



广东中冶合创科技有限公司

Guangdong Zhongye Hechuang Technology Company

地址：佛山市南海软件科技园信息大道研发楼 B 栋

电话：0757-66853532

传真：0757-66853531

网址：www.zyhckj.com

邮箱：zhongyehc@163.com

佛山市泓佳机械设备有限公司

FOSHAN HONG JIA MECHINERY EQUIPMENT CO.,LTD.

地址：佛山市南海区狮山镇一环辅道塘头车站旁
(鸿盈工业区 1 号)

电话：0757-81081115

传真：0757-81081116

网址：www.hongjia86.com

邮箱：hj@hongjia86.com



金属带材剪切生产线 METAL STRIP CUTTING&FINISHING LINE

研发 设计 制造
RESEARCH DESIGNING MANUFACTURING

纵剪分条机、飞剪机

广东中冶合创科技有限公司
Guangdong Zhongye Hechuang Technology Company

佛山市泓佳机械设备有限公司
FOSHAN HONG JIA MECHINERY EQUIPMENT CO.,LTD.



关于中冶合创

ABOUT ZHONGYE HECHUANG

广东中冶合创科技有限公司是一家集研发、设计、生产为一体的高新技术型企业，专业从事非标准及专用冶金精整设备设计与加工制造。广东中冶合创成立至今，凭借专业的水平和成熟的技术，在引进消化吸收国外先进技术的基础上成功研发出金属带材、纵剪、横切、飞剪、纵剪横切联合机组、汽车冲压落料线等系列产品，获得了用户广泛的应用和一致的好评。其中一些产品在国内处于领先地位，部分产品可替代进口。精湛的技术、可靠的产品质量及完善的售后服务，使得企业在十余年的发展历程中取得了骄人的业绩，在业内深得广泛的认可与良好的口碑。

As a high-tech company, Guangdong Zhongye Hechuang Technology Company, which integrates with designing, engineering, manufacturing we provide the professional design and manufacturing of nonstandard or metallurgy finishing machine. The company had created a series of metallurgy machine depending on professional and mature technology, based on the latest science which introduced and absorbed from abroad, and including "flying cut to length", "slitting line", "heavy gauge slitting line", "strip recoiling machine", "cross cut line", etc which had been applied into steel, aluminum, copper area. Some of the products are very well accepted and standing on the leading position in China as instead of the imported product. With more than ten years hardworking, the company achieved very good fame and good sales record owing to its reliable product quality and perfect after sales service. Through continuously cooperated with the foreign and domestic partners, the designing and manufacturing ability, after sales capacity of the company had got greatly improved, running scale widened, now the company from a research type institute in the initial had become into an management company who impact with researching, designing and manufacturing.

公司在发展的过程中，不断与国内外同行交流合作，创新研发、设计生产和调试服务能力迅速提高，规模不断扩大。公司已由初建时的以研发为主，制造为辅的研究型实体转型为产、学、研全方位发展的经营实体。一流的硬件环境加以团结、高效、专业的优秀团队使得公司充满了新鲜活力与发展动力。可为国内外各金属加工企业提供优质的精整设备及优良的技术服务。服务范围包括从研发设计、制造、安装调试直至生产出合乎要求合格产品并提供可靠的技术保障与良好的技术服务。

Depending on the first standard hardware and excellent team, the company emerged into a lively circumstance and full of energy. We focus on the event, that is to provide the best finishing machine and services for all the customers from the aluminum, copper steel. We provide whole set of technology service including designing, engineering, manufacturing and commissioning running till the qualified strip product is made.

“强化质量意识，持续改进体系，奉献精品设计，提供优质服务”的质量方针是企业不断的追求。

"Strengthening the quality notice, improving the system continuously, and providing the excellent product & services" is our manage spirit and will be the company's long lasting pursuing.

“道勤志远，创新求存”的经营理念是企业永恒的主题。广东中冶合创科技有限公司将秉承企业的精神，把握历史契机，追求卓越，愿与国内外各界合作伙伴携手并进，共创辉煌明天！

"Hardworking for great ambition, Innovation for survival" will be the spirit and always be the topic of company, Guangdong Zhongye Hechuang Technology Company will hand on the spirit grasp the historical chance, pursue the excellence, and cooperate with the domestic as well as foreign friends to our nice future.

目录

CONTENTS

| | |
|--|----|
| 钢板纵剪分条机组 Steel Plate Slitting Set | 01 |
| 复卷（重卷）机组 Trimming Line Brief Introfuction | 05 |
| 钢板整平横切机组 Steel Plate Leveling Traverse Cutting Set | 07 |
| 飞剪机组 Flying Cut To Length Set | 11 |
| 纵剪横切联合机组 Steel Coil Slitting And Cutting Line | 13 |
| 汽车冲压落料线 Punching Blanking Line | 15 |
| 不平行辊列校平机 Unparallel Roller Leveller | 17 |
| 六重式辊式校平机 Six-HI Roller Levelling And Cutting Machine | 19 |

钢板纵剪分条机组

STEEL PLATE SLITTING SET

一、概况 General introduction

钢板纵剪分条机组可将各种宽带卷切边、纵切成不同规格的窄带并进行卷取，具有高精度的纵剪分条宽度，为直接使用钢卷作原料进行深加工提供保障。是现代工业生产中追求更高的材料利用率和生产效率必不可少自动化加工设备。

The steel plate slitting set consists of feed-in coil car, uncoiling device leveling Device, cropping shears kink, rotary shears, scrap coiler, tensile force device, separating pressing roller, recoiler, and feed-out coil car. Imported high-performance PLC programmable control system is employed to realize global control. With reliable and stable hydraulic system, high-strength, high-rigidity structure, and rational site configurations, the device is more convenient and practical for your operation.

二、结构说明 Structure Description

组成：上料小车、开卷机、拆卷引料机、校平机、活套、导向装置、纵剪机、活套张力、废边收料机收卷机、卸料小车；

采用高性能 PLC 可编程控制系统控制；

可靠的液气气动系统，高强度、高刚度的结构设计；

Including feed-in coil car, de coiling device, open and feeding device, flatting device, detachable bridge. Measuring device, slitter, scrapers and feed-out coil car.

PLC system control with high performance.

Reliable hydraulic system, and structure with high strength and rigidity.

