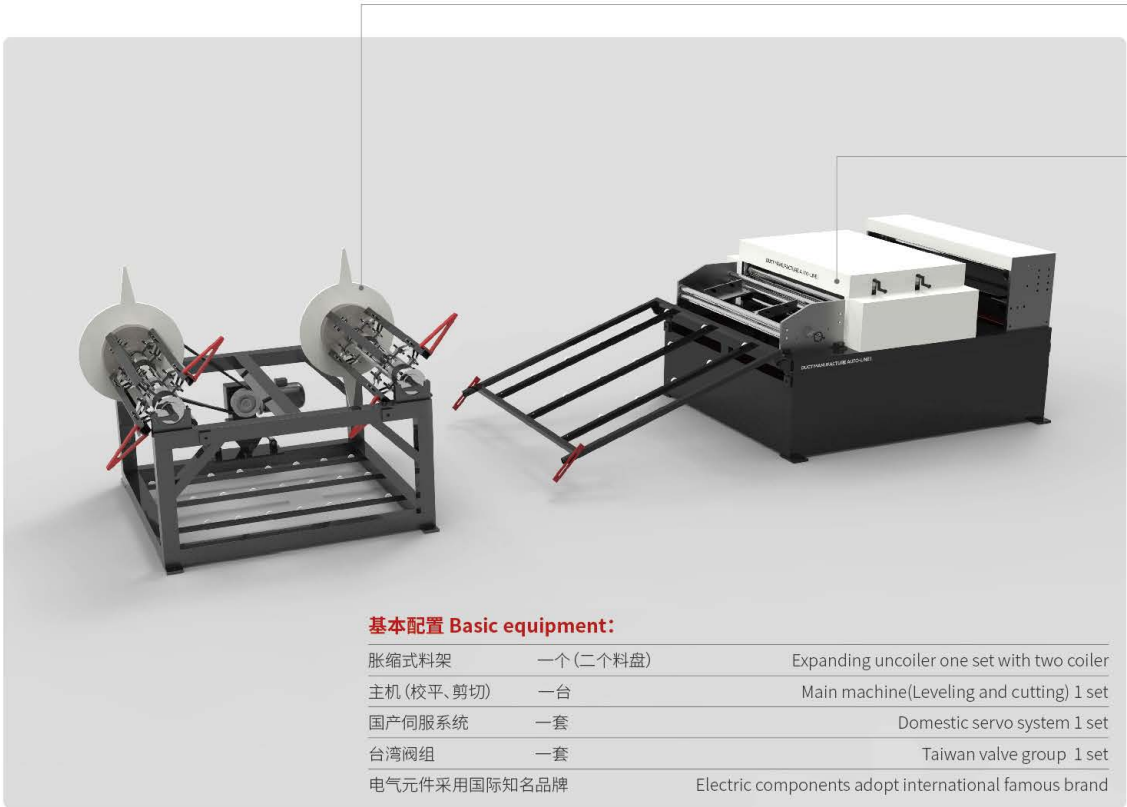


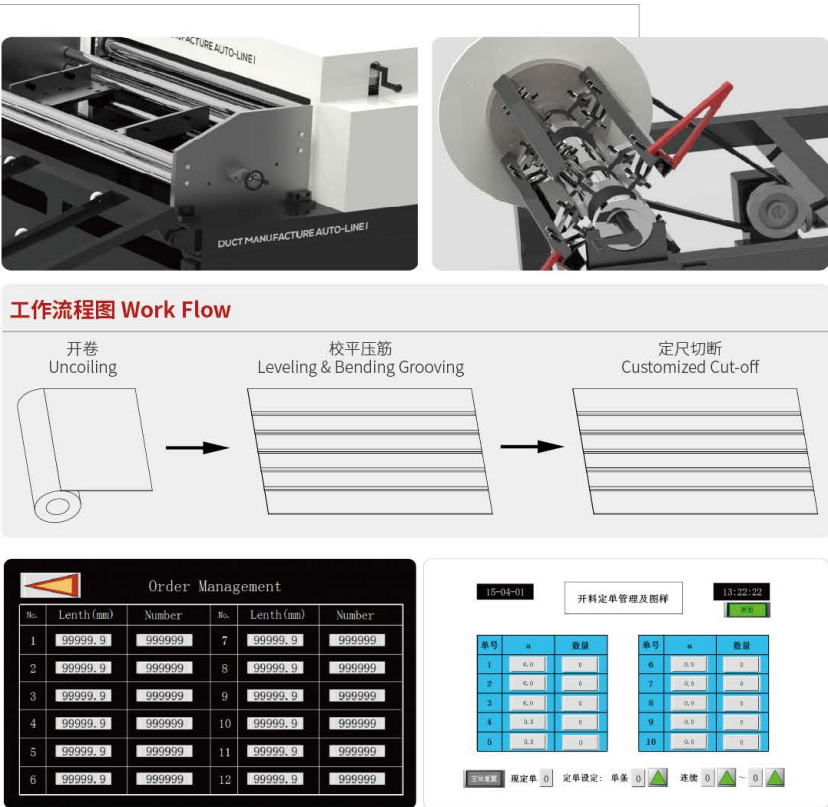
风管生产一线

Duct Automatic Line I

- 该生产线是由料架、校平压筋机构和液压剪切机构组成。控制部分采用全伺服控制。该生产线最大工作速度为16米/分，精度为：长度误差±0.5mm，对角线误差为±0.8mm。在经济 I 型的基础上，我们研发了IB型开卷平板生产线，IB型生产线可满足冷板厚度2.0mm，不锈钢板1.2mm的开卷生产。
- I 型、IB 型生产线均可根据客户的要求设置任意尺寸进行全自动下料生产。使用该生产线可以大大提高对板材的利用率，减少劳动强度和减少劳动力。该生产线具有优越的性价比。I 型生产线与辘骨机、折边机等组合便生为一组高效的风管生产设备。特别适合中小型的生产厂家使用。



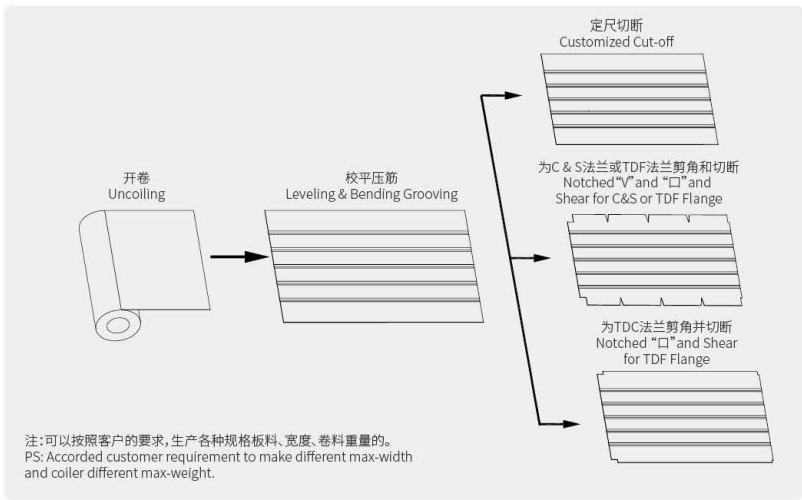
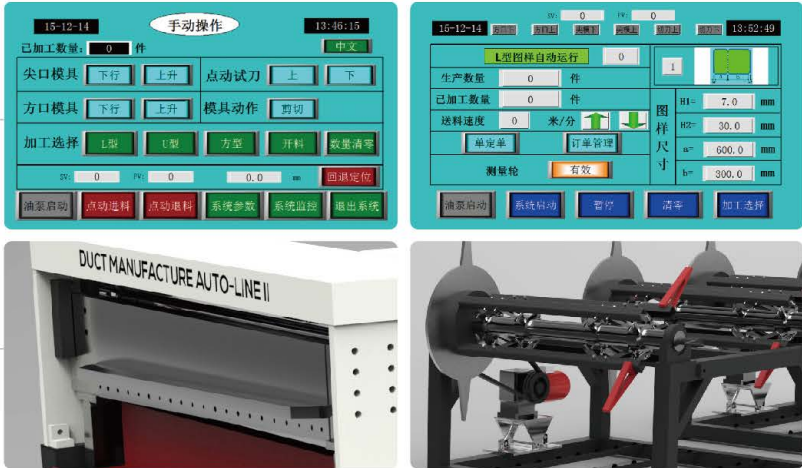
- The production line is composed of decoiler, leveling & grooving unit and hydraulic shear unit composition. The control section adopts full servo system control. The production line maximum operating speed of 20 m/min, accuracy: length tolerance ± 0.5mm, diagonal tolerance of ± 0.8mm. In the I type basis, we developed a type IB production line, IB-type production line to meet the mild steel thickness of 2.0mm, stainless steel of 1.2mm uncoiling production.
- Type I, IB-type production line can be set to any size fully automatic cutting production according to customer requirements. Use this production line can greatly improve the utilization of the steel plate, reduce labor intensity and reduce labor. The production line has a superior cost-effective. Combination of type I bone production line and reel machines, folding machines, etc. Can become a group of highly efficient duct production equipment. Especially for small and medium sized manufacturers use.



风管生产二线

Duct Automatic line II

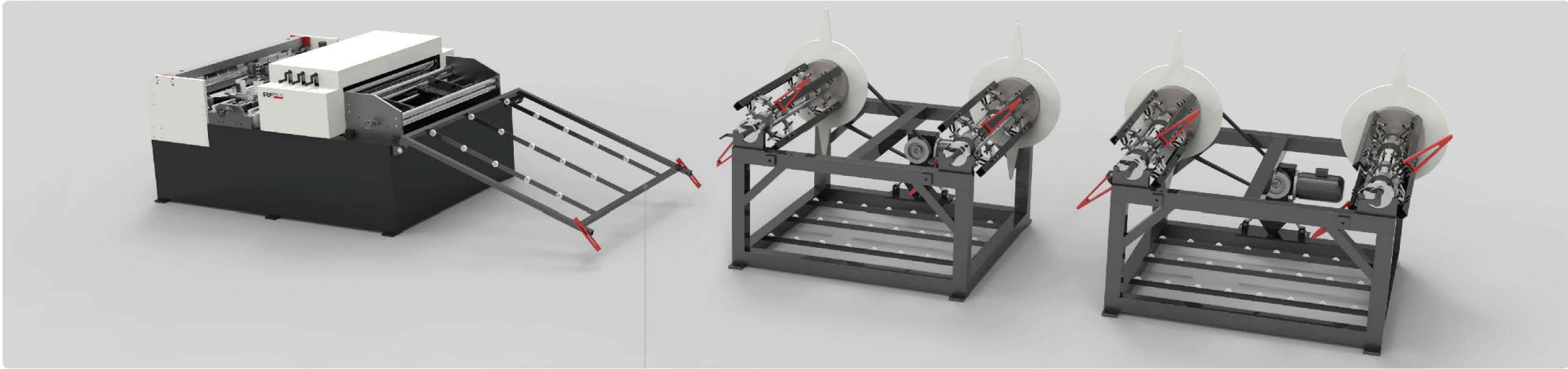
- 风管生产线 II 是在I型生产线的基础上增加了制作风管所需的冲切单元，它由料架、调平压筋单元、尖口冲切单元和方口冲切单元、切断单元所组成。标准配置为制作TDF法兰风管所需的尖口冲切单元和方口冲切单元，其中方口冲切单元也可用于生产TDC法兰。电器控制部分采用全伺服控制，该控制系统具有闭环反馈系统，加工精度和稳定性高。其最大工作速度为16米/分。长度误差为±0.5mm，对角线误差±0.8mm。
- Duct production line II is on the basis of the production line for type I add the cutting unit is used for air duct, this production line is composed of a decoiler, leveler & grooving unit, “V” and “口” notching unit, cutting unit composition. The standard configuration the “V” and “口” notching unit make for TDF flange duct, thereinto the “口” notching unit can also be used to produce TDC flange. Electrical control with full servo control, the control system has a closed-loop feedback system, high precision and stability. The maximum operating speed of 16 m / min. Length tolerance is ± 0.5mm, diagonal error ± 0.8mm.



风管生产三线

Duct Automatic line III

- 风管生产线III是由料架、校平压筋单元、尖口冲切单元和方口冲切单元、切断单元、折弯单元所组成。标准配置为制作TDF法兰风管所需的尖口冲切单元和方口冲切单元,其中方口冲切单元也可用于生产TDC法兰。折弯单元既可以加工与联合口相匹配的直角骨,也可以将板料折弯成“口”或“L”型之后,再经由辊骨机加工联合口,使之用于TDC法兰风管,大大提高对板材的利用率,减少劳动强度和减少劳动力。
- 该生产线电器控制部分采用全电脑控制,该控制系统具有闭环反馈系统,精度和稳定性明显提高。其最大工作速度为16米/分。长度误差为±0.5mm,对角线误差±0.8mm。本系统可满足单班生产1000m2方型风管能力。



基本配置 Basic equipment:

胀缩式料架	二个(四个料盘)	Expanding uncoiler( two sets with four coiler)
主机 (校平、剪切、折弯)	一台	Main machine(Leveling, cutting and folder) 1 set
剪角模具	一套	“V” and “口” notching unit 1 set
松下伺服系统	一套	Panasonic servo system 1 set
台湾阀组	一套	Taiwan valve group 1 set
电气元件采用国际知名品牌		Electric components adopt international famous brand

03

风管生产四线

Duct Automatic line IV

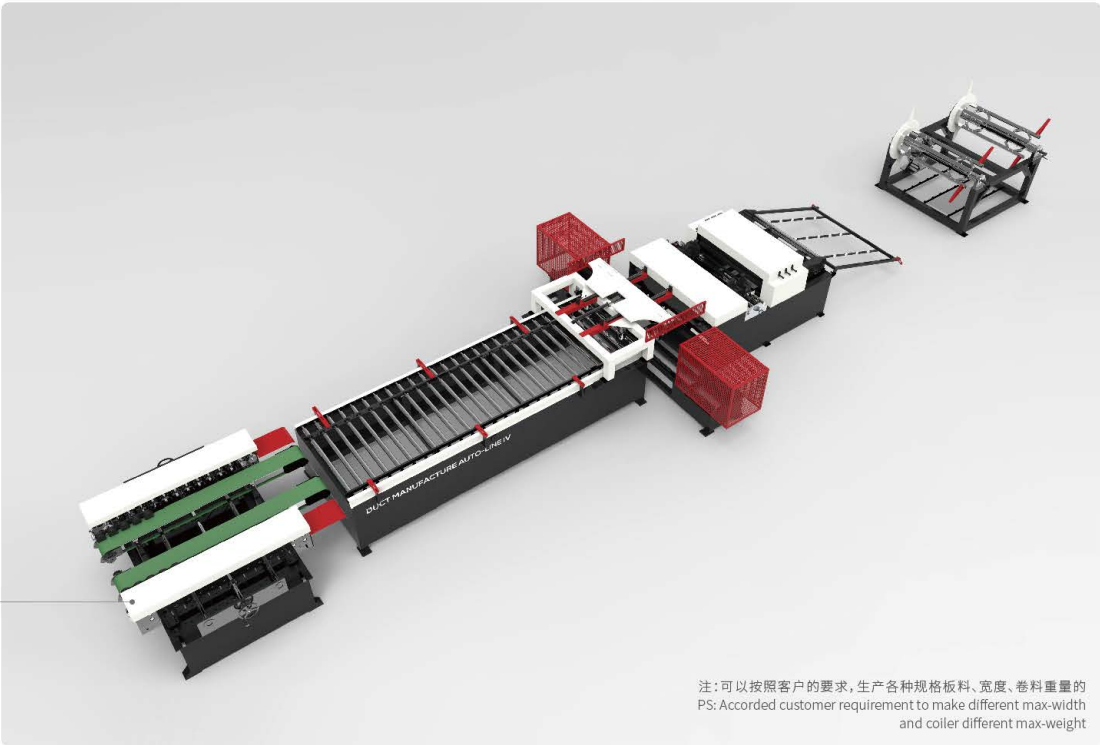
- 风管生产线IV是由料架、校平压筋、尖口冲切单元和方口冲切单元、切断单元、折弯单元、位移咬口单元、抓料机械手单元、双机联动角铁 & TDF法兰成形单元所组成。整个生产流程由伺服系统控制完成。
- 本生产线具有占地面积小、能耗低、易搬迁、高效等优点,可生产各种规格的矩形风管。控制部份采用独立的操作台;该控制系统具有闭环反馈系统,精度和稳定性明显提高。风管自动生产线进料速度为10m/min,长度误差为±0.5mm,对角线误差为±0.8mm;
- Duct production line III composed of a decoiler, leveler grooving unit, “V” and “口” notching unit, cutting unit, bending unit, reciprocating lock former unit, feed extraman unit, duplex flange (angle iron & TDF) composition, The entire production process is controlled by the servo system is completed.
- The production line has a cover an area of small, low energy consumption, easy to move, and high efficiency, can produce a variety of rectangular duct. Control part with a separate console; the control system has a closed-loop feedback system, significantly improved accuracy and stability. Duct automated production lines feed rate of 10m / min, length tolerance is ± 0.5mm, diagonal tolerance is ± 0.8mm;



