



Tube Mill & Roll Forming Machine 管材机械&冷弯成型设备

世技机械江苏有限公司

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世技机械江苏有限公司 公司简介

世技机械（江苏）有限公司坐落在江苏省昆山市，是钢卷纵剪分条机组、钢带横切机组、高频制管机、BG系列不锈钢制管机、FG系列碳钢-不锈钢复合管生产线和冷弯成型设备的自主研发、生产、销售和服务于一体高科技企业。

公司根据客户的不同需求，可设计生产超厚壁、超薄壁、非标机组，型号从Φ20—Φ610mm的高频直缝焊管机组，包括API高钢级石油套管、石油天然气管焊管机组，大型方矩形管焊管机组，以及大型冷弯焊管型钢机组。

冷弯成型机主要产品有：全自动欧式卷帘窗成型机、屋脊瓦成型机、护栏板成型机、护栏立柱成型机、屋面板成型机、双层压型板成型机、彩钢琉璃瓦成型机、C/Z型檩条成型机等、设备采用国外先进技术PLC电脑液压控制系统、其技术性能及精度均已达到国外先进水平，公司可以根据客户来图来样订做各种滚压成型设备。

公司始终坚持“以人为本、高效优质、服务优先”的方针，竭诚欢迎国内外新老朋友来我公司考察、洽谈，世技机械愿与您携手共创辉煌。

World Technology Machinery Jiangsu Co.,Ltd. Company introduction

Our company is a manufacturer and seller of kinds of metal sheet slitting line, steel coil cut to length line, ZG series carbon steel tube mills, BG series high precision stainless steel pipe mill line, High-precision stainless steel composite tube mill line, cold roll forming machine & related accessories.

Our roll forming machine lines include the following products:

Rolling shutter slats roll forming machine, roof ridge cap roll forming machine, guardrail roll forming machine, fence post roll forming machine, roof panel roll forming machine, double layer roll forming machine, steel tile roll forming machine, metal decking roll forming machine, downspout roll forming machine, corrugated metal sheet roll forming machine, C purlin roll forming machine, Z purlin roll forming machine, C/Z interchange purlin roll forming machine, octagonal tube roll forming machine, downspout roll forming machine.

Advantage of Roll Forming:

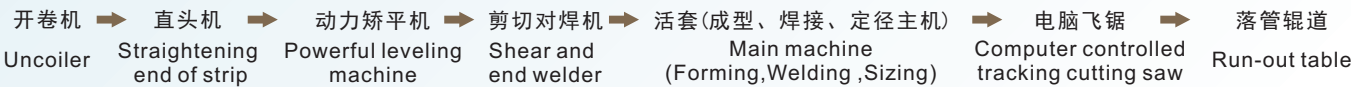
Roll formed parts can have a variety of shapes, angles and curves. Many materials are suitable for our custom roll forming machines, which allows us to provide components and parts with a wide variety of plated, pre-painted and laminated materials to meet your roll forming needs. We design products that best meet specific needs.

If you are interested in any of our products or would like to discuss a custom order, please feel free to contact us. We are looking forward to forming successful business relationships with new clients around the world in the near future.

ZG 45/50/60/76/90 /114/165/219直缝高频焊管机组
 ZG 45/50/6076/90/114/165/219 Straight seam and high frequency welded pipe mill line



基本配置
 Basic Components



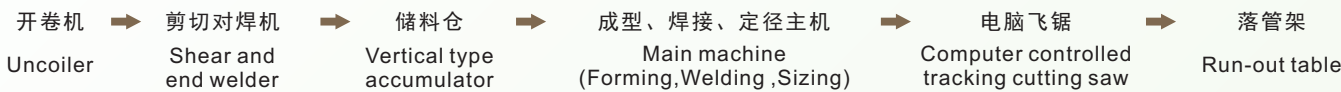
主要技术参数
 Main Technical Parameters

Parameters 参数 型号 Model	焊管直径 Diameter of Welded Tubes	焊管壁厚 Wall Thickness of Welded Tubes	焊管速度 Speed of Tube Welding	主电机功率 Power of Major Motor	高频功率 High Frequency Power
ZG76机组(Unit)	25~80mm	1.2~4.0mm	30~70M/min	160KW	300KW
ZG76扩127机组(Unit)	32~127mm	1.5~2.5mm	30~60M/min	90KW x 2	350KW
ZG90机组(Unit)	32~100mm	1.5~4.5mm	20~60M/min	110KW x2	350KW
ZG90扩140机组(Unit)	60~140mm	1.5~4.0mm	20~60M/min	132KW x 2	400KW
ZG114机组 (Unit)	40~114mm	1.2~5.5mm	15~60M/min	132KW x2	300KW
ZG165机组 (Unit)	76~165mm	2.0~60mm	15~50M/min	185KW x 2	600KW
ZG219机组 (Unit)	114~219mm	3.0~8.0mm	15~40M/min	250KW x 2	800KW

ZG 32/45/50/60 直缝高频焊管机组
 ZG 32/45/50/60 Straight seam and high frequency welded pipe mill line



基本配置
 Basic Components

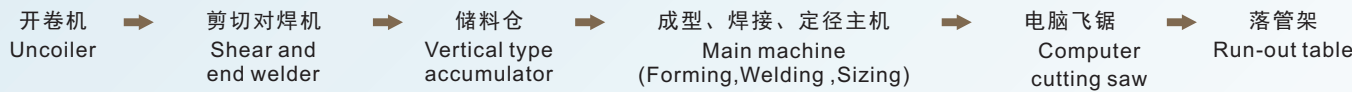


主要技术参数
 Main Technical Parameters

Parameters 参数 型号 Model	焊管直径 Diameter of Welded Tubes	焊管壁厚 Wall Thickness of Welded Tubes	焊管速度 Speed of Tube Welding	主电机功率 Power of Major Motor	高频功率 High Frequency Power
ZG32机组 (Unit)	12~32mm	0.5~2.5mm	50~100M/min	90KW	150KW
ZG45机组 (Unit)	13~45mm	0.8~2.0mm	40~90M/min	90KW	100KW
ZG50机组 (Unit)	12~50.8mm	0.6~3.5mm	50~100M/min	110KW	200KW
ZG60机组 (Unit)	16~60mm	1.0~3.5mm	50~90M/min	160KW	300KW

ZG 12/16/25/28 直缝高频焊管机组
ZG 12/16/25/28 Straight seam and high frequency welded pipe mill line

基本配置
Basic Components

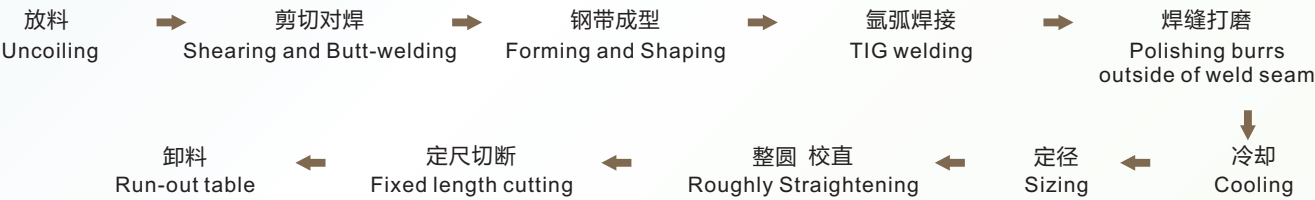


主要技术参数
Main Technical Parameters

Parameters 参数	型号 Model	ZG12机组(Unit)	ZG16机组(Unit)	ZG25机组(Unit)	ZG28机组(Unit)
焊管直径 Diameter of Welded Tubes		7~16mm	8~25mm	8~30mm	10~38mm
焊管壁厚 Wall Thickness of Welded Tubes		0.2~0.5mm	0.3~1.0mm	0.4~1.3mm	0.5~1.5mm
焊管速度 Speed of Tube Welding		50~100M/min	50~100M/min	50~100M/min	50~90M/min
主电机功率 Power of Major Motor		15KW	22KW	37KW	55KW
高频功率 High Frequency Power		60KW	60KW	100KW	100KW

BG系列不锈钢精密制管机组
BG series high precision stainless steel pipe mill line

基本配置
Basic Components



主要技术参数
Main Technical Parameters

机型 Model	管径 (mm) Tube Diameter(mm)	壁厚(mm) Wall Thickness(mm)	焊管速度(m/min) Welding Speed(m/min)	氢弧焊机 Ar-arc Welder
BG 20	8~25.4	0.5~1.0	0.5~8	400A
BG 40	25.4~50.8	0.8~2.0	0.5~6	600A
BG 60	38.1~76.2	1.0~3.0	0.5~4	600A