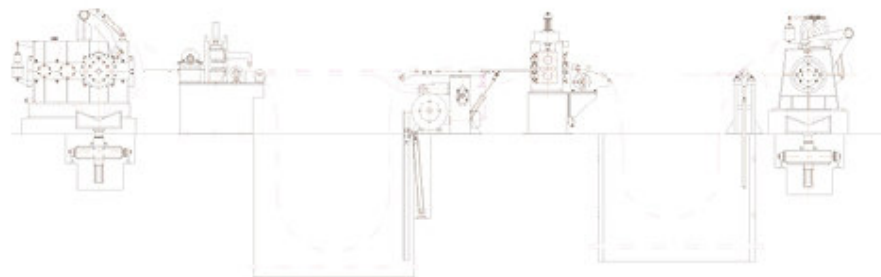
根据加工板材的厚度我们又把钢板纵剪机组分为薄板系列纵剪机组与厚板系列纵剪机组，薄板系列纵剪机组根据结构上的区别又分为机械型与液压型。

According to the thickness of the raw material, slitting line includes two series that thin and thick series. Slitting line of thin series can be mechanical or hydraulic type

技术参数 Specification

| 序号 No. | 生产线 名称 Commodity | 适用 材料 Raw material | 板料厚度 THK (mm) | 板料宽度 Width (mm) | 卷材内径 ID (mm) | 卷材 外径 OD (mm) | 卷材 重量 Weight (T) | 宽度 精度 Width accuracy (mm) | 纵剪 条数 Slits (pc) | 纵剪 精度 Slit tolerance (mm) | 速度 Speed (m/min) | 总功率 Capacity (kw) | 机械占 地面 Floor space (m) |
|-----------|------------------------|---|---------------------|-----------------------|------------------------|------------------------|---------------------------|---------------------------------------|---------------------------|---------------------------------------|------------------------|-------------------------|------------------------------------|
| 1 | 1.0 x 360 | 普 碳 钢 、 不 锈 钢 、 铝 及 各 种 特 殊 钢 | 0.1 - 1.0 | 100 - 360 | φ250/φ300 φ400/φ500 | ≤φ1200 | ≤2.5 | ≤±0.05 | ≤12 | ≥6 | ≤60 | ≤45 | 8 x 3 |
| 2 | 1.2 x 500 | | 0.15 - 1.2 | 100 - 500 | φ300/φ500 | ≤φ1200 | ≤3 | ≤±0.05 | ≤14 | ≥20 | ≤120 | ~80 | 8 x 3 |
| 3 | 2.0 x 650 | | 0.2 - 2.0 | 150 - 650 | φ508/φ10 | ≤φ1500 | ≤8 | ≤±0.05 | ≤16 | ≥20 | ≤180 | ~96 | 11 x 4 |
| 4 | 2.0 x 850 | | 0.25 - 2.0 | 200 - 850 | φ508/φ10 | ≤φ1500 | ≤10 | ≤±0.05 | ≤18 | ≥20 | ≤180 | ~96 | 11 x 4 |
| 5 | 2.0 x 1000 | | 0.2 - 2.0 | 300 - 1000 | φ508/φ10 | ≤φ1500 | ≤15 | ≤±0.05 | ≤24 | ≥20 | ≤180 | ~120 | 11 x 5 |
| 6 | 2.0 x 1250 | | 0.15 - 2.0 | 500 - 1250 | φ508/φ10 | ≤φ1500 | ≤15 | ≤±0.05 | ≤24 | ≥20 | ≤180 | ~160 | 12 x 6 |
| 7 | 2.0 x 1600 | | 0.2 - 2.0 | 500 - 1600 | φ508/φ10 | ≤φ1500 | ≤20 | ≤±0.05 | ≤32 | ≥20 | ≤200 | ~240 | 22 x 7 |
| 8 | 3.0 x 650 | | 0.2 - 2.0 | 200 - 650 | φ508/φ10 | ≤φ1500 | ≤15 | ≤±0.05 | ≤12 | ≥20 | ≤150 | ~180 | 22 x 7 |
| 9 | 3.0 x 1250 | | 0.3 - 2.75 | 500 - 1250 | φ508/φ10 | ≤φ1500 | ≤15 | ≤±0.05 | ≤12 | ≥20 | ≤180 | ~205 | 22 x 6.5 |
| 10 | 3.0 x 1600 | | 0.4 - 3.0 | 600 - 1600 | φ508/φ10 | ≤φ1500 | ≤25 | ≤±0.05 | ≤24 | ≥30 | ≤120 | ~230 | 23 x 8.5 |

注：上述标准仅供参考，可根据客户需求决定参数。

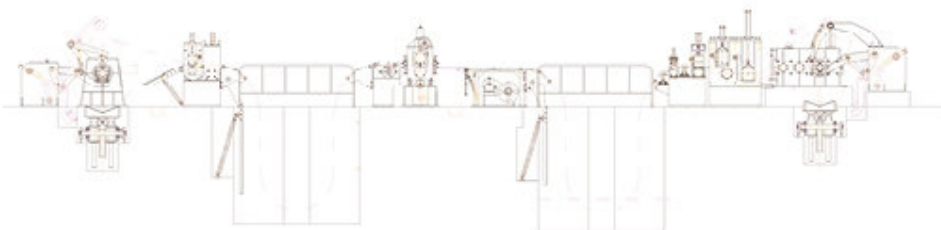


0.2~2.0×500 (650、700、850、1000) 纵剪机组
0.2~2.0×500 (650、700、850、1000) Slitting set

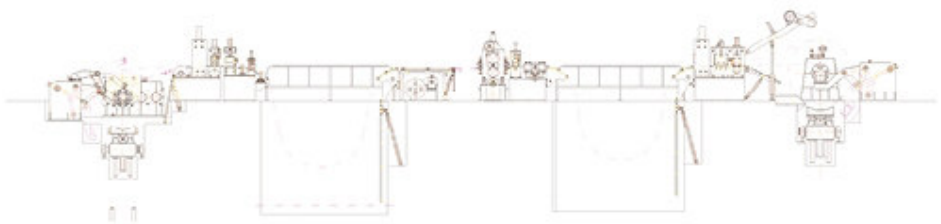


钢板纵剪分条机组

STEEL PLATE SLITTING SET



0.2~2.0×1000 (1300、1600、1800) 纵剪机组
0.2~2.0×1000 (1300、1600、1800) Slitting set



0.3~3.0×1300、1600、1800 纵剪机组
0.3~3.0×1300、1600、1800 Slitting set



中、厚板系列纵切机组

SLITTING LINE (THICK PLATE)