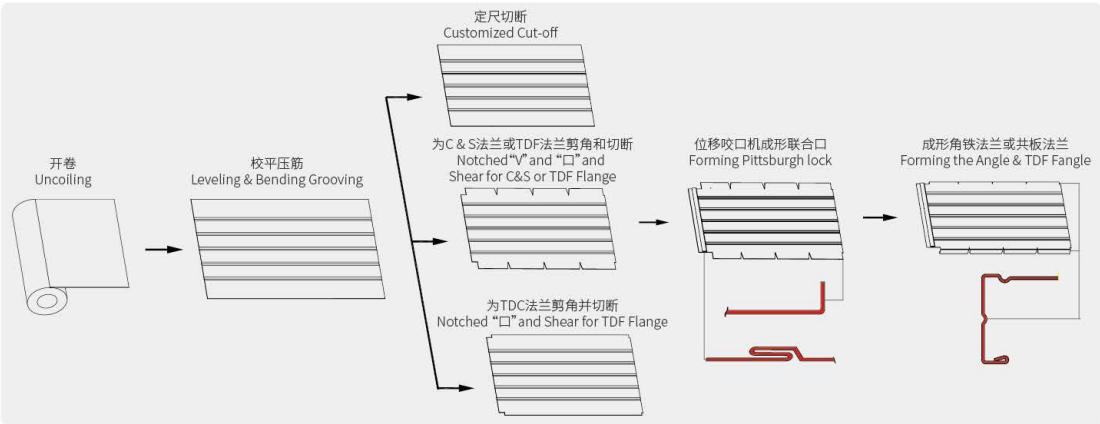
基本配置 Basic equipment:

胀缩式料架	二个(四个料盘)	Expanding uncoiler( two sets with four coiler)
主机 (校平、剪切、折弯)	一台	Main machine(Leveling, cutting and folder) 1 set
剪角模具	一套	“V” and “口” notching unit 1 set
松下伺服系统	一套	Panasonic servo system 1 set
往返升降式辊骨机	一套	Round-trip and lift type of pittsburgh lock machine 1 set
自动送料架	一套	Automatic feed frame 1 set
四机联动法兰机	一套	TDF flange forming machine 1 set
台湾阀组	一套	Taiwan valve group 1 set
电气元件采用国际知名品牌		Electric components adopt international famous brand

04



注:可以按照客户的要求,生产各种规格板料、宽度、卷料重量的  
PS: Accorded customer requirement to make different max-width and coiler different max-weight

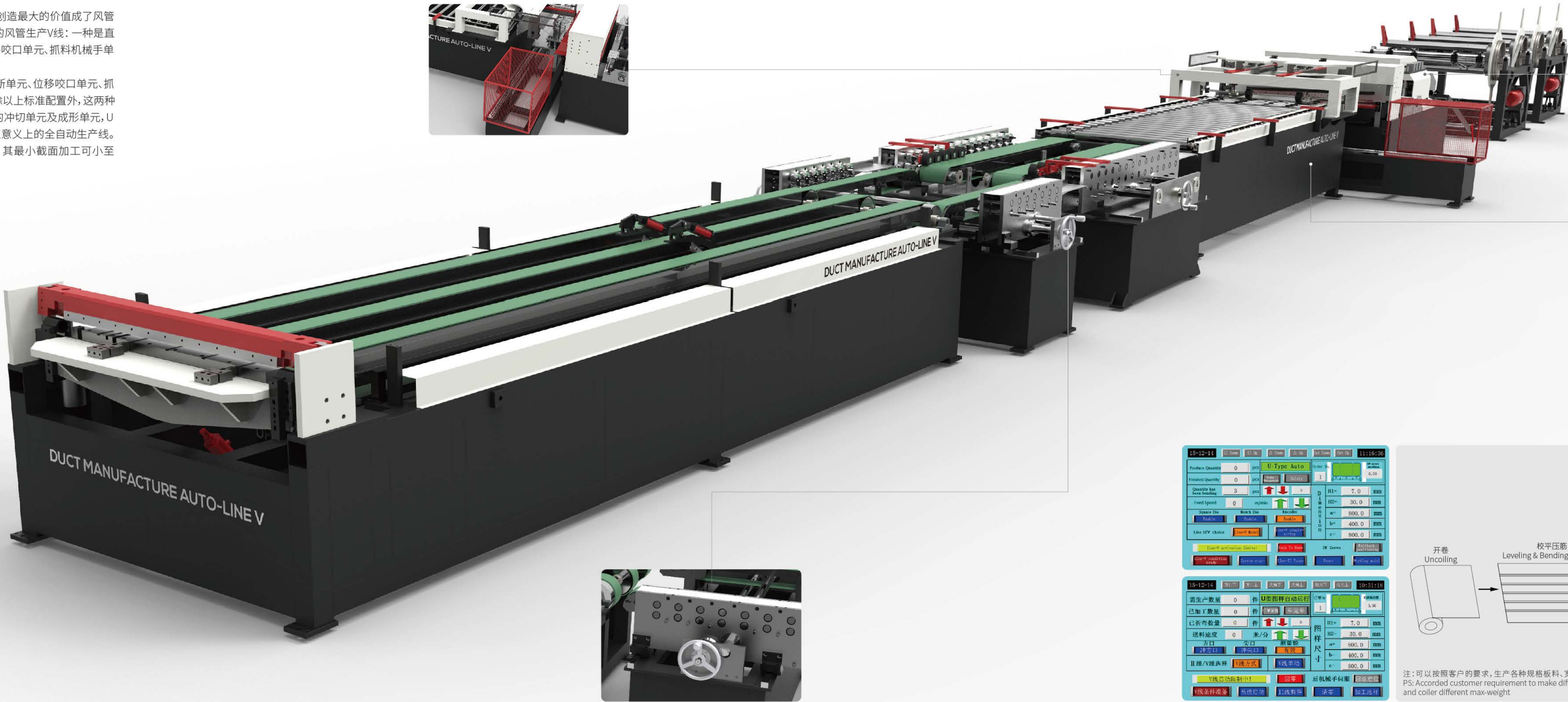


V型风管生产五线

Duct Automatic Line V

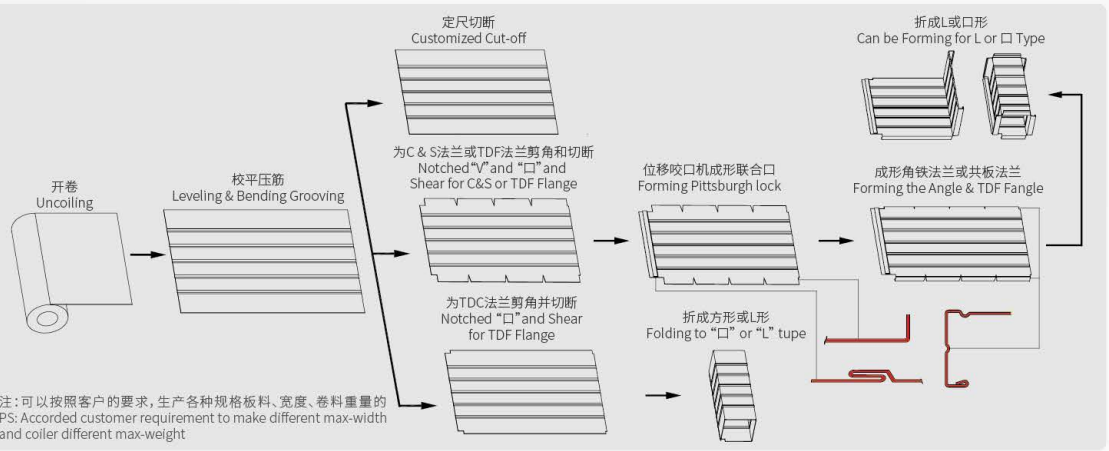
- 随着人工成本不断上升,而因竞争造成利润下降的今天,如何用最少的工人创造最大的价值成了风管制造商共同追求的目标.为满足客户的不同需求,我们研制开发了两种款式的风管生产V线:一种是直线型,它是由料架、校平压筋、尖口冲切单元和方口冲切单元、切断单元、位移咬口单元、抓料机械手单元、双机联动角铁 & TDF法兰成形单元、自动折弯单元所组成;
- 另一种是U型,它也是由料架、校平压筋、尖口冲切单元和方口冲切单元、切断单元、位移咬口单元、抓料机械手单元、双机联动角铁 & TDF法兰成形单元、自动折弯单元所组成;除以上标准配置外,这两种风管生产线还可以根据客户需求加装支撑孔冲孔单元、C & S法兰连接所需的冲切单元及成形单元, U型风管生产线更可加装用于加工小尺寸风管所需的按扣式咬口单元,是真正意义上的全自动生产线。
- 这两种生产线最大的特点是: 生产效率高,能制造小截面的“口”字风管。其最小截面加工可小至200×200mm的共板式法兰风管。

- In the labor costs continue to rise, and the resulting decline in profits today, how to create the most value with the fewest workers became duct manufacturer common goal. To meet the different needs of customers, we have research and developed duct production line has two styles: one is linear type V, them composed of a decoiler, leveler grooving unit, “V” and “口” notching unit, cutting unit, bending unit, reciprocating lock former unit, feed extraman unit, duplex flange (angle iron & TDF), automatic folder unit composition;
- Another is U type V, also composed of a decoiler, leveler grooving unit, “V” and “口” notching unit, cutting unit, bending unit, reciprocating lock former unit, feed extraman unit, duplex flange (angle iron & TDF), automatic folder unit composition;In addition to the above standard configuration, the two duct production line can also according to customer demand with the support of punching of the reinforce holes unit, C & S flange connection required for notching unit and forming unit, U-shaped duct production line can be added more for made of small-size duct desired snap lock seam unit. Is a fully automated production lines in the true sense.
- Both the production line biggest features are: high efficiency, can create a small section of “口” type duct. The minimum cross-sectional processing can be as small as 200 × 200mm TDF flange duct.



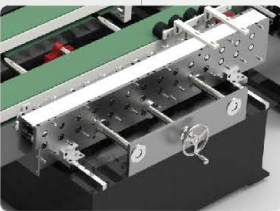
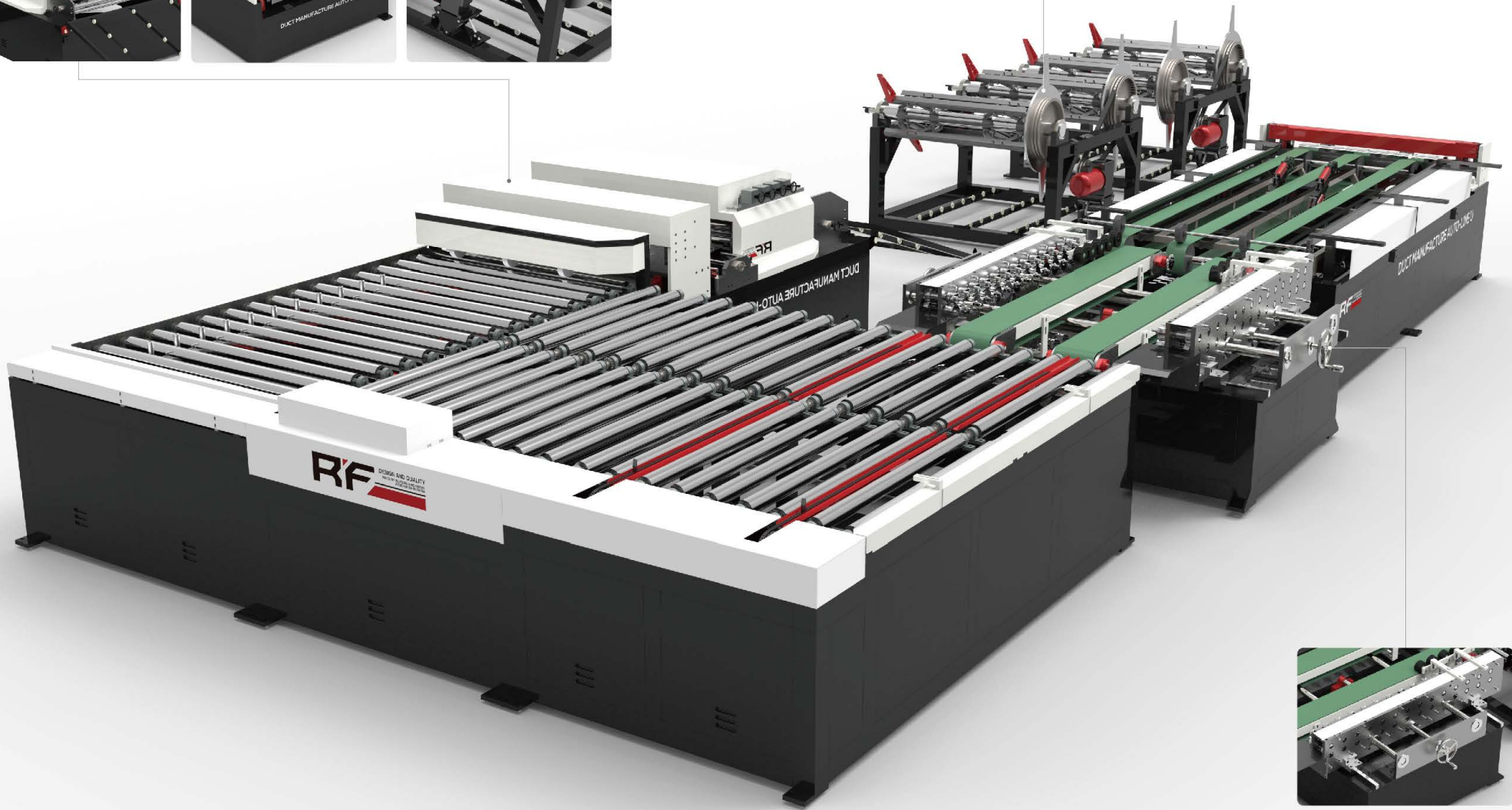
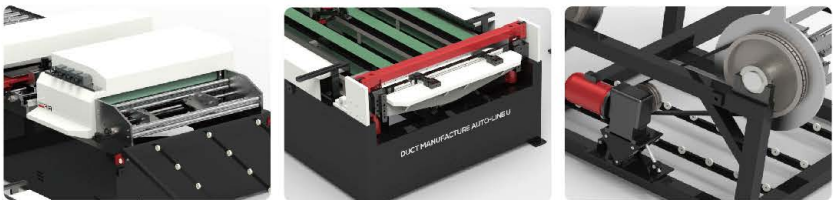
基本配置 Basic equipment:

胀缩式料架二个 (四个料盘)	Expanding uncoiler( two sets with four coiler)
主机 (校平、剪切、折弯) 一台	Main machine(Leveling, cutting and folder) 1 set
剪角模具 一套	“V” and “口” notching unit 1 set
松下伺服系统 一套	Panasonic servo system 1 set
往返升降式辘骨机 一套	Round-trip and lift type of pittsburgh lock machine 1 set
自动送料架 一套	Automatic feed frame 1 set
四机联动法兰机 一套	TDF flange forming machine 1 set
自动折弯架 一套	Automatic folder frame 1 set
台湾阀组 一套	Taiwan valve group 1 set
电气元件采用国际知名品牌	Electric components adopt international famous brand



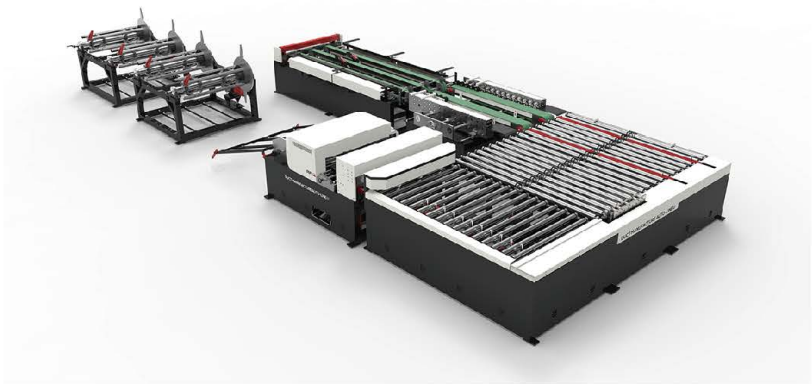
U型风管生产五线

U type duct automatic line V



07 RF

- 随着人工成本不断上升,而因竞争造成利润下降的今天,如何用最少的工人创造最大的价值成了风管制造商共同追求的目标。为满足客户的不同需求,我们研制开发了两种款式的风管生产V线:一种是直线型,它是由料架、校平压筋、尖口冲切单元和方口冲切单元、切断单元、位移咬口单元、抓料机械手单元、双机联动角铁 & TDF法兰成形单元、自动折弯单元所组成;
- 另一种是U型,它也是由料架、校平压筋、尖口冲切单元和方口冲切单元、切断单元、位移咬口单元、抓料机械手单元、双机联动角铁 & TDF法兰成形单元、自动折弯单元所组成;除以上标准配置外,这两种风管生产线还可以根据客户需求加装支撑孔冲孔单元、C & S法兰连接所需的冲切单元及成形单元, U型风管生产线更可加装用于加工小尺寸风管所需的按扣式咬口单元,是真正意义上的全自动生产线。
- 这两种生产线最大的特点是: 生产效率高,能制造小截面的“口”字风管。其最小截面加工可小至200×200mm的共板式法兰风管。

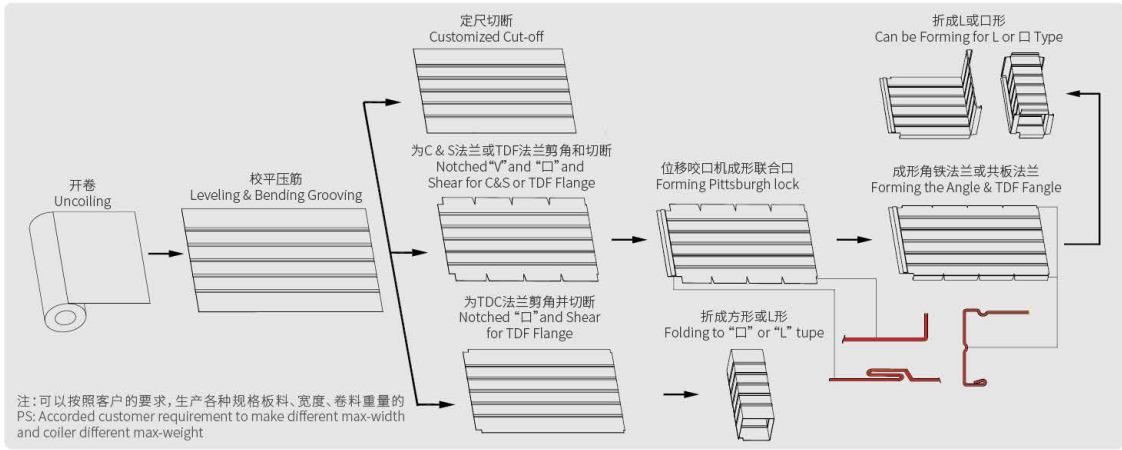
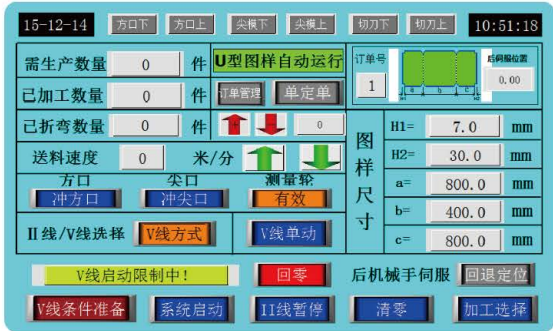
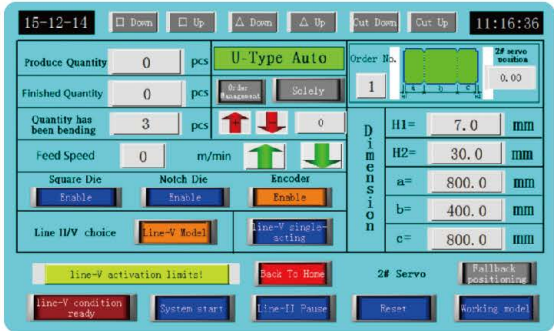











基本配置 Basic equipment:

胀缩式料架二个	(四个料盘)	Expanding uncoiler( two sets with four coiler)
主机 (校平、剪切、折弯)	一台	Main machine(Leveling, cutting and folder) 1 set
剪角模具	一套	“V”和“口” notching unit 1 set
松下伺服系统	一套	Panasonic servo system 1 set
往返升降式辘骨机	一套	Round-trip and lift type of pittsburgh lock machine 1 set
自动送料架	一套	Automatic feed frame 1 set
四机联动法兰机	一套	TDF flange forming machine 1 set
自动折弯架	一套	Automatic folder frame 1 set
台湾阀组	一套	Taiwan valve group 1 set
电气元件采用国际知名品牌		Electric components adopt international famous brand

08 RF





- In the labor costs continue to rise, and the resulting decline in profits today, how to create the most value with the fewest workers became duct manufacturer common goal. To meet the different needs of customers, we have research and d eveloped duct production line has two styles: one is linear type V, them composed of a decoiler, leveler grooving unit, “V” and “口” notching unit, cutting unit, bending unit, reciprocating lock former unit, feed extraman unit, duplex flange (angle iron & TDF), automatic folder unit composition;
- Another is U type V, also composed of a decoiler, leveler grooving unit, “V” and “口” notching unit, cutting unit, bending unit, reciprocating lock former unit, feed extraman unit, duplex flange (angle iron & TDF), automatic folder unit composition;In addition to the above standard configuration, the two duct production line can also according to customer demand with the support of punching of the reinforce holes unit, C & S flange connection required for notching unit and forming unit, U-shaped duct production line can be added more for made of small-size duct desired snap lock seam unit. Is a fully automated production lines in the true sense.
- Both the production line biggest features are: high efficiency, can create a small section of "口" type duct. The minimum cross-sectional processing can be as small as 200 × 200mm TDF flange duct.







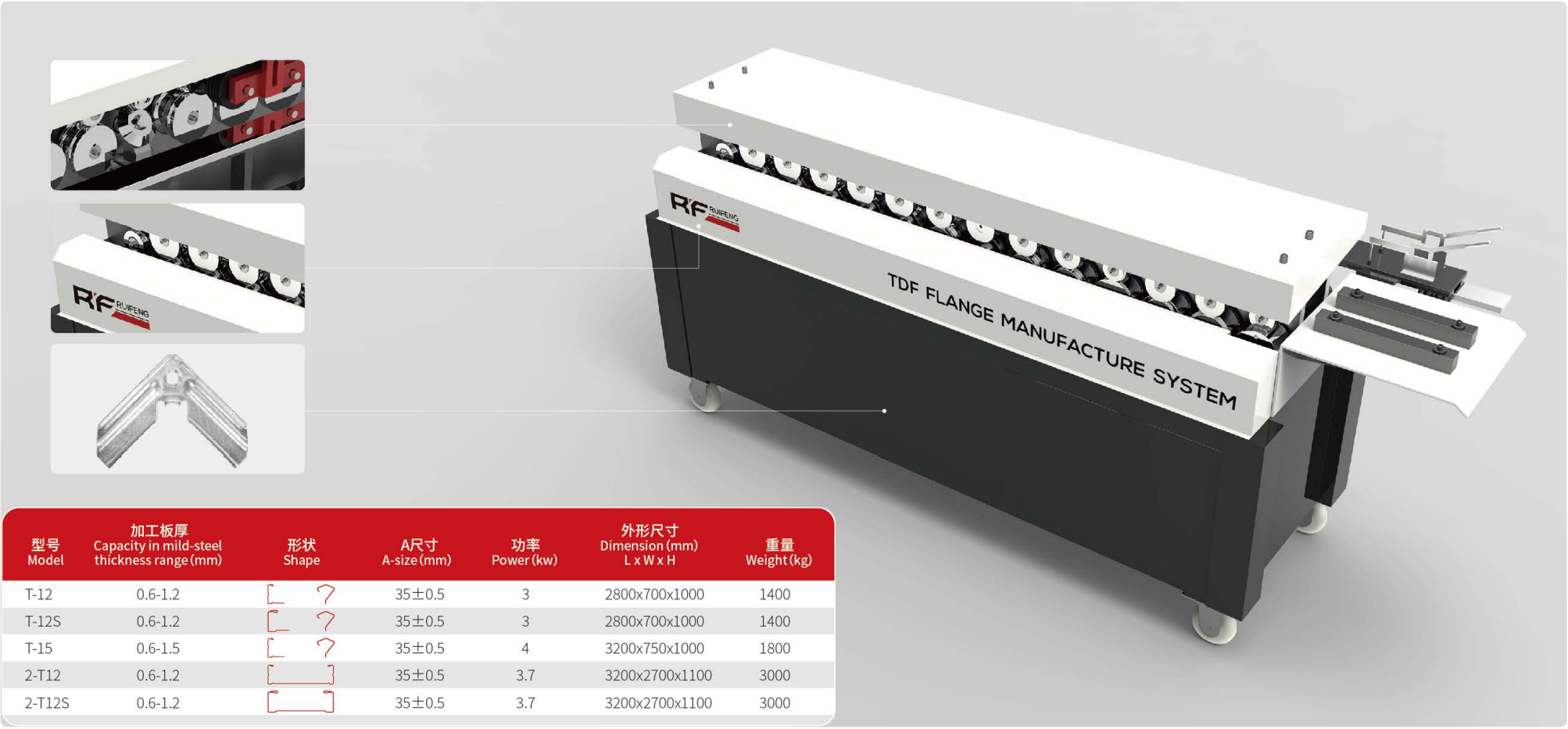
参数 Specification		AML-IB	AML-I	AML-II	AML-III	AML-IV	AML-V	AML-V(U TYPE)
加工板厚 Capacity (mm)	Mild steel	0.5—1.2	0.8—2.0	0.5—1.2	0.5—1.2	0.5—1.2	0.5—1.2	0.5—1.2
	Stainless steel	0.5—0.8	0.8—1.2	0.5—0.8	0.5—0.8	0.5—0.8	0.5—0.8	0.5—0.8
校平方式 Leveling type								
加强筋形状 Strengthening rib shape		U shape	×	U shape	U shape	U shape	U shape	U shape
最大工作速度 Max.works speed (m/min)		16	14	12	12	12	12	12
控制系统 (标准) Control System(Standard)		国产 localization	国产 localization	松下 Panasonic	松下 Panasonic	松下 Panasonic	松下 Panasonic	松下 Panasonic
卷料宽度 Coiler width (mm)		1250	1250	1250	1250	1250	1250	1250
卷料重量 Coiler weight (Kg)		6500	6500	6500	6500	6500	6500	6500
主机尺寸 Main machine dimensions (mm)	长 L	2350	2350	2350	2350	2350	2350	2350
	宽 W	1800	1800	1800	1800	1800	1800	1800
	高 H	1250	1200	1250	1250	1200	1200	1200
电机功率 (Kw)		4	5.5	3	3	25.6	28.5	36.7
重量 weight (Kg)		2700	3000	2700	2700	3000	2700	2700
主机尺寸 Main machine dimensions (mm)	长 L	2200	2200	2200	2200	2200	2200	2200
	宽 W	1800	1800	1800	1800	1800	1800	1800
	高 H	1600	1600	1600	1600	1600	1600	1600
标配料架数量 <small>Quantity of Standard Decoiler One Deoiler can be loading two coil</small>		1	1	2	2	2	2	2
电机功率 (Kw)		2.2	2.2	2.2×2	2.2×2	2.2×2	2.2×2	2.2×2
重量 weight (Kg)		800	800	800×2	800×2	800×2	800×2	800×2
可选配置 OPTIONS								
液压张紧料架 Hydraulic expansion of the mandrel		○	○	×	×	×	×	×
支撑孔冲孔单元 Punching of the Reinforce Holes Unit		×	×	○	○	○	○	○
按扣式咬口单元 Snap Lock Seam Unit		×	×	×	×	×	×	○
C & S 连接法兰 C & S Flange Unit		×	×	×	×	○	○	○
美式TDF法兰 Formker TDF Flange		×	×	×	×	○	○	○
共板式插接法兰 Duplex PDF20 Or 30 Flange Unit		×	×	×	×	○	○	○
控制系统 Control System		×	×	Rexroth	Rexroth	Rexroth	Rexroth	Rexroth2
加强筋形状 Strengthening rib shape		×	×	 或者 Or 				

## TDF共板法兰机

### TDF Flange former machine

- TDF 法兰是目前国际上应用最广泛的风管法兰之一，它具有成本低、密封性能好，安装方便简捷的特点，特别适合于截面面积不大的通风管道生产，TDF共板式法兰系统可用于工厂大规模工业化生产，是一种高效率化的风管法兰系统的全新设计，TDF共板式法兰机与辘骨机、剪角机、压筋机等组合可形成全自动化的生产，亦可分组，带机械到现场施工，非常适合目前国内施工企业的需要。
- TDF共板式法兰机按其工作性能及要求分为T-12、T-12S、T-15共三种型号，T-12、T-12S、T-15皆有两个成形工位，一边成形共板式法兰形“”，一边成形为勾夹“”；在此基础上，我们开发了双机联动共板法兰机2-T12、2-T12S。2-T12则两边同时成型“ ”。其宽度可以在1000~1530mm之间调整，所成形法兰质量好，效率高。T-12、T-12S、T-15工作速度均为6米/分钟。

- TDF flange is currently the most widely used one duct flanges, with low cost, well-seal and easy-fabrication, especially suitable to produce a duct with medium section area and applied in large-scale industrial manufacture. As a flexible machine, TDF will adapt to an auto line with a Pittsburgh lock machine, notching and bending machine. It may also be used on site.
- TDF system has three types: T-12, T-12S, T-15; T-12, T-12S, T-15 form one side forming clip“”and the other side forming flange“”at the same time. On this basis, we have developed Duplex machine 2-T12, 2-T12S. This machine in both sides synchronized form a flange"   ", TDF maybe commonly used for its width ranges from 300 to 1530mm. Its maximum work speed is 6 m/min.