高精度碳钢-不锈钢复合管生产线
High-precision stainless steel composite tube mill line

基本配置
Basic Components

开卷机 ➡ 剪切对焊机 ➡ 储料仓 ➡ 成型、焊接、定径主机 ➡ 复合机组 ➡ 落管架 ➡ 定尺锯切
Uncoiler ➡ Shear and end welder ➡ Accumulator ➡ Main machine (Forming, Welding, Sizing) ➡ Compositing machine ➡ Run-out table ➡ Computer controlled rotating cutting saw



设备描述
Description

碳钢-不锈钢复合管由两层管构成，内层为普通碳素钢管，外层为0.08-0.2mm的不锈钢包覆管，经焊接、抛光，达到与不锈钢管完全一样的外观形状。这种复合管强度高、成本低、外光光亮美观，不锈钢复合管作为节能、绿色环保新材料，主要用于纺织机械，食品机械，装饰装修，客车，市政建设栏杆等。

碳钢-不锈钢复合管机组采用先进的“同步焊接复合”法，“同步焊接复合”法沿着碳钢管焊接生产线，同步将不锈钢冷带外覆在碳钢管外表，经焊接、定径、矫直、定尺、抛光直至形成内层和外层紧密结合的复合管。

Stainless steel clad pipe mill is a new welding technology, which coats thin stainless steel(SUS304, SUS302, 430JIL) on the surface of carbon steel(Q195-235, 08AL, SPHC) pipe with high strength, the product has the features of both artistic appearance, therefore, corrosion resistance of stainless steel and high strength of carbon steel. It is the best substitute of stainless steel pipe as its lower price comparing with that of stainless steel pipe. Stainless steel clad pipe is widely used in household commodities, shoe racks, public facilities and guardrails such as all kinds of clothes racks, retractable poles, article racks, all purpose combination racks, table and chair legs, indoor handrails, ship and bus racks, and outdoor guardrails.

主要技术参数
Main Technical Parameters

Parameters 参数	型号 Model	FG20机组 (Unit)	FG30机组 (Unit)
焊管直径 Diameter of Welded Tubes		8~25.4mm	13~32mm
焊管壁厚 Wall Thickness of Welded Tubes		0.3~0.5mm	0.4~0.8mm
焊管速度 Speed of Tube Welding		10~35M/min	10~35M/min
主电机功率 Power of Major Motor		15KW	22KW
高频功率 High Frequency Power		60KW	60KW



储料活套
Strip Accumulator

活套功能
Function of accumulator

活套具有间断地接收来自开卷机的带钢并同时向冷弯钢管机组提供带钢的功能。用于将带钢在成型机前暂存起来，以保证在前、后卷带钢对焊期间焊管机组的连续生产。

This accumulator permits continuous operations of strip processing lines, there by reducing costly delays caused by end of a coil. The operation consists of feeding material into the inside of the super coil accumulator, and then transfer it to the outside diameter until the desire amount of strip storage is accumulated. During this time, the material is continulusly feed inti the tube mill. When the coil end is reached, the incoming material stops for coil joining. Stored material, however, is continuously removed form the outside of the accumulator and pulled into the processing line. Since the accumulated strip is constantly turning, there is virtually no additional load imposed on the tube mill. Sheared and welded strip is temporarily accumulated in this unit for continuous operation of the mill.

笼式活套（立式活套）
Vertical type accumulator



主要技术参数
Main Technical Parameters

储料方式: 定圈式，外进内出	Storing type: Fixed-coil type, outside input and inside output
驱动方式: 交流电机调速	Drive type: AC adjustable-speed motor
夹送料速度：150m/min	Pinching speed: 150m/min
活套电机：15KW	Motor of accumulator: 15KW
夹送电机：11KW	Motor of pinch device: 11KW
钢带宽度：40-100mm	Width of steel strip: 40-100mm
钢带厚度：0.5-3.0mm	Thickness of steel strip: 0.5-3.0mm

卧式螺旋活套
Horizontal type accumulator



设备组成
Composition

低翻转托架
角度可调翻转托架
整平送料机
活套

用于储料装卸和驱动带钢，由动力部分、内圈部分、中立辊部分、水平辊辊部分、外圈挡辊部分、送料挡辊架等部分组成，传动部分由电机、减速箱和万向联轴器组成。

高翻转托架
电气控制箱

电控系统由主电机控制作柜组成，设备设置安全保护、急停断电按钮，电控设备中的主要原件、易损件符合国标规定，三相四线供电。

Low overturn support
Angel adjusted overturn support
Flattening feeder
Accumulator

It is used for saving, loading, driving the strips. It include force parts, inner circular, middle roller, and level roller. The outer circular block rollers, feeding block rollers, the driven parts include the motor, gearbox and connection shaft.

High overturn support
Electric controller

It is with safety protections, emergency stop function, the main parts can be international standard. The electronic parts brand is Schneider.

备注
Remarks

储料活套为非标产品，我公司可以根据客户要求定制配套的活套。
The strip accumulator is non-standard product, our company can make strip accumulator according to customer's demand.

电脑飞锯
Computer Flying Saw

功能
Function

电脑飞锯是焊管生产线中的重要设备，它是在高速行进中自动精度定尺锯切各种形状的管材，达到所需长度的钢管。飞锯配备CD系列飞锯控制系统，定尺及同步性能好，机械传动可靠，具有速度快、性能好和精度高的特点，使生产效率大幅度提高。

This computer flying saw is one important equipment of total welded tube production. The CD series flying saw control system has a wide range of uses, such as following the tracks of the pipes(or other materials) and cutting them automatically. The system can greatly improve the productivity.



组成
Construction

本机由床身、齿轮条箱、锯车、测速系统、气路系统、驱动系统、电气系统、托辊架等部分组成。

Machine body, gear box, saw car, speed measuring system, air system, drive system, electric control system, roller frame, etc.

操作
Operation

电脑飞锯是自动运行操作。
电脑飞锯由交流伺服电机驱动。管子由两个液压缸夹住，被高速旋转的锯片切断，然后飞锯快速返回到起点。

It is full automatic operation.
The machine is travelling at same speed as tube on the carriage which is driven by AC. Servo motor. Tube is clamped by two hydraulic cylinder on both and cut by rotating saw which drop down by hydraulic cylinder on bearing with rail. Then, the machine returns rapidly to starting point. The saw is driven by AC. Motor. Cut length is accurately controlled by servo drive unit.

