

EMTK

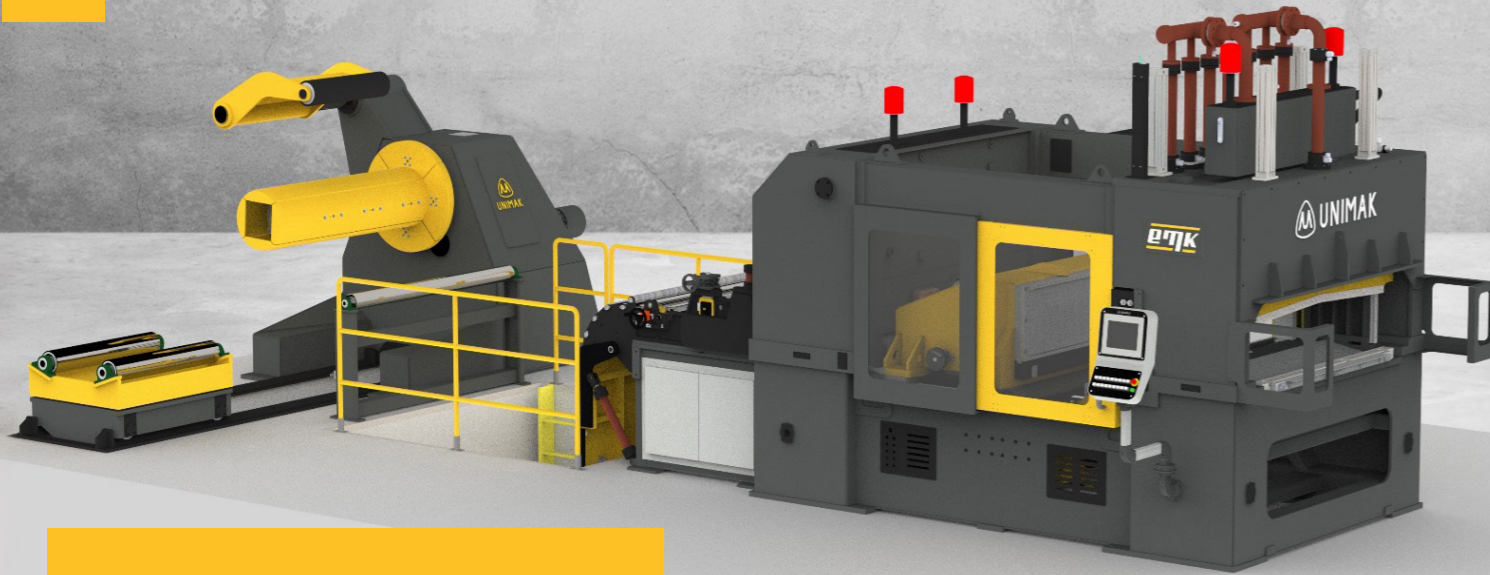
CNC - METAL - MAKİNA



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CORRUGATED WALLS



EMK CNC METAL has one fully automatic UNIMAK corrugated walls production line and welding machines for distribution transformers, with all the state of the art technologies

We can manufacture corrugated walls with "super onda" profile, with spot welding, with strip

EMK CNC METAL has experience in manufacturing corrugated walls for 10 MVA transformers, including 1 side corrugated walls weighing up to 1,000 kg

We are capable of bending according to customer drawings, allowing for various bending configurations on either side or the entire wall. This ensures that tank construction can be completed with just one welding process.