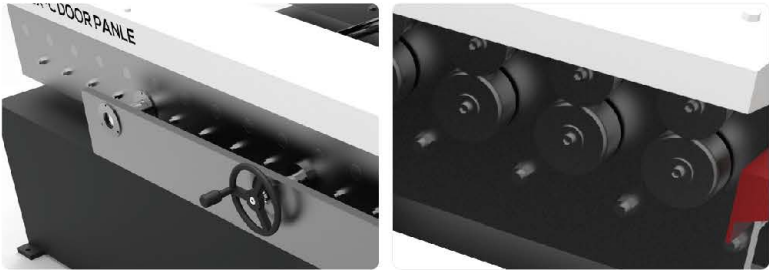


型号 Model	加工板厚 Capacity in mild-steel thickness range (mm)	形状 Shape	A尺寸 A-size (mm)	功率 Power (kw)	外形尺寸 Dimension (mm) L x W x H	重量 Weight (kg)
T-12	0.6-1.2	 	35±0.5	3	2800x700x1000	1400
T-12S	0.6-1.2	 	35±0.5	3	2800x700x1000	1400
T-15	0.6-1.5	 	35±0.5	4	3200x750x1000	1800
2-T12	0.6-1.2		35±0.5	3.7	3200x2700x1100	3000
2-T12S	0.6-1.2		35±0.5	3.7	3200x2700x1100	3000

## 双机联动插接式法兰机

### Duplex PDF former machine

- 该机可以在法兰 (PDF) 成形的同时进行连续旋转式铆接。生产速度为10米/min。只需要更换对应的轧辊, 就可生产出适合您生产需要的20mm、30mm或35mm法兰。该法兰机可以单独或两边同时成形。
- PDF共板法兰相对于TDC法兰来说是一个更好的选择, 它不像TDC法兰那要需要将法兰条根据风管的具体尺寸对法兰条进行切断、组合、安装、铆接, 而是将该法兰的小边直接铆接到管壁上, 降低了制造成本并提高了工作效率。



#### 基本配置 Basic equipment:

每一边成形轧辊数量为:	18组
成形20法兰的材料厚度:	0.6-0.9 mm
成形30和35法兰的材料厚度:	0.9-1.2 mm
最小剪角距离:	120-150 mm
轧辊轴直径:	ø40 mm
生产速度:	10 m/min
液压电机功率:	5.5 kW

No. of rolls on each side:	18 Groups
Material thickness for 20mm profile:	0.6-0.9 mm
Material thickness for 30 and 35mm profile:	0.9-1.2 mm
Min. length of blanks:	120-150 mm
Shaft diameter:	ø40 mm
Production speed:	10 m/min
Production speed:	5.5 kW



## 11

RF

## TDF折边机

### TDF Folder Machine

- TDF折边机按其控制方式分为手动折边机和液压折边机, 手动折边机采用伞齿轮锁紧结构; 液压折边机压紧和折弯皆由油缸控制。是专门为TDF法兰风管折弯而开发的一款专用设备, 它具有重量轻、移动方便的特点, 非常适合在施工现场使用, 它可以折弯任何尺寸的TDF法兰风管。

#### TDF 手动折边机 TDF Manual Folder machine



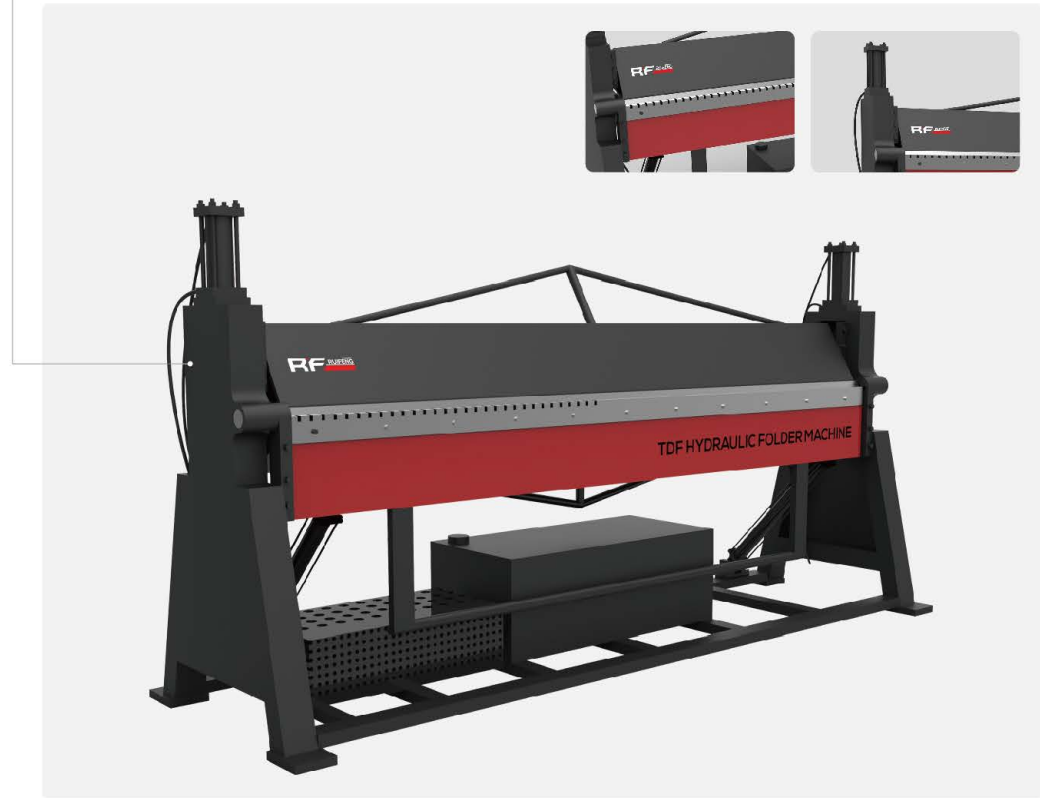
型号 Model	折弯厚度 Folding thickness (mm)	最小折弯角度 Min. folding angle	折弯宽度 Folding width (mm)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H
WS1.5x1300ATDF	1.5	40°	1250	350	1800x620x1600
WS1.5x2050ATDF	1.5	0.5-6	2000	490	2550x620x1600

## 12

RF

- TDF folding machine according to its manual control mode is divided into hydraulic folding machines and folding machines, manual folding machine with bevel gear locking structure; hydraulic folding machines chosen by pressing and bending cylinder control, is designed for TDF flange bending and the development of a special equipment, it has the advantages of light weight, convenient to move, very suitable for use in the construction site, it can be bent any size the duct of TDF flange.

#### TDF 液压折边机 TDF HYD Folder machine



型号 Model	折弯厚度 Folding thickness (mm)	最小折弯角度 Min. folding angle	折弯宽度 Folding width (mm)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H
WSY1.5X1300A TDF	1.5	40°	1250	480	1800 x 715 x 1450
WSY1.5X2050A TDF	1.5	40°	2000	650	2540 x 715 x 1450

TDC插接式法兰机

TDC flange Former machine

■ TDC法兰是目前国际上应用最广泛的风管法兰之一。它具有省时、省料、工作效率高、密封好、坚固耐用和驳接坚固等特点。它特别适用于通风管道截面面积较大的风管。TDC法兰机主要由送料架、冷轧成型主机和切割部分组成。配置了高速钢圆锯片不停机切割系统。可定尺切断。切断毛刺小, 可实现全自动化生产。其工作速度为6米/分钟。按其工作性能和法兰强度及密封等级可以分为四种型号: T-20、T-25、T-30、T-35、T-40, 其对应连接角码为 T-20DC、T-25DC、T-30DC、T-30DC和T-40DC。

■ TDC flange is currently the most widely used one duct flanges. It has the advantages of time saving, material saving, high work efficiency, good sealing, durable and connecting structure. It is especially suitable for duct to duct with a large sectional area. TDC flange machine is composed of feeding frame, cold rolling forming machine and a cutting part. The cutting part can be divided into the grinding wheel cutting and non-stop cutting system, cutting system can be realized without stopping the cut-to-length. Cutting burr of small, can realize the full automation of production. The working speed of 6m/min. According to the working performance and the strength of flange and sealing level can be divided into four types: T-20, T-25, T-30, T-35, T-40, the corresponding connection corner is T-20DC, T-25DC, T-30DC, T-30DC and T-40DC.



型号 Model	加工板厚 Capacity (mm)	电机功率 Motor (kw)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H
T-20	1.0	3	1520	5600x000x150
T-25	1.0	4	1530	5600x000x150
T-30	0.8	3	1550	5600x000x150
T-35	1.0-1.2	4	1780	560x000x150
T-40	1.0-1.2	4	1800	5660x000x150

13 RF

扣夹机

Clip Machine

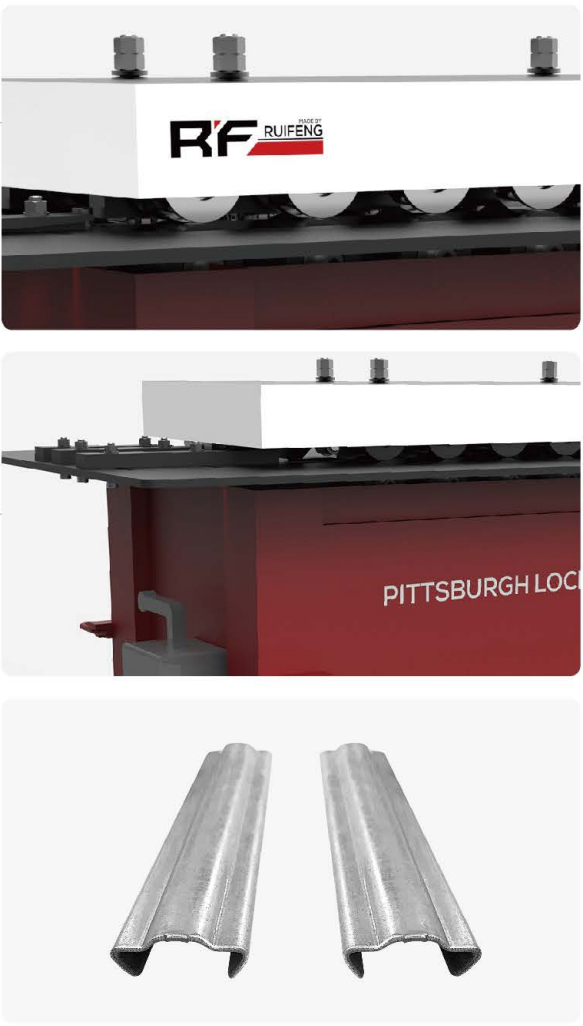


型号 Model	电机功率 Motor (kw)	加工板厚 Capacity (mm)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H
CP-12	1.5	0.5 - 1.2	230	1050X580X1050

14 RF

■ 该工作母机机共有两个成形工位, 只需安装相应的成形轧辊, 就可生产出所需要的20、25、30、35和40法兰扣夹, 20和30法兰扣夹是其标准配置。

■ The Machine Tools for a total of two forming station, only need to install the corresponding forming roll, can produce the required 20, 25, 30, 35 and 40 flange clip, 20 and 30 flange clip is the standard.



风管等离子切割机

HVAC Plasma cutting machine

- 就在20年前,工人们常常通过放样、手工剪的方式来剪切保温、通风和空调 (HVAC) 管道所需要的材料。需要大量的技术工人一丝不苟的工作,才能加工出符合要求的风管,不仅效率低下,而且所浪费的材料更是惊人。
- 如今,许多风管制造厂开始采用等离子切割机。这些工厂发现,等离子切割机是一种快速,清洁,经济而高效的金属切割方式。
- Just 20 years ago most heating, ventilation, and air-conditioning (HVAC) ductwork was cut by hand with snips and shears. Cutting out HVAC fittings was slow and labor-intensive. It took an experienced tinsmith with strong hands to slice through galvanized steel all day. It took even more skill to get the cuts and bends just right to coax flat panels of sheet metal into precise 3-D forms.
- Today many HVAC shops use plasma cutters—both hand-held torches and CNC mechanized systems—to cut material for fabrication. These fabricators find that for their applications, plasma is a fast, clean, economical way for them to cut light-gauge metal.



快速选择Create fittings fast

- 根据需要点击模型进入数据输入界面
- 可预览3D模型和法兰连接方式、咬口、曲线等
- 自动排版并可打印该弯头的材料清单
- 可切割各种自定义的平面图案
- 各种形状的切割件可最后组装成成品
- Click the shape you want and enter the details.
- Preview the 3D shape and flat pattern with connectors, seams, bend lines, etc.
- Print the material list and reports specifying how the part is made.
- Cut the flat pattern with the Plasma machine.
- Form and assemble the piece to make the finished part.