辅助机械&焊管模具

Accessory Equipments & Welded pipe mould

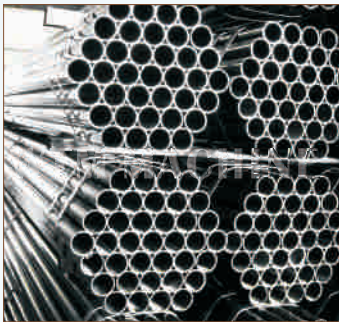
开卷机
Uncoiler



焊管模具-轧辊
Welded pipe mould-rollers



成品
Finished products



备件

Spare Parts



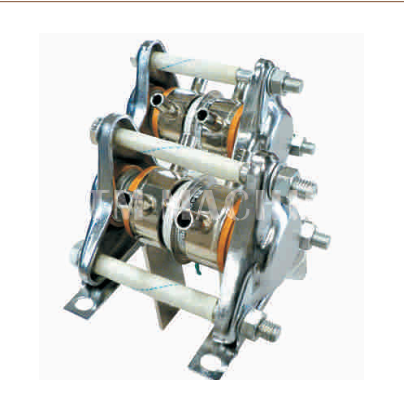
板型电容
Plate type capacitor



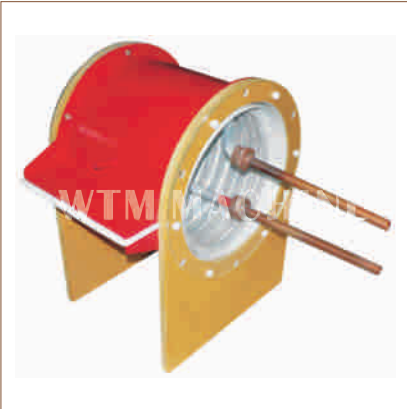
电子管水套
Water jacket of electric



电子管稳压器
Tube regulator



可控硅水套
Water jacket of silicon controlled



焊变
Welding part



锯片
Saw



可控硅
Silicon controlled

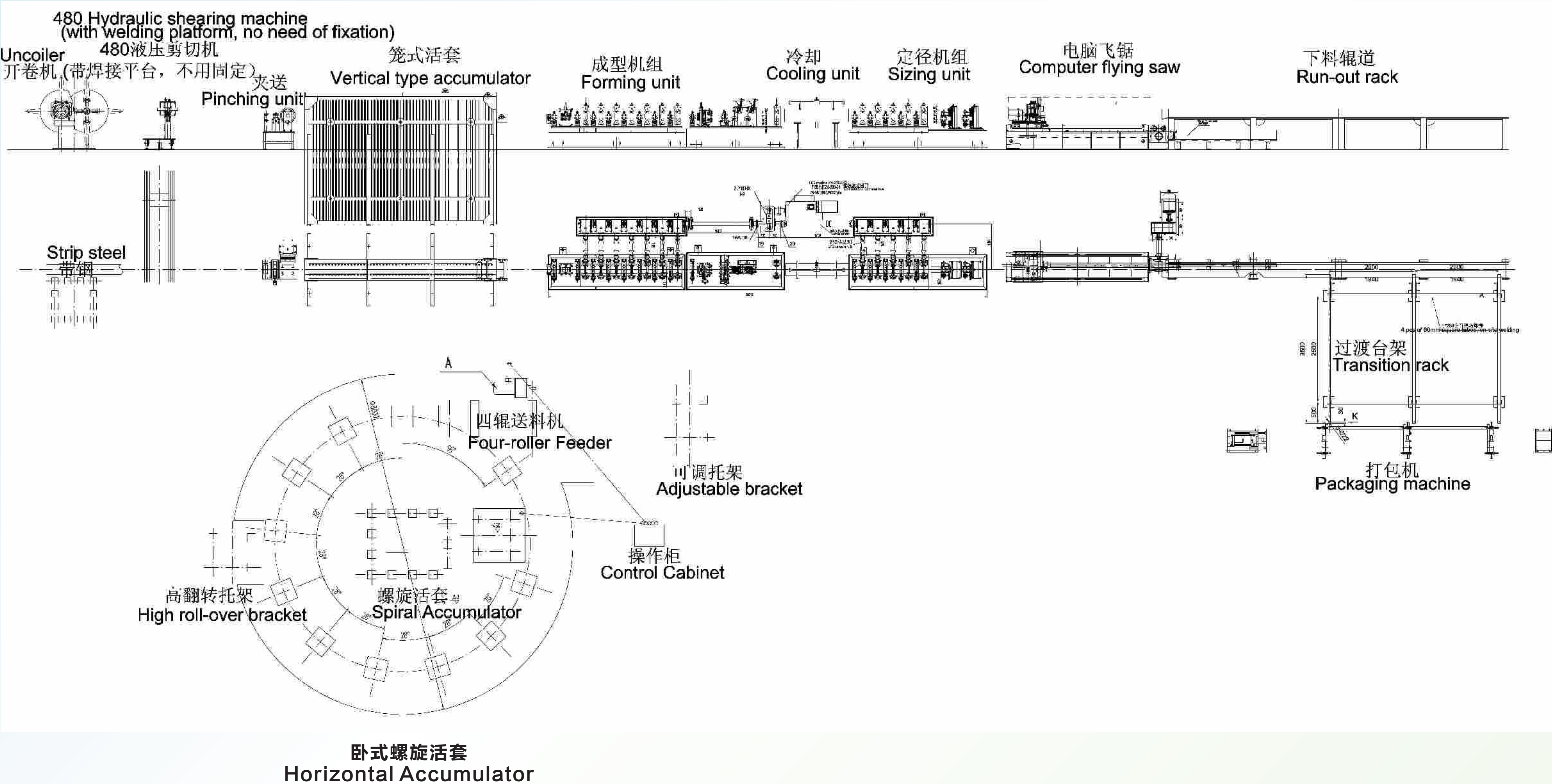


水冷电容
Water-cooled capacitor



油浸电容
Oil immersed capacitor

ZG 系列高频焊管机 组工艺流程示意图
Working -flow chart for ZG series pipe-making machine



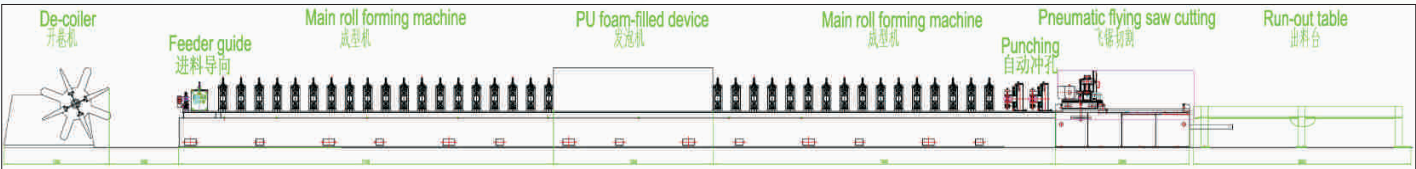
全自动欧式卷帘窗成型机
Automatic Rolling Shutter Slats Roll Forming Machine

工艺流程
Technical process

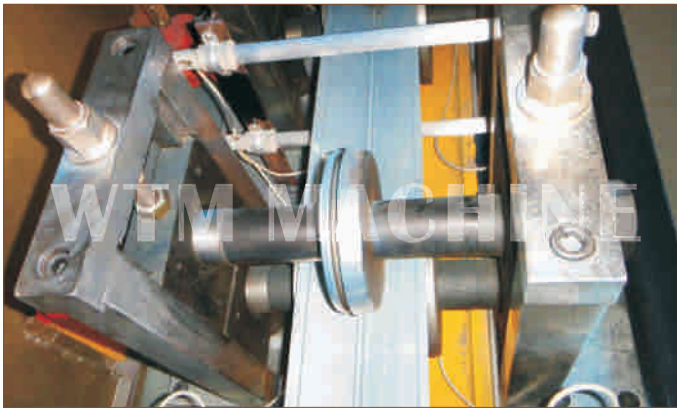
双头开卷机 → 进料导向 → 成型辊道 → PU发泡 → 自动冲孔 → 气动切断 → 成品出料
Double head decoiler → Feeder guide → Roll forming → PU injection → Punching → Pneumatic flying saw cutting → Run- out table



卷帘窗生产线布局图
Layout plan of roll shutter slats forming machine



欧式卷帘窗成型生产线
Rolling shutter slats forming machine



成型辊道
Roll forming part of shutter slats forming machine



聚氨酯发泡机
PU foam-filled device

欧式卷帘窗应用
Windows shutter application



设备组成
Components

双边式放料架
Double-head decoiler
滚轮成型主机
Main roll forming machine
聚氨酯发泡机
Polyester expanding machine
气压自动切割机
Pneumatic cutting machine
气压自动冲孔机
Pneumatic punching machine
PLC自动控制系统
Automatic PLC control system
跑料台
Run-out table

设备参数
Parameters

进料板厚：0.27-0.5mm
Steel thickness: 0.27-0.5mm
进料宽度：117-310mm
Steel width: 117-310mm
成型道次：37段或41段
Forming step: 37 or 41
主电机功率：11kw
Main motor power: 11kw
成型规格：ABE37, ABE42, ABE55, ABE65, ABE77, ABE90
Formed size: ABE37, ABE42, ABE55, ABE65, ABE77, ABE90

屋脊瓦成型机

Roof Ridge Cap Roll Forming Machine



工艺流程

Technical process

开料架 → 脊瓦成型机 → 电控柜 → 液压控制系统 → 成型模具 → 切断装置
Uncoiler → Roll forming machine → Control cabinet → Hydraulic control system → Forming mould → Shearing device

设备组成

Components

开料架, 进料平台, 成型主机, 成型模具, 剪切部分, 液压系统, 电控柜, 标配件(链条, 液压油管, 电磁阀, 限位开关)。

Uncoiler, feeding platform, main forming machine, mould former, shearing device, hydraulic system, control cabinet, Counter, Standard components.