2~9×1600 纵剪机组
2~9×1600 Slitting set

| 序号 No. | 生产线 名称 Commodity | 通用 材料 Raw material | 板料厚度 THK (mm) | 板料宽度 Width (mm) | 卷材内径 ID (mm) | 卷材 外径 OD (mm) | 卷材 重量 Weight (T) | 宽度 精度 Width accuracy (mm) | 纵剪 条数 Slits (pc) | 纵剪 精度 Slit tolerance (mm) | 速度 Speed (m/min) | 总功率 Capacity (kw) | 机械占 地面 Floor space (m) |
|-----------|------------------------|-----------------------------|---------------------|-----------------------|--------------------|------------------------|---------------------------|---------------------------------------|---------------------------|---------------------------------------|------------------------|-------------------------|------------------------------------|
| 1 | 4.0 x 1600 | 普碳钢 | 0.5 - 4.0 | 800 - 1600 | φ508/610 | ≤φ1500 | ≤ 25 | ≤ ±0.1 | ≤ 24 | ≥ 30 | ≤ 120 | ~220 | 25 x 7.5 |
| 2 | 6.0 x 800 | 不锈钢、 铝及 各种 特殊 钢 | 1.0 - 6.0 | 200 - 800 | φ508/610/760 | ≤φ1500 | ≤ 15 | ≤ ±0.1 | ≤ 24 | ≥ 30 | ≤ 60 | ~220 | 15 x 5.5 |
| 3 | 6.0 x 1600 | | 1.0 - 6.0 | 800 - 1600 | φ508/610/760 | ≤φ1500 | ≤ 25 | ≤ ±0.1 | ≤ 24 | ≥ 40 | ≤ 50 | ~220 | 28 x 10.5 |
| 4 | 9.0 x 1600 | | 2.0 - 9.0 | 800 - 1600 | φ508/610/760 | ≤φ2000 | ≤ 25 | ≤ ±0.1 | ≤ 12 | ≥ 60 | ≤ 40 | ~265 | 28 x 10 |
| 5 | 12 x 2000 | | 3.0 - 12.0 | 1000 - 2000 | φ508/610/760 | ≤φ2000 | ≤ 35 | ≤ ±0.5 | ≤ 10 | ≥ 200 | ≤ 20 | ~285 | 36 x 10 |
| 6 | 16 x 2200 | | 4.0 - 16.0 | 1000 - 2200 | φ508/610/760 | ≤φ2000 | ≤ 35 | ≤ ±0.5 | ≤ 10 | ≥ 200 | ≤ 20 | ~285 | 36 x 10 |

注：上述标准仅供参考，可根据客户需求决定参数。



复卷 (重卷) 机组

TRIMMING LINE

一、概况 General introduction >>>

重卷机组的主要功能是将带材切边，粗矫并重新卷取，主要包括开卷机，切边圆盘剪，卷取机等几部分。

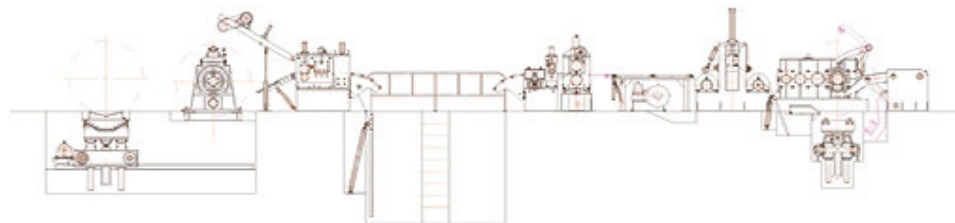
>>>厚度范围：0.3-5.0mm，

>>>重卷速度：200m/min。

Trimming line include decoiling, edge trimming, leveling and recoiling, which mainly consists of recoiler, edge trimmer recoiler

>>>Material thickness: 0.3-5.0mm

>>>Line speed: 200m/min



1~4×1250 切边复卷机组
1~4×1250 Edge-trimming and recoiling set



1. 原材料种类 钢及其合金带卷材

1. Material type
Aluminium and Aluminium alloy

2. 来料机械性能

强度极限： $\sigma_s=8-45\text{kg/mm}^2$

屈服极限： $\sigma_s=3-33\text{kg/mm}^2$

2. Mechanical performance

Strength limit: $\sigma_s=8-45\text{kg/mm}^2$

Yield limit: $\sigma_s=3-33\text{kg/mm}^2$

3. 原材料规格

卷材厚度：0.3-5mm

卷材宽度：800-2100mm

卷材外径： $\phi 2000\text{mm}$

卷材内径： $\phi 508\text{mm}$

$\phi 610\text{mm}$

最大卷材重量：25t

3. Material spec

Coil thickness: 0.3-5mm

Coil width: 800-2100mm

Coil OD: $\phi 2000\text{mm}$

Coil ID: $\phi 508\text{mm}$

$\phi 610\text{mm}$

Max weight: 25t

4. 机组技术参数

工作速度：200m/min

穿带速度：15m/min

作业线标高：+1000mm

机列方向：从操作侧看从左

到右

液压系统工作压力：10Mpa

气动系统工作压力：0.5Mpa

4. Line spec

Speed: 200m/min

Threading speed: 15m/min

Operation working central

height: +1000mm

Line direction: left to from the

operation side view

Hydraulic pressure: 10Mpa

Pneumatic pressure: 0.5Mpa

注：上述标准仅供参考，可根据客户需求决定参数。

钢板整平横切机组

STEEL PLATE LEVELING AND CUTTING SET

一、概况 General introduction

钢板整平横切机组具有高效定尺剪切钢板之功能，可将各种卷板材料经开卷、整平、定尺剪切成不同规格板材，是金属板材加工工业必不可少的高效加工流水线。在机组后面可增加成垛板系统，将定尺裁剪的板料收集成垛。适用于集装箱、机械制造、家用电器、汽车、不锈钢制品、轻工等行业部门。

The steel plate leveling and cutting line has the function of efficient to-length cutting of steel plates, consist of uncoil, level and cut into sheet with different length, and it has become an indispensable processing assembly line for metallic sheet materials processing. At the rear of the set, we can add a stacking device for collecting and pile cut sheet, It is applicable to industries such as Containers, machinery manufacturing, electrical appliances, autos, stainless steel Products, and light industry.