15 RF

风管等离子切割机

HVAC Plasma cutting machine

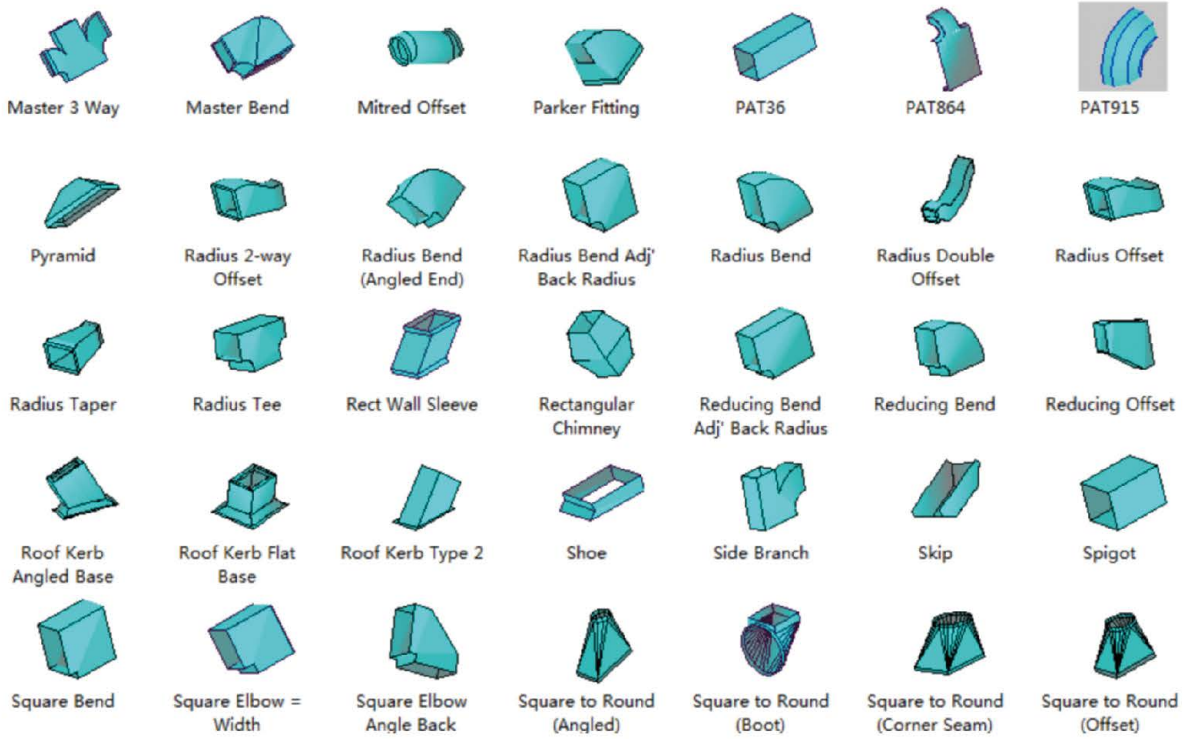
快速选择Create fittings fast

- 图库内的标准模型涵盖了暖通、屋顶、制管以及重工业；
- 样版图库内有圆形、矩形、椭圆及其配套组合件；
- 采用行业标准尺寸，接头，接缝，衬里和叶片；
- 从暖通设计软件包内选择图形并输入该图形到等离子的切割软件内就可以完美割切出所需要的图形；
- 该软件符合SMACNA 标准；
- 零件各个尺寸都可以修改：尺寸、偏移量、角度、大小、形状或结构；
- 切割前可显示预览，重量，面积，废料和成本；
- 保持生产的高效运行的同时可打印报告，材料清单，生产标签；
- 在有效切割区域内，可同时排版多个工件。
- Creates standard parts for HVAC, roofing, piping, and heavy plate industries;
- Comprehensive library has round, rectangular, oval and combination fittings;
- Uses industry standard gauges, connectors, seams, lining and vanes;
- The Plasma software imports shapes from optional HVAC layout software packages and allows precision cutting of flat patterns and other mechanical shapes!
- Applies SMACNA standards;
- Fully customizable parts - change dimensions, offsets, angles, size, shape, or construction;
- Shows previews, weight, square footage, scrap and costs before part is made;
- Keep production running efficiently with printed reports, materials lists, and production labels;
- Process multiple fittings at once for any number of jobs and zones.



16 RF

型号Model	HVAC 3100/5100
电源 Power supply	1PH,220V,50HZ / 可定制Can customize
显示器 Controller displayer	17" 真彩触摸屏 / 17" LCD colorful touch screen
切割宽度 Cutting width	1250mm,15300mm
切割长度 Cutting length	3100mm, 5100mm / 可定制Can customize
切割方式 Cutting model	Plasma
最大定位速度 Max Positioning speed	12000mm/min
建议定位速度 Recommended Positioning Speed	5000-8000mm/min
等离子电源 Plasma	Up to 48A, Highly recommend 推荐切割电流为48A



## 角码自动生产线

### Corner Automatic production line

■ 该生产线是由料架、校平单元、伺服送料单元、冲床和复合模具所组成,有别于传统的加工模式、大大提高了生产效率的同时降低了生产成本。

■ The automatic production line is composed of decoiler, leveling system, servo feeding system, punch and dies components. Is different from the traditional processing mode, greatly improves the production efficiency and reduce production costs.

**料架 Decoiler:**


卷料的最大宽度 Max. Material width:	≤250 mm
卷料的最大厚度 Max. material thickness:	≤2.0mm
最大承重 Max. load capacity:	≤2T
卷料外径 Outer diameter:	Φ1200mm
卷料内径 Inner diameter:	Φ480-520 mm

**校平单元 Leveling system:**

采用9辊校平, 2.2KW电机, 校平速度高达 10M/min  
Use 9 roller leveling, power 2.2 kW, speed: 10M/min

**伺服送料单元Servo feeding system:**

The feed shaft diameter:	Φ60mm
Measuring diameter of shaft:	Φ60mm
Maximum feed plate of width:	≤300mm
Maximum feed plate of thickness:	≤2mm
Maximum feed speed:	≤40m/min
Feeding and blanking step length tolerance:	±0.20mm
Feed products overall length tolerance:	±0.25mm
Servo motor power/brand:	1.8KW/ Japan Yaskawa
Transmission:	Synchronous wheel / gear
Length measuring encoder:	ROUNDSS 2500P





## 17

## 角码安装机

### Corner assemble machine

■ TDF 风管角码机用于TDF和TDC方形风管两端法兰角码安装,是矩形方管生产线的配套设备。只需将方管放到指定位置,就能自动完成送角码,压牢,固定三个步骤,单向双向装订角码一次到位。角码与风管法兰结合牢固,扭曲小,噪声低,效果好。多种不同结构形式的角码,多种规格尺寸都能顺利装配。

■ This machine is for fitting corners of TDF and TDC square duct as corollary equipment for rectangular duct line. Put the duct on appointed position. The machine finishes corner feeding. Pressing and fixing automatically. The corner and duct are fitted tightly with warping will be little. Low noise and effect is good. Many kinds of corners are workable.



型号 Model	切片厚度 Capacity (mm)	气压 Air Pressure (Mpa)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H
CM-1	0.5-1.2	0.6-0.8	500	1400×800×1200

## 18

# 液压合缝机

## HYD Seam lock machine

- 风管立式合缝机可以和风管生产线、T12法兰机和辘骨机配套使用。联合口和直角边是风管连接的理想接口,合缝机SL-12可以不用任何其他辅助的连接工具,就能准确高质量的结合联合口的缝隙,不仅美观大方,而且不损伤金属表面、噪声低,合缝严密、平整,效果良好。适用于不同的板厚,合缝快速安全。
- 采用三菱PLC控制,长时间工作性能稳定、优良。立式布局,符合人体力学的设计,操作方便,大大的提高了风管生产效率。

- This machine can be used with duct automatic line, TDF flange duct machine or TDC flange duct machine and Pittsburgh lock machine. The ideal duct connection includes united joint and right-angle side. The seam lock machine SL-12 works out seam of high quality without help of other auxiliary connecting tool. The process does nothing to hurt the surface of the work piece with low noise. The finished seam is close, even and effective. Plates in different thicknesses are workable and can be finished quickly and safely.
- This machine adopts Mitsubishi PLC to control, with long-time stable working ability, ergonomic design, easy operation and high efficiency. The seam lock speed can be 3 second/one duct.



板材厚度 sheet thickness range		法兰锻坯成型高度 sheet thickness range		结构图 Picture	
(mm)	(Gauge)	(B) (mm)			
0.75-1	22-21/0.03-0.04 in	9-11			
>1-1.2	21-18/0.04-0.05 in	11-13			
型号 Model	材质 Material	容量 Capacity	管材长度 Duct Length	功率 Hyd. Power	外形尺寸 Dimension (mm) L x W x H
SL-12	M.S or G.I	0.6-1.2	1000-1500	4KW	1205X1970X2290



19RF

# 手动C骨成形机

## Manual C cleat machine

- 这是一种手动工具,不需要做任何の設定或调整,只需几秒钟的时间就可以在方形风管的边缘加工成C骨,它共有两个操作手柄,上面的手柄用来成形C骨,下面的手柄打开后可以很容易的把工件取出来。
- A manually operated tool that forms uniform drive cleat edges on rectangular ductwork in seconds without set-up or adjustment. The upper handle forms the cleat and the lower handle opens the tool for easy removal of the material. Feature needle bearings. A quick-release is built into the lower handle.



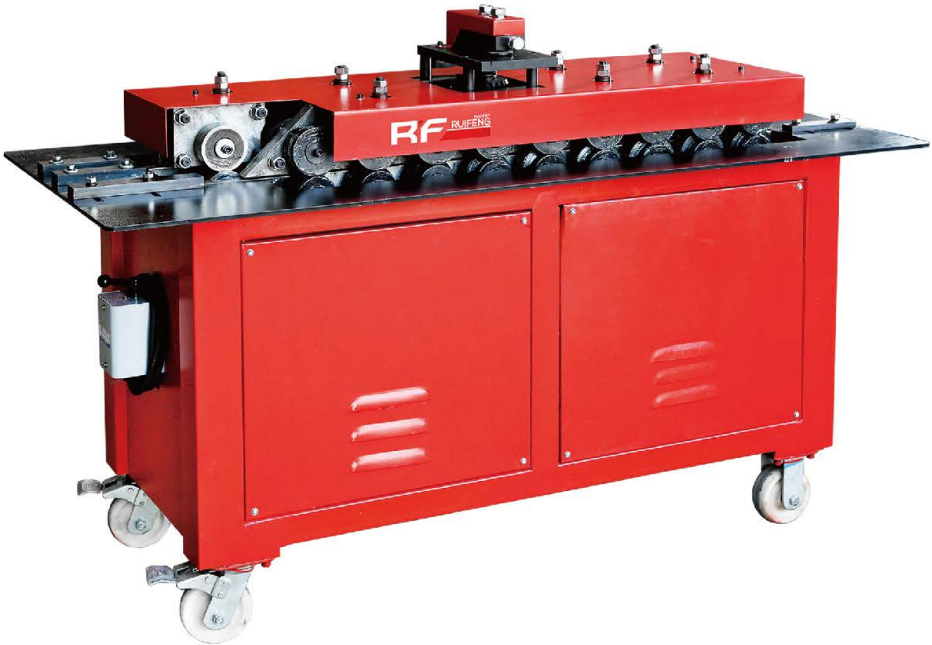
型号 Model	加工能力 Capacity	工作长度 work length
C-460	0.4-0.8mm	457mm
C-610	0.4-0.8mm	610mm
C-770	0.4-0.8mm	762mm

20RF

# 风管辘骨机

## Pittsburgh lock machine

重型辘骨机 Heavy type Pittsburgh Lock Machine



注：× 表示该机型无此功能  
Note: × indicates that this model does not have this function

型号 Model	成形组数 Rollforming station	电机功率 Motor power (KW)	机器长度 Machine length (mm)	机器宽度 Machine width (mm)	机器高度 Machine height (mm)	工作高度 working height (mm)	机器重量 Machine net (Kg)
LC-20	10	3	1690	690	1050	810	600
LC-20DR	10	3	1690	690	1050	810	650

型号 Model	最大加工能力Capacity(mm)镀锌板 (G.I)					
LC-20	10	2.0	×	2.0	2.0	×
LC-20DR	10	2.0	0.8	2.0	2.0	2.0

圆直角辘骨机 Pittsburgh Flanging Machine For elbow



- 圆直角辘骨机,是专为风管弯角处设计的一种机械,完全代替手工操作,它可加工内、外圆弧直角。
- This special machine is designed to form a rectangle with an arc instead of by manual operation. It can deal with both inner and outer arc triangles.

型号 Model	加工板厚 Capacity (mm)	速度 Speed (m/min)	功率 Motor (kw)	重量 Weight (kg)	外形尺寸 Dimension (mm) L x W x H	
R15	0.7-1.5	7	1.1	100	590x600x900	外形

# 按扣骨辘骨机

## Snap Lock former machine

- 这种骨形主要应用于小截面风管,设计的加工能力在0.5-1.2mm之间,它的最大特点就是合缝简单而快速,不需要像联合口那样合缝之后还要将边包过来才能确保风管不漏风。
- This system is used as a simple joining method to join between 0.5 and 1.2mm sheet steel at right angles and is designed to lock rigidly together without the need for a post seaming operation.



型号 Model	成形组数 Rollforming station	电机功率 Motor power (KW)	机器长度 Machine length (mm)	机器宽度 Machine width (mm)	机器高度 Machine height (mm)	工作高度 working height (mm)	机器重量 Machine net (Kg)	最大加工能力Capacity(mm)镀锌板 (G.I)
SLC-20	0.7-1.5	0.7-1.5	7	1.1	100	590x600x900	100	100



# 风管辘骨机

## Pittsburgh lock machine

■ 根据板料厚度和形状的不同，我们研制开发的辘骨机分为6组成形、7组成形、8组成形、9组成形和10组成形；这些机器中的每一种都在两侧分别安装了成形联合口和直角骨的轧辊，为尽可能的实现一机多用，其中的7组成形和8组成形的辘骨机共有4个加工工位，通过调整前定位板，可以加工6种不同的骨形，这些机器的轧辊均由高质量合金钢经真空淬火制成。为保证产品质量，轧辊轴的轴向和径向均装有滚子轴承。



注：× 表示该机型无此功能  
Note: × indicates that this model does not have this function

型号 Model	成形组数 Rollforming station	电机功率 Motor power (KW)	机器长度 Machine length (mm)	机器宽度 Machine width (mm)	机器高度 Machine height (mm)	工作高度 working height (mm)	机器重量 Machine net (Kg)	最大加工能力Capacity(mm)镀锌板 (G.I)					
LC-10BR	6	1.1	900	540	1030	810	185	1.0	1.0	0.8	×	×	×
LC-12	7	1.5	1040	560	1000	810	200	1.2	1.2	×	1.2	1.2	×
LC-12DR	7	1.5	1040	560	1100	810	230	1.2	1.2	0.8	1.2	1.2	×
LC-15	7	2.2	1140	600	1100	810	230	1.5	1.5	×	1.5	1.5	×
LC-15DR	7	2.2	1130	600	1150	810	230	1.5	1.5	0.8	1.5	1.5	×
LC-12M	8	2.2	1510	630	1000	810	360	1.2	1.2	0.8	×	×	0.8

23<sub>RF</sub>



# 立式骨辘骨机

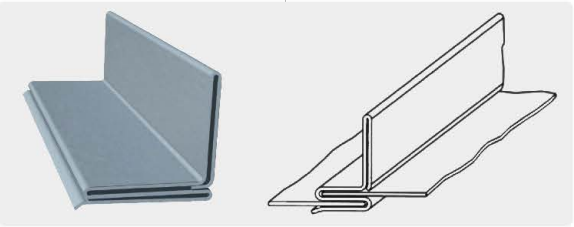
## Standing S Cleat Machine

- 立式S 骨是两个风管连接的另一种方式，它替代了传统扁平式S骨的地位，因为立式S骨在风管连接面是双重叠的。
- 虽然扁平式S骨在风管连接后可以保证统一的外观，但它无法应用在大面积的风管方面，但立式S骨则解决了这个问题，因为它含有一个25mm高的法兰边用以提高其刚性，从而扩大了立式S骨的应用范围。



Material	Thickness (mm)	Forming steps	Roller's specification	Quenching hardness	Roll shaft	Diameter	Motor (KW)	Reduction box	Roll forming speed
G.I or M.S	0.5-0.8	15 team	GCr15	HRC58°~60°	45#	Φ40	2.2	Cycloid AL reducer	8M/min

- S Cleat profiles have been designed to complement the Drive Cleat profile as a means of joining the un-formed overlapping edges when making in line duct connections.
- Both S Cleats are the same width as the Drive Cleat (28mm) giving a uniform appearance but the Standing S Cleat has an additional 25 high flange to increase rigidity over long runs.