设备参数

原料：彩钢板, 镀锌板
原料厚度：0.4-0.1.2mm
辊子排数：10-12排
外形尺寸：大约6.2*1.2*1.4米
功率：3.5KW+3.5KW
生产率：2-3m/min
卷筒直径：70mm
重量：大约2.5T
电源要求：220/380V 60HZ 3相

Parameters

Suitable material: colored steel plate, galvanized board
Material thickness: 0.4-1.2mm
Rows of rollers: 10-12 rows
Size: About 6.2*1.2*1.4m
Power: 3.5kw+3.5kw
Productivity: 2-3m/min
Diameter of shaft: 70mm
Machine weight: about 2.5T
Power supply: 220/380 V 60 HZ 3 phase

波纹瓦成型机

Corrugated Roll Forming Machine



工艺流程

Technical process

放料 → 进料导向 → 主机成型 → 液压切断 → 成品出料 → PLC控制
De-coiler → Feed with guide → Roll forming → Hydraulic cutting with fixed length → Run-out table → PLC control

设备参数

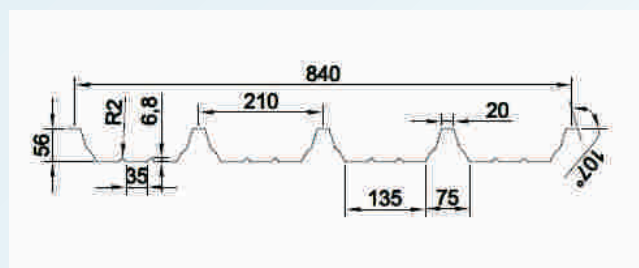
板料材质：镀锌板
板料厚度：0.15-1.0mm
最大进料宽度：1250mm
成型辊道次：18道
主机成型速度：约12-20m/min
主机结构形式：墙板式整体钢结构
传动方式：链轮链条传动
电源：380V,三相,50HZ
轧辊材质：轴承钢GCr15热处理
主轴材料：45号优质钢调质处理；
链轮：材料45号钢高频淬火；节距31.8；齿数10牙；
主机功率：5.5KW；
切断：采用飞锯停机切断。切刀材料Cr12Mov;淬火HRC58-62；
电控系统：全机采用工业电脑PLC控制。其配置PLC和触摸屏均为西门子品牌；旋转编码器为日本欧姆龙品牌；变频器为日本松下品牌；
生产线总尺寸：14000*2000*2400mm
设备总重量：约14吨左右；

Parameters

Material: galvanized steel sheet
Sheet thickness: 0.15-1.0mm
Max. Input width: 1250mm
Number of stations: 18 stations
Rolling speed: about 12-20m/min
Structure: Wall panel
Way of drive: by chain
Electric Source: 380V, 50HZ, 3 phase, Also can satisfy customer's require
Roll material: Gcr15 steel, heat treatment;
Main shaft material: 45# steel, quenching and tempering treatment;
Chain: material 45# steel, high-frequency hardening, pitch: 31.8; number of teeth: 10;
Main motor power: 5.5KW;
Cutting: use saw cutting. Blade material: Cr12Mov; Quenching HRC58-62;
Electric control system: Siemens system;
Machine size: 14000mm*2000mm*2400mm;
Total machine weight: about 14 tons.

TT 56-210 楼承板成型机

Metal Deck Roll Forming Machine



基本参数 General

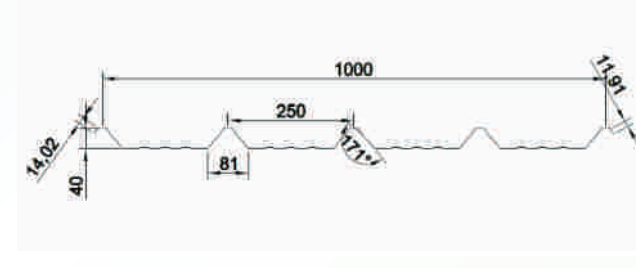
- | | |
|----------------------------|--|
| 1). 材料厚度: 0.4-1.0mm | 1). Thickness of steel coil: 0.4-1.0mm |
| 2). 适用原材料: PPGI, GI | 2). Material: PPGI, GI |
| 3). 进料宽度: 1220mm | 3). Input width: 1220mm |
| 4). 出料宽度: 840mm | 4). Output width: 840mm |
| 5). 设备总长度 (从开料架到收料台): 约15米 | 5). Total length (from de-coiler to output table): about 15M |
| 6). 设备总重: 约13吨 | 6). Total weight: about 13T |
| 7). 长度误差: 10±2mm | 7). Tolerance of length: 10±2mm |

成型系统 Main roll forming machine

- | | |
|---|---|
| 1). 机架: 采用350H钢焊接 | 1). Machine stand: 350H steel welding structure |
| 2). 成型机形式: 墙板式, 厚度14mm | 2). Structure: wall panel, thickness 14mm |
| 3). 成型排数: 20道 | 3). Number of stations: 20 stations |
| 4). 主轴材质: 45#钢 外径: 80mm 轴的处理: 调制, 外圆磨, 表面处理 | 4). Main shaft material: 45# steel, O.D.: 80mm, quenching and tempering treatment |
| 5). 辊轮材质: 优质45#钢, 淬火58-60° | 5). Roller material: high grade 45# steel, quenching 58-60°C |
| 6). 传动方式: 链条传动 | 6). Way of drive: by chain |
| 7). 成型速度: 8米/分钟 | 7). Forming speed: 8 m/min |
| 8). 主功率: 11kw. | 8). Main motor power: 11kw |
| 9). 外形尺寸 (长*宽*高): 11.0×1.7×1.7m | 9). Dimension (L*W*H): 11.0×1.7×1.7m |

TT 40-250 屋面板成型机

Roof Panel Roll Forming Machine



基本参数 General

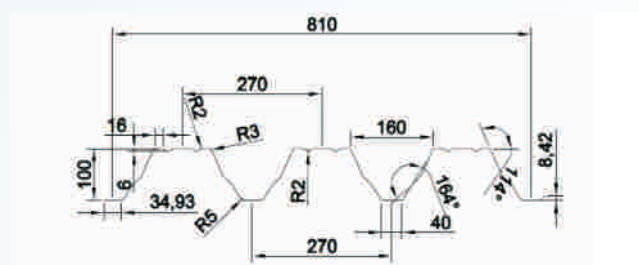
- | | |
|----------------------------|--|
| 1). 材料厚度: 0.3-0.9mm | 1). Thickness of steel coil: 0.3-0.9mm |
| 2). 适用原材料: PPGI, GI | 2). Material: PPGI, GI |
| 3). 进料宽度: 1220mm | 3). Input width: 1220mm |
| 4). 出料宽度: 1000mm | 4). Output width: 1000mm |
| 5). 设备总长度 (从开料架到收料台): 约13米 | 5). Total length (from de-coiler to output table): about 13M |
| 6). 设备总重: 约13吨 | 6). Total weight: about 13T |
| 7). 长度误差: 10±2mm | 7). Tolerance of length: 10±2mm |

成型系统 Main roll forming machine

- | | |
|---|---|
| 1). 机架: 采用350H钢焊接 | 1). Machine stand: 350H steel welding structure |
| 2). 成型机形式: 墙板式, 厚度14mm | 2). Structure: wall panel, thickness 14mm |
| 3). 成型排数: 15道 | 3). Number of stations: 15stations |
| 4). 主轴材质: 45#钢 外径: 80mm 轴的处理: 调制, 外圆磨, 表面处理 | 4). Main shaft material: 45# steel, O.D.: 80mm, quenching and tempering treatment |
| 5). 辊轮材质: 优质45#钢, 淬火58-60° | 5). Roller material: high grade 45# steel, quenching 58-60°C |
| 6). 传动方式: 链条传动 | 6). Way of drive: by chain |
| 7). 成型速度: 8-10米/分钟 | 7). Forming speed: 8-10 m/min |
| 8). 主功率: 5.5kw. | 8). Main motor power: 5.5kw |
| 9). 外形尺寸 (长*宽*高): 9.0×1.7×1.6m | 9). Dimension (L*W*H): 9.0×1.7×1.6m |

TH 100-270楼承板成型机

Floor Deck Roll Forming Machine



基本参数 General

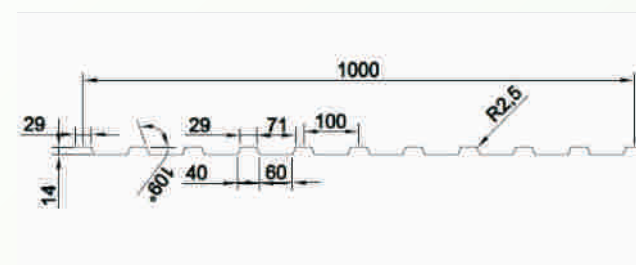
- | | |
|----------------------------|--|
| 1). 材料厚度: 0.7-1.25mm | 1). Thickness of steel coil: 0.7-1.25mm |
| 2). 适用原材料: PPGI, GI | 2). Material: PPGI, GI |
| 3). 进料宽度: 1220mm | 3). Input width: 1220mm |
| 4). 出料宽度: 810mm | 4). Output width: 810mm |
| 5). 设备总长度 (从开料架到收料台): 约18米 | 5). Total length (from de-coiler to output table): about 18M |
| 6). 设备总重: 约8吨 | 6). Total weight: about 8T |
| 7). 长度误差: 10±2mm | 7). Tolerance of length: 10±2mm |