二、结构说明 Structure Description

- » 组成：上料小车、开卷机、拆卷引料机、校平机、活套、定尺装置、剪床、输送机、垛板系统；
- » 采用高性能 PLC 可编程控制系统控制；
- » 可靠的液压气动系统，高强度、高刚度的结构设计；
- » Including feed-in coil car, de-coiling device, open and feeding device, flattening device, detachable bridge, measuring device, shear, transporting device and stacking device
- » PLC system control with high performance
- » Reliable hydraulic system, and structure with high strength and rigidity

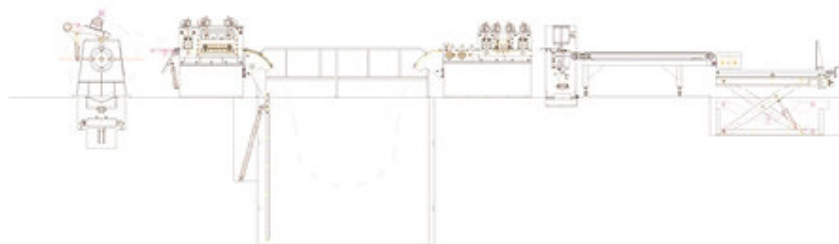
技术参数 Specification

| 序号 No. | 生产线 名称 Commodity | 适用材料 Raw material | 板料厚度 THK (mm) | 板料宽度 Width (mm) | 卷材内径 ID (mm) | 卷材 外径 OD (mm) | 卷材 重量 Weight (T) | 横切长度 范 Length arrange (mm) | 长度精度 Length accuracy (mm) | 对角线 精度 Diagonal tolerance (mm) | 平整度 Flatness (mm/m ²) | 速度 Speed (m/min) | 总功率 Capacity (kw) | 机械占 地面积 Footcrops (m) | 备注 Note |
|-----------|------------------------|-------------------------|---------------------|-----------------------|--------------------|------------------------|---------------------------|-------------------------------------|------------------------------------|--|---|------------------------|-------------------------|--------------------------------|------------|
| 1 | 2.0 x 500 | 不锈钢 | 0.2-2.0 | 200-500 | φ508 | ≤φ1200 | ≤6 | 300-1500 | ≤±0.5 | ≤±0.8 | ≤1.5 | 15-50 | ~75 | 16 x 4 | |
| 2 | 2.0 x 650 | 不锈钢 | 0.2-2.0 | 200-650 | φ508 | ≤φ1200 | ≤6 | 300-1500 | ≤±0.5 | ≤±0.8 | ≤1.5 | 15-50 | ~75 | 16 x 4 | |
| 3 | 2.0 x 1300 | 冷轧板 | 0.3-2.0 | 500-1300 | φ508/610 | ≤φ1500 | ≤15 | 500-3500 | ≤±0.5 | ≤±0.8 | ≤1.5 | ≤50 | ~95 | 22 x 7 | |
| 4 | 2.0 x 1600 | 冷轧板 | 0.3-2.0 | 500-1600 | φ508/610 | ≤φ1600 | ≤15 | 500-4000 | ≤±0.5 | ≤±0.8 | ≤1.5 | ≤60 | ~122 | 22.5 x 8 | |
| 5 | 2.6 x 1850 | 镀锌板 | 0.5-2.6 | 400-1850 | φ508/610 | ≤φ1500 | ≤20 | 400-4000 | ≤±0.5 | ≤±1.0 | ≤1.5 | ≤80 | ~180 | 25 x 9 | |
| 6 | 3.0 x 1600 | 镀锌板 | 0.3-3.0 | 500-1600 | φ508 | ≤φ1500 | ≤20 | 500-4000 | ≤±0.5 | ≤±1.0 | ≤1.5 | ≤45 | ~90 | 23 x 8 | |
| 7 | 4.0 x 1600 | | 0.6-4.0 | 600-1600 | φ508/610 | ≤φ2000 | ≤20 | 1000-12000 | ≤±0.5 | ≤±1.5 | ≤1.5 | ≤45 | ~100 | 30 x 8 | |

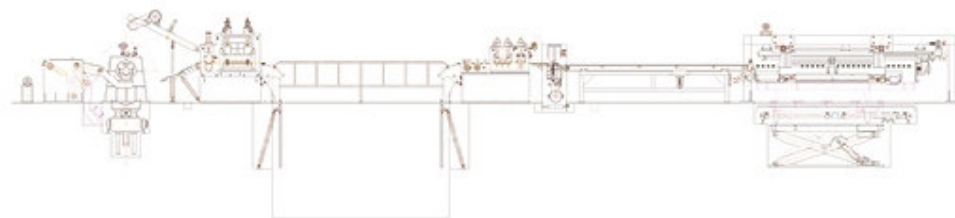
注：上述标准仅供参考，可根据客户需求决定参数。

薄板系列整平横剪机组

LEVELING AND CUTTING LINE



0.2~2.0×500、700、800 整平横切机组
0.2~2.0×500、700、800 Leveling and traverse cutting line



0.4~3.0×1300、1600、1800 整平横切机组
0.4~3.0×1300、1600、1800 Leveling and traverse cutting line