24<sub>RF</sub>

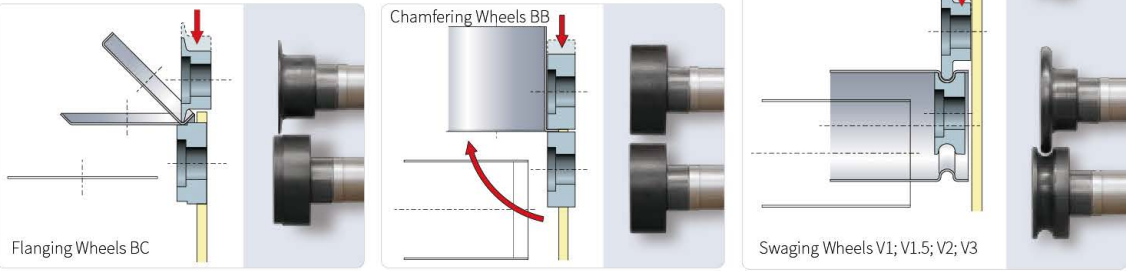
# 辘线机系列

## Swaging machine series

- 本机器具有制作圆管的压筋、连接等功能。即将薄板轧成一定形状的凸筋,目的在于加强板料、管道或金属构件的刚性,具有外形美观、体积小、重量轻、操作方便等特点。
- 辘线机分手动辘线机和电动辘线机,主要功能是制作圆管的压筋,连接等功能,并可通过特殊的轧辘制作出不同形状的工件。



型号 Model	形状 Shape	加工板厚 Capacity (mm)	电机 Motor (kw)	重量 Weight (kg)	外形尺寸 Dimension mm (L.H.W)
LX-18		1.8	2.2	145	850x450x1180
LX-15		1.5	0.75	85	830x360x1000
LH-10		1	/	50	640x480x1050
LH-8		0.8	/	18	300x200x400
LH-10A		1.0	/	30	400x200x450



# 叶片成形生产线

## Blade forming product line



Material	Thickness (mm)	Forming steps	Motor (KW)	Roller Specification	Manual De-coiler	Machine speed	Pneumatic automatic cut-off by saw knife Motor
G.1	0.6-1mm	14 stations	5.5KW	GCr15	1.5 Tons	8-10 meter/min	1.5kw

防火阀生产线系类

VCD Damper frame Brief introduction

- 防火阀是HVAC空气流量控制阀的主要部分，该阀是工业厂房民用建筑的通风、空调和空气净化工程不可缺少的中央空调末端配件，一般用在空调，通风系统管道中。
- 凭借我们在冷轧成型机和风管机械领域所积累的丰富经验，我们为防火阀制造商提供了整体解决方案，该方案包括：阀体成型生产线、叶片生产线、铆接平台等配套工具阀体成型生产线是基于厚度1.5mm的镀锌板来设计的，它由手动料架、校平、液压冲切单元（三套冲剪模具及伺服送料）、成型主机、切断单元、成品接料台，电气系统等组成。

- The VCD damper frame is the main part of the HVAC air flow control valve, the valve is an industrial plant civil construction of ventilation, air conditioning and air purification project indispensable central air conditioning end parts, generally used in air conditioning, ventilation system ducts, used to adjust the air flow manifold can also be used for new wind and back mix adjustment of the wind.
- With our abundant experience in the field of rollforming machine and duct machine, we provide the systematic solution for the fire damper manufacturer, the systematic solution includes: VCD frame production line, blade production line, riveting platform and other tools VCD frame profiles Line is designed according to 1.5mm thickness material. The VCD damper frame profile production line is consisted of decoiler (manual), leveler, hydraulic press (with 3 sets punching mold' s and servo motor control feeder), roll form machine, hydraulic cutter, run-out table, hydraulic system, electrical control system, etc.

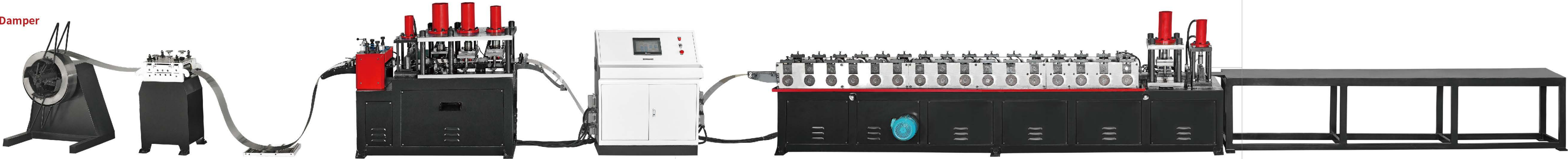
27  
RF

技术参数Specification:

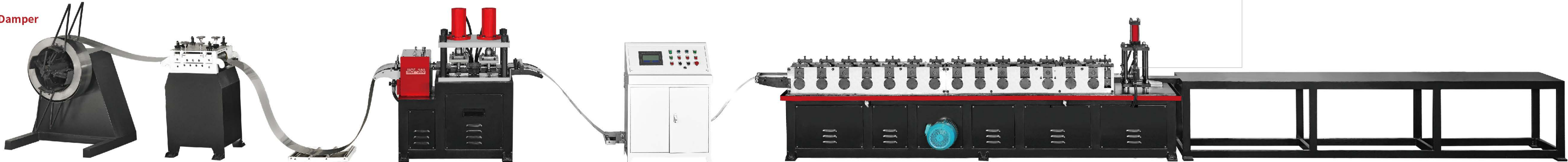
成形组数Forming Roller Stations:	16组· 16 Stations
轧辊轴直径Forming Roller shaft:	Φ48mm
轧辊材质Forming roller:	Cr12MoV, Quenching, hardness HRC56-58°
成型速度Forming Speed:	6 m/ min
主电机Main motor:	2+5.5kw
工件标质Material of Sheet:	G.I, M.S. S.S
厚度Sheet Thickness:	1.5mm
控制方式Control mode:	PLC

28  
RF

VCD Damper



Fire Damper



# 压筋机

## Bending grooving machine

- 本机是一种专用型、多种类薄板压筋机械，经过一次成型压筋或多次压筋成型，同时也可以根据需要更换轧轮，可压制理想的筋形。广泛用于建筑、汽连、船舶、电器厨具及空调通风的制造行业。
- 工作时，只需调整压轮，即可压制理想的弧度或角度，以及特定形状，压制的工作表面平整光滑，不擦伤，强度及刚性大大增强，成为各行各业理想选材。
- This machine is dedicated bending grooving machine, suitable for various thin plate. It can be shaped by one time or many times swaging. Even more, the roller can be changed in order to press the ideal shape. This machine is widely used in manufacturing building materials, auto, vessel, electric kitchen, air condition, ventilation and etc.
- While working, just adjusting the roller, this machine can press the ideal radian, angle and some specific shape. The pressed workpieces surface is flat, smooth, no scratch, and its intensity and rigidity has been improved greatly, which made it be to the ideal material in every industry.



型号 Model	厚度 Thickness (mm)	宽度 Width (mm)	形状 Shape	电机功率 Motor (kw)	重量 Weight (kg)	外形尺寸 Dimension mm (L.H.W)
G1.5X1250-5	1.5	1250		2.2	800	1680x860x1260
G1.2X2000-7	1.2	2000		3	1000	2500x860x1370

# 圆筒合缝机


## Round pipes Seam closing machine




- 如果你想把一张钢板制作成一个圆管并把两个边缘合起来，你需要两个步骤：首先，用辊骨机把钢板的两端制成形，在这之后，你要把工件翻一个面，用偏三星卷板机把两端成形好的钢板卷成圆筒。
- If you want to make a pipe out of sheet metal and you want to close the rounded material with a seam, there are two options. First, you use the Pittsburgh lock former machine and 3-roller bending machine a seam on both ends of the blank. After the first run, you flip the workpiece so that the two seams face in different directions. Then you round the sheet on a 3-roller bending machine and hang the two folds in each other.



型号 Model	速度 Width (mm)	加工料厚范围 Thickness Range	最大料宽 Max Coil Width
YJB-1.2x1600	6m/min	0.5-1.2 mm	1200 mm







**两种形状的咬口**  
Two types the profiles

你可以选择内合缝或者外合缝，左边为外合缝，右边为内合缝  
Seam combination with longitudinal seam and open hem  
Seam: facing outside (left) and inside (right)

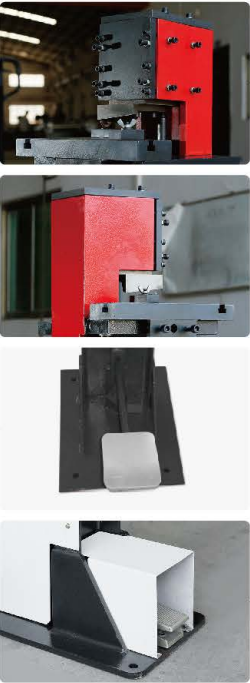
# 脚踏剪角机

## Foot power notching machine

**机械优势 Mechanical advantage:**

采用全钢焊接结构,具有良好的强度、刚性和抗震性;  
结构新颖,体积小,操作方便;  
加工工件快捷,剪切质量高;  
满足各类五金剪角加工需要,适用于仪器仪表、电器、轻工、机床型行业加工各种箱体、壳罩等。

Holistic welding structure, with good intensity, rigidity and quake-proof ;  
Novel structure, small volume, easy operation ;  
The strip speed is fast, and the notching quality is high ;  
Meet the needs of notching processing for all kinds of hardware. Suitable to process various boxes, shell covers and etc for apparatus, appliance, light industry, machine tool industry.



型号 Model	剪板长度 Cutting Length (mm)	剪板厚度 Cutting Thickness (mm)	剪切角度 Cutting angle	重量 Weightt(kg)	外形尺寸 Dimension(mm) (L.H.W)
Q11-1.5x80	80x80	0.5-1.5	90°	60	300x1100x300

# 气动剪角机

## Pneumatic notching machine

**机械优势 Mechanical advantage:**

采用气体驱动;  
采用全钢焊接结构,具有良好的强度、刚性和抗震性;  
结构新颖,体积小,操作方便;  
加工工件快捷,剪切质量高;  
满足各类五金剪角加工需要,适用于仪器仪表、电器、轻工、机床行业加工各种箱体、壳罩等。

Driven by air power;  
Holistic welding structure, with good intensity, rigidity and quake-proof;  
Novel structure, small volume, easy operation.  
The strip speed is fast, and the notching quality is high;  
Meet the needs of notching processing for all kinds of hardware. Suitable to process various boxes, shell covers and etc for apparatus, appliance, light industry, machine tool industry.



型号 Model	剪板长度 Cutting Length (mm)	剪板厚度 Cutting Thickness (mm)	剪切角度 Cutting angle	重量 Weightt(kg)	外形尺寸 Dimension(mm) (L.H.W)
Q11A1.5x80	80x80	0.5-1.5	90°	60	1900x1200x1000

# 液压剪角机

## HYD Notching Machine

**机械优势 Mechanical advantage:**

采用液压传动;  
采用全钢焊接结构,具有良好的强度、刚性和抗震性;  
切口角固定为90°,剪切速度快,结构紧凑,体积小,操作方便;  
设有单级及步进级操作功能选择;  
剪切行程可调,行程调节器能限制行程长度,增加每分钟剪切次数;  
满足各类五金剪角加工需要,适用于仪器仪表、电器、轻工、机床行业加工各种箱体、壳罩先等。

Driven by hydraulic pressure;  
Holistic welding structure, with good intensity, rigidity and quake-proof;  
Notching angle fixes in 90o with high notching speed, compact structure, small volume and convenient operation;  
Single stage and step-level operating function can be selected;  
Notching strode can be adjusted. Ist stroke adjustor can limit the strode length and increase the notching quantity per minute;  
Meet the needs of notching processing for all kinds of hardware, Suitable to process various boxes, shell covers and etc for apparatus, appliance, light industry, machine tool industry.

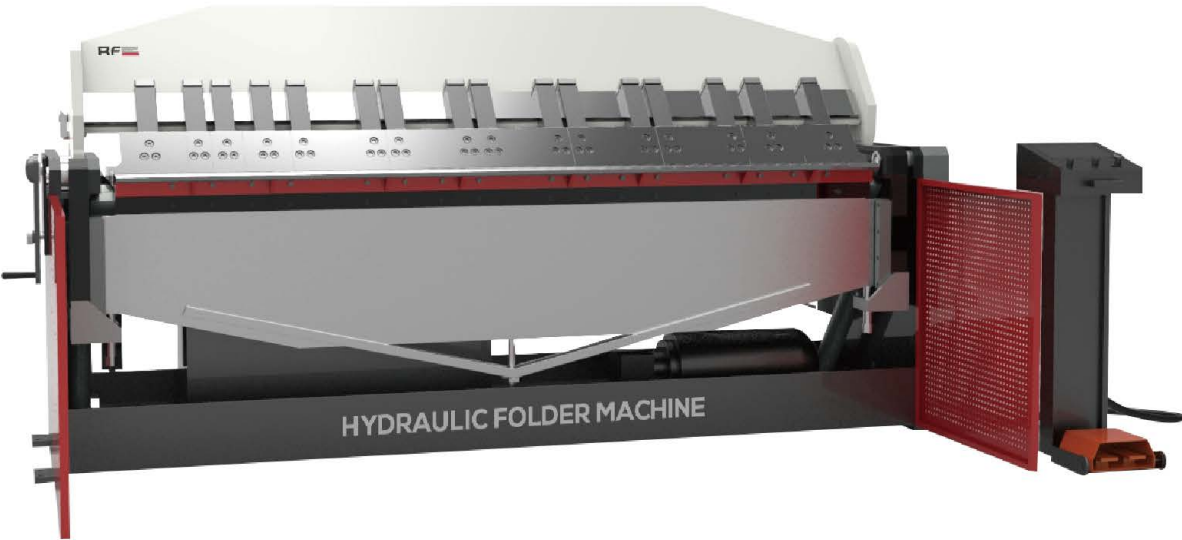
型号 Model	剪板长度 Cutting Length (mm)	剪板厚度 Cutting Thickness (mm)	重量 Weightt(kg)	外形尺寸 Dimension(mm) (L.H.W)
Q28A-4x250	250x250	0.5-4.0	3	900x680x1050
Q28A-6x250	250x250	0.5-6.0	4	930x750x1140



# 数控液压折边机

## Hydraulic folder machine

- 最新改版的系统液压折边机配备一个7“彩色触摸屏控制面板。这款触摸屏的独特之处是它可以存储99个折弯程序且每一个程序皆可设置20个工步，并且每个工步都允许设置材料折弯补偿值。此功能可以让每次折弯角度值都相同，重复定位精度大提高。另一个独特之处是该机器配有快速调整装置，允许调整从1mm到4mm的不同材料厚度。
- 床身采用全钢焊接结构，具有良好的刚性及抗震性；即时在满负荷工作时，也具有优异的强度和最小的床身变形。



Note: “K” is CNC control back gauge

Model	Folder Length (mm)	Folder Thickness (mm)	Max. lift of the upper beam (mm)	Evolving angle of the bending beam	Weight (kg)	Main Motor (KW)	Dimension(mm) (L.H.W)
HP(K)-4×2500	2500	0.5~4.0	200	0°~120°	3200	5.5	3000x1500x810(1920)
HP(K)-5×2000	2000	0.5~5.0	200	0°~120°	2700	5.5	2500x1500x810(1920)
HP(K)-4×3050	3050	0.5~4.0	200	0°~120°	3900	5.5	3600x1500x810 (1920)

# 33RF



### Features:

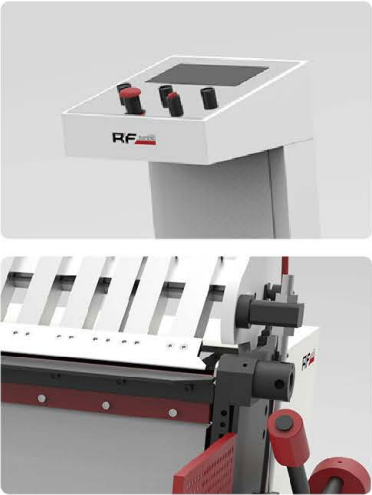
NC Touch Screen Control features 99 programs, each program has up to 20 bends & each bend has material compensation. It also incorporates a quick bend function for jobbing work;  
Auto cycle: after clamping bottom beam will bend to pre-set angle and return, head unclamps to set position;  
NC programmable opening height & bending dwell timer ensures consistent bending angle;  
Quick action rapid head adjustment to optimize bend radius on 1-6mm material thickness;  
Heavy duty steel fabricated construction;  
Roving foot pedal incorporates control panel for maximum flexibility;  
Unique moving guards ensures the front of the machine is clear for unobstructed loading/unloading of material;  
Quality hydraulic and electrical components supplies by leading manufactures including Rexroth, Telemecanique and Merlin Gerin;  
Extended fingers allows bending of pans or boxes to a depth of 205mm;  
Option CNC control back gauge or manual back gauge;  
Mild steel capacity is rated on hot rolled material with 250MPa.