成型系统 Main roll forming machine

- | | |
|---|---|
| 1). 机架: 采用350H钢焊接 | 1). Machine stand: 350H steel welding structure |
| 2). 成型机形式: 墙板式, 厚度14mm | 2). Structure: wall panel, thickness 14mm |
| 3). 成型排数: 24道 | 3). Number of stations: 24stations |
| 4). 主轴材质: 45#钢 外径: 80mm 轴的处理: 调制, 外圆磨, 表面处理 | 4). Main shaft material: 45# steel, O.D.: 80mm, quenching and tempering treatment |
| 5). 辊轮材质: 优质45#钢, 淬火58-60° | 5). Roller material: high grade 45# steel, quenching 58-60°C |
| 6). 传动方式: 链条传动 | 6). Way of drive: by chain |
| 7). 成型速度: 8米/分钟 | 7). Forming speed: 8 m/min |
| 8). 主功率: 18.5kw | 8). Main motor power: 18.5kw |
| 9). 外形尺寸 (长*宽*高): 6.7×1.7×1.3m | 9). Dimension (L*W*H): 6.7×1.7×1.3m |

TB 14-100 墙面板成型机

Wall Panel Roll Forming Machine



基本参数 General

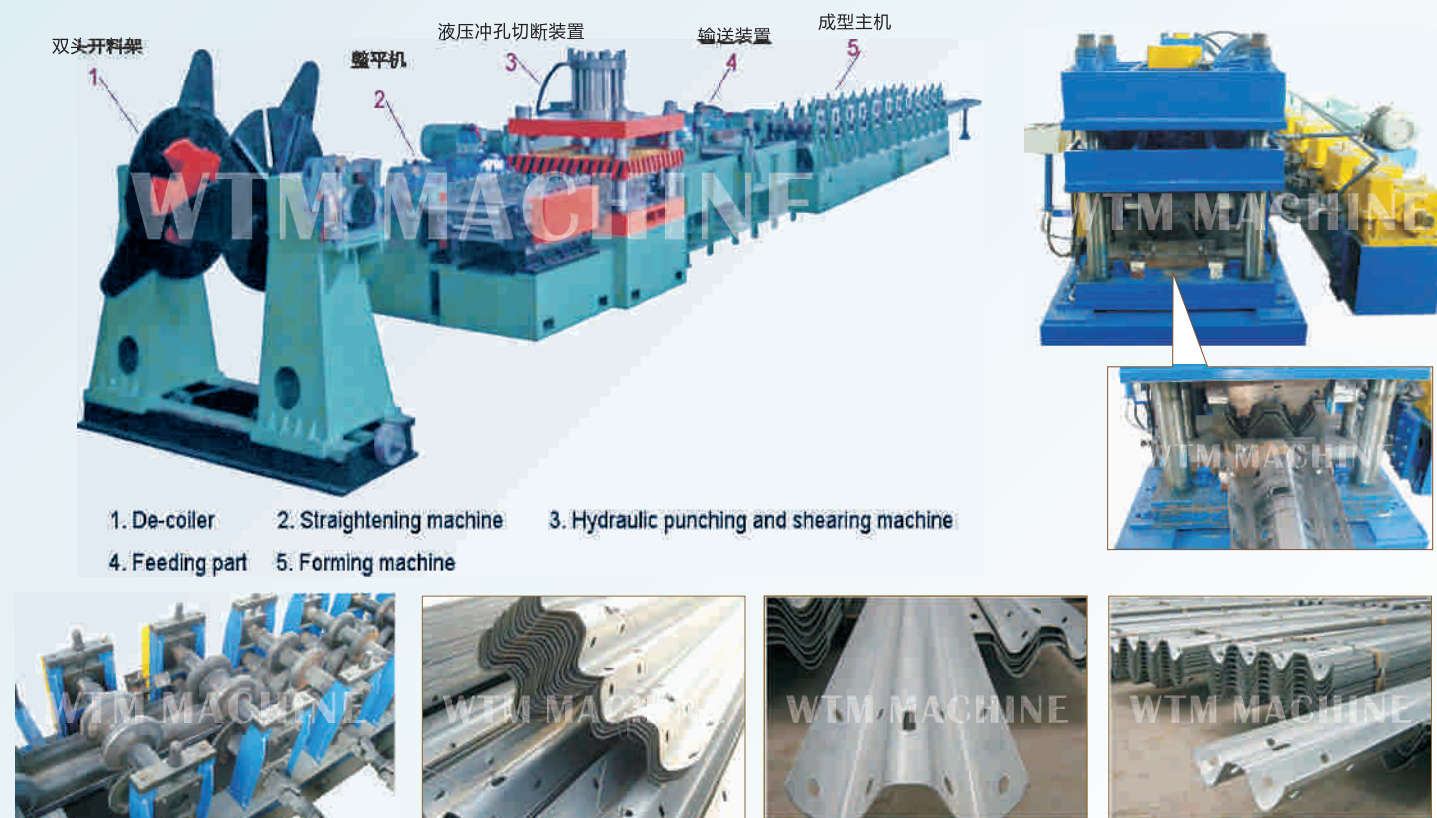
- | | |
|-------------------------------|---|
| 1). 材料厚度: 0.3-0.9mm | 1). Thickness of steel coil: 0.3-0.9mm |
| 2). 适用原材料: PPGI, GI | 2). Material: PPGI, GI |
| 3). 进料宽度: 1220mm | 3). Input width: 1220mm |
| 4). 出料宽度: 1000mm | 4). Output width: 1000mm |
| 5). 设备总长度 (从开料架到收料台): 约15-16米 | 5). Total length (from de-coiler to output table): about 15-16M |
| 6). 设备总重: 约8吨 | 6). Total weight: about 8T |
| 7). 长度误差: 10±2mm | 7). Tolerance of length: 10±2mm |

成型系统 Main roll forming machine

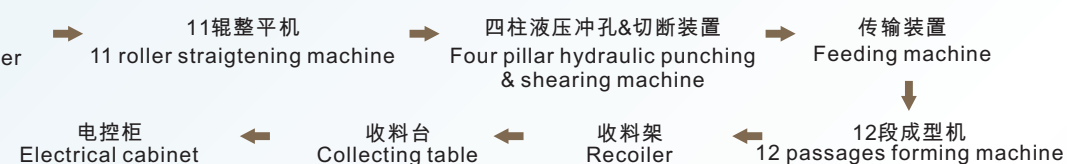
- | | |
|---|---|
| 1). 机架: 采用350H钢焊接 | 1). Machine stand: 350H steel welding structure |
| 2). 成型机形式: 墙板式, 厚度14mm | 2). Structure: wall panel, thickness 14mm |
| 3). 成型排数: 13道 | 3). Number of stations: 13 stations |
| 4). 主轴材质: 45#钢 外径: 80mm 轴的处理: 调制, 外圆磨, 表面处理 | 4). Main shaft material: 45# steel, O.D.: 80mm, quenching and tempering treatment |
| 5). 辊轮材质: 优质45#钢, 淬火58-60° | 5). Roller material: high grade 45# steel, quenching 58-60°C |
| 6). 传动方式: 链条传动 | 6). Way of drive: by chain |
| 7). 成型速度: 8米/分钟 | 7). Forming speed: 8 m/min |
| 8). 主功率: 5.5kw. | 8). Main motor power: 5.5kw |
| 9). 外形尺寸 (长*宽*高): 8.5×1.7×1.6m | 9). Dimension (L*W*H): 8.5×1.7×1.6m |

护栏板成型机

Guardrail Roll Forming Machine



工艺流程 / Technical process



设备参数

1. 双头开料架：
承重：10T
开卷内径：550mm
电机功率：7.5kw
外形尺寸：
2500*1300*2300mm
2. 整平机
辊径：100mm
电机类型：变频
整平辊数量：11
电机功率：7.5kw
外形尺寸：
1600*2300*1200mm
3. 液压冲孔&剪断装置
剪切力：180T
液压功率：7.5kw
外形尺寸：
1600x1300x2000mm

输送装置
功率：4kw
外形尺寸：3700x1800x1300mm
成型主机
轧辊直径：80mm
主电机功率：55kw
外形尺寸：8600x3200x1400mm
收料台
外形尺寸：4500x500x730mm
主减速机型号：ZQ650
成型轧辊材质：GCr15
冲孔头材质：T10；切断刀模材质：Cr12
成型生产线空间（长*宽*高）：
26000x3700x2500mm
生产线重量：35T
总生产速度：12M/s
操作人员：3人