中、厚板系列整平横剪机组

LEVELING AND TRAVERSE CUTTING LINE

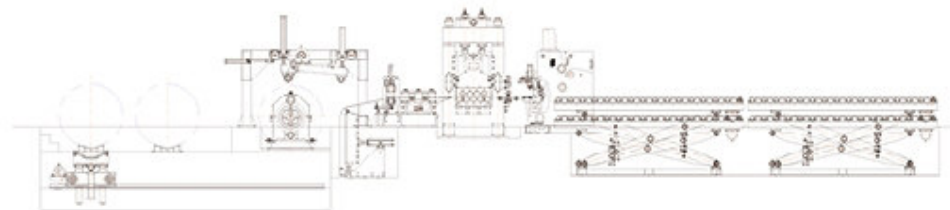
技术参数 Specification

| 序号 No. | 生产线 名称 Commodity | 适用 材料 Flow rates | 板料厚度 THK (mm) | 板料宽度 Width (mm) | 卷材内径 ID (mm) | 卷材 外径 OD (mm) | 卷材 重量 Weight (T) | 横切长度 范围 Length (mm) | 长度精度 Length accuracy (mm) | 对角线 精度 Diagonal tolerance (mm) | 平整度 Flatness (mm/m ²) | 速度 Speed (m/min) | 总功率 Capacity (kw) | 机械占 地面 Footprint (m) | 备注 Note |
|-----------|------------------------|---------------------------|---------------------|-----------------------|--------------------|------------------------|---------------------------|------------------------------|------------------------------------|--|---|------------------------|-------------------------|-------------------------------|------------|
| 1 | 6.0 x 1600 | 热轧 | 1.0 - 6.0 | 600 - 1600 | φ508/610 | ≤φ2000 | ≤30 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤30 | ~155 | 35 x 8 | |
| 2 | 8.0 x 1600 | 热轧 低碳 | 2.0 - 8.0 | 600 - 1600 | φ508/610 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤20 | ~180 | 25 x 8 | |
| 3 | 9.0 x 1600 | 热轧 碳素 | 2.0 - 9.0 | 600 - 1600 | φ508/610 | ≤φ2000 | ≤20 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤20 | ~170 | 25 x 8.5 | |
| 4 | 10 x 1600 | 卷板 | 2.0 - 10 | 600 - 1600 | φ508-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤30 | ~240 | 42 x 8 | 带修边 |
| 5 | 12 x 2000 | Q345 Q450 | 3.0 - 12 | 1000 - 2000 | φ508-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤16 | ~255 | 50 x 10 | 带修边 |
| 6 | 12 x 1800 | Q345 Q450 | 3.0 - 12 | 600 - 1600 | φ508-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.1 | ≤±1.5 | ≤2.0 | ≤16 | ~255 | 50 x 10 | 带修边 |
| 7 | 16 x 2000 | 热轧 Q450 | 4.0 - 16 | 1000 - 2000 | φ610-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.2 | ≤±3.0 | ≤2.0 | ≤12 | ~275 | 50 x 10.5 | 带修边 |
| 8 | 20 x 2200 | 热轧 不锈钢 | 5.0 - 20 | 900 - 2200 | φ610-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.2 | ≤±3.0 | ≤3.0 | 10-16 | ~220 | 29 x 9.6 | |
| 9 | 22 x 2200 | 热轧 不锈钢 | 5.0 - 20 | 900 - 2200 | φ610-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.2 | ≤±3.0 | ≤3.0 | 10-16 | ~220 | 29 x 9.6 | |
| 10 | 25 x 2200 | 热轧 不锈钢 | 5.0 - 20 | 900 - 2200 | φ610-φ760 | ≤φ2000 | ≤35 | 1000-12000 | ≤±0.2 | ≤±3.0 | ≤3.0 | 10-16 | ~220 | 30 x 11 | |

注：上述标准仅供参考，可根据客户需求决定参数。



4~16×2500 整平横切机组
4~16×2500 Leveling and traverse cutting line



8~22×2200 整平横切机组
8~22×2200 Leveling and traverse cutting line



飞剪机组

FLYING CUT TO LENGTH LINE

一、概况 General introduction >>>

钢板整平飞剪机组具有跟踪定尺剪切钢板之功能，可将各种卷板材料经开卷、整平、跟踪定尺剪切成不同规格板材，保证板料在设定速度下定尺剪切，有效地提高的生产线的生产效率。在机组后面可增加垛板集料系统将定尺剪裁的板料收集成垛。适用于集装箱、机械制造、家用电器、汽车、不锈钢制品、轻工等行业部门。

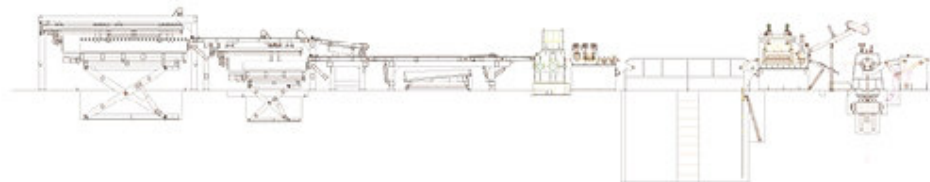
Plate leveling flying cut to length line with the functions of tracking measurer and measuring and cutting steel, can cut coil into different specifications sheet through decoiling, leveling, tracking measurer and cutting, ensuring that measuring and cutting sheet in a set speed to improve production line efficiency. In the end of the line, a device is equipped to stacking plate-sheet. This line is widely used in containers, machinery, household appliances, automobiles, stainless steel products and light industry, etc.

二、结构说明 Structure Description >>>

- >>> 机械组成：上料小车、开卷机、拆卷引料机、校平机、(活套)、定尺装置、飞剪、输送机、垛板集料系统。
- >>> 电气系统：整线采用高性能 PLC 可编程控制系统，采用闭环控制方式；飞剪自动匹配剪切速度，灵敏度高，精度高。
- >>> 液压系统：整线采用优良可靠的液压系统，机组配置国内外知名液压元器件，满足了高强度、高刚度的结构设计理念。
- >>> Mechanical component: feed-in coil car, decoiler, open and feeding device, leveling device, (detachable bridge), measuring device, flying cutter, transporting device and stacking device.
- >>> Electrical system: PLC control with high performance, adopting closed loop control, flying cutter match with automatic speed, high sensitivity.
- >>> Hydraulic system: adopting hydraulic parts from domestic and international well-known enterprises, designed to satisfy with high strength and rigidity.

| 规格型号 Model | 850 型 | 1250 型 | 1600 型 | 1850 型 |
|------------------------------------|--|-------------|-------------|-------------|
| 原始卷料 Processing material | 冷轧板、镀锌板、彩涂板、不锈钢板等 Cold-rolled steel coil, Galvanized coil, Cold-coated coil, Stainless steel coil, etc. | | | |
| 材料厚度 Processing sheet thickness | 0.3mm~2.0mm | 0.3mm~2.3mm | 0.5mm~3.0mm | 0.5mm~3.0mm |
| 材料宽度 Processing sheet width | 850mm(MAX) | 1250mm(MAX) | 1600mm(MAX) | 1850mm(MAX) |
| 卷料重量 Coil weight permitted | 8ton(MAX) | 15ton(MAX) | 20ton(MAX) | 20ton(MAX) |
| 剪切精度 Cutting accuracy | 剪切 Cutting $\pm 0.3\text{mm}$ 加减速 Acc/ decelerate $\pm 0.5\text{mm}$ | | | |
| 机组速度 Line speed | 80m/min~100m/min | | | |

