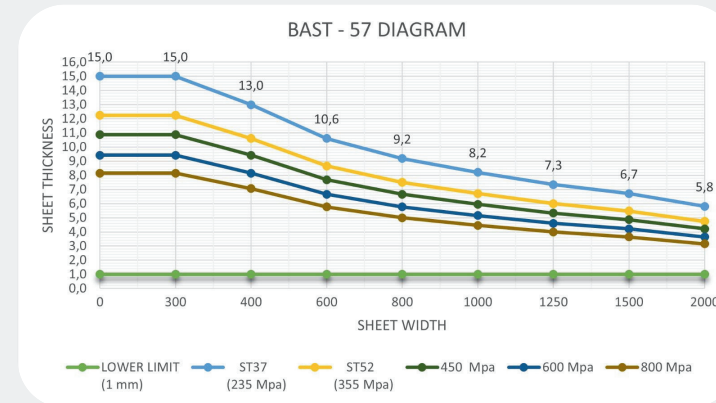
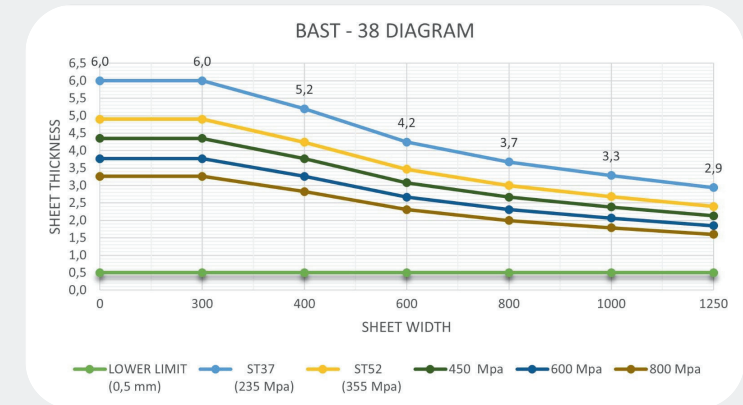
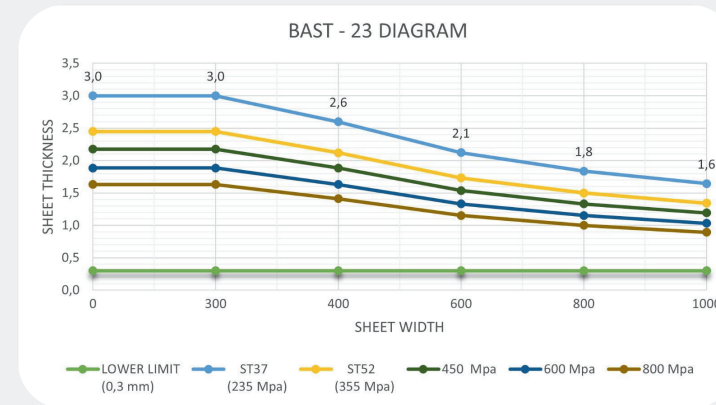


SHEET ALIGNMENT & CONTROL SYSTEM

BAST® machines offer optional entry and exit conveyors, which precisely guide and align the sheet metal as it enters the machine. The exit unit then supports the sheet as it exits, ensuring that the material remains straight and free from distortion. The position of the sheet is continuously monitored at the machine's entrance. Even if the sheet attempts to move beyond the machine's capacity limits, the system will not allow this, ensuring both safety and quality throughout the process. This feature guarantees consistent performance during operation.



CORRECTION DIAGRAMS



TECHNICAL SPECIFICATIONS

	BAST® 23	BAST® 38	BAST® 57	BAST® 90
SHEET THICKNESS (mm)	0,3 - 3	0,5 - 6	1 - 15	2 - 28
MACHINE WIDTH (mm)	430-630-830-1050	630-830-1050-1300	830-1050-1300-1550-2050	1050-1300-1550-2050
MINIMUM PIECE SIZE (mm)	50	70	100	200
SHEET METAL GAP ADJUSTMENT	SERVO MOTORISED	SERVO MOTORISED	SERVO MOTORISED	SERVO MOTORISED
AUTOMATIC SHEET GAP ADJUSTMENT	-	-	OPTIONAL	OPTIONAL
OVERLOAD PROTECTION SYSTEM	STANDARD	STANDARD	STANDARD	STANDARD
TWO-WAY USABLE MOULDS	1050 mm AND OVER STANDARD	1050 mm AND OVER STANDARD	1050 mm AND OVER STANDARD	1050 mm AND OVER STANDARD
FAST MOULD CLEANING SYSTEM	-	-	OPTIONAL	OPTIONAL
DISPLAY CONTROLLER	TOUCHSCREEN (EASYBAST)	TOUCHSCREEN (EASYBAST)	TOUCHSCREEN (EASYBAST)	TOUCHSCREEN (EASYBAST)
CE-CERTIFICATION	STANDARD	STANDARD	STANDARD	STANDARD