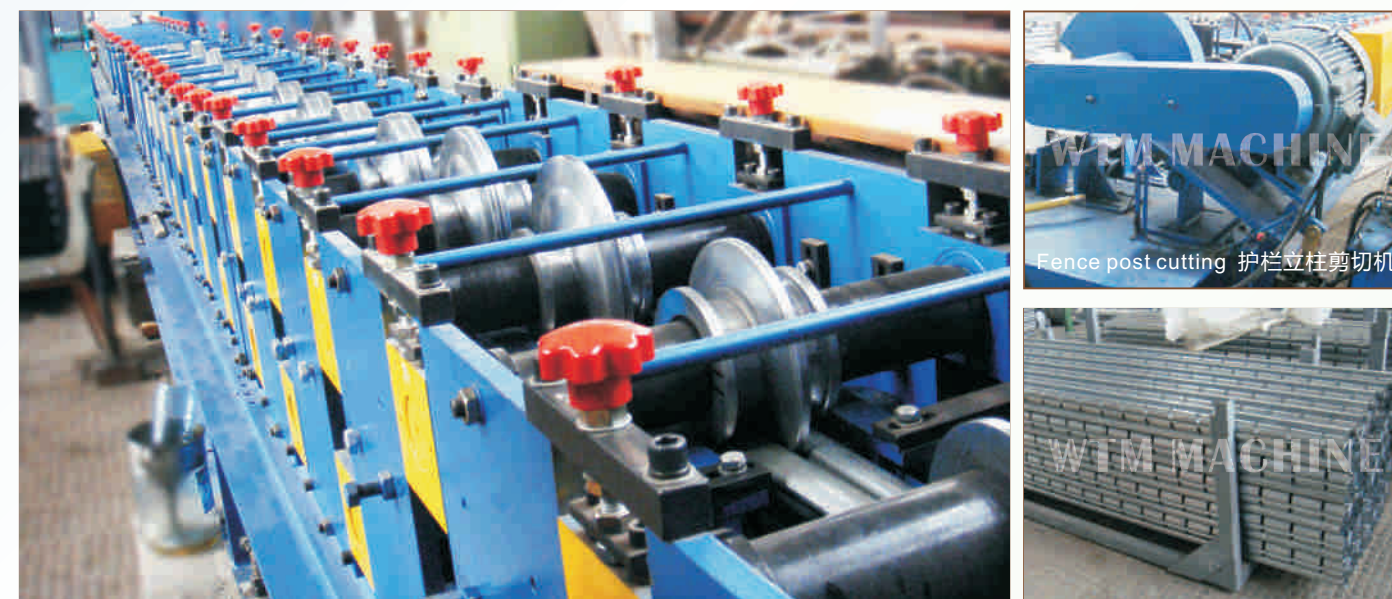
Parameters

1. Two head decoiler
Loading weight: 10T
Inner diameter: 550mm
Motor power: 7.5kw
Overall dimension:
2500*1300*2300mm
2. Straightening machine
Roller diameter: 100mm
Motor type: frequency
Number of the roller: 11
Motor power: 7.5kw
Overall size:
1600*2300*1200mm
3. Hydraulic punching and shearing machine
Cutting pressure: 180T
Hydraulic motor power: 7.5kw
Overall size:
1600*1300*2000mm
4. Feeding machine
Motor power: 4kw
Overall size:
3700*1800*1300mm

5. Forming machine
Roller diameter: 80mm
Main motor power: 55kw
Overall size:
8600*3200*1400mm
6. Collecting table
Overall size: 4500*500*730mm
7. Main reducer model:
ZQ650
8. Forming mould material:
GCr15
9. Material of the punching head: T10; Material of shearing mould: Cr12
10. Needed space of the production line(L*W*H):
26000*3700*2500mm
11. Weight of full production line: 35T
12. Total speed: 12m/s
13. Workers required: 3 workers

护栏立柱成型机

Fence Post Roll Forming Machine



工艺流程

Technical process



主要技术参数

板材厚度：0.8-1.2mm
工作速度：3-5m/min；
辊轧组数：22道主辊；
轧辊材料：Gcr15优质钢精加工处理，高频
淬火HRC58-62，轧辊辊径Φ120；
主轴材料：45号优质钢调质处理（轴径60mm）；
链轮：材料45号钢高频淬火；节距31.8；
齿数10牙；
主机功率：7.5KW；
切 断：采用飞锯停机切断，液压冲孔。
切刀材料Cr12Mov；淬火HRC58-62；
液压冲孔，切断系统电机功率：3KW；
电控系统：全机采用工业电脑PLC控制。其配置
PLC为日本松下品牌；触摸屏为日本
松下品牌；旋转编码器为日本欧姆龙
品牌；变频器为日本松下品牌；
机器外形尺寸：12000mm×900mm×1100mm；
设备总重量：约11吨左右；

Main technical parameters

Steel thickness: 0.8-1.2mm
Working speed: 3-5m/min;
Roll stands: 22
Roll material: Gcr15 steel, high-frequency hardening HRC58-62, roll
diameter: 120mm;
Main shaft material: 45# steel, quenching and tempering treatment, shaft
diameter 60mm;
Chain: material 45# steel, high-frequnecy hardening, pitch31.8; number
of teeth: 10;
Main motor power: 7.5KW;
Cutting: use saw cutting, hydraulic punching. Blade material: Cr12Mov;
Quenching HRC58-62;
Motor of hydraulic punching and cutting device: 3KW;
Electric control system: PLC system, brand: Panasonic; Touch screen brand:
Panasonic; Rotary enclider brand: Omron;
Converter brand: Panasonic;
Machine size: 12000mm×900mm×1100mm;
Total machine weight: about 11 tons

C型檩条成型机 Steel C Purlins Roll Forming Machine

工艺流程 Technical process

开卷放料 → 液压成型 → 定长切断 → 收料
Uncoiler → Roll forming → Hydraulic cutting → Run-out table

主要技术参数

Main technical parameter

轧制宽度：200mm
轧制厚度：1-2mm
成型道次：14道
轧制速度：0-15m/min
刀模材质：Cr12
轧辊材质：Gcr15
液压站功率：5.5KW
电机功率：15KW
外形尺寸：18000*1700*1500 (mm)
重量：8T

Install size: 13500mm*2200mm*1500mm
Rollers: 13-15 rows
Rolling material: Gcr 15
Main motor power: 11 KW
Hydraulic unit power: 11 KW
Pressure of the hydraulic unit: 18-20Mpa
Productivity: 9-10 m/min
Punching material: Cr12
Electric control system: PLC vector inverter
Raw material thickness: 1.5-3.0mm
Forming standard: 80-300
Shaped rib (optional)



彩钢琉璃瓦成型机 Steel Tile Roll Forming Machine

工艺流程

Technical process

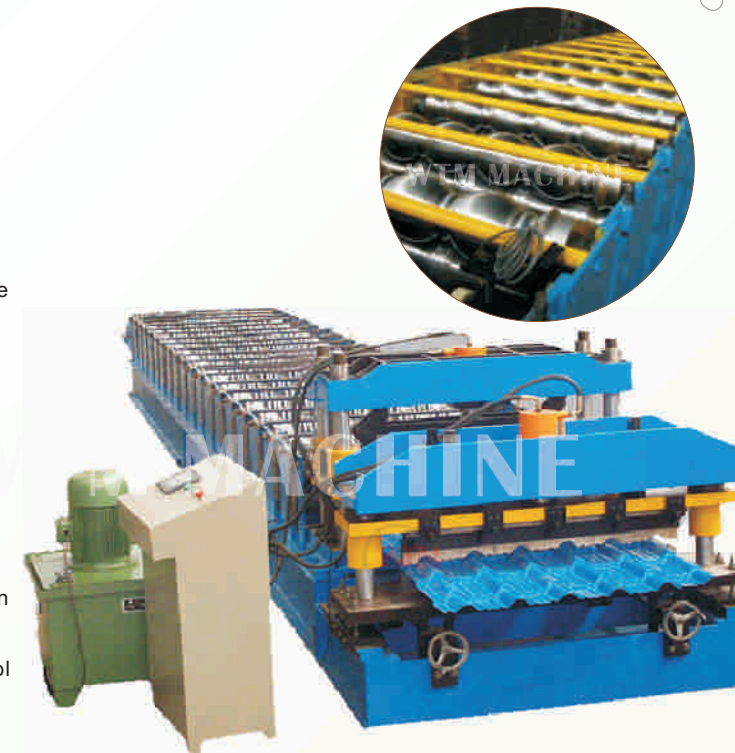
Uncoiler Feeder guider Roll forming Hydraulic cutting Run-out table
开卷机 → 进料导向 → 主机成型 → 液压切断 → 成品出料