注：上述标准仅供参考，可根据客户需求决定参数。



0.3~3.0×850、1250、1600、1850 飞剪机组
0.3~3.0×850、1250、1600、1850 Flying cut line



纵剪横切联合机组

PLATE SLITTING AND CUTTING LINE

技术参数 Specification

| 序号 No. | 生产线名称 Commodity | 适用材料 Raw material | 板料强度 (Mpa) | 板料厚度 THK (mm) | 板料宽度 Width (mm) | 卷材内径 ID (mm) | 卷材外径 OD (mm) | 卷材重量 Weight (T) | 纵剪公差 SA tolerance (mm) | 纵剪余数 Slits (pc) | 纵剪宽度精度 Slit tolerance (mm) | 横切长度范围 Length range (mm) |
|--------|-----------------|-------------------|--------------------------|---------------|-----------------|--------------|--------------|-----------------|------------------------|-----------------|----------------------------|--------------------------|
| 1 | 8 x 2000 | 恒温冷轧或热冷轧卷板 | abs<500Mpa etc<370Mpa | 4.0-8.0 | 850-2000 | φ508/φ10760 | φ1200-φ2000 | ≤ 30 | ≥ 60- ≤ 2000 | ≤ 20 | ≤ ±0.25 | 1000-6000 |
| 2 | 12 x 1800 | Q235 | | 4.0-12 | 500-1800 | φ508/φ10760 | φ1200-φ2000 | ≤ 30 | ≥ 150 | ≤ 15 | ≤ ±0.05 | 1000-10000 |
| | | Q345 | | 4.0-12 | | | | | | | | |
| | | B510 | | 3-5 | | | | | | | | |
| 3 | 16 x 2200 | Q235 | | 4.0-10mm | 1000-2200 | φ508/φ10760 | φ1200-φ2000 | ≤ 30 | ≥ 200 | ≤ 10 | ≤ ±0.05 | 1000-12000 |
| | | Q345 | | 4.0-16mm | | | | | | | | |
| | | 510L | abs<200Mpa etc<750Mpa | BS103-10mm | | | | | | | | |
| | | ZQS700L | | BS700L5-10mm | | | | | | | | |

注：上述标准仅供参考，可根据客户需求决定参数。

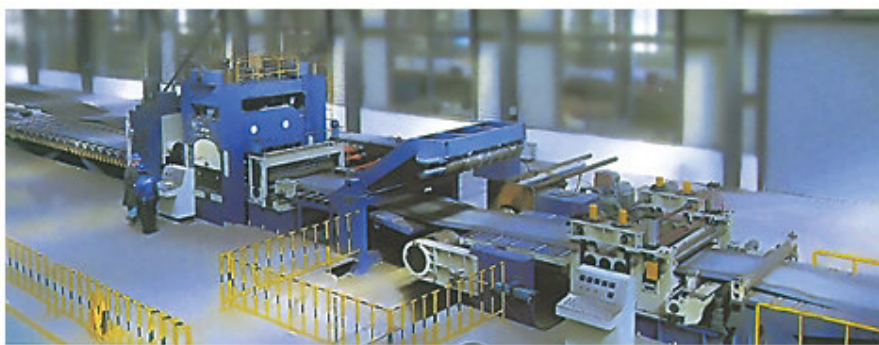
- » 高度可靠的机器性能
- » 精确的分条剪切
- » 整齐的卷取
- » 友好的人机界面

- » Cutting accuracy and precision thanks to the machine solidity
- » Accurate slitting and cutting
- » Tidy recoiling
- » Delightful man-machine interface



4~16×2200 纵剪横切联合机组

4~16×2200 Leveling and cutting line



冲压落料

PUNCHING BLANKING LINE

一、材料参数 Parameters >>>

材质：普通冷轧汽车钢板、冷热镀锌板、高强度汽车钢板、热轧酸洗板

屈服强度：200-400 N/mm²；抗拉强度：270-600 N/mm²；

延伸率：≥ 21%

钢板厚度：0.5-3.2 mm；

钢板宽度：200-1300 mm

卷料重量：10T；

卷料内径：508mm；卷料外径：800-1500 mm

板料校平精度：≤ 1.5mm/m²；

板料送料步进长度：50-000

送料精度 100-1500mm；± 0.2mm/m



Material : CR Auto Steel Plate、GI、High Grade Strength Auto Steel Plate、HR

Pickled Sheet

YS: 200-400 N/mm²; TS: 270-600 N/mm²;

Elongation: ≥ 21%

Thickness: 0.5-3.2 mm;

Width: 200-1300 mm

Weight: 10T;

Coils ID: 508mm; Coils OD: 800-1500 mm

Leveling Accuracy: ≤ 1.5mm/m²;

Feeding Step Length: 50-000

Feeding Accuracy: 100-1500mm; ± 0.2mm/m



二、生产线速度 Line Speed >>>

送料速度：0 - 70 m/min.