# 半液压折边机

## Half hydraulic folder machine

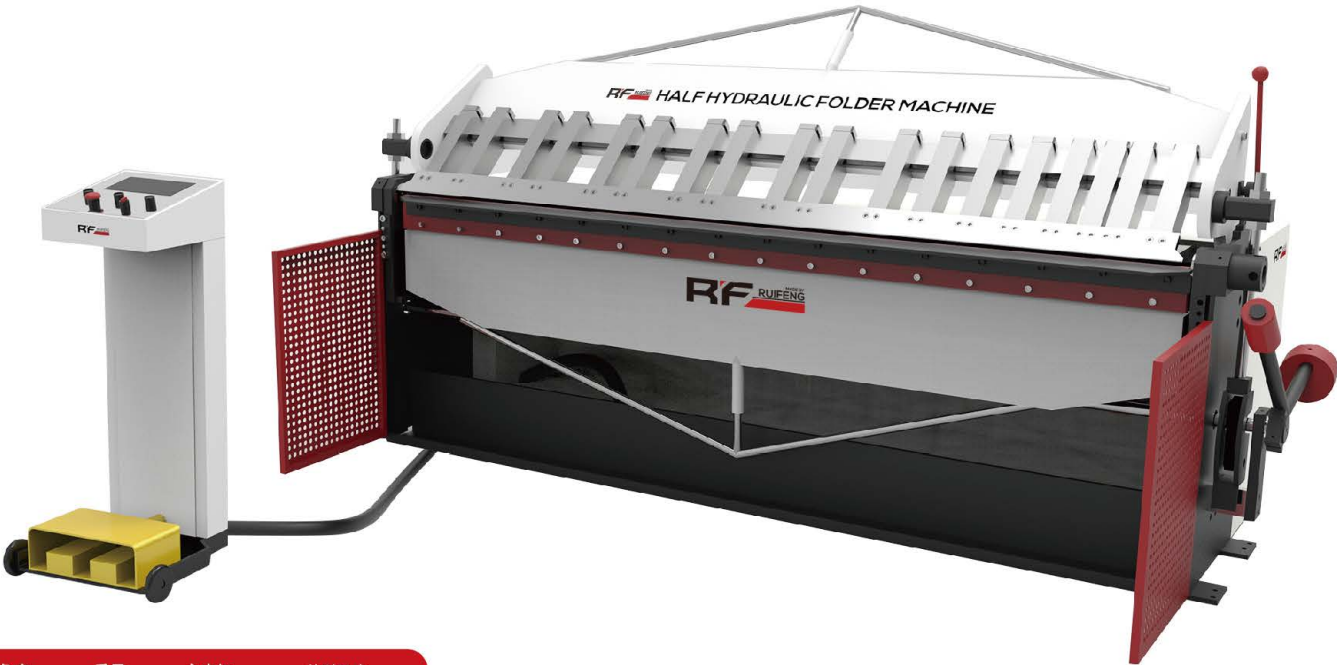
### 性能与特点 Functions and characteristics:

机器为全钢板焊接结构，具有足够的钢性和精度；  
上梁为手动锁紧，折边升降用液压控制；  
独立带脚踏开关的控制台，操作方便；  
加长刀杆设计，折盘盒类工件其最深可达230mm；  
刀片为分段设计，可根据需要自由组合，应用范围广；  
配单轴易用的可编程数显器来控制折弯角度，角度调整范围0° ~ 130°；  
上梁可以在板料厚度1 ~ 2mm范围内进行快速调整，用以实现最理想的折弯半径；  
在机器的右边设有控制上梁开启高度的装置，省时且保证了操作者的安全；  
折弯均具有保压功能，用以保证机器的工作精度；  
配手动后挡料，挡料有效行程650mm。



型号 Model	折边长度 Folder Length (mm)	折边厚度 Folder Thickness (mm)	上梁最大开口高度 Max. lift of the upper beam (mm)	折板回转角度 Evolving angle of the bending beam	重量 Weight (kg)	主电机 Main Motor (KW)	外形尺寸 Dimension(mm) (L.H.W)
MP-2x2500	2500	0.5-2.0	200	0°~120°	2000	3	3000x1500x810
MP-1.5x3050	3050	0.5-1.5	200	0°~120°	2600	3	3600x1500x810

# 34RF



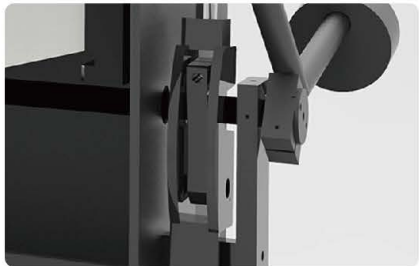
Heavy duty steel fabricated frame provides accurate bends;  
Hydraulic bending with manual clamp;  
Roving foot pedal incorporates control panel for maximum flexibility;  
Extended fingers allows bending of pans or boxes to a depth of 230mm;  
Ground segmented fingers can be repositioned to suit many applications;  
Easy to use single angle programmable controller incorporating digital readout for angles from 0° ~ 130°;  
Auto cycle after clamping bottom beam will bend to pre-set angle and return, head unclamps to set position;  
Safety top beam support stop lever located on right side of machine;  
Adjustable beam for varying material thickness;  
Includes rear 650mm manual back gauge.

扣式手动折边机

Manual pan brake

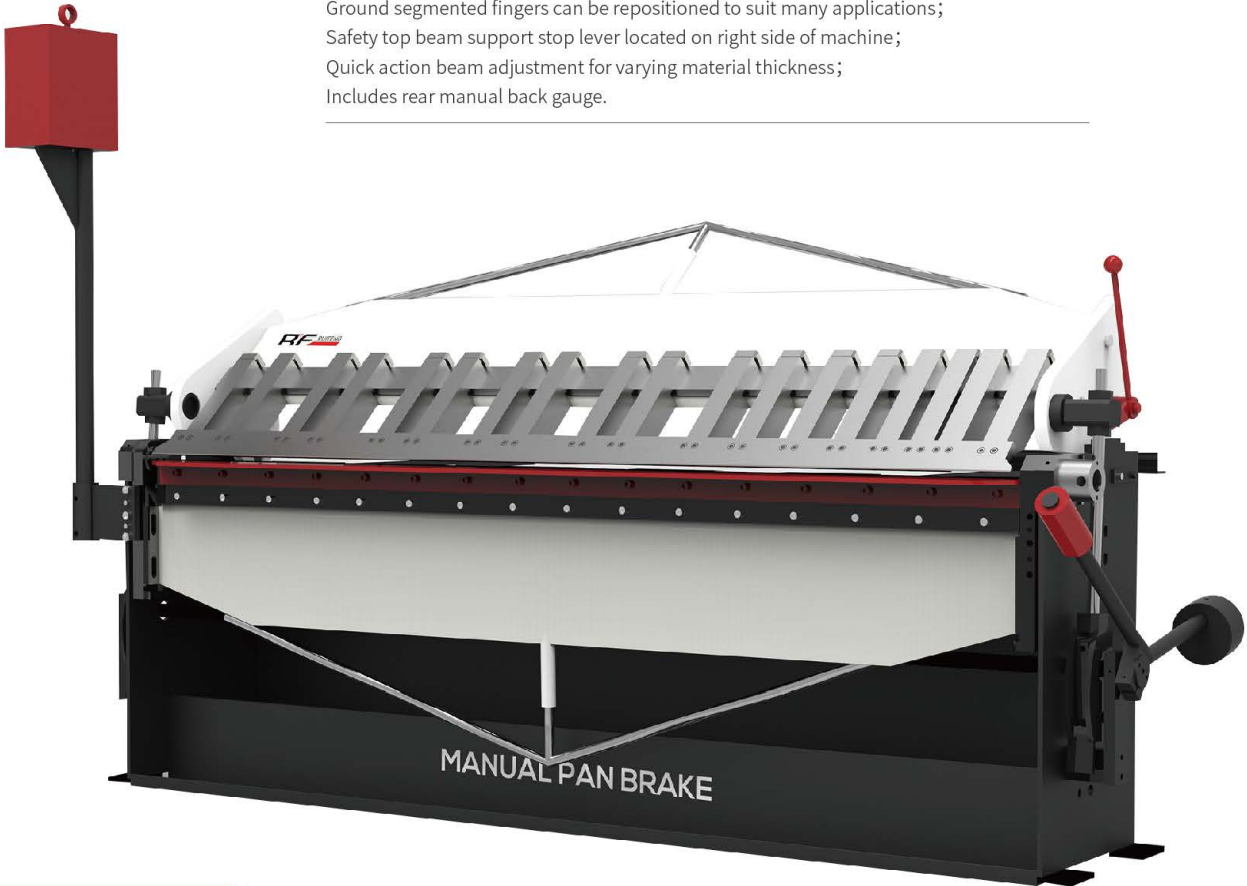
性能与特点 Functions and characteristics:

机器为全钢板焊接结构，具有足够的钢性和精度；  
加长刀杆设计，折盘盒类工件其最深可达200mm；  
机器两边装有刻度尺，直观显示当前所折弯的角度；  
刀片为分段设计，可根据需要自由组合，应用范围广；  
在机器的右边设有控制上梁开启高度的装置，省时且保证了操作者的安全；  
上梁可以在板料厚度1~2mm范围内进行快速调整，用以实现最理想的折弯半径；  
配手动后档料。



型号 Model	折边长度 Folder Length (mm)	折边厚度 Folder Thickness (mm)	上梁最大开口高度 Max. lift of the upper beam (mm)	折板回转角度 Evolving angle of the bending beam	重量 Weight (kg)	外形尺寸 Dimension(mm) (L.H.W)
HB-2x1250	1250	0.5-2.0	220	0°~120°	730	1820x1290x560
HB-2x2440	2440	0.5-2.0	220	0°~120°	1430	2940x1470x570

Heavy duty steel fabricated frame provides accurate bends;  
Extended fingers allows bending of pans or boxes to a depth of 200mm;  
Machine equipped with a graduation ruler on both sides, readout eliminates the bend angle guess work;  
Ground segmented fingers can be repositioned to suit many applications;  
Safety top beam support stop lever located on right side of machine;  
Quick action beam adjustment for varying material thickness;  
Includes rear manual back gauge.

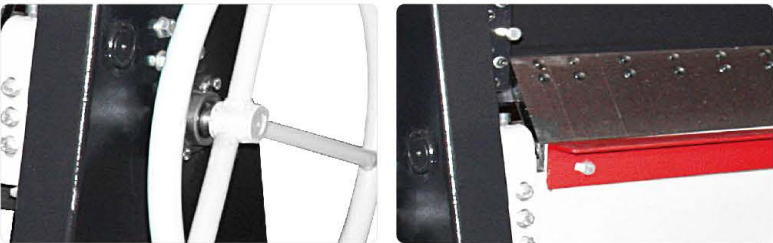


35 RF

丝杆锁紧手动折边机

Screw locking manual crimping machine

- 手动折边机，是锐丰机械厂二十多年生产和使用手动折边机的基础上研制的。它品种规格多样，集各类机型的优点于一身，其最大的优点在于它活动式可调上模，或可调下模，可调按面板刀具，并能根据不同需要加工不同尺寸，将金属板材折出翻边或四边一底的合件或盘件。
- 本手动折边机分轻便型，重型各种规格。适合于移动工地，通风管道制造、五金白铁盒件、盘件的加工。它以轻便、节能、工作效率高、产出快、回报率高而广泛受海内外的欢迎，是企业 and 家庭工厂理想节能设备。



型号 Model	折边长度 Folder Length (mm)	折边厚度 Folder Thickness (mm)	最小折角 Folding Angle	重量 Weight (kg)	外形尺寸 Dimension(mm) (L.W.H)
WS2.5x1300B	1300	2.5	60°	700	1900x800x1100
WS2 x 1300B	1300	2	60°	520	1850x800x1100
WS2 x 1500B	1500	2	60°	580	2050x800x1100
WS2 x 2000B	2000	2	60°	1150	2600x800x1200
WS2 x 2500B	2500	2	60°	1500	3100x800x1200
WS2 x 3100B	3100	2	60°	2800	3800x800x1200
WS1.5x1300B	1300	1.5	60°	390	1800x800x1100
WS1.5x1500B	1500	1.5	60°	480	2100x800x1100
WS1.5x2000B	2000	1.5	60°	700	2600x800x1100
WS1.5x2500B	2500	1.5	60°	1200	3100x800x1100



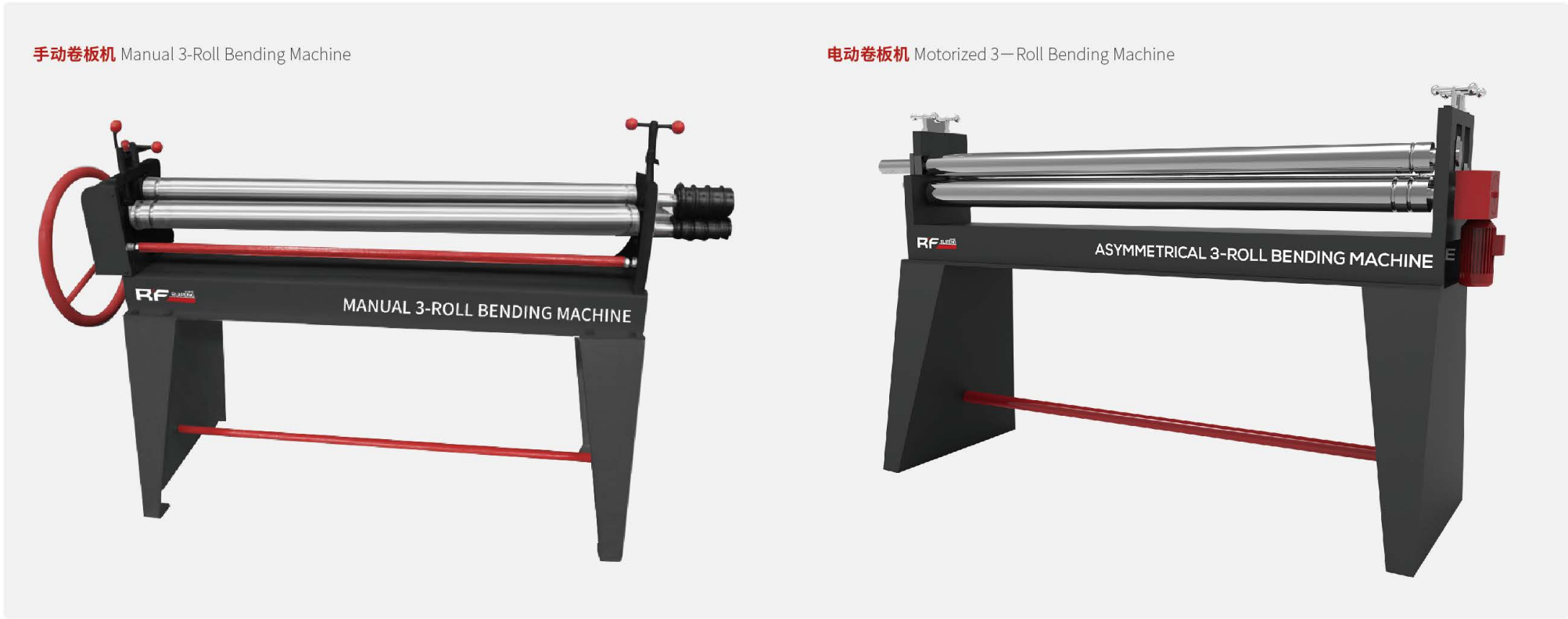
- With 25 years' experience in producing hand folders, our hand folders are of many types and incorporate with all the outstanding features. The advantage is that both its up and down movements can be adjusted. They can process workpieces according to the customer's requirement, and can fold sheet into a box/pan with four sides.
- Hand folders are suitable for duct making, metal box forming and pan processing and can be used on the site. They are in great demand all over the world for the light design, economical use and efficiency. They are perfect equipment for all occasion.