主要技术参数

Main technical parameter

成型道次：16-25
长度：150-500mm
深度：10-30mm
成型速度：32折/分钟
板材厚度：0.5-0.6mm
原材料：45#钢板，镀铬处理
主电机功率：5.5kw
液压站功率：4kw
电源要求：380V 50HZ 3相
误差：1.5mm
控制系统：PLC控制，带触摸屏

Roller station: 16-25 groups
Thickness of Material: 0.4-0.8mm
Valid material: PPGI, GI, Aluminum sheet, etc
Forming Speed: 10-15 m/min
Transporting Type: chain transmission
Main Power: 5.5kw
Hydraulic station power: 4kw
Electrical control system: PLC control system with touch screen
Cutting type: Hydraulic cutting
Cutting length tolerance: +/- 0.5mm



Z型檩条成型机 Steel Z Purlins Roll Forming Machine

工艺流程

Technical process

开卷放料 → 液压成型 → 定长切断 → 收料
Uncoiler → Roll forming → Hydraulic cutting → Run-out table

主要技术参数

Main technical parameter

轧制宽度：200mm
轧制厚度：1-2mm
成型道次：14道
轧制速度：0-15m/min
刀模材质：Cr12
轧辊材质：Gcr15
液压站功率：5.5KW
电机功率：15KW
外形尺寸：18000*1700*1500 (mm)
重量：9T

Install size: 13500mm*2200mm*1500mm
Rollers: 15 rows
Rolling material: Gcr 15
Main motor power: 11 KW
Hydraulic unit power: 11 KW
Pressure of the hydraulic unit: 18-20Mpa
Productivity: 9-10 m/min
Punching material: Cr12
Electric control system: PLC vector inverter
Raw material thickness: 1.5-3.0mm
Forming standard: 80-300



落水管冷弯成型机 Downspout roll forming machine

工艺流程

Technical process

Uncoiler Feeder guider Roll forming Hydraulic cutting Run-out table
开卷机 → 进料导向 → 主机成型 → 液压切断 → 成品出料

主要技术参数

Main technical parameter

进料板厚：0.4-1.0mm
成型速度：8-10m/min
成型道次：20
主电机功率：3kw
液压切断功率：7.5kw
液压力：12Mpa

电源：380V 50HZ 3相
公差：1.5mm
切割刀片材质：Cr12
控制系统：PLC带触摸屏
机器重量：10T

Steel thickness: 0.5-0.8mm
Forming speed: 8-10m/min
Roller stands: 20 stand
Main motor power: 3kw
Shaft diameter: 80mm
Hydraulic cutting power: 7.5kw
Hydraulic pressure: 12Mpa

Power supply: 380V 50HZ 3 phase
Tolerance: 1.5mm
Material of cutting: Cr12
Control system: PLC with touch screen
Machine net weight: 10T



纵剪机
Slitting Machine



圆盘剪切机是由开卷、送料、剪切、卷取等设备组成的一条生产线，它的主要功能是将宽钢带卷沿长度方向剪切成较窄的一定尺寸的钢带卷，为日后的轧制、焊管、冷弯成型、冲压等工序制备坯料。同时，更换不同材质的刀具，可分剪各种有色金属带材。

Slitting line machine is not only for the steel service cutting industry, but also for the pipe industry. A lot of customers make the pipes before slitting the large coil to the small size of coils. Slitting line can do uncoiling, slitting and recoiling works, make coil steel to any needed width coil steel.

主要技术参数
Main Technical Parameters

Parameters 参数	型号 Model	1200型	1500型	1800型
原料 Processing Material		冷轧轧板、镀锌板、不锈钢板等 Cold-rolled steel coil, Galvanized coil, Color-coated coil, Stainless steel coil, etc.		
板料厚度 Processing Sheet Thickness		0.3-3.0mm	0.3-3.0mm	0.3-3.0mm
板料宽度 Processing Sheet Width		1200mm(MAX)	1500mm(MAX)	1800mm(MAX)
卷料重量 Coil Weight Permitted		15ton(MAX)	18ton(MAX)	20ton(MAX)
分条精度 Width Accuracy		± 0.1mm		
分条速度 Line Speed		150-200m/min(MAX)		



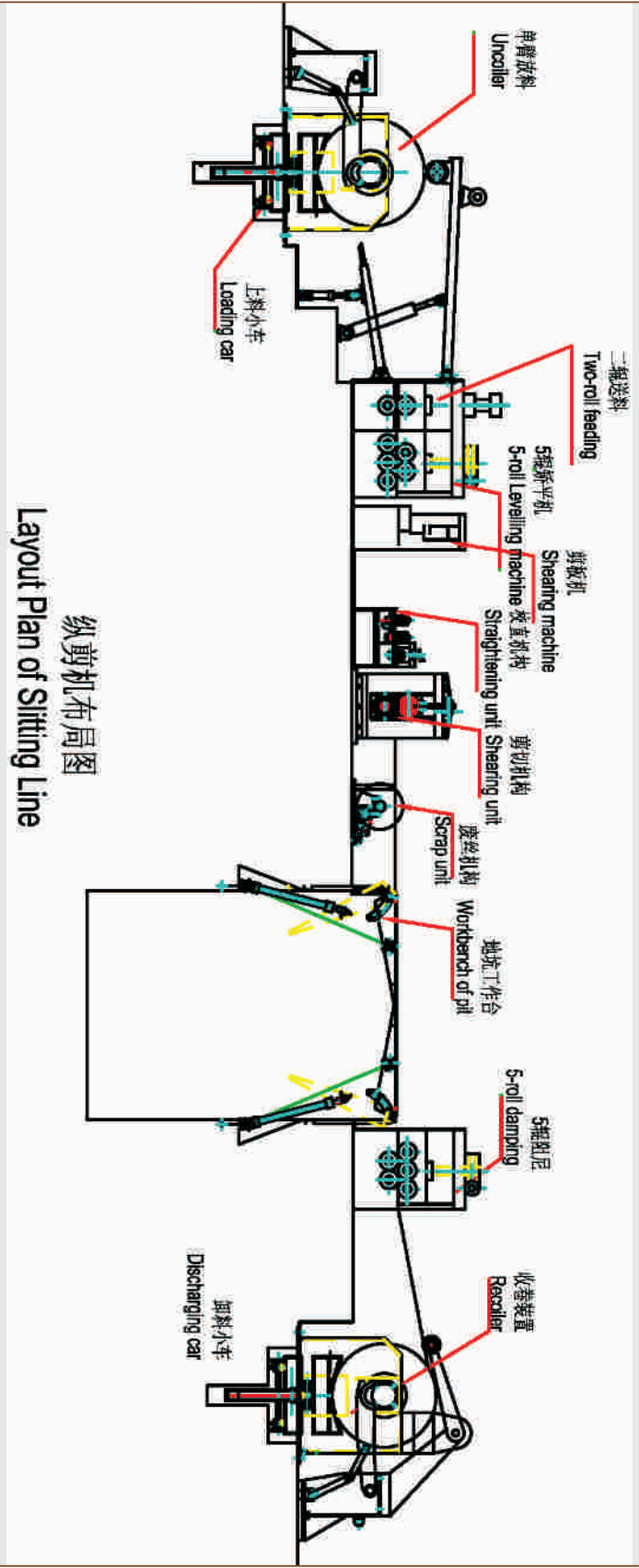
收卷机
Recoiler



分条
Slitting



分条刀模
Slitting mould



横切线 Cut-to-length line

产品描述 Description

该系列生产线用于将不同规格的卷料，经过开卷，矫平，剪切成为所需长度和宽度的平整板材。
该生产线布线合理，操作方便，自动化程度高，可加工各种不锈钢板，彩钢，铝板及电镀后涂装后的各类金属板材。适用于汽车，集装箱，家电，食品，建材等金属板材加工行业。
该生产线主要由上料小车，单或双支撑开卷机，初矫机，精剪机，堆垛装置，伺服传动系统等组成，同时在各机之间配有摆动式中间桥，牵引装置，纠偏装置等。

The cut to length line is applied for cutting steel coils to specified sheet material by the process of uncoiler, flattening, and cutting.

With reasonable layout, convenient operation, and high automatic level, the line is applied for stainless steel sheet, color sheet, aluminum sheet, and different kinds of sheet after galvanizing or coating process. It is used for autocar, container, electric appliance, food, packages, building industrial and so on.