Corrugated Wall Production Line Capability

- Fin Length = min. 400 mm – max. 1600 mm
- Fin Height = min. 40 mm – max. 400 mm
- Fin Pitch = min. 40 mm – max. 100 mm
- Fin Quantity = min. 3 – max. 99
- Thickness = 1 - 1,2 - 1,5 mm



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CORRUGATED WALL

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STANDARD FOR CORRUGATED WALL

DESCRIPTION	Bending Corner Details	Table Q						Unit
		Detail X		Detail Y		Detail Z		
		min.	max.	min.	max.	min.	max.	
Number of fins (N)	See Table N							
Edge Front (A)	See Table Q	5	20	15	15	15	15	mm
Edge Rear (B)	See Table Q	5	20	15	15	15	15	mm
Pitch (P)	See Table N	0	0	15	60	10	25	mm
Thickness (t)	See Table M	0	0	90	90	45	45	deg
Fin height (H)	See Table M	0	0	15	60	10	25	mm
Fin wall length (L)	See Table M	0	0	90	90	45	45	deg

SPOT WELDING DETAILS

FORM A: Corrugated wall for the transformer tank with conservation tank are spot welded on the all embossings

FORM B: Corrugated wall for the hermetic type transformer tank are spot welded on the first and last finwall's embossing

PREPARED BY

CONTROL

APPROVAL

REVISION : 3

DATE : 01.01.2019

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CORRUGATED WALL

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Technical specification for corrugated wall

Symbol	Unit	Description
c =	95	mm See picture
e =	6	mm See picture
h =	100	mm Distance between two spot weldings
M1 =		mm See Table M
M2 =		mm See Table M
M3 =		mm See Table M

Table N

Pitch	Max. number of fins	Max. length of fin wall
P [mm]	N	[mm]
40	99	
45	99	
50	99	
55	99	
60	99	
65	99	
70	99	
75	99	
80	99	
85	99	
90	99	
95	99	
100	99	

Table M

Fin Height	Fin wall Length																				
	L [mm]																				
H [mm]	400	500	600	700	800	900	1000	1100	1200	1300	1400	1500	NO EMBOSINGS			1 EMBOSING			2 EMBOSINGS		
t [mm]	1,00-1,20	1,00-1,20	1,00-1,20	1,00-1,20	1,00-1,20	1,20-1,50	1,20-1,50	1,20-1,50	1,20-1,50	1,20-1,50	1,20-1,50	1,20-1,50	M1	M2	M3	M1	M2	M3	M1	M2	M3
150	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
170	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
190	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
210	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
230	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
250	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
270	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
290	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
310	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
330	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
350	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
370	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
390	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50
400	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50	50

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EMBOSSING SETTING TABLE

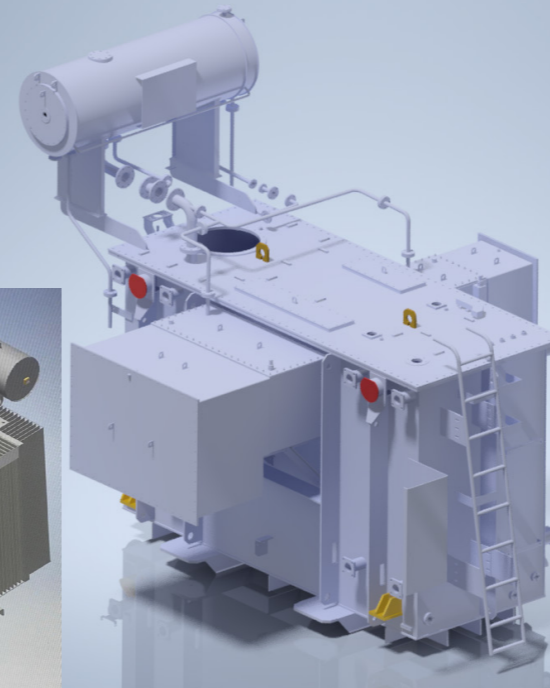
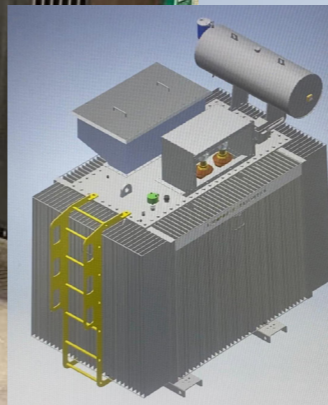
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Technical specification for corrugated wall

TANKS FOR DISTRIBUTION TRANSFORMERS

TANKS FOR POWER TRANSFORMERS



Construction of complete carpentry, equipped with every component, such as case, lid, conservator and protections, with accessories and armor that can reach a weight of 25 tons. In addition to the standard production, the company also manufactures carpentry with materials suitable for resisting in extreme environments.