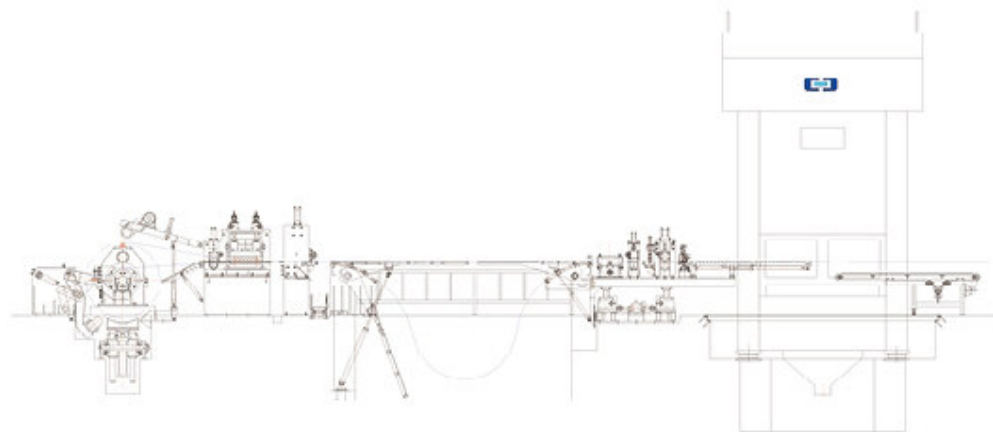
落料压力机行程次数：30 - 60SPM

说明：目前已配备一汽大众、广州本田、东风日产、宇通客车等汽车配套厂家

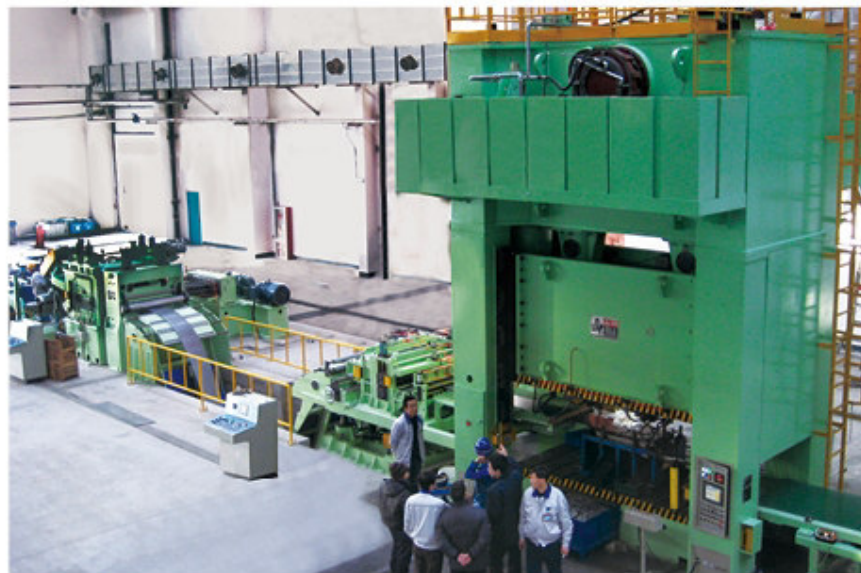
Feeding Speed: 0 - 70 m/min.

Blanking Press Travel Times: 30 - 60SPM

Description : There have been equipped with FAW-Volkswagen, Guangzhou Honda, Nissan, Yutong Bus and other auto manufacturers supporting.



0.5-3.2×1250 标准型汽车落料生产线
0.5-3.2×1250Type Auto Blanking Line



不平行辊列校平机

UNPARALLEL ROLLER LEVELLING MACHINE

- » 机架为框架式结构或者四柱预应力框架式结构;
- » 工作辊表面有较高强度、刚度、表面硬度和加工精度;
- » 上、下排工作辊设有支撑辊支撑;

- » The four-column structure with high strength and rigidity
- » High rigidity, hardness and processing precision of leveling rollers
- » Support rollers
- » Adjustable gaps of leveling and support rollers
- » Data display, PLC, video—data input, edit, modification and store



- » 参数为标准参数，根据用户特殊要求可以变更;
- » 表中为标准机型的外形尺寸，根据用户要求可变更外形尺寸;
- » 可为用户提供普通型、数量型、数控型板料校平机。

» The parameters are standard ones, and they can be changed according to customers' needs.

» The outline dimensions in the table are for standard Models, and they can be changed according to customers' requirements.

» Able to provide customers with sheet materials leveling machines of common type, numerical display



| 规格型号 Model | 最大校平厚度 Max Leveling thickness (mm) | 最小校平厚度 Min level thickness (mm) | 最大校平宽度 Max leveling Width (mm) | 板材屈服强度 Yield Strength Mpa | 工作辊直径 Leveling roller diameter (mm) | 工作辊辊距 Leveling rollers distance (mm) | 工作辊辊数 Number of leveling roller(n) | 校平速度 Leveling speed (m/min) | 主电机功率 Motor (kw) | 外形尺寸 Dimension(m) |
|---------------|---------------------------------------|------------------------------------|-----------------------------------|------------------------------|--|---|---------------------------------------|--------------------------------|---------------------|----------------------|
| W43S-1.5x1000 | 1.5 | 0.6 | 1000 | 245 | 38 | 40 | 21 | 6 | 5.5 | 3.5x1.1x1.5 |
| W43S-2X1250 | 2 | 0.6 | 1250 | 245 | 48 | 50 | 19 | 10 | 7.5 | 3.8x1.2x1.8 |
| W43S-3x1250 | 3 | 0.6 | 1250 | 245 | 60 | 65 | 19 | 10 | 15 | 4.3x1.3x1.9 |
| W43S-3x1600 | 3 | 0.7 | 1600 | 245 | 70 | 75 | 17 | 9 | 15 | 5.2x1.7x2.2 |
| W43S-4x1600 | 4 | 0.8 | 1600 | 245 | 75 | 80 | 15 | 9 | 22 | 5.3x1.6x2.2 |
| W43S-6x1600 | 6 | 1.5 | 1600 | 345 | 95 | 100 | 13 | 9 | 30 | 5.8x1.6x2.8 |
| W43S-6x2000 | 6 | 1.5 | 2000 | 345 | 95 | 100 | 13 | 9 | 37 | 7x1.6x3.2 |
| W43S-8x2000 | 8 | 2 | 2000 | 345 | 120 | 125 | 13 | 8 | 37 | 7x1.7x3.5 |
| W43S-10x2000 | 10 | 2.5 | 2000 | 345 | 140 | 150 | 13 | 9 | 45 | 7.2x1.9x4 |
| W43S-12x1600 | 12 | 3 | 1600 | 345 | 140 | 150 | 13 | 9 | 45 | 6.6x1.9x4 |
| W43S-12x2000 | 12 | 3 | 2000 | 345 | 150 | 160 | 11 | 9 | 55 | 7.1x2x4.1 |
| W43S-12x2500 | 12 | 3 | 2500 | 345 | 150 | 160 | 11 | 9 | 63 | 7.6x2x4.3 |
| W43S-12x3200 | 12 | 4 | 3200 | 345 | 160 | 180 | 11 | 7 | 63 | 7x2.15x4.5 |
| W43S-16x1600 | 16 | 4 | 1600 | 345 | 160 | 180 | 11 | 7 | 63 | 7.5x2x4.2 |
| W43S-16x2000 | 16 | 4 | 2000 | 345 | 180 | 200 | 11 | 8 | 75 | 8.1x2.2x4.6 |
| W43S-16x2500 | 16 | 4 | 2500 | 345 | 180 | 200 | 11 | 7 | 75 | 8.6x2.2x4.8 |
| W43S-16x3200 | 16 | 4 | 3200 | 345 | 180 | 200 | 11 | 7 | 75 | 9.2x2.3x4.9 |
| W43S-20x2000 | 20 | 5 | 2000 | 345 | 200 | 220 | 9 | 7 | 63 | 9.2x2.5x4.9 |
| W43S-20x2500 | 20 | 5 | 2500 | 345 | 220 | 250 | 9 | 7 | 75 | 9.8x2.5x4.9 |
| W43S-20x3200 | 20 | 5 | 3200 | 345 | 220 | 250 | 9 | 6 | 75 | 10.5x2.5x5.2 |
| W43S-25x2000 | 25 | 6 | 2000 | 345 | 220 | 250 | 9 | 6 | 75 | 9.3x2.5x5 |
| W43S-25x2500 | 25 | 6 | 2000 | 345 | 220 | 250 | 9 | 6 | 75 | 9.8x2.5x5.1 |
| W43S-25x3200 | 25 | 6 | 3200 | 345 | 260 | 300 | 9 | 7 | 90 | 10.6x2.6x5.3 |
| W43S-30x2000 | 30 | 6 | 2000 | 345 | 260 | 300 | 9 | 7 | 90 | 9.3x2.6x5.2 |
| W43S-30x2500 | 30 | 6 | 2500 | 345 | 260 | 300 | 9 | 7 | 90 | 9.8x2.6x5.3 |
| W43S-30x3200 | 30 | 8 | 3200 | 345 | 260 | 300 | 9 | 6 | 110 | 10.4x2.65x5.5 |