36 RF

偏三星卷板机

Asymmetrical 3-roller bending machine

- 分电动和手动两种，专为薄板卷圆而设计的轻型卷圆机，带预弯功能，手动调整侧辊升降来控制卷圆直径的大小，上辊可以分离取料，操作简单而高效。
- Points of electric and manual, designed for sheet rolling and designed light rolling machines, with pre-bending function, manual control up & down top roll for curving adjustment, can be separated, simple and efficient.



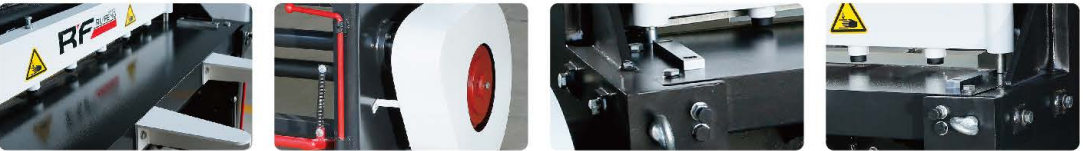
型号 Model	折边厚度 Folder Thickness (mm)	最大卷板宽度 Minimum diameter full capacity (mm)	上辊直径 Top roller diameter (mm)	下辊直径 Bottom roller diameter (mm)	主电机 Main motor (mm)	重量 Weight (kg)	外形尺寸 Dimension(mm) (L.W.H)
W11G-1.2x1530	1.2	1530	72	72	1.5	280	2050x550x1200
W11G-1.5x1300	1.5	1300	72	72	1.5	250	1820x550x1200
W11G-2x1000	2	1000	72	72	1.5	230	1550x550x1200
W11-1.2x1530	1.2	1530	72	72	*	250	2000x550x1200
W11-1.5x1300	1.5	1300	72	72	*	220	1750x550x1200
W11G-2x1000	2	1000	72	72	*	200	1500x550x1200



电动剪板机

Electric shear machine

- 本机械采用全钢焊接结构，结构简单，操作简便，造型美观，能耗低，广泛适用于冶金、轻工、机械、五金等中厚钢板的加工。本机械刀具采用特殊钢材。
- The machine adopts all steel welded structure, simple structure, easy operation, beautiful shape, low energy consumption, is widely used in metallurgy, light industry, machinery, metal and other thick steel plate processing.



型号 Model	剪板长度 Cutting Length (mm)	剪板厚度 Cutting Thickness (mm)	剪切次数 Cutting cycle per minute (mm)	剪切角度 Cutting angle	重量 Weightt (kg)	主电机 Main motor	外形尺寸 Dimension(mm) (L.H.W)
Q11-3x1300	1300	0.5-3.0	20/min	1°30′	1300	3	2100x1400x1100
Q11-2x2000	2000	0.5-2.0	18/min	1°30′	1600	3	2800x1400x1100
Q11-4x2500	2500	0.5-4.0	18/min	1°30′	3500	5.5	3100x1400x1500



角铁卷圆机系列

Section bender machine

- 角铁卷圆机用于通风安装工程中, 专门制作角钢法兰盘的设备, 它与我厂生产的L-12C咬口机、三辊卷圆机配套使用, 可完成母线圆形风管的成形产品, 是实现机械化生产的主要配套设备。
- 机器是对称式三辊 (正三星) 型材卷弯机。用于将扁钢、角钢等型材卷弯成各种规格的圆形构件, 经过焊接加工制成铁圈, 可作为圆管道的连接法兰等零件。
- This machine is specially used to produce flange angle equipment in the project of ventilaton installation. Through working with our L-12C locking machine and 3-roller bending machine, it can finish the procedure of product’ s forming shape in the mainline of round duct, It’ s the main supporting equipment in realizing mechanized production.
- This Symmetrical 3-roller Plate Bending Machine can bend flat steel, andgle steel into round components with all kinds of specifications, which can be welded into the ring. This ring can be used as flange connector in round tube.

型号 Model	加工能力 Process Capacity	最小弯圆直径 Min Diameter (mm)	重量 Weightt(kg)	外形尺寸 Dimension(mm) (L.W.H)
W24-400	4#角钢 4#angle steel	Φ400	500	1040x660x1400
W24Y-500	5#角钢 5# angle steel	Φ500	900	1250x760x1540

液压角铁卷圆机  
HYD Section Bending Machine



电动角铁卷圆机  
Motorized Section Bending Machine

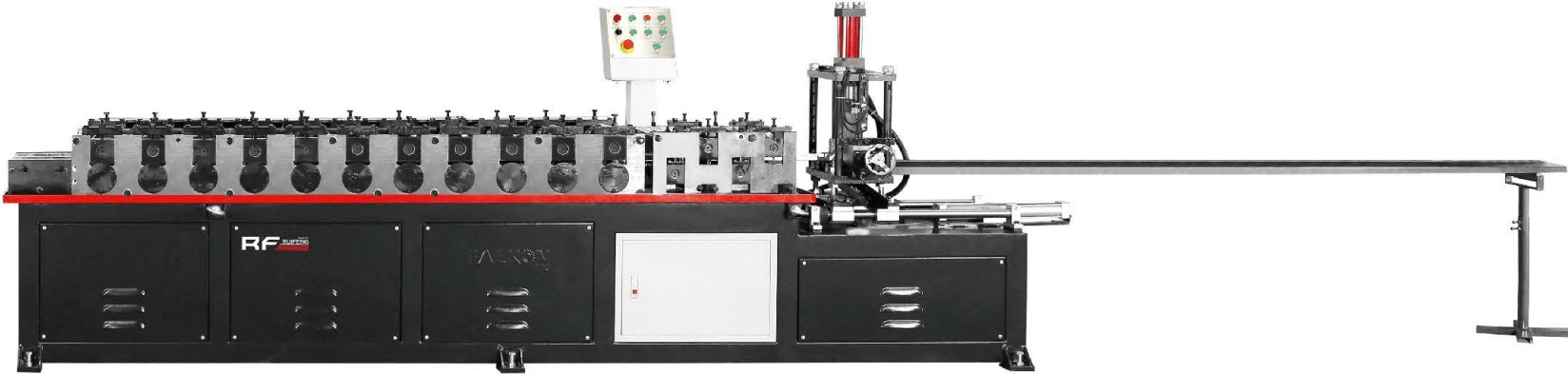


39 RF

冷弯成形机

ROLL FORMING MACHINE

- 我公司是国内首先应用德国冷弯成型轧辊设计软件COPRA于生产设计的企业之一。从开始阶段的辊花设计、计算、成型工艺模拟。到毛坯管理、计算机数控制造、质量控制的整个过程, 锐丰均通过COPRA提供全面的软件解决方法, 并通过优化产品质量, 减少工程所需要时间来克服冷弯成型残余应力, 变换和安装新轧辊成本等等。
- 产品范围包括建筑轻钢结构专用彩钢瓦系列、楼承板系列、琉璃瓦系列、金属落水系列、彩钢聚氨酯配套系列、C、Z型钢檩条系列设备及公路护栏设备, 桥架梯边设备, 车辆型材设备, 货架物流设备, 环保型材设备, 轻钢装饰设备, 门业制造设备, 简易开平纵剪设备等, 并制造提供各类相关辅助设备。



FURRING CHANEL

Material	G.1
Thickness	0.4-0.8mm
Input width	108mm
Motor Power	3kw
Machine speed	8-10 meter/min

Pneumatic cut off system

STUD & TRACK PROFILES

Material	G.1
Thickness	0.4-1mm
Motor Power	4kw
Machine speed	8-10 meter/min
Dimension (mm) (W.H)	STUD 50x34 63x34 70x34 92x34 123x34
TRACK	52x25 65x25 72x25 94x25 125x25

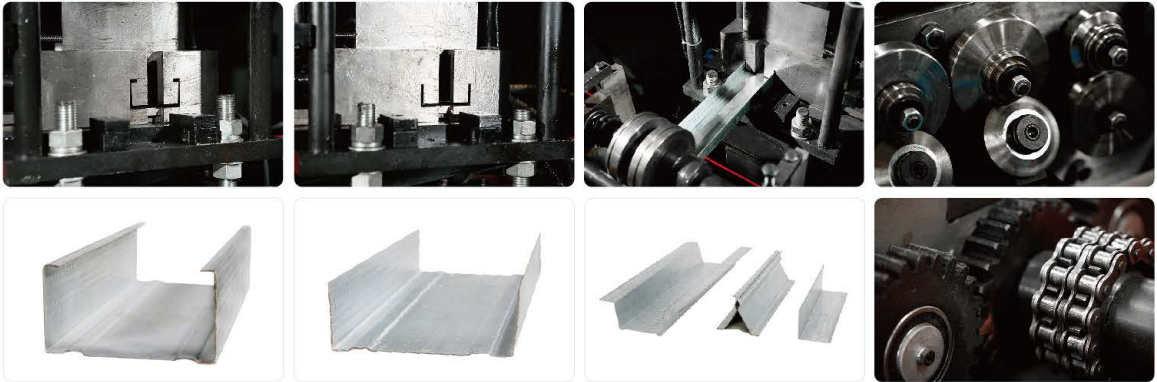
Hydraulic cut off system with multi sizes

MAIN CHANNEL & ANGLE

Material	G.1
Thickness	0.4-0.8mm
Motor Power	3kw
Machine speed	8-10 meter/min
Two sets of rollers installed on the machine, A set of processing angle, Another set of processing C-Channel.	

Pneumatic cut off system

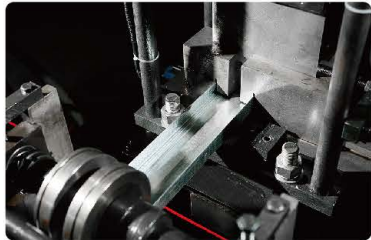
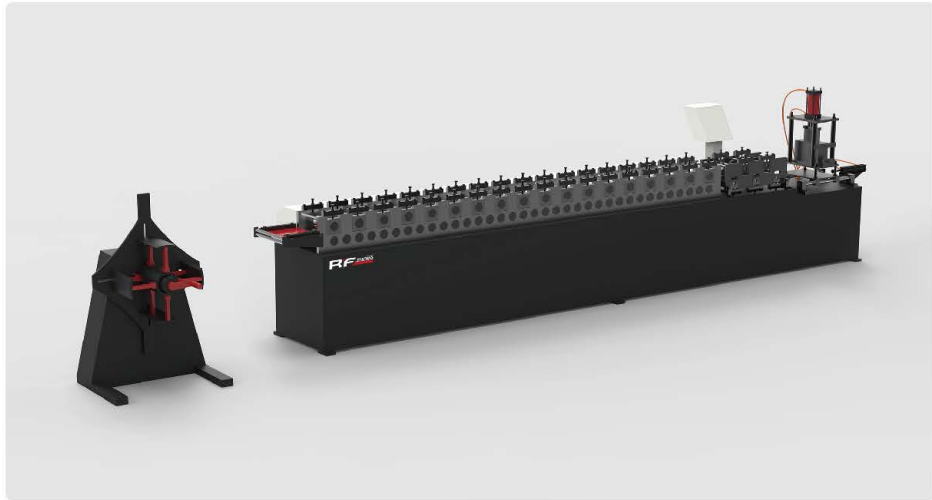
- Our company is one of few companies who have applied the special design software COPRA to roll forming machine. COPRA solves all the problems in processing, including design of rolling wheels, product forming and quality controlling, By improving the wheel's quality and reducing the processing time, it overcomes disadvantages of roll forming technique, such as remaining stress and high-cost for wheel installation and replacement. Making high precision wheels is available with COPRA technology.
- The product range includes the construction of light steel structure-specific color-coated steel tile Series, Deck forming machine series , glazed tile series , downspout series, Color polyurethane series, C,Z purlin series of equipment and highway guard rail equipment, bridge ladder edge equipment, vehicles profile equipment, shelves logistics equipment, environmental protection material equipment, light steel decorative device, the door industry manufacturing machine, simple slitting machine etc. Additionally we manufacture and provide various related auxiliary equipment.



40 RF

横梁

Shelf Beam



防火门

Fire-proof door Duplex Door panel

防火门Fire-proof door Duplex Door panel

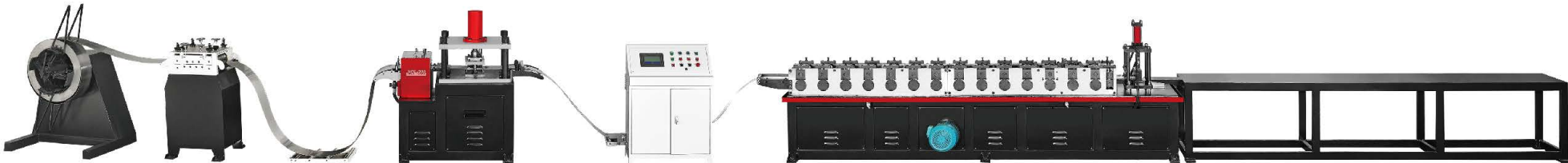
Model	DP-1.5
Material	G.1
Thickness	1-1.5mm
Forming Steps	16 stations
Rollers specification	GCr15
Main Motor	5.5kw
Machine speed	6-8 meter/min
Side A	Forming Door Panel Bottom Side (PAN)
Side B	Forming Door Panel Top Side (LIP)



41

风管挂架

Duct Rack YX-41X21/41/61



42