The cut to length line consists of coil car, single or double bracing uncoiler, leveler, edge trimmer, cutter, stacker, and servo drive system, etc. Between every two machines, there are rocker middle bridge, puller, and adjusting system.



渡桥
Transfer bridge



升降台
Lifting table



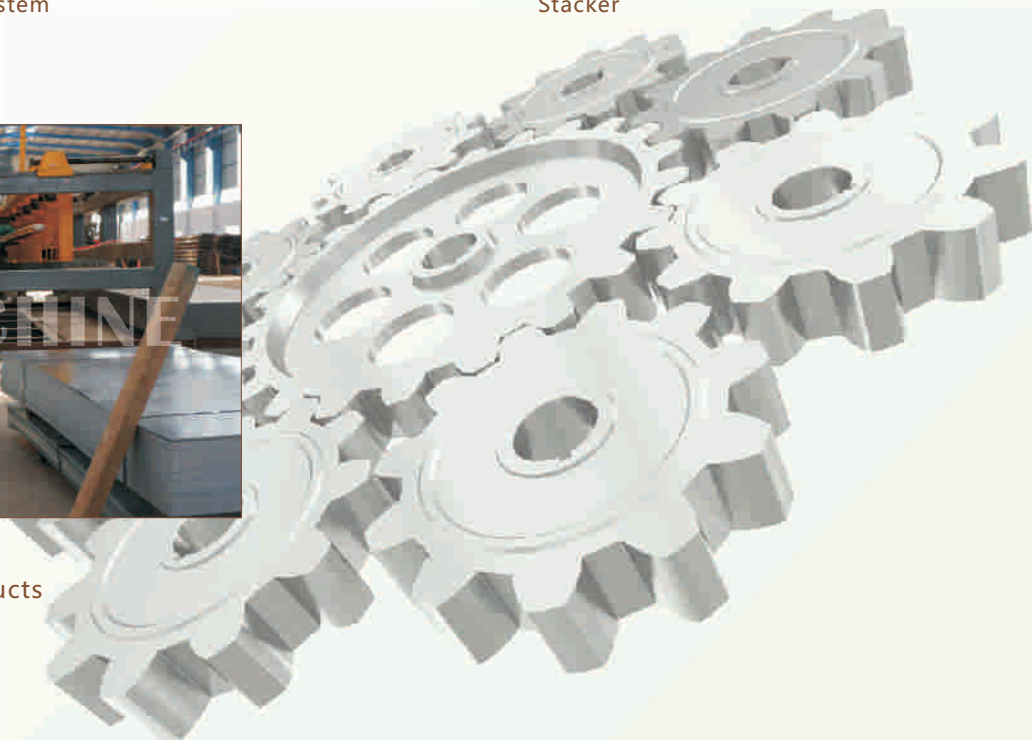
整平机
Straightening system



落料架
Stacker



成品
Finished products



为了设备符合客户要求及准确报价, 请对下列参数详细填写, 回传(Fax): 0510-88236613, 或发邮件(Email): sales@anber-inc.com

Please fill in the following blanks so that we can give you right offer.

客户名称(Customer Name): 日期(Date): 联系人(Contact Person):

电话(Tel): 手机(Mobile): 传真(Fax):

联系地址(Address):

矫平横切机组询盘需求表
Selection Guidance for Cut to Length Line

一、项目性质 Project.

☐ 新建项目(New project)

☐ 扩产项目(Expanding project)

二、原材料钢卷数 (Material coil data)

材质(Material): 屈服强度(Yield strength):

抗张强度(Tensile strength): 厚度(Thickness):最薄(Min.) mm → 最厚(Max.) mm

卷重(Coil weight): mm 内径(Coil I.D.): φ mm → φ mm

外径(Coil O.D.): φ mm → φ mm 宽度(Width): 最窄(Min.) mm → 最宽(Max.) mm

三、成品板技术要求 (Requirement for processed steel plate)

定尺长度(Length): 最短(Shortest) : mm 最长(Longest) : mm

定尺公差(Length tolerance): ± mm

矫平速度(Levelling speed) : mm

收料形式(Recoiling type) :

四、设备性能要求 (Requirement for the machine's performance)

设备配置(Equipment configuration):

☐ 经济实用型(Economical and practical)

☐ 精密高档型(Precise and with high speed)

电源要求(Power supply): V Hz

进料方向(Feeding direction) , 从操作面看(From the operation side):

☐ 左进料右出料Feeding from left, and output to right

☐ 右进料左出料Feeding from right, and output to left

电机控制(Motor control):

☐ 直流控制(DC control)

☐ 变频控制(VF control)

☐ 交流调速(AC control)

五、客户其他要求(Other requirements)

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联系地址(Address):

纵剪分条机组询盘需求表
Selection Guidance for Slitting Line

一、项目性质 Project.

☐ 新建项目(New project)

☐ 扩产项目(Expanding project)

二、原材料钢卷数 (Material coil data)

材质(Material): 屈服强度(Yield strength):

抗张强度(Tensile strength): 厚度(Thickness):最薄(Min.) mm → 最厚(Max.) mm

卷重(Coil weight): mm 内径(Coil I.D.): φ mm → φ mm

外径(Coil O.D.): φ mm → φ mm 宽度(Width):最(Min.) mm → 最厚(Max.) mm

三、成品技术要求 (Requirement for processed steel plate)

纵剪条数(Slitting pieces):最薄板(Thinnest sheets) : 条(PCS) 最厚板(Thickest sheets) : 条(PCS)

最窄条宽(Min. strip width): mm

分条精度(Slitting precision) : ± mm 收卷内径(Recoiling I.D.) : φ mm

收卷速度(Recoiling Speed) : m/min 收卷重量(Recoiling Weight) : ton

四、设备性能要求 (Requirement for the machine's performance)

设备配置(Equipment configuration):

☐ 经济实用型(Economical and practical)

☐ 精密高档型(Precise and with high speed)

电源要求(Power supply): V Hz

进料方向(Feeding direction) , 从操作面看(From the operation side):

☐ 左进料右出料Feeding from left, and output to right

☐ 右进料左出料Feeding from right, and output to left

电机控制(Motor control):

☐ 直流控制(DC control)

☐ 变频控制(VF control)

☐ 交流调速(AC control)

五、客户其他要求(Other requirements)

成品系列
Finished product series

彩钢瓦
Color steel tile

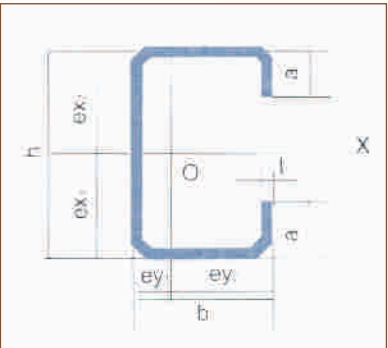
彩钢瓦是一种新型结构材料，近年来国内外出现了。其优点是重量轻，强度高，外观精美、寿命长（15-20年）。它已被广泛使用在首席工程由于其抗震防灾，耐热性，易于安装。以上的优点使其在大跨度建筑的一个理想的建筑材料。

Color steel tile is one kind of new construction material which the recent years emerged at home and abroad. It has many advantage such as light weight, high intensity, good apperance and long life span (15-20 years). It has been used widely in chief engineering due to its seismic prevention, heat resistance, and easy to install . Above merits allows it being an ideal building material for long-span construction.



Cold-rolled inward curling channel steel

mark: [300x 100x20x2.5-DB6723-86]
A3-GB700-79



Cold-rolled inward curling channel steel

外形尺寸 Dimension			
h	b	a	s
60	30	15	2
60	30	15	2.5
80	40	20	2
80	40	20	2.5
80	40	20	3
100	50	20	2
100	50	20	2.5
100	50	20	3
120	50	20	2
120	50	20	2.5
120	50	20	3
140	50	20	2
140	50	20	2.5
140	50	20	3
140	60	20	2
140	60	20	2.5
140	60	20	3
140	50	20	2
150	50	20	2.5
150	50	20	3
150	60	20	2
150	60	20	2.5
150	60	20	3
150	60	20	2

外形尺寸 Dimension			
h	b	a	s
150	60	20	2.5
150	60	20	3
160	70	20	2
160	70	20	2.5
160	70	20	3
180	70	20	2
180	70	20	2.5
180	70	20	3
200	70	20	2
200	70	20	2.5
200	70	20	3
200	80	20	2
200	80	20	2.5
200	80	20	3
250	80	20	2
250	80	20	2.5
250	80	20	3
300	100	20	2.5
300	100	20	3
300	100	20	4
350	100	20	2.5
350	100	20	3
350	100	20	4