The welds, also carried out in a semi-automatic cycle, are controlled using non-destructive methods and the details are finished in order to guarantee the highest quality of the product, always in step with the customer's needs.

EMK CNC METAL's manufactures corrugated wall tanks in strict accordance with customer drawings. Our production capabilities allow us to create not only individual tanks but also undertake serial production to meet larger-scale project requirements.

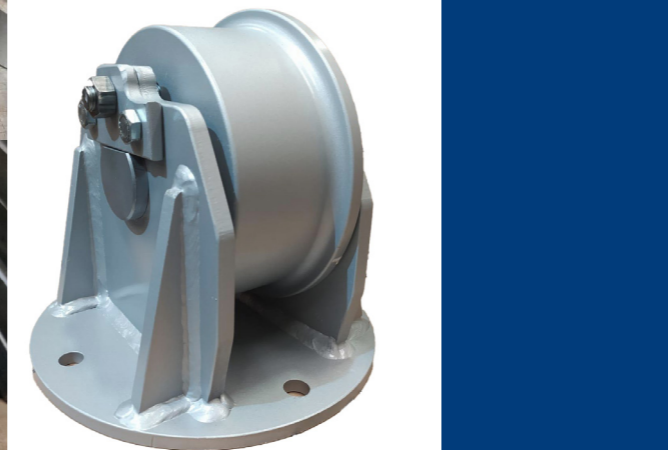
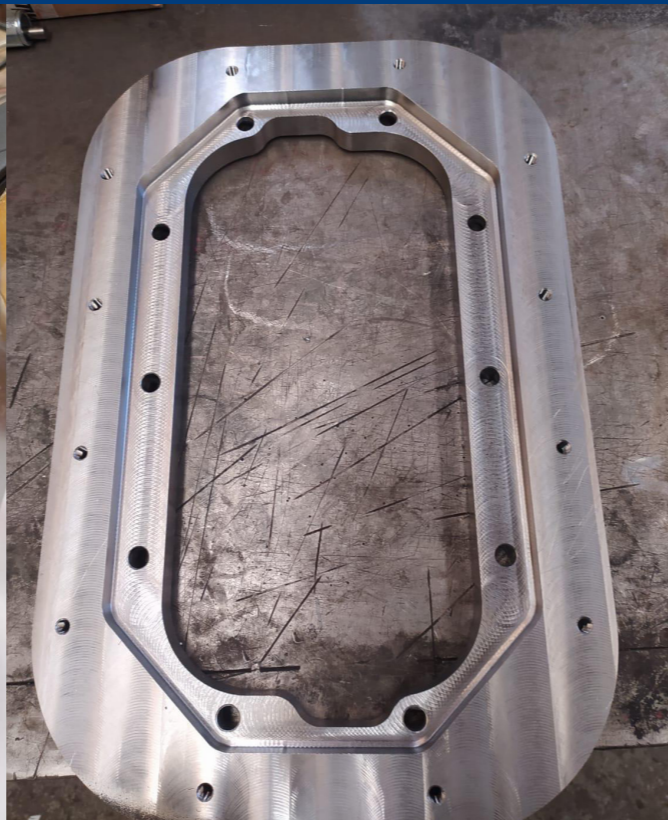
The manufacturing range is from 50 kVA to 10 MVA.

We can provide hermetically sealed tanks or expansion tanks, our corrugated walls design will change in accordance to the type of transformer. Hermetic tanks in fact needs elastic corrugated wall design, while expansion tanks requires more rigid design with spot-welded corrugated walls and a conservator mounted on its top. Conservators, cable boxes, covers, accessories and reinforcements can be manufactured with the tanks following customer design.



MACHINED PARTS FOR TANKS

CERTIFICATES





EMK CNC METAL MAKİNA İMALAT SANAYİ TİCARET LİMİTED ŞİRKETİ

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