注：上述标准仅供参考，可根据客户需求决定参数。

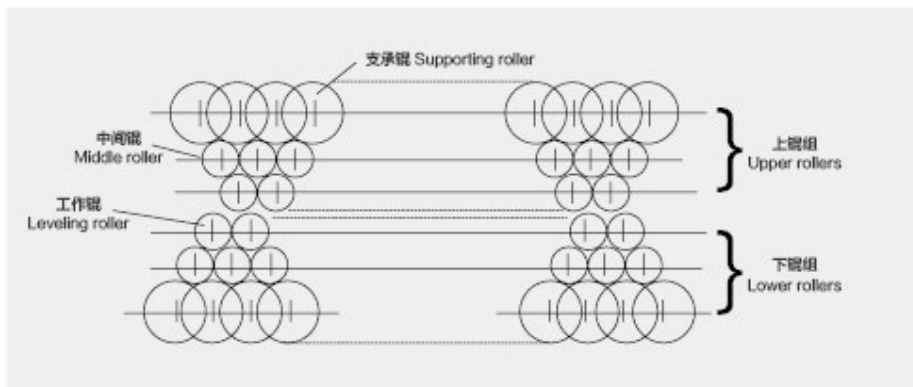
六重式辊式校平机

SIX-FOLD ROLLER-TYPE COMMON(ECONOMICAL)
LEVELING MACHINE



- » 机架为框架结构；具有强度高、刚度好的特点。
- » 具有很高的加工材料表面保护；
- » 具有很高的校平精度；
- » 单面分三层辊：支撑辊、中间辊、工作辊。
- » 数量显示，PLC 控制，可视化输入、编辑、修改、储存工艺参数。
- » 六重式辊式校平机为业内最先进的校平设备。

- » The frame structure with high strength and rigidity
- » High surface protection for processed material
- » High leveling precision
- » Three layers upper: support, middle and leveling rollers
- » Data display, PLC, video—data input, edit, modification and store
- » Most advanced leveling machine in this industry



六重式辊式校平机辊系示意图
Six-fold roller-type leveling machine rollers

| 规格型号 Model | 最大校平厚度 Max Leveling thickness (mm) | 最小校平厚度 Min level thickness (mm) | 最大校平宽度 Max leveling Width (mm) | 板材屈服强度 Yield Strength Mpa | 工作辊直径 Leveling roller diameter (mm) | 工作辊辊距 Leveling rollers distance (mm) | 工作辊辊数 Number of leveling roller(n) | 校平速度 Leveling speed (m/min) | 主电机功率 Motor (kw) | 外形尺寸 Dimension(m) |
|---------------|---------------------------------------|------------------------------------|-----------------------------------|------------------------------|--|---|---------------------------------------|--------------------------------|---------------------|----------------------|
| W43S-1.5x1000 | 1.5 | 0.6 | 1000 | 245 | 38 | 40 | 21 | 6 | 5.5 | 3.5x1.1x1.5 |
| W43S-1.5x1500 | 1.5 | 0.6 | 1500 | 245 | 48 | 50 | 21 | 6 | 7.5 | 4.3x1.19x1.5 |
| W43S-2x800 | 2 | 0.6 | 800 | 360 | 48 | 50 | 21 | 6 | 7.5 | 3.1x1.19x1.5 |
| W43S-2x1250 | 2 | 0.6 | 1250 | 245 | 48 | 50 | 19 | 10 | 7.5 | 3.8x1.2x1.8 |
| W43S-2.5x1250 | 2.5 | 0.6 | 1250 | 240 | 50 | 55 | 19 | 8 | 7.5 | 4.3x1.2x1.8 |
| W43S-3x1250 | 3 | 0.7 | 1250 | 240 | 60 | 65 | 19 | 8 | 11 | 4.3x1.29x1.82 |
| W43S-3x1600 | 3 | 0.8 | 1600 | 240 | 65 | 70 | 17 | 8 | 15 | 4x1.5x1.9 |
| W43S-3x2500 | 3 | 0.8 | 2600 | 300 | 75 | 80 | 19 | 10 | 22 | 7x3.3x1.74 |
| W43S-6x2000 | 6 | 1.5 | 2000 | 380 | 95 | 100 | 13 | 9 | 37 | 6.6x3.53x1.75 |

注：上述标准仅供参考，可根据客户需求决定参数。